

## Guide to Norton Grinding Wheels

*Disclaimer: For specific recommendations in your particular grinding operation, call your local Norton representative.*

CRUCIBLE TRADE NAME (AISI GRADE)	STEEL CONDITION	CENTERLESS THROUGHFEED	CENTERLESS INFEEED	INTERNAL GRINDING	SURFACE GRINDING STRAIGHT	SURFACE GRINDING CUP WHEEL	SURFACE GRINDING SEGMENT	CYLINDRICAL GRINDING
<b>COLD WORK TOOL STEELS</b>								
KETOS (O1)	HARDENED	3SGP54-LVS	3SGP54-MVS	3SG54-LVS	5SG40-IVS	5SG46-IVS	5SG30-FVSP	3SG80-KVS
	ANNEALED	57A54-LAVCN	57A54-M8VCN	32A60-LVBE	38A40-18VBE	32A36-E12VBEP	86A30-F12VBEP	64A60-K8V127
AIRKOOL (A2)	HARDENED	3SGP60-KVS	3SGP60-LVS	3SG60-LVS	5SG60-IVS	5SG60-IVS	5SG36-EVSP	3SG80-KVS
	ANNEALED	57A60-K8VCN	57A60-L8VCN	32A60-KVBE	53A60-18VBE	32A46-D12VBEP	86A36-E12VBEP	64A60-K8V127
AIRDI 150 (D2)	HARDENED	3SGP60-JVS	3SGP60-KVS	3SG60-KVS	5SG46-IVS	5SG46-IVS	5SG46-EVSP	3SG60-JVS
	ANNEALED	57A60-JBVCN	57A60-K8VCN	32A60-JVBE	32A46-18VBE	32A46-D12VBEP	86A46-D12VBEP	64A60-J8V127
<b>HOT WORK TOOL STEELS</b>								
NUDIE V/XL (H1 3)	HARDENED	3SGP60-LVS	3SGP60-LVS	5SG60-IVSP	5SG60-JVS	5SG46-IVS	5SG30-FVSP	3SG60-KVS
	ANNEALED	57A60-K8VCN	57A60-K8VCN	32A60-KVBE	32A60-J8VBE	32A36-G12VBEP	86A30-F12VBEP	64A60-K8V127
<b>PLASTIC MOLDING STEELS</b>								
S7 (S7)	HARDENED	3SGP60-KVS	3SGP60-KVS	3SG80-KVS	5SG60-JVS	5SG46-IVS	5SG30-FVSP	3SG60-KVS
	ANNEALED	57A60-KSVCN	57A60-K8VCN	32A54-LVBE	38A60-J8VBE	32A46-H8VBE	86A30-F12VBEP	64A60-K8V127
CSM 2 (P20)	HARDENED	3SGP60-LVS	3SG60-NVS	3SG60-LVS	5SG46-JVS	3SG46-IVS	5SG30-FVSP	3SG60-LVS
	ANNEALED	57A60-MSVCN	57A60-P6VCN	32A60-LVBE	32A46-LVBE	32A46-18VBE	86A30-F0VBEP	64A60-K8V127
CSM 420 (420)	HARDENED	3SGP80-KVS	3SGP80-NVS	3SG80-KVS	5SG60-IVS	3SGP46-IVS	3SGP36-EVSP	3SG60-JVS
	ANNEALED	53A80-K8VCN	53A80-P6VCN	32A80-KVBE	32A60-H8VBE	32A46-18VBE	86A36-E12VBEP	64A60-J8V127
MAXEL 400 FM (-)	HARDENED	SGP60-LVS	3SGP80-NVS	3SG80-KVS	5SG60-IVS	3SGP46-IVS	3SGP36-EVSP	3SG60-JVS
	ANNEALED	53A60-L8VCN	53A80-P6VCN	32A80-KVBE	32A60-H8VBE	32A46-48VBE	86A36-E12VBEP	64A60-J8V127
MAXEL 2000 (-)	HARDENED	3SGP60-KVS	3SGP80-NVS	3SGP80-KVS	5SG60-JVS	5SG46-IVS	3SGP36-EVSP	3SG60-JVS
	ANNEALED	53A60-K8VCN	53A80-O6VCN	32A80-LVBE	32A60-16VBE	32A46-18VBE	86A36-E12VBEP	64A60-JV8127
CSM 21 (-)	HARDENED	5SGP80-KVS	5SGP80-NVS	3SGP60-KVS	5SG60-IVS	5SGP46-IVS	5SG46-DVSP	3SG60-JVS
	ANNEALED	53A80-K8VCN	53A80-O6VCN	32A60-LVBE	32A60-18VBE	32A46-18VBE	86A46-D12VBEP	64A60-J8V127
<b>HIGH SPEED STEELS</b>								
REX M2 (M2)	HARDENED	5SG60-KVS	5SG60-KVS	5SG60-KVS	5SG60-KVS	5SG60-KVS	5SG60-KVS	5SG60-KVS
	ANNEALED	32AK6-VBE	32AK6-VBE	32AK6-VBE	32AK6-VBE	32AK6-VBE	32AK6-VBE	32AK6-VBE
CPM M4HC (M4)	HARDENED	5SG80-KVS	3SGP80-NVS	3SG60-KVS	5SG60-GVSP	5SG46-GVSP	5SG36-EVSP	5SG60-JVS
	ANNEALED	57AC60-QB	53A80-K6VCN	5SG80-HVSP	32A60-H8VBE	32A36-G12VBEP	86A36-E12VBEP	64A60-J8V127
CPM REX20 (M62)	HARDENED	5SG80-KVS	3SGP80-NVS	5SG80-HVSP	5SG60-GVSP	5SG46-GVSP	5SG30-EVSP	5SG60-JVS
	ANNEALED	57AC60-QB	53A80-K6VCN	32A80-JVS	32A60-H8VBE	32A36-G12VBEP	86A30-E12VBEP	64A60-J8V127
CPM T15 (T15)	HARDENED	5SG80-KVS	3SGP80-NVS	5SG60-HVSP	5SG60-GVSP	5SG46-IVS	5SG30-EVSP	5SG60-JVS
	ANNEALED	57AQ80-QB	53A80-K6VCN	32A60-IVS	32A60-H8VBE	32A36-G12VBEP	86A36-E12VBEP	64A60-J8V127
CPM REX76 (M48)	HARDENED	5SG80-KVS	3SGP80-MVS	3SG60-KVS	5SG80-GVSP	5SG46-IVS	5SG30-EVSP	5SG60-JVS
	ANNEALED	57AQ60-QB	53A80-K6VCN	5SG60-IVSP	32A60-H8VBE	32A36-G12VBEP	86A36-EDVBEP	64A60-J8V127
<b>SPECIAL WEAR RESISTANT GRADES</b>								
CPM 9V (-)	HARDENED	5SG80-KVS	3SGP80-NVS	5SG60-HVSP	5SG60-GVSP	5SG46-IVS	5SGP46-DVSP	5SG60-IVS
	ANNEALED	57AQ60-QB	53A80-K6VCN	32A60-IVS	32A60-H8VBE	32A36-G12VBEP	86A46-D12VBEP	64A60-J8V127
CPM 10V (A11)	HARDENED	5SG80-KVS	3SGP80-NVS	5SG60-HVSP	5SG60-GVSP	5SG46-IVS	5SGP46-DVSP	5SG60-IVS
	ANNEALED	57AQ60-QB	53A80-K6VCN	32A60-IVS	32A60-H8VBE	32A36-G12VBEP	86A46-D12VBEP	64A60-J8V127
CPM 15V (-)	HARDENED	5SG80-KVS	3SGP80-NVS	5SG60-HVSP	5SG60-GVSP	5SG46-IVS	5SGP46-DVSP	5SG60-IVS
	ANNEALED	57AQ60-QB	53A80-K6VCN	32A60-IVS	32A60-H8VBE	32A36-G12VBEP	86A46-D12VBEP	64A60-J8V127
CPM S60V/S90V (-) 440V/420V	HARDENED	5SG80-KVS	3SGP80-MVS	5SG60-JVS	5SG60-GVSP	5SG46-IVS	5SG36-EVSP	5SG60-JVS
	ANNEALED	57AC80-QS	53A80-K6VCN	5SG60-HVSP	32A60-H8VBE	32A36-G12VBEP	86A36-E12VBEP	64A60-J8V127