

NORTON



38A White Aluminum Oxide



37C Black and 39C Green Silicon Carbide



32A Light Gray Aluminum Oxide



32AA Gray Aluminum Oxide



5SG Blue Seeded Gel Ceramic

Abrasive Toolroom Grinding Wheels

Typical applications: surface grinding, tool and cutter grinding, drill and tool sharpening, and cylindrical grinding. Use coarser grit sizes (46-60) for heavy stock removal. Use finer grit sizes (120-220) for finishing applications.

38A WHITE ALUMINUM OXIDE

Value-priced for cool, fast tool reconditioning. Ideal for light grinding on all tool steels. 38A friable abrasive grain provides cool, burn-free cutting. VBE bond yields consistency and excellent wheel balance.

37C BLACK AND 39C GREEN SILICON CARBIDE

The ideal choice for grinding non-ferrous metals, carbides, and cast irons, and for dressing diamond and CBN wheels. 39C is extremely sharp, high purity silicon carbide engineered for non-ferrous and non-metallic materials. Use small diameter 37C wheels for dressing diamond and CBN wheels.

32A LIGHT GRAY ALUMINUM OXIDE

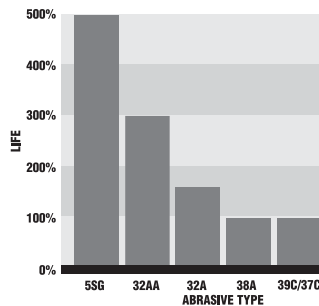
The benchmark abrasive used in the toolroom. Sharp monocrystalline abrasive grain is form holding and free cutting. Use induced porosity (32A-VBEP) for less heat generation. VBE bond yields consistency and excellent wheel balance.

32AA GRAY ALUMINUM OXIDE

A blend of TG ceramic aluminum oxide and 32A abrasive grains. Offers broad versatility. VTR bond system yields better part tolerance and form holding. TG abrasive grain draws less power, is freer cutting, and reduces burn.

5SG BLUE SEEDED GEL CERAMIC

Designed for maximum productivity and versatility, lowering total-per-part grinding costs. Fast stock removal rates—2X faster than conventional abrasives. 3-5 times more wheel life than aluminum oxide abrasive. Use induced porosity (5SG-VSP) for less heat generation. This patented wheel is used for D2, M, T, A, or S series steels and other high temperature alloys. 5SG-VSP with induced porosity for less heat generation. For maximum performance, dress with SG diamond tools.



PROBLEM:

TROUBLESHOOTING GUIDE
POSSIBLE CAUSES:

SUGGESTED CORRECTION:

Not holding form

Incorrect wheel dressing
Wheel too coarse
Wheel too soft
Worn machine bearings
Wrong wheel structure

Dress wheel finer
Use finer grit
Use harder grade
Check for run-out and correct
Use non-porous wheel

Burning of workpiece

Worn dressing tool
Poor coolant flow
Wheel acting hard
Work speed too slow
Infeed too fast

Inspect, rotate or replace dressing tool
Increase/direct coolant flow to contact area
Dress wheel coarser, use softer wheel grade, or use a porous wheel
Increase work speed
Reduce stock removed per pass or upgrade to 32AA or 5SG

Poor surface finish or quality of grind

Incorrect wheel dressing
Worn dressing tool
Dirty coolant
Wheel too coarse
Wheel too hard

Redress more frequently or increase/decrease dress traverse rate
Inspect, rotate, or replace dressing tool
Filter coolant or replace with new
Use finer grit
Use softer grade