

Selecting a Carbide Wheel

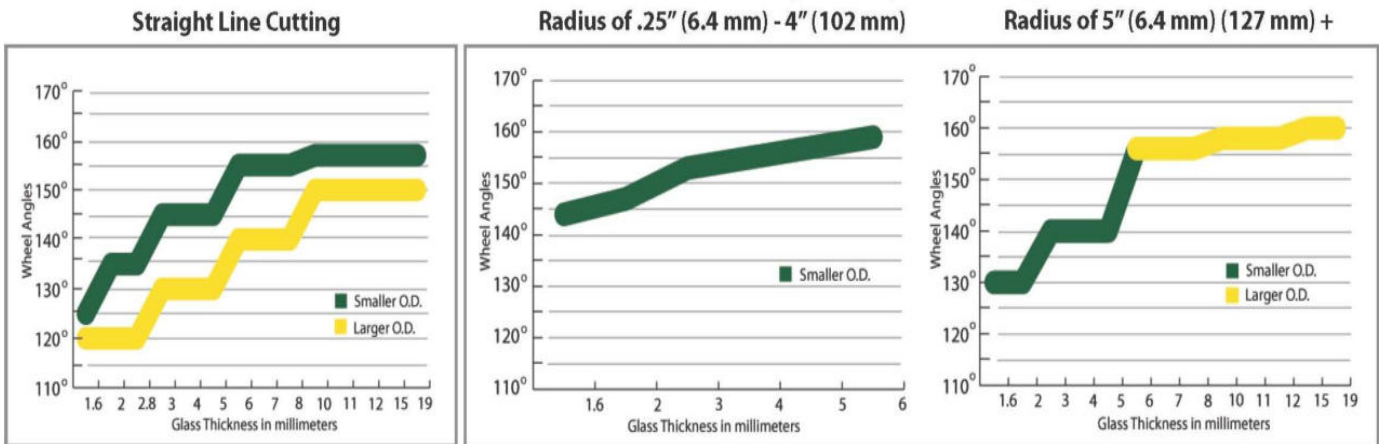
When selecting the proper wheel, Fletcher recommends a four step selection process.

Step One: O.D. Selection – Determine the outside diameter of the wheel based on thickness of the glass. Smaller O.D.'s provide for finer adjustment, larger I.D.'s provide extend life.

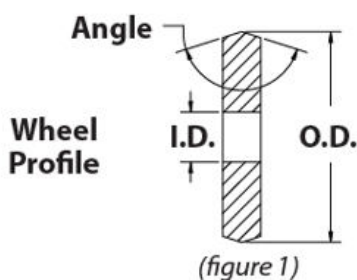
Step Two: I.D. Selection – Determine the inside diameter

C125	C140	C175	C196	C215	C228	C230	C236	C245	W245	V500
O.D. = 0.125" (3.1 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.140" (3.4 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.175" (4.4 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.196" (5 mm) I.D. = 0.051" (1.30 mm) T = 0.039 (1 mm)	O.D. = 0.215" (5.46 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.228" (5.79 mm) I.D. = 0.055" (1.40 mm) T = 0.043 (1.09 mm)	O.D. = 0.230" (5.84 mm) I.D. = 0.093" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.236" (6 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.245" (6.22 mm) I.D. = 0.055" (1.40 mm) T = 0.042 (1.06 mm)	O.D. = 0.245" (6.22 mm) I.D. = 0.062" (1.57 mm) T = 0.120 (3.05 mm)	O.D. = 0.500" (12.7 mm) I.D. = 0.118" (3.00 mm) T = 0.158 (4.01 mm)

Step Three: Angle Selection – Determine type of cut either Straight or Shape cutting. Refer to charts below for additional information.



Step Four: Wheel Grind – RG (Regular Grind) most versatile grind used for straight and shape cutting; CR (Course Grind) used for tube cutting and for irregular surface cutting; PL (Polished) use for very thin and specialty glass cutting



Order as follows:
O.D. - I.D. - Angle - Finish

Wheel Outside Diameter ———— (RG) (PL) (CR)
Wheel Inside Diameter ———— Wheel Angle

Example:
C245 - 055 - 134 - RG