

BONDED ABRASIVES

CYLINDRICAL GRINDING WHEELS



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ABOUT CYLINDRICAL GRINDING WHEELS

CUMI's versatile range of cylindrical wheels are used for a variety of grinding operations that require size generation, fine surface finish and fast stock removal. Special wheels are also available for multiple diameters and shoulder grinding with pre-formed wheel faces.

CUMI's cylindrical grinding wheels find wide application in the grinding of valves, plunger pins, eye bolts, transmission shafts, cam shafts, crank shafts etc.,

FEATURES:

- Best choice of abrasive grain wheels for higher stock removal, higher productivity and form retention
- Customizes sketches for every customer requirement
- Wide range of bond system to customize individual grinding needs



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ADVANTAGES OF CUMI WHEELS



1. High stock removal
2. Better productivity
3. Excellent surface finish
4. Lower dressing frequency
5. Burn free component

CUMI Code	Grit Range	Diameter		Thickness		Hardness	Structure	Speed
		mm	inch	mm	inch			
CN	46 - 120	300 - 600	12 - 26	25-150	1-6	H - M	6 - 13	35, 50 & 63
CUMISA/CSA				25 - 150	1 - 6	H - M	6 - 13	35, 50 & 63
SBA				25 - 250	1 - 10	H - M	5 - 8	35 & 50
50A				25 - 150	1 - 6	H - M	6 - 13	35 & 50
RA				25 - 150	1 - 6	H - M	5 - 8	35 & 50
55A				25 - 150	1 - 6	H - M	5 - 8	35, 50 & 63
AA				25 - 250	1 - 10	H - M	5 - 8	35, 50 & 63
DA				25 - 150	1 - 6	H - M	5 - 8	35 & 50
A				25 - 150	1 - 6	H - M	5 - 8	35 & 50
CGC				25 - 150	1 - 6	H - M	5 - 8	35 & 50
GC				25 - 150	1 - 6	H - M	5 - 8	35 & 50
C				25 - 150	1 - 6	H - M	5 - 8	35 & 50

SHAPES



COMMONLY USED MACHINES

- Schaudt
- Landsl
- Paragon
- Palmay
- Studer
- Junker
- NTC
- Micromatic
- T-Sugami
- Shigya
- Okamoto
- Okuma

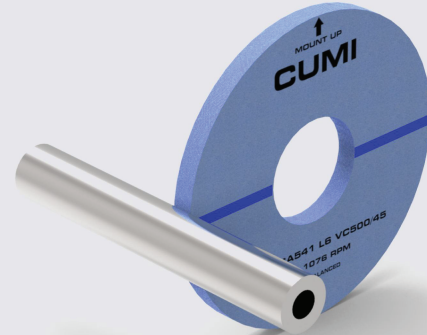
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HIGH SPEED STEEL

Hardness	Speed	Best	Better	Good
Low content Vanadium & Molybdenum	35	1CUMISA60 J6 VC500	RAA60 J5 VF8	AA60 K5 V8
	50	1CN60 J6 VC500/50	RAA60 J5 VF8/50	AA60 K5 V50
High content Vanadium & Molybdenum	35	1CUMISA601 H12 VCA2	RAA601 H10 V736	AA601 H10 V736
	50	1CN601 G12 VCA2/50	RAA601 G10 V736/50	AA601 G10 V736/50

TUNGSTEN CARBIDE

Hardness	Speed	Best	Better	Good
For all HRC	35	GC60 K5 VG	CGC60 K5 VG	C60 K5 VG
	50	GC60 J5 VS2110/50	CGC60 J5 VS2110/50	C60 J5 VS2110/50



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4

GENERAL PURPOSE

Hardness	Speed	Best	Better	Good
< 40 HRC	35	AA463 M5 V2016	DA463 M5 V10	A463 M5 V10
	50	1CUMISA541 L6 VC500/50	5SA463 L5 V500/50	DA463 M5 V50
	63	1CUMISA541 L6 VC500/60	AA463 L5 V60	5SA463 L5 V500/60
50 HRC to 60 HRC	35	AA463 K5 V2016	DA463 K5 V10	A463 K5 V10
	50	1CUMISA541 J6 VC500/50	5SA463 J5 V500/50	DA463 K5 V50
	63	1CN541 J6 VC500/60	AA463 J5 V60	5SA463 J5 V500/60

CAST IRON

Hardness	Speed	Best	Better	Good
< 40 HRC	35	GC463 N5 VG	-	-
	50	GC463 N5 VS2110/50	-	-
	63	-	-	-
50 HRC to 60 HRC	35	GC463 L5 VG	-	-
	50	GC463 L5 VS2110/50	-	-
	63	-	-	-

STEEL

Hardness	Speed	Best	Better	Good
< 40 HRC	35	AA463 M5 V2016	SBA463 M5 V10	A463 M5 V10
	50	1CUMISA541 K6 VC600/50	5SA463 L5 V500/50	DA463 M5 V50
	63	1CUMISA541 K6 VC600/60	5SA463 L5 V500/60	AA463 L5 V60
50 HRC to 60 HRC	35	53MA541 J7 VC500/50	5SA463 K5 V500	AA46/54 K5 V8
	50	53MA541 J7 VC500/50	5SA463 K5 V500/50	AA46/54 K5 V50
		1CUMISA541 J6 VC600/50	5SA463 J5 V500/60	AA54 J5 V60
	63	53MA541 J7 VC500/60		
		1CN541 J6 VC600/60		

STAINLESS STEEL 300 SERIES

Operation	Speed	Best	Better	Good
Rough	35	GC463 K5 VG	CGC463 K5 VG	AC463 K5 VG
Finish		GC80 J5 VG	CGC80 J5 VG	C80 J5 VG
Rough	50	GC463 K5 VS2110/50	CGC463 K5 VS2110/50	C463 K5 VS2110/50
Finish		GC80 J5 VS2110/50	CGC80 J5 VS2110/50	C80 J5 VS2110/50
	Upto 35		GC60 J11 VR	
Rough	35	1CUMISA461 J6 VC500	RAA46/54 J5 VF8	AA46/54 K5 V8
Finish		1CUMISA801 J6 VC500	RAA80 J5 VF8	AA80 J5 V8
Rough	50	1CUMISA461 J6 VC500/50	RAA46/54 J5 VF8/50	AA46/54 K5 V50
Finish		1CUMISA801 J6 VC500/50	RAA80 J5 VF8/50	AA80 J5 V50
	Upto 50 MPS	1CUMISA461 H12 V736/50	RAA461 H10 V736/50	AA461 H10 V736/50

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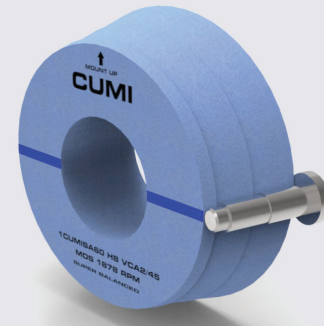
5

SOFT STEEL (< 40 HRC)

Operation	Speed	Area of Contact	Best	Better	Good
Rough	35	<= 10 mm	AA46/54 L5 V8	DA 463 K5 V10	A463 K5 V10
			AA46/54 L5 V50	DA 463 K5 V50	A463 K5 V50
	50	> 10 mm	AA46/54 J7 V8	DA463 J7 V10	A463 J7 V10
			AA46/54 J7 V50	DA463 J7 V50	A463 J7 V50
Finish	35	<= 10 mm	AA60 K5 V8	DA60 K5 V10	A60 K5 V10
			AA60 K5 V50	DA60 K5 V50	A60 K5 V50
	50	> 10 mm	AA60 I7 V8	DA60 I7 V10	A60 I7 V10
			AA60 I7 V50	DA60 I7 V50	A60 I7 V50

HARD STEEL (> 40 HRC)

Operation	Speed	Area of Contact	Best	Better	Good
Rough	35	<= 10 mm	1CUMISA60 H8 V736	53A60 H8 VCA2 RA60 K5 VF8	AA60 H8 V736
			1CN60 H8 V736/50	53A60 H8 VCA2/50 RA60 J5 VF8/50	AA60 H8 V736/50
	50	> 10 mm	1CUMISA60 H10 V736	53A60 H10 VCA2 RA60 K5 VF8	AA60 H10 V736
			1CN60 H12 V736/50	53A60 H12 VCA2/50 RA60 J5 VF8/50	AA60 H12 V736/50
Finish	35	<= 10 mm	1CUMISA80 H8 V736	53A80 H8 VCA2 RA80 K5 VF8	AA80 H8 V736
			1CN80 H10 V736/50	53A80 H10 VCA2/50 RA80 J5 VF8/50	AA80 H10 V736/50
	50	> 10 mm	1CUMISA80 H12 V736	53A80 H12 VCA2 RA80 K5 VF8	AA80 H12 V736
			1CN80 H13 V736/50	53A80 H13 VCA2/50 RA80 J5 VF8/50	AA80 H13 V736/50





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