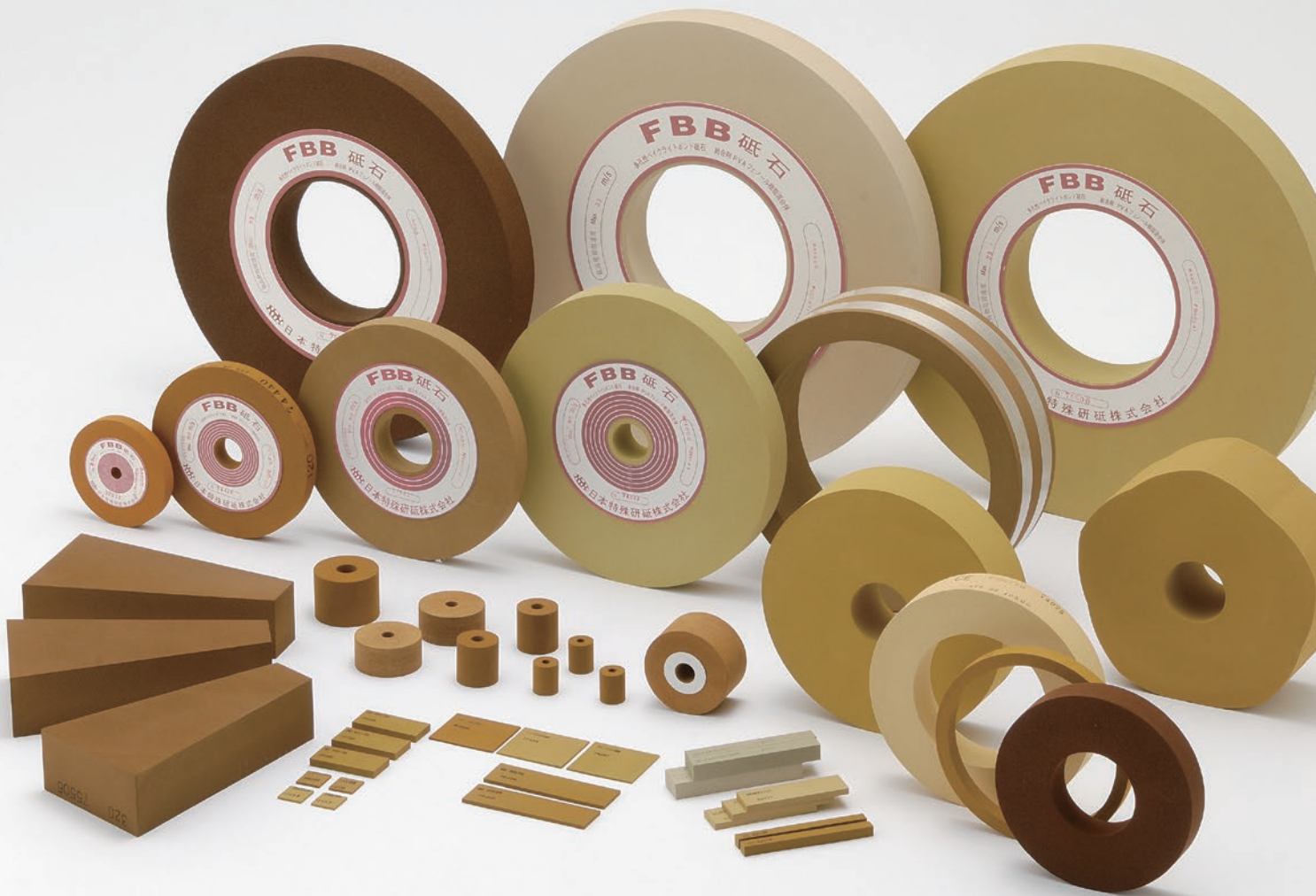


FBB Grinding Wheels



Nippon Tokushu Kento Co., Ltd.

FBB Grinding Wheels,

made from PolyVinyl Alcohol and thermosetting resins. Its elasticity effect enables to produce good surface roughness. It is suitable for precision instrument grinding.

Major Applications:

various rods, pins, bearings and blades



parts for lapping



rods & pins



bearings



steel cutting rules

Wheel specifications & Dimension table

Abrasive	Grit#		Grade						Curing
			Hardness		Density		Grain %		
GC	220	1000	N3	soft	S	low	10	low	A
	320	1500		↑		↑		↑	
	400	2000	N5		M	12	B		
	600	3000	N6	↓	H	high	14	high	
	800			hard		↓		high	

		Unit:mm						
D	T	19	25	32	38	50	75	100
180								
205								
255								
305								
355								
405								

For other dimensions, please contact us.

⚠ Cautions for operation

- Do not use beyond the maximum peripheral speed (m/s) indicated on each wheel or inspection card.
- Check all wheels before tightening, and do not use the wheel that has cracking, fractures or chipping.
- Recommended flange tightening method and pressure:
 - When mounting flange on the FBB Grinding Wheel, tighten flange bolts with a standard hexagon wrench.
 - *Excessive tightening weaken the wheel rotational strength.
 - *Do not hammer the hexagon wrench to tighten nor connect a pipe to hexagon wrench.
 - When tightening down the flange bolts with a torque wrench, tightening torque is calculated as below:

$$MQ \text{ (tightening torque)} = \frac{0.49 \times d \times Af}{n}$$
 - MQ : proper tightening torque (N·m)
 - d : bolt diameter (cm)
 - Af : flange contact area (cm²)
 - n : number of bolts
- Coolant: designed for wet grinding, water-soluble type is recommended.
- Do not leave the wheels in any place where it will be subjected to direct sunlight or high-temperature and humidity.
- Addition to the above cautions, always handle, store, and use wheels in a careful manner according to A.N.S.I. Safety Code B7.1.



Nippon Tokushu Kento Co., Ltd.

Head office 18 Oike-cho, Kisshoin, Minami-ku, Kyoto, 601-8327, JAPAN
Tel:+81-75-691-5141 Fax:+81-75-672-3590

Tokyo office 5-8-25 Yayoi-cho, Nakano-ku, Tokyo, 164-0013, JAPAN
Tel:+81-3-5342-3751 Fax:+81-3-5342-3753

URL <https://www.nittokuken.co.jp/>
E-mail Sales@nittokuken.co.jp

AGENT