

# UB

# Grinding Wheels

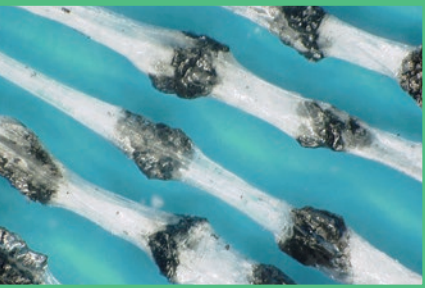
for centerless grinder



Nippon Tokushu Kento Co., Ltd.

# UB Centerless Grinding Wheels,

made from PVA synthetic fibers developed by our spinning technology and bonded with thermosetting resins. Abrasive grains are tightly bound inside of PVA fibers. Its elasticity effect offers smooth and continuous grinding without scratches and heat generation.



PVA synthetic fibers

## Major Applications:

cylindrical parts, such as rods or shafts for 4-wheel vehicles and front fork pipes for motorcycles



shock absorber



front fork pipes



car parts



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## Wheel specifications & Dimension table

Abrasive		Grade	Physical Properties
ND60	NS600		
ND90	NS700	S	90W-1.6
ND120	NS800	M	130W-1.3
ND220	NS1000	H	150W-1.2
	NS1500		

		Unit:mm			
D	T	150	205	255	305
405					
455					
510					
610					

For other dimensions, please contact us.

### Physical Properties Symbols

$130 \text{ W} - 1.3$  ①Young's Modulus: A large figure indicates harder structure.  
① ② ③ Real Young's Modulus = ①×10MPa  
②Measurement condition: "W" for wet condition.  
③Strain(%): A large figure indicates higher elongation.

## ⚠ Cautions for operation

- Do not use beyond the maximum peripheral speed (m/s) indicated on each wheel or inspection card.
- Check all wheels before installing, and do not use the wheel that has cracking, fractures or chipping.
- When tightening down the flange bolts with a torque wrench, tightening torque is calculated as below:

$$MQ \text{ (tightening torque)} = \frac{0.2 \times d \times p \times Af}{n}$$

MQ : proper tightening torque (N·m)  
d : bolt diameter (cm)  
p : proper pressure of flange contact area (6-7 MPa)  
Af : flange contact area (cm<sup>2</sup>)  
n : number of bolts

- Coolant: designed for wet grinding, water-soluble type is recommended.
- Need 3 minutes idling before operation and 10 minutes de-watering after operation.
- 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.

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