



# Grinding Wheel Series

[www.bayunion-tech.com](http://www.bayunion-tech.com)

# About Bay Union

Bay Union Abrasive Technology Co., Ltd. was founded in 1987. We have focused on producing vitrified bonded grinding wheels for many years.

Bay Union has advanced vitrified bonds and special self-developed equipments, so we can supply high quality grinding wheels in a very fast and steady way.



**HIGH PERFORMANCE, HIGH-QUALITY STABILITY, and FAST DELIVERY** are our strength, and that is why we can expand very fast in percision grinding market.

In order to satisfy customers' needs, Bay Union is promoting standard series whether for applying Surface Grinding, Cylindrical Grinding or Internal Grinding, we provide a faster way in selecting suitable products for your grinding demands. For all product series, we have ready stock in corresponding wheels for replacement with more value.

## Bay Union Value



## Vitrified bonded CBN Wheel

CBN grinding wheel is a type of grinding wheel that uses cubic boron nitride (CBN) as an abrasive. Its features are as follows:

### High hardness

CBN grinding wheel has a much higher hardness than conventional grinding wheels, so it can more effectively remove materials with high hardness, such as High-speed steel, Alloy steel, and Bearing steel.

### High thermal stability

CBN grinding wheel has high thermal stability, and can be used for a long time in high-temperature environments without losing its strength, making it an ideal grinding wheel for processing high-hardness materials.

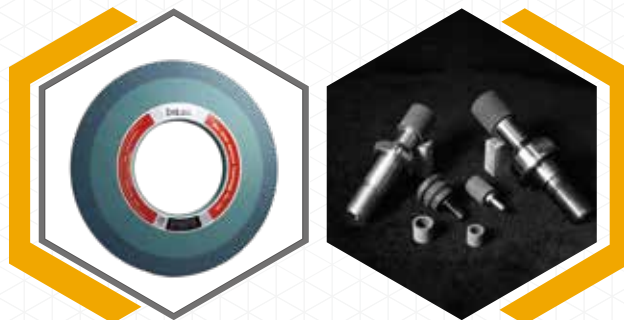
### High precision

CBN grinding wheel can achieve high-precision grinding, with good surface roughness and high profile quality of the workpiece.

### Long life time

Due to the high hardness of CBN grinding wheel, its service life is long and can be several times that of conventional grinding wheels.

BAYUNION can highly customize CBN grinding wheels to meet your grinding needs, greatly improving grinding efficiency and extending the life of the grinding wheel.



## BF Surface Grinding Wheel



- Ceramic aluminum oxide (SG grain)
- Maximum grinding performance
- Excellent form holding & Longer tool life
- Versatile on a wide variety of steels

## PP Internal Grinding Wheel



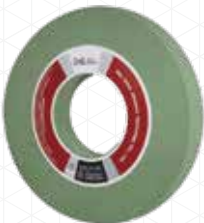
- Special ceramic aluminum oxide
- High grinding material removal rate
- Good heat discharge
- Suitable for hardened steels

## CKS Cylindrical Grinding Wheel



- Highly versatile
- Ruby aluminum oxide
- Tougher abrasive than WA grain
- Suitable for high-alloy steels and stainless steel 400 series

## GF Cylindrical Grinding Wheel



- White aluminum oxide with green bond
- Fast cutting
- Good form holding
- Suitable for all kinds of steels

*Your Best Grinding Choice !*

# Application Features

## Internal Grinding

Series	Features	Branch	Feeding		Dimension ratio	
			Auto	Semi-auto	Wheel OD V.S. Workpiece ID	Wheel thickness V.S. Workpiece Length
PP Series	High stable removing rate SUJ2, Composite material HRc50~63	PPW	○	☆	1 : 2	1 : 3~0.5
		PP	☆	△	1 : 1.8	1 : 1.5~0.8
BF Series	SG grian/Longer wheel life time General Steels and Alloy SCM440, S45C, SCr420	BFS	☆	○	1 : 1.5	1 : 2.5
		BFU	○	△	1 : 1.5	1 : 2

## Cylindrical Grinding

Series	Features	Branch	Feeding		Lubricant	
			Auto	Semi-auto	100% synthetic	Semi-synthetic
PP Series	High density alloy grinding Cold forging / Hot Forging / SKH / SKD	PPW	☆	○	☆	○
CK Series	Blend of special abrasives SKD / SUJ2 /General Steels and Alloy	CKL	○	☆	○	○
		CKS	○	△	△	○
GF Series	General Steels and Alloy S45C / SCr420 / SNCM	GFV	☆	○	○	○
		GF	○	○	○	△

## Surface Grinding

Series	Features	Branch	Feeding		Lubricant	
			Auto	Semi-auto	Dry	All types
BF Series	SG grian/Longer wheel life time General Steels and Alloy HRc40~60	BFM	○	☆	☆	○
		BFV	○	○	☆	○
CK Series	Blend of special abrasives STAVAX, SKH, SKD Over HRc55	CKQ	☆	☆	☆	○
		CK	○	○	○	☆

○ : Acceptable    △ : Good    ☆ : Excellent

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