

# NORTON DIAMOND / CBN STOCK WHEELS

SIZE (D x T x H)	SPECIFICATION	PART #
<b>Type 1A1 Straight – Diamond (cont'd)</b>		
6 x 3/8 x 1-1/4	ASD120-R75B99-1/4	69014192773
	ASD150-R75B99-1/4	69014191695
	SD150-R100B99-1/4	69014191696
6 x 1/2 x 1-1/4	ASD120-R75B99-1/4	69014192777
	ASD150-R75B99-1/4	69014191698
	ASD220-R75B99-1/4	69014192779
	ASD320-R75B99-1/4	69014192780
	SD120-R100B99-1/4	66260273557
	SD150-R100B99-1/4	66260273561
	SD180-R100B99-1/4	69014191700
7 x 1/4 x 1-1/4	ASD150-R75B99-1/4	69014191701
	SD100S-R100B99-1/4	69014192210
	SD120-R100B99-1/4	66260273566
	SD150-R100B99-1/4	69014191703
	SD180-R100B99-1/4	69014191704
	SD220-R100B99-1/4	69014191705
7 x 3/8 x 1-1/4	SD120-R100B99-1/4	69014191849
	SD220-R100B99-1/4	69014191852
7 x 1/2 x 1-1/4	ASD100-R75B99-1/4	69014192211
	ASD150-R75B99-1/4	69014191853
	ASD180-R75B99-1/4	69014192212
	SD120-R100B99-1/4	69014191854
	SD150-R100B99-1/4	69014191855
	SD180-R100B99-1/4	69014191856
	SD220-R100B99-1/4	69014191857
	SD150-R100B99-1/4	66260273574
8 x 1/2 x 1-1/4	ASD120-R75B99-1/4	69014192305
10 x 1/2 x 3	ASD180-R100B99-1/4	69014192306
	ASD150-R75B99-1/4	69014192310
12 x 1/2 x 3	ASD150-R75B99-1/4	69014192311
12 x 1/2 x 5	ASD150-R75B99-1/4	69014192311
12 x 1 x 3	ASD120-R75B99-1/4	69014192312
12 x 1 x 5	ASD120-R75B99-1/4	69014192313
14 x 1/2 x 5	ASD150-R75B99-1/4	69014192314
14 x 1 x 5	ASD120-R75B99-1/4	69014192316
20 x 1 x 12	ASD120-R75B99-1/4	69014192325

Standard Package = 1 wheel

SIZE (D x T x H)	SPECIFICATION	PART #
<b>Type 1A1 Straight – cBN</b>		
6 x 1/8 x 1-1/4	CB120-TB99-1/4	66260273601
6 x 1/4 x 1-1/4	CB120-TB99-1/4	66260273605
6 x 1/2 x 1-1/4	CB120-TB99-1/4	66260273607
7 x 1/4 x 1-1/4	CB120-TB99-1/4	69014192021
7 x 1/2 x 1-1/4	CB120-TB99-1/4	66260273567
12 x 1/2 x 5	CB150-TB99-1/4	66260273560
12 x 1 x 5	CB150-TB99-1/4	66260273562
<b>Type 1A1R Cut-Off – Diamond</b>		
3 x .020 x 1/2 (ME104177)	M4D150-N50M99-1/8	69014192060
4 x .012 x 1/2 (ME104180)	M4D180-N75M99-1/8	69014192063
4 x .020 x 1/2 (ME104180)	M4D220-N75M99-1/8	69014192064
4 x .030 x 1/2 (ME104180)	M4D220-N100M99-1/8	69014192067
4 x .030 x 1/2 (ME104180)	M4D150-N75M99-1/8	69014192068
4 x 1/32 x 3/4 (ME43570)	SD100S-R100B99-1/4	69014192151
4 x 1/32 x 1-1/4 (ME43570)	SD120-R100B99-1/4	69014191706
5 x .015 x 1/2 (ME104180)	SD100S-R100B99-1/4	69014192152
6 x .017 x 1-1/4 (ME104180)	M4D220-N100M99-1/8	69014192070
6 x .025 x 1-1/4 (ME104180)	M4D150-N100M99-1/8	69014192082
6 x .035 x 5/8 (ME104177)	M4D220-N100M99-1/8	69014192083
6 x .035 x 5/8 (ME104177)	M4D150-N100M99-1/8	69014192086
6 x .035 x 1-1/4 (ME43572)	M4D100-N75M99-1/8	69014192088
	SD100-R75B99-1/4	69014192155
	ASD100S-R100B99-1/4	69014192158
	ASD120-R100B99-1/4	69014192159
	SD100-R100B99-1/4	69014191858
	SD100S-R100B99-1/4	69014192156
	SD220-R100B99-1/4	69014192157

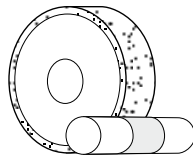
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**NEW!** See page 305 for Norton Thrifline stock wheels, engineered at low initial cost, for small volume operations.

## TECH TIP

Cylindrical grinding applications – 1A1 wheels:

- Includes all outside grinding of round parts, even though the finished product is not always a true cylinder.
- Infeed at both ends of the traverse to keep wheel face flat.
- Use work supports to prevent deflection.
- Rough grinding traverse speed should be 1/2 to 2/3 of the thickness of the wheel per work revolution.
- Finishing grinding traverse speed should be 1/2" or less per work revolution.

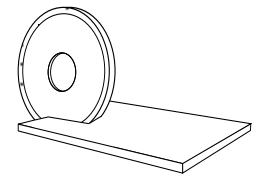


It is the user's responsibility to refer to and comply with ANSI B7.1

## TECH TIP

Cut-off applications – 1A1R wheels:

- Use the largest diameter flanges possible
- Use flanges of equal diameter
- Use the thickest wheel possible for increased stiffness and straightness of cut



cBN wheels are used on hardened steels. Diamond wheels are used to cut or slot carbide, glass or ceramic parts.



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## TECH TIP

Diamond Grinds:

- Cemented carbide
- Glass
- Ceramics
- Fiberglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

cBN Grinds:

- High-speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hard stainless steel
- Abrasion-resistant ferrous materials

## Can't Find Your Specification Here?

Review this stock section first. If you can not find the specification you need:

- Then refer to the brief descriptions of our B99 Express and CNC lines (following this section)
- See the more in-depth B99 Express product availability in our "Diamond and cBN Superabrasives Standard Catalog" #8068 on [www.nortonabrasives.com](http://www.nortonabrasives.com) or contact your Norton representative for a complete listing of Norton made-to-order superabrasive products.