

Grier

Abrasive Co., Inc.



Call Rapp Industrial for your discounted pricing 724-789-7853 - 888-789-7277. Email us - sales@rappindustrialsales.com

Manufacturers of Quality Abrasives Since 1966



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Mounted Points

There are many factors involved in selecting the right abrasive for your application.

- One Factor is...Size & Shape
- **GRIER** offers all standard shapes plus many custom shapes for your application
- Featured here: **“A”, “B” and “W” Shapes**

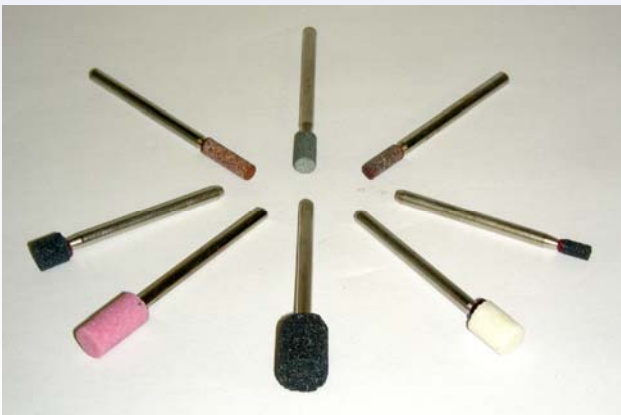
These parts are mounted on either 1/8” or 1/4” mandrels as our standard, but other sizes, shapes and mandrel diameters are available upon request.



“A” Shapes



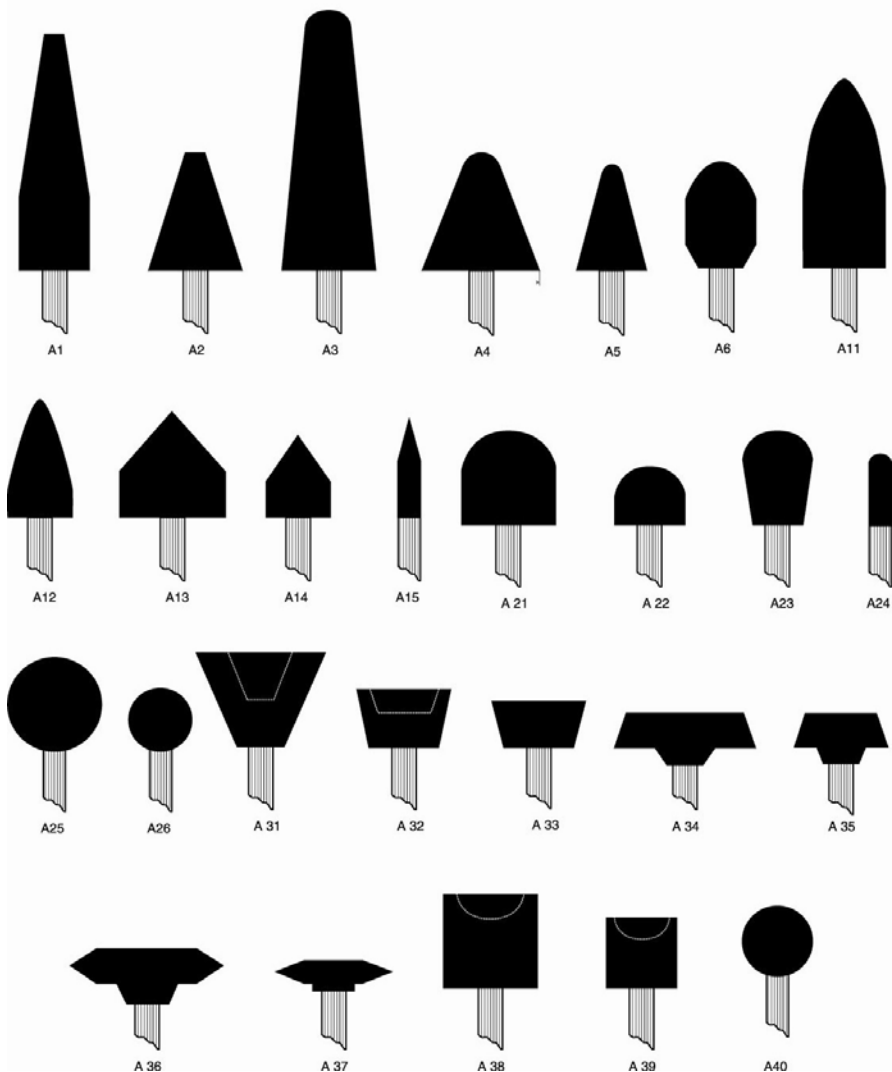
“B” Shapes



“W” Shapes

For more information, see our other handouts:

- General Abrasive Information
- Grinding Wheels
- Segments
- And a wide variety of other specialty item handouts

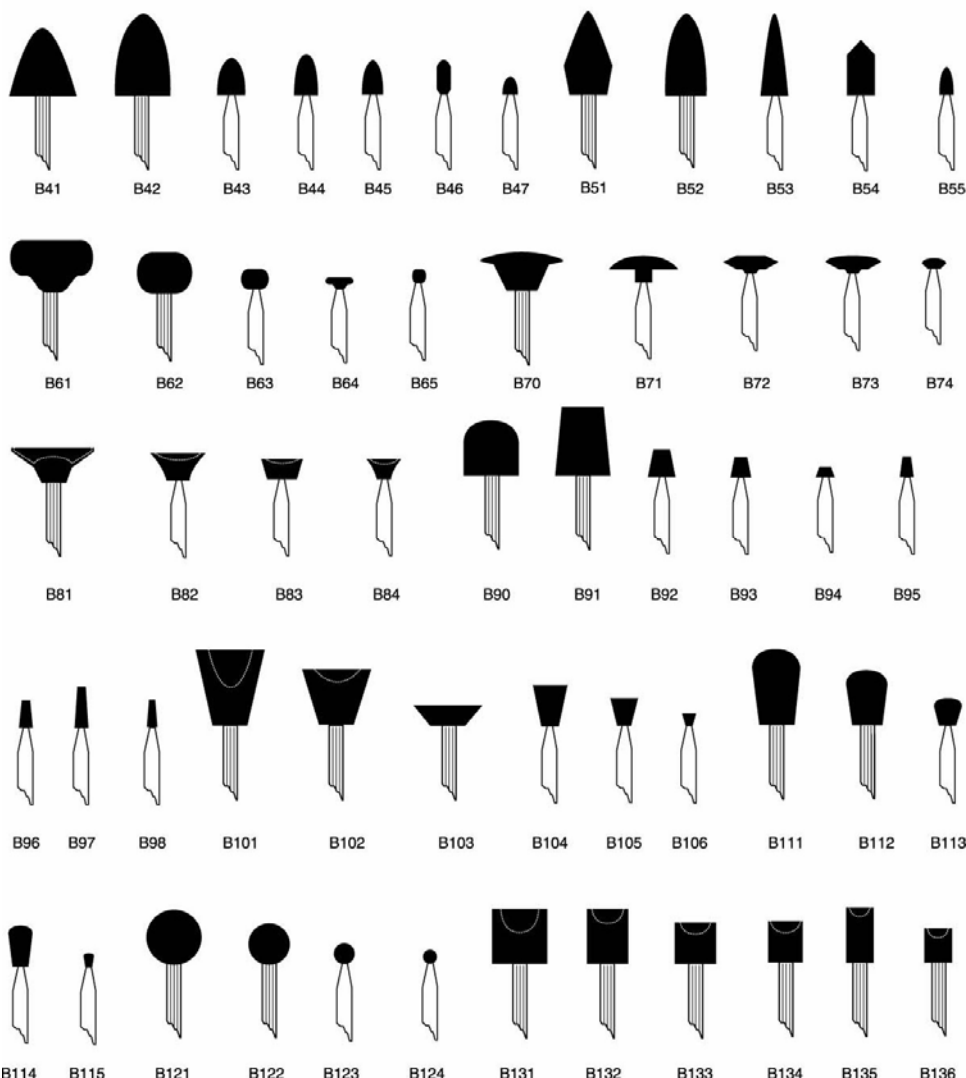


1/4" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
A1	3/4	2 1/2	19,800
A2	1	1 1/4	38,200
A3	1	2 3/4	16,100
A4	1 1/4	1 1/4	30,560
A5	3/4	1 1/8	45,000
A6	3/4	1 1/8	39,000
A11	7/8	2	19,860
A12	11/16	1 1/4	48,000
A13	1 1/8	1 1/8	33,950
A14	11/16	7/8	55,560
A15	1/4	1 1/16	72,750
A21	1	1	34,500
A22	3/4	5/8	50,930
A23	3/4	1	39,370

1/4" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
A24	1/4	3/4	76,500
A25	1	1	35,620
A26	5/8	5/8	61,120
A31	1 3/8	1	27,780
A32	1	5/8	38,200
A33	1	1/2	38,200
A34	1 1/2	3/8	25,470
A35	1	3/8	38,200
A36	1 5/8	3/8	23,520
A37	1 1/4	1/4	30,560
A38	1	1	34,500
A39	3/4	3/4	47,250
A40	3/4	3/4	47,250



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1/8" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
B41	5/8	5/8	33,750
B42	1/2	3/4	33,750
B43	1/4	5/16	81,370
B44	7/32	3/8	68,400
B45	3/16	5/16	104,250
B46	1/8	5/16	105,000
B47	1/8	5/32	105,000
B51	7/16	3/4	45,370
B52	3/8	3/4	45,370
B53	1/4	5/8	60,000
B54	1/4	1/2	60,000
B55	1/8	1/4	105,000
B61	3/4	5/16	38,250
B62	1/2	3/8	41,020
B63	1/4	3/16	92,400
B64	1/4	1/16	105,000
B65	1/8	1/8	105,000
B70	3/4	1/8	50,930
B71	5/8	1/8	61,120

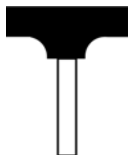
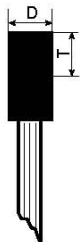
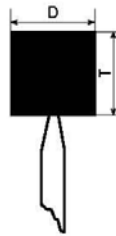
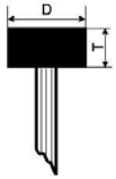
1/8" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
B72	1/2	1/8	73,500
B73	1/2	1/8	73,500
B74	7/32	3/32	105,000
B81	3/4	3/16	50,930
B82	1/2	1/4	76,390
B83	3/8	3/16	87,600
B84	5/16	3/16	105,000
B90	1/2	1/2	34,500
B91	1/2	5/8	34,500
B92	1/4	1/4	81,370
B93	3/16	3/16	105,000
B94	11/64	3/32	105,000
B95	1/8	3/16	105,000
B96	1/8	1/4	105,000
B97	1/8	3/8	105,000
B98	3/32	1/4	105,000
B101	5/8	11/16	33,750
B102	5/8	1/2	45,370
B103	5/8	3/16	61,120

1/8" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
B104	5/16	3/8	68,400
B105	1/4	1/4	104,250
B106	1/8	7/64	105,000
B111	7/16	11/16	33,750
B112	3/8	1/2	45,370
B113	1/4	1/4	81,370
B114	7/32	3/8	68,400
B115	3/32	1/8	105,000
B121	1/2	1/2	45,370
B122	3/8	3/8	61,650
B123	3/16	3/16	104,250
B124	1/8	1/8	105,000
B131	1/2	1/2	34,500
B132	3/8	1/2	45,370
B133	3/8	3/8	54,000
B134	5/16	3/8	61,650
B135	1/4	1/2	60,000
B136	1/4	5/16	77,250

1/4" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
B41	5/8	5/8	61,120
B42	1/2	3/4	61,120
B51	7/16	3/4	81,000
B52	3/8	3/4	81,000
B61	3/4	5/16	50,930
B62	1/2	3/8	71,250
B71	5/8	1/8	61,120
B72	1/2	1/8	76,390
B73	1/2	1/8	76,390
B91	1/2	5/8	61,500
B101	5/8	11/16	61,120
B102	5/8	1/2	61,120
B111	7/16	11/16	66,000
B112	3/8	1/2	81,000
B121	1/2	1/2	76,390
B131	1/2	1/2	61,500
B132	3/8	1/2	81,000



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1/8" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
W141	3/32	5/32	93,750
W142	3/32	1/4	93,750
W143	1/8	1/8	105,000
W144	1/8	1/4	105,000
W145	1/8	3/8	105,000
W146	1/8	1/2	105,000
W147	5/32	1/32	93,750
W148	5/32	1/16	93,750
W149	5/32	1/4	90,750
W150	3/16	1/16	93,750
W151	3/16	1/8	105,000
W152	3/16	1/4	105,000
W153	3/16	3/8	80,850
W154	3/16	1/2	70,500
W156	1/4	1/32	93,750
W157	1/4	1/16	123,000
W158	1/4	1/8	105,000
W159	1/4	3/16	92,400
W160	1/4	1/4	81,370
W161	1/4	5/16	77,250
W162	1/4	3/8	68,400
W163	1/4	1/2	60,000
W164	1/4	3/4	45,900
W165	5/16	1/16	107,400
W166	5/16	1/8	96,970
W167	5/16	1/4	75,000
W168	5/16	5/16	68,400
W169	5/16	3/8	61,650
W170	5/16	1/2	52,500
W171	5/16	3/4	37,120
W172	3/8	1/16	99,370
W173	3/8	1/8	87,600
W174	3/8	1/4	69,000
W175	3/8	3/8	54,000
W176	3/8	1/2	45,370
W177	3/8	3/4	33,750
W178	3/8	1	26,250
W180	1/2	1/32	79,000
W181	1/2	1/16	76,390
W182	1/2	1/8	73,500
W183	1/2	1/4	51,750
W184	1/2	3/8	41,020
W185	1/2	1/2	34,500
W186	1/2	3/4	26,250
W187	1/2	1	20,620
W190	5/8	1/16	61,120
W191	5/8	1/8	58,870
W192	5/8	1/4	43,120
W193	5/8	3/8	32,250
W194	5/8	1/2	29,400
W195	5/8	3/4	22,120
W196	5/8	1	17,620
W199	3/4	1/16	50,930
W200	3/4	1/8	50,930
W201	3/4	1/4	38,250
W202	3/4	3/8	30,600
W203	3/4	1/2	25,500
W204	3/4	3/4	18,900
W210	7/8	1/16	43,650
W211	7/8	1/8	43,650
W212	7/8	1/4	33,750
W213	7/8	3/8	27,000
W215	1	1/8	38,200
W216	1	1/4	30,520

1/4" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
W176	3/8	1/2	81,000
W177	3/8	3/4	66,000
W178	3/8	1	55,200
W179	3/8	1 1/4	45,750
W182	1/2	1/8	76,390
W183	1/2	1/4	76,390
W184	1/2	3/8	71,250
W185	1/2	1/2	61,500
W186	1/2	3/4	51,000
W187	1/2	1	40,500
W188	1/2	1 1/2	30,370
W189	1/2	2	24,000
W190	5/8	1/16	61,120
W191	5/8	1/8	61,120
W192	5/8	1/4	61,120
W193	5/8	3/8	61,120
W194	5/8	1/2	56,400
W195	5/8	3/4	46,500
W196	5/8	1	35,250
W197	5/8	2	21,000
W198	5/8	2 1/2	16,500
W201	3/4	1/4	50,930
W202	3/4	3/8	50,930
W203	3/4	1/2	50,930
W204	3/4	3/4	42,750
W205	3/4	1	34,500
W206	3/4	1 1/4	28,720
W207	3/4	1 1/2	24,000
W208	3/4	2	18,750
W209	3/4	2 1/2	15,000
W211	7/8	1/8	43,650
W212	7/8	1/4	43,650
W213	7/8	3/8	43,650
W215	1	1/8	38,200
W216	1	1/4	38,200
W217	1	3/8	38,200
W218	1	1/2	38,200
W219	1	3/4	35,100
W220	1	1	25,500
W221	1	1 1/2	19,120
W222	1	2	15,900
W223	1	2 1/2	12,370
W224	1	3	9,200
W225	1 1/4	1/4	30,560
W226	1 1/4	3/8	30,560
W227	1 1/4	1/2	30,560
W228	1 1/4	3/4	30,520
W229	1 1/4	1	24,000
W230	1 1/4	1 1/4	20,400
W231	1 1/4	1 1/2	17,620
W232	1 1/4	2	14,250
W235	1 1/2	1/4	25,470
W236	1 1/2	1/2	25,470
W237	1 1/2	1	22,500
W238	1 1/2	1 1/2	15,600
W239	1 1/2	2	12,750
W240	1 1/2	2 1/2	10,500
W241	1 1/2	3	9,000
W242	2	1	19,100
W243	2	1 1/2	14,500
W244	2	2	11,750
W245	2	2 1/2	9,600
W246	2	3	8,250

3/8" DIA. MANDRELS			
SHAPE	DIA. (in.)	THICK. (in.)	MAX RPM @ 1/2" OVERHANG
W223	1	2 1/2	24,740
W224	1	3	24,740
W231	1 1/4	1 1/2	30,560
W232	1 1/4	2	28,500
W238	1 1/2	1 1/2	25,470
W239	1 1/2	2	24,470
W240	1 1/2	2 1/2	21,000
W241	1 1/2	3	18,000
W242	2	1	19,100
W243	2	1 1/2	19,100
W244	2	2	19,100
W245	2	2 1/2	19,100
W246	2	3	16,500



123 Taft Drive
South Holland, IL 60473

Web: www.grierabrasive.com



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RIGHT NOW! Mounted Points

Get your general purpose mounted points shipped from stock!

They come in all the common shapes
with 4 standard specifications to choose from.

Minimum Order Quantity on 1/8" mandrel (D1) is 100

Minimum Order Quantity on 1/4" mandrel (D2) is 50

"A" Shapes

BLUE	RED	PINK	WHITE	MANDREL
A1-GB-10057/C	A1-R-10394/C	A1-P-15741/C		D2
A1-GB-8332	A1-R-169	A1-P-26176	A1-W-7869	D2
A3-GB-1071/C	A3-R-1358/C			D2
A3-GB-412	A3-R-770	A3-P-26177	A3-W-6806	D2
A4-GB-7222	A4-R-420	A4-P-26178		D2
A5-GB-16193/C	A5-R-3021/C			D2
A5-GB-7004	A5-R-457	A5-P-26179	A5-W-7051	D2
A6-GB-12419	A6-R-6907	A6-P-26180		D2
A11-GB-1081/C	A11-R-16774/C			D2
A11-GB-13883	A11-R-153	A11-P-26181	A11-W-12	D2
A12-GB-16194/C	A12-R-1742/C			D2
A12-GB-2043	A12-R-449	A12-P-26182		D2
A13-GB-509	A13-R-570	A13-P-26183		D2
A14-GB-7279	A14-R-6842	A14-P-26184		D2
A15-GB-8391	A15-R-1134	A15-P-26185		D2
A21-GB-7610	A21-R-421	A21-P-26186		D2
A22-GB-7195	A22-R-3052	A22-P-26187		D2
A23-GB-13780	A23-R-250	A23-P-26188		D2
A24-GB-13884	A24-R-148	A24-P-26189		D2
A25-GB-13885	A25-R-1971	A25-P-26190		D2
A26-GB-6851	A26-R-1362	A26-P-26191		D2
A31-GB-16332/C				D2
A31-GB-479	A31-R-152	A31-P-26192		D2
A32-GB-2040	A32-R-459	A32-P-26193		D2
A33-GB-15192	A33-R-448	A33-P-26194		D2
A34-GB-1639	A34-R-1197	A34-P-26195	A34-W-8432	D2
A35-GB-6211	A35-6068	A35-P-26196		D2
A36-GB-14439	A36-R-465	A36-P-26197	A36-W-6550	D2
A37-GB-14440	A37-R-422	A37-P-26198		D2
A38-GB-1317/C				D2
A38-GB-2046	A38-R-1709	A38-P-26199		D2
A39-GB-6981	A39-R-151	A39-P-26200		D2
A40-GB-3005	A40-R-1056	A40-P-26201		D2

COLORS...

Indicate the point's relative hardness in this program.

BLUE = HARD
RED = MEDIUM
PINK = MEDIUM-SOFT
WHITE = SOFT

SHANKS...

D1 = 1/8" X 1-1/2" MANDREL

D2 = 1/4" X 1-1/2" MANDREL

D3 = 3/8" X 1-1/2" MANDREL

GRIT...

LARGER SHAPES = 60

SMALLER SHAPES = 80/100

DENOTED "/C" = 36

For more information, see our other handouts:

- General Abrasive Information
- Carbide Burs
- Mounted Point Kits
- And a wide variety of other specialty item handouts

BLUE	RED	PINK	WHITE	MANDREL
B41-GB-6849	B41-R-136	B41-P-26237		D1
B42-GB-6546	B42-R-1361	B42-P-26238	B42-W-7009	D1
B43-GB-9828	B43-R-7852	B43-P-26239	B43-W-12996	D1
B44-GB-14470	B44-R-636	B44-P-17751	B44-W-8544	D1
B45-GB-329	B45-R-323	B45-P-26240	B45-W-14916	D1
B46-GB-10543	B46-R-1360	B46-P-26241	B46-W-11243	D1
B47-GB-6545	B47-R-1817	B47-P-26242	B47-W-6852	D1
B51-GB-16806	B51-R-1721	B51-P-26243		D1
B52-GB-1438	B52-R-177	B52-P-19310	B52-W-14347	D1
B53-GB-6520	B53-R-548	B53-P-16853	B53-W-13484	D1
B54-GB-16807	B54-R-7021	B54-P-26244		D1
B55-GB-5026	B55-R-590	B55-P-26245	B55-W-1728	D1
B61-GB-1961	B61-R-1687	B61-P-26246		D1
B62-GB-16808	B62-R-7110	B62-P-26247		D1
B63-GB-6793	B63-R-8774	B63-P-26248		D1
B64-GB-16004	B64-R-868	B64-P-26249		D1
B65-GB-15428	B65-R-6165	B65-P-26250		D1
B70-GB-7287	B70-R-6385	B70-P-26251		D1
B71-GB-16809	B71-R-1298	B71-P-26252		D1
B72-GB-16810	B72-R-6823	B72-P-26253		D1
B73-GB-16811	B73-R-1851	B73-P-26254		D1
B74-GB-16655	B74-R-1816	B74-P-26255		D1
B81-GB-8353	B81-R-382	B81-P-26256		D1
B82-GB-16812	B82-R-7001	B82-P-26257		D1
B83-GB-16417	B83-R-6622	B83-P-26258		D1
B84-GB-9498	B84-R-7019	B84-P-26259		D1
B90-GB-1960	B90-R-15448	B90-P-26260		D1
B91-GB-16813	B91-R-7111	B91-P-26261		D1
B92-GB-15767	B92-R-2053	B92-P-26262		D1
B93-GB-492	B93-R-6540	B93-P-26263		D1
B94-GB-16105	B94-R-973	B94-P-26264		D1
B95-GB-16033	B95-R-7228	B95-P-26265		D1
B96-GB-13798	B96-R-290	B96-P-26266	B96-W-4	D1
B97-GB-7067	B97-R-289	B97-P-25954	B97-W-8805	D1
B98-GB-8690	B98-R-5015	B98-P-26267		D1
B101-GB-15974	B101-R-3065	B101-P-26268		D1
B102-GB-3077	B102-R-6916	B102-P-26269		D1
B103-GB-1959	B103-R-539	B103-P-26270		D1
B104-GB-15937	B104-R-6168	B104-P-26271		D1
B105-GB-16005	B105-R-7030	B105-P-26272		D1
B106-GB-5059	B106-R-1171	B106-P-26273		D1
B111-GB-3076	B111-R-7026	B111-P-26274		D1
B112-GB-15975	B112-R-6167	B112-P-26276		D1
B113-GB-1399	B113-R-6151	B113-P-26277		D1
B121-GB-1221	B121-R-1163	B121-P-26278		D1
B122-GB-1222	B122-R-161	B122-P-26279	B122-W-4052	D1
B123-GB-309	B123-R-1725	B123-P-26280	B123-W-11028	D1
B124-GB-9689	B124-R-415	B124-P-26281	B124-W-6634	D1
B125-GB-20176	B125-R-1819	B125-P-26282	B125-W-9209	D1
B131-GB-6176	B131-R-786	B131-P-26283	B131-W-10472	D1
B132-GB-3075	B132-R-1063	B132-P-26284		D1
B133-GB-1843	B133-R-3085	B133-P-26285	B133-W-6661	D1
B134-GB-11110	B134-R-13669	B134-P-26286		D1
B135-GB-1638	B135-R-261	B135-P-26287	B135-W-109	D1
B136-GB-6022	B136-R-855	B136-P-35459		D1



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RIGHT NOW!

BLUE	RED	PINK	WHITE	MANDREL
W141-GB-8689	W141-R-943	W141-P-26288		D1
W142-GB-1829	W142-R-944	W142-P-26289		D1
W143-GB-4019	W143-R-4066	W143-P-26290	W143-W-6129	D1
W144-GB-192	W144-R-259	W144-P-16911	W144-W-2091	D1
W145-GB-113	W145-R-836	W145-P-16851	W145-W-8654	D1
W146-GB-15247	W146-R-1342	W146-P-26291	W146-W-720	D1
W151-GB-16815	W151-R-3051	W151-P-26292		D1
W152-GB-701	W152-R-440	W152-P-26293	W152-W-10692	D1
W153-GB-336	W153-R-677	W153-P-16849	W153-W-6423	D1
W154-GB-10590	W154-R-655	W154-P-16893	W154-W-99	D1
W157-GB-6046	W157-R-1922	W157-P-26294		D1
W158-GB-702	W158-R-6897	W158-P-26295		D1
W159-GB-16816	W159-R-13728	W159-P-26296		D1
W160-GB-6054	W160-R-1082	W160-P-26297		D1
W161-GB-603	W161-R-6000	W161-P-26298		D1
W162-GB-386	W162-R-380	W162-P-26299	W162-W-6718	D1
W163-GB-1287	W163-R-175	W163-P-16850	W163-W-6067	D1
W164-GB-7693	W164-R-800	W164-P-16894	W164-W-15811	D1
W165-GB-8198	W165-R-6534	W165-P-26300		D1
W166-GB-15327	W166-R-7013	W166-P-26301		D1
W167-GB-16817	W167-R-7014	W167-P-26302		D1
W168-GB-16818	W168-R-1813	W168-P-26303		D1
W169-GB-16819	W169-R-1814	W169-P-26304		D1
W170-GB-497	W170-R-430	W170-P-26305		D1
W171-GB-16820	W171-R-16104	W171-P-26306		D1
W172-GB-5023	W172-R-1824	W172-P-26307		D1
W173-GB-9602	W173-R-11157	W173-P-26308		D1
W174-GB-8635	W174-R-1078	W174-P-26309		D1
W175-GB-14743	W175-R-254	W175-P-26310	W175-W-18119	D1
W176-GB-6018	W176-R-144	W176-P-16860		D1
W176-GB-9713	W176-R-6239	W176-P-26311		D2
W177-GB-10103	W177-R-6455	W177-P-17733	W177-W-11980	D1
W177-GB-426	W177-R-429	W177-P-26312		D2
W178-GB-16821	W178-R-1097	W178-P-6982	W178-W-7008	D1
W178-GB-8399	W178-R-11174	W178-P-26313		D2
W179-GB-7202	W179-R-7157	W179-P-26314		D2
W181-GB-1825	W181-R-1755	W181-P-26315		D1
W182-GB-16822	W182-R-11446	W182-P-26316		D1
W183-GB-6359	W183-R-3060	W183-P-20109	W183-W-10078	D1
W184-GB-20190	W184-R-9029	W184-P-26317		D1
W184-GB-16823	W184-R-3036			D2
W185-GB-1947	W185-R-173	W185-P-16859	W185-W-7987	D1
W185-GB-11264	W185-R-13579	W185-P-26318	W185-W-14703	D2
W186-GB-16824	W186-R-1224	W186-P-20108	W186-W-14819	D1
W186-GB-8388	W186-R-252			D2
W187-GB-16825	W187-R-1970		W187-W-8015	D1
W187-GB-15111	W187-R-179	W187-P-26319	W187-W-7715	D2
W188-GB-15349	W188-R-157	W188-P-26320		D2
W189-GB-16826	W189-R-3061	W189-P-26321	W189-W-6980	D2
W190-GB-9539	W190-R-6747	W190-P-26323		D1
W191-GB-9538	W191-R-3064	W191-P-26324		D1
W192-GB-384	W192-R-5080	W192-P-26325		D1
W192-GB-20163	W192-R-10073			D2
W193-GB-16827	W193-R-20172	W193-P-26326		D1
W193-GB-19924	W193-R-486			D2

BLUE	RED	PINK	WHITE	MANDREL
W194-GB-8761	W194-R-1861	W194-P-26327		D1
W194-GB-16843	W194-R-6352	W194-P-34097		D2
W195-GB-16828	W195-R-990	W195-P-27716		D1
W195-GB-20164	W195-R-4023	W195-P-26328		D2
W196-GB-9573	W196-R-1075	W196-P-26329		D2
W197-GB-1170	W197-R-1074	W197-P-26330	W197-W-14396	D2
W198-GB-16829	W198-R-143	W198-P-26331		D2
W200-GB-8636	W200-R-156	W200-P-26332	W200-W-97	D1
W201-GB-105	W201-R-515	W201-P-20111		D1
W202-GB-16707	W202-R-142	W202-P-26333		D1
W202-GB-20162	W202-R-640			D2
W203-GB-6801	W203-R-246	W203-P-27717		D1
W203-GB-6015	W203-R-977	W203-P-26334		D2
W204-GB-13845	W204-R-8648	W204-P-30649	W204-W-1046	D1
W204-GB-20199	W204-R-757	W204-P-26335		D2
W205-GB-6193	W205-R-4030	W205-P-26336		D2
W206-GB-1801	W206-R-6161	W206-P-26337		D2
W207-GB-6179	W207-R-2089	W207-P-26338		D2
W208-GB-11606	W208-R-1343	W208-P-26339		D2
W209-GB-11086	W209-R-172	W209-P-26340		D2
W210-GB-16831	W210-R-20175	W210-P-27718		D1
W211-GB-16832	W211-R-245	W211-P-26341		D1
W212-GB-16467	W212-R-1982	W212-P-26342		D1
W212-GB-20166	W212-R-512			D2
W213-GB-16113	W213-R-13797			D1
W213-GB-20167	W213-R-20177	W213-P-26343		D2
W214-GB-16833	W214-R-9764			D1
W214-GB-20201	W214-R-20202	W214-P-26344		D2
W215-GB-6460	W215-R-634	W215-P-26345	W215-W-8803	D1
W215-GB-1354	W215-R-6935			D2
W216-GB-11929	W216-R-164			D1
W216-GB-18523	W216-R-505	W216-P-26346		D2
W217-GB-5078	W217-R-1756	W217-P-26347		D2
W218-GB-5091	W218-R-2083	W218-P-26348		D2
W219-GB-16740	W219-R-992	W219-P-26349		D2
W220-GB-1059/C	W220-R-127/C			D2
W220-GB-13886	W220-R-141	W220-P-26350	W220-W-10689	D2
W221-GB-10705	W221-R-1650	W221-P-26351		D2
W222-GB-15136	W222-R-1672	W222-P-26352		D2
W223-GB-1439	W223-R-6619	W223-P-26353		D2
W225-GB-1149	W225-R-163	W225-P-26354		D2
W226-GB-16835	W226-R-816	W226-P-26355		D2
W227-GB-16836	W227-R-155	W227-P-26356	W227-W-8312	D2
W228-GB-15193	W228-R-1344	W228-P-26357		D2
W229-GB-6050	W229-R-154	W229-P-26358		D2
W230-GB-16837	W230-R-760	W230-P-26359		D2
W231-GB-16838	W231-R-1443	W231-P-26360		D2
W232-GB-15248	W232-R-853	W232-P-26361		D2
W235-GB-1905	W235-R-446	W235-P-26362	W235-W-7678	D2
W236-GB-6357/C	W236-R-1215/C			D2
W236-GB-10507	W236-R-488	W236-P-26363	W236-W-291	D2
W237-GB-8763	W237-R-171	W237-P-26364		D2
W238-GB-15165	W238-R-991	W238-P-26365		D2
W242-GB-8408	W242-R-170	W242-P-26366	W242-W-9325	D2
W244-GB-18920	W244-R-20182	W244-P-27723		D2



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RESIN

“A” & “W” SHAPES

RESIN	MANDREL
A1-B-20283/C	D2
A3-B-20286/C	D2
A5-B-19783/C	D2
A11-B-20287/C	D2
A24-B-20284/C	D2

RESIN	MANDREL
W164-B-20322/C	D2
W178-B-20292/C	D2
W179-B-20324/C	D2
W188-B-20295/C	D2
W189-B-20325/C	D2
W197-B-20297/C	D2
W198-B-20299/C	D2
W205-B-20300/C	D2
W207-B-20301/C	D2
W208-B-20302/C	D2
W218-B-20304/C	D2
W220-B-20305/C	D2
W221-B-20422/C	D2
W222-B-17720/C	D2
W223-B-20310/C	D2
W235-B-20311/C	D2
W236-B-20446/C	D2
W242-B-20314/C	D2

RIGHT NOW!

Custom Grades and Shapes are available upon request.

The RIGHT NOW Program is for general applications where delivery from stock is the primary factor.

TROUBLESHOOTING

<u>Problem</u>	<u>Possible Cause</u>	<u>Correction</u>
Wheel Loading or Glazing	Wheel too hard Wheel too fine Insufficient Pressure Excessive RPM	Downgrade one level softer Use coarser grit Increase pressure up to max safe level Reduce RPM
Burning Work-piece	Wheel too hard Wrong wheel selected Stock removal too fast	Downgrade one level softer Choose heat-sensitive abrasive & bond Decrease stock removal per pass
Chatter	Wheel too hard Wheel out of balance Machine or grinder vibration	Downgrade one level softer Balance wheel or dress mounted point Check machine bearings or grinder collet
Scratching Work-piece	Wheel too hard Wheel too coarse	Downgrade one level softer Use finer grit
Improper Stock Removal	Too little, wheel too soft Too much, wheel too hard Short wheel life Grinder out of balance	Upgrade one level harder Downgrade one level softer Choose less friable grain Repair grinder or replace collet



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South Holland, IL 60473



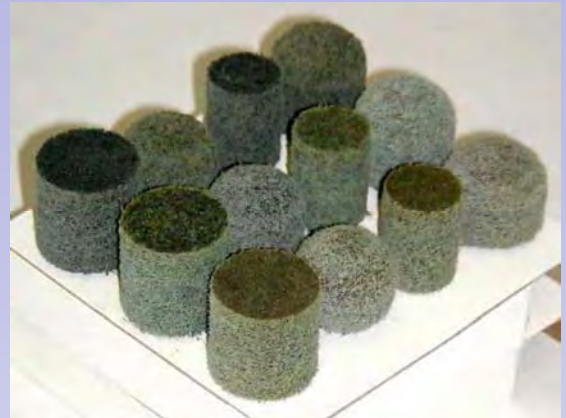
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GRIER-BRITE

GRIER-BRITE is constructed of pressed, non-woven, tough, abrasive nylon fibers, used primarily in finishing and surface preparation along with light deburring. **GRIER-BRITE** is designed to provide long-life and being typically non-loading, it will not disrupt critical tolerances.

A wide variety of applications can be addressed with 6 formulas and many different shapes and sizes.



<u>FEATURES</u>	<u>ADVANTAGES</u>	<u>BENEFITS</u>
Non-Metallic	Quieter & Smoother Running than Wire Brushes	No Metal Contamination of Work-Piece
Conformable	Eliminates Hand Operation on Contours and Designs	Saves Time & Money
Non-woven Construction	Non-loading	Longer Life, Will NOT Unwind
Smooth Running	Eliminates "Chatter" Marks Created by Bonded Abrasives	Saves Work Steps & Money
Various Sizes & Formulations	Wide Selection	Adaptable to Specific Job

MARKETS:

- AEROSPACE
- BOAT BUILDING & REPAIR
- DENTAL
- TOOL & DIE
- CONSTRUCTION, FARMING & MINING MACHINERY
- JEWELRY
- AUTOMOTIVE
- FOOD PROCESSING EQUIPMENT MANUFACTURERS
- CUTLERY
- MOLD SHOPS
- STAINLESS STEEL EQUIPMENT MANUFACTURERS
- APPLIANCE MANUFACTURERS

<u>FORMULA</u>	<u>GRAIN TYPE</u>	<u>FEATURES</u>
N1	ALUMINUM OXIDE	Fine Composition, Requires Very Little Pressure & Highly Conformable
N2	ALUMINUM OXIDE	Fine Composition, Requires Light Pressure & Moderately Conformable
N3	ALUMINUM OXIDE	Medium Composition, Requires Heavy Pressure & Aggressive Acting
N4	ALUMINUM OXIDE	Coarse Composition, Requires Heaviest Pressure & Most Aggressive Acting (includes light deburring)
S5	SILICON CARBIDE	Fine/Soft Composition, Requires Very Little Pressure, Moderately Conformable & Provide High Luster
S6	SILICON CARBIDE	Fine/medium Composition, Requires Light Pressure, Moderately Conformable & Provide Highest Luster

**OTHER
CONSIDERATIONS:**

1. Softer wheels produce a rougher finish
2. Lower SFPM produce a rougher finish
3. Deburring requires high SFPM (6,000)
4. Decorative finishes require lower SFPM (900)
5. Blending requires high SFPM (7,000)
6. S/C provides a finer finish (higher luster) than A/O
7. Polishing requires light pressure

AVAILABLE SHAPES

A21	B42	W154	W201
A22	B44	W160	W205
A23	B52	W163	W219
A25	B90	W174	W220
A33	B121	W176	W228
A40	B122	W183	W237
		W185	W242
		W187	

Most shapes available on each shank:
3/32", 1/8", 1/4", 3mm or 6mm

All shapes available in any formula:
N1, N2, N3, N4, S5 or S6

Several kits are also available. Ask your representative for more details.



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GRIER-TEX

GRIER-TEX is a cotton fiber abrasive. It is the result of laminating non-woven cotton fiber with various grains and bonds to achieve varying characteristics. **GRIER-TEX** works well on both ferrous and non-ferrous materials, but works extremely well on stainless steel. **GRIER-TEX** runs quiet, smooth and cool with virtually no loading. The non-loading aspect is ideal for working with softer metals, such as aluminum.



<u>GRAIN TYPE</u>	<u>GRIT</u>	<u>HARDNESS</u>	<u>BOND</u>
Aluminum Oxide	24-Coarse	F-Softest	GX-Latex ZX-Resin
Silicon Carbide	36	G	
	54-Medium	J-Medium	
	80	K-Medium/Hard	
	120-Fine	M-Hard	
	180	N-Extra Hard	
	320-Ultra Fine		

Available Specifications & Applications:

FGX *	Blending, Polishing & Finishing (standard soft grade)
GGX *	Light Deburring & Finishing
JZX	Light Deburring (standard medium grade)
KZX	Light Deburring (standard medium/hard grade)
MZX *	Light Stock Removal & Deburring (standard hard grade)
NZX	Deburring & Medium Stock Removal

AVAILABLE SHAPES

A1 *	A22 *	B41	W144	W176	W197 *	W219 *
A2 *	A23 *	B42	W145	W177	W201	W220 *
A3 *	A24 *	B51	W152	W178	W202	W221 *
A4 *	A25 *	B52	W153	W179 *	W203	W222 *
A5 *	A26 *	B61	W154	W183	W204	W226 *
A6 *	A34 *	B62	W160	W184	W205 *	W228 *
A11 *	A35 *	B91	W161	W185	W206 *	W230 *
A12 *	A36 *	B104	W162	W186	W207 *	W232 *
A13 *	A37 *	B111	W163	W187	W208 *	W235 *
A14 *	A40 *	B112	W164	W188 *	W215	W236 *
A15 *		B121	W170	W189 *	W216	W237 *
A21 *		B122	W174	W195	W217 *	W238 *
		B123	W175	W196 *	W218 *	W242 *

Standard mandrels are 1/8 x 1-1/2" unless marked by *

* Mandrels are 1/4 x 1-1/2"

All shapes available in any specification:

FGX, GGX, HGX, JZX, MZX & NZX

Other shapes, mandrels and threaded mandrels are also available



KITS



12 Piece "A&W" GRIER-TEX KIT

1/4 x 1-1/2" Mandrel

1 Each in Soft & Hard Specification:
A5, A25, W178, W204, W219, W220

PART# KT-1/4-12AW-GTX

12 Piece "B&W" GRIER-TEX KIT

1/8 x 1-1/2" Mandrel

2 Each in Soft & 1 Each in Hard Specification:
B52, B121, W176, W185

PART # KT-1/8-12BW-GTX



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RUB-BRITE

RUB-BRITE is rubber bonded abrasive that is available in a variety of shapes, sizes and specifications. **RUB-BRITE** works well in many ferrous and non-ferrous applications, including: ceramics, aluminum, brass, copper, hardened and medium grade steels, stainless steel, and inconel. **RUB-BRITE** is ideal for finishing and blending and is slightly more aggressive than GRIER-BRITE, but less aggressive than GRIER-TEX.



Many industries have applications for RUB-BRITE, but several industries have proven that RUB-BRITE is a key solution for them, including: JEWELRY, AEROSPACE, AUTOMOTIVE, DENTAL and TOOL & DIE.

<u>GRAIN TYPE</u>	<u>GRIT</u>	<u>HARDNESS</u>	<u>Mandrels</u>
Aluminum Oxide	46-Coarse	Regular	3/32", 1/8", 1/4"
	80-Medium	Hard	3mm & 6mm
	120-Fine		

Other grits and hardnesses are available upon request.

KITS:

<u>PART #</u>	<u>DESCRIPTION</u>	<u>MANDREL</u>	<u>APPLICATION</u>	<u>QTY</u>
KT-RUB-1/8-12PC	B & W Shapes 2 Hardnesses & 2 Grits	1/8 x 1-1/2"	Blending & Finishing	12
KT-RUB-1/8-36PC	B & W Shapes 2 Hardnesses & 2 Grits	1/8 x 1-1/2"	Blending & Finishing	36
KT-RUB-1/4-12PC	A & W Shapes 2 Hardnesses & 2 Grits	1/4 x 1-1/2"	Blending & Finishing	12
KT-RUB-1/4-24PC	A & W Shapes 2 Hardnesses & 2 Grits	1/4 x 1-1/2"	Blending & Finishing	24

"A" SHAPES

SHAPE	46 GRIT		80 GRIT		120 GRIT	
	REG	HARD	REG	HARD	REG	HARD
A2	X	X	X	X		
A4	X	X	X	X		
A11	X	X	X	X		
A12	X	X	X	X		
A13	X	X	X	X		
A14	X	X	X	X		
A21	X	X	X	X		
A22			X	X		
A23	X	X	X	X		
A25	X	X	X	X		
A26			X	X		
A33	X	X	X	X		
A37			X	X		
A36			X	X		
A38	X	X	X	X		
A39	X	X	X	X		
A40	X	X	X	X		

"B" SHAPES

SHAPE	46 GRIT		80 GRIT		120 GRIT	
	REG	HARD	REG	HARD	REG	HARD
B41			X	X		
B43			X	X		
B44			X	X	X	X
B52	X	X	X	X		
B54	X	X	X	X		
B90	X	X	X	X		
B91			X	X		
B92			X	X	X	X
B102	X	X	X	X		
B104			X	X	X	X
B105			X	X	X	X
B111	X	X	X	X		
B112	X	X	X	X		
B121	X	X	X	X		
B122			X	X	X	X
B123			X	X	X	X
B131	X	X	X	X		

Other Sizes and Shapes are
available upon request.

"W" SHAPES

SHAPE	46 GRIT		80 GRIT		120 GRIT	
	REG	HARD	REG	HARD	REG	HARD
W144			X	X	X	X
W146			X	X	X	X
W153			X	X	X	X
W154			X	X	X	X
W160			X	X	X	X
W162			X	X	X	X
W163	X	X	X	X		
W164	X	X	X	X	X	X
W167	X	X	X	X	X	X
W174			X	X	X	X
W176	X	X	X	X		
W177	X	X	X	X		
W178	X	X	X	X		
W183			X	X	X	X
W184			X	X	X	X
W185	X	X	X	X		
W186	X	X	X	X		
W187	X	X	X	X		
W189	X	X	X	X		
W192			X	X	X	X
W194	X	X	X	X		
W195	X	X	X	X		
W196	X	X	X	X		
W197	X	X	X	X		
W201			X	X	X	X
W203	X	X	X	X		
W204	X	X	X	X		
W206	X	X	X	X		
W208	X	X	X	X		
W216			X	X	X	X
W218	X	X	X	X		
W219	X	X	X	X		
W220	X	X	X	X		
W222	X	X	X	X		
W226	X	X	X	X		
W227	X	X	X	X		
W228	X	X	X	X		
W229	X	X	X	X		
W230	X	X	X	X		
W232	X	X	X	X		
W236	X	X	X	X		
W237	X	X	X	X		
W239	X	X	X	X		
W242	X	X	X	X		
W244	X	X	X	X		



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MOLD & DIE MTD PTS

RED A/O = MEDIUM SPEC

Part#	Grit	Mandrel
B41-R-30561	80	1/8x1-1/2
B42-R-16215	60	1/8x1-1/2
B43-R-31049	80	1/8x1-1/2
B44-R-30566	80	1/8x1-1/2
B45-R-30562	80	1/8x1-1/2
B52-R-30327	80	1/8x1-1/2
B53-R-122	100	1/8x1-1/2
B55-R-797	80	1/8x1-1/2
B91-R-21172	60	1/8x1-1/2
B96-R-32422	80	1/8x1-1/2
B97-R-30567	80	1/8x1-1/2
B111-R-10116-NC	60	1/8x1-1/2
B112-R-1037-NC	60	1/8x1-1/2
B121-R-1163-NC	60	1/8x1-1/2
B122-R-21173	60	1/8x1-1/2
B123-R-16380	80	1/8x1-1/2
B125-R-30751	80	1/8x1-1/2
B132-R-19620	80	1/8x1-1/2
B133-R-16377	80	1/8x1-1/2
B135-R-19625	80	1/8x1-1/2
B136-R-16613	80	1/8x1-1/2
SP510-R-29498-NC	60	1/8x1-1/2
SP529-R-30006	80	1/8x1-1/2
SP530-R-29995	80	1/8x1-1/2
SP585-R-31945	80	1/8x1-1/2
W142-R-1748	100	1/8x1-1/2
W144-R-16280	80	1/8x1-1/2
W145-R-16249	80	1/8x1-1/2
W153-R-16283	80	1/8x1-1/2
W154-R-30564	80	1/8x1-1/2
W160-R-16259	80	1/8x1-1/2
W162-R-30565	80	1/8x1-1/2
W163-R-16213	80	1/8x1-1/2
W169-R-19650	60	1/8x1-1/2
W176-R-16299	60	1/8x1-1/2
W185-R-1458-NC	60	1/8x1-1/2
B43-R-16509-NC	100	3/32x1-1/2
B64-R-17321-NC	100	3/32x1-1/2
B105-R-17680-NC	100	3/32x1-1/2
B123-R-16446-NC	100	3/32x1-1/2
SP121-R-17644-NC	60	3/32x1-1/2
SP171-R-16431-NC	100	3/32x1-1/2
SP184-R-17322-NC	100	3/32x1-1/2
W142-R-17628-NC	100	3/32x1-1/2
W149-R-16469-NC	100	3/32x1-1/2
W154-R-16466-NC	80	3/32x1-1/2
W160-R-21175	80	3/32x1-1/2
W163-R-16383-NC	80	3/32x1-1/2
W172-R-17437-NC	80	3/32x1-1/2
W181-R-17433-NC	80	3/32x1-1/2
B44-R-30887	80	3mmx1-1/2
B45-R-19591	80	3mmx1-1/2
B52-R-30885	80	3mmx1-1/2
B53-R-19595	100	3mmx1-1/2
B55-R-19597	100	3mmx1-1/2
B122-R-19613	60	3mmx1-1/2
B123-R-16445	80	3mmx1-1/2
B135-R-19623	80	3mmx1-1/2
W144-R-16477	80	3mmx1-1/2
W152-R-19638	80	3mmx1-1/2
W153-R-19640	80	3mmx1-1/2
W154-R-30886	80	3mmx1-1/2
W160-R-19642	80	3mmx1-1/2
W162-R-19646	80	3mmx1-1/2
W163-R-16500	80	3mmx1-1/2
W200-R-21441	60	3mmx1-1/2

GRIER offers a wide range of mounted points for use in the Mold & Die industry. The **BLUE** spec is a well known standard that holds shape very well while cutting fast and leaving a smooth finish. The **RED** spec is fast cutting and non-loading for use on hard metals. The **WHITE** spec is very fine grit to be used for great surface finish. The

Cotton Fiber product is good for polishing and the **Green Silicon Carbide** spec is used for grinding on carbide materials. Don't forget to use a **dressing stone** with rounded grooves to keep your points operating at their best.

Packaged in quantities of 12, 36 or 72 typically, depending on size.

BLUE A/O = HARD SPEC

Part#	Grit	Mandrel
B41-GB-32198	120	1/8x1-1/2
B42-GB-16398	120	1/8x1-1/2
B44-GB-30555	120	1/8x1-1/2
B45-GB-30321	120	1/8x1-1/2
B51-GB-16399	120	1/8x1-1/2
B52-GB-30175	120	1/8x1-1/2
B53-GB-16453	120	1/8x1-1/2
B55-GB-19599	120	1/8x1-1/2
B82-GB-16401	120	1/8x1-1/2
B96-GB-16355	120	1/8x1-1/2
B97-GB-30557	120	1/8x1-1/2
B98-GB-16403	120	1/8x1-1/2
B103-GB-16339	120	1/8x1-1/2
B105-GB-16347	120	1/8x1-1/2
B112-GB-19611	120	1/8x1-1/2
B121-GB-19612	120	1/8x1-1/2
B122-GB-16709	120	1/8x1-1/2
B123-GB-16356	120	1/8x1-1/2
B124-GB-16406	120	1/8x1-1/2
B125-GB-30749	120	1/8x1-1/2
B135-GB-16409	120	1/8x1-1/2
SP529-GB-30005	120	1/8x1-1/2
SP530-GB-30007	120	1/8x1-1/2
SP585-GB-31944	120	1/8x1-1/2
W144-GB-30323	120	1/8x1-1/2
W163-GB-30325	120	1/8x1-1/2
W170-GB-30554	120	1/8x1-1/2
B123-GB-19655	120	3/32x1-1/2
SP172-GB-16447	120	3/32x1-1/2
SP175-GB-16395	120	3/32x1-1/2
SP177-GB-16420	120	3/32x1-1/2
W144-GB-16454	120	3/32x1-1/2
W163-GB-25765	120	3/32x1-1/2
B43-GB-19589	120	3mmx1-1/2
B44-GB-30320	120	3mmx1-1/2
B45-GB-30322	120	3mmx1-1/2
B52-GB-32051	120	3mmx1-1/2
B53-GB-19596	120	3mmx1-1/2
B55-GB-19598	120	3mmx1-1/2
B71-GB-33676	120	3mmx1-1/2
B91-GB-33677	120	3mmx1-1/2
B96-GB-16439	120	3mmx1-1/2
B97-GB-30559	120	3mmx1-1/2
B98-GB-19609	120	3mmx1-1/2
B112-GB-33639	120	3mmx1-1/2
B122-GB-19614	120	3mmx1-1/2
B123-GB-19615	120	3mmx1-1/2
B124-GB-19617	120	3mmx1-1/2
B125-GB-30888	120	3mmx1-1/2
B135-GB-19624	120	3mmx1-1/2
SP529-GB-32968	120	3mmx1-1/2
SP585-GB-31949	120	3mmx1-1/2
W144-GB-30324	120	3mmx1-1/2
W163-GB-30326	120	3mmx1-1/2
W170-GB-30560	120	3mmx1-1/2

WHITE A/O = FINE GRIT

Part#	Grit	Mandrel
B43-W-17141	400	3/32x1-1/2
B55-W-17435	400	3/32x1-1/2
B64-W-17200	400	3/32x1-1/2
B105-W-16511	400	3/32x1-1/2
B106-W-26541	400	3/32x1-1/2
B123-W-16396	400	3/32x1-1/2
B124-W-16323	400	3/32x1-1/2
SP171-W-16422	400	3/32x1-1/2
SP172-W-16391	400	3/32x1-1/2
SP173-W-16392	400	3/32x1-1/2
SP185-W-16457	400	3/32x1-1/2
SP224-W-16515	400	3/32x1-1/2
SP403-W-26540	400	3/32x1-1/2
W158-W-16393	400	3/32x1-1/2

GREEN S/C for CARBIDE

Part#	Grit	Mandrel
B43-GC-18983	100	1/8x1-1/2
B51-GC-17163	100	1/8x1-1/2
B136-GC-18051	120	1/8x1-1/2
SP121-GC-17189	120	1/8x1-1/2
SP184-GC-17578	120	1/8x1-1/2
B55-GC-17158	150	3/32x1-1/2
B123-GC-17663	120	3/32x1-1/2
W181-GC-17190	150	3/32x1-1/2

DRESSING STONE

Part#	ST-3-1/2-C-17166
Size	9/16 x 1-3/8 x 3-1/2
Grit	46
Grain	Silicon Carbide
Grooves	Round diameters 1/4, 3/16, 1/8 & 1/16"

COTTON FIBER A/O = POLISHING

Part#	Grit	Grade	Mandrel
W144-X-26869	180	SOFT	1/8x1-1/2
W152-X-15295	80	SOFT	1/8x1-1/2
W152-X-15815	320	SOFT	1/8x1-1/2
W160-X-7381	80	SOFT	1/8x1-1/2
W163-X-7354	80	SOFT	1/8x1-1/2
W204-X-2582	320	SOFT	1/8x1-1/2
W236-X-11622	54	SOFT	1/4x1-1/2
W236-X-18192	80	SOFT	1/4x1-1/2
W144-X-14637	120	MEDIUM	1/8x1-1/2
W145-X-16384	80	MEDIUM	1/8x1-1/2
W145-X-26721	120	MEDIUM	1/8x1-1/2
W145-X-34166	180	MEDIUM	1/8x1-1/2
W145-X-34167	320	MEDIUM	1/8x1-1/2
W146-X-17983	80	MEDIUM	1/8x1-1/2
W146-X-3765	120	MEDIUM	1/8x1-1/2
W154-X-10175	80	MEDIUM	1/8x1-1/2
W154-X-11288	120	MEDIUM	1/8x1-1/2
W154-X-11481	180	MEDIUM	1/8x1-1/2
W154-X-27538	320	MEDIUM	1/8x1-1/2
W163-X-10889	120	MEDIUM	1/8x1-1/2
W163-X-11480	320	MEDIUM	1/8x1-1/2
W163-X-11855	180	MEDIUM	1/8x1-1/2
W163-X-8573	80	MEDIUM	1/8x1-1/2
W176-X-11289	180	MEDIUM	1/8x1-1/2
W176-X-34168	320	MEDIUM	1/8x1-1/2
W176-X-8574	80	MEDIUM	1/8x1-1/2
W176-X-9977	120	MEDIUM	1/8x1-1/2
W185-X-11290	120	MEDIUM	1/8x1-1/2
W185-X-19668	180	MEDIUM	1/8x1-1/2
W185-X-34169	320	MEDIUM	1/8x1-1/2
W185-X-8527	80	MEDIUM	1/8x1-1/2
W144-X-19660	80	MEDIUM	3mmx1-1/2
W146-X-17317	320	HARD	1/8x1-1/2
W146-X-18525	180	HARD	1/8x1-1/2
W163-X-10889	120	HARD	1/8x1-1/2
W163-X-8573	80	HARD	1/8x1-1/2

For more information, see our other handouts:

- General Abrasive Information
- Mounted Points
- Carbide Burs
- And a wide variety of other specialty item handouts

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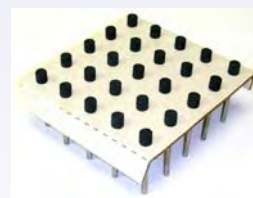


JIG GRINDING MTD WHEELS

GRIER Part #	Shape		Specification			USE	Mandrel		Qty/ Box
	Dia.	Thk.	Grit	Hard.	Color		Dia.	Lng.	
W144-GC-18069	1/8	1/4	80/100	I	GREEN	1	1/8	1 5/16	25
W144-W-18070	1/8	1/4	100	S	OFF-WHITE	2	1/8	1 5/16	25
W144-R-18071	1/8	1/4	90	P	BROWN	3	1/8	1 5/16	25
W144-W-18072	1/8	1/4	80	P	OFF-WHITE	4	1/8	1 5/16	25
W152-GC-18073	3/16	1/4	80/100	P	GREEN	1	1/8	1 1/2	25
W152-W-18074	3/16	1/4	60	R	OFF-WHITE	2	1/8	1 1/2	25
W152-R-18075	3/16	1/4	90	P	BROWN	3	1/8	1 1/2	25
W152-W-18076	3/16	1/4	80	N	OFF-WHITE	4	1/8	1 1/2	25
W160-GC-18077	1/4	1/4	60/80	L	GREEN	1	1/8	1 1/2	25
W160-W-18078	1/4	1/4	80	R	OFF-WHITE	2	1/8	1 1/2	25
W160-R-18079	1/4	1/4	90	R	BROWN	3	1/8	1 1/2	25
W160-W-18080	1/4	1/4	80	N	OFF-WHITE	4	1/8	1 1/2	25
W176-GC-18081	3/8	1/2	60/80	L	GREEN	1	1/4	1 5/8	25
W176-W-18082	3/8	1/2	60	Q	OFF-WHITE	2	1/4	1 5/8	25
W176-GB-18083	3/8	1/2	60	P	BLUE	3	1/4	1 5/8	25
W176-W-18084	3/8	1/2	80	N	OFF-WHITE	4	1/4	1 5/8	25
W185-GC-18085	1/2	1/2	60/80	L	GREEN	1	1/4	1 5/8	25
W185-W-18086	1/2	1/2	60	Q	OFF-WHITE	2	1/4	1 5/8	25
W185-GB-18087	1/2	1/2	60	P	BLUE	3	1/4	1 5/8	25
W185-W-18088	1/2	1/2	80	N	OFF-WHITE	4	1/4	1 5/8	25
W160-GC-18089	1/4	1/4	60/80	L	GREEN	1	1/4	3	25
W160-W-18090	1/4	1/4	80	R	OFF-WHITE	2	1/4	3	25
W160-R-18091	1/4	1/4	90	Q	BROWN	3	1/4	3	25
W160-W-18092	1/4	1/4	80	N	OFF-WHITE	4	1/4	3	25
W176-GC-18093	3/8	1/2	60/80	L	GREEN	1	1/4	3	25
W176-W-18094	3/8	1/2	60	R	OFF-WHITE	2	1/4	3	25
W176-GB-18095	3/8	1/2	60	L	BLUE	3	1/4	3	25
W176-W-18096	3/8	1/2	80	O	OFF-WHITE	4	1/4	3	25
W185-GC-18097	1/2	1/2	60/80	L	GREEN	1	1/4	3	25
W185-W-18098	1/2	1/2	80	Q	OFF-WHITE	2	1/4	3	25
W185-GB-18099	1/2	1/2	60	P	BLUE	3	1/4	3	25
W185-W-18100	1/2	1/2	80	O	OFF-WHITE	4	1/4	3	25
W203-GC-18101	3/4	1/2	60/80	L	GREEN	1	1/4	2 1/8	25
W203-W-18102	3/4	1/2	80	O	OFF-WHITE	2	1/4	2 1/8	25
W203-GB-18103	3/4	1/2	60	P	BLUE	3	1/4	2 1/8	25
W203-W-18104	3/4	1/2	80	N	OFF-WHITE	4	1/4	2 1/8	25
W218-GC-18105	1	1/2	60/80	L	GREEN	1	1/4	2 1/8	25
W218-W-18106	1	1/2	60	P	OFF-WHITE	2	1/4	2 1/8	25
W218-GB-18107	1	1/2	60	P	BLUE	3	1/4	2 1/8	25
W218-W-18108	1	1/2	80	N	OFF-WHITE	4	1/4	2 1/8	25
W203-GC-17455	3/4	1/2	60	I	GREEN	1	3/8	3 5/8	12
W203-GB-17382	3/4	1/2	60	J	BLUE	3	3/8	3 5/8	12
W203-GB-17968	3/4	1/2	80	L	BLUE	4	3/8	3 5/8	12
W218-GC-17456	1	1/2	60	I	GREEN	1	3/8	3 5/8	12
W218-GB-17692	1	1/2	60	J	BLUE	3	3/8	3 5/8	12
W218-W-17613	1	1/2	80	K	WHITE	4	3/8	3 5/8	12
W218-GC-17762	1	1/2	60	I	GREEN	1	3/8	2 1/8	12
W218-GB-17453	1	1/2	60	J	BLUE	3	3/8	2 1/8	12
W218-GB-17969	1	1/2	80	L	BLUE	4	3/8	2 1/8	12
W236-GC-17763	1 1/2	1/2	60	I	GREEN	1	3/8	2 1/8	12
W236-GB-17764	1 1/2	1/2	60	J	BLUE	3	3/8	2 1/8	12
W236-GB-17970	1 1/2	1/2	80	L	BLUE	4	3/8	2 1/8	12
W236-GC-17765	1 1/2	1/2	60	I	GREEN	1	3/8	2 1/8	12
W236-GB-17614	1 1/2	1/2	60	J	BLUE	3	3/8	2 3/4	12
W236-W-17454	1 1/2	1/2	80	K	WHITE	4	3/8	2 3/4	12

1 = Use for plastics, cast iron, glass, other non-metallic materials & non-ferrous metals
2 = Use for stainless & construction steels
3 = Use for steels for tool & die
4 = Use for harder stainless steels & hardened steels

GRIER's JIG grinding mounted wheels are specially formulated and precision made and for this precise craft. JIG grinding can be performed on many materials, including steels (hard and soft), stainless steel, non-ferrous materials, cast-iron, glass, ceramics, plastics, rubber and fiber optics.



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CENTER LAPS



GRIER's Center Lap Mounted Points have a 60 degree included angle. Center Lapping is used when you need to finish center holes in parts that require turning or grinding between centers. Center Lap Mounted Points are wax treated to minimize loading.

GRIER Part #	Shape		Specification			MAX RPM	Mandrel		Qty/ Box
	Dia.	Thk.	Grit	Hard.	Color		Dia.	Lng.	
W189L-G-27699	1/2	2	150	U	BROWN	48,000	1/2	1 1/4	50
W189L-G-27700	1/2	2	80	T	BROWN	48,000	1/2	1 1/4	50
W197L-G-27709	5/8	2	150	U	BROWN	42,000	1/2	1 1/4	50
W197L-G-27710	5/8	2	80	T	BROWN	42,000	1/2	1 1/4	50
W208L-G-27707	3/4	2	150	U	BROWN	37,500	1/2	1 1/4	50
W208L-G-27708	3/4	2	80	T	BROWN	37,500	1/2	1 1/4	50
W222L-G-27697	1	2	150	U	BROWN	31,800	1/2	1 1/4	50
W222L-G-27698	1	2	80	T	BROWN	31,800	1/2	1 1/4	50
W232L-G-27703	1 1/4	2	150	U	BROWN	28,500	1/2	1 1/4	25
W232L-G-27704	1 1/4	2	80	T	BROWN	28,500	1/2	1 1/4	25
W239L-G-27701	1 1/2	2	150	U	BROWN	25,470	1/2	1 1/4	25
W239L-G-27702	1 1/2	2	80	T	BROWN	25,470	1/2	1 1/4	25
W244L-G-27705	2	2	150	U	BROWN	19,100	1/2	1 1/4	25
W244L-G-27706	2	2	80	T	BROWN	19,100	1/2	1 1/4	25

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EDGE-MASTER

The **EDGE-MASTER** is a unique solution for fine finishing of various edges. Initially developed for aerospace leading and trailing edges, the **EDGE-MASTER** has found many finishing applications outside aerospace, such as recreational, medical, automotive, tool rooms, etc.

The base material is GRIER-TEX: a non-woven cotton fiber abrasive available in different grains, grits, hardnesses and bonds. Once the GRIER-TEX is mounted onto a mandrel, a variety of radii can be cut into the abrasive to match a specific contour of your work-piece.



*See our **GRIER-TEX** brochure for more details on the base material!*



We even offer the **TRIFECTA CUT** with 3 radii cuts on the same head.

*Talk to your sales representative for more details. The **EDGE-MASTER** is available on either 1/4" or 1/8" mandrels and the head size varies depending on the size of the radius cut and the specific application. Follow all ANSI grinding guidelines for Maximum RPM Ratings when using this or any grinding abrasive products.*

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Mounted Point KITS

Need a variety of different mounted points?
Not sure which ones you like? Just want a few of each?

GRIER Abrasive offers...

Kits of all Shapes & Sizes

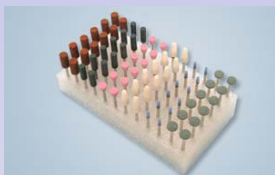
"I WANT IT ALL"

VITRIFIED KITS



Part #: KT-1/8-72BW-COMB
Mandrels: 1/8" x 1-1/2"
Packaging: Stand up Box

QTY: 72 pcs
Contents: Grier products with progression of grades from aggressive material removal down to blending and polishing. All in common shapes and sizes.



Part #: KIT-3/32-RAND-72
Mandrels: 3/32" x 1-1/2"
Packaging: Stand up Box

QTY: 72 pcs
Contents: Random shapes and grades (varies from kit to kit).



Part #: (left) KIT-1/8-WB-BLUE
Part #: KIT-1/8-WB-RED
Part #: KIT-1/8-WB-WHITE
Mandrels: 1/8" x 1-1/2"
Packaging: Stand up Box

QTY: 100 pcs
Contents: B & W shapes. Three different grades to choose from: Blue, Red and White. Blue kit is pictured at left.



Part #: KIT-1/8-RAND-100
Mandrels: 1/8" x 1-1/2"
Packaging: Stand up Box

QTY: 100 pcs
Contents: Random shapes and grades (varies from kit to kit).



Part #: (left) KIT-1/4-AW-BLUE
Part #: KIT-1/4-AW-RED
Mandrels: 1/4" x 1-1/2"
Packaging: Stand up Box

QTY: 12 pcs
Contents: A & W shapes. Two different grades to choose from: Blue and Red. Blue kit is pictured at left.



Part #: KIT-1/4-AW-BLUE 50PC
Part #: (left) KIT-1/4-AW-RED 50PC
Mandrels: 1/4" x 1-1/2"
Packaging: Stand up Box

QTY: 50 pcs
Contents: A & W shapes. Two different grades to choose from: Blue and Red. Red kit is pictured at left.



Part #: KIT-1/4-RAND-50
Mandrels: 1/4" x 1-1/2"
Packaging: Stand up Box

QTY: 50 pcs
Contents: Random shapes and grades (varies from kit to kit).



Part #: KIT-1/4-BLUE-100
Mandrels: 1/4" x 1-1/2"
Packaging: Stand up Box

QTY: 100 pcs
Contents: A & W shapes in Blue Grade.

RESIN



Part #: (left) **KT-1/4-14AW-RSN**
 Part #: **KT-1/4-14AW-ZRC**
 Mandrels: **1/4" x 1-1/2"**
 Packaging: **Bagged**

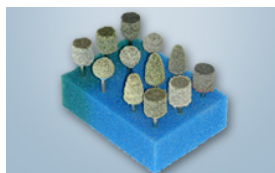
QTY: **14 pcs**
 Contents: **A & W shapes. Two different grades to choose from: Regular A/O and Zirconia. Regular A/O kit is pictured left.**

GRIER-BRITE



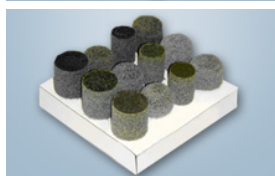
Part #: **KIT-G/B-COMB 6PC**
 Mandrels: **1/8" x 1-1/2"**
 Packaging: **Plastic Box**

QTY: **6 pcs**
 Contents: **B & W shapes in each of 6 different formulas.**



Part #: **KT-1/8-12BW-GB**
 Mandrels: **1/8" x 1-1/2"**
 Packaging: **Plastic Box**

QTY: **12 pcs**
 Contents: **B & W shapes in each of 6 different formulas.**



Part #: **KT-1/4-12AW-GB 12PC**
 Mandrels: **1/4" x 1-1/2"**
 Packaging: **Stand up Box**

QTY: **12 pcs**
 Contents: **A & W shapes in N2, N4 and S6 formulas only.**

GRIER-TEX



Part #: **KT-1/8-12BW-GTX**
 Mandrels: **1/8" x 1-1/2"**
 Packaging: **Plastic Box**

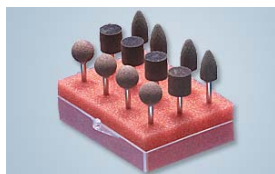
QTY: **12 pcs**
 Contents: **B& W shapes in Soft and Hard formulas.**



Part #: **KT-1/4-12AW-GTX**
 Mandrels: **1/4" x 1-1/2"**
 Packaging: **Stand up Box**

QTY: **12 pcs**
 Contents: **A & W shapes in Soft and Hard formulas.**

RUB-BRITE



Part #: **KT-RUB-1/8-12PC**
 Mandrels: **1/8" x 1-1/2"**
 Packaging: **Plastic Box**

QTY: **12 pcs**
 Contents: **B & W shapes in 80-Reg, 80-Hard, 120-Reg and 120-Hard formulas.**



Part #: **KT-RUB-1/8-36PC**
 Mandrels: **1/8" x 1-1/2"**
 Packaging: **Stand up Box**

QTY: **36 pcs**
 Contents: **B & W shapes in 80-Reg, 80-Hard, 120-Reg and 120-Hard formulas.**



Part #: **KT-RUB-1/4-12PC**
 Mandrels: **1/4" x 1-1/2"**
 Packaging: **Stand up Box**

QTY: **12 pcs**
 Contents: **A & W shapes in 46-Reg, 46-Hard, 80-Reg and 80-Hard formulas.**



Part #: **KT-RUB-1/4-24PC**
 Mandrels: **1/4" x 1-1/2"**
 Packaging: **Stand up Box**

QTY: **24 pcs**
 Contents: **A & W shapes in 46-Reg, 46-Hard, 80-Reg and 80-Hard formulas.**



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PLUGS & CONES

PLUG & CONE wheels are furnished in any GRIER specification and with a complete choice of sizes. These wheels are bonded with GRIER's specifically formulated resin and vitrified bonds to give fast stock removal while holding shape and giving long life.

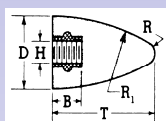
APPLICATIONS

- Hogging Material
- Weld Seam Removal
- Surface Prep

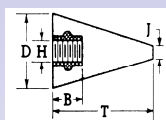
SIZES

- Diameters up to 3"
- Thickness up to 4"
- Standard threaded inserts

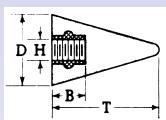
T16 Cone



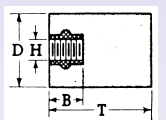
T17 Cone



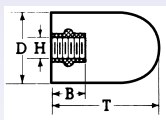
T17R Cone



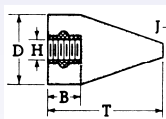
T18 PLUG



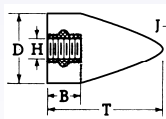
T18R PLUG



T19 Cone



T19R Cone



For more information, see our other handouts:

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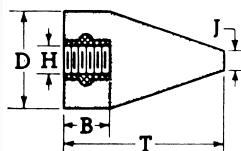
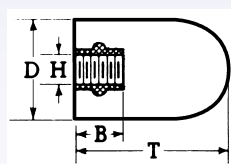
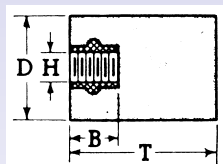
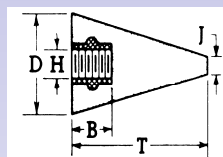
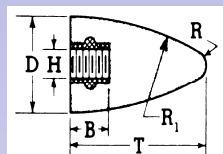


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RIGHT NOW!

PLUGS & CONES



TYPE	Part Number	Base Diameter (D)	Thick (T)	Tip Diameter (J)	Insert thread	Grit
16	T16-1-1/2B21283	1 1/2	2 1/2		3/8-24	24
	T16-1-1/2B20513	1 1/2	2 1/2		5/8-11	24
	T16-1-1/2B20677	1 1/2	3		3/8-24	16
	T16-1-1/2B20516	1 1/2	3		5/8-11	16
	T16-1-1/2B20518	1 1/2	3		5/8-11	24
	T16-1-3/4B20519	1 3/4	3		5/8-11	20
	T16-2B21404	2	3		3/8-24	24
	T16-2B21204	2	3		5/8-11	16
	T16-2-3/4B21219	2 3/4	3 1/2		5/8-11	16
	T16-2-3/4B20522	2 3/4	3 1/2		5/8-11	24
17	T17-1-1/2B20686	1 1/2	3	1/2	3/8-24	16
	T17-1-1/2B20528	1 1/2	3	1/2	3/8-24	24
	T17-2B20942	2	3	3/4	5/8-11	16
	T17-2B20690	2	4	3/4	5/8-11	16
18	T18-1B20530	1	2		3/8-24	20
	T18-1B20884	1	3		3/8-24	24
	T18-1-1/2B20697	1 1/2	2 1/2		3/8-24	16
	T18-1-1/2B20534	1 1/2	2 1/2		3/8-24	24
	T18-1-1/2B20714	1 1/2	2 1/2		5/8-11	16
	T18-1-1/2B25606	1 1/2	2 1/2		5/8-11	24
	T18-1-1/2B21527	1 1/2	3		3/8-24	16
	T18-1-1/2B20989	1 1/2	3		3/8-24	24
	T18-1-1/2B21052	1 1/2	3		5/8-11	16
	T18-1-1/2B25601	1 1/2	3		5/8-11	24
	T18-2B20708	2	3		5/8-11	16
	T18-2B20886	2	3		5/8-11	24
	T18-2B20716	2	4		5/8-11	20
18R	T18R-1-1/2B25607	1 1/2	2 1/2		3/8-24	16
	T18R-1-1/2B25608	1 1/2	2 1/2		3/8-24	24
	T18R-1-1/2B20704	1 1/2	2 1/2		5/8-11	16
	T18R-1-1/2B20547	1 1/2	2 1/2		5/8-11	24
	T18R-1-1/2B25602	1 1/2	3		3/8-24	16
	T18R-1-1/2B25603	1 1/2	3		3/8-24	24
	T18R-1-1/2B25605	1 1/2	3		5/8-11	24
	T18R-2B21196	2	3		5/8-11	16
	T18R-2B20536	2	4		5/8-11	16
	T18R-3B20711	3	3		5/8-11	16
19	T19 1-1/2B20549	1 1/2	3	1/2	3/8-24	16
	T19-2B20723	2	4	5/8	5/8-11	16

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GRINDING WHEELS

How do you grind?

Do you need a general purpose bench & pedestal grinding wheel?
Or a precision surface grinding wheel? Or cup wheels for the tool-room?
What about those internal applications? ...
You're in luck, GRIER has solutions for your grinding needs.



All GRIER wheels are available in standard grains, grits, bonds and structures. Each application is reviewed thoroughly to ensure the proper grinding wheel is selected for YOU.

GRIER has many standard parts, so ask for help choosing the right wheel for your application.

GRIER also designs and supplies custom formulas and shapes, so contact us to solve those unique applications.

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South Holland, IL 60473

Bench & Surface Wheels

- Diameter up to 12"
- Thickness up to 2"
- All standard hole sizes
- Types 1,5,6,7,11 & 12 are typical

Internal Wheels

- Diameter up to 4"
- Thickness up to 4"
- Types 1, 5 & 6 are typical

For more information, see our other handouts:

- General Abrasive Information
- Mounted Points
- Carbide Burs
- And a wide variety of other specialty item handouts



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RESIN WHEELS

GRIER offers resin wheels in both reinforced and non-reinforced and can be made in diameters up to 12" with max thickness of 2". A wide variety of standard formulas are available, and custom grades are welcome.

A sub-set of our resin wheels is the "cut-off wheel" category. Cut-off wheels are all reinforced and start at a diameter of 1-1/4" with thicknesses as small as 1/32". GRIER offers 4 levels of performance to be matched to the specific application.



CUT-OFF WHEELS



APPLICATIONS

- Foundry-Gate/Riser Removal
- General Tool Room
- Metal Fabrication
- Construction
- Any Portable Grinder
- Pipe Cutting

Wheel Type	Cut	Life	Materials	Cost
A/O = Aluminum Oxide	Faster	Long	General Purpose	Low
LAZER = Aluminum Oxide & Ceramic	Fastest	Long	General Purpose	Medium
ZIRC = Aluminum Oxide & Zirconia	Fast	Longest	General Alloys & Stainless	Medium
ZIRC+ = Aluminum Oxide, Zirconia & Ceramic	Fastest	Longer	Exotic Alloys & Harder Metals	High

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GRINDING WHEELS: BENCH

TYPE 1 -- NO RECESS SILICON CARBIDE -- GREEN (GC)

<u>GRIER</u> <u>PART #</u>	<u>Dia</u>	<u>Thk.</u>	<u>Hole</u> <u>Dia</u>	<u>Grit</u>	<u>Pkg</u> <u>Qty</u>
T1-6GC31612	6	1/2	1	60	10
T1-6GC31614	6	1/2	1	120	10
T1-6GC31615	6	3/4	1	60	10
T1-6GC31616	6	3/4	1	80	10
T1-6GC31617	6	3/4	1	120	10
T1-6GC31618	6	1	1	60	10
T1-6GC31619	6	1	1	80	10
T1-6GC31620	6	1	1	120	10
T1-7GC31627	7	1	1	60	10
T1-7GC31628	7	1	1	80	10
T1-7GC31629	7	1	1	120	10
T1-8GC31632	8	1	1	60	10
T1-8GC31633	8	1	1	80	10
T1-8GC31634	8	1	1	120	10
T1-10GC31635	10	1	1 1/4	60	5
T1-10GC31636	10	1	1 1/4	80	5
T1-10GC31637	10	1	1 1/4	120	5
T1-10GC31639	10	1 1/4	1 1/4	60	4
T1-10GC31638	10	1 1/4	1 1/4	80	4
T1-10GC31640	10	1 1/2	1 1/4	80	4
T1-12GC31643	12	2	1 1/4	60	4
T1-12GC31644	12	2	1 1/4	80	4

TYPE 1 -- NO RECESS					
ALUMINUM OXIDE -- GRAY (27A)					
GRIER PART #	Dia	Thk.	Hole Dia	Grit	Pkg Qty
T1-6G31650	6	1/2	1	46	10
T1-6G31651	6	1/2	1	60	10
T1-6G31652	6	1/2	1	80	10
T1-6G31653	6	3/4	1	36	10
T1-6G31654	6	3/4	1	46	10
T1-6G31655	6	3/4	1	60	10
T1-6G31656	6	3/4	1	80	10
T1-6G31660	6	1	1	36	10
T1-6G31657	6	1	1	46	10
T1-6G31658	6	1	1	60	10
T1-6G31659	6	1	1	80	10
T1-7G31664	7	1	1	36	10
T1-7G31665	7	1	1	46	10
T1-7G31666	7	1	1	60	10
T1-7G31667	7	1	1	80	10
T1-8G31668	8	3/4	1	46	10
T1-8G31669	8	3/4	1	60	10
T1-8G31670	8	1	1	36	10
T1-8G31671	8	1	1	46	10
T1-8G31672	8	1	1	60	10
T1-8G31673	8	1	1	80	10
T1-10G31674	10	1	1 1/4	36	5
T1-10G31675	10	1	1 1/4	46	5
T1-10G31676	10	1	1 1/4	60	5
T1-10G31677	10	1	1 1/4	80	5
T1-10G31060	10	1 1/4	1 1/4	36	4
T1-10G31678	10	1 1/4	1 1/4	46	4
T1-10G31679	10	1 1/4	1 1/4	60	4
T1-10G31183	10	1 1/4	1 1/4	80	4
T1-10G31680	10	1 1/2	1	36	4
T1-10G31681	10	1 1/2	1 1/4	46	4
T1-10G31178	10	1 1/2	1 1/4	60	4
T1-12G31685	12	1 1/2	1 1/4	36	4
T1-12G31686	12	1 1/2	1 1/4	46	4
T1-12G33999	12	2	1 1/4	36	4
T1-12G31688	12	2	1 1/4	46	4
T1-12G34026	12	2	1 1/4	60	4
T1-12G31687	12	2	1 1/2	36	4
T1-12G31689	12	2	1 1/2	60	4
T1-12G31690	12	2	1 1/2	80	4



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GRINDING WHEELS: SURFACE

SURFACE GRINDING WHEELS TYPE 1 -- NO RECESS

			GRIER PART #'S				
<u>Grit</u>	<u>Hardness</u>	<u>Pkg Qty</u>	<u>White-28A</u>	<u>Pink-29A</u>	<u>Premium Off-White-23A</u>	<u>Premium Ruby-36A</u>	<u>Ultra Premium Ceramic Light Blue-183A</u>

6" Dia. X 1/4" W X 1-1/4" Hole

60	K	10		T1-6P31228			
80	K	10		T1-6P31229			T1-6WB31425

6" Dia. X 1/2" W X 1-1/4" Hole

46	K	10	T1-6W31224	T1-6P31230			
60	K	10	T1-6W31458	T1-6P31231			
80	K	10	T1-6W31225	T1-6P31233			

7" Dia. X 1/4" W X 1-1/4" Hole

46	H	10		T1-7P31139			
46	I	10		T1-7P31115			
46	J	10	T1-7W31420	T1-7P31433	T1-7W31132	T1-7R31150	
46	K	10	T1-7W31421	T1-7P31116			
60	I	10	T1-7W31423	T1-7P31117	T1-7W31436		T1-7WB31188
60	J	10	T1-7W31424	T1-7P31052	T1-7W31134		
60	K	10	T1-7W31425	T1-7P31118	T1-7W30190	T1-7R31155	T1-7WB31190
80	I	10		T1-7P31120	T1-7W31437		
80	J	10	T1-7W31066	T1-7P31121			
80	K	10	T1-7W31426	T1-7P31122	T1-7W31438		T1-7WB31192
100	I	10	T1-7W31428	T1-7P31124			
100	J	10	T1-7W31429	T1-7P31125	T1-7W31136		
100	K	10	T1-7W31430	T1-7P31126			T1-7WB31194
120	I	10		T1-7P31128			
120	J	10		T1-7P31129			
120	K	10	T1-7W31800	T1-7P30918	T1-7W31138		
120	L	10					
150	K	10	T1-7W31432	T1-7P31130			

SURFACE GRINDING WHEELS

TYPE 1 -- NO RECESS (Continued)

			GRIER PART #'S				
<u>Grit</u>	<u>Hardness</u>	<u>Pkg Qty</u>	<u>White-28A</u>	<u>Pink-29A</u>	<u>Premium Off-White-23A</u>	<u>Premium Ruby-36A</u>	<u>Ultra Premium Ceramic Light Blue-183A</u>

7" Dia. X 1/2" W X 1-1/4" Hole							
46	G-porous	10				T1-7R33343	
46	H	10	T1-7W31409	T1-7P31055	T1-7W31447	T1-7R31510	
46	I	10	T1-7W31222	T1-7P31056	T1-7W31448		T1-7WB31207
46	J	10	T1-7W31410	T1-7P31057	T1-7W31449	T1-7R31061	T1-7WB31208
46	J-porous	10	T1-7W31223	T1-7P31148			
46	K	10	T1-7W31411	T1-7P31439	T1-7W31054	T1-7R31053	
60	G-porous	10	T1-7W31149				
60	H	10	T1-7W31412	T1-7P31440	T1-7W31450		
60	I	10	T1-7W31413	T1-7P31441	T1-7W31451	T1-7R31513	
60	J	10	T1-7W31414	T1-7P31442	T1-7W31452	T1-7R31514	
60	K	10	T1-7W31059	T1-7P31443	T1-7W31144	T1-7R31515	T1-7WB31212
80	H	10	T1-7W31801				
80	I	10	T1-7W31415	T1-7P31444			
80	J	10	T1-7W31416	T1-7P31445	T1-7W31146	T1-7R31516	
80	K	10	T1-7W31067	T1-7P31446	T1-7W31454	T1-7R31517	T1-7WB31215
100	H	10		T1-7P31141			
100	I	10	T1-7W31417		T1-7W31455		
100	K	10	T1-7W31419	T1-7P31143			

7" Dia. X 3/4" W X 1-1/4" Hole							
46	I	10		T1-7P31464			
46	K	10		T1-7P31237			
60	I	10	T1-7W31234	T1-7P31238			
60	J	10				T1-7R31371	
60	K	10	T1-7W31235	T1-7P31239		T1-7R31372	

7" Dia. X 1" W X 1-1/4" Hole							
60	I	10	T1-7W31236				



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SURFACE GRINDING WHEELS

TYPE 1 -- NO RECESS (Continued)

			GRIER PART #'S				
<u>Grit</u>	<u>Hardness</u>	<u>Pkg Qty</u>	<u>White-28A</u>	<u>Pink-29A</u>	<u>Premium Off-White-23A</u>	<u>Premium Ruby-36A</u>	<u>Ultra Premium Ceramic Light Blue-183A</u>

8" Dia. X 1/4" W X 1-1/4" Hole

46	H	10	T1-8W31277	T1-8P31283			
46	J	10				T1-8R31374	
60	I	10	T1-8W31278	T1-8P31284			
60	K	10	T1-8W31467				
80	I	10				T1-8R31376	
80	J	10				T1-8R31377	
80	K	10	T1-8W31468	T1-8P31285	T1-8W31282		
100	K	10	T1-8W31279	T1-8P31286			

8" Dia. X 1/2" W X 1-1/4" Hole

46	G-porous	10				T1-8R33342	
46	H-porous	10	T1-8W31803	T1-8P31288			
46	H	10	T1-8W31469	T1-8P31068	T1-8W31501	T1-8R31518	
46	I	10	T1-8W31470		T1-8W31162	T1-8R31519	T1-8WB31410
46	J	10	T1-8W31471	T1-8P31065	T1-8W31502	T1-8R31520	T1-8WB31411
46	K	10	T1-8W31472		T1-8W31163	T1-8R31521	T1-8WB31412
60	H	10	T1-8W31473				
60	I	10	T1-8W31474	T1-8P31497	T1-8W31164		T1-8WB31413
60	J	10	T1-8W31475		T1-8W31165		
60	K	10	T1-8W31077	T1-8P31498		T1-8R31524	T1-8WB31414
80	I	10	T1-8W31476	T1-8P31160			
80	J	10	T1-8W31477	T1-8P31161			
80	K	10	T1-8W31478				

8" Dia. X 3/4" W X 1-1/4" Hole

46	G-porous	10		T1-8P31291			
46	H	10	T1-8W31479	T1-8P31289			
46	I	10					T1-8WB31415
46	K	10		T1-8P31290			

8" Dia. X 1" W X 1-1/4" Hole

46	I	10			T1-8W31504		T1-8WB31509
46	K	10		T1-8P31171			
60	I	10	T1-8W31481	T1-8P31172			



SURFACE GRINDING WHEELS

TYPE 1 -- NO RECESS (Continued)

			GRIER PART #'S				
Grit	Hardness	Pkg Qty	White-28A	Pink-29A	Premium Off-White-23A	Premium Ruby-36A	Ultra Premium Ceramic Light Blue-183A
10" Dia. X 1/2" W X 3" Hole							
60	I	8		T1-10P31201			
60	J	8	T1-10W31482				
10" Dia. X 3/4" W X 1-1/4" Hole							
46	J	5				T1-10R31197	
10" Dia. X 3/4" W X 3" Hole							
46	I	5	T1-10W31484				
10" Dia. X 1" W X 3" Hole							
46	H	5		T1-10P31306			
46	I	5	T1-10W31303	T1-10P31307	T1-10W31062		T1-10WB31419
46	J	5	T1-10W31487				
46	K	5		T1-10P31309			
60	H	5		T1-10P31310			
60	I	5	T1-10W31304		T1-10W31314		
60	J	5		T1-10P31312			T1-10WB31421
60	K	5			T1-10W31315		
12" Dia. X 1" W X 3" Hole							
46	H-porous	5		T1-12P31336			
46	H	5	T1-12W31492				
46	I	5	T1-12W31493	T1-12P31333			
46	J	5	T1-12W31494	T1-12P31500	T1-12W31407		T1-12WB31430
46	K	5		T1-12P31334			
60	I	5		T1-12P31321			
60	J	5		T1-12P31322			
12" Dia. X 1" W X 5" Hole							
46	H-porous	5		T1-12P31343			
46	I	5	T1-12W31329	T1-12P31340			
60	I	5	T1-12W31330				
60	K	5		T1-12P31342			
12" Dia. X 1-1/2" W X 3" Hole							
46	I	4		T1-12P31346			
12" Dia. X 1-1/2" W X 5" Hole							
46	H	4	T1-12W31332	T1-12P31347	T1-12W31348		



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SURFACE GRINDING WHEELS

TYPE 5 -- RECESS ONE SIDE (See Sizes Below)

					GRIER PART #'S		
Grit	Hardness	Pkg Qty	Recess Dia.	Recess Depth	White-28A	Pink-29A	Premium Off-White-23A

7" Dia. X 3/4" W X 1-1/4" Hole							
46	G-porous	10	2-3/4	1/4			
46	I	10	2-3/4	1/4		T5-7P31240	
46	J	10	2-3/4	1/4	T5-7W33159		
46	K	10	2-3/4	1/4		T5-7P31241	
60	I	10	2-3/4	1/4			
60	K	10	2-3/4	1/4		T5-7P31243	

7" Dia. X 1" W X 1-1/4" Hole							
46	G-porous	10	2-3/4	1/2			
46	H	10	2-3/4	1/2	T5-7W31251	T5-7P31166	
46	I	10	2-3/4	1/2	T5-7W31252	T5-7P31167	
60	I	10	2-3/4	1/2	T5-7W31253	T1-7P31168	
60	K	10	2-3/4	1/2	T5-7W31462	T5-7P31169	

7" Dia. X 1" W X 1-1/4" Hole							
46	H-porous	10	3	1/2	T5-7W33169		
46	H	10	3	1/2	T5-7W31692	T5-7P31255	
46	I	10	3	1/2	T5-7W31463	T5-7P31256	
46	J	10	3	1/2			T5-7W33242
60	I	10	3	1/2	T5-7W31254	T5-7P31809	
60	J	10	3	1/2			T5-7W33245

8" Dia. X 3/4" W X 1-1/4" Hole							
46	H	10	3	1/4			T5-8W33265
46	I	10	3	1/4	T5-8W33185		T5-8W33266
60	J	10	3	1/4	T5-8W33186		

8" Dia. X 1" W X 1-1/4" Hole							
46	H	10	3-1/4	1/2	T5-8W31295	T5-8P31293	
46	I	10	3-1/4	1/2	T5-8W31296	T5-8P31294	T5-8W33271
46	J	10	3-1/4	1/2			T5-8W33272
46	K	10	3-1/4	1/2	T5-8W33189		
60	I	10	3-1/4	1/2	T5-8W32057		
60	K	10	3-1/4	1/2			

12" Dia. X 1-1/2" W X 5" Hole							
46	H	4	7-1/2	1/2			T5-12W33316
46	I	4	7-1/2	1/2	T5-12W31352		
46	J	4	7-1/2	1/2	T5-12W31353	T5-12P31356	
60	K	4	7-1/2	1/2			T5-12W33319



SURFACE GRINDING WHEELS TYPE 7 -- RECESS TWO SIDES (See Sizes Below)

					GRIER PART #'S		
<u>Grit</u>	<u>Hardness</u>	<u>Pkg Qty</u>	<u>Recess Dia.</u>	<u>Recess Depth</u>	<u>White-28A</u>	<u>Pink-29A</u>	<u>Premium Off-White-23A</u>

12" Dia. X 2" W X 5" Hole							
46	H	4	7-1/2	1/2			T7-12W31362
46	I	4	7-1/2	1/2	T7-12W31358	T7-12P31360	
46	J	4	7-1/2	1/2	T7-12W31359	T7-12P31361	



SURFACE GRINDING WHEELS TYPE 11 -- RECESS ONE SIDE (FLARING CUP)

			GRIER PART #'S			
Grit	Hardness	Pkg Qty	White-28A	Pink-29A	Premium Off-White-23A	Premium Ruby-36A

4/3" Dia. X 1-1/2" W X 1-1/4" Hole 5/16" Rim 5/16" Back 1/2"						
46	H	10	T11-4/3W31813			
46	I	10	T11-4/3W31814		T11-4/3W33372	
46	J	10	T11-4/3W31527	T11-4/3P31270		
46	K	10	T11-4/3W31815		T11-4/3W31533	
60	I	10	T11-4/3W31528			
60	J	10	T11-4/3W31529	T11-4/3P31272	T11-4/3W31534	T11-4/3R31174
60	K	10		T11-4/3P31273	T11-4/3W33375	T11-4/3R31175
80	J	10	T11-4/3W31180			
80	K	10	T11-4/3W31530			

5/3-3/4" Dia. X 1-3/4" W X 1-1/4" Hole Rim 1/4" Back 1/2"						
46	H	10	T11-5/3-3/4W31064	T11-5/3-3/4P31262		T11-5/3-3/4R31184
46	I	10	T11-5/3-3/4W31257	T11-5/3-3/4P31532		T11-5/3-3/4R32938
46	J	10	T11-5/3-3/4W31258	T11-5/3-3/4P31263	T11-5/3-3/4W31268	
46	K	10	T11-5/3-3/4W31259	T11-5/3-3/4P31264		T11-5/3-3/4R31186
60	I	10	T11-5/3-3/4W31260	T11-5/3-3/4P31265		
60	J	10	T11-5/3-3/4W31531	T11-5/3-3/4P31266		T11-5/3-3/4R31188
60	K	10	T11-5/3-3/4W31816	T11-5/3-3/4P31812	T11-5/3-3/4W33379	T11-5/3-3/4R31189
80	K	10	T11-5/3-3/4W31261	T11-5/3-3/4P31267		



SURFACE GRINDING WHEELS

TYPE 12-- DISH

			GRIER PART #'S	
<u>Grit</u>	<u>Hardness</u>	<u>Pkg Qty</u>	<u>White-28A</u>	<u>Premium Ruby-36A</u>

6" Dia. X 1/2" W X 1-1/4" Hole				
46	J	10		T12-6R31535
60	H	10	T12-6W31366	
60	J	10	T12-6W31526	T12-6R31382
60	K	10	T12-6W31819	T12-6R31383
80	K	10	T12-6W31367	T12-6R31823

7" Dia. X 1/2" W X 1-1/4" Hole				
46	K	10	T12-7W31891	
60	I	10	T12-7W31893	
60	J	10	T12-7W31693	
60	K	10	T12-7W31892	
80	K	10	T12-7W31894	



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SEGMENTS

GRIER Abrasive offers one of the most extensive product lines of **SEGMENTS** with over one hundred standard shapes and numerous other “special” shapes. All of these shapes and sizes are available in a variety of grains, grits and special “combo” products. Whether you have a 6” or 60” diameter chuck, GRIER has the **SEGMENT** that will work for you.



Grain Types

	<u>Single Grains</u>	<u>“COMBO” Grains</u>
A/O	20A (Lavender)	68A (Ruby & White)
	23A (Tan)	78A (Brown & White)
	27A (Brown)	79A (Pink & Brown)
	28A (White)	83A (Tan & White)
	29A (Pink)	89A (Pink & White)
	36A (Ruby)	
S/C	C (Black)	CA (Brown & Black)
	GC (Green)	

Segments are used in surface grinding applications to grind flat stock or flat surfaces. Typically a group of segments are loaded into chuck that moves the abrasives over the work-piece, but some operations move the work-piece and keep the segments stationary.

*We also offer ceramic grains in any combination you need, ask for a custom quote.
Other grains and “combos” are available upon request.*

Segment Shape	Chuck Diameter	Width	Thickness	Height
AA 1	various	11-5/16"	2-1/8"	6"
AA 1 SPL	various	11"	2-5/8"	6-1/8"
AA 1 SPL 2	various	11"	2-1/8"	6"
AA 1 SPL 3	various	11"	2-1/4"	6"
AA 1 SPL 4	various	11"	2"	6"
AA 2	various	6-1/2"	1-7/8"	5-1/2"
BL 11	11"	6-1/4"	1-1/4"	5"
BL 18	18"	7-1/16"	1-3/4"	6"
BL 20	20"	5-11/16"	2"	6"
BL 27	27"	7-3/4"	2-1/2"	7"
BL 32	32"	9-9/16"	2-11/16"	7"
BL 36	36"	8-7/16"	3"	8"
BL 42	42"	10-1/8"	3"	8"
BL SPL 1		8-3/8"	3"	9"
BLA 32	32"	4-1/2"	3-1/2"	9"
BLA 36	36"	4-1/2"	3-1/2"	9"
BLA 42	42"	4-1/2"	3-1/2"	9"
CA 18A	18"	6"	2"	7"
CA 22A	22"	6"	2"	7"
CA 26	26"	6"	2"	7"
CA 27	27"	6"	2"	7"
CA 30	30"	6"	2"	7"
CD 6	6"	3-1/2"	7/8"	3-1/2"
CD 8	8"	4-3/4"	1-1/4"	4"
CD 10	10"	6-1/2"	1-1/4"	4"
CD 12	12"	7-1/2"	1-1/2"	5"
CD 14	14"	8-7/8"	1-3/4"	5"
CD 14L	14"	8-7/8"	1-3/4"	6"
CD 16	16"	10-1/8"	2"	5"
CD 18	18"	11-1/4"	2-1/4"	5"
CD 18L	18"	11-1/4"	2-1/4"	6"
CD 20	20"	8"	1-7/8"	6"
CD 20A	20"	10-1/8"	2"	6"
CD 20B	18"	11-1/4"	2-1/4"	6"
CD 22-6	18"	11-1/4"	2-1/4"	6"
CD 22-8	22"	11-1/4"	2-1/4"	8"
CD 22A-6	22"	11-1/4"	2-1/2"	6"
CD 22A-8	22"	11-1/4"	2-1/2"	8"
CD 22B-6	22"	11-1/4"	3"	6"
CD 22B-8	22"	11-1/4"	3"	8"
CD 24	24"	7-1/4"	1-7/8"	7"
CD 30	30"	7-1/4"	1-7/8"	7"
CD 32	20"	8"	1-7/8"	6"
CD 32A	22"	11-1/4"	2-1/4"	8"
CD 42	22"	11-1/4"	2-1/4"	8"
CD SPL 1		5-9/16"	2"	5"
CH (CHURCHILL)	various	4-1/16"	1-1/2"	6"
CP 14	14"	5-5/16"	1-1/2"	5"
CR 42	42"	10-3/4"	2-1/8"	6-1/4"



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Segment Shape	Chuck Diameter	Width	Thickness	Height
DIA 30	30"	6-1/2"	2"	7-1/4"
DIA 30A	30"	6"	3"	7-1/4"
DIA 36	36"	6-1/2"	2"	7-1/4"
DIA 36A	36"	6"	3"	7-1/4"
DIC 30	30"	7-3/8"	2"	7-1/4"
DIC 30A	30"	7-3/8"	3"	7-1/4"
DIC 36	36"	7-3/8"	2"	7-1/4"
DIC 36A	36"	7-3/8"	3"	7-1/4"
DIC SPL 1		7-1/4"	1-3/4"	7-5/16"
HA 16	16"	5-5/16"	1-1/4"	6"
HA 20	20"	5-5/16"	2"	7"
HA 24	24"	5-5/16"	2"	7"
HA 36	36"	7-7/8"	2"	7"
HA 44	44"	8"	3"	7"
HA SPL 1		6-7/8"	2"	7"
HA SPL 2		11-1/4"	2-5/8"	7"
HI 23	23"	7-1/8"	2"	7-1/4"
HI 26	26"	7-1/8"	2"	7-1/4"
HI 30	30"	7-1/8"	2"	7-1/4"
HI 32	32"	7-1/8"	2"	7-1/4"
HL 14	14"	4-29/32"	1-1/4"	5"
HL 16	16"	5-19/32"	1-1/4"	5"
HM 14	14"	5-1/8"	1-1/2"	6"
HM 16	16"	6-1/16"	2"	6"
HM 20	20"	5-15/16"	2"	6"
HM 22	22"	6-11/16"	2"	6"
HM 26	26"	6-1/2"	2"	6"
HM 32	32"	6-3/4"	2"	7"
NO 14	14"	5"	1-1/2"	6"
NO 18	18"	5"	1-1/2"	6"
NO 18A	18"	5-9/16"	2-1/4"	6"
NO 20	20"	5"	1-1/2"	6"
NO 20A	20"	5-9/16"	2-1/4"	6"
NO 22	22"	5"	1-1/2"	6"
NO 22A	22"	5-9/16"	2-1/4"	6"
NO 24	24"	5"	1-1/2"	6"
NO 26	26"	5"	1-1/2"	6"
NO 27	27"	5"	1-1/2"	6"
NO 32	32"	5"	1-1/2"	6"
NO 36	36"	5"	1-1/2"	6"
NO 42	42"	5"	1-1/2"	6"
PA 14	14"	6"	1-1/2"	6-1/2"
PA 14A	14"	6"	1-1/2"	6"
PA 14B	14"	6"	1-1/2"	5-1/2"
RA 1	10"-60"	4-3/16"	1"	4-1/2"
RA 1-1/2	10"-60"	4-3/16"	1-1/2"	5"
RA 2	10"-60"	4-3/16"	2"	5-1/2"
RA 2-1/2	10"-60"	4-3/16"	2-1/2"	6"
RO 12	12"	3-15/16"	1-1/4"	4"
RO 14	14"	4-1/8"	1-1/4"	4"
RO 16	16"	4-7/8"	1-1/4"	4"



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Segment Shape	Chuck Diameter	Width	Thickness	Height
SA 1	various	4-5/16"	1-5/8"	6-5/16"
SA 30A	30"	6-15/16"	2-7/16"	8"
SB 1 (GS-PBS)	various	2-1/2"	1"	3-15/16"
SB 2	various	3-1/2"	1-3/16"	5"
SB 3	various	4"	1-1/2"	8"
SB 4	various	4-5/8"	1-3/4"	7"
SC 1	various	4-19/32"	1-3/4"	6"
SC 2	various	5-1/2"	1-3/4"	5-7/8"
SC 3	various	6-1/4"	2-3/16"	9"
SC 4	various	6-3/16"	2-1/4"	10-1/2"
SC 5	various	6-1/4"	2-3/16"	12"
SD 1	various	3-11/16"	1"	4-3/4"
SD 2	various	5-19/32"	1"	5"
SD W/ NOTCH	various	5-9/16"	1"	5"
SE 1	various	3-1/8"	13/16"	3-1/8"
SE 2	various	3-1/8"	2-11/32"	3-1/8"
SE 3 (GS-RGS)	various	2"	5/8"	3-5/8"
SE 12	12"	4-11/32"	1-13/16"	3"
SG 1	various	4-1/4"	1-1/8"	6"
SO 1	various	2-19/32"	25/32"	4"
SO 2	various	2-3/8"	3/4"	4-3/4"
SO 3	various	2-3/8"	7/8"	4-3/8"
SO 4	various	2-3/4"	1"	6"
SO 5	various	2-3/4"	1"	6"
SO 6	various	2-3/4"	1"	6"
SO 7	various	4"	1-1/2"	7"
SO 8	various	4"	1-1/2"	9"
SO 8 SH	various	4"	1-13/32"	9"
SO 9	various	4-3/4"	1-1/2"	8"
SO 10	various	4-3/4"	1-5/8"	8"
STG 10	10"	4-15/16"	1"	4"
STG 12	12"	5-15/16"	1-1/4"	5"
STG 14	14"	5-5/16"	1-1/4"	4"
STG 14A	14"	5-5/16"	1-1/4"	5"
STG 16	16"	6"	1-1/4"	4"
STG 16A	16"	6"	1-1/4"	5"
STG 16B	16"	6"	1-1/4"	6"
STG 18	18"	6-13/16"	1-1/2"	5"
STG 18A	18"	6-13/16"	1-1/2"	6"
STG 18B	18"	6-13/16"	2"	5"
STG 18C	18"	6-13/16"	1-1/4"	5"
STG 20	20"	6-13/16"	1-1/2"	5"
GRIER-20	20"	6-13/16"	1-1/2"	5"
STG 20L	20"	6-13/16"	1-1/2"	6"
STG 20A	20"	6-13/16"	2"	5"
STG 20B	20"	6-13/16"	2"	6"
STG 22	22"	5-3/4"	1-1/2"	5"
STG 30	30"	8"	2"	6"
STG SPL 1		6-13/16"	2"	4"
STG SPL 2		8-1/4"	2"	7-1/2"
STG SPL 3		7"	2"	4"

With the acquisition of segment molds from various sources we have many old molds in stock that are not listed. Send us a sketch of the shape with dimensions and we may have the mold.



123 Taft Drive
South Holland, IL 60473



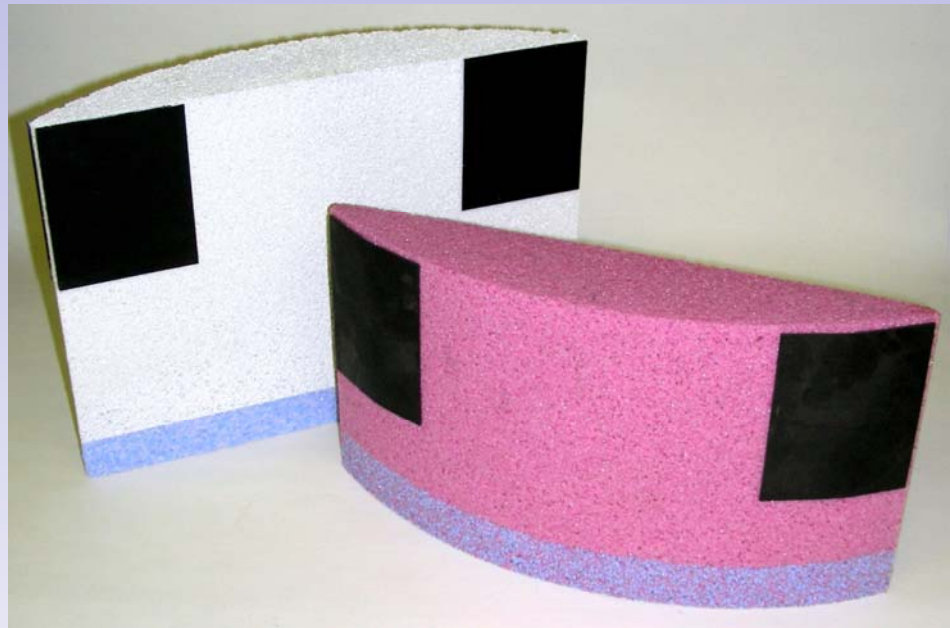
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SEGMENTS... GO BLUE!

*GRIER Abrasive offers one of the most extensive product lines of **SEGMENTS** with over one hundred standard shapes and numerous other “special” shapes. All of these shapes and sizes are available in a variety of grains and grits.*

The most valuable of the grain choices is Ceramic Grain. The unique properties of Ceramic Grain give **SEGMENTS** longer life, require less dressing and provide faster material removal than naturally occurring grains. Ceramic **SEGMENTS** will reduce the # of setups, reduce machine down-time and reduce freight costs. GRIER Abrasive is confident that Ceramic Grain will improve most applications. To prove it, GRIER Abrasive offers the **GO BLUE!** Program.



HOW **GO BLUE!** WORKS...

Along with your regular order of **SEGMENTS**, GRIER Abrasive will make one set of custom trials that have one inch (1”) of ceramic grain blend on the bottom of the segment. GRIER asks that you trial this one inch of ceramic and compare it to one inch of your regular order specification. GRIER has custom test reports that will help weigh the performance ratio versus the cost ratio to see if Ceramic Grain **SEGMENTS** are right for you.

**Ask your representative for the custom test report
and your trial order in **GO BLUE!****

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SEGMENTS: GRIER-20

The STG-20 segment shape is an industry standard used in Sterling chucks on Blanchard-type grinders. GRIER has made this shape for many years, but customers have asked for improvements. The STG-20 edges are prone to chipping or breaking, product density is not entirely uniform, and assembling the inter-locking segments is not quick and easy.



GRIER has designed a new and improved version of the STG-20 called the **GRIER-20** to address these issues. The edges of the **GRIER-20** are more robust, the design allows for uniform density, and the segments align very easily without the need for inter-locking.

*Most Importantly, **GRIER-20** is offered at a lower price!*

GRIER-20



STG-20



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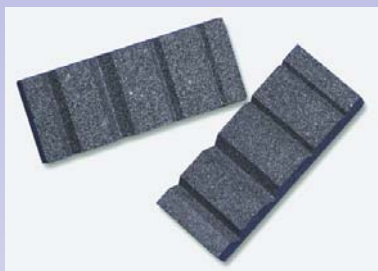


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STICKS & STONES

GRIER Sticks & Stones will help you dress your wheels, put a fast edge on any cutting surface, true up a wheel, shape a wheel or mounted point, hone a surface or debur the edge of your work-piece. GRIER offers a wide selection of dressing sticks, bench stones, slip stones, boat stones, axe stones, floor rubs and tool room files.



Dressing Stone for Mounted Points:

size is 9/16" x 1-3/8" x 3-1/2" with grooves to improve shaping capabilities. Grooves can be "V" shape or rounded to fit your need. Available in silicon carbide or aluminum oxide.

Boat Stones:

used primarily on large die seams and breaking down sharp edges on machine parts. These stones are made to be held easily and are available in aluminum oxide or either silicon carbide (black or green).



Floor Rub Combo:

grooved on the sides for easy use and hand protection. This stone is made in a combination of silicon carbide grits (medium and fine).

Dressing Sticks:

used for truing, shaping and dressing vitrified wheels and for general dressing of super-abrasives and diamond wheels. Dressing greatly improves the performance of all wheels and is an important part of getting the maximum life out of a wheel.



ALUMINUM OXIDE

Size (inches)	Grade	Part#
1/2 x 1/2 x 4	220I	ST-4-W-18439
1/2 x 1/2 x 6	100F	ST-6-W-18423
	150H	ST-6-W-17742
	220H	ST-6-W-10368
	320H	ST-6-W-13723
3/4 x 3/4 x 4	150H	ST-4-W-16010
	240H	ST-4-W-18424
3/4 x 3/4 x 8	220H	ST-8-W-18426
1 x 1 x 6	150H	ST-6-W-13856
	220H	ST-6-W-15866
	320H	ST-6-W-18422
1 x 1 x 8	150H	ST-8-W-13259
	220H	ST-8-W-18427
2 x 2 x 8	46H	ST-8-W-12828
	100H	ST-8-W-18429
	150H	ST-8-W-18425

SILICON CARBIDE

Size (inches)	Grade	Part#
1/2 x 1/2 x 6	80L	ST-6-C-18430
	150L	ST-6-C-18431
	220L	ST-6-C-15952
3/4 x 3/4 x 6	36R	ST-6-C-18433
	120L	ST-6-C-18434
1 x 1 x 6	24R	ST-6-C-18435
	80O	ST-6-C-18436
	150L	ST-6-C-18437
	320J	ST-6-C-21290
1 x 1 x 8	24S	ST-8-C-12569
1/2 x 6	24S	ST-6-C-12126
Round		

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Slip Stones: easy to handle and suitable for tools and knives with curved cutting edges, molder's knives and bead planers. They are also popular with wood carvers for gouge sharpening. Available in aluminum oxide and silicon carbide.

Standard sizes:

- 4-1/2x1-3/4x3/8-1/8
- 4-1/2x1-3/4x1/2-3/16
- 4-1/2x2-1/8x5/8-5/16



Bench Stones:

available in coarse, medium and fine grits in either aluminum oxide or silicon carbide. S/C will put a fast edge on the cutting surface while A/O will have a finer finish. GRIER also offers Orange Oil-Treated stones in aluminum oxide that hold shape very well.

ALUMINUM OXIDE

Size (inches)	Grade	Part#
1/4 x 1 x 4	Coarse	ST-4-GB-18446
	Medium	ST-4-GB-18447
	Fine	ST-4-GB-18148
1/2 x 1 x 4	Coarse	ST-4-GB-18448
	Medium	ST-4-GB-16523
	Fine	ST-4-GB-16524
1 x 2 x 6	Coarse	ST-6-GB-898
	Medium	ST-6-GB-7958
	Fine	ST-6-GB-762
1 x 2 x 8	Coarse	ST-8-GB-897
	Medium	ST-8-GB-658
	Fine	ST-8-GB-896

COMBINATION A/O

Size (inches)	Grade	Part#
1 x 2 x 6	Crs/Fine	ST-6-GB-898-899
1 x 2 x 8	Crs/Fine	ST-8-GB-896-897

SILICON CARBIDE

Size (inches)	Grade	Part#
1/4 x 1 x 4	Coarse	ST-4-C-18442
	Medium	ST-4-C-18443
	Fine	ST-4-C-8392
1/2 x 1 x 4	Coarse	ST-4-C-18444
	Medium	ST-4-C-13594
	Fine	ST-4-C-18445
1 x 2 x 6	Coarse	ST-6-C-1300
	Medium	ST-6-C-10100
	Fine	ST-6-C-1299
1 x 2 x 8	Coarse	ST-8-C-6009
	Medium	ST-8-C-8087
	Fine	ST-8-C-8990

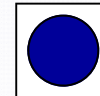
COMBINATION S/C

Size (inches)	Grade	Part#
1 x 2 x 6	Crs/Fine	ST-6-C-1299-1300
1 x 2 x 8	Crs/Fine	ST-8-C-6009-6010

Tool Room Files: squares and triangles are the most popular, and all shapes are available in coarse, medium and fine grits in either aluminum oxide or black silicon carbide. Choose your shape according to the area that needs honing, and the tightest fit should be selected. The rounds and half-rounds are best for contoured surfaces. GRIER supplies all the common sizes in each shape:



1/4"x4", 3/8"x4", 1/2"x4", 1/2"x6", 3/4"x6", 1"x6"



Axe Stone: combination stones with 2 different grits and can be easily held in the hand. Use these for sharpening cutting edges on various tools. Available in aluminum oxide or silicon carbide:
3" dia. x 5/8" thick

For more information, see our other handouts:

- General Abrasive Information
- Mounted Points
- Carbide Burs
- And a wide variety of other specialty item handouts

GRIER Abrasive Co., Inc.
123 Taft Drive
South Holland, IL 60473





General Abrasive Information

There are many factors involved in matching an abrasive to an application. The information contained herein relates to typical conditions, however, there are endless combinations of these factors. GRIER's experience will be an important ingredient to assist in matching abrasive to application. Listed below are some of the important ingredients to proper selection.

To make bonded abrasives, you need (1) abrasive grain and (2) bond. To get specific properties, GRIER selects the appropriate (3) grade, (4) structure and (5) treatment.

(1) ABRASIVE GRAIN

Aluminum Oxide consists of blunt shaped grains and is very tough in its lowest refined form. It is produced in a variety of refinements and by its versatility can be used from very hard to soft applications; making it the most commonly used abrasive.

Silicon Carbide is hard and sharp with exceptional strength, but due to its brittleness it breaks down faster than aluminum oxide under heavy loads.

Ceramic Grain abrasive is non-fused ceramic aluminum oxide that is extremely tough in all grades. It provides exceptional durability and cut rates. This grain is more costly, so its merits need to be evaluated against the other abrasives.



PROPERTIES

Friability – the degree to which a grain is easily fractured. A **friable abrasive** grain is easily fractured by impact, therefore, constantly exposing fresh cutting crystals to the work piece making it the fastest cutting abrasive. A **semi-friable abrasive** grain does not fracture as readily as friable grain, therefore, gives longer life but does not cut quite as freely.

Grain Size – abrasives are classified into grit sizes ranging from very-coarse to super-fine. Coarser grits are used for heavy stock removal while fine grits are used to improve a surface finish or meet dimensional tolerances.

Very-Coarse =	8 to 16 grit
Coarse =	20 to 46 grit
Medium =	54 to 120 grit
Fine =	150 to 220 grit
Very-Fine =	240 to 320 grit
Super-Fine =	400 to 600 grit



CATEGORIES

Aluminum Oxides

23A — Aluminum oxide is an off-white friable, very aggressive grain, used in larger mounted point and wheel applications where a tougher application is indicated.

27A — Aluminum oxide is semi-friable and of average hardness. It is the most widely used medium density, fused aluminum oxide. It has a complete range of grit sizes for use in general purpose vitrified applications.

28A — Premium aluminum oxide is friable white grain which has an aggressive, cool, fast cutting action while holding form well. It is used in grinding heat sensitive alloys, taking advantage of its friability and cool cutting. This grain is also widely used in grinding of heat treated tool steels, high speed steels, and internal wheels.

29A — Aluminum oxide is a pure fused abrasive, alloyed with chrome oxide making it pink in color. Although friable and cool cutting, it exhibits marked form-holding characteristics. Applications will be found in precision, broad surface and tool room grinding on hard alloy steels.

36A — Aluminum oxide is a high chromium ruby-colored fused abrasive, free of titania. It is made by fusing high purity calcined alumina and chromium oxide. It is a friable abrasive, somewhat tougher than white, with corner-holding characteristics, which is needed for precision grinding. It is a premium priced grain as compared to 28A-white and 29A-pink, so the merits as compared to these types should be weighed.

AMA — Aluminum oxide is a friable, very aggressive grain for a tough compositions.

Silicon Carbides

C — Silicon carbide is a black, semi-friable medium density abrasive. It is produced in both resin and vitrified points and wheels for grinding hard or brittle materials, such as cast iron, ceramics, and glass: as well as low tensile strength, ductile non-ferrous metals.

GC — Silicon carbide is a green in color, friable, highly pure, medium density abrasive used in vitrified bonded points and wheels. It is most commonly used for grinding hard, brittle materials, such as cemented carbides, where fast cool cutting is desirable.

Ceramic Grains

11A (CG) — Aluminum oxide is non-fused ceramic grain that is very tough, pure, and of uniform quality. Applications are in resin and vitrified points and wheels for high stock removal rates and long life. It performs especially well in precision grinding and fine finish applications, without excess heat generation. Since it is a premium priced grain, its merits need to be weighed in comparison to the more common specifications, and is most commonly used in combination with other grains for best results.

COMBINATIONS

Used in various proportions to obtain desired results:

17A = 11A + 27A aluminum oxide
18A = 11A + 28A aluminum oxide
19A = 11A + 29A aluminum oxide
68A = 36A + 28A aluminum oxide
69A = 36A + 29A aluminum oxide
73A = 27A + 23A aluminum oxide
78A = 27A + 28A aluminum oxide
79A = 27A + 29A aluminum oxide
7MA = 27A + AMA aluminum oxide
89A = 28A + 29A aluminum oxide
BG = C + GC silicon carbide
CA = C silicon carbide + 27A aluminum oxide (resin products only)



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(2) BOND

The Bond used in producing abrasive product is what holds the abrasive grains together and has no cutting capabilities of its own. GRIER manufactures product using vitrified, resin, and latex bonds.

Vitrified bond is a glass or ceramic bond which is very hard and comparatively brittle. There are various vitrified bonds that are used to obtain certain desired results or to meet required standards. GRIER manufactures vitrified product in 11, 13, 22, 31, 41, 51, and 55 bonds.

Resin bond is a strong, tough, resilient material. It absorbs shock better than vitrified. It is used for fast stock removal and is popular with foundries with off-hand operations. It works well on stainless steel, brass, bronze, and aluminum.

Latex bond is the bond utilized by GRIER in its soft Griertex product.

(3) GRADE

Hardness Ranges:

F to I	Soft
P to R	Medium
T to V	Hard

The grade or hardness designation of an abrasive is controlled by the type of bond used and the ratio of bond to grain mix.

Soft grades are generally used on very hard materials, large areas of contact or rapid stock removal.

Hard grades are generally used for soft materials, small areas and longer wheel life.

(4) STRUCTURE

The concentration of abrasive grains for a specific area determines the structure of the product. Induced porosity is obtained by adding a material that will burn off in the firing process to produce a very open structure.

Density Ranges:

1 to 3	Closed
4 to 5	Normal-Points
6 to 9	Normal-Wheels
10 to 12	Open

(5) TREATMENT

When a bonded abrasive is treated, its pores are generally filled with a substance that will assist in its working capabilities. Treatments reduce loading, aid in cutting, improve wheel life, and lubricate cutting action. Resin and wax are the primary treatments used.

Resin treating hardens the abrasive product and adds lubrication to assist in cutting.

Wax treating is popular when grinding brass or aluminum, for it greatly reduces loading and it lubricates the cutting action.



CONSIDERATIONS FOR GOOD WHEEL OPERATION

Wheel speed is very important to obtain the desired finish. An operator should not exceed the speed standards given by the American National Standards Institute's current safety requirement of maximum speeds. However, it is important to match the abrasive formula to your operational speeds. Specifications will perform differently at different speeds. You should occasionally speed test and torque test your grinder to ensure it is operating at desired levels. There are many factors that can adversely affect your grinder's capabilities.

Run out of the grinder is a problem that must be constantly monitored. Worn chucks and lack of properly maintained grinders can result in spindle failure, wheel breakage and unsafe conditions for operators.

Dressing your wheel or point is important to maintain the integrity of your wheel shape, cutting quality, and to minimize loading problems.

<u>TROUBLESHOOTING</u>		
<u>Problem</u>	<u>Possible Cause</u>	<u>Correction</u>
Wheel Loading or Glazing	Wheel too hard Wheel too fine Insufficient Pressure Excessive RPM	Downgrade one level softer Use coarser grit Increase pressure up to max safe level Reduce RPM
Burning Work-piece	Wheel too hard Wrong wheel selected Low coolant flow Work-piece speed too slow Stock removal too fast	Downgrade one level softer Choose heat-sensitive abrasive & bond Increase coolant flow Increase Work-piece speed Decrease stock removal per pass
Chatter	Wheel too hard Wheel out of balance Machine or grinder vibration	Downgrade one level softer Balance wheel or dress mounted point Check machine bearings or grinder collet
Scratching Work-piece	Wheel too hard Wheel too coarse	Downgrade one level softer Use finer grit
Improper Stock Removal	Too little, wheel too soft Too much, wheel too hard Short wheel life Grinder out of balance	Upgrade one level harder Downgrade one level softer Choose less friable grain Repair Grinder or replace collet

For more information, see our other handouts:

- Mounted Points
- Grinding Wheels
- Segments
- And a wide variety of other specialty item handouts



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CARBIDE BURS



CARBIDE BURS are the newest product line addition to the GRIER family and come in a wide variety of shapes, sizes, lengths and flute types. They are used for rapid stock removal on medium and hardened steels, stainless steel, titanium, inconel and many other ferrous and non-ferrous metals.

FEATURES

CNC Machine Ground

- Consistent tolerances.
- Runs smoother.
- Lasts longer.
- Reduces fatigue on the operator.

Double-Ended Burs

These burs have cutting flutes on both ends of the mandrel to provide an economical solution while also reducing inventory. Ask your representative if your size and shape qualify.

Re-Sharpening Program

Some burs can be re-sharpened to like-new condition. Ask your representative if your size and shape qualify.

Re-Conditioning Program

When a bur cannot be re-sharpened, the bur head can be removed and a new one fitted to the mandrel for less cost than buying a whole new bur.

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TYPES OF CUTS

Standard Cut

General purpose fluting is for medium stock removal and finish. Good for steel, cast iron and ferrous metals. This cut will be supplied unless otherwise noted.

Double Cut

Cross-fluted pattern is the most versatile cut that removes metal faster in harder materials, reduces pulling action of bur, gives operator greater control and reduces loading by having smaller chips and slivers. It can also be run at slower speeds than normal.

Chip Cut

Fluting design is in-between standard and double cut designs and is available upon request.

Aluminum Cut (NF)

Extra deep fluting is designed to eliminate loading on Non-Ferrous materials.

Fine or Coarse

When a medium cut does not suit your needs, please specify a fine cut for a finer finish, or a coarse cut for rapid stock removal. Available for single, double and chip cuts.

SA CYLINDRICAL		SA-1 SA-1L SA-2 SA-2A SA-3	SA-3A SA-3B SA-4 SA-5 SA-6	SA-7 SA-8 SA-9 SA-11 SA-12	SA-13 SA-14 SA-15 SA-16 SA-41	SA-42 SA-43 SA-51 SA-52 SA-53	SA-61 SA-63 SA-81
SB CYLINDRICAL—END CUT		SB-1 SB-1A SB-2 SB-2A SB-3	SB-3A SB-3B SB-4 SB-5 SB-6	SB-7 SB-8 SB-9 SB-11 SB-12	SB-13 SB-14 SB-15 SB-16 SB-43	SB-ECO SB-51	
SC CYLINDRICAL— RADIUS END		SC-1 SC-1A SC-2 SC-2A SC-3	SC-3A SC-3B SC-4 SC-5 SC-6	SC-7 SC-9 SC-11 SC-12 SC-13	SC-14 SC-15 SC-16 SC-41 SC-42	SC-51 SC-52 SC-53 SC-61 SC-81	
SD BALL SHAPE		SD-1 SD-2 SD-3 SD-4 SD-5	SD-6 SD-7 SD-9 SD-11 SD-12	SD-14 SD-41 SD-42 SD-51 SD-53	SD-61 SD-81		
SE OVAL SHAPE		SE-1 SE-3 SE-5 SE-6 SE-7	SE-11 SE-41 SE-51 SE-53 SE-61	SE-81			
SF TREE—RADIUS END		SF-1 SF-3 SF-4 SF-5 SF-6	SF-7 SF-11 SF-13 SF-14 SF-15	SF-41 SF-42 SF-51 SF-53 SF-61	SF-81		
SG TREE—POINTED END		SG-1 SG-2 SG-3 SG-5 SG-6	SG-7 SG-13 SG-15 SG-41 SG-42	SG-43 SG-44 SG-51 SG-52 SG-53	SG-61 SG-81		
SH FLAME		SH-1 SH-2 SH-5 SH-6 SH-7	SH-41 SH-53				
SJ TAPER—60° INCLUDED ANGLE		SJ-1 SJ-2 SJ-3 SJ-5 SJ-6	SJ-7 SJ-9 SJ-42 SJ-81				
SK TAPER—90° INCLUDED ANGLE		SK-1 SK-2 SK-3 SK-5 SK-6	SK-7 SK-8 SK-9 SK-42 SK-81				
SL CONE—RADIUS END 90° INCLUDED ANGLE		SL-1 SL-2 SL-3 SL-4 SL-5	SL-6 SL-7 SL-41 SL-42 SL-53	SL-81			
SM CONE—POINTED END		SM-1 SM-2 SM-3 SM-3A SM-4	SM-5 SM-6 SM-41 SM-42 SM-53	SM-51 SM-53 SM-61			
SN TAPER—INVERTED		SN-1 SN-1E SN-2 SN-2E SN-3	SN-3E SN-6 SN-6E SN-7 SN-7E	SN-41 SN-42 SN-51 SN-53 SN-61	SN-81		

All parts above are standard products. When ordering, please specify the type of cut desired.



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CARBIDE BUR SIZE CHART



SA	Shank	Cutting Dia.	Cutting Length
SA-1	1/4	1/4	5/8
SA-1L	1/4	1/4	1
SA-2	1/4	5/16	3/4
SA-2A	1/4	5/16	1
SA-3	1/4	3/8	3/4
SA-3A	1/4	3/8	1
SA-3B	1/4	3/8	1 1/2
SA-4	1/4	7/16	1
SA-5	1/4	1/2	1
SA-6	1/4	5/8	1
SA-7	1/4	3/4	1
SA-8	1/4	7/8	1
SA-9	1/4	1	1
SA-11	1/4	1/8	1/2
SA-12	1/4	1/8	5/8
SA-13	1/4	5/32	5/8
SA-14	1/4	3/16	5/8
SA-15	1/4	3/4	1/2
SA-16	1/4	3/4	3/4
SA-41	1/8	1/16	1/4
SA-42	1/8	3/32	7/16
SA-43	1/8	1/8	9/16
SA-51	1/8	1/4	1/2
SA-52	1/8	5/32	1/2
SA-53	1/8	3/16	1/2
SA-61	3/32	1/16	1/4
SA-63	3/32	3/32	3/8
SA-81	3/16	3/16	1/2



SB	Shank	Cutting Dia.	Cutting Length
SB-1	1/4	1/4	5/8
SB-1L	1/4	1/4	1
SB-2	1/4	5/16	3/4
SB-2A	1/4	5/16	1
SB-3	1/4	3/8	3/4
SB-3A	1/4	3/8	1
SB-3B	1/4	3/8	1 1/2
SB-4	1/4	7/16	1
SB-5	1/4	1/2	1
SB-6	1/4	5/8	1
SB-7	1/4	3/4	1
SB-8	1/4	7/8	1
SB-9	1/4	1	1
SB-11	1/4	1/8	1/2
SB-12	1/4	1/8	5/8
SB-13	1/4	5/32	5/8
SB-14	1/4	3/16	5/8
SB-15	1/4	3/4	1/2
SB-16	1/4	3/4	3/4
SB-43	1/8	1/8	9/16
SB-ECO	1/8	1/8	Endcut only
SB-51	1/8	1/4	3/16



SC	Shank	Cutting Dia.	Cutting Length
SC-1	1/4	1/4	5/8
SC-1A	1/4	1/4	1
SC-2	1/4	5/16	3/4
SC-2A	1/4	5/16	1
SC-3	1/4	3/8	3/4
SC-3A	1/4	3/8	1
SC-3B	1/4	3/8	1 1/2
SC-4	1/4	7/16	1
SC-5	1/4	1/2	1
SC-6	1/4	5/8	1
SC-7	1/4	3/4	1
SC-9	1/4	1	1
SC-11	1/4	1/8	1/2
SC-12	1/4	1/8	5/8
SC-13	1/4	5/32	5/8
SC-14	1/4	3/16	5/8
SC-15	1/4	3/4	1/2
SC-16	1/4	3/4	3/4
SC-41	1/8	3/32	7/16
SC-42	1/8	1/8	9/16
SC-51	1/8	1/4	1/2
SC-52	1/8	5/32	1/2
SC-53	1/8	3/16	1/2
SC-61	3/32	3/32	3/8
SC-81	3/16	3/16	1/2

*All dimensions
in inches*



SD	Shank	Cutting Dia.	Cutting Length
SD-1	1/4	1/4	1/4
SD-2	1/4	5/16	5/16
SD-3	1/4	3/8	3/8
SD-4	1/4	7/16	7/16
SD-5	1/4	1/2	1/2
SD-6	1/4	5/8	5/8
SD-7	1/4	3/4	3/4
SD-9	1/4	1	1
SD-11	1/4	1/8	1/8
SD-12	1/4	1/8	3/32
SD-14	1/4	3/16	3/16
SD-41	1/8	3/32	3/32
SD-42	1/8	1/8	1/8
SD-51	1/8	1/4	1/4
SD-53	1/8	3/16	3/16
SD-61	3/32	3/32	3/32
SD-81	3/16	3/16	3/16



SE	Shank	Cutting Dia.	Cutting Length
SE-1	1/4	1/4	3/8
SE-3	1/4	3/8	5/8
SE-5	1/4	1/2	7/8
SE-6	1/4	5/8	1
SE-7	1/4	3/4	1
SE-11	1/4	3/16	5/16
SE-41	1/8	1/8	7/32
SE-51	1/8	1/4	3/8
SE-53	1/8	3/16	9/32
SE-61	3/32	3/32	1/8
SE-81	3/16	3/16	9/32



SF	Shank	Cutting Dia.	Cutting Length
SF-1	1/4	1/4	5/8
SF-3	1/4	3/8	3/4
SF-4	1/4	7/16	1
SF-5	1/4	1/2	1
SF-6	1/4	5/8	1
SF-7	1/4	3/4	1
SF-11	1/4	1/8	1/2
SF-13	1/4	1/2	3/4
SF-14	1/4	3/4	1 1/4
SF-15	1/4	3/4	1 1/2
SF-41	1/8	1/8	1/4
SF-42	1/8	1/8	1/2
SF-51	1/8	1/4	1/2
SF-53	1/8	3/16	1/2
SF-61	3/32	3/32	1/4
SF-81	3/16	3/16	1/2



SG	Shank	Cutting Dia.	Cutting Length
SG-1	1/4	1/4	5/8
SG-2	1/4	5/16	3/4
SG-3	1/4	3/8	3/4
SG-5	1/4	1/2	1
SG-6	1/4	5/8	1
SG-7	1/4	3/4	1
SG-13	1/4	1/2	3/4
SG-15	1/4	3/4	1 1/2
SG-41	1/8	1/8	1/4
SG-42	1/8	1/8	5/16
SG-43	1/8	1/8	3/8
SG-44	1/8	1/8	1/2
SG-51	1/8	1/4	1/2
SG-53	1/8	3/16	1/2
SG-61	3/32	3/32	1/4
SG-81	3/16	3/16	1/2



SH	Shank	Cutting Dia.	Cutting Length
SH-1	1/4	1/4	5/8
SH-2	1/4	5/16	3/4
SH-5	1/4	1/2	1 1/4
SH-6	1/4	5/8	1 7/16
SH-7	1/4	3/4	1 5/8
SH-41	1/8	1/8	1/4
SH-53	1/8	3/16	3/8



SJ	Shank	Cutting Dia.	Cutting Length
SJ-1	1/4	1/4	3/16
SJ-2	1/4	5/16	5/16
SJ-3	1/4	3/8	5/16
SJ-5	1/4	1/2	7/16
SJ-6	1/4	5/8	9/16
SJ-7	1/4	3/4	11/16
SJ-9	1/4	1	15/16
SJ-42	1/8	1/8	3/32
SJ-81	3/16	3/16	3/16

**All dimensions
in inches**



SK	Shank	Cutting Dia.	Cutting Length
SK-1	1/4	1/4	1/8
SK-2	1/4	5/16	3/16
SK-3	1/4	3/8	3/16
SK-5	1/4	1/2	1/4
SK-6	1/4	5/8	5/16
SK-7	1/4	3/4	3/8
SK-8	1/4	7/8	7/16
SK-9	1/4	1	1/2
SK-42	1/8	1/8	1/16
SK-81	3/16	3/16	1/8



SL	Shank	Cutting Dia.	Cutting Length
SL-1	1/4	1/4	5/8
SL-2	1/4	5/16	7/8
SL-3	1/4	3/8	1 1/16
SL-4	1/4	1/2	1 1/8
SL-5	1/4	5/8	1 3/16
SL-6	1/4	5/8	1 5/16
SL-7	1/4	3/4	1 1/2
SL-41	1/8	1/8	3/8
SL-42	1/8	1/8	1/2
SL-53	1/8	3/16	1/2
SL-81	3/16	3/16	7/16



SM	Shank	Cutting Dia.	Cutting Length
SM-1	1/4	1/4	1/2
SM-2	1/4	1/4	3/4
SM-3	1/4	1/4	1
SM-3A	1/4	1/4	1 1/4
SM-4	1/4	3/8	5/8
SM-5	1/4	1/2	7/8
SM-6	1/4	5/8	1
SM-41	1/8	1/8	11/32
SM-42	1/8	1/8	7/16
SM-43	1/8	1/8	5/8
SM-51	1/8	1/4	1/2
SM-53	1/8	3/16	1/2
SM-61	3/32	3/32	1/4



SN	Shank	Cutting Dia.	Cutting Length
SN-1	1/4	1/4	5/16
SN-1E	1/4	1/4	5/16
SN-2	1/4	3/8	3/8
SN-2E	1/4	3/8	3/8
SN-3	1/4	1/2	1/2
SN-3E	1/4	1/2	1/2
SN-6	1/4	5/8	3/4
SN-6E	1/4	5/8	3/4
SN-7	1/4	3/4	5/8
SN-7E	1/4	3/4	5/8
SN-41	1/8	3/32	1/8
SN-42	1/8	1/8	3/16
SN-51	1/8	1/4	1/4
SN-53	1/8	3/16	1/4
SN-61	3/32	3/32	1/8
SN-81	3/16	3/16	1/4

TYPES OF CUTS

Standard Cut

Double Cut

Chip Cut

Aluminum Cut (NF)

Above Cuts come standard in medium grade, but fine and coarse grades are available. Ask your representative.

Grier
Abrasive Co., Inc.

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 Email: griersales@grierabrasive.com



Made in the USA

Three Piece Collet Chuck Assembly	GRIER Part #	Description	Interchangeable with the Following:
	CN2-01	200 Series Collet Chuck Nut	ARO: 44129 ATS: C-1023N & 1035N CP: C-119255 Cleco: 847803-4 Dotco: 2058 IR: DG120-699A
		200 Series Collet	Refer to the collet part list and cross reference chart below
	CB2-01	200 Series Collet Chuck Body	ARO: 33218 ATS: C-1023B & C-1035B CP: C-119256 Cleco: 86338-4 Dotco: 2054 IR: G140-4

200 Series Collet Parts list & Cross Reference Chart

GRIER Part #	Hole Size	Aro	ATS	Cleco	Dotco	Erickson/ Kennametal	Ingersoll Rand	Lyndex	Sioux
COL2DA18	1/8	32968-1	C-1028-1/8	32968-1	204	200DA0125	G140 700 2	020 008	*****
COL2DA316	3/16	32968-3	*****	32968-3	206	200DA0188	*****	020 012	*****
COL2DA14	1/4	32968-5	C-1028-1/4	32968-5	208	200DA0250	G160HD 700 1/4	020 016	21110
COL2DA38	3/8	32968-9	C-1028-3/8	32968-9	212	200DA0.375	DG120 700 G6	020 024	*****
COL2DA6m	6mm	*****	*****	*****	213	*****	*****	*****	*****
COL2DA8m	8mm	*****	*****	*****	216	*****	*****	020 011	

• Other sizes available upon request

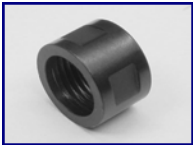
G R I E R A B R A S I V E



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Made in the USA

Four Piece Collet Chuck Assembly	GRIER Part #	Description	Interchangeable with the following:
	CN3-01	300 Series Collet Chuck Nut	ARO: 31810 ATS: C-1021N Cleco: 847510-5 Dotco: 1058 IR: AG210-698 & G120-699 Sioux: 21104
	CNP3-01	300 Series Collet Chuck Nose Piece	ARO: 31811 ATS: C-1022 Cleco: 847509-7 Dotco: 1053 IR: G120-291 Sioux: 21105
		300 Series Collet	Refer to the collet part list and cross reference chart below
	CB3-01	300 Series Collet Chuck Body	ATS: C-1021B & C-1034B Cleco: 847508 Dotco: 1054 IR: G120-4 Sioux: 21103

300 Series Collet Parts list & Cross Reference Chart

GRIER Part #	Hole Size	Aro	ATS	Cleco	Dotco	Erickson/ Kennametal	Ingersoll Rand	Lyndex	Sioux
COL3DA332	3/32	31812 3	*****	*****	303	300DA0094	*****	030 006	*****
COL3DA18	1/8	31812 4	C-1027-1/8	847534 5	304	300DA0125	DG110700G2	030 008	21102
COL3DA316	3/16	31812 6	C-1027-3/16	847535 2	306	300DA0188	DG110700G3	030 012	21101
COL3DA14	1/4	31812-8	C-1027-1/4	864182 1	308	300DA0250	DG110700G4	030 016	21100
COL3DA3M	3mm	*****	*****	*****	311	*****	*****	*****	*****
COL3DA6M	6mm	*****	*****	*****	310	*****	*****	030 015	*****

• Other sizes available upon request

G R I E R A B R A S I V E

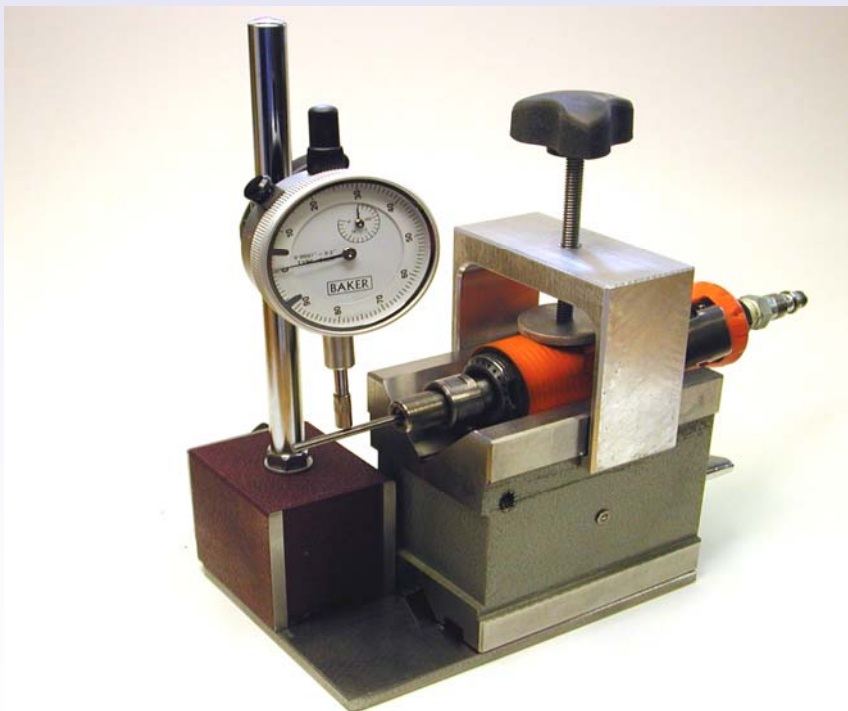


RUNOUT TESTER

Now available for the first time industry wide, **GRIER** has introduced an assembled kit capable of testing your grinder's "Total-Indicated-Runout" (T.I.R.) right on the finishing line. This testing assembly will aid you in solving the old question of **"tool or attachment"**. Only if your grinder is operating within its designed parameters can you address the needs of:

- **Minimizing Finishing Time**
- **Improving Quality of Finish**
- **Reducing Rework Due to Poor Finish or Gouging**
- **Increasing Life of Mounted Points, Carbide Burs and Coated Abrasives.**
- **Improving Safety**
- **Establishing a Maintenance Program Tailored to Your Tool Use.**

In the years of responding to customer inquiries, GRIER has found that the prime culprit of a problem in the field is grinder runout. Many plants are unaware of the allowable runout tolerances. The major grinder manufacturers maintain internal spindle runout of 0.0005" (0.013mm), not to be confused with 0.0050" (0.130mm) as checked with a gage pin one inch out of the collet. ANSI has published standards that the runout on a precision dowel test pin mounted in the collet shall not exceed the following T.I.R. readings, when measured at a distance of 1" (25mm) from the front end of the collet, or at a distance equal to the depth of the collet, whichever is shorter.



<u>Tool</u>	<u>GRIER Suggested Max. T.I.R. Allowable</u> 2, 2-1/2 & 3" Mandrels	<u>ANSI Max. T.I.R. Allowable</u> 1-1/2" Mandrel
Grinders below 25,000 RPM	0.005 in. (0.127mm)	0.007 in. (0.178mm)
Grinders 25,000 to 40,000 RPM	0.003 in. (0.076mm)	0.005 in. (0.127mm)
Grinders over 40,000 RPM	0.001 in. (0.025mm)	0.003 in. (0.076mm)

GRIER RUNOUT TESTING

TROUBLE-SHOOTING GUIDE

If you answer yes to any of the following, runout could be your problem:

1. Are only one or two operators having problems while others are not?
2. Are you having problems with both carbide burs and points?
3. Do your shanks/mandrels show a scoring on the metal from the collet?

Possible causes of runout:

- Dirt and grime in the collet
- Worn collet
- Excessive tightening of the collet
- Hitting the collet wrenches to remove the carbide bur or mounted point
- Internal wear of the grinder

To minimize runout problems:

- Set up a maintenance program for the cleaning and replacement of the collets. Daily cleaning is recommended.
- Only hand tighten collets with the appropriate wrenches (very little force is necessary, collet assemblies are precision made).
- Avoid striking the collet or wrenches.

If runout is found, try the following before repairing the grinder:

- Use compressed air to blow out the nosepiece, chuck body and collet.
- Clean or replace the collet.

If runout type problems still persist:

- Test the grinder for runout to evaluate if it needs to be rebuilt.
- No sense wasting time and money repairing something that isn't broken.

KIT INCLUDES:

- | | | |
|---------------------------|-----------------------------|-------------------------|
| ● Metal Base | ● Precision Gauge (0.0001") | ● 1/4" Collet |
| ● Magnetic Gauge Post | ● 1/4" dia. Carbide Pin | ● 1/8" Collet |
| ● Magnetic Tool Holder | ● 1/8" dia. Carbide Pin | ● Carrying Case |
| ● Adjustable Support Pins | ● Tool Protection Disc | ● Assembly Instructions |
| ● Holding Clamp | ● Wrench | |

CONTACT YOUR LOCAL GRIER DISTRIBUTOR
TO ORDER YOUR RUNOUT TEST KIT TODAY.



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GRIER-FLEX-SYSTEM (GFS)

**Patent
Pending!**

*When you need to go inside a work-piece
or work around corners,
GRIER helps you do that with the **GFS**.
No more hard-to-reach places!*



GFS: STANDARD

- Smaller Mounted Points
- Smaller Carbide Burs (3/16" dia.)
- Smaller head size for smaller areas
- Use for general applications



GFS: HEAVY DUTY

- BIGGER Mounted Points
- BIGGER Carbide Burs (3/8" dia.)
- BIGGER internal components
- Use for more robust finishing and bigger defects

The GRIER-FLEX-SYSTEM (GFS) attaches to a variety of different grinders thanks to its patent pending design. This one-handed solution to many difficult situations allows you to finish the impossible casting or work-piece and reduce scrap. You just bend the outer sheath with a tubing bender to match your contour and choose your mounted point or carbide bur. The BENEFITS are:

- Ease of changing mounted points (simple threaded design)
- Protective sheath remains cool via use of bearings and tubing liner
- Protective sheath is thick walled and rugged for industrial use
- The inner flexible shaft has a high torque capacity

CAUTION: This solution requires work in a guarded, enclosed space. Use conventional mounted points wherever possible as your first choice.

For more information, see our other handouts:

- General Abrasive Information
- Mounted Points
- Carbide Burs
- And a wide variety of other specialty item handouts

GRIER Abrasive Co., Inc.
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REACH-IN

... and get the job DONE!

When you need to go DEEP inside a work-piece, GRIER helps you do that with different solutions.

No more hard-to-reach-places!



The #500 Reach-In Mandrel

A 1/4 x 6" tapered spindle tapped and threaded to receive a mounted point with a threaded mandrel. This mandrel allows you to reach into a confined space where a conventional mandrel cannot reach.

High-Strength Mandrels

Available in 2-3/4" to 5-3/4" lengths, these mandrels have been specially designed to solve those reach-in problem situations. Made of high tensile strength steel with just the right amount of flexibility, these let you run at a higher RPM.



CAUTION: All solutions require work in a guarded, enclosed space. Use conventional mounted points wherever possible as your first choice.

For more information, see our other handouts:

- General Abrasive Information
- Grinding Wheels
- Segments
- And a wide variety of other specialty item handouts

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