

GRINDING WHEELS SPEED

The speed of grinding stones is very important, if the speed of wheels is too low, it will consume a lot (low performance); and if the speed of wheels is too high, it will consume less (stone breaking).

PERIPHERICAL SPEED OF THE GRINDING WHEEL (m/sec)		
WORK	MATERIALS	m/s
Surface grinding	Steel	25 ÷ 32
	Grey cast iron	25
	Brass - Bronze	25
	Hard metal	8 ÷ 15
	Mild metal	20
Surface grinding with abrasive cylindrical cup or segments	Steel	20 ÷ 25
	Grey cast iron	20
	Hard metal	8 ÷ 15
	Mild metal	20
Tool sharpening	Steel	25
	Hard metal	18 ÷ 28
Cutting	Steel	From 45 to 100
	Grey cast iron	
	Non ferrous metals	
	Plastic	
Deburring	Acciaio	25 ÷ 35
	Cast iron	
Deburring (resinoid wheels not reinforced)	Steel	35 ÷ 50
	Cast iron	
Deburring (resinoid wheels reinforced)	Acciaio	60 ÷ 80
	Cast iron	