Data Sheet

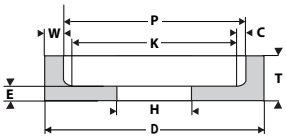
Item
318

1. Product description:

Vitrified Straight Cup Grinding Wheel

Dimensions (in):	6" x 2" x 1-1/4"
Dimensions (mm):	150 x 50 x 31.75
Abrasive:	Aluminum Oxide
Specification:	89A60K5VA1
Grit:	60
Grade:	K
Max. rpm:	5,100
Line:	89A Orange
Max. speed:	40 m/s

Type 6



D =	**150**	**mm**
T =	**50**	**mm**
H =	**31.75**	**mm**
W=	**10**	**mm**
E=	**16**	**mm**

Carbon Steel | High-Speed Steel | Tool Steel

Certification

This cup is certified by the Organization for the Safety of Abrasives.

1. Application

Surface Grinder

Tool Grinder

• Recommended for sharpening cutting tools made of carbon steel, high-speed steel (HSS), and tool steel.
• VA1 bond (orange) provides excellent wheel profile retention.
• Suitable for sharpening cutters, milling cutters, drill bits, and other steel tools.

2. Operating instructions

• For use with a surface grinder or tool grinder.
• Visually inspect the cup wheel before mounting.
• Ensure that the grinder's operating speed does not exceed the maximum RPM indicated on the cup wheel.
• Make sure the cup wheel is properly mounted and firmly seated against a straight relieved flange.
• Mount the cup wheel and run it at no load for one minute to verify that it is free from damage.
• For operations using coolant, start the wheel before turning on the coolant flow.
• At the end of the operation, turn off the coolant flow before stopping the cup wheel.
• Use only on properly anchored machines that are in good operating condition.

3. Safety information

• Never exceed the maximum operating speed indicated on the product label.
• Always use the machine's safety guards.
• Always wear appropriate personal protective equipment (PPE), including gloves, hearing protection, a dust mask, and safety glasses.
• Do not use a cup wheel that has been dropped, struck, exposed to liquids, or shows any signs of damage.
• Improper use may result in serious injury.
• Use this product in accordance with ANSI B7.1.

4. Handling

• Perform the initial inspection while the wheel is still in its original packaging. If there is visible evidence of damage, the product should not be accepted.
• Handle cup wheels carefully to prevent impacts or drops. Do not mount a cup wheel if it has been dropped, cracked, chipped, or is suspected of being damaged.

5. Storage

• Store cup wheels on a flat, stable surface. Prevent impacts and drops during storage and handling.
• Do not expose wheels to:
(a) Water or other solvents.
(b) Extreme temperatures or humid conditions.
• For additional information, refer to ANSI B7.1.

6. Packaging units

• 4 pieces.