



# **RADIAC'S DYNAMIC CERAMIC HIGH PERFORMANCE GRINDING PRODUCTS**

Made exclusively with  
3M™ Cubitron™ Abrasive Grain 321

**Radiac**  
Abrasives

Precision Engineered Grinding Wheels  
[www.radiac.com](http://www.radiac.com)

AMERICAN MADE



AMERICAN OWNED

# THE RADIAC CERAMIC

## Advantages...

- COOLER CUTTING
- BETTER FORM HOLDING
- MORE AGGRESSIVE GRINDING ACTION
- LONGER WHEEL LIFE & LESS DRESSING

## Suitable Applications ...

Typical applications include those that require cool cutting action to eliminate heat cracks or checks, applications where form holding is critical, or heavy stock removal is needed. Precision operations and high production applications are ideal for High Performance Products containing **3M™ Cubitron™ Abrasive Grain 321**.

### HISTORY

For over a decade, Radiac Abrasives has been producing high performance grinding products utilizing 3M™ Company's patented Cubitron™ abrasive grain. During that Time, both Radiac and 3M have made great advances in abrasive, bond and process technology.

3M™ Company's Cubitron™ Abrasive Grain 321 is the result of over ten years of extensive research and process development. Its unique microstructure produces an abrasive that is tougher and cooler cutting than conventional abrasives. This, in combination with Radiac's improved vitrified bond technology and formulations, provides products unmatched by the competition.

### SPECIAL FORMULATIONS

Radiac Abrasives offers high performance wheels containing 3M Cubitron Abrasive Grain 321 blended with either our pink (RAA) or premium white (WA) abrasive in a wide range of standard stock and engineered tool room products. These traditional combinations allow Radiac to produce products with the aggressive grinding characteristics of ceramic abrasive and the friability that white and pink abrasives provide.

More recently, Radiac has designed and tested unique blends of 3M Cubitron Abrasive Grain 321 and other abrasives to achieve unsurpassed customer requirements for stock removal, finish, and wheel life on various materials including the latest exotic metals and composites. Radiac can also provide 3M Cubitron Abrasive Grain 321 blends in resinoid bonded products specifically designed for use in roll grinding and various other primary metal applications.

### RECOMMENDATIONS...

Our 8BP products with a mixture of ceramic grain and pink RAA abrasive is suitable for most standard materials including high nickel alloys, stainless steel, and high carbon or high chrome materials.



DIMENSIONS	TYPE	SPECIFICATION	R.P.M.	PRODUCT NUMBER
4/3 X 1-1/2 X 1-1/4	11	8BP60-J8-V8	5730	F323155
	11	8BP60-L8-V8	5730	F323156
5/3-3/4 X 1-3/4 X 1-1/4	11	8BP60-K8-V8	4585	F323157
	1/4R 1/2B B/P 2014			
7 X 1/4 X 1-1/4	1	8BP60-I8-V8	3600	A323176
	1	8BP60-J8-V8	3600	A329742
	1	8BP60-K8-V8	3600	A323174
	1	8BP80-K8-V8	3600	A323175
7 X 1/2 X 1-1/4	1	9BP46-I8-V8	3600	A329744†
	1	8BW46-H8-V8	3600	A327004
	1	8BW46-I8-V8	3600	A322667
	1	8BW60-I8-V8	3600	A323050
	1	8BP46-G800-V0S	3600	K329743
	1	8BP46-H800-V0S	3600	K323163
	1	8BP46-I8-V8	3600	A322483
	1	8BP46-I800-V0S	3600	K324551
	1	8BP46-J8-V8	3600	A323162
	1	8BP46-K8-V8	3600	A322645
8 X 1/2 X 1-1/4	1	8BP60-G800-V0S	3600	K329745
	1	8BP60-H8-V8	3600	A329746
	1	8BP60-H800-V0S	3600	K323158
	1	8BP60-I8-V8	3600	A322516
	1	8BP60-J8-V8	3600	A322240
	1	8BP60-K8-V8	3600	A321716
	1	8BP80-I8-V8	3600	A322959
	1	8BP80-J8-V8	3600	A323159
	1	8BP80-K8-V8	3600	A321715
	1	7BP46-J8-V8	3600	A323160
	1	7BP60-I8-V8	3600	A322825
	1	7BP60-J8-V8	3600	A323161
	1	8BW46-H8-V8	3600	A325935
	1	8BP46-G800-V0S	3600	K329747
	1	8BP46-H800-V0S	3600	K323164
	1	8BP46-I8-V8	3600	A323167
	1	8BP46-J8-V8	3600	A322642
	1	8BP46-K8-V8	3600	A323168
	1	8BP60-G800-V0S	3600	K329748
	1	8BP60-H800-V0S	3600	K323165
1	8BP60-I8-V8	3600	A323169	
1	8BP60-I800-V0S	3600	K323166	
1	8BP60-J8-V8	3600	A323170	
1	8BP60-K8-V8	3600	A323171	
1	8BP80-J8-V8	3600	A323172	
1	8BP80-K8-V8	3600	A323173	
8 X 3/4 X 1-1/4	1	8BP46-I8-V8	3600	A323145
	1	8BP46-J8-V8	3600	A322519
	1	8BP60-I8-V8	3600	A323147

### Grit Selection

GRIT SIZE	RADIUS	FINISH RMS
46	Over .020	Over 32
60	.016-.020	15 - 20
80	.010-.020	12 - 18
100	.008-.010	10 - 15
120	.005-.008	8 - 12

† Limited Quantities Available

# CERAMIC ADVANTAGE

**Competition ...** In extensive field tests, our products consistently outperformed competitive products containing significantly higher concentrations of ceramic abrasive. This means better performance and greater value for our customers.

**Grinding Parameters ...** To obtain the best results from any of our ceramic products, faster traverse rates and heavier downfeeds should be used. Dressing of our ceramic products should only be done as often as required to restore the form of the wheel.

DIMENSIONS	TYPE	SPECIFICATION	R.P.M.	PRODUCT NUMBER
8 X 3/4 X 1-1/4	1	8BP60-J8-V8	3600	A323148
	1	8BP60-K8-V8	3600	A323149
10 X 1/2 X 1-1/4	1	8BP46-L8-V8	2485	A328608
	1	8BP60-L8-V8	2485	A340092
10 X 5/8 X 1-1/4	1	8BP46-L8-V8	2485	A321832
	1	8BP60-L8-V8	2485	A327234
10 X 1 X 3	1	8BP46-H800-VOS	2485	K324839
	1	8BP46-I8-V8	2485	A323333
	1	8BP46-J8-V8	2485	A325428
	1	8BP60-J8-V8	2485	A324611
10 X T/4 1R B/P 2554	52	8BP46-F800-VOS	2105	N331200
12 X 5/8 X 1-1/4	1	8BP46-L8-V8	2070	A324754
	1	8BP60-L8-V8	2070	A341422
12 X 3/4 X 1-1/4	1	8BP46-L8-V8	2070	A325431
	1	8BP60-L8-V8	2070	A322729
	1	7BP54-O5-B51T	3025	Q337825
12 X 3/4 X 3	1	8BP46-I8-V8	2070	A324911
12 X 7/8 X 1-1/4	1	8BP46-L8-V8	2070	A325432
	1	8BP60-L8-V8	2070	A322730
12 X 1 X 3	1	8BP46-H8-V8	2070	A329751
	1	8BP46-H800-VOS	2070	K322836
	1	8BP46-I8-V8	2070	A324981
	1	8BP60-G800-VOS	2070	K329752
	1	8BP60-I800-VOS	2070	K329753
12 X 1 X 5	1	8BP46-H8-V8	2070	A329754
	1	8BP46-H800-VOS	2070	K323150
	1	8BP46-I8-V8	2070	A329755
	1	8BP60-G800-VOS	2070	K329756
	1	8BP60-I8-V8	2070	A321337
	1	8BP60-I800-VOS	2070	K329758
	1	8BP60-J8-V8	2070	A323151
12 X 1-1/2 X 5	1	8BP60-I800-VOS	2070	K329759
12 X 2 X 1-3/4 X FACE 1/S 4-7/8 X 1 B/P26311	5	8BP60-J8-V8	2070	G332128
14 X 1 X 3	1	8BP46-I8-V8	1800	A326446
14 X 1 X 5	1	8BP46-H800-VOS	1800	K323152
	1	8BP46-I8-V8	1800	A323884
	1	8BP60-I8-V8	2185	A326299
14 X 1-1/2 X 5	1	8BP46-H8-V8	1800	A329760
	1	8BP46-H800-VOS	1800	K323153
	1	8BP46-I8-V8	1800	A328682
	1	8BP60-H8-V8	1800	A329761
	1	8BP60-J8-V8	1800	A323154
<b>SEGMENTS</b>				
5 X 1-1/2 X 6 NO B/P1913	50	7BP30-G800-VOS		P336197
11-1/4 X 2-1/4 X 6 CD B/P2697	50	7BP30-F800-VOS		P336422
	50	7BP30-G800-VOS		P339914
11-1/4 X 3 X 8 CDXTL B/P26306	50	7BP30-F800-VOS		P352050
	50	7BP30-G800-VOS		P342470

## BW

- Mixture of Ceramic and White Aluminum Oxide
- Good for very heat sensitive parts
- Ideal for materials over 50Rc
- Lighter stock removal

## BP

- Mixture of Ceramic and Pink Aluminum Oxide
- Excellent for materials containing high levels of Chrome
- Ideal for materials over 40Rc
- Heavy stock removal

### Stock Removal Rates Per Pass

	.0005 - 0.002	.003 - .010	.010 - .020
7BP/7BW			
8BP/8BW			
9BP/9BW			

## 7BP 7BW

- Suited for small contact areas and applications where heavy downfeeds are needed
- Popular in segments for Blanchard style grinding

## 8BP 8BW

- Most popular for all applications including surface, cylindrical, internal and tool sharpening
- Excellent in general tool room applications

## 9BP 9BW

- Designed primarily for internal grinding, surface grinding and applications involving large contact areas

### Hardness Selection

MATERIAL	SOFT	MEDIUM	HARD
HARDNESS	<50 Rc	50-57 Rc	>57 Rc
WHEEL GRADE			
H			
I			
J			



Precision Engineered Grinding Wheels

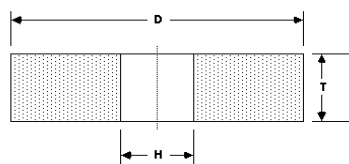
# The Radiac ADVANTAGE

MULTIPLE ABRASIVE MIXTURES	Suited for a wide variety of applications Tiered levels of cost and performance Improved performance on difficult materials
BOND TECHNOLOGY	Superior grade consistency Does not alter abrasive structure Designed for maximum abrasive performance
STANDARD STOCK AVAILABILITY	Reduced inventory cost Immediate availability Popular specifications readily available Lower order quantity
LEAD TIMES	Consistent on time delivery Shortest lead times in industry Lower stocking levels
SUPERIOR WHEEL QUALITY	Exceptional grinding performance Reduced costs Consistent part quality

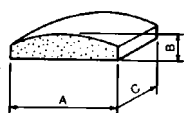
## Performance Guarantee

*We believe that Radiac Grinding Wheels will give you performance and cost savings exceeding that provided by the products you are currently using.*

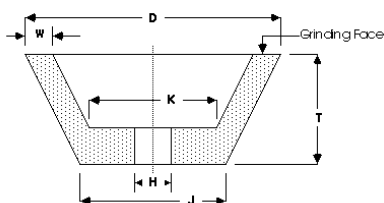
*If you feel that the Radiac wheels you have purchased are not a better value than the product you are currently using, we will give you credit based upon the performance received.*



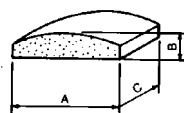
Type 1 Wheel



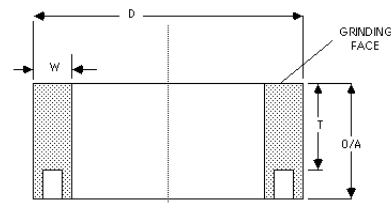
Segment CD



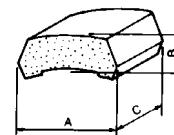
Type 11 Wheel



Segment CDXTL



Type 52 Wheel



Segment N0

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