



**1187 Wilmette Avenue, Suite 133
 Wilmette, Illinois 60091
 T: 847-716-7369 F: 847-716-7367
 www.acmproducts.com**



Wheel Selection Guide

The following guide is provided to show the versatility of ACM Products Company's cutting wheels in cutting a variety of materials. We STOCK abrasive cutting wheels for use in cutting over sixty different types of materials from aluminum to zirconium, wet OR dry. ACM's Abrasive Cutting Wheels have been specifically engineered to repetitively deliver high-quality, precision cuts with a minimum of wasted effort and materials.

ACM Cut Off Saws and Wheels are specifically designed for the delicate nature of precision cutting and therefore ACM Products Co. only stocks Non-Reinforced Wheels. (Strict safety standards are met with wheel covers and safety shields.) Reinforced wheels have a higher safety rating than Non-Reinforced wheels because they are interwoven with filaments however, they do not cut as cleanly as non-reinforced wheels. Non-reinforced wheels provide a more "finished" cut and what little burr remains is nominal. When used within the proper guidelines (fixed saw base, enclosed wheel covers, and material clamps) non-reinforced wheels are considered safe to use also. Because there are no filaments interwoven into the wheel, this permits the use of much thinner wheels particularly when waste is a factor, or when cutting precious metals. ACM Products Co. stocks wheels as thin as .008" for those critical cutting applications.

Standard stock items come in aluminum oxide, or silicon carbide grits in a rubber or resin bond. To aid in determining the proper wheel for specific cutting applications, please see the following explanations to help in understanding ACM nomenclatures:

The first number (4 or 5) stands for ACM Wheel Diameter in inches.

4AEG-90-32	4AUB-120-15	4CUT-240-08	5DMC-100-25
------------	-------------	-------------	-------------

The first letter (A, C, or D) stands for the abrasive material:

A= Aluminum-Oxide	C= Silicon-Carbide	D= Diamond
-------------------	--------------------	------------

The second letter (U, E, or M) stands for the type of bond used to adhere the abrasive material:

U= Rubber	E= Resin	M= Metal
-----------	----------	----------

The third letter (B, D, G, H, or T) indicates the hardness of the bond. The second number (60, 90, 120, etc.) is the grit size; "60" being the most coarse to "240" being a very fine grit for a smoother finished cut. Coarse grit provides a faster cut, finer grit provides a smother finish (less bur). The third number (08, 10, 15, etc.) is the wheel thickness in thousandths. ACM stocks Cut Off Wheels in thicknesses from .008 to .062 thousandths. To provide for an even smoother finish, we recommend cutting wet whenever possible.

Wheel Selection Chart

MATERIAL	DRY CUTTING	WET CUTTING
AGATE	N/A	DMC
ALNICO	AEG-90	AUB-120
ALUMINUM	AEG-90, AUB-90	AUB-120
BERYLLIUM OXIDE	AUB-90	CUT-90
BORON CARBIDE	N/A	DMC
BRASS ROD	AEG-90	AUB-90
BRASS TUBING	AUB-90, AUD-120	AUB-120, AUD-120
BRONZE ROD, SOFT	AEG-90	AUB-90
BRONZE ROD, HARD	AEG-120	AUB-120
BRONZE TUBING	AUB-90,120	AUB-120
BRONZE (200)	AUB-120, AEG-90	AUB-120
CEMENTED CARBIDES	N/A	DMC
CARBON ROD, SOFT	N/A	DMC
CARBON ROD, HARD	AEG-90	DMC
CAST IRON	AEG-90	AUB-90,AEG-90
COLUMBIUM	AUB-90	N/A
COPPER ROD	AUB-90	AUB-102
COPPER TUBING	AUB, AUD-120	AUB-120, AUD-120
DRILL ROD, SOFT	AEG-90,AUD	AUB-90, AUD-120
DRILL ROD, HARD	AEG-90, AUB	AUB-90, AUD-120
DURALUMIN, BAR	AUH-100	AUH-150
DURALUMIN, TUBE	AUH-100	AUH-150
FERRITE	N/A	DMC
FIBERGLASS	N/A	CUT, DMC
GERMANIUM & SILICON	N/A	DMC
GLASS, SOLID	N/A	DMC
GLASS, TUBING	N/A	CUT-120, DMC
HAYNES ALLOY	AUB	AUB-120
INCONEL	AUB-120	AUB-120
IRIDIUM	N/A	AUH-150
LUCITE	N/A	CUT-90
METALLURGICAL SPEC.	N/A	AUB-120
MOLYBDENUM	AUB	N/A
MONEL	AEG-90, AUB-90	AUB-120
NICKEL	AEG-90	AUB-90, AUD-120
NICKEL SILVER	AEG, AUB-90	AUD-120
PIPE STEEL	AUB, AUH-100	AUB-120, AUH-150
PLASTICS	CUT-90	CUT
PLATINUM	AUH-100	AUH-150
PORCELAIN, FIRED	N/A	CUT-120, DMC
PORCELAIN, PREFIRED	CUT-120	CUT-120
QUARTZ	N/A	DMC
RUBBER EXTRUSION	AEG-90	N/A
RUBBER HOSE	CUT-90	N/A
STEEL, HARD	AEG-90, AUB	AUB
STEEL, SOFT	AEG-90, AUB	AUB-120, AUH-150
STEEL, 300 SERIES	AEG	AUB-120, AUH-150
STEEL, 400 SERIES	AEG	AUB
STEEL, HI-SPEED	AEG	AUB
STELLITE, HARD	AEG	AUB
TANTALUM	AUB-90	AUB-120
THERMOCOUPLES	AUB	AUB
TITANIUM	N/A	CUT
TUBING, CHROME-MOLY	AUH-100	AUH-100
TUBING, LOW CARBON	AEG-90, AUB	AUB-120, AUH-100
TUBING, STAINLESS	AUH	AUH
TUBING, 300 SERIES	AUH-100	AUB-120
TUNGSTEN CARBIDE	N/A	DMC
ZINC	AUB, AUH-100	AUB-120
ZIRCONIUM	CUT-120	N/A