

JWP Grinding Stones, FBB Grinding Stones for Lapping Process

Hardness Comparison table

	JWP	FBB (soft type)	FBB (hard type)
Hardness	soft ←	medium	→ hard
Young's Modulus	50~600 MPa	300~1500 MPa	1000~3000 MPa

Standard specifications & Dimension table

JWP Grinding Stones

Abrasive	Grit#	Grade	Young's Modulus
C	400 1500	S	50~80 MPa
	600 2000		
	800 3000	M	90~160 MPa
	1200 4000		
GC	6000	H	170~600 MPa

Dimension

Segment type : Available in various size for lapping machine.

FBB Grinding Stones (soft type)

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

Dimension

Segment type : Available in various size for lapping machine.

Wheel type : Maximum Outer Diameter 510mm, Maximum Thickness 50mm

Example of Abrasive grain and Grade

- 1) FBB-N GC220 N5H14C
- 2) FBB-N GC800 N5H12A

FBB Grinding Stones (hard type)

Abrasive	Grit#	Grade					
		Kind of Bond	Amount of Bond	Amount of Filler	Density	Cure Temp.	
WA	120	LBA (Brittle type)	low	low	low	low	
	220		4	4	4	H	
	320		5	5	5	A	
	400		6	6	6	B	
GC	600	LHB (Hard type)	7	7	7	C	
	800		8	8	8	C	
	1000		8	8	8	C	
	2000		high	high	high	high	

Dimension

Segment type : Available in various size for lapping machine.

Wheel type : Maximum Outer Diameter 510mm, Maximum Thickness 50mm

Example of Abrasive grain and Grade

- 1) FBB-C WA320 LBA438H
- 2) FBB-C WA600 LHB546C

※Please ask the availability of combination.

⚠ Cautions for operation

1. Do not use beyond the maximum peripheral speed (m/s) indicated on each stone/wheel or inspection card.
2. Check all stones/wheels before installing, and do not use the stone/wheel that has cracking, fractures or chipping.
3. Coolant: designed for wet grinding, water-soluble type is recommended.
4. Do not leave the wheels in any place where it will be subjected to direct sunlight or high-temperature and humidity.
5. Addition to the above cautions, always handle, store, and use stones and wheels in a careful manner according to A.N.S.I. Safety Code B7.1.



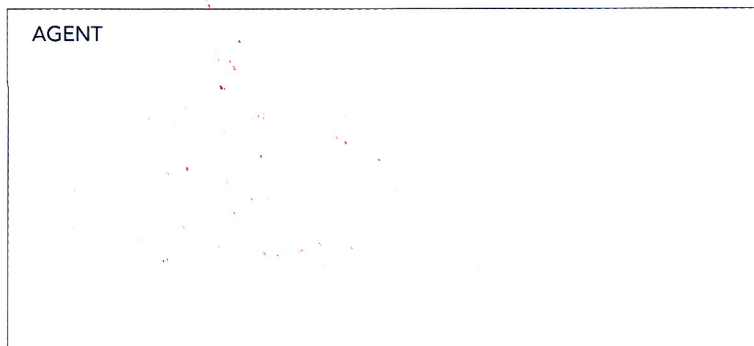
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AGENT



JWP
FDP

Grinding Stones