

Table II. Suggested Surface Speed and Abrasives for Various Metals

Material	Operation	Abrasive ^a	Grits	Belt Speed	Lubricant	Contact Wheel Type	Hardness/Durometer
Hot and cold rolled steel	Grinding	ZA, A/O, or CAO	24-60	4,000-7,000	Dry	Cog tooth or serrated	70-95 duro.
	Polishing	ZA, A/O, or CAO	80-150	4,000-7,000	Dry or light grease	Plain face rubber, canvas	40-70 duro. medium
	Fine polishing	A/O	180-320	4,000-7,000	Heavy grease or polishing oil	Plain face rubber, canvas, cloth	Soft
Stainless Steel	Grinding	ZA or A/O	36-60	3,000-5,000	Dry	Cog tooth or serrated	70-95 duro.
	Polishing	ZA or A/O	80-150	3,000-5,000	Dry or light grease	Plain face rubber	40-70 duro.
	Fine polishing	A/O or S/C	180-240	3,000-5,000	Heavy grease or polishing oil	Plain face rubber, canvas, cloth	Soft
Aluminum	Grinding	ZA, A/O, or CAO	24-80	4,000-7,000	Light grease	Cog tooth or serrated	70-95 duro.
	Polishing	A/O or S/C	100-180	4,000-7,000	Light grease	Plain face rubber	40-70 duro. medium
	Fine polishing	A/O or S/C	220-320	4,000-7,000	Light grease or heavy grease	Plain face rubber, canvas, cloth	Soft
Copper and copper alloys	Grinding	A/O or S/C	36-80	3,000-7,000	Light grease	Cog tooth or serrated	70-95 duro.
	Polishing	A/O or S/C	100-150	3,000-7,000	Light grease	Plain face rubber, canvas, cloth	40-70 duro. medium
	Fine polishing	A/O or S/C	180-320	3,000-7,000	Light grease or heavy grease	Plain face rubber, canvas, cloth	Soft
Nonferrous die castings	Grinding	ZA, A/O, or CAO	24-80	5,000-7,000	Light grease	Serrated or plain	70-95 duro.
	Polishing	A/O or S/C	100-180	5,000-7,000	Light grease	Plain face rubber, canvas, cloth	40-70 duro. medium
	Fine polishing	A/O or S/C	220-320	5,000-7,000	Light grease or heavy grease	Plain face rubber, canvas, cloth	Soft
Cast iron	Grinding	ZA, A/O, or CAO	24-60	2,000-5,000	Dry	Cog tooth or serrated	70-95 duro.
	Polishing	ZA or A/O	80-150	2,000-5,000	Dry	Serrated or plain	40-70 duro.
	Fine polishing	ZA or A/O	150-240	2,000-5,000	Light grease	Plain rubber	30-50 duro.
Titanium	Grinding	ZA or S/C	36-60	1,000-2,500	Dry	Cog tooth or serrated	70-95 duro.
	Polishing	S/C	80-120	1,000-2,500	Light grease	Serrated or plain	40-70 duro.
	Fine polishing	S/C	150-240	1,000-2,500	Light grease	Plain face rubber, canvas, cloth	Soft

Note: ZA = zirconia alumina; A/O = aluminum oxide; CAO = ceramic aluminum oxide; S/C = silicon carbide; duro. = durometer.