



CENTRELESS wheels

- + Centreless grinding is grinding the outer surface of any cylindrical part, supported without centres on a stationary work rest blade and moving between the grinding wheel and the regulating wheel.
- + Normal speed of operation : 25 to 45 MPS.
- + Sterling's Centreless grinding wheels have versatile application in Bearing, Auto and Auto Components, Cutting Tools, Stainless Steel Bar, Fastner and other General Engineering Industries.
- + Suitable for machines like HMT, Cincinnati, Foldage, Solitaire, WMW, Micromatic, Jyothi, Scarlo, Parishudh, Lidkoping etc.

Recommendation

Component /Material	Grading			
Axles	A60 L5 V15	A60 J5 V15		
Bearings	A60 L5 V15	A60 J5 V15	DA80-5 K8 V18N	FSW 60 J7 VC8
Gudgeon Pin	A60 L5 VC10			
Automotive Valves	A60 L5 V15			
Engineering Files	A46 T7 V9	DA36 Q6 V9		
Soft Steel	A60 M5 V15			
Hardened Steel	A60 L5 VC11	GC60 K5 V4		
Stainless Steel Bar	A60 L5 VC10	A60 M5 VC10	CGC 54 M5 V4	C60 K5 V4
Tungsten Carbide	GC60 K5 V4			
Ceramics	C463 L5 V4	GC100 M5 V4		

Product Range

Abrasive	Diameter	Thickness	Grit	Hardness	Structure	Type
A	300-750	80 - 250	36 - 120	I - O	5 - 8	1 - 5 - 7
AA - DA	300-750	80 - 250	46 - 80	I - M	5 - 8	1 - 5 - 7
C - GC	300-600	80 - 250	46 - 80	I - L	5 - 8	1 - 5 - 7
FS	300-600	80 - 250	46 - 80	I - L	5 - 8	1 - 5 - 7

Commonly Used Sizes

300 x 80 x 140	400 x 150 x 228.60	600 x 200 x 304.8
350 x 100 x 127	400 x 200 x 203.2	600 x 250 x 304.8
350 x 100 x 152.4	500 x 150 x 304.8	
350 x 150 x 127	500 x 200 x 304.8	

