

## TECHNICAL INFORMATION

# Speeds for grinding tools

GRINDING AND POLISHING  
(with bonded tools)

		Recommended cutting speed $v_c$ (m/s)							
		5	10	20	30	40	50	63	80
Tool diameter (mm)	2	47,700	95,500	191,000	286,500	382,000	477,500	601,600	763,900
	3	31,800	63,700	127,300	191,000	254,600	318,300	601,600	509,300
	4	23,900	47,700	95,500	143,200	191,000	238,700	300,800	382,000
	5	19,100	38,200	76,400	114,600	152,800	191,000	240,600	305,600
	6	15,900	31,800	63,700	95,500	127,300	159,200	200,500	254,600
	8	11,900	23,900	47,700	71,600	95,500	119,400	150,400	191,000
	10	9,500	19,100	38,200	57,300	76,400	95,500	120,300	152,800
	13	7,300	14,700	29,400	44,100	58,800	73,500	92,600	117,500
	20	4,800	9,500	19,100	28,600	38,200	47,700	60,200	76,400
	25	3,800	7,600	15,300	22,900	30,600	38,200	48,100	61,100
	32	3,000	6,000	11,900	17,900	23,900	29,800	37,600	47,700
	40	2,400	4,800	9,500	14,300	19,100	23,900	30,100	38,200
	50	1,900	3,800	7,600	11,500	15,300	19,100	24,100	30,600
	60	1,600	3,200	6,400	9,500	12,700	15,900	20,100	25,500
	80	1,200	2,400	4,800	7,200	9,500	11,900	15,000	19,100
	100	1,000	1,900	3,800	5,700	7,600	9,500	12,000	15,300
		Speed (rpm)							