

ANSI B74.12-2001 TABLE 2

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TABLE 2- ALLOWABLE LIMITS FOR THE SIZING OF ALUMINUM OXIDE AND SILICON CARBIDE ABRASIVE GRAIN FOR GRINDING WHEEL MANUFACTURE AND GENERAL POLISHING PURPOSES¹⁾

Grit No.	Sieve ¹ through which 100% must pass	Control sieve ¹		Maximum of over-size on control sieve ¹	Minimum through control sieve and retained		Cumulative minimum through control sieve and retained		Maximum of 3% through sieve No. ¹
		No.	Opening inches		Per-cent	On sieve No. ¹	Per-cent	On sieve No. ¹	
				Percent					Per-cent
4	5/16	3 1/2	0.223	20	40	4	70	4 and 5	6
5	.265	4	0.187	20	40	5	70	5 and 6	7
6	3 1/2	5	0.157	20	40	6	70	6 and 7	8
7	4	6	0.132	20	40	7	70	7 and 8	10
8	5	7	.110	20	45	8	70	8 and 10	12
10	6	8	.0937	20	45	10	70	10 and 12	14
12	7	10	.0787	20	45	12	70	12 and 14	16
14	8	12	.0661	20	45	14	70	14 and 16	18
16	10	14	.0555	20	45	16	70	16 and 18	20
20	12	16	.0469	20	45	18	70	18 and 20	25
22	14	18	.0394	20	45	20	70	20 and 25	30
24	16	20	.0331	25	45	25	65	25 and 30	35
30	18	25	.0278	25	45	30	65	30 and 35	40
36	20	30	.0234	25	45	35	65	35 and 40	45
40	25	35	.0197	25	45	40	65	40 and 45	50
46	30	40	.0165	30	40	45	65	45 and 50	60
54	35	45	.0139	30	40	50	65	50 and 60	70
60	40	50	.0117	30	40	60	65	60 and 70	80
70	45	60	.0098	25	40	70	65	70 and 80	100
80	50	70	.0083	25	40	80	65	80 and 100	120
90	60	80	.0070	20	40	100	65	100 and 120	140
100	70	100	.0059	20	40	120	65	120 and 140	200
120	80	120	.0049	20	40	140	65	140 and 170	230
150	100	140	.0041	15	40	200	65	200 and 230	325
180	120	170	.0035	15	40	200 and 230	65	200, 230 and 270	---
220	140	200	.0029	15	40	230 and 270	60	230, 270 and 325	---
240	170	200	.0029	5	8	230 and 270	38	230, 270 and 325	---

1) The sieves referred to are those of the United States Sieve Series, described in table 1, which have been in conformance with the AGA Standard Sands. (Information on the AGA Standard Sands can be obtained from UAMA, 30200 Detroit Road, Cleveland, Ohio 44145-1967)