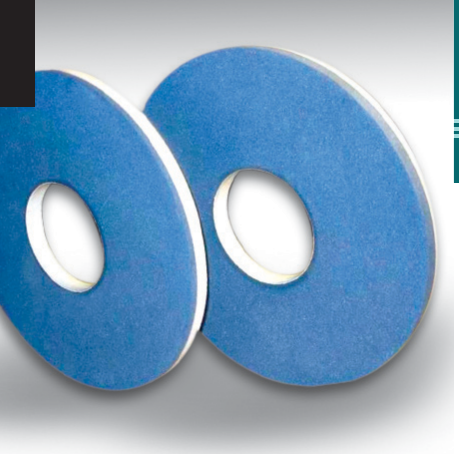

CRANKSHAFT GRINDING WHEELS

Crank up productivity without giving up a micron in surface finish.

It is a special high-precision cylindrical grinding application used in the grinding of crankshafts for the automotive OEM and replacement markets.

Sak Abrasives Ltd.

TOPLINE
Let the sparks fly

User segments

- Automotive (OEM and replacement segments)
- Defense
- Industrial motors

The TOPLINE advantage

- Micron-perfect surface finish
- Excellent form retention
- Reduced dressing frequency and high grinding efficiency results in greater productivity
- Dual grits to grind shaft surfaces of different hardness

TOPLINE Recommendations

Material	TOPLINE specification
Forged steel – soft	1A 463 N5 VS10
Forged steel – hard	1A 543 I5 VS10
Cast iron	3A 46 I5 VS10
Nodular iron	2A 46 L5 VT6
Regrinding	1A 463 L5 VS10

Abrasive	Grit	Hardness	Type	Bond
1A	463, 543	K, L, M	1	VS2

Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
14	1/2 - 7/8	3	355	13 - 22	76.2	1800
16	3/4 - 1	3 - 5	400	20 - 25	76.2 - 127	1575
18	1 - 1 3/4	3 - 5	450	25 - 44	76.2 - 127	1400
20	3/4 - 1 1/2	3 - 6	500	19 - 38	76.2 - 152.4	1260
22	7/8 - 1 3/4	6	550	22 - 44	152.4	1145
23	3/4 - 1 1/4	6	585	19 - 32	152.4	1050
24	3/4 - 1 3/4	8	600	19 - 44	203.2	1050
26	3/4 - 1 3/4	8	660	19 - 45	203.2	955
28	3/4 - 1 3/4	6 - 8	710	19 - 45	152.4 - 203.2	900
30	3/4 - 1 3/4	8, 12, 17 3/4	760	19 - 45	203.2, 304.8, 450.8	840
32	3/4 - 2	8, 12	810	19 - 50	203.2, 304.8	780
36	1 - 2 1/2	12	915	25 - 65	304.8	690