Identifying markings on conventional grinding tools

	abrasive	grain size	degree of hardness	structure	bonding system	special marking
example	**40A**	**60 - 3**	**M**	**5**	**V**	**7235**

abrasive

normal corundum:
10A - 20A

sintered corrundum:
21A - 28A, 121A - 829A

semi-precious corundum and combinations:
30A - 39A

aluminium oxide white, red, pink and combinations:
40A - 48A

monocrystalline:
49A

zirconium corundum and combinations:
50A - 79A

silicon carbide and combinations:
80C - 97C

grain size

very coarse	8, 10, 12
coarse	14, 16, 20, 24
medium	30, 36, 40, 46, 54, **60**
fine	70, 80, 90, 100, 120
very fine	150, 180, 220, 240
dust fine	280, 320, 400, 500, 600

degree of hardness

extremely soft	A, B, C, D
very soft	E, F, G
soft	H, I, J, K
medium	**M**, N, O
hard	P, Q, R, S
very hard	T, U, V, W
extremely hard	X, Y, Z

structure

very dense	0, 1
close	2, 3
medium	4, **5**
open	6, 7
very open	8, 9
porous	12, 13, 14,
highly porous	15

bonding system

ceramic bond	**V** / VM
resin bond	B / BE / BF

special marking

internal marking