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#### 2 Selection of Granule-Degree

Coarse granule of abrasive materials bring better efficiency, while the surface of workpiece will be rough.

In the condition of satisfy the coarseness of surface, it is better to choose coarse Grit-size. It is better for Resinoid binder grinding tools to choose 70/80 80# and following RVD(JR1) Diamond.

It is better for Metalic (bronze) binder grinding tools to choose MBD(JR2) Diamond. Granularity number & Basal granule size of Synthetic Diamond or CBN will be seen in the former sheet(Page.2).

CBN tools process ordinary steels, carbon steel and varieties of alloyed steel precede Diamond.

The relationship between Diamond granularity and process coarse granularity

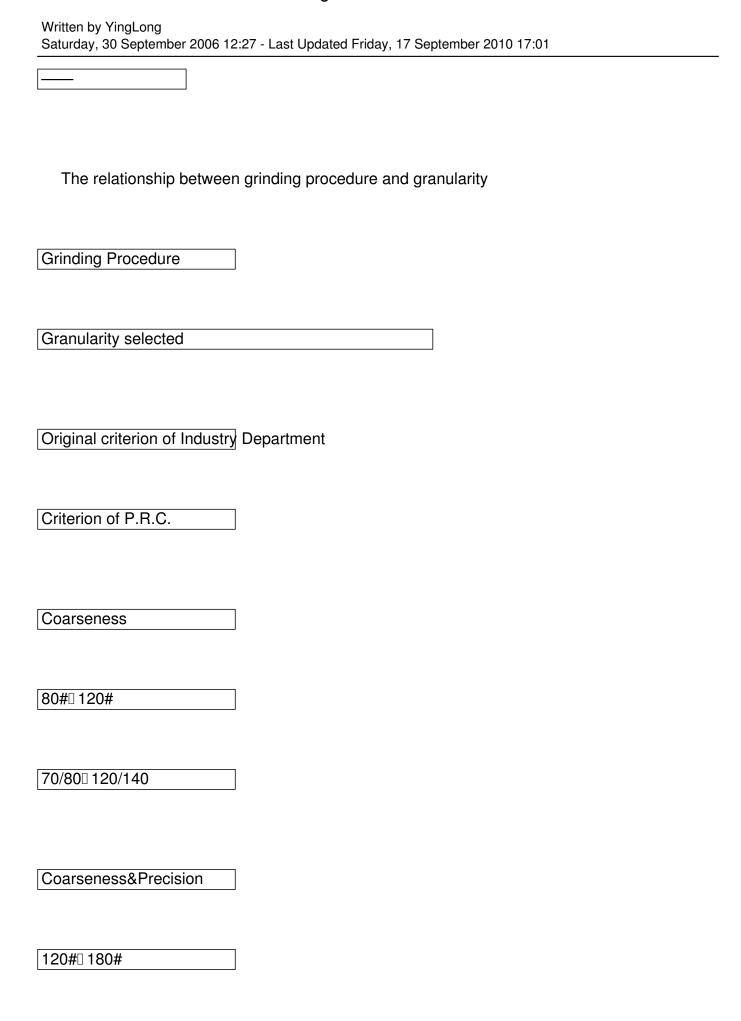
Granularity number	
Reachable surface coarseness	
Original criterion of Industry Department	
Criterion of P.R.C.	
Resin Binder	
Metal Binder	
80#100#	

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70/80 100/120
100#🛘 150#
100/120 140/170
180#0 240#
140/170 230/270
□ 9□ □ 10

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280#□ W20	
230/270 12-22	
□ 10□ □ 11	
W140 W5	
8-120 4-8	
<b>11 12</b>	
W50 W0.5	
4-8 0-0.5	



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120/140 200/230	]	
Precision		
180#□ W40		
200/230 36-54		
Grinding&Polishing		
W40 W1		
36-540 0.5-1	]	