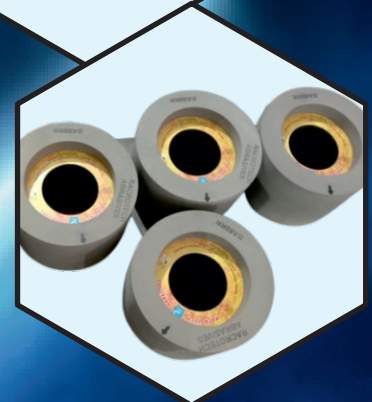
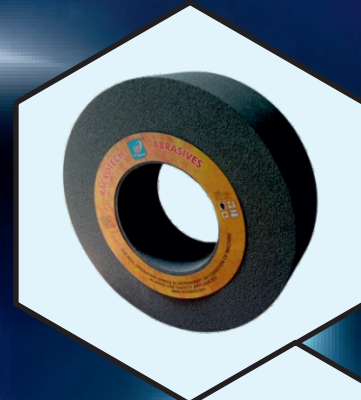
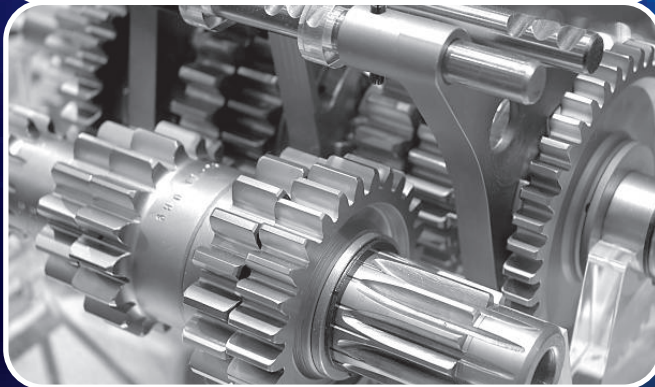
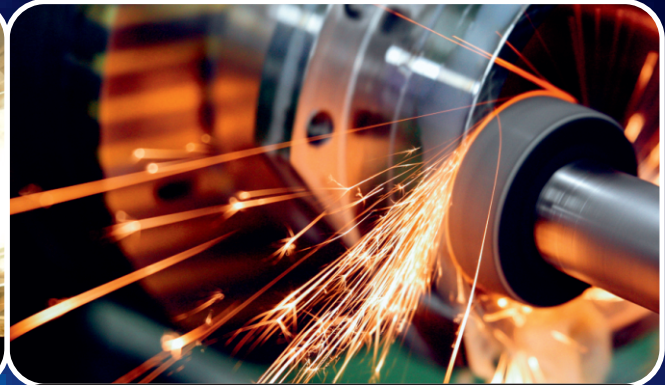




AN ISO 9001 : 2015 Certified

# RACROTECH ABRASIVES

*" A Leading Supplier of Bonded Abrasives "*



**GRINDING ATTITUDE**

# About Us

*The founder of "RACROTECH" brand has more than 15 years of excellent experience in the industry. He along with his group dedicated to provide rich quality at lowest price collided with superior service for Vitrified Bonded/Resinoid Bonded/Rubber Bonded Grinding Wheel and Abrasives Items.*

*Company having experienced technical team in relevant field to provide new development as per customer requirement and market demand with upgrade of technology*

*Their company aims at serving as many customer possible and an economical revolution considering the present industrial situation other than aiming only at the profit.*

*Employees have been trained by leaders in the field, they adopt time tested proven process method.*

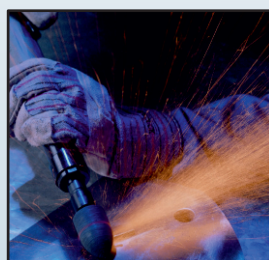
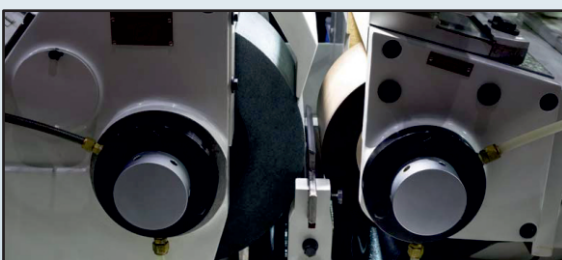
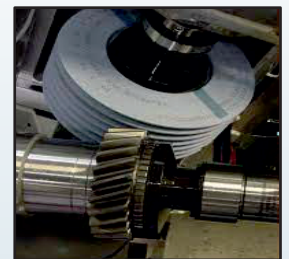
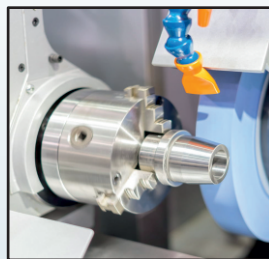
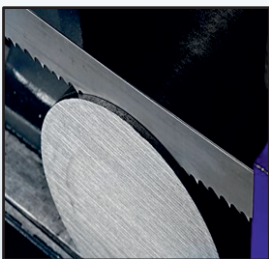
*In very short period of time, company has build dealer's / distributor network and direct end user across india.*

# Mission

*To Serve as many customers as possible with good quality Abrasive products.*

# Vision

*To evolve into an international Abrasive market.*



# Overview

## Symbols

### For Example

1	1100	x	40	x	305	WA	F60	K	7	V	35m/s
Type Code	Diameter	Thickness	Hole	Abrasive	Grit No.	Hardness	Structure No.	Bond	Max Linear Velocity		
1	150	3	12.7	A	F16	Soft					
2	200	6	19.05	WA	F24	G	0				
3	250	8	25.4	AA	F30	H	1		20m/s		
4	300	10	31.75	38A		J	2	V	25m/s		
5	350	13	32	PA	Coarse	K	3		32m/s		
6	400	20	38.1	25A	F36	L	4		35m/s		
7	450	25	50.8	SA	F46	M	5		40m/s		
8	500	32	75	MA		N	6				
11	600	40	76.2	GC	Medium	P	7				
12a	610	50	101.6	C	F60	Q	8	B			
12b	750	75	127	RA	F80	R	9		45m/s		
20	810	100	203	DA	F100	S	10		50m/s		
23	900	150	203.2	9A	F120	T	11		60m/s		
26	915	200	254	RA		Y	12		70m/s		
38	1066	250	304.8	64A	FINE	Hard	13	R			
39	1100	300	305	55A			14				

## Abrasives

Code	Type	Application
A	Brown Aluminum Oxide	It is use for ordinary grinding, cutting and freedom grinding of carbon steel, alloy steel, malleable cast iron, hard bronze.
WA (38A)	White Aluminum Oxide	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)	Pink Aluminum Oxide	It is suitable for grinding alloy steel, tool steel, chilled steel, gears, profiling and instrument rack.
SA	Microcrystalline Aluminum Oxide	It is suitable for grinding high speed steel, austenitic stainless steel, high speed steel, titanium alloy and high hardness and strength workpieces.
MA	Microcrystalline Aluminum Oxide	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	Green silicon carbide	It is suitable for grinding or cutting hard alloy (carbide trips), glass, gem, stone, ceramics etc.
C	Black silicon carbide	It is suitable for grinding or cutting cast iron, non-ferrous or non-metal material etc.



## Grit No.

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.

Grit	Application	Surface Roughness
F-12-F24	Used for snagging, rough grinding or cutting etc.	
F-30-F46	Used for common coarse grinding	-1.8 m
F-60-F100	Used for Precision fine grinding	1.6-0.2 m
F-120-F20	Used for lapping polishing and threading grinding etc.	0.2-0.1 m
W20	Used for mirror grinding and very fine polishing	0.1-0.012 m



## Hardness

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

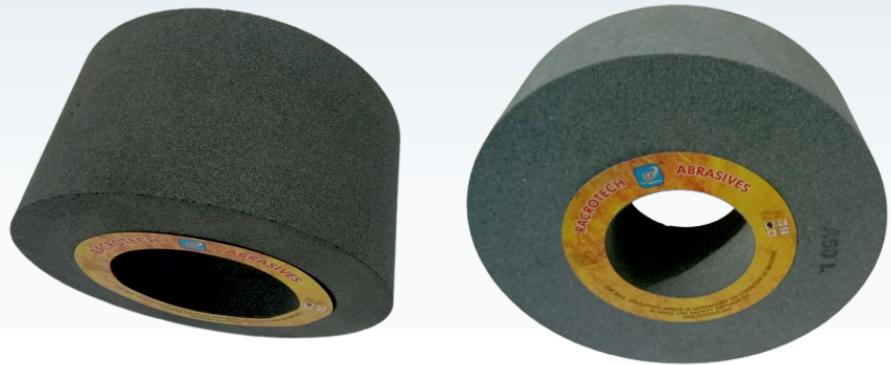
1. Generally, the grinding wheels in soft hardness are used for cutting harder work pieces, whereas the wheels in a bit higher hardness are used for cutting soft work pieces.
2. In the process of grinding, when the contact surface between workpiece and grinding wheel is big or feed amount is big grinding 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 grinding the work pieces 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.

Hardness	Softer			Soft		Medium		Hard			Harder		Extrahard
	1	2	3	1	2	1	2	1	2	3	1	2	
Code	G	H	J	K	L	M	N	P	Q	R	S	T	Y

## Structure No.

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.

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



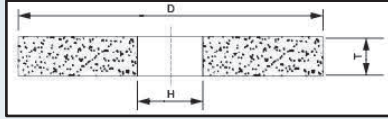
## Max Operating Speed

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 over speed.
2. the air pressure of the air tool need to keep stable, otherwise it is easy to cause grinding wheels over speed and broken.
3. when you place order to us. pls mention the speed m/s. otherwise we will produce as 35m/s.

Diameter	MaxLinear Velocity ( m/s)							
	mm	30m/s	35m/s	40m/s	45m/s	50m/s	60m/s	70m/s
Inch								
4	100	5730	6684	7636	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

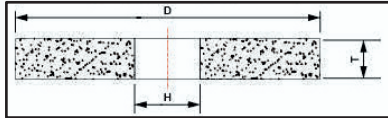
## General Purpose Grinding

RACROTECH ABRASIVES 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.



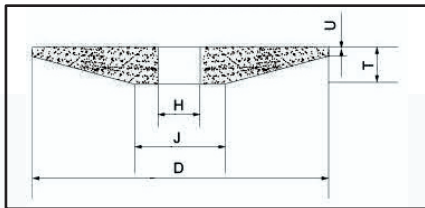
OD	T	H	Grit	Grain	Hardness	Structure	Speed
50mm	6-20mm	12.7mm	A WA AA 38A 25A PA SA GC C	F24 F36 COARSE F46 F54 MEDIUM F60 F80 FINE F100 F120 F150	H J K L M N O P Q R S T Y	4 5 6 7 8 9	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
100mm	6-25mm	19.05mm					
	6-25mm	25.4mm					
	6-25mm	31.75mm					
	6-25mm	32mm					
	6-50mm	38.1mm					
		50.8mm					
	10-55mm	75mm					
		127mm					
	32-63mm	38.1mm					
	32-75mm	50.8mm					
	32-100mm	75mm					
	32-125mm	127mm					
		203mm					

## Bench Grinder Grinding

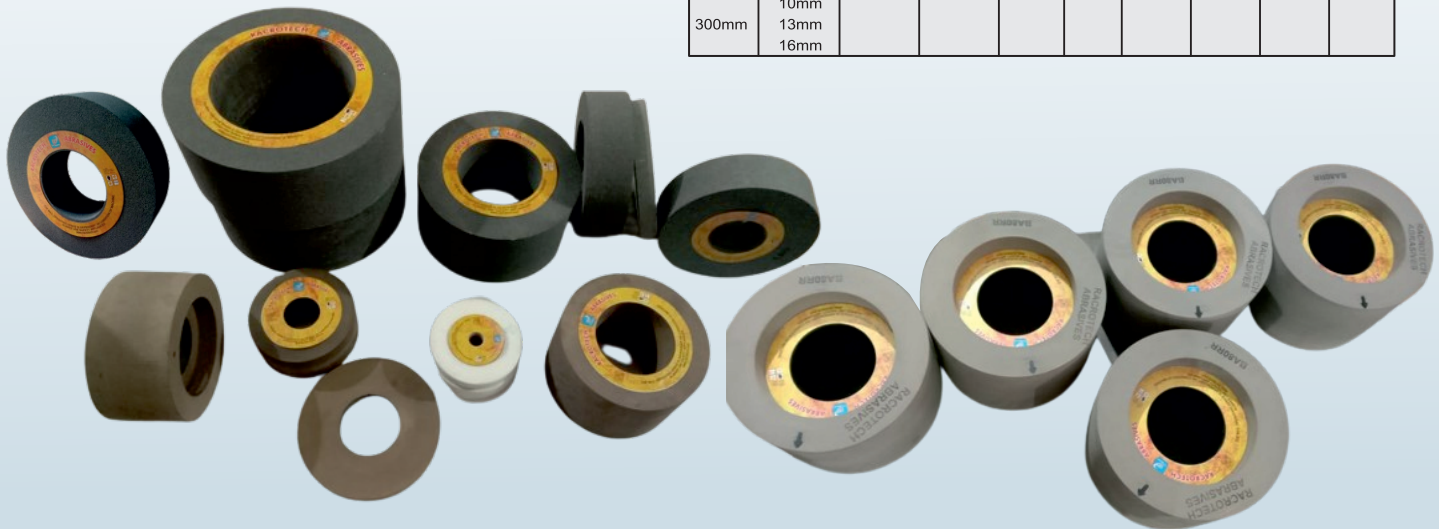


OD	T	H	Grit	Grain	Hardness	Structure	Speed
100mm	12mm	12.7mm	A				
125mm	13mm	15.88mm	WA	F36	K	5	33m/s
150mm	20mm	19.05mm	AA	F46	L	6	35m/s
175mm	25mm	20mm	38A	F54	M	7	40m/s
180mm	32mm	25.4mm	25A	F60	N	8	45m/s
200mm	38.1mm	31.75mm	PA	F80	P	9	50m/s
300mm	40mm	32mm	SA	F100	Q	10	60m/s
350mm	50mm	38.1mm	GC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

## Saw Gumming Grinding

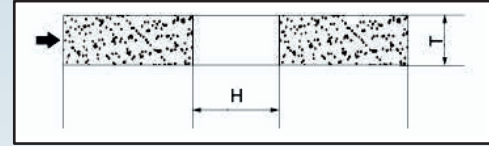
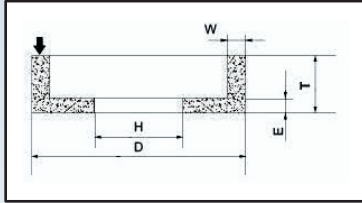


OD	T	H	J	U	Grit	Grain	Hardness	Structure	Speed
125mm	6mm	12.7mm 19.05mm 20mm 25.4mm 31.75mm 32mm	57mm 299mm	2mm 3mm 4mm	A WA AA 38A 25A PA SA GC	F60 F80 F100 F120	P Q R S	1 2 3 4 5 6	33m/s 35m/s
	8mm								
	10mm								
150mm	6mm								
	8mm								
	10mm								
175mm	6mm								
	8mm								
	10mm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



## Tool Room Grinding

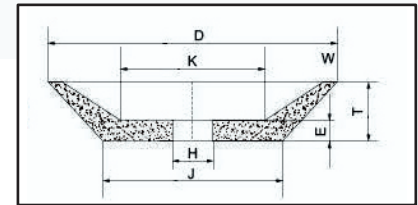
RACROTECH ABRASIVES Tool Room Grinding mainly used for sharpening milling cutter, drills, slotting cutters etc. the characters of reasonable and homogeneous structure, strong cutting performance, and not burning workpieces.



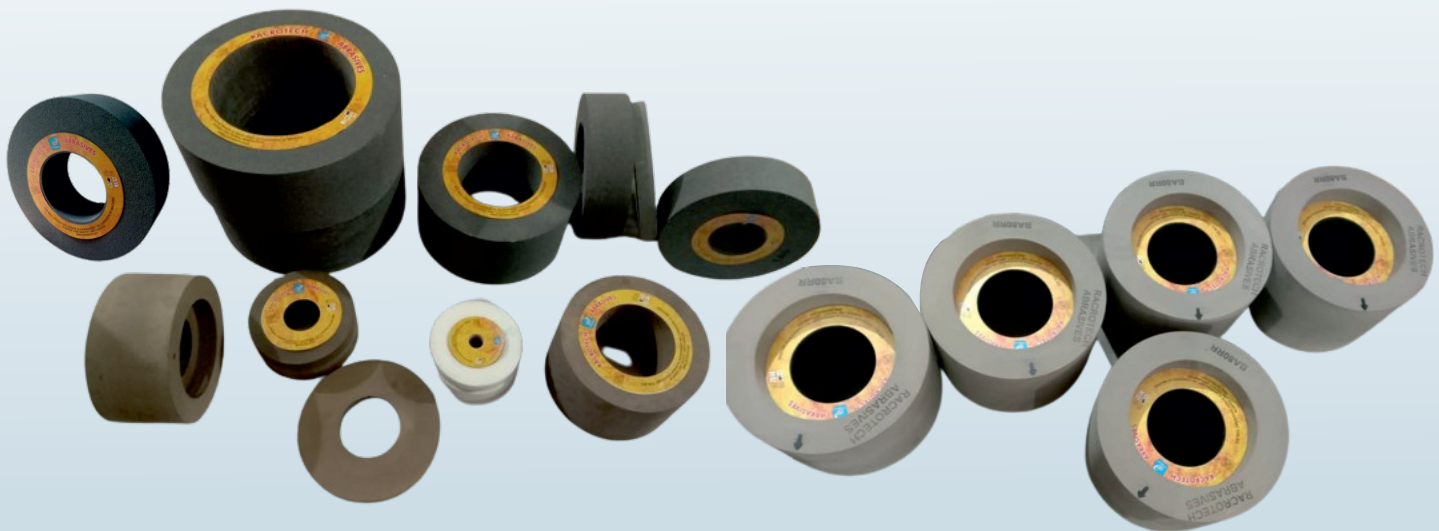
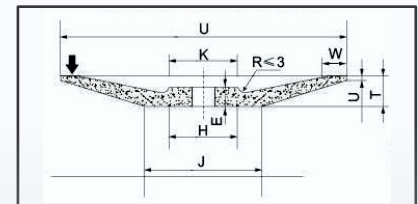
OD	T	H	W	E	R	Grit	Grain	Hardness	Structure	Speed
75mm	40mm	25.4mm	4mm	8mm						
100mm	50mm	31.75mm	13mm	10mm		A	F46	H		
125mm	63mm	25.4mm	20mm	13mm		WA	F54	J	5	33m/s
150mm	63mm	31.75mm	12.5mm	13mm	3	AA	F60	K	6	35m/s
	80mm		15mm	4	38A	F80	L	7		
200mm	63mm	75mm	13mm	15mm	5	25A	F100	M	8	
	100mm	100mm	20mm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

OD	T	H	Grit	Grain	Hardness	Structure	Speed
100mm	3-25mm	12.7mm	A	F46	H		
150mm	3-25mm	19.05mm	WA	F54	J	5	33m/s
		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		

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



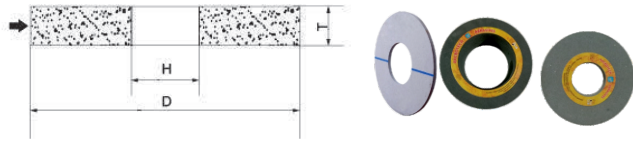
OD	T	H	K	J	W	U	E	Grit	Grain	Hardness	Structure	Speed
75mm	8mm	13mm	30mm	30mm	4mm	2mm	5mm					
100mm	10mm	20mm	40mm	40mm	6mm	2mm	6mm	WA	F46	H	5	33m/s
125mm	13mm	31.75mm	50mm	50mm	6mm	3mm	8mm					
150mm	16mm		60mm	60mm	8mm	4mm	10mm	200mm	38A	F60	K	7
200mm	20mm	80mm	81mm	10mm	4mm	12mm	250mm					
300mm	20mm	127mm	103mm	13mm	6mm	15mm	4mm	25A	F100	M	8	
350mm	25mm		180mm	193mm	25mm	18mm						
400mm	25mm	291mm	35mm	6mm	24mm							



## Flat Surface Grinding

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.

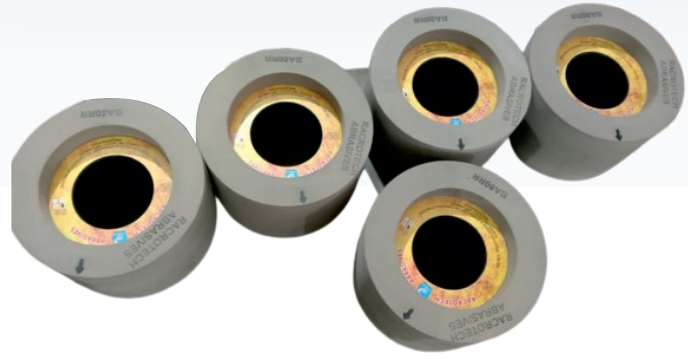
OD	T	H	Grit	Grain	Hardness	Structure	Speed		
150mm	13mm	31.75mm 32mm	A WA AA 38A 25A PA SA GC	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s		
200mm	13mm 20mm 25mm								
250mm	16mm 20mm 25mm 32mm								
300mm	20mm 25mm 32mm 40mm 50mm	75mm 127mm 203mm			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



## Centreless Grinding

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

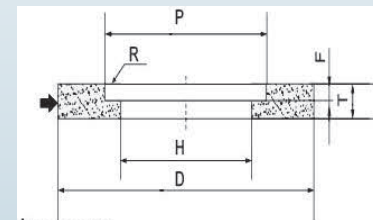
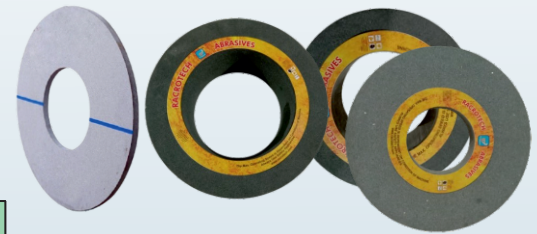
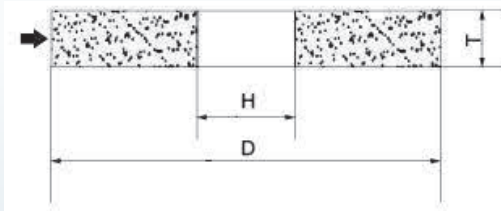
Type Code	OD	T	H	P	F	R	Grit	Grain	Hardness	Structure	Speed
1 5 7	300mm	100mm-125mm	127mm	190mm	10mm 16mm 20mm 25mm	5mm 8mm	A WA AA 38A 25A PA SA GC C	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
	350mm		150mm-150mm	152.4mm							
	400mm	100mm-250mm	203mm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



## Cylindrical Grinding

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

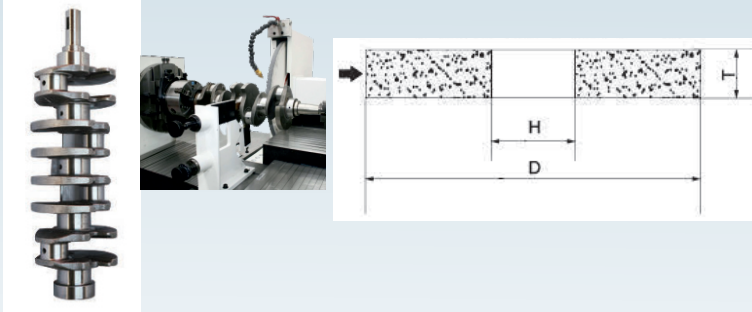
OD	T	H	Grit	Grain	Hardness	Structure	Speed
250mm	20mm-40mm	75mm 76.2mm 127mm	A WA AA 38A 25A PA SA GC C	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
300mm	20mm-63mm	75mm 76.2mm 127mm					
350mm	25mm-63mm	127mm					
400mm	32mm-80mm	127mm 203mm 203.2mm				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



OD	T	H	P	F	R max	Grit	Grain	Hardness	Structure	Speed	
300mm	40mm 50mm	76.2mm	150mm	13mm	3.2	A	F36	K	5	33m/s	
350mm		127mm	190mm	13mm							
400mm	40mm-80mm	127mm	215mm	13mm	5	WA	F46	L	6	35m/s	
450mm		203mm	215mm	13mm		25mm	38A	F54	M	7	40m/s
500mm		203.2mm	215mm	13mm		25mm	25A	F60	N	8	45m/s
600mm	80mm-100mm	203mm	400mm	13mm 25mm 50mm	8	PA	F80	P	9	50m/s	
750mm		304.8mm				305mm	GC	F120	Q	10	60m/s
750mm	63mm-100mm	305mm	C	F120							

## Crankshaft & Cam Shaft Grinding

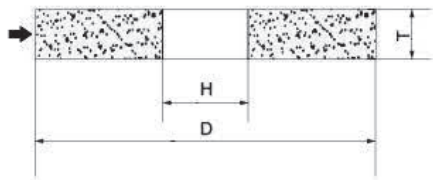
The wheels are mainly used for grinding all kinds of crankshafts and camshafts of auto, tractor motorcycle, ship engine as well as transport machinery etc. Our wheels have uniform Structure and hardness, out of balance performance, and cost performance etc.



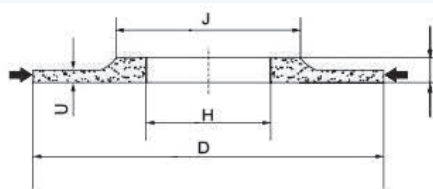
OD	T	H	Grit	Grain	Hardness	Structure	Speed
500mm	16mm-55mm 55mm-90mm	127mm 203mm 203.2mm 304.8mm 305mm	A	F36 F46 F54 F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	33m/s 35m/s 40m/s 45m/s 50m/s 60m/s
600mm			WA				
610mm			AA				
635mm			38A				
660mm			25A				
700mm			PA				
710mm			SA				
750mm			GC		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



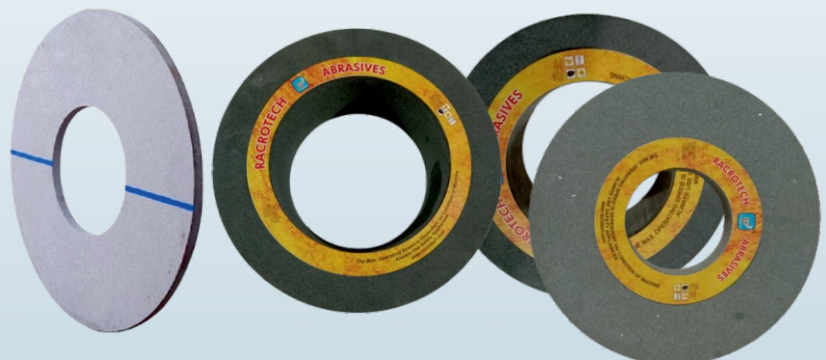
## Bearing Grinding



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



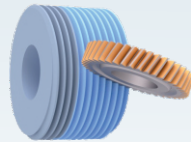
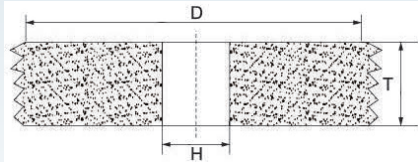
OD	T	H	J	U	Grit	Grain	Hardness	Structure	Speed
500mm	16mm	305mm	350mm	6mm	A WA AA 38A SA	F60 F80 F100 F120	K L M N P Q	5 6 7 8 9 10	35m/s 40m/s 45m/s 50m/s 60m/s
	20mm			8mm					
				10mm					
	600mm			20mm					
10mm									
25mm				13mm					
				16mm					



## Worm Grinding Wheels

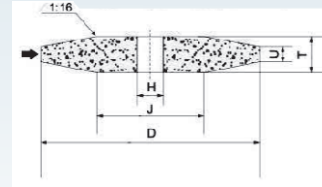
The wheels are mainly used for grinding spur gear, helical gear, conical gear, slotting cutter, shaving cutter, etc.

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



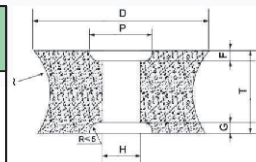
## Gear Grinding

OD	T	H	U	Grit	Grain	Hardness	Structure	Speed
	13mm 16mm 20mm	20mm 31.75mm 32mm	4mm 6mm	A WA AA 38A 25A				
	13mm 16mm			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
	10mm-25mm	75mm	11mm					
	20mm 25mm 32mm		6mm					
	32mm	127mm						
	32mm							
	32mm-90mm							



## Needle Grinding

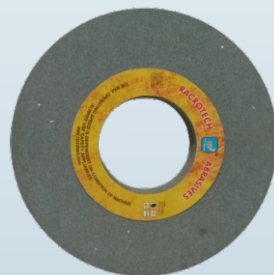
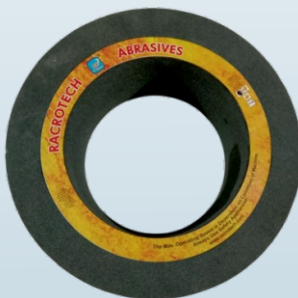
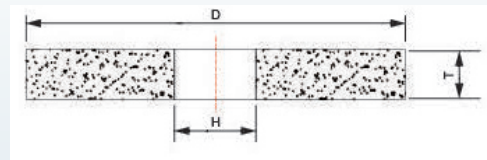
OD	T	H	P	F=G	R	Grit	Grain	Hardness	Structure	Speed
400mm	150mm	100mm	170mm	25mm	150mm	A WA AA 38A	F46 F54 F60	K L M N	5 6 7 8	33m/s 35m/s 40m/s 45m/s
450mm	200mm	150mm	225mm	25mm	200mm	25A PA SA	F80 F100	P Q	9 10	50m/s 60m/s



## Roll Grinding

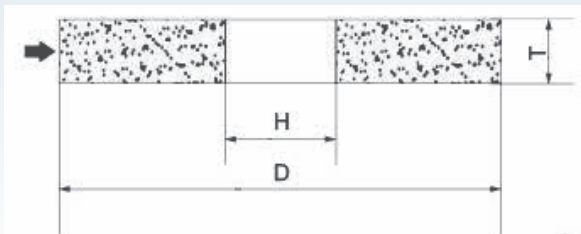
The wheels widely used in steel factory for all kinds of hot-roll, cold-roll steel sheets, stainless steel plate and strip and metal rolls in papermaking industry. the wheels has high strength, uniform structure and hardness, high efficiency etc.

OD	T	H	Grit	Grain	Hardness	Structure	Speed	Bond
450mm-600mm	50mm-63mm							
750mm	63mm-150mm	203mm	A WA AA	F36 F46 F54	H I J	5 6 7	33m/s 35m/s 40m/s	V B
800mm	100mm	203.2mm	38A	F60	K	8	45m/s	
900mm 915mm	63mm-150mm	304.8mm	25A	F80	L	9	50m/s	
		305mm	PA	F100	M	10	60m/s	
1066mm	63mm-125mm	508mm	SA GC C	F120	N			



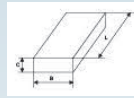
## Internal (Bore) Grinding

OD	T	H	Grit	Grain	Hardness	Structure	Speed
6mm-40mm	16mm	20mm	A	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
32mm-50mm							
6mm-63mm							
8mm-50mm							
10mm-63mm							
32mm-120mm							
63mm-120mm	20mm 31.75mm 32mm	GC					



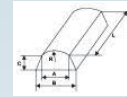
## Segments

3101- BXCXL (mm)



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

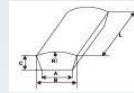
3109- B/AXCXL(mm)



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

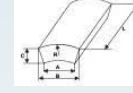
3102- B/AXCXL(mm)

B	A	C	R	L
110	85	38	230	150



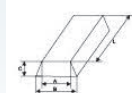
3103- B/AXCXL(mm)

B	A	C	R	L
115	80	45	250	150



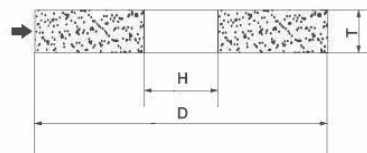
3104- B/AXCXL(mm)

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



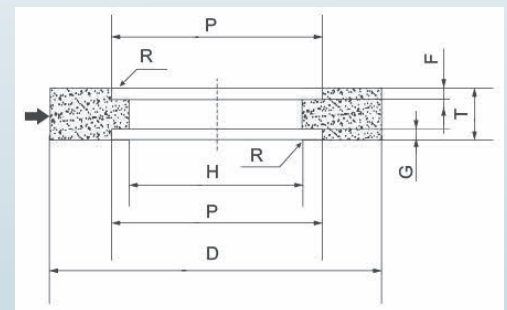
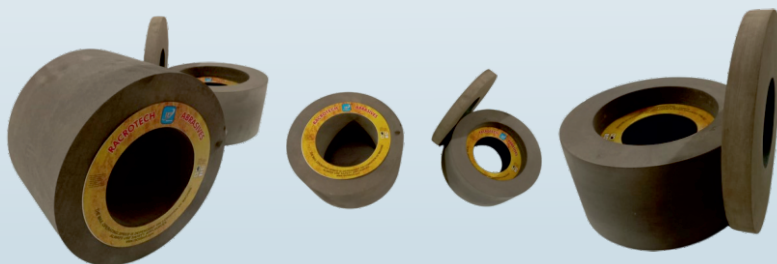
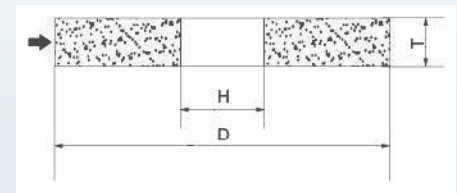
## Resin Bonded Snagging Wheels

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



## Rubber Control & Centreless

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 35m/s 40m/s 45m/s 50m/s 60m/s
	250mm	125mm	127mm					
	300mm	150mm-350mm	127mm					
	350mm	125mm-250mm	127mm					
	400mm	100mm-380mm	127mm					
	500mm	100mm-200mm	305mm					



# STICKS & STONES

## Dressing sticks

- Dressing sticks are used for truing and dressing bench and pedestal grinding wheels to keep grinding wheel sharp and running smoothly.
- RACROTECH dressing sticks are extensively used in glass industry for cleaning and conditioning.
- Dressing sticks are available in silicon carbide and white aluminium oxide.

### FEATURES

- Free cutting and load resistant.
- Advanced fine grit technology for precision applications.
- Customization is possible to meet special dressing applications.



## Honing Sticks

- Honing is the finishing of internal dimensions of automobile cylinder heads and other components when an excellent and accurate finish is required.
- Honing is generally performed with square, rectangle or specially shaped sticks or blocks.
- Certain honing sticks, particularly when used for steel, are treated with sulphur to increase stick life and prevent loading.

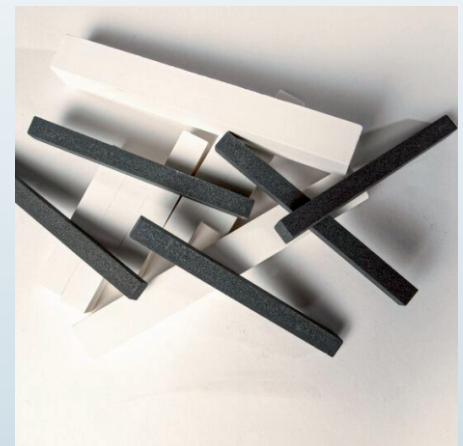


Application

### Recommendation

Material	Grading
Cast iron	C150 L V4
Carbon steel	AA150 L V18N (S)
Steel & Nitrally	AA150 H V18N (S)
Bearing steel	C180 N V4

(S) Indicates sticks treated with sulphur



## Internal Grinding Wheels

- Internal grinding wheels are used in production of precision components demanding a highly accurate geometry and surface.
- RACROTECH internal grinding wheels are available in sharp aluminium oxide grains for excellent cutting actions.

### International Range

#### FEATURES

- High performance abrasive grain
- Reduction in grinding cycle, Reduction in dressing frequency
- Superior surface finish, Dimension accuracy

Professional Grade	Premium Grade	International Grade
DA60/80 I7 VR10	PAA60 K5 VR10	MCA80 K8 VR10
AA80 I7 V615	PA60 I5 V15	3CG80 K7 VR10
DA80 J7 V615	PA90 J5 V615	3CG46 I8 V615

### Premium Range

#### FEATURES

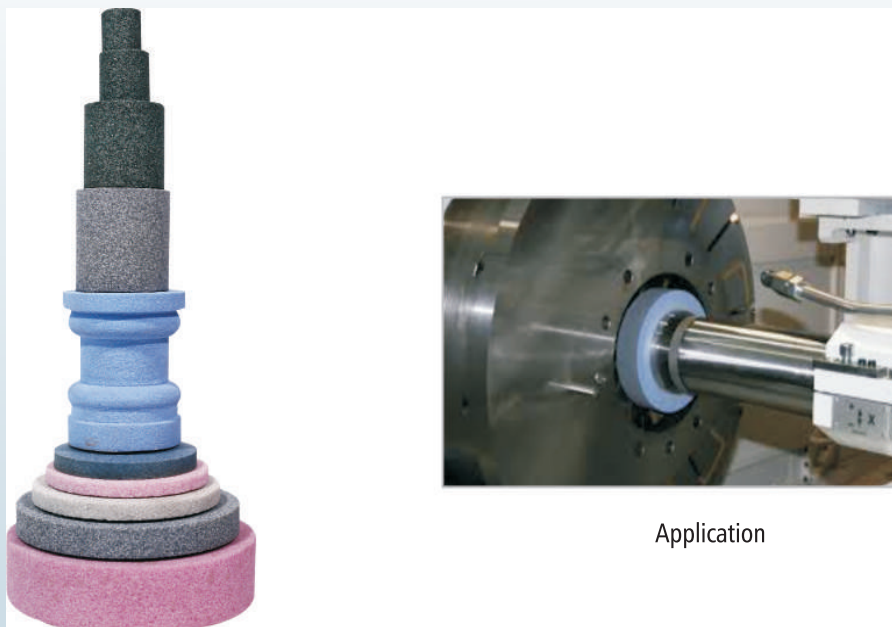
- Fast cutting, Good form retention
- Good surface finish

### Typical Application

- Bearing
- Small Cylinder
- Compressor parts
- Injection nozzle parts
- Gear parts
- Hydraulic Cylinder
- Tappets
- Connecting rods

#### Common Sizes (In mm)

13 X 13 X 6.35
20 X 20 X 6.35
20 X 25 X 6.35
25 X 25 X 6.35
40 X 20 X 12.7
50 X 40 X 12.7



Application

## F-TYPE WHEELS

- Disc grinding is the production of flat surfaces by presenting the work piece to the wheel face in horizontal or vertical spindle machines.
- In double disc grinders, opposite and parallel surfaces are ground flat at high rates of production providing good surface finish. RACROTECH offers specially designed disc grinding wheels with special bond systems, which is the best in India.
- Suitable for machines like Gardner, Besley, Diskus, Foldage, Nippie, Modular, Parivartan, OMD, Bennet, Rolland, Nissie, Daisho etc.

### International Grade

#### FEATURES

- High performance abrasive grains.
- Efficient cutting action on all types of material.
- Able to take more depth of cut, Lower threshold power, Superior surface finish.
- Highest productivity, Lowest grinding cost per component.

Application	Professional Grade	Premium Grade	International Grade
-------------	--------------------	---------------	---------------------

#### Bearing Industries

Bearing Ring	AA80 J8 BR	A80 J8 BR	CG80 J8 BR / 24A60 J5 BR
Bearing Roller	A60 J5 BR	AA60 J5 BR/	73A60 J5 BR

#### Automotive Industries

Connecting Rod	AA60 K5 BR	73A60 L5 BR	3CG60 K5 BR
Piston Ring	C60 K8 BR	GC60 K8 BR	1CG/GC K8 BR
Spring	A24 P7 BR	FSP24 P7 BR	3CG24 L7 BR
Disc brake		FSP46 H+8 BR75	2CGF46 H+8 BR75
Valve Plate	AA54 N5 BR	FSW46 N5 BR	73A46 N5 BR
Washer	DA60 N4 BRM	AA60 J8 BR	73A60 J8 BR
Piston Ring	C40 O BR	C60 L6 BR706	74A70 J8/K8 BR33



Spring



Bearing



Piston Ring

### Premium Grade

#### FEATURES

- Sharp, durable abrasive grains.
- Exceptional part integrity & quality.
- Able to grind large contact area.

#### Common Sizes (In mm)

350 X 65 X 25.4	585 X 65 X 19.05	660 X 90 X 12.7/25.4
355 X 52 X 110	585 X 65 X 250	660 X 90 X 300
400 X 65 X 75	585 X 75 X 195	750 X 60 X 38
450 X 65 X 150	600 X 65 X 300	750 X 70 X 350
450 X 80 X 151	600 X 80 X 20	760 X 75 X 19
450 X 80 X 40	660 X 75 X 480	762 X 75 X 25.4
500 X 65 X 140	660 X 76.2 X 12.7	810 X 65 X 280
500 X 75 X 300		



Application

# SEGMENTS

- Segments are generally used on rotary table surface grinding machines. RACROTECH provides wide range of all purpose shapes, sizes and specifications of segments which are composed with selected abrasives in grits, grades, structures and best system to match any material removal or surface finish requirement from precision tool room grinding to bonding uneven surface production jobs.
- Suitable for machines like Blanchard, Churchill and John Land, Lumsden, Mattison, Gusti, WMW, TOS, Camut, Snow, Gockel, Reform, HMT, Atlas etc.

## International Grade

### FEATURES

- High performance ceramic abrasive grains.
- High performance ceramic bond and induced porosity.
- Fast and cool cutting, No burn on parts.
- Long segment life.

## Premium Grade

### FEATURES

- High performance abrasive grains
- Fast metal removal, Induced porosity
- Long life

Application Grade	Professional Grade	Premium Grade	International Grade
Valve plate	AA54 K5 BR	PAA54 K5 BR	2CG301 F16 VR8
Connecting rod	AA46 H8 V18P	PAA36 H8 V18P	3CG24-2 E12 V32
Disc brake	GC80-2 I4 BR	FSG80-2 I4 BR84	3CG24-2 E12 V32
High chrome casting	AA30 G12 VTR	PAA30 G12 VTR	3CG24-2 D12 V32
Jaw plates	AA30 O5BR	SFP60 N+4 BR60	2CG30 O4 BR60
Industrial knife	AA46 I5 VR8	PAA45 I5 VR8	2CG46 I8 VR8
Tool bit	AA46 G5 VLT	PAA46 G5 VLT	2CG46 G5 VLT

## Common Sizes (In mm)

285.75 X 57.15 X 152.4	117.48 X 73.025 X 247.65	90 X 50/45 X 16	60/65 X 20 X 65
285.75 X 57.15 X 203.2	152.4 X 152.4 X 100	125/85 X 35 X 140	84/80 X 24 X 120
127 X 38.1 X 200	150 X 80 X 25	68/57 X 30 X 130	19.5 X 80 X 70
66.04/55 X 30.54 X 100	175 X 80 X 25	100 X 45/50 X 16	150 X 80/71 X 25
103/94 X 38 X 180	103.19/84.14 X 38.1 X 152.4	305 X 222/130 X 95	74.61/61.91 X 90.48 X 50.8
57/65 X 25 X 105	203.2 X 84.14/103.19 X 38.10	107.16 X 44.45 X 25	125 X 60/25 X 15
100/85 X 40 X 150	185 X 62/56 X 20	118 X 40.50 X 200	64.3/38 X 20 X 60
152.4 X 84.14/103.19 X 38.10	87/103.5 X 38 X 200	110/90 X 45 X 200	222.25/155.58 X 76.2 X 304.8
103/94 X 38 X 180	173.03 X 38.1 X 127	100/85 X 38 X 200	92.08/68.27 X 24.05 X 142.08
70/64 X 25 X 150	170.06 X 45 X 46	117/88 X 45 X 200	120/80 X 44.5 X 200



# HYPODERMIC NEEDLE GRINDING WHEELS

- RACROTECH Hypodermic Needle Grinding Wheels are well established for grinding the tip of hypodermic needle (Human as well as Veterinary), which is made from stainless steel of various gauge pipes.
- RACROTECH wheels are designed in special grade having modified bond which gives higher output and burr-less finish.

## Recommendation

Category of Needle	Grading			
Veterinary needle	DA400 L5 BR	DA600 J/K5 BR		
Human needle	C600 K5 EFP	C800 K5 EFP	GC600 K5 EFP	GC800 K5 EFP

## Selection of grit size as per needle gauge (G)

	JIS	ANSI	FEPA
22G (0.8 mm)	GC800	GC500	GC400
23 to 25G (0.6 mm)	GC1000	GC600	GC500
25 to 26G (0.4 mm)	GC1200	GC800	GC600
26 to 30G (0.2 mm)	GC2000	GC1000	GC 800/1000

## Common Sizes (In mm)

350 X 50 X 127

400 X 100 X 127

450 X 50 X 127

450 X 75 X 203.2

450 X 80 X 127



# MOUNTED POINTS, PLUGS & CONES

- Mounted points are capable of reaching places inaccessible to larger types of grinding wheels. It can be used safely on high speed portable grinding machines.
- RACROTECH mounted points are available in various abrasives to suite every need of the end user.

## Typical Application

- Deburring
- Tool sharpening
- Removing metal marks and parting lines
- Finishing cavities
- Smoothing intricate profiles of castings, forgings
- Die Grinding.
- Grinding of steel rolling rolls

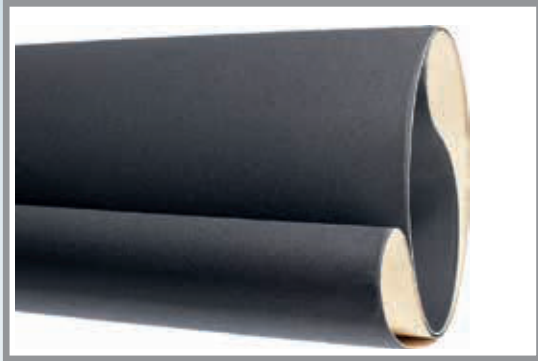
## Standard Spindles

- Type A - 6 and 6.35mm diameter
- Type B - 3, 6 and 6.35mm diameter
- Type W - 3, 6 and 6.35mm diameter



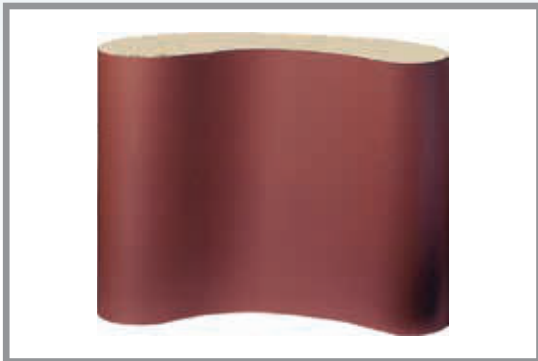
Applications

## WIDE BELTS



### SILICON CARBIDE WIDE BELTS

- Silicon Carbide, cloth /polyester backed wide belts are designed for high productivity and consistent finish
- Code product grit best suited for particle / chip boards, mdf, decorative laminates, SS coils
- **Code:** DCY 658
- **Grits:** 36, 40, 50, 60, 80, 100, 120, 150, 180, 220
- **Width:** 610 ~1350mm



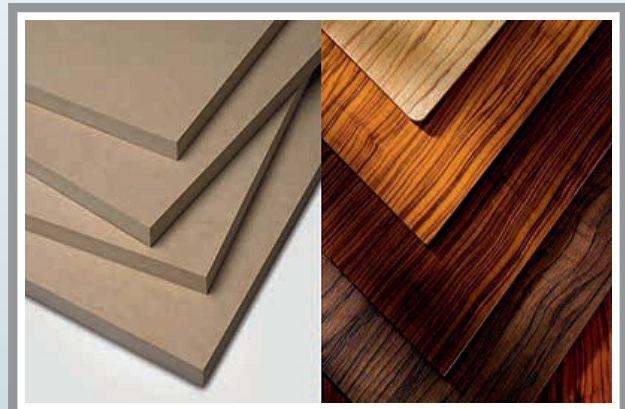
### ALUMINIUM OXIDE WIDE BELTS

- Aluminum oxide, cloth backed wide belts are designed for high productivity and consistent finish
- Best suited for plywood, solid wood boards, block boards
- **Code:** CC34X / CC44N/CP44N
- **Grits:** 36, 40, 50, 60, 80, 100, 120, 150, 180, 220
- **Width:** 610 ~1350mm



### ZIRCONIA WIDE BELTS

- Zirconia cloth /polyester backed wide belts are designed for high productivity and superior finish
- Best suited for ss coils, friction material, solid wood boards, sheet metal
- **Code:** BZP 628
- **Grits:** 36, 60, 80, 100, 120
- **Width:** 610 ~1350mm



# BI-METAL BAND SAW BLADES

Multi Purpose Blade for basic workshop cutting operations.

## Features:

- M42 HSS Tips
- Constant and Variable TPI available
- Positive, Neutral, Hook Tooth available

## Applications:

- Carbon Steel
- Structural Steel
- Aluminum, Alloy Steel
- Stainless Steel

## Work Pieces:

- Round bar
- Pipe
- Flat
- ⋈ Structural

Dimensions (mm)	teeth per inch (tpi)									
	3	4	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
mm										
20 x 0.9	PN	PN	-	PN	PN / N	PN / N / PT	N / PT	N	N / PT	N / PT
27 x 0.9	PN	PN	-	PN	PN / N	PN / N / PT	N / PT	N	N / PT	N / PT
34 x 1.1	PN	PN	-	PN	PN / N	PN / N / PT	N / PT	N	N / PT	-
41 x 1.3	-	-	PN	PN	PN	PN / N	-	-	-	-

Universal Application for Ferrous and Non Ferrous Metal Cutting.

## Features:

- M42 HSS Tips
- Positive, Neutral, Hook Tooth available
- Variable TPI
- Prolonged Tool Life

## Applications:

- Non-Ferrous Metals
- Thick Walled Structurals
- Alloy Steel
- Stainless Steel

## Work Pieces:

- Round bar
- Pipe
- Flat
- ⋈ Structural

Dimensions	teeth per inch (tpi)									
	0.75/1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	
mm										
20 x 0.9	-	-	PN	PN	N/PT	N/PT	N	N/PT	N	
27 x 0.9	-	-	PN	PN	N	N	N	N	N	
34 x 1.1	-	-	PN	PN	PN / N	N	N	N	-	
41 x 1.3	-	PN	PN	PN / N	PN / N	PN / N	-	-	-	
54 x 1.6	PN	PN	PN	PN / N	N	-	-	-	-	
67 x 1.6	PN	PN	PN	N	-	-	-	-	-	

Efficient and Powerful Saw Blade with vibration resistant tooth edge

## Features:

- M42 HSS Tips
- Positive, Neutral, Hook Tooth available
- Variable TPI
- Excellent life time expectancy

## Applications:

- Alloy Steel
- Stainless Steel
- Non-Ferrous Metals
- Hollow Structure
- Tool Steel, Die Steel

## Work Pieces:

- Round bar
- Pipe
- Flat
- ⋈ Structural

Dimensions	teeth per inch (tpi)									
	0.75/1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14	
mm										
20 x 0.9	-	-	N	N	N	N	N	N / PT	N	
27 x 0.9	-	-	PN / N / PT	PN / N / PT	PN / N / PT	N / PT	N	N / PT	N	
34 x 1.1	-	-	PN / PT	PN / N / PT	PN / N / PT	N / PT	N	N / PT	-	
41 x 1.3	-	PN	PN / PT	PN / PT	PN / N / PT	N / PT	-	-	-	
54 x 1.6	PN	PN	PN / PT	PN / PT	N / PT	-	-	-	-	
67 x 1.6	PN	PN	PN / PT	PN / PT	-	-	-	-	-	
80 x 1.6	PN	PN	-	-	-	-	-	-	-	

Best Suited for cutting Hard Materials like Stainless Steel, Die Steels and Super Alloys.

## Features:

- M51 Powder Metallurgy
- Positive, Neutral, Tooth available
- Variable TPI
- Excellent life time expectancy

## Applications:

- Alloy Steel
- Tool Steel
- Die Steel
- Stainless Steel

## Work Pieces:

- Round bar
- Pipe
- Flat

Dimensions	teeth per inch (tpi)									
	0.75/1.25	1 / 1.5	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14
mm										
27 x 0.9	-	-	-	PN / N	PN / N	PN / N	N	N	N	N
34 x 1.1	-	-	-	PN / N	PN / N	PN / N	N	N	N	-
41 x 1.3	-	-	PN / N	PN / N	PN / N	PN / N	N	-	-	-
54 x 1.6	PN	-	PN	PN / N	PN / N	N	-	-	-	-
67 x 1.6	PN	PN	PN	PN / N	PN / N	-	-	-	-	-

**PN : Positive Tooth   N : Neutral Tooth   PT : Hook Tooth**



AN ISO 9001 : 2015 Certified

# RACROTECH ABRASIVES

*"A Leading Supplier of Bonded Abrasives"*

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