



信发磨具
XINFA ABRASIVES

Quality Grinding wheels manufacture
Since 1989



山东信发磨料磨具有限公司
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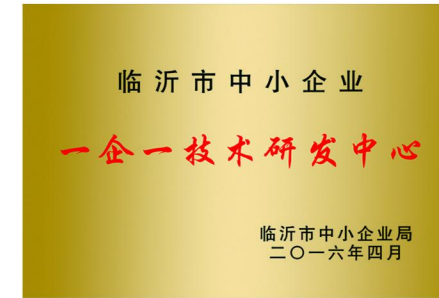


About Us 企业简介

山东信发磨料磨具有限公司始建于1989年。地处全国物流之都临沂市。距青岛港180公里，距日照港60公里，公司专注于陶瓷固结磨具的研发与生产。

公司是中国磨料磨具协会会员，获得质量管理体系ISO9001:2008认证。目前公司拥有100多台套国内先进的生产、检验设备。拥有年产陶瓷固结磨具10000吨的产能，连续多年获得市级重合同守信用企业称号。公司技术研发于2015年10月挂牌“市级企业技术中心”。中国制造，世界品质。产品出口至东南亚、中东、印度、韩国、日本、欧洲、美国、巴西等20多个国家和地区。

公司致力于成为世界磨削行业一流品牌，推崇诚信、正直、感恩、共赢、品质、专业。创新、发展的企业价值观，旨在为客户提供科学、高效、合理、稳定的磨削产品。

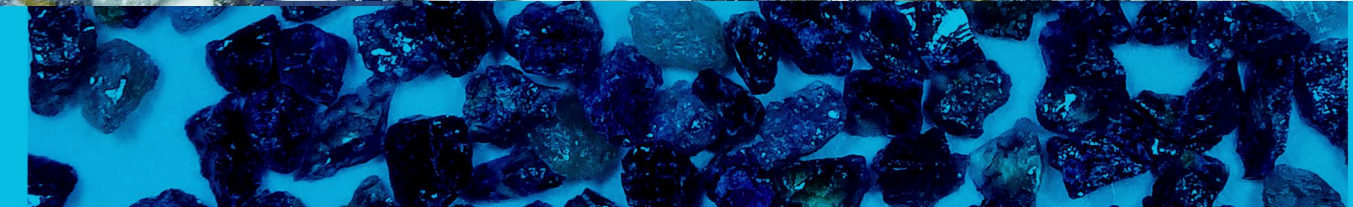


Established in 1989, Shandong Xinfa Abrasive and Grinding Tools Co.,Ltd has been specialized in research-development and manufacture of vitrified bond grindingwheels. Located in the National Logistics Center of Linyi City, there is only 180km away with Qingdao Port and 60 km with Rizhao Port. The geographical advantages bring us Xinfa favorable conditions for export business.

The enterprise is the member of China Abrasives Association and its quality has passed the authentication of quality management system ISO9001:2008. Now our factory own more than 100sets of advanced production and testing equipments.capacity of production over 10000tons per year.

Shandong Xinfa Abrasive and Grinding Tools Co.,Ltd is successively awarded the municipal Honoring Unit title for good credit in honoring contract .The company's technology research and development center is listed as city level enterprise technology R & D center in 2015.Made in China, the world's quality, our Xinfa products are exported to Southeast Asia, the Middle East, India, South Korea, Japan, Europe, the United States, Brazil, more than 20 countries and regions.

The company is committed to become the world leading manufacturer of abrasives.We respect the corporate value of honesty,integrity, gratitude, win-win, quality,professionalism, innovation and development, aimed to provide clients the scientific,efficient,reasonable and stable grinding products.





- ★专注陶瓷结合剂砂轮的研发与生产
- ★累计出口20多个国家，中国制造，世界品质
- ★2001年即获得ISO质量管理体系认证
- ★连续5年获得市级“重合同守信用”企业称号

- ★Focus on vitrified wheel R & D production since 1989
- ★Goods been exported to more than 30 countries, Made in China, World level quality
- ★Annual output ranked top 3 for 5 consecutive years in whole China
- ★Acquired ISO quality management system certification in year 2001
- ★Obtain municipal "observe contracts and keep promise" Enterprise for 5 consecutive years



Enterprise Culture 企业文化

企业愿景：成为世界磨削行业一流品牌

企业价值观：诚信 正直 感恩 共赢 品质 专业 创新发展

企业使命：致力于为客户提供科学，高效，合理，稳定的磨削产品

公司理念

用人理念：人才是第一生产力

成长理念：态度端正，努力奋斗

品质理念：产品质量高于一切

管理理念：团队协作，控制过程

经营理念：客户至上，互利共赢

领导理念：信仰坚定，以身作则

创新理念：改变观念，突破思维

发展理念：务实高效，健康理性

Corporate Vision: To become the world leading manufacturer of abrasives.

Corporate Values: honesty, integrity, gratitude, win-win, quality, professionalism, innovation and development,

Enterprise Mission: Committed to providing customers with scientific, efficient, reasonable and stable grinding products.

DEVELOPMENT HISTORY

发展历程



1989年 成立莒南县磨具厂

1999年 扩建更名为山东信发磨料磨具有限公司

2001年 获得ISO9001-2000质量管理体系认证

2008年 投资兴建国内最先进的电脑自动控温燃气隧道窑

2010年 获得市级“重合同，守信用”企业称号

2014年 获得ISO9001:2008质量管理体系认证

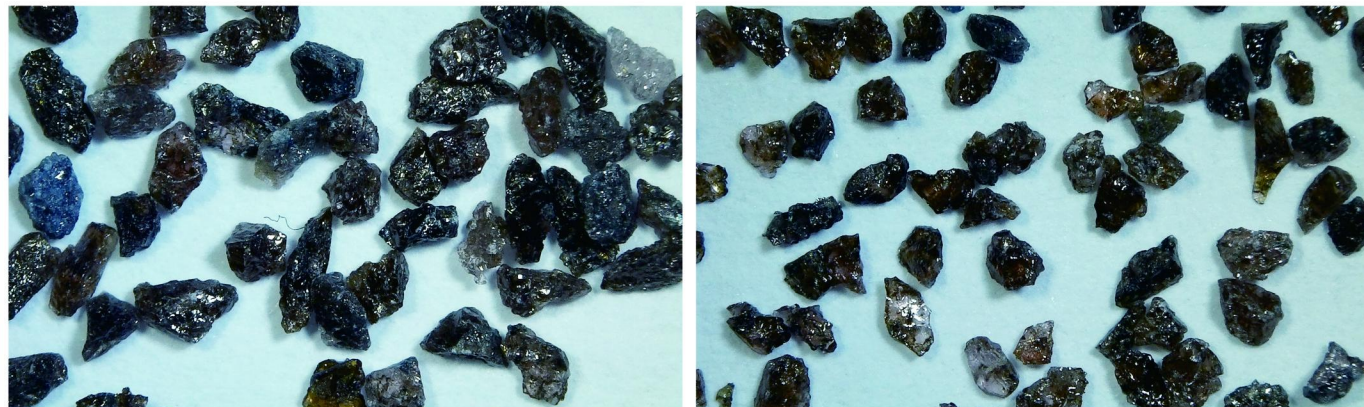
2015年 获得两项国家实用新型专利证书
2015年10月被临沂市经济及信息化委员会认定为“市级企业技术中心”

2017年 年产8000吨巴马克棕刚玉磨料生产线投产

2018年 通过国家高新技术企业认定



棕刚玉巴马克磨料 Brown Fused Alumina for Bonded Abrasives



我公司生产的棕刚玉磨料是使用精选的棕刚玉冶炼块，通过巴马克生产线加工处理，具有颗粒形状好、堆积密度高、清洁度高、磁性物含量低、自锐性好、磨削力强的特点，特别适用于制造陶瓷、树脂高端固结磨具及其他研磨、抛光等用途。

The grains produced by our company uses selected brown fused alumina smelting blocks and is processed by Barmac production line. It has the characteristics of good particle shape, high bulk density, high cleanliness, low magnetic content, good self sharpening and strong grinding force. It is especially suitable for manufacturing top grade abrasives of bond vtrfied and resin and other grinding and polishing purposes.

项目Item	指标Specification
颜色Colour	深棕Dark Brown
晶形Crystal System	三方晶系Alpha-alumina trigonal system
硬度 (莫氏)Mohs Hadness	≥9.0
熔点Melting (°C) Temperature (°C)	2050
最高使用温度 (°C) Refractory Temperature (°C)	1800
真密度 (g/cm ³) True Density	≥3.90
磁性物Magnetic Materia	0.01%

型号Grit No.	F12	F14	F16	F20	F22	F24	F30	F36
堆积密度 Bulk Density	2.02-2.10	2.00-2.08	1.97-2.05	1.94-2.02	1.92-2.00	1.90-1.98	1.88-1.96	1.87-1.95
型号Grit No.	F40	F46	F54	F60	F70	F80	F90	F100
堆积密度 Bulk Density	1.81-1.89	1.79-1.87	1.77-1.85	1.76-1.84	1.75-1.83	1.73-1.81	1.71-1.79	1.64-1.72
型号Grit No.	F120	F150	F180	F220				
堆积密度 Bulk Density	1.61-1.69	1.59-1.67	1.57-1.65	1.55-1.63				





高温煅烧棕刚玉磨料 Brown Fused Aluminum Oxide Blue fired



我公司生产的高温煅烧棕刚玉是对巴马克磨料，通过天然气隧道窑进行1300度高温煅烧而成，颜色变为蓝色，与普通棕刚玉相对、亲水性加强、纯度和清洁度更高、磁性物含量极低、锋利度和耐用度更高、尤其适用于生产高档树脂固结磨具及涂附磨具等。

The high-temperature fired brown fused aluminum oxide by our company is made of Barmac grains calcined at 1300 °C in natural gas tunnel kiln. The color turns blue. Compared with ordinary brown fused aluminum oxide, it has enhanced hydrophilicity, higher purity and cleanliness, extremely low magnetic content, higher sharpness and durability. It is especially suitable for the production of high-grade resin bond abrasives and coated abrasives etc.

项目Item	指标Specification
颜色Colour	深蓝Dark Blue
晶形Crystal System	三方晶系Alpha-alumina trigonal system
硬度 (莫氏)Mohs Hardness	≥9.0
熔点 (°C) Melting Temperature (°C)	2050
最高使用温度 (°C) Refractory Temperature (°C)	1900
真密度 (g/cm ³) True Density	≥3.90
磁性物Magnetic Material	0.076%

用途 Purpose	规格 Specification	主要化学成分 (%) Chemical composition (%)				磁性物 (%) Magnetic material content (%)
		Al ₂ O ₃	Fe ₂ O ₃	SiO ₂	TiO ₂	
磨料磨具 For abrasive	4#—80#	≥95	≤0.2	≤1.5	≤3.0	≤0.03
	90#—150#	≥94				≤0.03
	180#—240#	≥93.5	≤0.3	≤1.5	≤3.5	≤0.03





Quality Grinding wheels manufacture
Since 1989

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砂轮概述 Overview

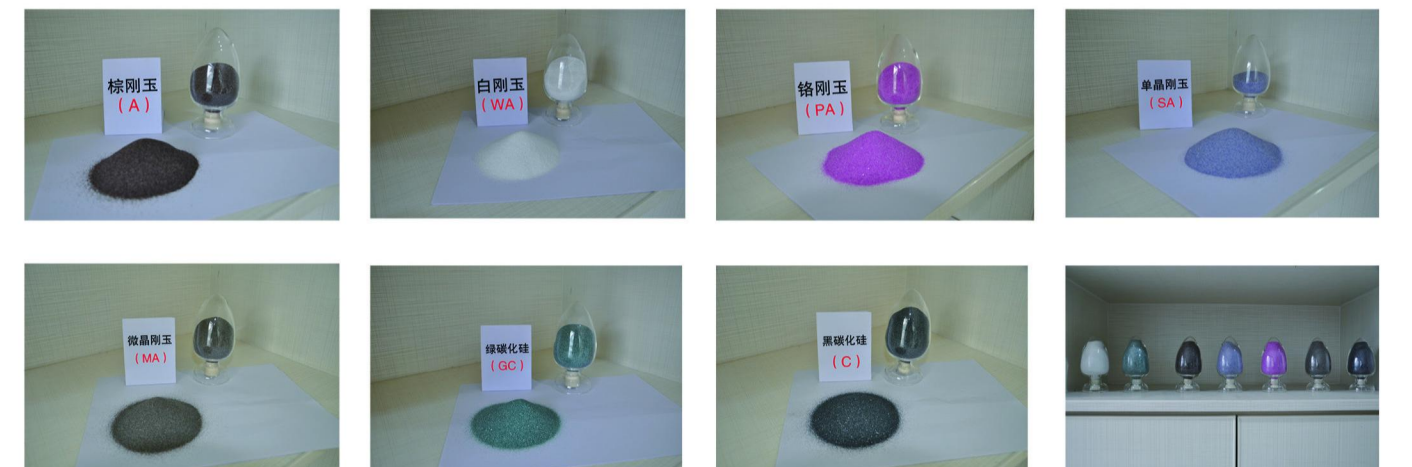
标识方法 Symbols

举例 For Example

1 形状代号 Type Code	1100 直径 Diameter	x 厚度 Thickness	x 孔径 Hole	WA 磨料 Abrasive	F60 粒度 Grit No.	K 硬度 Hardness	7 组织号 Structure No.	V 结合剂 Bond	35m/s 线速度 Max Linear Velocity
1 平行砂轮	150	3	12.7	A	F16	软 Soft			
2 筒型砂轮	200	6	19.05	WA	F24	G	0 紧		普通转速
3 单斜边砂轮	250	8	25.4	AA	F30	H	1	陶瓷 V	20m/s
4 双斜边砂轮	300	10	31.75	38A	粗	J	2		25m/s
5 单面凹砂轮	350	13	32	PA	Coarse	K	3		32m/s
6 杯型砂轮	400	20	38.1	25A	F36	L	4		35m/s
7 双面凹砂轮	450	25	50.8	SA	F46	M	5		40m/s
8 双面凹二号砂轮	500	32	75	MA	中	N	6		
11 碗型砂轮	600	40	76.2	GC	Medium	P	7	树脂 B	
12a 碟型一号砂轮	610	50	101.6	C	F60	Q	8		45m/s
12b 碟型二号砂轮	750	75	127	RA	F80	R	9		50m/s
20 单面锥砂轮	810	100	203	DA	F100	S	10		60m/s
23 单面凹锥砂轮	900	150	203.2	9A	F120	T	11		70m/s
26 双面凹锥砂轮	915	200	254	RA	细	Y	12	橡胶 R	
38 单面凸砂轮	1066	250	304.8	64A	FINE	硬 Hard	13		高速砂轮
39 双面凸砂轮	1100	300	305	55A			14 松		

磨料 Abrasives

代号 Code	种类 Type	特性	适用范围 Application
A	棕刚玉 Brown Alumina Oxide	棕褐色，硬度高，韧性大	适用于碳钢、合金钢、可锻造铸铁、硬青铜的磨削及研磨。 It is use for ordinary grinding, cutting and freedom grinding of carbon steel, alloy steel, malleable cast iron, hard bronze.
WA (38A)	白刚玉 White Alumina Oxide	白色，硬度高于棕刚玉，韧性低于棕刚玉，脆性大，切削性能强。	适用于经过热处理的工作件，如淬火钢、高速钢、工具钢、合金钢、高碳钢、非铁金属、薄壁工件的粗糙磨削、粗燥研磨、珩磨或精加工。 It is used for the grinding of high hardness and strength workpieces such as chilled steel, high carbon steel, ordinary high speed steel, alloy steel etc. it is mainly suitable for ordinary grinding, cutter sharpening, ultra precision honing, gear grinding, threads grinding, profiling grinding etc.
PA (25A)	铬刚玉 Pink Aluminum Oxide	粉、紫红色或玫瑰红色，硬度与白刚玉相近，但韧性高于白刚玉，耐用度高，磨削工件表面光洁度高。	适用于淬火钢、高速钢、工具钢、合金钢、高碳钢、轴承钢等产品的磨削。成型磨削的效果也比较好。 It is suitable for grinding alloy steel, tool steel, chilled steel, gears, profiling and instrument rack.
SA	单晶刚玉 Microcrystalline Aluminum Oxide	磨粒呈淡蓝灰色，相比与棕刚玉、白刚玉硬度高、韧性好，呈单颗粒球状晶体，具有良好的多棱切削刃，抗破碎性较强，磨削效率高。	适用于强度高、韧性大，容易变形和烧伤工件的加工磨削，如不锈钢、高钒钢、高速钢等。 It is suitable for grinding high speed steel, austenitic stainless steel, high speed steel, titanium alloy and high hardness and strength workpieces.
MA	微晶刚玉 Microcrystalline Aluminum Oxide	磨粒由微小晶体组成，韧性好，强度高，自锐性能好，颜色类似棕刚玉。	适用于轴承钢、不锈钢和特种球墨铸铁等的磨削。高速磨削。 It is suitable for heavy loading grinding, mirror grinding and high-rate grinding all kinds of quenched hard steel, stainless steel and special ductile iron etc.
GC	绿碳化硅 Green silicon carbide	绿色，半透明晶体，磨粒硬度高、脆性大，锋利，导热性能好。	适用于硬质合金刀具工件、玛瑙、宝石、陶瓷、玻璃、石材、非金属、硬铬工件等的磨削加工。 It is suitable for grinding or cutting hard alloy (carbide tips), glass, gem, stone, ceramics etc.
C	黑碳化硅 Black silicon carbide	黑色，磨粒硬度高与刚玉类磨料、且脆性大而锋利，具有较好的导热和抗电性能。	适用于有色金属及非金属材料的磨削加工，如铸铁、黄铜、铝、青铜（铸造）、钢管（铸造）耐火材料等 It is suitable for grinding or cutting cast iron, non-ferrous or non-metal materials etc.





粒度 Grit No.

粒度：是指磨料颗粒几何尺寸的大小。

砂轮粒度的选择直接影响到工件加工的表面粗糙度及磨削效率。

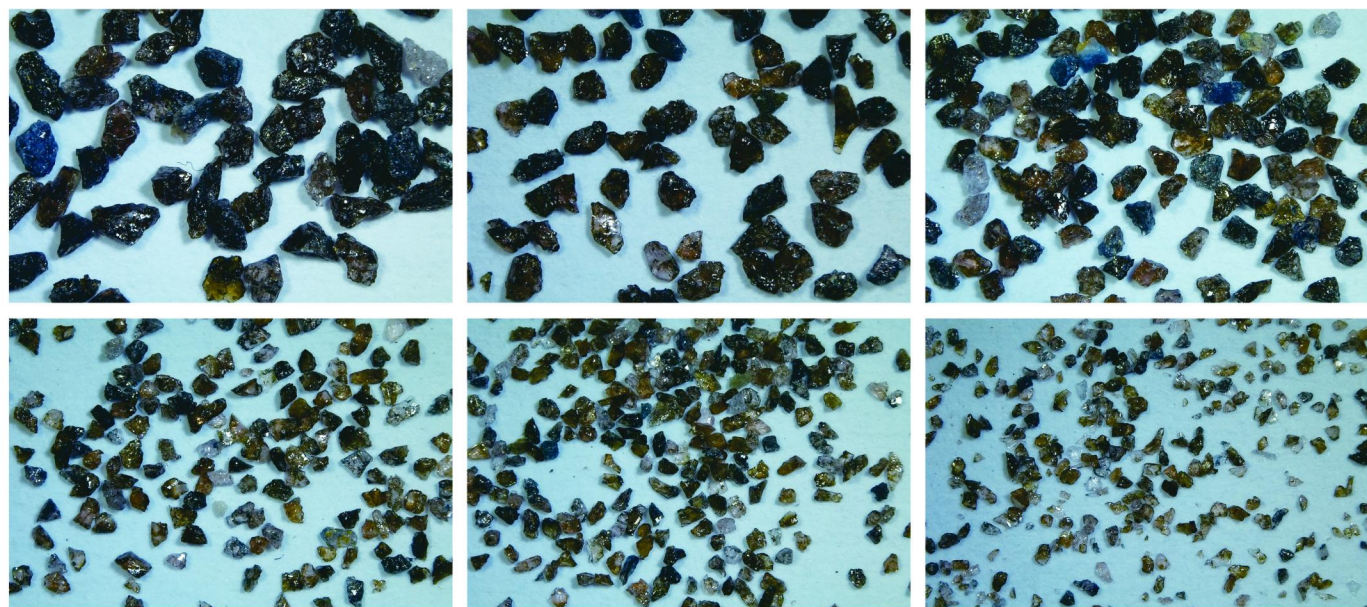
通常选择使用较粗粒度的砂轮磨削时效率高，但工件表面粗糙度差；使用较细粒度的砂轮磨削时工件表面粗糙度较好，但磨削效率低。所以为保证较高的磨削效率，在满足工件表面粗糙度要求的前提下，应尽量选用粒度较粗的砂轮。

Grit means the geometric dimensions of the abrasives grain size.

The grit directly influences surface roughness and grinding efficiency of the workpieces.

Generally,coarse grits have high grinding efficiency,but surface roughness is poor.fine grits have good surface roughness ,but grinding efficiency is low,so that in order to insure high grinding efficiency,under the condition of meeting the surface roughness,coarse grits should be selected first.

粒度	适用范围	粗糙度
Grit	Application	Surface Roughness
F12-F24	用于荒磨、粗磨、切断 Used for snagging , rough grinding or cutting etc.	
F30-F46	用于平面、外圆、内圆、无心磨等粗加工要求 Used for common coarse grinding	-1.8μm
F60-F100	用于平面、外圆、内圆、无心磨等各种磨床的较精细磨削要求Used for Precision fine grinding	1.6-0.2μm
F120-W20	用于精细、螺纹等磨削要求 Used for lapping polishing and threading grinding etc.	0.2-0.1μm
W20以细	用于镜面磨、精细抛光等 Used for mirror grinding and very fine polishing	0.1-0.012μm



硬度 Hardness

硬度：磨具在磨削加工过程中磨料从磨具表面脱落的难易程度

磨具硬度的选择：

1. 通常硬度较软的砂轮用来磨削较硬的工件，硬度较硬的砂轮用来磨削较软的工件。
2. 磨削加工过程中，工件与磨具的接触面大或进给量大时，应选择较软硬度的砂轮。成型磨削过程中，为保证工件几何形状的精度，可适当提高砂轮的硬度。
3. 磨削加工导热性能差的工件和刀刀具时，为避免烧伤、退火，应选择硬度较软一些的砂轮。
4. 高速磨削时需选择较软硬度的砂轮；湿磨与干磨相比可以选择硬度稍硬一些的砂轮。

The hardness of abrasive toolsmeans the difficulty of abrasive grains falling of the surface of the abrasive tools under the effect of outside force.

1. Generally,the grinding wheels in soft hardness are used for cutting harder workpieces,whereas the wheels in a bit higher hardenss are used for cutting soft workpieces.

2. In the process of grinding,when the contact surface between workpiece and grinding wheel is big or feed amount is big,grinding wheels with softer hardness should be selected.for form grinding ,in order to ensure the workpiece geometrical shape precision,grinding wheels hardness should be enhanced suitably.

3. When grunding the worpieces with bad heat-conducting property and sharpening cutters.in order to avoid burning and annealing,soft hardness should be selected.

4、 When grinding at high speed,softer hardness should be selected.Hardness in dry grinding should be softer than in wet grinding.

硬度等级	软			中软		中		中硬			硬		超硬
Hardness Grade	Softer			Soft		Medium		Hard			Harder		Extrahard
硬度代号 Code	软1	软2	软3	中软1	中软2	中1	中2	中硬1	中硬2	中硬3	硬1	硬2	超硬
	G	H	J	K	L	M	N	P	Q	R	S	T	Y



组织号 Structre No.

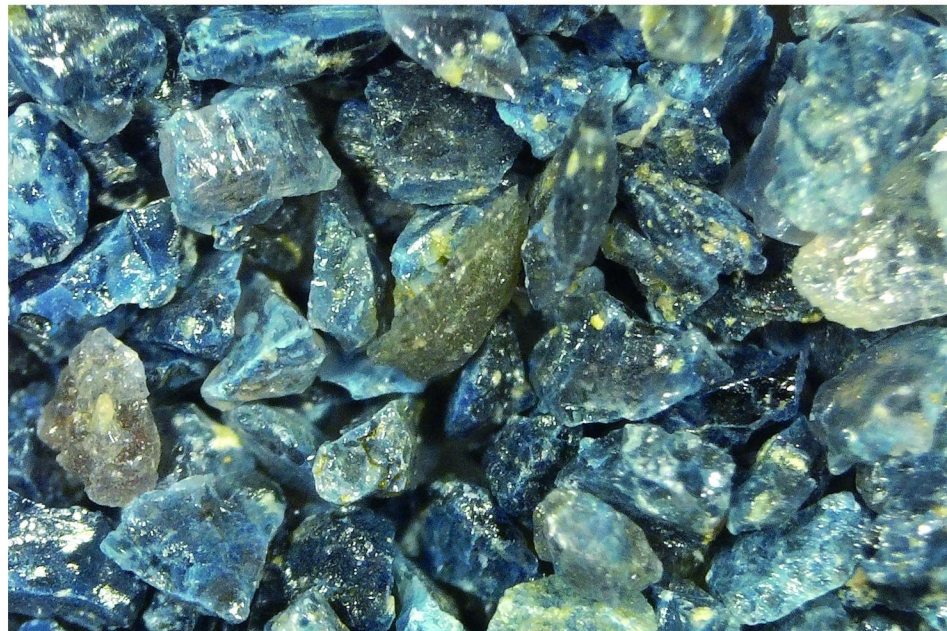
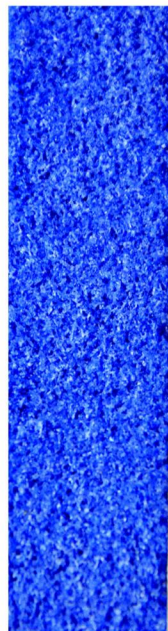
组织号是指组成砂轮的磨粒、结合剂、气孔三部分体积的比例关系。

磨粒所占的比例越大，组织就越紧密；反之就疏松。

组织疏松（磨粒率低）的磨具，磨粒间的气孔多，排屑方便，工件散热性好，不烧伤。
组织紧密（磨粒率高）的磨具，能保持较好的几何形状，被磨工件的表面粗糙度好，加工精度高。

Structure No.means the volume percentage of abrasive grains in abrasives tools.The greater of abrasive grains proportion is, the more compact the structure is,on the contrary,the structure is porous.the geometrical shape of compact structure abrasive tools can be kept better.the surface roughness and machining accuracy of the workpieces grinded by compact structure grinding wheels are better.the loose structure abrasives tools have the characters of more holes between grains and easy chips removal,good heat dissipation,and hot burning workpieces.

组织号 Structure No.	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14
磨粒率 % of abrasives grains	62	60	58	56	54	52	50	48	46	44	42	40	38	36	34



线速度 Max Operating Speed

1、砂轮上标示的速度为最高工作线速度

2、砂轮的工作线速度由砂轮转速和砂轮直径决定

3、订货请务必注明工作线速度，如果不标注我司将默认按照 35m/s 线速度安排生产常用砂轮最高工作线速度如下表

1. The speed marked on abrasive tools is the max.operating linear speed,the unit is m/s ,before used should be verified.dont use at overspeed.

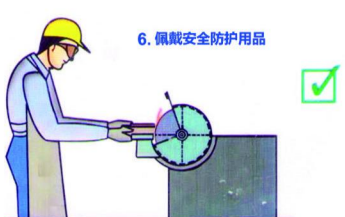
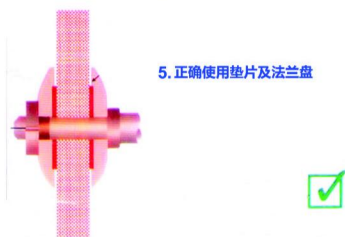
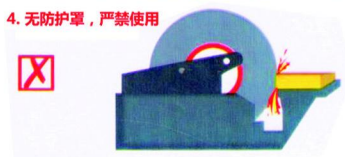
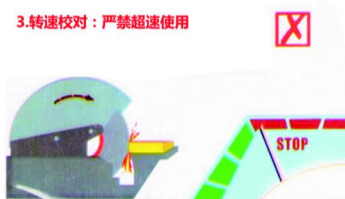
2. the air pressure of the air tool need to keep stable,otherwise it is easy to cause grindig whees overspeed and broken.

3. when you place order to us.pls mention the speed m/s.otherwise we will produce as 35m/s.

砂轮直径		最高工作线速度						
Diameter		MaxLinear Velocity (m/s)						
Inch	mm	30m/s	35m/s	40m/s	45m/s	50m/s	60m/s	70m/s
4	100	5730	6684	7639	8594	9549	11459	13369
5	125	4584	5348	6112	6875	7639	9167	10695
6	150	3820	4456	5093	5730	6366	7639	8913
7	175	3274	3820	4365	4911	5457	6548	7639
8	200	2865	3342	3820	4297	4775	5730	6684
10	250	2292	2674	3056	3438	3820	4584	5348
12	300	1910	2228	2546	2865	3183	3820	4456
14	350	1637	1910	2183	2456	2728	3274	3820
16	400	1432	1671	1910	2149	2387	2865	3342
18	450	1273	1485	1698	1910	2122	2546	2971
20	500	1146	1337	1528	1719	1910	2292	2674
24	600	955	1114	1273	1432	1592	1910	2228
30	750	764	891	1019	1146	1273	1528	1783
36	900	637	743	849	955	1061	1273	1485
42	1066	537	627	717	806	896	1075	1254
44	1100	521	608	694	781	868	1042	1215



砂轮的安全使用：The safe use of the grinding wheel:



1. 收到砂轮后，应使用平板车等工具运输，搬运须小心轻拿轻放，禁止重压，震动及碰撞，尤其不能在地上滚动砂轮；根据砂轮的尺寸，形状不同，将砂轮竖放或者平放；对砂轮的支撑必须牢固，不能将砂轮斜靠在设备旁边。

2. 敲击砂轮听是否存在哑音回声，以确定砂轮不存在裂纹，目测砂轮可能存在的损坏情况，发现裂纹和哑声的砂轮严禁装机使用。

3. 校对机床的转速是否与砂轮上所表明的最高安全使用转速相符，如果不符，严禁装机使用。

4. 机床或砂轮机必须配备坚固的防护罩装置，防护罩至少要罩住砂轮直径的一半。

5. 砂轮内径与砂轮轴尺寸必须相符，不能间隙过大，也不能强制安装或任意改变砂轮的孔径。

6. 正确选择使用法兰盘，通常情况下法兰的直径相当于砂轮直径的三分之一，且两片尺寸大小须相同。

7. 法兰盘与砂轮的接触面要使用厚度 0.5mm-1.5mm 的干净垫片（橡胶片，纸片等），并在法兰盘圆周外部露出 1mm-2mm。

8. 对于多点紧固的法兰，须根据机床建议的力矩大小将法兰用力均匀地紧固在砂轮上，并对称顺序进行分数次逐步拧紧，严禁将紧固螺丝拧的过紧。

9. 启动机床前，须检查设备的各项防护装置及各种动作的复位开关已经调整到位。

10. 磨削加工前，机床必须以工作速度空转不得少于 3 分钟，操作者严禁直接面对机床站立。

11. 磨削加工时，操作者应佩戴眼镜或其他相似的安全防护用品。

12. 磨削加工或者必要，需重新修整砂轮时，接触要轻缓，进刀量要适度，禁止将工件强行挤入砂轮，或对砂轮施加外力使其停止转动；砂轮停止转动前，将冷却液关闭，以免造成砂轮失去平衡。

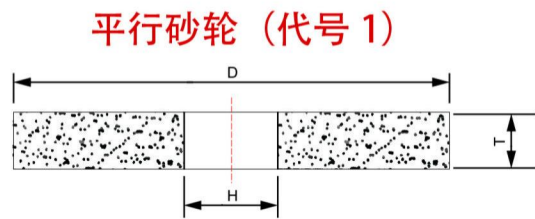




通用磨砂轮 General Purpose Grinding

信发通用磨砂轮适用于台式砂轮机磨削，台式磨床磨削、荒磨及其他一般应用磨削。选择使用严格把关的优质磨料制成，磨料具有良好的自锐性能，配套使用的结合剂能很好的把持住磨料，达到较高的磨削清除率和较长的使用寿命，能够保证快速磨削，低温磨削和理想的表面光洁度，从而实现高效率的磨削。

XINFA General Purpose Grinding is suitable for the bench grinding machinery, snagging and other general purpose. Choose to use strict quality abrasives with good self sharpening performance, supporting the bond can hold abrasive well. and achieve the removal rate and longer life, it can guarantee the fast grinding, grinding in low temperature and the good surface finishing, so as to realize the high efficiency grinding.



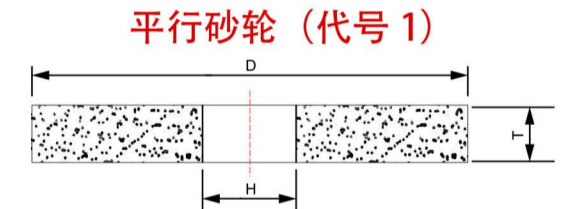
平行砂轮 (代号 1)

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
50mm	6-20mm	12.7mm 19.05mm	A WA AA 38A 25A PA SA GC C	F24 F36 COARSE F46 F54 MEDIUM F60 F80 FINE F100 F120 F150	H J K L M N O P Q R S T Y	4	33m/s
100mm	6-25mm	20mm					
150mm	6-25mm	25.4mm					
200mm	6-25mm	31.75mm					
250mm	6-25mm	32mm					
300mm	6-50mm	38.1mm 50.8mm					
350mm	10-55mm	75mm 127mm					
400mm	32-63mm	38.1mm 50.8mm					
450mm	32-75mm	75mm					
500mm	32-100mm	127mm					
600mm	32-125mm	203mm					



砂轮机砂轮 Bench Grinder Grinding

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
100mm	12mm	12.7mm	A				
125mm	13mm	15.88mm	WA	F36	K	5	33m/s
150mm	20mm	19.05mm	AA	F46	L	6	35m/s
175mm	25mm	20mm	38A	F54	M	7	40m/s
180mm	32mm	25.4mm	25A	F60	N	8	45m/s
200mm	38.1mm	31.75mm	PA	F80	P	9	50m/s
300mm	40mm	32mm	SA	F100	Q	10	60m/s
350mm	50mm	38.1mm	GC	F120			
400mm	50mm	38.1mm	GC	F120			
450mm	80mm	50.8mm	C				

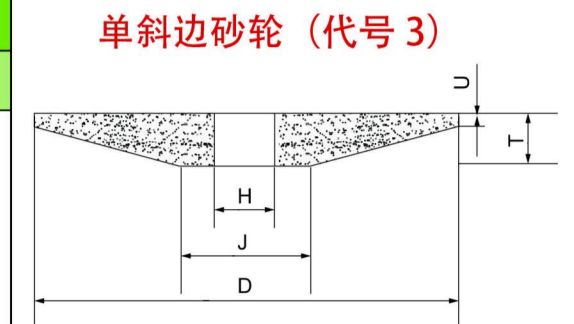


平行砂轮 (代号 1)



锯齿磨砂轮 Saw gumming Grinding

直径	厚度	孔径	J	U	材质	粒度	硬度	组织号	转速
OD	T	H	J	U	Grit	Grain	Hardness	Structure	Speed
125mm	6mm 8mm 10mm	12.7mm 19.05mm 20mm 25.4mm 31.75mm 32mm	57mm- 299mm	2mm 3mm 4mm	A WA AA 38A 25A PA SA GC	F60 F80 F100 F120	P Q R S	1 2 3 4 5 6	33m/s 35m/s
150mm	6mm 8mm 10mm 13mm								
175mm	6mm 8mm 10mm 13mm								
200mm	6mm 8mm 10mm 13mm								
250mm	10mm 13mm 16mm								
300MM	10mm 13mm 16mm								



单斜边砂轮 (代号 3)



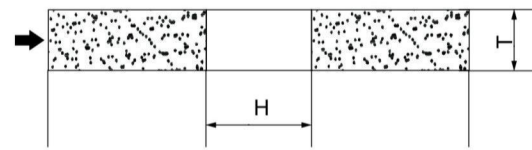


工具磨砂轮 Tool Room Grinding

我公司生产的工具磨砂轮通常用于铣刀，铰刀，钻头，拉刀等工具的磨削，具有组织均匀，结构合理，切削能力强，不烧伤工件等特点

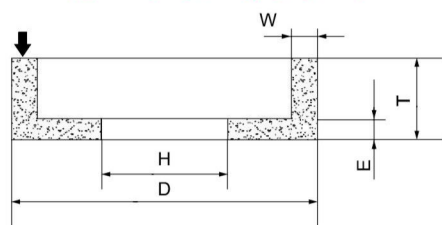
XINFA Tool Room Grinding mainly used for sharpening milling cutter,drills, slotting cutters etc.the characters of reasonable and homogeneous structure,strong cutting performance,and not burning workpieces.

平行砂轮 (代号 1)



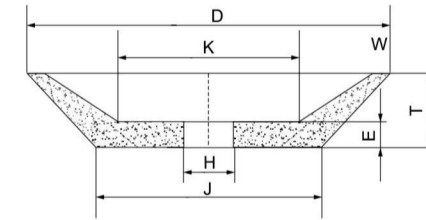
直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
100mm	3-25mm	12.7mm	A	F46	H		
		19.05mm	WA	F54	J	5	33m/s
150mm	3-25mm	20mm	AA	F60	K	6	35m/s
200mm	3-25mm	25.4mm	38A	F80	L	7	40m/s
		31.75mm	25A	F100	M	8	45m/s
250mm	3-25mm	32mm	PA	F120	N		

杯型砂轮 (代号 6)



直径	厚度	孔径	壁厚	底厚	内角	材质	粒度	硬度	组织号	转速
OD	T	H	W	E	R	Grit	Grain	Hardness	Structure	Speed
75mm	40mm	25.4mm	4mm	8mm						
100mm	50mm	31.75mm	13mm	10mm		A	F46	H		
125mm	63mm	25.4mm	20mm	13mm	3	WA	F54	J	5	33m/s
					4	AA	F60	K	6	35m/s
150mm	63mm	31.75mm	12.5mm	13mm	5	38A	F80	L	7	
	80mm	65mm	13mm	13mm		25A	F100	M	8	
200mm	63mm	75mm	15mm	18mm		PA	F120	N		
	100mm	100mm	20mm	25mm		GC				
250mm	100mm	150mm	25mm	25mm						

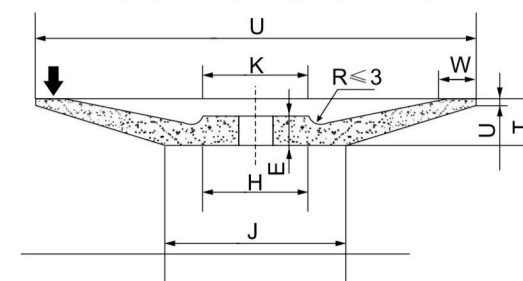
碗型砂轮 (代号 11)



直径	厚度	孔径	壁厚	底厚	底直径	内直径	内角	材质	粒度	硬度	组织号	转速
OD	T	H	W	E	J	K	R	Grit	Grain	Hardness	Structure	Speed
50mm	25mm	12.7mm	5mm	7mm	32mm	23mm	3					
75mm	32mm	20mm	5mm		52mm	44mm		A				
100mm	30mm	25.4mm	10mm	10mm	50mm	40mm	4	WA	F46	H		
	35mm		7.5mm		75mm	62mm		AA	F54	J	5	33m/s
125mm	35mm		10mm	10mm	66mm	55mm		38A	F60	K	6	35m/s
	45mm			13mm	92mm	75mm		25A	F80	L	7	
150mm	35mm	25.4mm	12.5mm	13mm	91mm	75mm		PA	F100	M	8	
	50mm	31.75mm	15mm	15mm	114mm	97mm		GC	F120	N		
175mm		32mm	22.5mm		102mm	86mm	5					
200mm	63mm	100mm	25mm	25mm	127mm	106mm						
250mm	140mm	140mm	30mm		201mm	155mm						
300mm	150mm		35mm	40mm	247mm	191mm						

直径	厚度	孔径	K	J	W	U	E	材质	粒度	硬度	组织号	转速
OD	T	H	K	J	W	U	E	Grit	Grain	Hardness	Structure	Speed
75mm	8mm	13mm	30mm	30mm	4mm	2mm	5mm					
100mm	10mm	20mm	40mm	40mm	6mm	2mm	6mm					
125mm	13mm		50mm	50mm	6mm	3mm	8mm					
150mm	16mm	31.75mm	60mm	60mm	8mm	4mm	10mm	WA	F46	H		
200mm	20mm	32mm	80mm	81mm	10mm	4mm	12mm	AA	F54	J	5	33m/s
250mm	25mm		100mm	103mm	13mm	6mm	15mm	38A	F60	K	6	35m/s
300mm				181mm	15mm		13mm	25A	F80	L	7	
350mm	20mm	127mm	180mm	193mm	25mm	4mm	18mm	PA	F100	M	8	
400mm	25mm			243mm	25mm				F120	N		
500mm				291mm	35mm		27mm					
600mm	32mm	203mm	255mm	406mm	35mm	6mm	24mm					

碟形砂轮 (代号 12a)



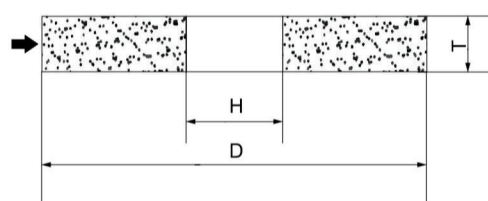


平面磨砂轮 Flat Surface Grinding

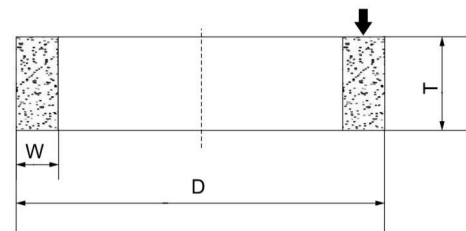
本产品供平面磨床使用，适用于各行业的平面磨削，可根据工件的材料性能，表面质量，几何精度等要求，来选择匹配的砂轮满足使用要求。

This product can be used for surface grinding machine. It is suitable for surface grinding of various industries. According to the material properties, surface quality and geometric precision of the workpiece, the matching grinding wheel can be chosen to the performance .

平行砂轮 (代号 1)



筒型砂轮 (代号 2)



直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
150mm	13mm	31.75mm 32mm	A WA AA 38A 25A PA SA GC	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
200mm	13mm 20mm 25mm						
250mm	16mm 20mm 25mm 32mm						
300mm	20mm 25mm 32mm 40mm 50mm						
350mm	32mm 40mm 50mm	75mm 127mm 203mm 203.2mm 304.8mm 305mm					
400mm	32mm	304.8mm 305mm					
450mm	40mm						
500mm	50mm						
600mm	32mm						
750mm	40mm						
900mm	50mm						

直径	厚度	壁厚	材质	粒度	硬度	组织号	转速
OD	T	W	Grit	Grain	Hardness	Structure	Speed
90mm	80mm	5mm 7mm 10mm	A WA AA 38A 25A PA SA GC	F36 F46 F54 F60 F80 F100 F120	K L M N P	5 6 7 8 9 10	33m/s 35m/s
250mm	125mm	25mm					
300mm	75mm 100mm	25mm 50mm					
350mm	125mm	35mm 50mm					
450mm	125mm 150mm	35mm 100mm					
500mm	150mm	60mm					
600mm	100mm	60mm					



无心磨砂轮 Centreless Grinding

无心磨砂轮广泛应用于工具制造及各类轴承，轴类的无心磨削。

The wheels are mainly used for grinding mass slender axles,short axles without center hole,specific taper pins,bearing, many type shafts etc.

形状代号	直径	厚度	孔径	P	F	R	材质	粒度	硬度	组织号	转速
Type Code	OD	T	H	P	F	R	Grit	Grain	Hardness	Structure	Speed
1 5 7	300mm	100mm-125mm	127mm 152.4mm	190mm	10mm 16mm 20mm 25mm	5mm 8mm	A WA AA 38A 25A PA SA GC C	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
	350mm	100mm-150mm	203mm	200mm							
	400mm	100mm-250mm	203.2mm	265mm							
	450mm	150mm-200mm	225mm 254mm	280mm							
	500mm	100mm-300mm	304.8mm	375mm							
	600mm	150mm-300mm	305mm	400mm							
	750mm	400mm		435mm							





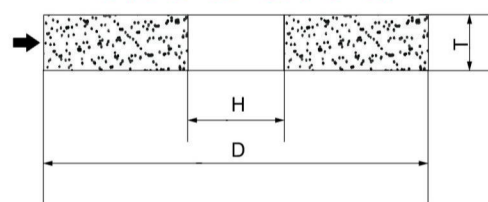
外圆磨砂轮 Cylindrical Grinding

本产品供外圆磨床使用，砂轮以外圆周为工作面，广泛应用于阀门，传动轴，轴承等工件的磨削，可根据工件的材料性能，表面质量，几何精度等要求，来选择匹配的砂轮满足使用要求。

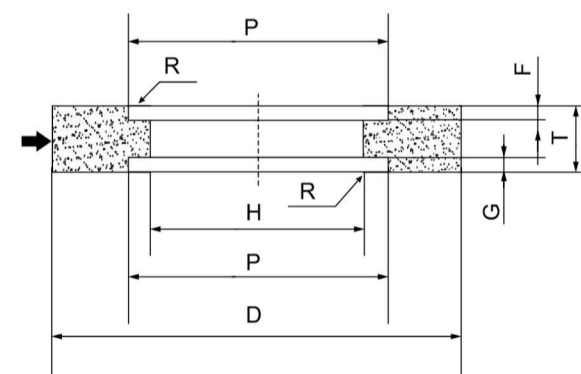
Excircle grinding are the most common grinding ways,which are used on excircle grinder.the outer circle surface of grinding wheels is the working face.the wheels are mainly used for valve,Drive Shaft,bearing etc.According to the material properties, surface quality and geometric precision of the workpiece, the matching grinding wheel can be chosen to the performance .

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
250mm	20mm-40mm	75mm 76.2mm 127mm	A WA AA 38A 25A PA SA GC C	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
300mm	20mm-63mm	75mm 76.2mm					
350mm	25mm-63mm	127mm					
400mm	32mm-80mm	127mm 203mm 203.2mm					
450mm		203.2mm					
500mm		203.2mm 254mm					
600mm	40mm-150mm	304.8mm					
750mm	50mm-75mm	305mm					

平行砂轮 (代号 1)

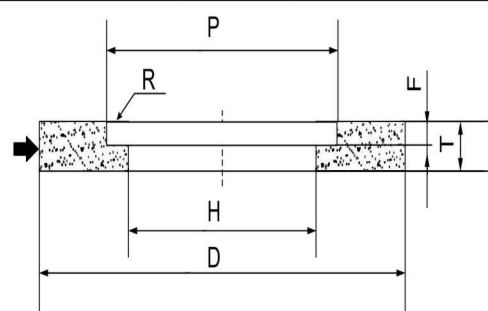


直径	厚度	孔径	凹直径	1凹深度	2凹深度	R 最大	材质	粒度	硬度	组织号	转速
OD	T	H	P	F	G	R max	Grit	Grain	Hardness	Structure	Speed
300mm	40mm	76.2mm 127mm	150mm 190mm	6mm-10mm		3.2	A				
350mm	50mm	127mm	215mm	10mm-13mm		5	WA	F36	K	5	33m/s
400mm							AA	F46			L
450mm	40mm-80mm	127mm 203mm 203.2mm	215mm 280mm	10mm-13mm		8	38A	F54	M	7	40m/s
							25A	F60	N	8	45m/s
							PA	F80	P	9	50m/s
500mm	50mm-100mm	203mm	400mm	10mm-25mm		8	SA	F100	Q	10	60m/s
600mm							GC	F120			
750mm							C				

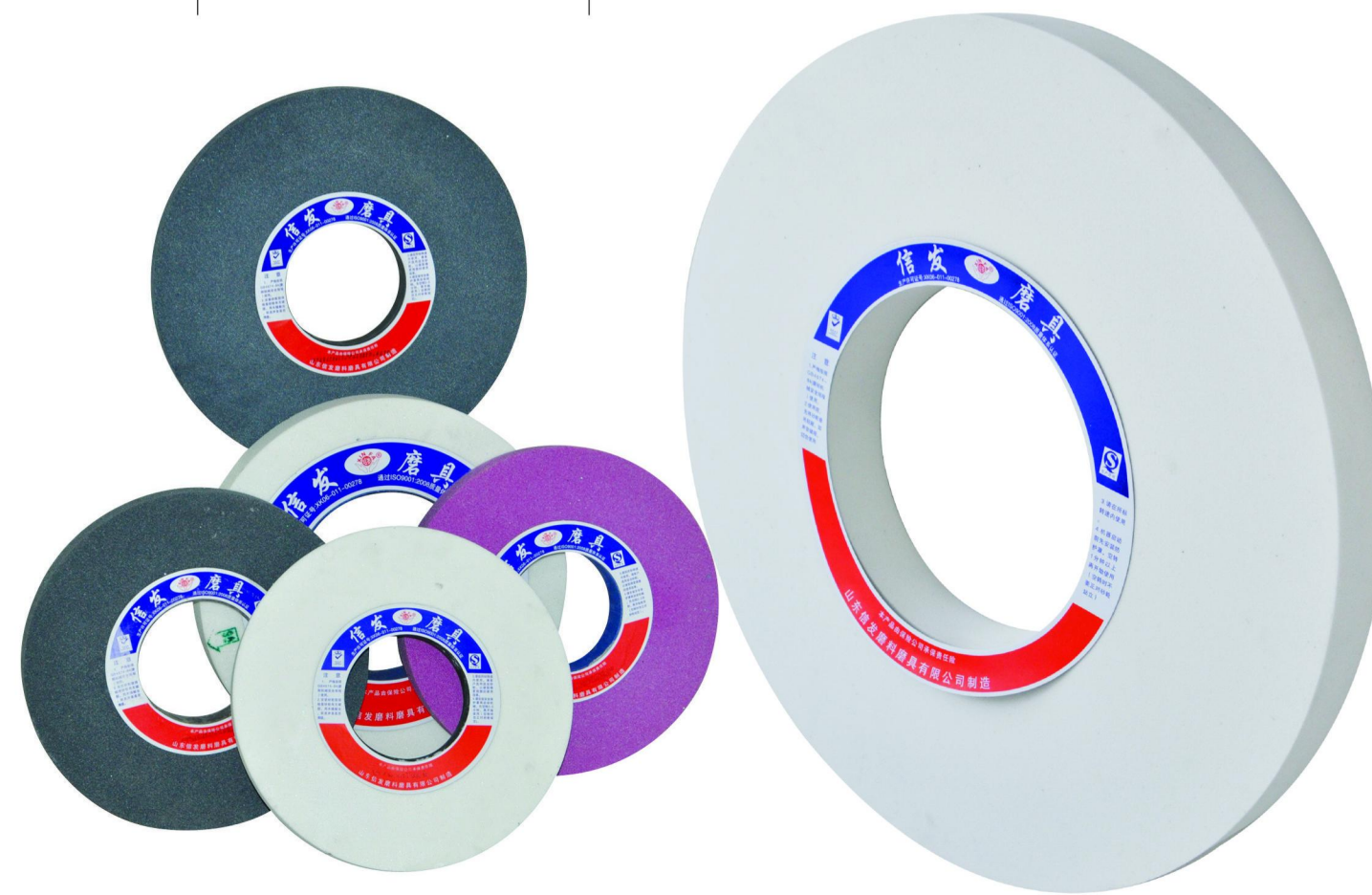


双面凹砂轮 (代号 7)

直径	厚度	孔径	凹直径	凹深度	R 最大	材质	粒度	硬度	组织号	转速	
OD	T	H	P	F	R max	Grit	Grain	Hardness	Structure	Speed	
300mm	40mm	76.2mm 127mm	150mm 190mm	13mm	3.2	A					
350mm	50mm	127mm	215mm	13mm	5	WA	F36	K	5	33m/s	
400mm						AA	F46				L
450mm	40mm-80mm	127mm 203mm 203.2mm	215mm 280mm	13mm 25mm	8	38A	F54	M	7	40m/s	
						25A	F60	N	8	45m/s	
						PA	F80	P	9	50m/s	
500mm	40mm-100mm	203mm	400mm	13mm 25mm	8	SA	F100	Q	10	60m/s	
600mm						GC	F120				
750mm						C					



单面凹砂轮 (代号 5)

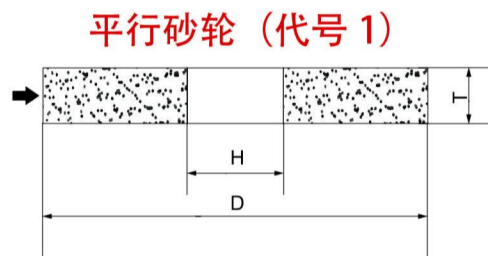




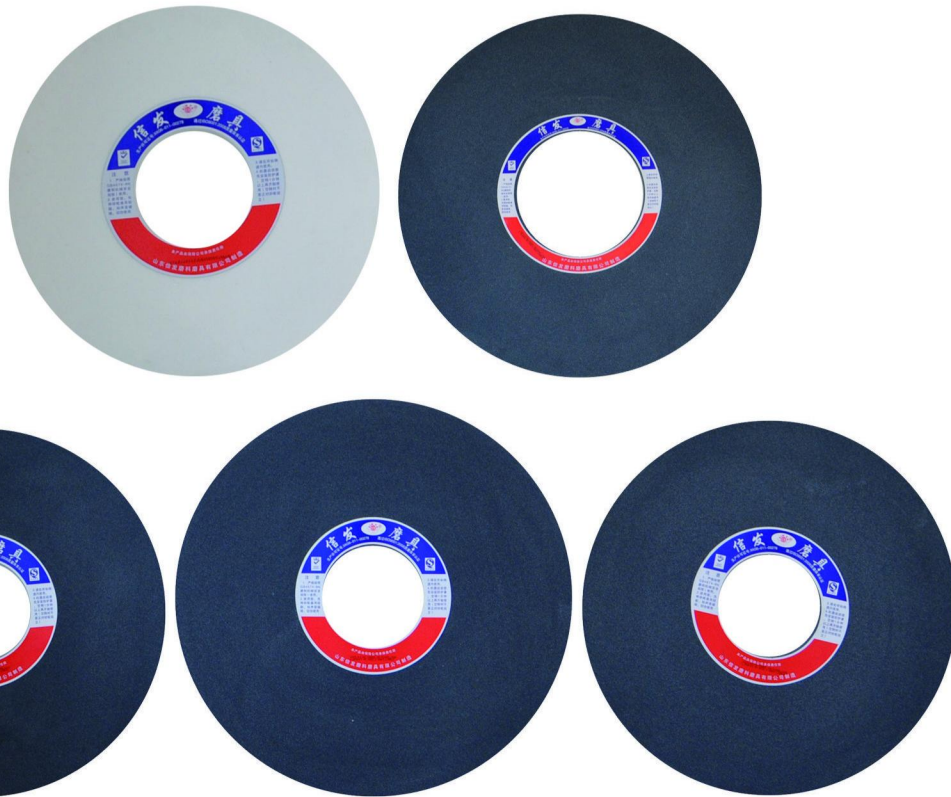
曲轴及凸轮轴磨削砂轮 Crankshaft & Cam Shaft Grinding

曲轴磨砂轮主要由于汽车，拖拉机，摩托车，轮船等运输机械的各种曲轴，凸轮轴的磨削，属于较特殊的外圆切入磨削。我公司生产的曲轴磨砂轮具有组织硬度均匀，静平衡优于国家标准规定值，性价比高等特点

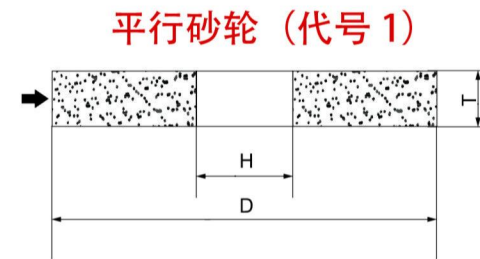
The wheels are mainly used for grinding all kinds of crankshafts and camshafts of auto, tractor motorcycle, ship engine as well as transport machinery etc. Our wheels have uniform Structure and hardness, out of balance performance, and cost performance etc.



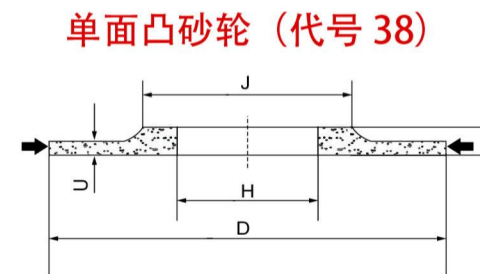
直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
500mm	16mm-55mm 55mm-90mm	127mm 203mm 203.2mm 304.8mm 305mm	A WA AA 38A 25A PA SA GC C	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
600mm							
610mm							
635mm							
660mm							
700mm							
710mm							
750mm							
760mm							
810mm							
900mm							
1065mm							
1100mm							



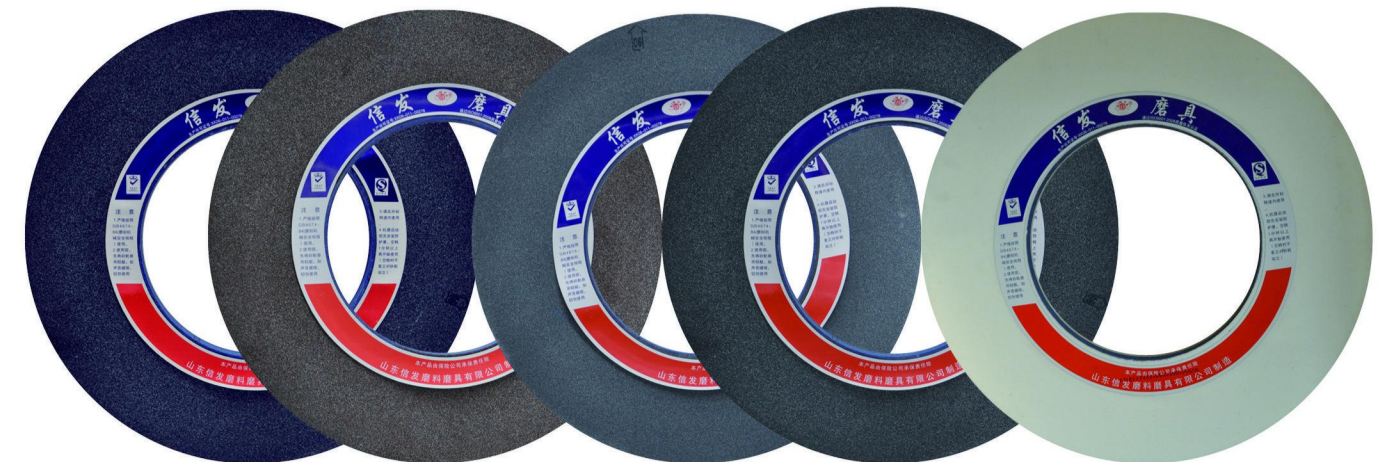
轴承沟道磨砂轮 Bearing Grinding



直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
500mm	14mm-50mm	305mm	A WA AA 38A	F46 F60 F80 F100 F120	L M N P Q	5 6 7 8 9 10	35m/s 40m/s 45m/s 50m/s 60m/s
600mm							



直径	厚度	孔径	J	U	材质	粒度	硬度	组织号	转速
OD	T	H	J	U	Grit	Grain	Hardness	Structure	Speed
500mm	16mm	305mm	350mm	6mm	A WA AA 38A SA	F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	35m/s 40m/s 45m/s 50m/s 60m/s
	20mm			8mm					
				10mm					
600mm	20mm			8mm					
	25mm			10mm					
				13mm					



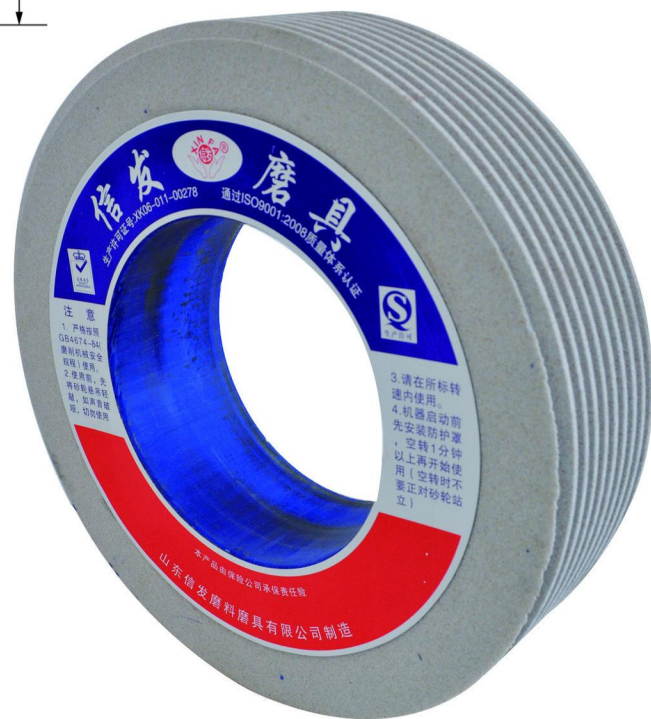
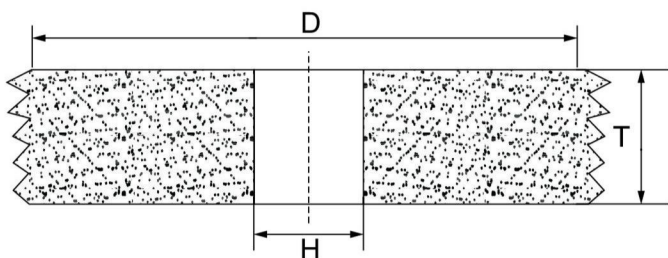


蜗杆磨砂轮 Worm Grinding Wheels

The wheels are mainly used on for grinding spur gear, helical gear, conical gear, slotting cutter, shaving cutter, etc

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
220mm	180mm	76.2mm	A WA AA 38A 25A PA SA	F60 F80 F100 F120	H J K L M N	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
240mm	230mm	90mm					
250mm	50mm	110mm					
275mm	125mm	127mm					
300mm	63 80 100 125 145mm	160mm					
350mm	63 84 104 125 150mm						
400mm	84 104mm	203mm					
450mm	84 104mm						

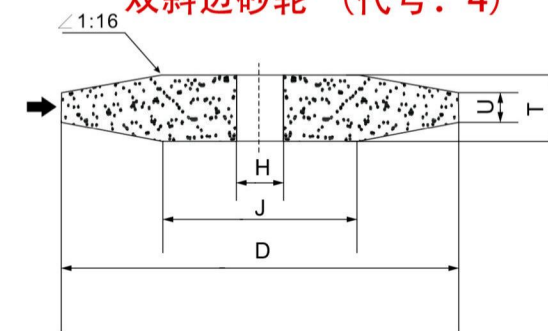
蜗杆磨砂轮 (代号 PMC)



齿轮磨砂轮 Gear Grinding

直径	厚度	孔径	U	材质	粒度	硬度	组织号	转速
OD	T	H	U	Grit	Grain	Hardness	Structure	Speed
125mm	13mm 16mm 20mm	20mm 31.75mm 32mm	4mm 6mm	A WA AA 38A 25A PA SA GC	F60 F80 F100 F120	K L M N P Q	5 6 7 8 9	35m/s 40m/s 45m/s 50m/s
150mm	16mm 20mm							
200mm	13mm 16mm	75mm	11mm					
250mm	10mm-25mm							
300mm	20mm 25mm	127mm	6mm					
350mm	32mm							
400mm	32mm							
455mm	32mm-90mm							

双斜边砂轮 (代号: 4)

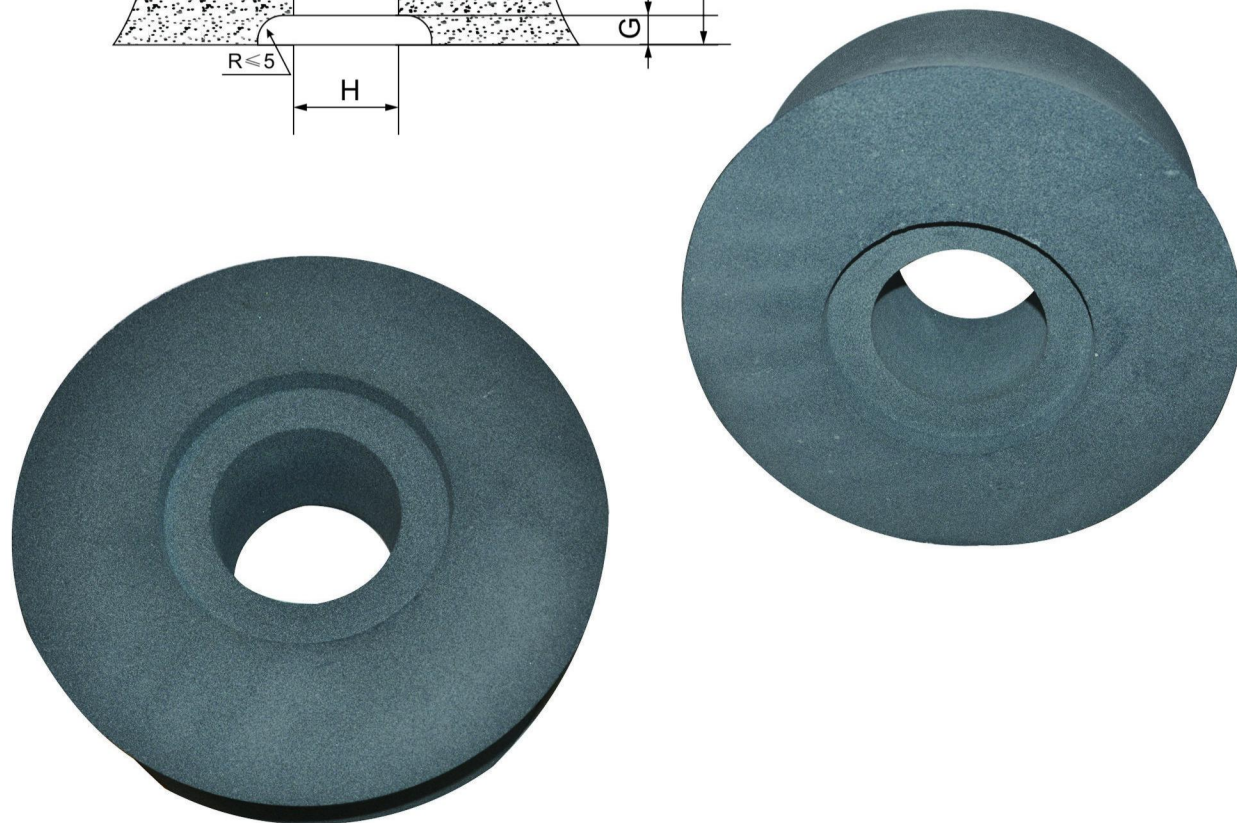
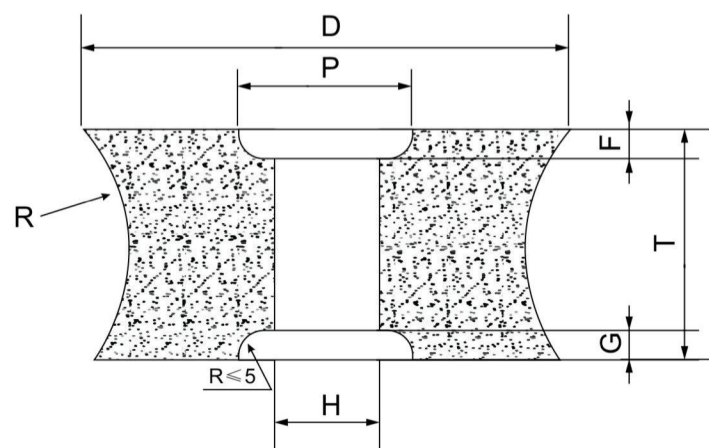




磨针砂轮 Needle Grinding

直径	厚度	孔径	P	F=G	R	材质	粒度	硬度	组织号	转速
OD	T	H	P	F=G	R	Grit	Grain	Hardness	Structure	Speed
400mm	150mm	100mm	170mm	25mm	150mm	A WA AA	F46	K L	5 6	33m/s 35m/s
450mm	200mm	150mm	225mm	25mm	200mm	38A 25A PA SA	F54 F60 F80 F100	M N P Q	7 8 9 10	40m/s 45m/s 50m/s 60m/s

磨针用双面凹J型面砂轮 (代号: 7-J)



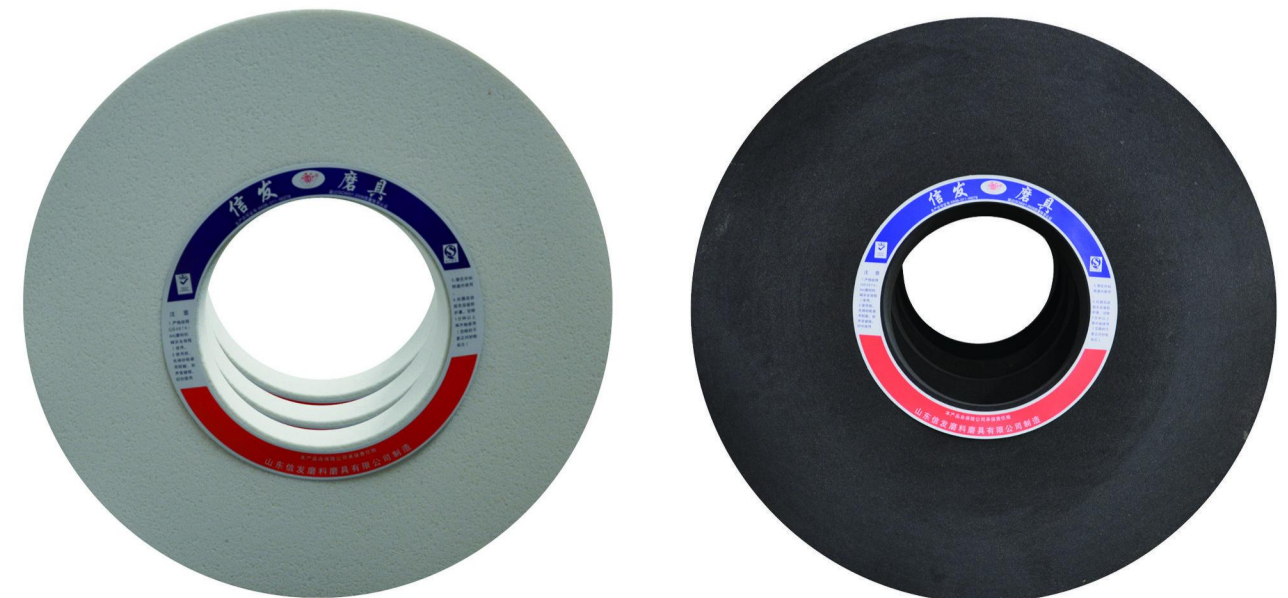
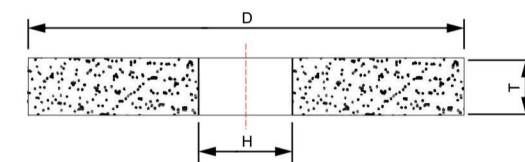
轧辊磨砂轮 Roll Grinding

轧辊磨砂轮广泛应用于钢铁轧钢厂的各种冷轧，热轧，不锈钢板带等，及造纸行业使用的金属辊的工作辊或支撑辊的磨削，砂轮具有强度高，硬度均匀，磨削效率高等特点。

The wheels widely used in steel factory for all kinds of hot-roll, cold-roll steel sheets, stainless steel plate and strip and metal rolls in papermaking industry.the wheels has high strength,uniform structure and hardness,high efficiency etc.

直径	厚度	孔径	材质	粒度	硬度	组织号	转速	结合剂
OD	T	H	Grit	Grain	Hardness	Structure	Speed	Bond
450mm-600mm	50mm-63mm	203mm 203.2mm 304.8mm 305mm 508mm	A WA AA	F36	H	5	33m/s	V 陶瓷 B 树脂
750mm	63mm-150mm		F46	I	6	35m/s		
800mm	100mm		F54	J	7	40m/s		
900mm 915mm	63mm-150mm		F60	K	8	45m/s		
			F80	L	8	45m/s		
1066mm	63mm-125mm	SA	M	9	50m/s			
		GC	N	10	60m/s			
			C					

平行砂轮 (代号 1)

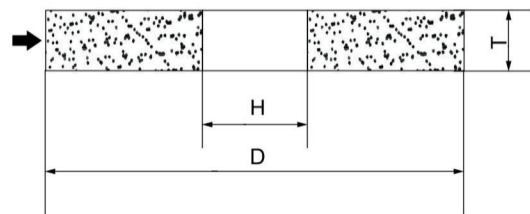




内圆磨砂轮 Internal (Bore) Grinding

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
50mm	6mm-40mm	16mm	A WA AA 38A 25A PA SA GC	F46 F54 F60 F80 F100 F120	H J K L M N P	4 5 6 7 8 9	33m/s 35m/s 40m/s 45m/s
60mm	32mm-50mm	20mm					
70mm	6mm-63mm						
80mm	8mm-50mm						
90mm	10mm-63mm						
100mm	32mm-120mm						
125mm	63mm-120mm	20mm					
150mm		31.75mm 32mm					

平行砂轮 (代号 1)



磨块 Segments

平行砂瓦 代号: 3101
3101-BXCXL(mm)

mm		
B	C	L
50	25	150
80	25	150
90	35	150
80	50	200

梯形砂瓦 代号: 3109
3109-B/AXCXL(mm)

mm			
B	A	C	L
60	50	15	125
100	85	35	150

平凹形砂瓦 代号: 3102
3102-B/AXCXL(mm)

mm				
B	A	C	R	L
100	85	38	230	150

凸平形砂瓦 代号: 3103
3103-B/AXCXL(mm)

mm				
B	A	C	R	L
115	80	45	250	150

扇形砂瓦 代号: 3104
3104-B/AXCXL(mm)

mm				
B	A	C	R	L
60	40	85	25	75
125	85	225	35	125

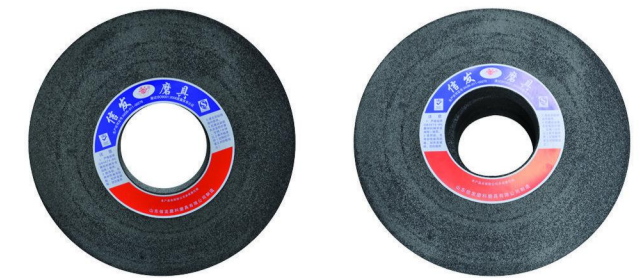
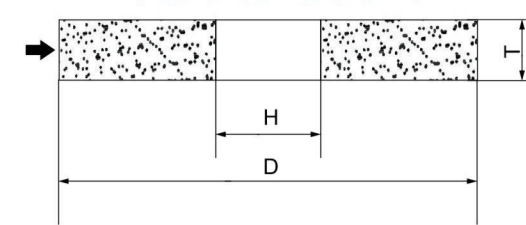


树脂荒磨砂轮

Resin Bonded Snagging Wheels

直径	厚度	孔径	材质	粒度	硬度	组织号	转速
OD	T	H	Grit	Grain	Hardness	Structure	Speed
300-900mm	30-100mm	38.1mm-305mm	A WA	F16	M	7	35m/s
				F20	N	8	40m/s
				F24	P	9	45m/s
				F30	Q	10	50m/s
					S		60m/s

平行砂轮 (代号 1)

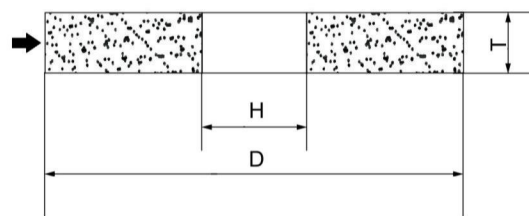




橡胶导轮无心磨 Rubber Control & Centreless

形状代号	直径	厚度	孔径	材质	粒度	硬度	组织号	转速
Type Code	OD	T	H	Grit	Grain	Hardness	Structure	Speed
1; 7;	200mm	100mm	75mm	A WA AA 38A	F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s
	250mm	125mm	127mm					35m/s
	300mm	150mm-350mm	127mm					40m/s
	350mm	125mm-250mm	127mm					45m/s
	400mm	100mm-380mm	203mm					50m/s
	500mm	100mm-200mm	305mm					60m/s

平行砂轮 (代号 1)



双面凹砂轮 (代号 7)

