











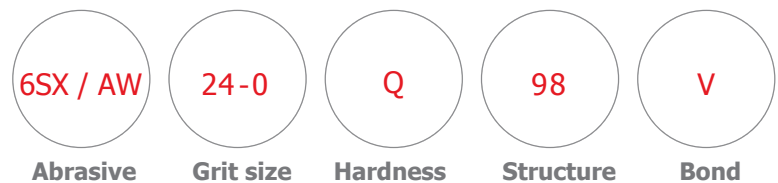


QUALITY MARKING OF GRINDING WHEELS



Abrasives Aluminum oxides (Al ₂ O ₃), silicon carbides (SiC), superabrasives (CBN/diamond)	Grit size Description of the abrasive grain size	Hardness Resistance of the grain to breaking out of the bond structure.	Structure Refers to the abrasive concentration and the distribution of abrasive grain, bond, and pore space.		Bond Holds the grains in place within the grinding wheel structure.
			Manufacturing process 1	Manufacturing process 2	
 Brown fused alumina AN	very coarse 8, 10, 12	very soft D, E, F, G	very dense 1 - 15	very dense 80 - 81	V vitrified
 Sintered alumina SA-SZ	coarse 14, 16, 20, 24	soft H, I, J, K	dense 16 - 25	dense 82 - 84	B synthetic resin
 Semi-friable alumina AH	medium 30, 36, 40, 46, 54, 60	medium L, M, N, O	medium 26 - 35	medium 85 - 88	E epoxy resin
 White fused alumina AW	fine 70, 80, 90, 100, 120	hard P, Q, R, S	open 36 - 42	open 89 - 92	M magnesite
 Pink fused alumina AR	very fine 150, 180, 240	very hard T, U, V, W	very open 43 - 49	very open 93 - 94	R rubber
 Ruby fused alumina AX	ultra fine 280, 320, 360, 400, 500, 600, 800, 1000	ultra hard X, Y, Z	porous 50 - 60	porous 95 - 96	
 Monocrystalline alumina AT			very porous 61 - 79	very porous 97 - 98	
 Zirconia alumina ZF/ZK					
 Black silicon carbide CS					
 Green silicon carbide CG					
 CBN 1B-99B					
 Diamond 1D-99D					

Example



Since grinding usually takes place near the end of the production process, the manufacturing costs are significantly influenced by the quality of the grinding tool.

High-quality precision tools from THELEICO reduce your production scrap, make your grinding process more efficient, and increase your product quality.

THELEICO guarantees certified international standards.

