Data Sheet

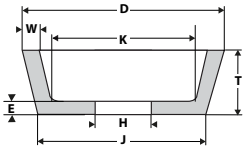
Item
338

1. Product description:

Vitrified Flaring Cup Grinding Wheel

Dimensions (in):	4" x 1-1/2" x 1-1/4"
Dimensions (mm):	100 x 40 x 31.75
Abrasive:	Aluminum Oxide
Specification:	89A60K5VA1
Grit:	60
Grade:	K
Max. rpm:	7,650
Line:	89A Orange
Max. speed:	40 m/s

Type 11



D =	**100**	**mm**
T =	**40**	**mm**
H =	**31.75**	**mm**
W=	**6**	**mm**
E=	**13**	**mm**
J=	**75**	**mm**
K=	**65**	**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.