



# TOOL ROOM GRINDING WHEELS

Remove that last micron of metal to obtain a finish as smooth as silk.

Typical applications are in the grinding of cutting tools like drills, reamers and milling cutters, surface grinding and cylindrical grinding.

## User segments

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

## The TOPLINE advantage

- Precision surface finish with superior dimensional accuracy
- Excellent form retention
- Burn-free cutting
- Lower grinding costs

## TOPLINE Recommendations

Material	TOPLINE specification
High speed steel	2A 46/54 K5 VS8
Tool steel	2A 46/54 K5 VS8
High alloy steel	2A 60 J5 VS8
Tungsten carbide	6G 60 K5 VSA
Special tool steel	6A 60 K6 VS31

Sak Abrasives Ltd.



Abrasive	Grit	Hardness			Type	Bond
2A	46, 60, 80, 100, 120, 150, 220	G, H, I, J, K, L, M, Q			1	VT3
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
3	1	1/2	75	25	12.7	10825
4	1/2	1/2, 3/4, 1 1/4	100	13	12.7, 20, 31.75	8120
4	1/4, 1	1/2, 1 1/4	100	6, 25	12.7, 31.75	8120
6	3/4	5/8, 1 1/4	150	20	16, 31.75	4140
6	1/4	1 1/4	150	6	31.75	4140
6	1/2	1/2, 1 1/4	150	13	12.7, 31.75	4140
7	1/4, 1/2	1 1/4	180	6, 13	31.75	3600
7	3/8, 3/4	1 1/4	180	9, 20	31.75	3600
8	1/4 - 3/4	1 1/4	200	6 - 20	31.75	3600
10	1	3	250	25	76.2	2485
14	1, 1 1/2	5	350	25, 38	127	1800

Abrasive	Grit	Hardness		Type	Bond	
8M	46,60, 80, 100, 120	F, G, H, I, J, K, L, M		1	VT6	
Diameter	Thickness	Bore	D (mm)	T (mm)	B (mm)	Speed (rpm)
4	1/4	3/4	100	6	20	8120
6	1/4 - 1	1 1/4	150	6 - 26	31.75	4140
6	1/4, 3/4	1/2	150	6, 20	12.7	4140
7	1/4 - 1	1 1/4	180	6 - 26	31.75	3600
7	3/8	1 1/4	180	9	31.75	3600
8	1/4 - 1	1 1/4	200	6 - 26	31.75	3600
8	3/8	1 1/4	200	9	31.75	3600
10	1	2, 3	250	25	50.8, 76.2	2485
10	3/4	3	250	9	76.2	2485
12	1/2-2	3, 5	300	13-50	76.2, 127	2070
12	2	1 1/4	300	50	31.75	2070
14	1	3, 5	350	25	76.2, 127	1800
14	1/2, 1 1/2, 2	5	350	13, 38, 50	127	1800

Abrasive	Grit	Hardness		Type	Bond	
6G, 6CG	60, 80, 100, 120	K, L, M		1	VTA	
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
6	1/2	1 1/4	150	13	31.75	4140
7	1/2, 1	1 1/4	180	13, 25	31.75	3600
8	1/2, 1	1 1/4	200	13, 25	31.75	3600
10	1 1/2	2	250	38	76.2	2485
14	1, 1 1/2	5	350	25, 38	127	1800

Abrasive	Grit	Hardness	Type	Bond		
5C	60	M	1	VTA		
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
3	1	1/2	75	25	12.7	10825
4	1/2	1/2, 3/4	100	13	12.7, 20	8120

Abrasive	Grit	Hardness		Type	Bond	
4A	46, 60	H, I, J, K		1	VT3	
Dia. (In.)	Thick. (In.)	Bore (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Speed (rpm)
7	1/2	1 1/4	180	13	31.75	3600
8	1/2	1 1/4	200	13	31.75	3600