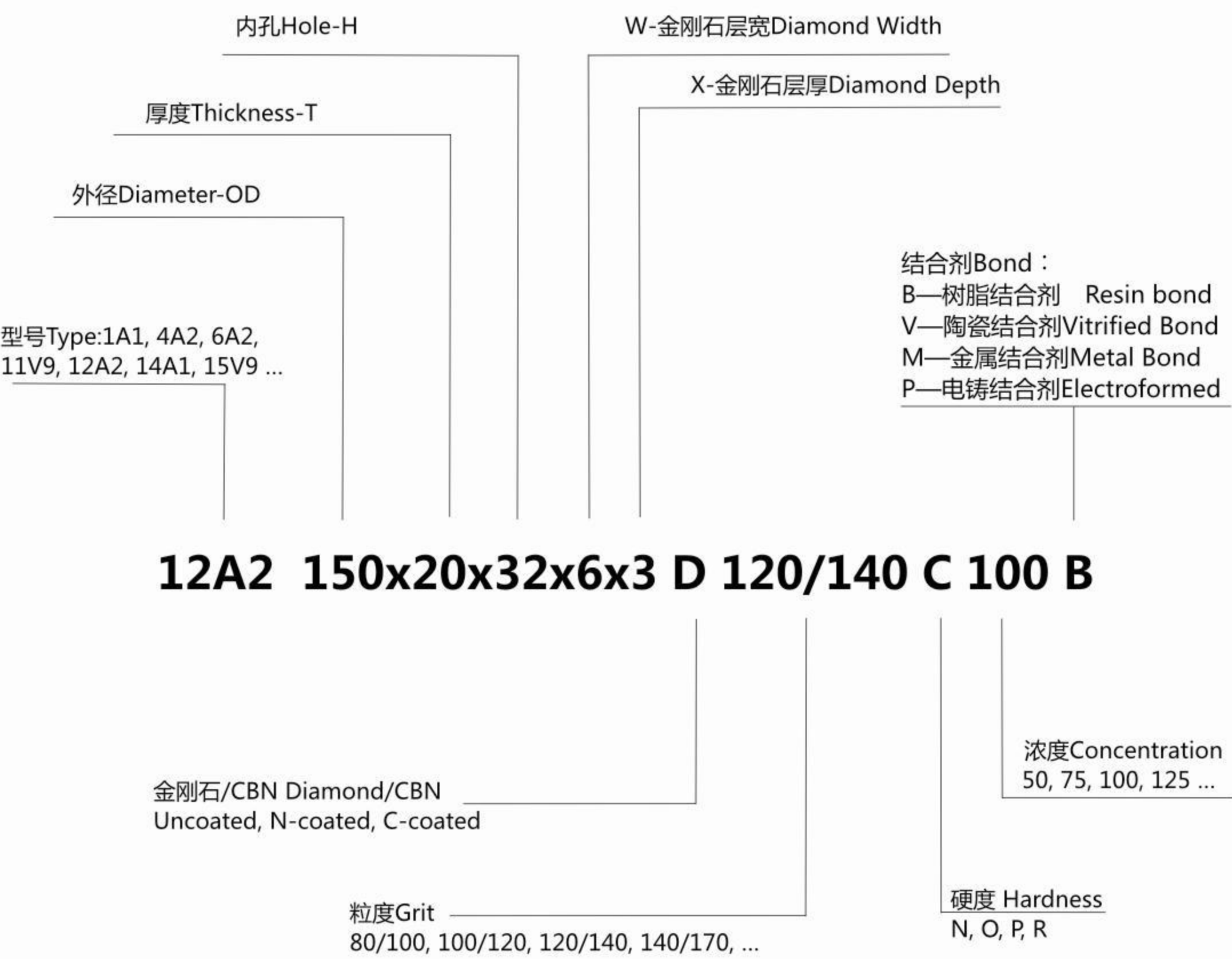


金刚石和CBN砂轮型号
TYPES OF DIAMOND & CBN WHEELS

Shape	Shape	Shape
1A1 	1G1 	6A2 
1A1R 	1L1 	6A2C 
1A8 	1M1 	6A2H 
1D1 	1Q1 	6A9 
1DD1 	1QQ1 	9A3 
1E1 	1V1 	9A3H 
1EE1 	1Y1 	11A2 
1E9 	2A2T 	11A9 
1F1 	3A1 	11V4 
11V5 	12V5 	11V5 
12A2 	12V9 	15V9 
12V4 	15A2 	
HH1 	HH2 	

金刚石和CBN砂轮标注方法
MARKING OF DIAMOND & CBN WHEELS



如何订购砂轮
How to make an order

订购砂轮时，请尽量将以下信息告诉我们：

砂轮的型号、尺寸（外径、厚度、孔径、磨料层宽度及深度）、磨料种类、粒度、结合剂类型、浓度、磨削方式（干磨或湿磨）以及被加工材料、使用设备、型号等。描述越清楚越能得到最适合的砂轮。

How to make an order

More detailed for your description, more proper wheels you could get, please let us know:

Type – such as 1A1, 1A1R, 6A2, 11V9.

Size – Diameter, Thickness, Hole, Width and depth of abrasive layer, angle.

Specification – Abrasive (D or CBN), Grit, Bond, Concentration.

Workpiece – Material, Grinding process (wet or dry) and Machine used.

磨曲轴、凸轮轴砂轮 Wheels for Crankshaft & Camshaft

- 砂轮形状：1A1, 3A1, 14A1。
- 砂轮尺寸范围：100mm-750mm。
- 最高使用速度：160m/s。
- 应用范围：该砂轮适用于汽车、农用车以及船舶重型工程车发动机曲轴连杆径及轴径面和凸轮轴桃形面及主轴径面的高效强力磨削。
- 可加工材料：适用于加工铸铁类（如冷激铸铁、球墨铸铁、灰口铸铁、合金铸铁等）与钢件类（如20Cr、GCr15、CF53、45钢、55钢、80B高碳钢等）材料。
- 特点：具有加工效率高、精度高、不产生烧伤及表面退火现象，使用寿命长，易修整的特点。
- 适用设备：Junker, Toyoda, Schaudt, 恒博、杰克、海捷、EMAG、LANDIS等。



- Shape:1A1, 3A1, 14A1.
- Diameter:100mm-750mm.
- Speed:160m/s.
- Applications:The vitrified CBN wheels are used for high efficient and heavy grinding of crankshaft and camshaft of Automobile, Trackor, Transport.
- Workpieces:Cast iron series (such as cold cast iron, nodular cast iron, grey cast iron, alloy cast iron) and steel series (such as 20Cr、 GCr15、 CF53、 #45、 #55、 80B).
- Features:high efficiency and precision without burning and annealing, easy to dress and durability.
- Machines:Junker,Toyoda,Schaudt,EMAG,LANDIS,etc.

万向节砂轮 Wheels for Universal Joint

- 砂轮形状：1A8、1A8W。
- 砂轮尺寸范围：Φ6-30mm。
- 结合剂：陶瓷。
- 磨料：CBN。
- 应用设备：德国EX-CELL-O XG692 XG662、意大利MECCANORA。
- 应用范围：主要应用于汽车零部件固定型球笼套等速万向节;星形套、钟形壳内外球道磨削，保持架窗孔磨削等。
- 砂轮优点：锋利性及形状保持性好，具有较大的材料去除率，可以使用一刀工艺完成全部球道磨削，6个球道的磨削时间仅需60-80s。大幅提高加工效率。砂轮的性能已达到国外进口砂轮水平。



- Shape:1A8、1A8W.
- Diameter:Φ6-30mm.
- Bond:Vitrified.
- Abrasives:CBN.
- Grinders:EX-CELL-O XG692 XG662、 MECCANORA.
- Applications:Mainly in the filed of Automobile, such as CV joint, Starlike Sleeve, Inner and out race, Case, etc.
- Features:Good sharpening and shape holding, higher removal rate and efficiency, 6 races ground by only 60~80 seconds, the quality has reached to that imported.

加工轴承用砂轮 Wheels for bearing

- 砂轮形状：1A8、1A8W、3A1、1A1。
- 砂轮尺寸范围：Φ10-130mm。
- 结合剂：陶瓷。
- 磨料：CBN。
- 应用设备：日本TOYO、YONGKE、德国Mikrosa、日本KOYO。
- 应用范围：轴承内径磨削、外沟道磨削、断面磨削等。
- 砂轮优点：锋利性及形状保持性好，具有较大的材料去除率，散 热性能好，修正间隔可达到300台/修。加工精度高，圆度、圆柱度、直线度≤2μm，精度一致性CPK值≥1.33,可以在离散度要求高的产品中提高成品率。



- Shapes:1A8、1A8W、3A1、1A1.
- Diameter:Φ10-130mm.
- Bond:Vitrified.
- Abrasives:CBN.
- Machines:TOYO、YONGKE、 Mikrosa、 KOYO.
- Application:Inner diameter, out race and surfaces of bearing.
- Features:Good sharpening and shape holding, higher removal rate and efficiency, good heat dissipation, dressing interval reaches to 300 pieces. roundness, cylindricity, straightness ≤2μm, CPK≥1.33.

油泵油嘴砂轮 Wheels for pump nozzle

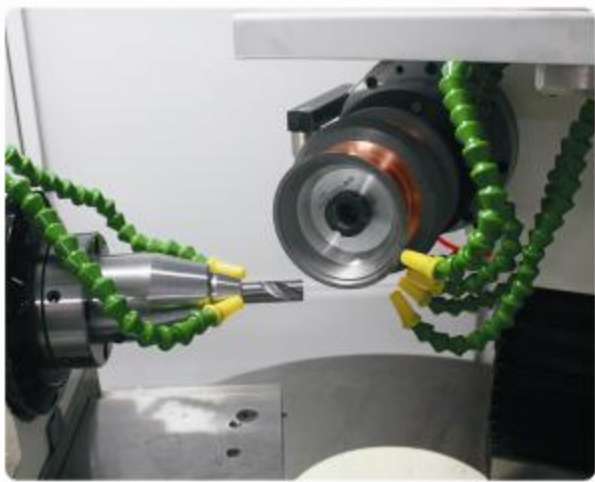


- 砂轮形状：1A8W。
- 砂轮尺寸范围：Φ4-30mm。
- 结合剂：陶瓷。
- 磨料：CBN。
- 应用设备：沈阳海默数控磨床、UVA Nomyline。
- 应用范围：油泵油嘴内孔磨削。
- 砂轮优点：锋利性及形状保持性好，磨削效率高，散热性好，加工精度高，圆度、圆柱度、直线度≤2μm。

- Shape:1A8W.
- Diameter:Φ4-30mm.
- Bond:Vitrified.
- Abrasives:CBN.
- Machines:UVA Nomyline.
- Application:Hole grinding of pump nozzles.
- Features:Good sharpening and shape holding, higher removal rate and efficiency, good heat dissipation, roundness, cylindricity, straightness ≤2μm.

整体刀具砂轮 Solid Tools

- 砂轮规格：1A1、14A1、11V9、1V1。
 - 常用规格：D150, D125, D100, D75。
 - 结合剂：复合结合剂Hybrid及树脂结合剂。
 - 砂轮应用：开槽磨削、铲磨、周边磨削、端面磨削、齿隙磨削。
 - 应用设备：WALTER、ANCA、SAACKE、EWAG。
- 高精度CNC磨床专用砂轮，应用于单轴或多轴联动的数控磨床。该砂轮由耐热性极好的树脂结合剂以及树脂-金属复合结合剂与优质金刚石或CBN制成，具有精度高、转速高、磨削效率高和保持性好等特点，已完好应用于Walter, Anca, Ewag等高精度数控磨床。



- Shapes:1A1、14A1、11V9、1V1.
 - Specifications:D150 , D125 , D100 , D75.
 - Bond:Hybrid,Resin.
 - Application:Fluting, Grooving, Relief grinding, Peripheral grinding, Section grinding and Tooth grinding.
 - Grinders:WALTER、ANCA、SAACKE、EWAG.
- The wheels for multi-axis CNC grinders are the professional ones made with polyamide and hybrid bonds and quality diamond or CBN with the performance of high speed, high accuracy, high efficiency and excellent shape-standing. These products have been successfully used in the grinders, such as Walter, Anca, Ewag, etc.

强力开槽砂轮 Wheels for Power Grooving

- 砂轮规格：1A1、14A1、1V1。
- 常用规格：D150, D125, D100, D75。
- 结合剂类型：复合结合剂 Hybrid。
- 砂轮应用：主要整体硬质合金钻头、铣刀、铰刀等数控刀具的强力开槽磨削。
- 加工参数：线速度16-25m/s, 单次进给量2.4-4.0mm, 进给速度80-150mm/min。
- 砂轮特点：兼具树脂结合剂的锋利性好、自锐性好和金属结合剂刚性好、强度高、形状保持性好的优点。切深大、进给快，磨削加工效率高；耐磨性及形状保持性好，修整间隔长；加工工件质量完美，粗糙度、尺寸精度符合要求；微震动、低负载，对机床损伤小；加工效率比树脂砂轮提高100-150%。
- 应用实例：φ16 mm钻头开槽，槽深6mm, 每次进刀3 mm,刃长30 mm, 进给速度110 mm/min,所用时间3 min48 s,与Wendt及Winter砂轮一致。



- Shapes:1A1、14A1、1V1.
- Specifications:D150, D125, D100, D75.
- Bond:Hybrid.
- Application:Solid carbide drills, milling cutter, reamer, etc.
- Working parameter:16~25m/s, single feed 2.4~4.0mm by the feed speed 80~130mm/min.
- Features:With the advantages of both resin and metal bonds, free cutting and self-sharpening, good rigidity and strength, excellent shape retention, big deep and fast feed, long dressing interval, workpiece in good quality, little vibration, low load, efficiency higher 100~150% than that in resin bond.

树脂结合剂CBN砂轮 Resin bonded CBN Wheel

- 砂轮形状：1A1、14A1、1V1、11V9、12V9。
- 常用规格：D150, D125, D100, D75。
- 结合剂：树脂。
- 应用范围：主要用于高速钢、合金钢钻头、铣刀、铰刀等数控刀具的开槽磨削、铲磨、周边磨削、端面磨削、齿隙磨削等。
- 加工材质：M2、M35、M2A1等高速钢。
- 砂轮特点：切深大、进给快，磨削加工效率高；耐磨性及形状保持性好，修整间隔长；加工工件质量完美，粗糙度、尺寸精度符合要求；微震动、低负载，对机床损伤小。
- 加工参数：线速度25-30m/s, 单次进给量为1.0-2.5mm, 进给速度为300-400mm/min。
- 应用案例：M2A1整体高速钢四刃铣刀，Φ12mm铣刀加工时间为4min30s, Φ10mm铣刀加工时间为3min30s, Φ8mm铣刀加工时间为2min30s。



- Shapes:1A1、14A1、1V1、11V9、12V9.
 - Specifications:D150 , D125 , D100 , D75.
 - Bond:Resin.
 - Application:For the Fluting, Grooving, Relief grinding, Peripheral grinding, Section grinding and Tooth grinding of HSS, alloy steel cutter, reamer, etc.
 - Workpieces:M2 、M35 、M2A1 , etc.
 - Features:Deep grinding, feed fast, high efficiency, good wear resistance and shape retention, little vibration, low load, high efficiency.
 - Working parameter:25~30m/s, single feed 1,2~2,5mm by the feed speed 300~400mm/min.
- Examples of application:Solid HSS four-edged milling cutter Φ12mm by the time 4'30";Φ10mm by the time 3'30", Φ8mm by the time 2'30".

强力开槽实用案例

工件尺寸	16 mmφ 30 mm 槽长	
槽深	6 mm	
	3 mm /刀, 分两刀进给	
槽数	2	
材质	硬质合金麻花钻	
设备	Woter S500 (15 KW) 油冷	
砂轮规格	1A1-125-10-10-D64	
砂轮生产商	国际顶级品牌	AYTECH 赛扬
进给速度	80 mm/min	80 mm/min
设备负载	23~34%	26~36%
砂轮线速度	19 m/s	20 m/s
开槽时间	3 min 48 s	3 min 48 s
结论	赛扬公司的强力开槽砂轮加工中的负载，加工时间，锋利性与国际顶级品牌砂轮完全一致。	

刀粒周边磨砂轮
Peripheral Grinding Wheels for Inserts

- 加工对象：PCD、PCBN、硬质合金、陶瓷、金属陶瓷等。
- 加工设备：Agathon、EWAG、WAIDA、Wendt
- 砂轮特点：砂轮平面度好、砂轮磨削能力强，砂轮耐用度强，被加工工件的刃口质量优。
- Applications: Precision peripheral grinding of Indexable insert of Carbide, Ceramics, Metal-ceramic, etc.
- Grinders: Agathon、EWAG、WAIDA、Wendt.
- Features of the wheel: Good flatness, strong grinding and durability and sharpening edges of workpieces.

树脂周边磨砂轮 Resin Bonded Peripheral Grinding for Inserts

- 砂轮形状：2A2T、6A2T。
- 主要规格：外径250mm、350mm、400mm。环宽4~20mm。厚度4~20mm。
- 磨料种类：金刚石，CBN。结合剂：树脂结合剂。
- 应用：主要用于硬质合金、金属陶瓷等材质刀粒的刃磨加工，也可用于PCBN周边磨加工。
- 主要粒度：硬质合金D15~D76; 金属陶瓷D25~D54; 陶瓷D25~D54。
- Shapes: 2A2T、6A2T. OD: 250mm、350mm、400mm.
- Width of ring: 4 ~ 20mm. Thickness: 4 ~ 20mm
- Abrasives: Diamond, CBN. Bond: Resin.
- Application: Carbide Insert, Diamond grit: D15~D76; Ceramic-Metal alloy Insert, grit: D25~D54; Ceramic Insert. grit: D25~D54.



PCD、PCBN刃磨与周边磨陶瓷砂轮 PCD、PCBN Insert Profile Grinding

- 砂轮形状：2A2T, 6A2T, 11A2T。
- 磨料种类：金刚石。粒度：D40 ~ D5。结合剂：陶瓷。
- 砂轮尺寸：150mm, 350mm, 400mm。
- 应用：砂轮主要用于PCD与PCBN材质的刀具、刀片等切削工具的刃磨，以及可转位刀片的周边磨加工。
- 适用设备：AGATHON、EWAG、WENDT、WAIDA等手动及数控磨床。
- 产品特点：具有磨削锋利、耐用度高、易修整、型面精度保持性好、刀片刃口质量好的优点。可根据需要提供致密型和气孔型各种规格。
- Shapes: 2A2T, 6A2T, 11A2T.
- Abrasive: Diamond.
- Grits: D40 ~ D5.
- Bond: Vitrified.
- Diameter: 150mm, 350mm, 400mm.
- Application: These vitrified diamond wheels are used for the edge grinding and peripheral grinding of PCD, PCBN and other Indexable tools.
- Grinders: AGATHON、EWAG、WENDT、WAIDA, etc.
- Features of the wheels: Free cutting, durability, easy to be dressed, excellent shape-holding and good edge of the workpiece, both compact and porous can be supplied.



无芯磨砂轮 Centerless Grinding Wheel

树脂结合剂无芯磨砂轮

- 砂轮形状：1A1。
- 砂轮尺寸：最大外径可做750mm。
- 磨料粒度：最细磨料#3000。
- 磨料种类：金刚石、CBN。
- 加工对象：硬质合金、陶瓷、金属陶瓷、高速钢模具钢等材料的外圆。
- 砂轮特点：砂轮能够批量高效率磨削；砂轮锋利性好，寿命长，被加工工件的粗糙度低，被加工工件同心度一致；精加工后工件表面粗糙度低。
- Shape: 1A1.
- Diameter: Up to 750mm.
- Grit: Finest to #3000.
- Abrasives: Diamond, CBN.
- Application: Cylindrical grinding of carbide, ceramic, metal-ceramic, Hss, Die steels, etc.
- Features: High efficient grinding in batch, good sharpening and durability, high precision and concentricity of workpieces.



陶瓷结合剂无芯磨砂轮

- 砂轮形状：1A1。
- 砂轮尺寸：Φ300-Φ500mm。
- 结合剂：陶瓷。
- 磨料：金刚石。
- 应用设备：无锡上机精密外圆磨床、北二外圆磨床。
- 应用范围：轴类、棒料、轴承套圈；一般滚子、光轴；活塞销、圆柱形滑阀、滚针等。
- 砂轮优点：加工出的工件精度高，圆度、圆柱度好，尺寸一致性好。同树脂结合剂无芯磨砂轮相比，陶瓷结合剂无芯磨砂轮具有更好的锋利性及形状保持性，加工效率高，寿命长。
- Shape: 1A1.
- Diameter: Φ300-Φ500mm.
- Bond: Vitrified.
- abrasives: Diamond
- Grinders: All grinders for centerless grinding.
- Application: Shafts, bars, bearing rings, rollers, piston pins, cylindrical valves, Needle rollers, etc.
- Features: More sharpening and better shape retention, high efficiency and long durability. Makes workpiece in high precision, good roundness and cylindricity, good size consistency.



胶木基砂轮 Bakelite Diamond/CBN Wheels



- 胶木基砂轮整体重量轻，砂轮具有一定的弹性，加工出来的工件表面光洁度优于铝基以及钢基体。
- 应用范围：适用于设备功率不大，砂轮外径大，产品精度要求高的产品对象。
- 砂轮形状：1A1、3A1、14A1等。
- 砂轮规格：各种尺寸均可以定做。
- 磨料：金刚石或者CBN。
- 结合剂：树脂结合剂。

压缩机行业CBN砂轮
Vitrified CBN Wheels for Compressor Parts

陶瓷结合剂CBN砂轮广泛应用于空调压缩机部件的磨削加工，如压缩机活塞、气缸、缸盖、轴承、齿轮等的加工，砂轮具有开放的组织 and 良好的自锐性。同时，这些砂轮也应用于汽车零部件等行业。

Vitrified CBN wheels are widely used in the field of compressor for the grinding of piston, cylinder, cap, bearing and gear, etc. The products have opened structure (Compact & porous structure) and self-sharpening. Also these wheels have been used in the of Auto industry and other industries.

内圆磨砂轮
Wheels For Internal Grinding

- 砂轮形状：1A8、1A8W。
- 砂轮尺寸：Φ10-60mm。
- 应用设备：日本TOYO、YONGKE、德国Mikrosa、日本KOYO。
- 结合剂：陶瓷。
- 磨料：CBN。
- 应用范围：压缩机活塞内圆磨削，气缸内圆磨削，缸盖、机架内圆磨削等。
- 砂轮特点：锋利性及形状保持性好，具有较大的材料去除率，散热性能好。
活塞加工节拍≤25s, 修整间隔40-120台/修；缸盖加工节拍≤15s,修整间隔50-300台/修；
机架加工节拍≤20s, 修整间隔50-300台/修；气缸加工节拍≤15s, 修整间隔60-300台/修；
加工精度高，圆度、圆柱度、直线度≤3μm。
- Shapes:1A8、1A8W.
- Diameter:Φ10-60mm.
- Grinders:TOYO、YONGKE、Mikrosa、KOYO.
- Bond:vitrified.
- Abrasives:CBN.
- Application:Internal grinding of compressor piston, cylinder, cylinder cover, cylinder frame, etc.
- Features:Good sharpening and shape retention, large material removal rate, good heat dispersion, accurate machining, keep tolerance of roundness, cylindricity and straightness≤3μm.
For piston grinding, cycle time is≤25s, dressing interval is 40~120 pieces;
For cylinder cover grinding, cycle time is ≤15s, dressing interval is 50~300 pieces;
For cylinder frame grinding, cycle time is ≤20s, dressing interval is 30~300 pieces;
For cylinder grinding, cycle time is ≤15s, dressing interval is 60~300 pieces.



外圆磨砂轮
Camshaft Grinding

曲轴偏芯磨砂轮
Camshaft Grinding

主要适用于压缩机曲轴偏芯部的磨削，外径250mm,钛合金基体。具有加工效率高、工件粗糙度好（RZ1.2-2.4）,寿命长(≥15000件)的优点。

- Shape:1A1. Diameter:250mm. Abrasive:CBN.
- Bond:Vitrified. Core:Titanium alloy.
- Feature:High grinding efficiency and precision (RZ1.2~2.4), durability (≥15000 pieces).



项目	单位	数据	项目	单位	数据
加工型号	/	曲轴	加工余量	mm	Φ0.283
材质	/	QT550/HT250	粗糙度	μm	Rz2.0
硬度	HB	180-260	加工节拍	s	17
使用有效直径	mm	Φ250-Φ240	修整间隔	/	800
砂轮转速	rpm	6100	精度	mm	尺寸公差：±0.0035
冷却液	/	水溶性切削液			圆柱度：0.004
					平行度：0.005

曲轴止推面砂轮
Crankshaft Grinding



曲轴止推面砂轮：主要适用于压缩机曲轴止推面的磨削，外径400mm，铝合金基体。具有自锐性好、精度高的优点。

- Shape:4A9. Diameter:400mm. Abrasive:CBN.
- Bond:Vitrified. Core:Aluminum alloy.
- Feature:High grinding efficiency and precision, self-sharpening.

项目	单位	数据	项目	单位	数据
加工型号	/	曲轴	加工余量	mm	0.1-0.15
材质	/	QT550/HT250	粗糙度	μm	Rz2.4
硬度	HB	180-260	加工节拍	s	14
使用有效直径	mm	53-50	修整间隔	/	400
砂轮转速	rpm	3600			平面度：0.003
冷却液	/	水溶性切削液	精度	mm	垂直度：0.005

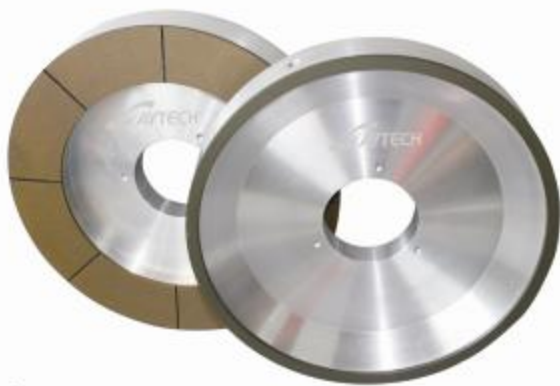
双端面磨砂轮
Double Grinding Disc

- 双端面磨金刚石/CBN砂轮，用于平行度和平面度要求非常高的零部件的加工，如轴承、齿轮、压缩机零部件、各类垫圈、油泵零件、汽车部件等，适用于铜、铝、铸铁、塑料、粉末金属及各种钢材等各种材料的精密加工。
- 砂轮特点：两片砂轮同时使用，双面加工，磨削效率高，工件精度高。
 - 外径：350 ~ 1200mm。
 - 结合剂：树脂、陶瓷。

- For the parts of bearing, gears, compressor, washers, Oil pump, Automobile, etc that must have parallel and flat surface areas, finished to critical tolerances. Almost any material can be ground in this fashion: brass, aluminum, cast iron, plastic, powdered metal and steels.
- Features:Grinding by two sides simultaneously, high production rate and precision.
 - Diameter:350 ~ 1200mm.
 - Bonds:resin、vitrified.

树脂双端面砂轮 Resin Bonded Double Grinding Discs

- 砂轮形状：6A2, 6A2T。
 - 砂轮应用：可用于压缩机、液压机、磁性材料、汽车配件等核心配件的双端面高精度磨削加工。
 - 砂轮特点：具有弹性好、强度高、耐冲击、不易堵塞、效率高、加工表面光泽度高、冷却效果好、不易烧伤等优点。
 - 被加工工件：精度高，平面度 $\leq 2\text{btm}$ ，平行度 $\leq 3\text{btm}$ ，粗糙度 $Ra \leq 0.2\text{btm}$ 。
- Shapes:6A2, 6A2T.
- Application:For the parts of Compressor, Hydrolic machines, Magnetic materials, Automobile, etc.
- Features:Free cutting, good elasticity, hight efficiency, without burning.
- Workpiece:Hight precision, Flatness $\leq 2\text{btm}$, Parrellelist $\leq 3\text{btm}$, Roughness $Ra \leq 0.2\text{btm}$.



双端面刀粒砂轮 Wheels for inserts

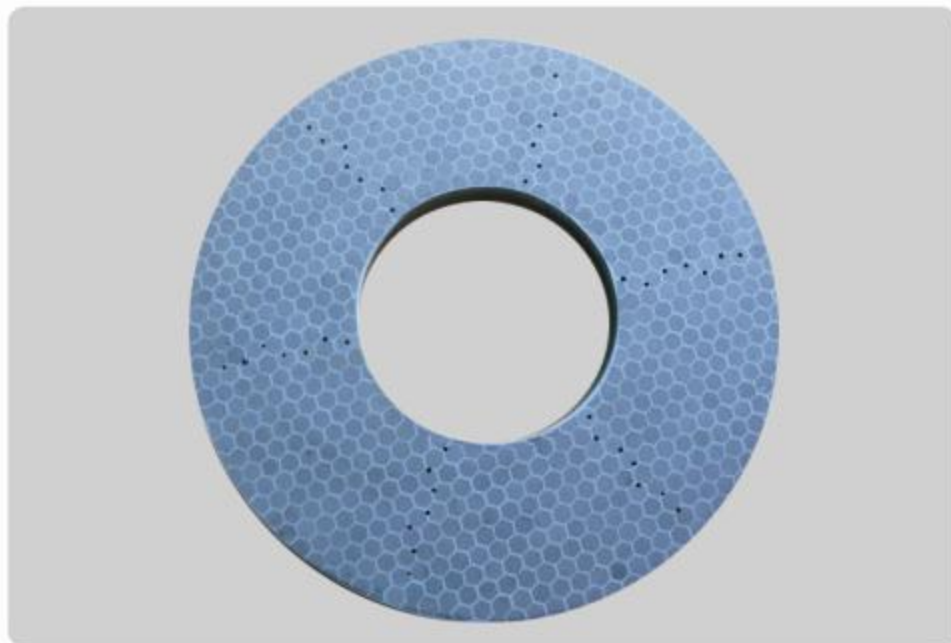
- 砂轮形状：6A2, 6A2T。
 - 结合剂：树脂结合剂。
 - 工件材料：硬质合金、陶瓷、金属合金陶瓷。
 - 加工设备：ATM, Melchiorre, Peter Wolters, Diskus, Viotto, Wendt.
 - 冷却介质：油，乳化液。
- Shapes:6A2, 6A2T.
- Bond:Resin.
- Workpieces:Carbide, Ceramic, Alloy-ceramics.
- Grinders:ATM, Melchiorre, Peter Wolters, Diskus, Viotto, Wendt.
- Coolant:Oil, emulsion.



陶瓷双端面砂轮 Vitrified Double Grinding Discs

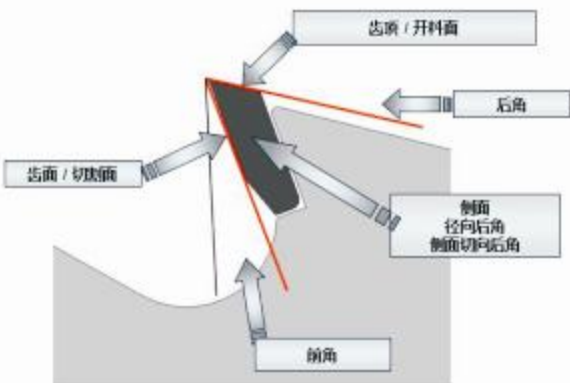
- 砂轮型号：6A2, 6A2T。
- 结合剂：陶瓷。
- 磨料：金刚石、CBN。
- 砂轮应用：硬质合金、粉末冶金、铸铁件、热处理钢件、陶瓷、金属陶瓷等，如压缩机活塞断面磨削，中间板断面磨削，滑片断面磨削，液压件断面磨削等。
- 砂轮特点：锋利性好，修整间隔长，寿命长，磨削效率高等。同普通磨料双端砂轮相比，陶瓷CBN双端砂轮的寿命可以提高20-100倍，修整间隔是普通磨料砂轮的10倍以上，工件平面度可达0.003mm。
- 砂轮尺寸范围： $\Phi 500-1020\text{mm}$ 。
- 应用设备：Peter Wolters、AM、STAHLI。

- Shapes：6A2，6A2T.
- Bond：vitrified.
- Abrasives：Diamond、CBN.
- Application:Grinding for Carbide,Powder metallurgy,Casting,Ceramics,Metal-ceramics,etc.for example, compressor piston, sliding vane, Hydraulic parts.
- Features：Good sharpness,long dressing intervals,long durability and high efficiency.The time is 20 to 100 times and dressing interval is 10 times compare to conventional grinding wheels,the flatness of workpiece can reach 0.003mm.
- Specifications：O.D：500-1020mm.
- Grinding：Peter Wolters、AM、STAHLI.



木工工具砂轮
Diamond/CBN Wheels for Woodworking

- 砂轮型号：1A1, 3A1, 4A2, 6A2, 12A2, 12V2, 12V9, 14A1, 14F1.
- 加工对象：硬质合金、金属陶瓷、PCD材料的圆锯片、带锯的前角、后角和侧面的数控刃磨及木工用钻头、铣刀及各类工具钢、合金钢刀具。
- 特点：砂轮锋利性好，磨削效率高，寿命长，加工工件的刃口质量优异、加工工件表面质量优异。
- Shapes:1A1, 3A1, 4A2, 6A2, 12A2, 12V2, 12V9, 14A1, 14F1.
- Workpieces: carbide, metal-ceramic, PCD circle and band saws and tools used in the woodworking, such as edging tools, drills, milling tools and other tools made by tool steel, alloy steels.
- Features: Free cutting, high efficiency, durability, good grinding quality.



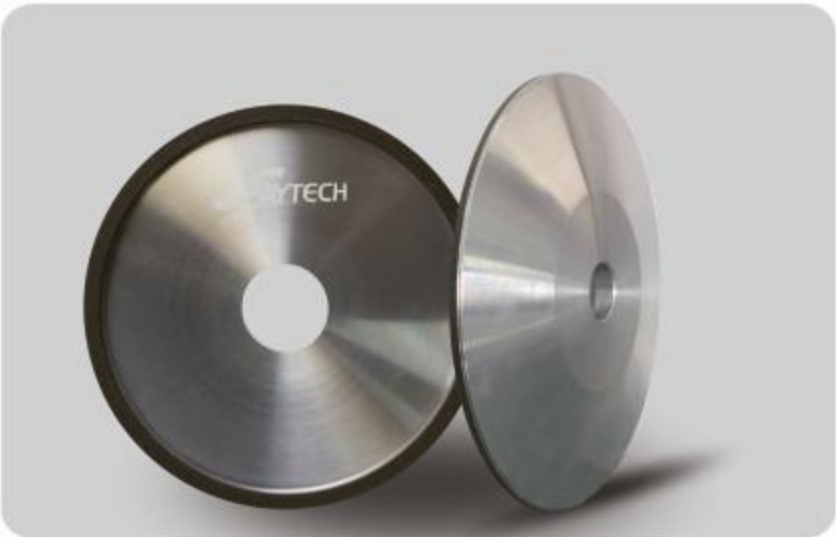
圆锯片砂轮 Diamond Wheels for Circle Saws

硬质合金圆锯片有三个部位需要磨削加工，齿前角，齿后角和齿两侧。不同部位需要以不同的砂轮在不同机器上完成。这些砂轮赛扬都能提供。

There are three parts, face, top and sides which need to be ground for the teeth of circle saw, and different parts need different wheels to grind on different machines. Saiyang can supply all the wheels for different applications.

前角砂轮 Wheels For Face Grinding

- 常用规格：125D-10T-32H-2W-2X 125D-13T-32H-3W-3X 150D-16T-32H-4.5W-2X 150D-10T-32H-6W-2X.
- 砂轮形状：4A2, 12V2, 12V9, 可按齿距大小选择。
- 磨料：金刚石。
- 常用粒度：400#, 600#.
- 结合剂：树脂。
- 工件材质：硬质合金齿。
- 冷却液：水冷，油冷。
- 设备：Vollmer、Woodtronic、Akemat、Widma.



- Specifications:125D-10T-32H-2W-2X 125D-13T-32H-3W-3X 150D-16T-32H-4.5W-2X 150D-10T-32H-6W-2X.
- Shapes:4A2, 12V2, 12V9 chosed by pitch.
- Abrasive:Diamond.
- Grits:400#,600#.
- Bond:Resin.
- workpiece:carbide teeth.
- Coolant:Water, Oil.
- Grinders:Vollmer、Woodtronic、Akemat、Widma.

木工工具砂轮
Diamond/CBN Wheels for Woodworking

后角砂轮 Wheels For Top Grinding

- 砂轮形状：12A2,6A9. 加工材质：硬质合金齿。
- 规格：125D-16T-32H-5W-6X, 125D-16T-32H-3W-6X.
- 结合剂：树脂结合剂。 磨料：金刚石。
- 常用粒度：325#, 400#, 120/320, 230/500, 325/600.
- 应用设备：Vollmer、Woodtronic、Akemat、Widma.
- 砂轮特性：砂轮锋利性好，磨削效率高。被加工工件平面度好。砂轮耐用度好、寿命长。砂轮能够同时进行粗加工和精加工，被加工工件的表面光洁度好。



- Shapes:12A2,6A9. Workpiece:Carbide teeth.
- Specifications:125D-16T-32H-5W-6X, 125D-16T-32H-3W-6X.
- Bond:Resin. Abrasives:Diamond.
- Grits:325#, 400#, 120/320, 230/500, 325/600.
- Grinders:Vollmer、Woodtronic、Akemat、Widma.
- Features:Good sharpening and high efficiency, durability, fit to coarse and fine grinding at same time, make workpiece a good flatness and roughness.

侧面砂轮 Wheels For Side Grinding

- 砂轮形状：1A1、3A1、14A1。 加工材质：硬质合金齿。
- 规格：80D-10T-32H-5W-5X,100D-10T-32H-5W-2X, 100D-10T-32H-5W-5X.
- 结合剂：树脂结合剂。 磨料：金刚石。
- 常用粒度：120#, 240#, 400#, 600#.
- 应用设备：Vollmer、Woodtronic、Akemat、Widma.
- 砂轮特性：砂轮锋利性好，磨削效率高，砂轮耐用度好、寿命长。



- Shapes:1A1、3A1、14A1. Workpiece:Carbide teeth.
- Specifications:80D-10T-32H-5W-5X,100D-10T-32H-5W-2X, 100D-10T-32H-5W-5X.
- Bond:Resin. Abrasives : Diamond.
- Grits:120#, 240#, 400#, 600#.
- Grinders:Vollmer、Woodtronic、Akemat、Widma.
- Features:Good sharpening and high efficiency, durability, fit to coarse and fine grinding at same time, make workpiece a good flatness and roughness.

仿形砂轮 Wheels For Profile Grinding

- 砂轮形状：14A1、14F1。
- 常用规格：200D-10T-32H-10W-2X, 200D-10T-32H-10W-5X, 225D-10T-60H-10W-2X, 225D-10T-60H-10W-3X.
- 常用粒度：120#, 240#, 320#, 500#, 600#.
- 加工材质：硬质合金齿。 应用设备：各种仿形磨齿机器。
- 砂轮特性：砂轮锋利性好，磨削效率高砂轮耐用度好，修整间隔长。被加工工件的表面光洁度好。



- Shapes:14A1、14F1.
- Specifications:200D-10T-32H-10W-2X, 200D-10T-32H-10W-5X, 225D-10T-60H-10W-2X, 225D-10T-60H-10W-3X.
- Grits:120#, 240#, 320#, 500#, 600#.
- Workpiece:Carbide teeth. Grinders:Profile Grinders
- Features:Good sharpening and high efficiency,durability, long dressing interval, workpiece in good quality.

木工工具砂轮
Diamond/CBN Wheels for Woodworking

PCD锯片陶瓷砂轮
Wheels For PCD Circle Saws

- 砂轮形状: 3A1, 12A2。磨料: 金刚石。常用粒度: W20,W28,W40。
- 结合剂: 陶瓷。设备: Vollmer。
- 应用: 12A2型125x18x32x6x8砂轮用于加工锯齿的后角。3A1型100x10x32x10x6砂轮用于加工锯齿的两个侧面。
- 砂轮优点: 锋利性好, 寿命高
- Shapes:3A1, 12A2。Abrasive:Diamond。Grits:W20,W28,W40.
- Bond:Vitrified。Grinders:Vollmer.
- Application:12A2-125x18x32x6x8 for the grinding of top , 3A1 100x10x32x10x6 for the grinding of two sides.
- Features:Sharpening and durability.



冷锯加工的砂轮
Wheels For Cold Saws

- 应用范围: 高速钢锯片开槽, 硬质合金冷锯分屑槽的开槽, 前角磨加工。
- 砂轮规格: 外径: 150、200mm, 环宽5~10mm,厚度0.3~4.0mm。
- 砂轮形状: 14A1,14F1。磨料: 金刚石, CBN。
- 结合剂: 树脂。加工材质: 硬质合金、高速钢。
- 砂轮特性: 磨削效率高、砂轮形状保持性好, 耐用度好, 使用寿命长。
- Application: Fluting and face grinding for HSS saws and cold saws.
- Specifications: O.D_150、200mm, Rim Depth_5~10mm, Thickness_0.3~4.0mm.
- Shapes:14A1,14F1。Abrasives:Diamond, CBN.
- Bond:Resin。Workpiece:Carbide, HSS, etc.
- Features:Good grinding efficiency and shape retention, durability.



木工刀具砂轮
Wheels For Woodworking Tools

- 应用范围: 用于木工锯片齿面的快速、经济加工。
- 规格: 外径80~150mm, 环宽1~10mm, 厚度2~10mm。
- 结合剂: 树脂结合剂。磨料: 金刚石。设备: 孚尔默CP200\CHU, Vollmer。
- 应用参数: 加工硬质合金圆锯片(板式锯) 300D-96T 砂轮线速度22m/s 最大切削进给0.15mm。
- 砂轮特点: 独特的几何结构使其在加工窄小齿间距锯片时具有显著优势,多种规格能满足所有锯片自动研磨机。磨削时间短、效率高,磨削刃面平整、使用寿命长。
- Application:Used for the quick and economic grinding.
- Specifications:O.D_80~150mm, Rim depth_1~10mm, Thickness_2~10mm.
- Bond:Resin。Abrasives:Diamond。Grinders:CP200\CHU, Vollmer.
- Parameters:At the speed 22m/s with the feed depth 0.15mm for the grinding of carbide circle saw 300D-96T.
- Features:Fit to the grinding of narrow gaps, different wheels can be chosed for different grinders with high grinding efficiency and durability.



用于切断的金刚石、CBN砂轮
Diamond/CBN Wheels for Cutting

金刚石和CBN切割砂轮,主要用于石英、玻璃、LED、硬质合金、复合材料、陶瓷以及高速钢、合金钢等材料的切割加工。分为树脂结合剂和金属结合剂两种。

- 金刚石切割砂轮特点: 适用于非金属材料及非铁族金属材料的切割加工。
- CBN切割砂轮特点: 适用于含铁金属材料、合金材料及复合材料的切割加工。
- 树脂结合剂切割砂轮特点: 切割锋利, 效率高。
- 金属结合剂切割砂轮特点: 强度高、刚性好、使用寿命长。

There are two kinds of cutting wheels, diamond and CBN cutting wheels with two different bonds, resin bond and metal bond.

Diamond cutting wheels are suitable for the cutting of tungsten carbide, Quartz, Glass, LED, ceramic, etc. with the characteristics of free cutting and high efficiency.

CBN cutting wheels are suitable for the cutting of HSS, Alloy steel, Composite materials, etc. with the characteristics of high strength, good rigidity and long life.

树脂结合剂金刚石/CBN切割砂轮
Resin Bonded Diamond/CBN Cutting Wheels

- 型号: 1A8, 1A1R。
- 应用范围: 用来切割石英、硬质合金、模具钢等棒材的切断。
- 砂轮规格: 外径: 10~500 mm, 环宽2~15 mm,厚度0.3~4.0 mm。
- 磨料: 金刚石或者CBN。
- Types:1A8, 1A1R.
- Abrasives:diamond or CBN.
- Speifications:O.D: 10~500 mm, Rim depth: 2~15 mm,
- Thickness:0.3~4.0 mm.
- Applications:suitable for the cutting of tungsten carbide, Quartz, mould steel, etc.



金属结合剂金刚石或CBN切割砂轮
Metal Bonded Diamond/CBN Cutting Wheels

- 型号: 1A8, 1A1R。
- 外径: 40~200mm。
- 薄度: 最薄可做到0.05mm。
- Types:1A8, 1A1R.
- Diameter:40~200mm.
- Thickness:Up to 0.05mm.



金属结合剂组合砂轮
Group Cutting Wheels

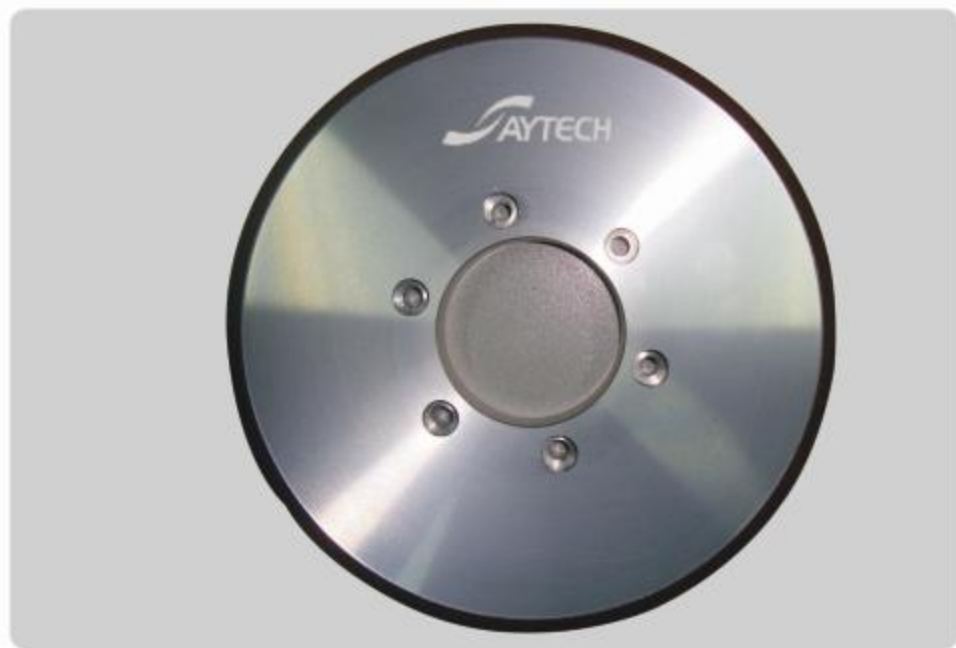
- 超薄超精, 良好的刚性和精密度, 可用于深度切割和强力切割。
- Metal bonded diamond wheels, ultra thin and precision, group application, excellent rigidity and accuracy, for deep and strong cutting.



微钻行业砂轮
Diamond/CBN Wheels for Micro-drills

- 此类砂轮用于精密加工棒料直径小，开槽深度浅的硬质合金和高速钢微钻。其特点是：锋利性好、形状保持优异、砂轮修正间隔时间长、加工出的工件表面光洁度优异等。
- 加工对象：整体硬质合金、不锈钢焊接式PCB加工用微型铣刀、钻头的磨削。
 - 砂轮种类：无心磨砂轮，段差砂轮，开槽砂轮。
 - 砂轮形状：1A1、3A1、14A1等。
 - 砂轮规格：各种尺寸均可以定做。
 - 磨料种类：金刚石，CBN。
 - 结合剂：树脂结合剂。
 - 砂轮特点：砂轮的耐用度好，修正间隔长，形状保持优。刀具刃口缺陷少。

- These resin bonded diamond and CBN wheels are used for the precision grinding of tungsten carbide and HSS micro drills with little diameter and shallow slots with the characteristics of free grinding, good shape-holding, less dressing and excellent workpiece finishing.
- Workpiece: Solid carbide and welded SS micro milling tools and drills.
 - Wheels: Centerless, stages and fluting.
 - Shapes: 1A1、3A1、14A1,etc.
 - Specifications : As requested.
 - Abrasives: Diamond, CBN.
 - Bonds: Resin.
 - Features of wheels: Good shape holding, long dressing interval, free edge and good durability.

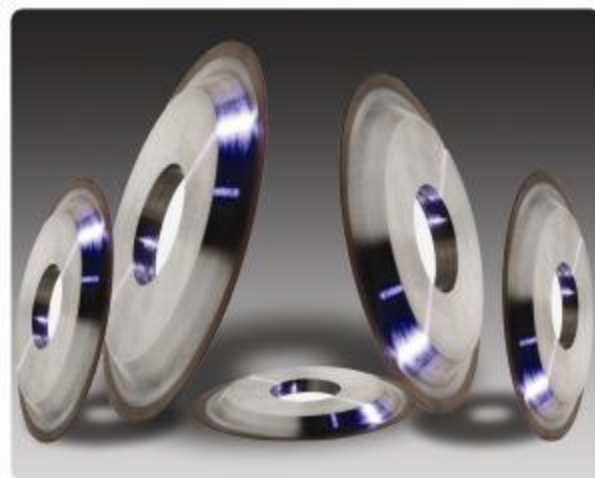


模具行业砂轮
Diamond/CBN Wheels for Molds and Die

- 加工对象：硬质合金，高速钢等。用于加工精度高的曲面，平面，高精度零件的槽，内外R，形状复杂而且尺寸要求高的模具零部件等。
 - 特点：砂轮线速度高、跳动小、锋利性好、自锐性好、寿命长，尖角形状保持好。
- Workpieces:Tungsten steel, carbide, HSS, etc.
 - Application:For the grinding of curved surface, slots and grooves of high precision parts, arcs and radius of some complicated tools and cutters.
 - Features:High speed grinding, little run-out, free cutting, self-sharpening, durability and good shape retention.



PG砂轮 Wheels For PG Grinding



- 砂轮形状：3A1, 14A1, 4B1。
 - 外径：Φ65-Φ180mm。
 - 厚度：0.3mm ~ 2.0mm。
 - 角度：5°- 12°。
 - 磨料：金刚石，CBN。
 - 结合剂：树脂，金属。
 - 应用范围：针对精密模具零部件、精密冲头、精密刀具进行的研削、仿削、曲线研削精修等等的精密加工。金刚石砂轮用来加工钨钢、陶瓷合金、陶瓷等超硬材料及其它难切削硬脆材料等。立方氮化硼砂轮用来加工SKS、SKH、SKD、不锈钢等高硬度铁系材料。
 - 应用设备：WAIDA、WASINO、DOEBELI&PETEWE。
 - 砂轮特点：砂轮锋利性好、跳动小，砂轮形状保持好，切槽直，被加工工件R角小。
 - 加工方式：纵向往复进刀(干磨)。
 - 加工参数：转速8000—10000 rpm。
- Shape:3A1, 14A1, 4B1.
 - Diameter:Φ65-Φ180mm.
 - Thickness:0.3mm ~ 2.0mm.
 - Angle:5°- 12°.
 - Abrasive:Diamond, CBN.
 - Bond:Resin,Metal.
 - Application:For the polishing, curved and profile grinding of precision moulds and dies, punches, tools and cutters.
 - Grinders:WAIDA、WASINO、DOEBELI&PETEWE.
 - Features:High speed grinding, little run-out, free cutting, self-sharpening, durability and good shape retention, small angle.
 - Process:Dry grinding with reciprocating feed.
 - Parameter:8000 ~ 10000RPM.

模具行业砂轮
Diamond/CBN Wheels for Molds and Die

外圆磨砂轮 Wheels For Cylindrical Grinding

- 砂轮形状：1A1, 3A1, 14A1。
 - 可做粒度：#80 ~ #3000。
 - 磨料种类：SDC, CBN。
 - 结合剂：树脂结合剂。
 - 加工对象：主要用于硬质合金、高速钢、铸铁及高硬度铁系等材料的加工。
 - 加工设备：外圆磨床。
 - 砂轮特点：砂轮的锋利性好，修整间隔长，砂轮寿命长。
-
- Shapes：1A1, 3A1, 14A1.
 - Grits：#80 ~ #3000.
 - Abrasive：SDC , CBN.
 - Bond：Resin.
 - Workpieces: carbide,HSS, cast iron and other hardened steels.
 - Grinders: General cylindrical grinders.
 - Features: Sharpening, long dressing interval, durability.



坐标磨砂轮 Wheels For Jig Grinding

- 砂轮形状：1A1W(电镀)。
 - 外径：φ2.5mm-φ30mm。
 - 柄径：φ3mm,φ4mm,φ6mm,φ8mm, φ10mm。
 - 磨料种类：CBN。
 - 结合剂：电镀结合剂。
 - 应用范围：各种模具钢。
 - 设备：美国摩尔MOORE、瑞士豪泽HAUSER、国产咸阳机床等。
 - 砂轮特点：砂轮的锋利性好，砂轮寿命长。
 - 加工方式：上下往复研磨(干/湿磨)。
-
- Shape:1A1W.
 - Diameters:φ2.5mm - φ30mm.
 - Bars:φ3mm,φ4mm,φ6mm,φ8mm, φ10mm.
 - Abrasive:CBN.
 - Bond:electroplated.
 - Grinders:MOORE、HAUSER , etc.
 - Features:Sharpening, precision and durability.
 - Process:Dry or wet grinding with reciprocating feeds.
 - Parameter:Over 20000RPM (coarse and fine grinding).



钻石加工砂轮
Vitrified Diamond Wheels for Diamonds and Sapphire

该砂轮主要用于天然钻石腰部和底部的粗磨、精磨加工，以及水晶玻璃和激光晶体的磨削加工。具有寿命长、磨削锋利且无需修整，光洁度高的优点。

This vitrified diamond wheels are used for the grinding, polishing of natural diamonds, crystal glass and laser crystal as well as sapphire. Durability, free cutting, good finishing without dressed.

磨边砂轮 Wheels For Girdle Grinding

- 砂轮形状：1A1。
 - 砂轮规格：170X10X32X14。
 - 磨料：金刚石。
 - 结合剂：陶瓷。
 - 应用：主要用于加工钻石的腰部。适用于粗磨、精磨以及粗精一体磨削，可加工0.01-5克拉的钻石。
 - 粒度：粗磨#270, 精磨#1000 ~ #3000,粗精一体#800 ~ #1000。
 - 主要优点：加工效率高，钻石光洁度高。
-
- Shape:1A1.
 - Size:170X10X32X14.
 - Abrasive:Diamond.
 - Bond:Vitrified.
 - Application:Mainly used for the girdle' s coarse and fine grinding of diamonds.
 - Grits:Coarse grinding #270, Fine grinding #1000 ~ #3000, Coarse and Fine #800 ~ #1000.
 - Features:High grinding efficiency and high grinding precision with excellent roughness.

磨底砂轮 Wheels For Pavilion Grinding

- 砂轮形状：1A1。
 - 砂轮规格：200X15X32X15。
 - 磨料：金刚石。
 - 结合剂：陶瓷。
 - 应用：主要用于钻石原石切割后的底部加工，一般用于粗磨。
 - 粒度 Grits: #170 ~ #800, 优先推荐 #270。
 - 主要优点：加工效率高，寿命长。
-
- Shape:1A1.
 - Size:200X15X32X15.
 - Abrasive:Diamond.
 - Bond:Vitrified.
 - Application:Mainly used for the coarse grinding of bottom of diamonds.
 - Grits:#170 ~ #800, #270 suggested.
 - Features:High grinding efficiency and durability, no chipping happened.



硅片减薄砂轮 Thinning or back grinding Wheel

- 陶瓷结合剂金刚石砂轮，用于硅片减薄及蓝宝石晶片等的磨削加工。砂轮锋利性好、加工效率高、耐用度高、使用寿命长、工件的平行度与平面度稳定性好。
- 砂轮形状：6A2, 6A2T。
 - 磨料种类：金刚石。
 - 结合剂：陶瓷结合剂。
 - 砂轮特点：砂轮锋利性好，磨削效率高，被加工工件表面纹路一致，无崩边、划伤现象。性价比高，能替代进口产品。
 - 配套机床：SHUWA SGM-6301, NTS Nano Surface-180G, NTS Nano Surface 250/NC-VDM, WEC。



- Vitrified diamond wheels for the thinning and finishing of silicon wafer and sapphire. Quality stability, Free Cutting.
- Types: 6A2, 6A2T.
 - Abrasive: Diamond.
 - Bond: Vitrified.
 - Features: Sharpening, high efficiency and precision without chipping and scratching, reasonable price, replace the wheels imported.
 - For the Machines: SHUWA SGM-6301, NTS Nano Surface-180G, NTS Nano Surface 250/NC-VDM, WEC.

硅片倒角砂轮 Chamfering of wafer



- 砂轮形状：6A2。
 - 砂轮特点：砂轮锋利性好，形状保持性优越，加工后的工件表面粗糙度低，工件无划伤、崩边现象。
 - 结合剂：树脂结合剂。
 - 应用范围：磨削硅片的棱角。
 - 砂轮规格：外径：100~250mm，环宽2~10mm，厚度5~10mm。
 - 磨料：金刚石。
 - 结合剂：树脂结合剂。
- Type: 6A2.
 - Features: Free of cutting, High precision, no chipping and scratching.
 - Bond: Resin.
 - Applications: Chamfering of wafer.
 - Specifications: O.D_100 ~ 250mm, rim width_2 ~ 10mm, Thickness_5 ~ 10mm.
 - Abrasives: Diamond.
 - Bond: Resin.

切断砂轮 Cut Off Wheels

超薄超精切割刀片，树脂结合剂、金属结合剂和电铸结合剂，用于硅片、磁头、IC、LSI、复合材料、光学纤维等的精密切割加工。

Diamond/CBN blades resin bonded, metal bonded and electrodeposit for the precision cutting of wafer, magnetic head, IC, LSI, optical fiber, etc. resin, metal and electroformed bonds.



磨边砂轮 Edging Wheels

- 主要特点：砂轮槽型一致性高，互换性好、加工精度高、锋利性好，使用寿命长，噪音小。可以保证被加工产品的尺寸要求，不崩边、不崩角。
- 应用范围：主要用于各种玻璃及制品的磨边加工，包括普通玻璃、微晶玻璃、光伏玻璃、PDP玻璃、LCD。
- 结合剂：金属结合剂。

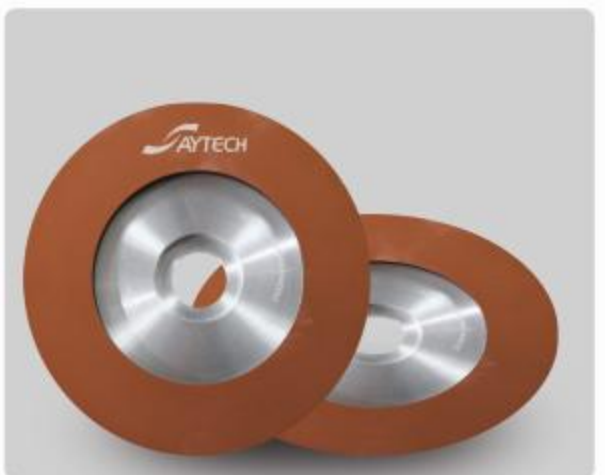
- Features: Good repeatability and interchangeability, high precision and sharpening, low noisy and no chipping.
- Applications: For the grinding of all glasses, such as general glass, micro-crystalline glass, PV glass, DPD and LCD.
- Bond: Metal.



抛光砂轮 Polishing Wheel

- 砂轮形状：6A2。
- 特点：砂轮磨削效率高，被加工工件表面品质优，表面光亮度高。砂轮最细能够达10000#。
- 磨料种类：金刚石。
- 结合剂：树脂结合剂。
- 应用范围：用来抛光硅片、蓝宝石晶片等高精度材料。
- 砂轮规格：外径：150mm、200mm。环宽：20mm~50mm。厚度6mm。

- Type: 6A2.
- Features: High efficiency and high precision, grit up to #10000.
- Abrasive: Diamond.
- Bond: Resin.
- Applications: Silicon, sapphire wafer polishing.
- Specifications: O.D_150mm、200mm, Rim width_20 ~ 50mm, Thickness_6mm.



金刚石和CBN砂轮使用速度推荐（一般应用）			Recommended Wheel Speeds for Diamond and CBN Wheels(for general applications)	
结合剂种类（Bond）		冷却条件（Coolant）	砂轮速度（m/s）	
青铜 （Bronze）		干磨(Dry)	12~18	
		湿磨(Wet)	15~22	
树脂 （Resin）		干磨(Dry)	15~20	
		湿磨(Wet)	18~25	
陶瓷外圆 （Vitrified for external grinding wheel）		湿磨(Wet)	45~160	
陶瓷内圆 （Vitrified for internal grinding wheel）		湿磨(Wet)	30~65	
双端面（Double disc）		湿磨(Wet)	20~1500（rpm）	
磨削形式 （Grinding method）		金刚石砂轮(湿磨)（m/s） Diamond wheel for wet	CBN砂轮(m/s)	
			干磨(Dry)	湿磨(Wet)
平面磨削(Surface Grinding)		20~30	25~30	28~35
外圆磨削（Cylindrical grinding）		20~30	25~30	30~40
内圆磨削（Internal grinding）		12~15	17~25	18~28
工具磨削（Tool grinding）		12~20	15~25	18~28

主要国家磨料粒度对照表												
Synthetic Diamond Grain Mesh Size Comparison Chart												
International Sdanard ISO			FEPA		USA		JAPAN		Theoretical Basic Size		RUSSIA	
					ANSI B74.16-1971		JIS4130-1998				9206-80	
Grain No.	Grain No.	Grain Size	Grain No.	Grain Size	Grain No.	Grain Size	Grain No.	Grain Size	Grain No.	Grain Size	Grain No.	Grain Size
											500/400	500/400
427	40/50	425/300	B/427	355/300	40/50	425/300	40/50	425/300	0.015	0.378	400/315	400/315
301	50/60	300/250	B/301	300/250	50/60	300/250	50/60	300/250	0.011	0.288		
252	60/80	250/180	B/252	250/180	60/80	250/180	60/80	250/180	0.009	0.226	250/200	250/200
181	80/100	180/150	B/181	180/150	80/100	180/150	80/100	180/150	0.0069	0.174	200/160	200/160
151	100/120	150/125	B/151	150/125	100/120	150/125	100/120	150/125	0.0058	0.148	160/125	160/125
126	120/140	125/106	B/126	125/106	120/140	125/106	120/140	125/106	0.0048	0.123	125/100	125/100
107	140/170	106/90	B/107	106/90	140/170	106/90	140/170	106/90	0.0041	0.103	100/80	100/80
91	170/200	90/75	B/91	90/75	170/200	90/75	170/200	90/75	0.0034	0.866	80/63	80/63
76	200/230	75/63	B/76	75/63	200/230	75/63	200/230	75/63	0.0030	0.075		
64	230/270	63/53	B/64	63/53	230/270	63/53	230/270	63/53	0.0026	0.066	63/50	63/50
54	270/325	53/45	B/54	53/45	270/325	53/45	270/325	53/45	0.0022	0.057	50/40	50/40
46	325/400	45/38	B/46	45/38	325/400	45/38	325/400	45/38	0.0019	0.048		

砂轮转速换算表

Conversion between M/S and RPM

砂轮直径		线速度 Speed（M/S）								
Diameter		15	20	25	30	35	40	45	60	80
寸inch	毫米mm	每分钟转数 RPM								
1"	25	11500	15300	19100	23000	26750	30550	34370	45840	61000
1 1/2"	40	71600	9550	11940	14320	16700	19100	21500	28700	38200
2"	50	5730	7650	9550	11450	13400	15275	17185	22900	30500
2 1/2"	65	4400	5900	7350	8800	10300	11750	13200	17600	23500
3"	75	3825	5100	6380	7650	9000	10185	11455	15300	20400
3 1/2"	90	3185	4245	5300	6370	7430	8490	9560	12750	17000
4"	100	2865	3825	4775	5730	6700	7640	8600	11450	15300
4 1/2"	115	2490	3320	4150	4980	5815	6640	7470	9965	13300
5"	125	2300	3035	3800	4600	5300	6110	6875	9200	12200
6"	150	1900	2550	3200	3800	4450	5100	5730	7640	10200
7"	175	1635	2200	2730	3270	3800	4365	4910	6550	8950
8"	200	1440	1910	2390	2875	3350	3820	4300	5730	7640
9"	225	1275	1700	2100	2550	2975	3395	3820	5100	6840
10"	250	1150	1525	1900	2300	2675	3050	3440	4575	6100
12"	300	950	1275	1590	1900	2230	2550	2865	3820	5100
14"	350	820	1090	1370	1640	1900	2180	2450	3275	4360
16"	400	725	960	1200	1450	1675	1910	2150	2870	3820
18"	450	635	850	1060	1275	1485	1700	1910	2550	3400
20"	500	575	770	960	1150	1340	1525	1720	2290	3050
22"	550	515	700	850	1030	1200	1390	1565	2080	—
24"	600	475	640	800	950	1110	1295	1430	1910	—
26"	650	440	590	730	875	1030	1175	1320	1750	—
28"	700	405	540	675	810	950	1090	1225	1640	—
30"	750	380	510	635	765	890	1020	1145	1530	—
32"	800	360	475	600	715	835	955	1075	1435	—
34"	850	340	450	565	675	790	900	1010	—	—
36"	900	320	425	530	640	750	850	955	—	—
38"	950	300	400	500	600	700	805	905	—	—
40"	1000	285	380	480	570	670	765	860	—	—
42"	1050	275	365	455	550	640	—	—	—	—
44"	1100	260	350	430	520	600	—	—	—	—