

CYLINDRICAL GRINDING – GENERAL PURPOSE

Generate perfectly sized parts in a flash

Used in O.D. grinding of gear shafts, splined shafts, transmission shafts, valves, plunger pins, eye bolts, bearing races etc.

User segments

- Automotive
- Bearing industry
- General engineering
- Tool and die industry

The TOPLINE advantage

- Increased productivity due to higher stock removal and freer cutting
- Fine surface finish
- Reduced rework
- Reduced loading and dressing frequency

TOPLINE Recommendations

Material	TOPLINE specification
Soft steel, Hardened Steel	1A 463 L5 VS10
High speed steel	2A 46/54 K5 VS8
Stainless steel	5C 363 N5 VSA
Tungsten carbide	6G 60 L5 VSA
General purpose	1A 463 L5 VS10
Chilled cast iron, non ferrous material	5C 60 J5 VSA

Sak Abrasives Ltd.

TOPLINE
Let the sparks fly

Abrasive	Grit	Hardness	Type	Bond
1A	60	K, L, N	1	VT4

Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
10	1	3	250	25	76.2	2520
12	1, 2	5	300	25, 50	127	2100
14	1, 1 5/8, 2	5	350	25, 40, 50	127	1800
16	1 5/8	5	400	40	127	1575
20	3 1/4	8	500	80	203.2	1260

Abrasive	Grit	Hardness	Type	Bond
2A	46, 54, 60	K	1	VT3

Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
12	1, 2	3	300	25, 50	76.2	2100
14	1 5/8	5	350	40	127	1800

Abrasive	Grit	Hardness	Type	Bond		
3A	46, 60, 80, 100	H, I, J, K	1	VT4		
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
16	1/2	5	400	13	127	1575
16	1	8	400	25	203.2	1575
16	1 1/2, 2, 3	5	400	38, 50, 75	127	1575
18	1/2	5, 8	450	13	127, 203.2	1400
18	1 - 3	5, 8	450	25 - 75	127, 203.2	1400
20	1/2, 1	8, 10	500	13, 25	203.2, 254	1260
20	1 1/2	5	500	38	127	1260
20	2	5, 12	500	50	127, 304.8	1260
20	3	8, 10	500	75	203.2, 254	1260
24	1/2, 1 - 3	12	600	13, 25 - 75	304.8	1050
30	1 - 4	12	750	25 - 100	304.8	840

Abrasive	Grit	Hardness	Type	Bond			
8M	46	I	7	VT6			
Dia. (In.)	Thick. (In.)	Bore (In.)	Recess (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Recess (mm)
18	2	8	Rec 2/S 10 1/2 x 1/2	450	50	203.2	263 x 13
20	2	8	Rec 2/S 11 1/2 x 1/2	500	50	203.2	288 x 13
20	3	8	Rec 2/S 11 1/4 x 1/2	500	75	203.2	281 x 13
20	3	8	Rec 2/S 11 1/4 x 1/2	500	75	203.2	281 x 13
20	3	10	Rec 2/S 12 1/4 x 5/8	500	75	254	306 x 16
20	6	10	Rec Side A 12 1/4 x 2: Side B 12 1/4 x 1	500	150	254	Side A 306 x 50; Side B 306 x 25

Abrasive	Grit	Hardness	Type	Bond			
1A	463,60,80	K, L, M	1	VT4			
Dia. (In.)	Thick. (In.)	Bore (In.)	Recess (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Recess (mm)
12	1 5/8	5	ROS 7 5/8x5/8	300	40	127	ROS 190x15
14	1 5/8	5	ROS 7 5/8x5/8	350	40	127	ROS 190x15
16	1 5/8, 2	5	ROS 7 5/8x5/8	400	40, 50	127	ROS 190x15
18	2 5/8	10	ROS 13x1/2	450	65	254	ROS 325x13
20	2 5/8	10	ROS 13x3/8	500	65	254	ROS 325x10