



DIAMOND AND C.B.N. PARTICLE SIZES

ABRASIVE MESH SIZE	AVERAGE PARTICLE SIZE IN INCHES	ALLOWANCE FOR ABRASIVE PER SIDE
20/30	.030" + - .006"	.036"
30/40	.020" + - .005"	.025"
40/50	.015" + - .005"	.020"
60/80	.010" + - .0015"	.0115"
80/100	.007" + - .0015"	.0085"
100/120	.006" + - .0015"	.0075"
140/170	.004" + - .001"	.005"
170/200	.0035" + - .001"	.0045"
200/230	.003" + - .0005"	.003"
230/270	.0025" + - .0005"	.0025"
325/400	.0019" + - .0005"	.002"

When manufacturing your own tool blank for diamond or C.B.N. coating, use the "allowance for abrasive" column to determine blank dimensions. For example, if 60/80 mesh is to be used, allow .0115" per side for abrasive thickness.

Female radii should be larger on the tool blank than the finish size required. If a .375" female radius is required on the grinding wheel, and it is to be coated with 80/100 mesh, the tool blank radius should be machined or ground to .3835" (.375" + .0085").

Male radii should be smaller on the tool blank to allow for abrasive thickness. As with the above example, if a .375" male radius is required, and 80/100 mesh is to be used, then a .3665" radius should be machined or ground on the tool blank. (.375" - .0085")

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