

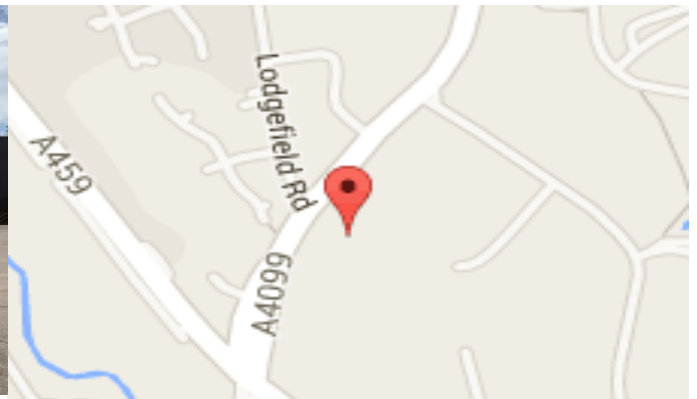


Swift and Whitmore Ltd

The Industrial Abrasive Specialist



Swift and Whitmore Ltd are the largest UK independent manufacturer and supplier of grinding wheel and abrasives and have supplied industry since 1968. Situated in the heart of the West Midlands, we are ideally located for quick nationwide delivery.



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Swift and Whitmore Ltd

Product Range



Bonded Abrasives
abrasives • non slip friction coatings



- Hot pressed high speed billet grinding wheels primarily for use in the steel industry
- Resin bonded wheels for use in the foundry and forging industry
- Roll grinding wheels
- Centerless grinding wheels
- Saw sharpening wheels
- Fettling wheels
- Surface grinding Segments are the optimum method of achieving a heavy, fast and economical way of stock removal.



Floor Finishing industry Grinding stones, hand rubbing blocks and fibre-backed silicon carbide discs. Compatible with all leading grinding machines including Errut, Terrco and Ellis



Mounted points and tungsten carbide burs for deburring operations using high speed portable tools



Vitrified and CBN wheels for tool room and precision grinding including cup, saucer and surface grinding wheels

Links to Group Websites

www.swiftabrasives.com
www.bondedabrasivesltd.co.uk
www.phoenixabrasives.co.uk
www.norab.co.uk
www.arcorundum.co.uk
www.naylor-abrasives.co.uk



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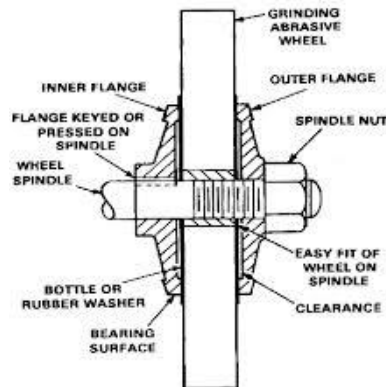
- Coated abrasives including finishing belts, fibre, Velcro & adhesive discs, spirabands, hand pads and convolute wheels
- Diamond Wheels, Tools, Files, dressers & Compounds
- Diamond and CBN (Cubic Boron Nitrate) have similar characteristics both superior to conventional abrasives, providing high hardness, strength, thermal conductivity and wear.
- Grinding Cones and plugs are designed for removing burrs and flash and finishing any type of metal surface in a confined area.



Reinforced and non reinforced cutting and grinding discs in a wide variety of sizes



Straight Cutting discs up to 2000mm diameter



Technical seminars and bespoke customer training courses





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Table of recommended speeds for abrasive wheels

Wheel diameter in millimeters	Maximum operating speed in m/s													
	10	12	16	20	25	32	35	40	45	50	63	80	100	125
6	31 900	38 200	51 000	64 000	80 000	102 000	112 000	128 000	143 500	160 000	201 000	-	-	-
8	24 000	29 000	38 200	48 000	60 000	76 500	84 000	95 500	107 500	120 000	150 500	191 000	-	-
10	19 100	23 000	30 600	38 200	48 000	61 200	67 000	76 500	86 000	95 500	120 500	153 000	191 000	-
13	14 700	17 700	23 550	29 500	35 600	47 100	51 500	58 800	66 200	73 500	92 600	118 000	147 000	184 000
16	11 950	14 350	19 100	23 900	29 850	38 200	41 800	47 800	53 750	59 700	75 200	95 500	120 000	150 000
20	9 550	11 500	15 300	19 100	23 900	30 600	33 500	38 200	43 000	47 800	60 200	76 500	95 500	120 000
25	7 650	9 200	12 300	15 300	19 100	24 500	26 800	30 600	34 500	38 200	48 200	61 200	76 500	95 500
32	6 000	7 200	9 550	11 950	14 950	19 100	20 900	23 900	27 000	30 000	37 600	48 000	60 000	75 000
40	4 800	5 750	7 650	9 550	11 950	15 300	16 750	19 100	21 500	23 900	30 100	38 200	47 200	59 700
50	3 850	4 600	6 150	7 650	9 550	12 250	13 400	15 300	17 200	19 100	24 100	30 600	38 200	47 750
63	3 050	3 650	4 850	6 100	7 600	9 750	10 650	12 150	13 650	15 200	19 100	24 300	30 250	37 900
80	2 400	2 900	3 850	4 800	6 000	7 650	8 400	9 550	10 750	12 000	15 100	19 100	23 900	29 850
100	1 950	2 300	3 100	3 850	4 800	6 150	6 700	7 650	8 600	9 550	12 100	15 300	19 100	23 900
115	1 700	2 000	2 700	3 350	4 200	5 350	5 850	6 650	7 500	8 350	10 500	13 300	16 650	20 800
125	1 550	1 850	2 450	3 100	3 850	4 900	5 350	6 150	6 900	7 650	9 650	12 250	15 300	19 100
150	1 300	1 550	2 050	2 550	3 200	4 100	4 500	5 100	5 750	6 400	8 050	10 200	12 700	16 000
180	1 100	1 300	1 700	2 150	2 700	3 400	3 750	4 250	4 780	5 350	6 700	8 500	10 650	13 300
200	955	1 150	1 550	1 950	2 400	3 100	3 350	3 850	4 300	4 800	6 050	7 650	9 550	11 950
230	830	1 000	1 350	1 700	2 100	2 700	2 950	3 350	3 750	4 200	5 250	6 650	8 350	10 400
250	765	920	1 250	1 550	1 950	2 450	2 700	3 100	3 450	3 850	4 850	6 150	7 650	9 550
300	640	765	1 050	1 300	1 600	2 050	2 250	2 550	2 870	3 200	4 050	5 100	6 400	8 000
350/356	550	655	875	1 100	1 400	1 750	1 950	2 200	2 460	2 750	3 450	4 400	5 500	6 850
400/406	480	575	765	960	1 200	1 550	1 700	1 950	2 150	2 400	3 050	3 850	4 800	6 000
450/457	425	510	680	850	1 100	1 400	1 500	1 700	1 910	2 150	2 700	3 400	4 250	5 350
500/508	385	460	615	765	960	1 250	1 350	1 550	1 720	1 950	2 450	3 100	3 850	4 800
600/610	320	385	510	640	800	1 050	1 150	1 300	1 450	1 600	2 050	2 550	3 200	4 000
660	290	350	465	580	725	930	1 050	1 200	1 300	1 450	1 850	2 350	2 900	3 650
750/762	255	310	410	510	640	820	895	1 050	1 150	1 300	1 650	2 050	2 550	3 200
800/813	240	290	385	480	600	765	840	960	1 075	1 200	1 550	1 950	2 400	3 000
900/914	215	255	340	425	535	680	750	850	955	1 100	1 350	1 700	2 150	2 700
1 000/1 016	195	230	310	385	480	615	670	765	860	960	1 250	1 550	1 950	2 400
1 050/1 067	185	220	295	365	455	585	640	730	820	910	1 150	1 500	1 850	2 300
1 120	175	210	280	350	435	560	610	695	785	870	1 100	1 400	1 750	2 200
1 220	160	195	255	320	400	510	560	640	720	800	1 050	1 300	1 600	2 000
1 500	130	155	205	255	320	410	450	510	575	640	805	1 050	1 300	1 600

from BS EN 12413: 1999

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