

## RECOMMENDED SPEEDS FOR DIAMOND AND CBN GRINDING WHEELS -- RESIN BONDED

WHEEL SPEED SFPM	WHEEL DIAMETER																
	1"	2"	3"	4"	5"	6"	7"	8"	9"	10"	12"	14"	16"	18"	20"	24"	30"
	<b>REQUIRED R.P.M. (Revolution per Minute)</b>																
<b>2000</b>	7600	3800	2500	1900	1500	1300	1100	950	850	760	640	550	480	425	380	320	255
<b>2500</b>	9500	4800	3200	2400	1900	1600	1350	1200	1050	950	790	680	600	530	480	400	320
<b>3000</b>	11500	5700	3800	2900	2300	1900	1600	1450	1270	1150	950	820	720	636	570	480	380
<b>3500</b>	13500	6700	4500	3350	2700	2200	1900	1670	1480	1330	1120	950	835	740	670	560	445
<b>4000</b>	15300	7600	5100	3800	3050	2500	2200	1900	1700	1530	1270	1090	955	850	760	640	510
<b>4500</b>	17200	8600	5700	4300	3400	2850	2450	2150	1900	1720	1430	1230	1070	955	860	715	570
<b>5000</b>	19000	9500	6400	4800	3800	3200	2700	2400	2120	1910	1590	1360	1190	1060	950	795	640
<b>5500</b>	21000	10500	7000	5300	4200	3500	3000	2600	2330	2010	1750	1500	1310	1170	1050	875	700
<b>6000</b>	23000	11200	7600	5700	4600	3800	3250	2850	2550	2290	1910	1630	1430	1270	1150	955	760
<b>6500</b>	24800	12400	8300	6200	4950	4100	3550	3100	2760	2480	2070	1770	1550	1380	1240	1030	830
<b>7000</b>	26800	13100	8900	6700	5300	4450	3800	3350	2970	2670	2230	1910	1670	1480	1340	1115	890
<b>7500</b>	28700	14300	9500	7150	5700	4800	4100	3600	3180	2860	2390	2050	1790	1590	1430	1190	955
<b>8000</b>	30500	15300	10200	7650	6100	5100	4350	3800	3390	3050	2550	2180	1910	1700	1530	1270	1020
<b>9000</b>	34500	17200	11500	8600	6900	5700	4900	4300	3820	3440	2860	2450	2150	1910	1720	1430	1150
<b>10000</b>	38200	19100	12700	9500	7600	6350	5450	4800	4240	3820	3180	2730	2400	2120	1910	1590	1270
<b>11000</b>	42000	21000	14000	10500	8400	7000	6000	5250	4670	4200	3500	3000	2620	2330	2010	1750	1400
<b>12000</b>	46000	23000	15300	11500	9200	7650	6550	5700	5090	4580	3820	3270	2860	2550	2290	1910	1530

### RECOMMENDED SPEEDS FOR DIAMOND / CBN GRINDING WHEELS

RESIN BOND	DRY	WET
DIAMOND	3000 to 4500 SFPM	4500 to 6500 SFPM
	15 to 22 M/S	22 to 32 M/S
CBN	3000 to 6000 SFPM	6000 to 7500 SFPM
	15 to 30 M/S	30 to 37 M/S

Caution: Never exceed the safe maximum operating speed  
Resin bonded wheels - Not to exceed 8,000 SFPM

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