

ABRASIVE GRIT

ABRASIVE GRIT CHARACTERISTICS

A	A tough variant of aluminium oxide with 3 % mixture of titanium oxide. When burning at low temperature the abrasive grit maintains its brown colour. When burning at high temperature the colour turns grey blue. Brown aluminium oxide is used for grinding wheels for bench grinders and other manual operations and for whetstones.
19A	A mixture of abrasive grit A and 38A. Used on standard wheels for surface and round grinding, centuries grinding and grinding material that is not especially heat sensitive.
38A	White aluminium oxide with very high degree of purity: 99 %. The most brittle and most cold-cutting of the aluminium oxide abrasives. Used in standard products for grinding hard and heat sensitive material such as high speed steel and alloys. 38A is used for round, flat and internal grinding of e.g. tools, punches and gauge blocks.
57A	Semi-brittle brown aluminium oxide with high degree of purity: 98 %. The high degree of purity makes it an abrasive with a very broad application area such as round and centuries grinding of both hard and soft steel. U57A is a variant where the abrasive grit is coated with a ceramic coating which increases durability when used on homoplastic bound cut-off wheel.
86A	Ruby red aluminium oxide is a highly refined form of aluminium oxide with a small portion of chromium oxide. This makes 41A tougher than white aluminium oxide through increasing the strength on the cutting plane. This abrasive is primarily used for mounted points.
SGB	A mixture of premium abrasive with Norton SG ceramic abrasive in a medium high concentration.
3SG	A mixture of premium abrasive with Norton SG ceramic abrasive in a high concentration.
5SG	A mixture of premium abrasive with Norton SG ceramic abrasive in a very high concentration.
37C	Silicon carbide. Used mainly on homoplastic bound wheels for grinding grey cast iron and non-ferrous metals and on ceramic bound wheels for grinding e.g. rubber and stone.
39C	Silicon carbide with a very high degree of purity. Ideal for grinding tungsten carbide, burnt ceramic and glass.

BONDING AGENT

CERAMIC

Ceramic bonding agent is the most common for precision grinding. The porosity and strength reached with this bonding agent gives a high removal rate and great precision. Ceramic bound wheels are not affected by water, acid or temperature variations.

The most common ceramic bonding agents are:

V	V is a ceramic high temperature bonding agent which is used for exacting operations.
VS	VS is a high performance low temperature bonding agent with a very broad application area. Used among others for tool grinding, round, surface and centuries grinding.
VTECH	VTECH is a very advanced low temperature bonding agent which is used with a conventional abrasive for grinding operations on a high technical level to optimise grinding and cutting parameters.
VX	VX-bonding agent gives increased edge and form stability and is mainly used together with premium abrasive grit.
VXP	VXP is a highly porous variant of the VX bonding agent used for surface grinding and other operations with a large contact area.