TOOL & CUTTER WHEELS (side tab)

Tool & Cutter Wheels

The standard shapes most commonly used
in tool & cutter grinding are:

- T-6 – Straight Cup Wheel
- T-11 – Flaring Cup
- T-12 – Dish Wheels
- T-50 – Plate Mount Wheels

The shape of the wheel is determined by the shape, size,
and accessibility of the part to be ground.
When grinding peripheral cutters, cup wheels are used. Dish wheels are best for formed cutters.

- WA – Used when a good cuting action is needed on all steels.
  When a sharp corner or radius must be held, use fine grits combined with J or K hardness.
- GC – Used for non-ferrous metals such as cemented materials.
- PA – Used for high alloy steel applications such as sharpening HSS cutters, reamers and chisels.
- AS3 – Used for fast metal removal; excellent for grinding 50 Rockwell C and harder.

Master Selection Stock Sheet

WA: White Premium Aluminum Oxide
PA: Pink Aluminum Oxide

AS3: Ceramic Aluminum Oxide
GC: Green Silicon Carbide

SIZE	WA 46H	WA 46I	WA 46J	WA 46K	WA 60I	WA 60J	WA 60K	WA 80J	WA 80K	PA 46I	PA 46K	PA 60I	PA 60K	PA 80K	AS3 46I	AS3 60J	AS3 60K	GC 60I	GC 80I	GC 100I	GC 120I
4 x 2 x 20mm Deckel Cup **T6**	–	–	–	–	–	–	–	•	–	–	–	–	–	–	–	–	–	–	–	–	–
4/3 x 1½ x 1¼ Flaring Cup **T11**	–	–	•	•	•	•	•	–	•	–	•	•	•	•	–	•	•	•	•	•	–
5/3¾ x 1¾ x 1¼ Flaring Cup **T11**	•	•	•	•	•	•	•	–	•	•	•	–	•	–	•	•	–	•	–	–	–
5 x 1½ x 1¼ Straight Cup **T6**	–	–	•	•	–	•	•	–	•	–	–	–	–	–	–	–	–	–	–	–	–
6 x 2 x 1¼ Straight Cup **T6**	–	–	–	–	–	–	•	–	–	–	–	–	–	–	–	–	–	–	–	–	–
6 x ½ x 1¼ Dish Wheel **T12**	–	–	–	•	–	•	•	–	–	–	–	–	–	–	–	–	–	–	–	–	–
6 x ¾ x 1¼ Dish Wheel **T12**	–	–	–	–	–	–	•	–	–	–	–	–	–	–	–	–	–	–	–	–	–
6 x 1 x 4 Plate Mount Wheel **T50**	–	–	–	•	–	–	–	–	–	–	–	–	–	–	–	–	–	•	•	•	•

Tool Room Wheels

Almost all manufacturing plants have a tool room which is involved with the maintenance
and repair of cutting tools, and the overall maintenance and repair of the plant itself.

Typical grinding operations done in the tool room are:
1. Surface Grinding
2. Tool & Cutter Grinding
3. Internal Grinding
4. Cutoff

With the exception of cutoff, most wheels are vitrified bond. These wheel come in various shapes and sizes.
Operations are generally dry.