Attachment table 20

Highest using peripheral velocity (unit: meters/second)		Grinding wheel types	Sizes (unit : millimeters) Diameter (D)	Thickness (T)	Hole diameter	concave diameter (P)	thickness of mounting portion (E)	diameter of the parallel portion of the mounting portion(J or K)	edge thickness (W)
Normal velocity		all	below 1500 for cutting grinding wheel		below 0.7D	over 1.02Df+4	over T/4 for straight-cup shape， over T/2 for one-concaved， two-concaved， saucer or sawing-use-saucer shape	over Df+2R	below E
Velocity except the normal velocity	below 45	Surface， tapered one-side，tapered two-side，one-concaved，two-concaved， safety，wedge-shaped , gap-shaped or protruding- type grinding wheel	below 1065					over Df+2R	
	Over 45 below 60	Surface， tapered one-side，tapered two-side，one-concaved，two-concaved， safety，wedge-shaped , gap-shaped or protruding- type grinding wheel	below 1065	over D/50 below 305	below 0.5D	over 1.02Df	over (2/3)T	over Df+2R	
	Over 60 below 80	straight，wedge-shape，safety or cutting	below 1500 for cutting grinding wheel，below 760 for others	over D/50 below 152	below 0.33			over Df+2R	
	Over 80 below 100	straight，wedge-shape，safety or cutting	below 1500 for cutting grinding wheel，below 760 for others	over D/50 below 80	below 0.2D			over Df+2R	

Remark: 1. Df is the diameter of fixed-flange and R is the fillet radius of the concave in the table.
2. it is any value if it not been set in the table.