

DIANAMIC® SUPERABRASIVE PARTICLE SIZE REFERENCE CHART				MESH SIZES
MESH	SIZE	FEPA**	OFFSET ALLOWANCE	APPLICATION
16/18	.047"	1181	.049"	EXTRA HEAVY STOCK REMOVAL
18/20	.040"	1001	.043"	EXTRA HEAVY STOCK REMOVAL
20/25	.034"	851	.036"	EXTRA HEAVY STOCK REMOVAL
20/30	.034"	852	.036"	EXTRA HEAVY STOCK REMOVAL
25/30	.028"	711	.030"	VERY HEAVY STOCK REMOVAL
30/40	.023"	601	.025"	VERY HEAVY STOCK REMOVAL
40/50	.017"	437	.018"	HEAVY STOCK REMOVAL
50/60	.012"	301	.013"	COARSE ROUGHING
60/70	.010"	251	.011"	COARSE ROUGHING
60/80	.010"	252	.0105"	COARSE ROUGHING
80/100	.007"	181	.0075"	GENERAL PURPOSE SEMI ROUGH
100/120	.006"	151	.0063"	GENERAL PURPOSE SEMI ROUGH
120/140	.005"	126	.0053"	GENERAL PURPOSE
140/170	.004"	107	.0043"	GENERAL PURPOSE
170/200	.0036"	91	.0038"	SEMI FINISH
200/230	.003"	76	.0032"	SEMI FINISH
230/270	.0025"	64	.0027"	SEMI FINISH
270/325	.0022"	54	.0024"	FINISH
325/400	.0018"	46	.0019"	FINISH
400/500	.0016"	-	.0017"	FINE FINISH
500/600	.0012"	-	.0013"	FINE FINISH

DIANAMIC® SUPERABRASIVE PARTICLE SIZE REFERENCE CHART				MICRON SIZES
MICRON	APPROX GRIT EQUIVALENT	SIZE RANGE mm	SIZE IN INCHES	APPLICATION
45	400/500	40-50	.0018"	FINE FINISHING
35	500/600	30-40	.0014"	FINE FINISHING
30	800	25-35	.0012"	VERY FINE FINISHING
15	1000	8-22	.0006"	VERY FINE FINISHING
9	1500	6-13	.00035"	VERY FINE FINISHING
6	1800	4-8	.00024"	EXTREME FINE FINISHING
3	2100	2-4	.00012"	EXTREME FINE FINISHING

1 micron = .0000395" **FEPA Standard for Superabrasive Grain Sizes 1997

Non-standard Diamond and cBN Mesh and Micron sizes that are scalped, halved, quartered or micronized available as special orders.

Standard Diamond and cBN Mesh and Micron sizes listed. Diamond is available in Synthetic, or Natural.

The **DIANAMIC®** Superabrasive (Diamond and cBN) Particle Size Chart should be used as a reference guide when manufacturing wheel cores for coating and for strip / recoat estimations.

1. A MALE RADIUS should finish SMALLER than the required finish size. SUBTRACT the particle size offset allowance size from the expected finish size to achieve the correct pre coat dimension.
2. A FEMALE RADIUS should finish LARGER than the required finish size. ADD the particle size offset allowance from the expected finish size to achieve the correct pre coat dimension.

DIANAMIC® recommends that we be contacted for technical support and coating offset recommendations when manufacturing wheel cores to confirm sizes.

DIANAMIC® Made in Michigan since 1985

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