INTERNAL GRINDING

Accurately profile surfaces so that components fit perfectly.

Used in bore grinding of inner rings, gears etc. and track grinding of outer rings, steering nuts, etc.

Sak Abrasives Ltd.

TOPLINE
Let the sparks fly

User segments

- Automotive
- Engineering component manufacturing
- Cutting tools and dies
- Bearings

The TOPLINE advantage

- Advanced tooling techniques enabling accurate dimensioning of components
- Precisely ground surfaces
- Free cutting design improves stock removal rates.

TOPLINE Recommendations

Material	TOPLINE recommendation
Best	8M 80 K9 VT6
Better	4A 60 L7 VS11
Good	1A 60 K5 VT4
Sulfur treated	2A 60 M8 VS11

Abrasive	Grit	Hardness	Bond
8M	60	K, M	VT6

Dia. (In.)	Thick. (In.)	Bore (In.)	Recess (In.)	Dia. (mm)	Thick. (mm)	Bore (mm)	Recess (In.)
1/2	1/2	1/4	-	13	13	6.35	-
3/4	3/4	1/4	3/8x3/8	20	20	6.35	9x9
1	1	3/8	1/2x1/2	25	25	9	12.7x12.7
1	1	1/4	1/2x1/2	25	25	6.35	12.7x12.7
1 ¼	1	3/8	5/8x1/2	31.75	25	9	16x12.7
1 ½	1	3/8	3/4x1/2	38.1	25	9	20x12.7
1 ½	1	3/8	5/8x1/2	38.1	25	9	16x12.7
2	1	3/8	3/4x1/2	50	25	9	20x12.7
2	1 1/2	5/8	1x3/4	50	38	16	25x20