

Attachment table 16

Grinding wheel types			limitation of general using peripheral velocity for grinding wheel(unit: meters/second)	
			Bonder being inorganic substance	Bonder being orgnic substance
straightgrinding wheel	no reinforced	general grinding use	33	50
		overweight grinding	-	63
		screw grinding or slot grinding	63	63
		crankshaft or cam shaft grinding	45	50
	reinforced	diameter below 100 milimeters, thickness below 25milimeters	-	80
		diameter over 100 milimeters and below205 milimeters, thickness below 13milimeters	-	72
		other sizes	-	50
tapered one-side ' tapered two-side ' one-concaved ' two-concaved ' safety ' saucer-shaped or sawing-use grinding wheel			33	50
wedge grinding wheel	general grinding use	33	50	
	screw grinding or slot grinding	63	63	
gap- type grinding wheel	general grinding use	33	50	
	crankshaft or cam shaft grinding	45	50	
ring or ring- piece grinding wheel			30	35
straight-cup or taper-cup grinding wheel			30	40
sawtooth-shaped grinding wheel or sawtooth-shaped-ring-piece grinding wheel			33	45
dish grinding wheel(diameter below 230 milimeters, thickness below 10 milimeters	noreinforced	-	57	
	reinforced	-	72	
cutting grinding wheel	noreinforced	-	63	
	reinforced	-	80	
Remark: The heightest using peripheral velocity for the foreign inputs in accordance with the following table to do conversion.				
Highest using peripheral velocity(ins/minute)		Conversion(meters/second)		
6500		33		
8500		45		
9500		50		
12000		60		
16000		80		
20000		100		