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Basic Recommendations For Correct Wheel Speeds, In and Cross Feeds that are specific to Electroplated Single Layer Superabrasive Grinding Wheels

Single Layer Superabrasive grinding wheel maximum safe operating speed is 12,000 SFPM.

Although 12,000 is the maximum safe speed, it is not necessarily the most efficient. There are some exceptions to this rule; however it is best to keep below 12,000 SFPM.

Single layer Superabrasive grinding wheels operate most effectively at speeds lower than the maximum recommended safe operating SFPM.

The following are general recommendations for SFPM:

Single Layer Superabrasive grinding wheels 5,500 to 6,500 SFPM.

General recommendation for in-feed of .002" to .004" per pass with cross feed from 2 – 3" per minute. Without proper and adequate coolant supply, the wheel will not perform well and will fail quickly. See the Dianamic coolant questionnaire for more information about recommended coolant and delivery systems.

Always refer to ANSI B7.1 grinding wheel safety standards for safe handling, speeds and storage of grinding wheels.

