

# **CREEPFEED GRINDING**

Specially formulated porous bond systems to rough and finish a variety of materials in a single pass.

Used to grind difficult to machine alloys requiring high stock removal rates.

# Sak Abrasives Ltd.



## **User segments**

- Aerospace
- Turbine manufacturing

### The TOPLINE advantage

- Specially formulated VSCP bond system for exceptional stock removal rates and burr-free surface finish
- Good repeatability
- Lower total grinding cost

#### **TOPLINE Recommendations**

Material	TOPLINE recommendation	
Nickel alloys	2A/4A	
Tool steel/high chrome steel	2A	
Titanium/ cast iron	6G	

Abrasive	Grit	Hardness		Bond	
4A,2A	60, 80	Hard, Harder, Extra Hard		VS10	
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)
16	1	5	400	25	127
16	2 1/2	5	400	63	127
16	4	5	400	100	127
20	2 1/2	8	500	63	203.2
20	4	8	500	100	203.2
24	4	8	600	100	203.2
	4A,2A  Dia. (In.)  16  16  16  20  20	4A,2A     60,80       Dia. (In.)     Thick. (In.)       16     1       16     2 1/2       16     4       20     2 1/2       20     4	Dia. (In.)       Thick. (In.)       Bore (In.)         16       1       5         16       2 1/2       5         16       4       5         20       2 1/2       8         20       4       8	Dia. (In.)       Thick. (In.)       Bore (In.)       Dia. (mm)         16       1       5       400         16       2 1/2       5       400         16       4       5       400         20       2 1/2       8       500         20       4       8       500	4A,2A       60,80       Hard, Harder, Extra Hard       VS10         Dia. (In.)       Thick. (In.)       Bore (In.)       Dia. (mm)       Thick. (mm)         16       1       5       400       25         16       2 1/2       5       400       63         16       4       5       400       100         20       2 1/2       8       500       63         20       4       8       500       100