

Standard Shapes and Profiles of Grinding Wheels

Shape and profile of a grinding wheel are indicated by the corresponding shape type number (figure 3) and profile symbol (figure 4).

Standard Shapes

e.g. 1-A (Type 1 straight wheel, profile A)

Figure 3

<p>1 Straight wheel</p>	<p>2 Cylinder wheel</p> <p>$T \geq W$ $W \leq 0.17D$</p>	<p>3 Wheel, tapered one side</p>	<p>5 Wheel, recessed one side</p>
<p>6 Straight cup wheel</p> <p>$E \geq F$ $F \leq \frac{T}{2}$ $P \geq 1.02D_{+4}$</p>	<p>7 Wheel, recessed two sides</p> <p>$F+G < \frac{T}{2}$ $P \geq 1.02D_{+4}$</p>	<p>11 Taper cup wheel</p> <p>$E \geq \frac{T}{4}$ $W \leq E$ $K \geq D_{+2R}$</p>	<p>12 Dish wheel</p> <p>$E \geq \frac{T}{2}$ $K \geq D_{+2R}$</p>
<p>13 Saucer wheel</p> <p>$U=E$ $R=\frac{U}{2}$ $K \geq D_{+2R}$</p>	<p>20 Wheel, relieved one side</p> <p>$N < \frac{T}{2}$ $K \geq D_{+2R}$</p>	<p>21 Wheel, relieved two sides</p> <p>$N+O < \frac{T}{2}$ $K \geq D_{+2R}$</p>	<p>22 Wheel, relieved one side, recessed other side</p> <p>$N+F < \frac{T}{2}$ $P \geq 1.02D_{+2R}$</p>
<p>23 Wheel, relieved and recessed same side</p> <p>$N+F < \frac{T}{2}$ $P \geq 1.02D_{+2R}$</p>	<p>24 Wheel, relieved and recessed one side, recessed other side</p> <p>$N+F+G < \frac{T}{2}$ $P \geq 1.02D_{+2R}$</p>	<p>25 Wheel, relieved and recessed one side, relieved other side</p> <p>$N+F+O < \frac{T}{2}$ $P \geq 1.02D_{+2R}$</p>	<p>26 Wheel, relieved and recessed both sides</p> <p>$N+F+G+O < \frac{T}{2}$ $P \geq 1.02D_{+4}$</p>
<p>27 Depressed center wheel</p> <p>$U=E$</p>	<p>28 Coolie hat wheel</p> <p>$U=E$</p>	<p>35 Disc wheel, cemented or with mechanical clamping</p> <p>$T < W$</p>	<p>36 Disc wheel with inserted nuts</p>
<p>37 Cylinder wheel with inserted nuts</p> <p>$W \leq 0.17D$</p>	<p>38 Hubbed wheel</p>	<p>39 Duplex hubbed wheel</p>	<p>31 Segments</p>

D.: Flange diameter

Profiles

Figure 4

<p>A</p>	<p>B</p>	<p>C</p>	<p>D</p> <p>$R = \frac{3}{10}T$</p>	<p>E</p>	<p>F</p> <p>$R = \frac{1}{2}T$</p>	<p>G</p> <p>$R = \frac{1}{8}T$</p>	
<p>H</p> <p>$R = \frac{1}{8}T$</p>	<p>I</p> <p>$R = \frac{1}{8}T$ $S = \frac{1}{3}T$</p>	<p>J</p> <p>$R = \frac{7}{10}T$</p>	<p>K</p>	<p>L</p> <p>$R = T$</p>	<p>M</p>	<p>N</p> <p>V and X should be specified with order.</p>	<p>P</p>

Inquire of our service clerk about the shapes and the profiles not listed above.