



Varun Udyog
— an ISO 9001-2008 certified company —

RESIN BONDED DIAMOND WHEELS

Varun Udyog offers a comprehensive range of products conforming to FEPA Standard from 6mm to 700mm in diameter.

SURFACE FINISH RECOMMENDATION

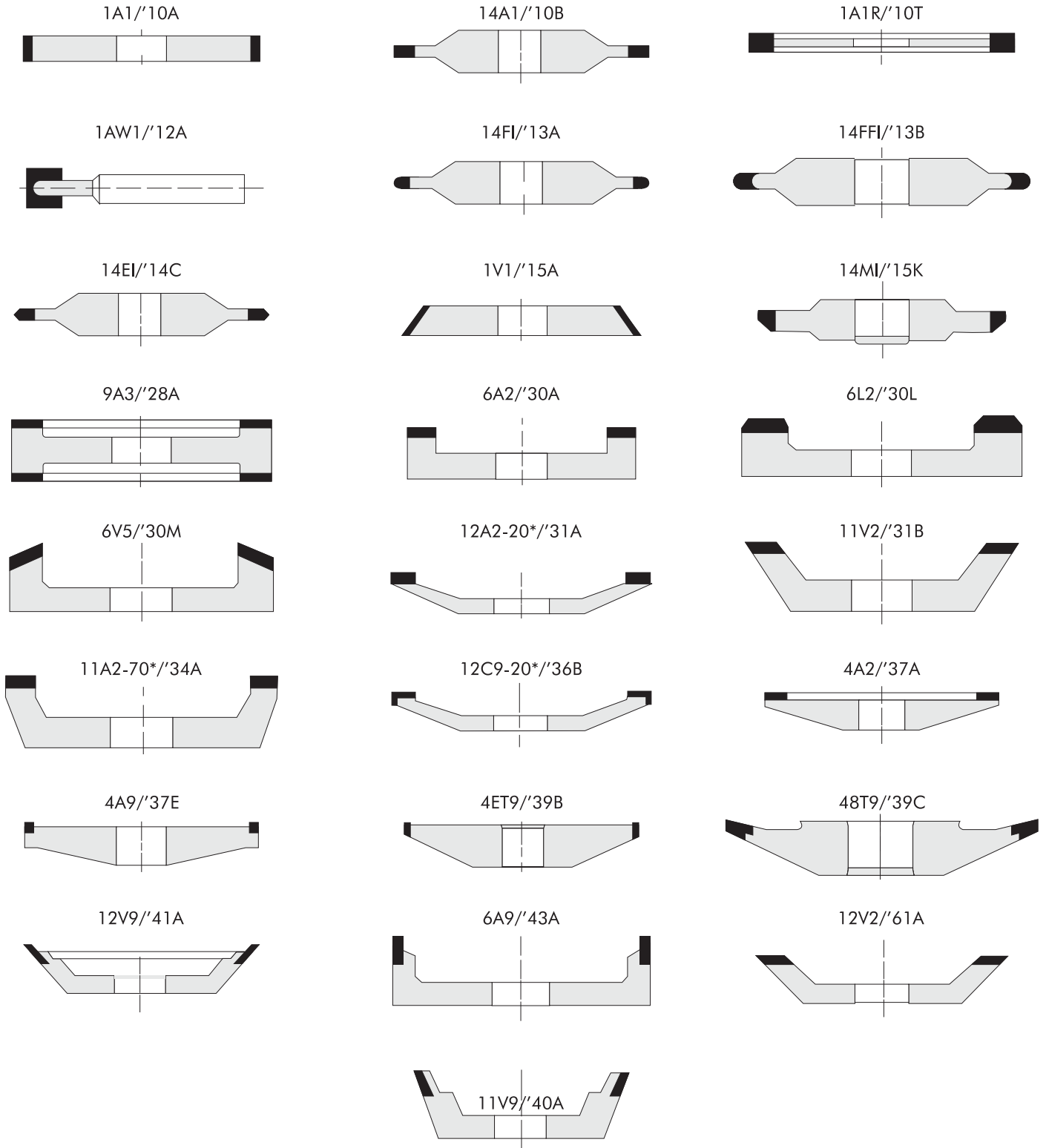
FEPA - Grit Size		Mean Roughness		Surface Quality
Diamond	CBN	DIAMOND	CBN	N
–	B301	–	2.10	N8
–	B251	–	1.77	N8-N7
–	B213	–	1.41	N7
–	B181	–	1.12	N7-N6
–	B151	–	0.75	N6
	B126		0.66	N6
D181	B107	0.53	0.53	N6-N5
D151	B91	0.50	0.50	N6-N5
D126	B76	0.45	0.45	N6-N5
D107	B62	0.40	0.40	N5
D91	B54	0.33	0.33	N5-N4
D76	B46	0.25	0.25	N5-N4
D64	–	0.18		N4
D54	–	0.16		N4-N3
D46	–	0.15		N4-N3
MD25	–	0.12		N3
MD20	–	0.05		N3-N2
MD10		0.025		N2-N1

SURFACE COMPARISON

	N1	N2	N3	N4	N5	N6	N7	N2
Ra(μm)	0.025	0.05	0.10	0.2	0.4	0.8	1.60	3.20
Rt(μm)	0.500	0.80	1.25	2.5	5.0	8.0	16.0	32.0
Rz(μm)	0.400	0.63	1.00	2.0	4.0	6.3	10.0	16.0

FEPA - Shapes

These drawings show the most important grinding wheel geometries



Bore Size Standards

Wheel Diameter (mm)	Bore Sizes Available with Tolerance
300 \varnothing	127 H7
175 \varnothing to 250 \varnothing	20, 31.75, 32, 50.8, 76, 76.2, 127 H7
75 \varnothing to 125 \varnothing	10, 20, 31.75, 32, 50.8 H7
50 \varnothing	10, 20, 31.75 H7