

# FBB Grinding Wheels



NIPPON TOKUSHU KENTO CO., LTD.

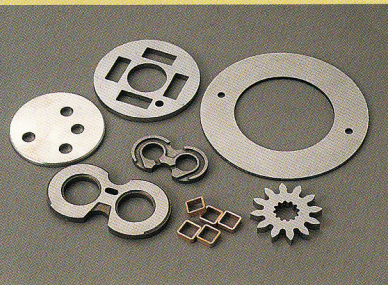


# FBB Grinding Wheels,

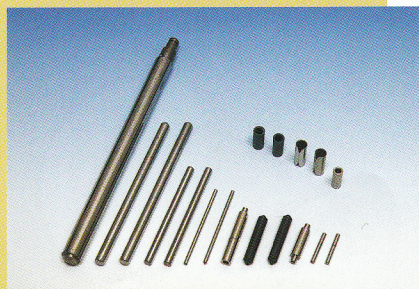
made from PolyVinyl Alcohol and thermosetting resins. Its elasticity effect enables to produce good surface roughness. It is suitable for precision instrument grinding.

## Major Applications:

various rods, pins, bearings and blades



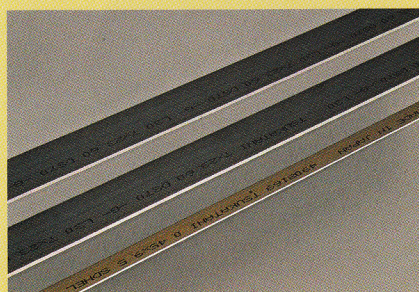
parts for lapping



rods & pins



bearings



steel cutting rules

## Wheel specifications & Dimension table

Abrasive	Grit#		Grade			Curing			
			Hardness	Density	Grain %				
GC	220	1000	N3	soft	S	low	10	low	A
	320	1500	N5	↑	M	↑	12	↑	B
	400	2000							
	600	3000	N6	↓	H	↓	14	↓	C
	800								
			hard		high		high		

		Unit:mm						
D	T	19	25	32	38	50	75	100
180								
205								
255								
305								
355								
405								

For other dimensions, please contact us.

## ⚠ Cautions for operation

- Do not use beyond the maximum peripheral speed (m/s) indicated on each wheel or inspection card.
- Check all wheels before tightening, and do not use the wheel that has cracking, fractures or chipping.
- Recommended flange tightening method and pressure:
  - When mounting flange on the FBB Grinding Wheel, tighten flange bolts with a standard hexagon wrench.
    - \*Excessive tightening weaken the wheel rotational strength.
    - \*Do not hammer the hexagon wrench to tighten nor connect a pipe to hexagon wrench.
  - When tightening down the flange bolts with a torque wrench, tightening torque is calculated as below:
 
$$MQ (\text{tightening torque}) = \frac{0.49 \times d \times Af}{n}$$

MQ: proper tightening torque (N·m)  
d : bolt diameter (cm)  
Af : flange contact area (cm<sup>2</sup>)  
n : number of bolts
- Coolant: designed for wet grinding, water-soluble type is recommended.
- Do not leave the wheels in any place where it will be subjected to direct sunlight or high-temperature and humidity.
- Addition to the above cautions, always handle, store, and use wheels in a careful manner according to A.N.S.I. Safety Code B7.1.



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