



**VNX2**  
**Engineered Solutions for Surface Grinding**

TYROLIT - A Company of the SWAROVSKI Group



### Surface Grinding-Standard Assortment

Shape	D	T	H	X	Material No. VNX2 Surface Rough	Material No. VNX2 Surface Medium	Material No. VNX2 Surface Fine
1A1S	6	0.5	1.25	0.25		324018	
1A1S	7	0.5	1.25	0.25	321906*	321244*	321249
1A1S	7	0.5	1.25	0.5	332249	332251	332252
1A1S	7	1	1.25	0.5	332255	332256	332257
1A1S	8	0.5	1.25	0.25	321251*	321255*	321917
1A1S	8	0.5	1.25	0.5	332258	332259	332262
1A1S	8	1	1.25	0.5	323923	323808	323945
1A1S	12	0.5	5	0.25	332264	332269	332272
1A1S	12	0.5	5	0.5	332265	332271	332275
1A1S	12	1	5	0.5	318621*	315572	319377
1A1S	14	1	5	0.5	332860	332863	332865

Other sizes are available upon request. All dimensions in inches.

\*Items available from stock

### Surface Grinding-Parameters and Materials

		Tungsten Carbide	HSS	Inconel	Alloy Steel	Cast Iron	Aluminum	Titanium	Ceramic	Glass
Infeed (inches/pass)	VXN2 Surface Rough	0.001	0.0013	0.0015	0.0007	0.0015	0.0015	0.0004	0.0015	0.0015
	VXN2 Surface Medium	0.0007	0.001	0.0013	0.0005	0.0013	0.0013	0.0003	0.0013	0.0013
	VXN2 Surface Fine	0.0005	0.0007	0.001	0.0003	0.001	0.001	0.0002	0.001	0.001
Table Feed Rate (feet/minute)						35				
Cross Feed Rate (% of wheel width)						10 - 20				
Surface Speed (sfpm)						6500 - 7500				

### Truing

VNX2 Truing Parameters

	Truing
Infeed (inches/pass)	0.001
Table Feed Rate (feet/minute)	35
Cross Feed Rate (% of wheel width)	10 - 20
Surface Speed (sfpm)	6500 - 7500

### VNX Truing Block

Material Number

2V9450\*

**NEW!**

Highly Recommended

Dressing with Aluminum Oxide Sticks - required after truing.  
Continuous cross feed produces best finish.

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