

VITRIFIED WHEELS



CATEGORY DEFINITION

Used on surface, cylindrical, and tool and cutter grinders, Norton precision, form-holding vitrified toolroom wheels maximize your productivity. Available in latest-generation ceramic alumina, aluminum oxide, and silicon carbide – for every ferrous and nonferrous MRO, small job shop, and production operation.

APPLICATIONS:	Surface grinding, tool and cutter grinding, and resharpener
SHAPES:	Type 01 Straight, Type 02 Cylinder, Type 05 and 07 Recessed 1 and 2 Sides, Type 06 and 11 Straight and Flaring Cups, Type 12 Dish, Type 20 Concaved 1 Side, and Type 35 Plate Mounted Disc
SIZE RANGE:	2" – 18" diameter
GRIT RANGE:	46 – 220
ABRASIVE GRAIN:	Ceramic Alumina, Aluminum Oxide, Silicon Carbide

MATERIAL-TO-PRODUCT RECOMMENDATION GUIDE

PERFORMANCE/PRODUCTIVITY APPLICATION / MATERIAL	NARROW CONTACT AREA			MEDIUM CONTACT AREA			WIDE CONTACT AREA		
	BEST	BETTER	GOOD	BEST	BETTER	GOOD	BEST	BETTER	GOOD
Tool Resharpener									
• Heavy Stock Removal (> .004) HSS & Tool Steel RC 50-68	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-GVSP 3SGR46-GVP2	32A46-GVBEP 48A46-GVP2	38A46-GVBEP 38A46-GVP2
• Moderate Stock Removal (.002-.004) HSS & Tool Steel RC 50-68	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	5SG60-GVSP 3SGR60-GVP2	32A60-GVBEP 48A60-GVP2	38A60-GVBEP
Carbide			39C60-JVK			39C60-JVK			
Surface Grinding									
• Heavy Stock Removal (> .004) HSS & Tool Steel RC 50-68	5NQ46-JVS	32A46-JVBE	38A46-JVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-GVSP 3SGR46-GVP2	32A46-GVBEP 48A46-GVP2	38A46-GVBEP 38A46-GVP2
400 Series Stainless									
Soft Steels RC 30-45	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-HVSP 3SGR46-HVP2	32A46-HVBEP 48A46-HVP2	38A46-HVBEP 38A46-HVP2
300 Series Stainless									
Cast Iron: Ductile & Gray	5SG46-KVS	32A46-KVBE	38A46-KVBE	5SG46-JVS	32A46-JVBE	38A46-JVBE	5SG46-HVSP 3SGR46-GVP2	32A46-HVBEP 48A46-HVP2	38A46-HVBEP 38A46-HVP2
Nonferrous Alloys			39C46-JVK			39C46-IVK			
• Moderate Stock Removal (.002-.004) HSS & Tool Steel RC 50-68	5NQ60-JVS	32A60-JVBE	38A60-JVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	5SG60-GVSP 3SGR60-GVP2	32A60-GVBEP 48A60-GVP2	38A60-GVBEP
400 Series Stainless									
Soft Steels RC 30-45	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	5SG60-HVSP 3SGR60-HVP2	32A60-HVBEP 48A60-HVP2	38A60-HVBEP 38A60-HVP2
300 Series Stainless									
Cast Iron: Ductile & Gray	5SG60-KVS	32A60-KVBE	38A60-KVBE	5SG60-JVS	32A60-JVBE	38A60-JVBE	5SG60-HVSP 3SGR60-HVP2	32A60-HVBEP 48A60-HVP2	38A60-HVBEP 38A60-HVP2
Nonferrous Alloys			39C60-JVK			39C60-IVK			
• Light Stock Removal and Finishing (<.001) HSS & Tool Steel RC 50-68		32A80-JVBE	38A80-JVBE		32A80-JVBE	38A80-JVBE		32A80-HVBE	38A80-HVBE
400 Series Stainless									
Soft Steels RC 30-45		32A80-KVBE	38A80-KVBE		32A80-JVBE	38A80-JVBE		32A80-HVBE	38A80-HVBE
300 Series Stainless									
Cast Iron: Ductile & Gray		32A80-KVBE	38A80-KVBE		32A80-JVBE	38A80-JVBE		32A80-HVBE	38A80-HVBE
Nonferrous Alloys			39C80-JVK			39C80-IVK			39C80-HVK

TECHtip

SELECTING A WHEEL WITH THE CORRECT BOND TYPE

SINGLE POINT DIAMOND TOOLS

- Use VBE, V, VS, VS3, and VK bonds for general purpose applications or medium contact areas.
- Use VBEP, VSP, VS3P, VCP, and VP2 bonds on wide contact areas where heat is an issue.



It is the user's responsibility to refer to and comply with ANSI B7.1