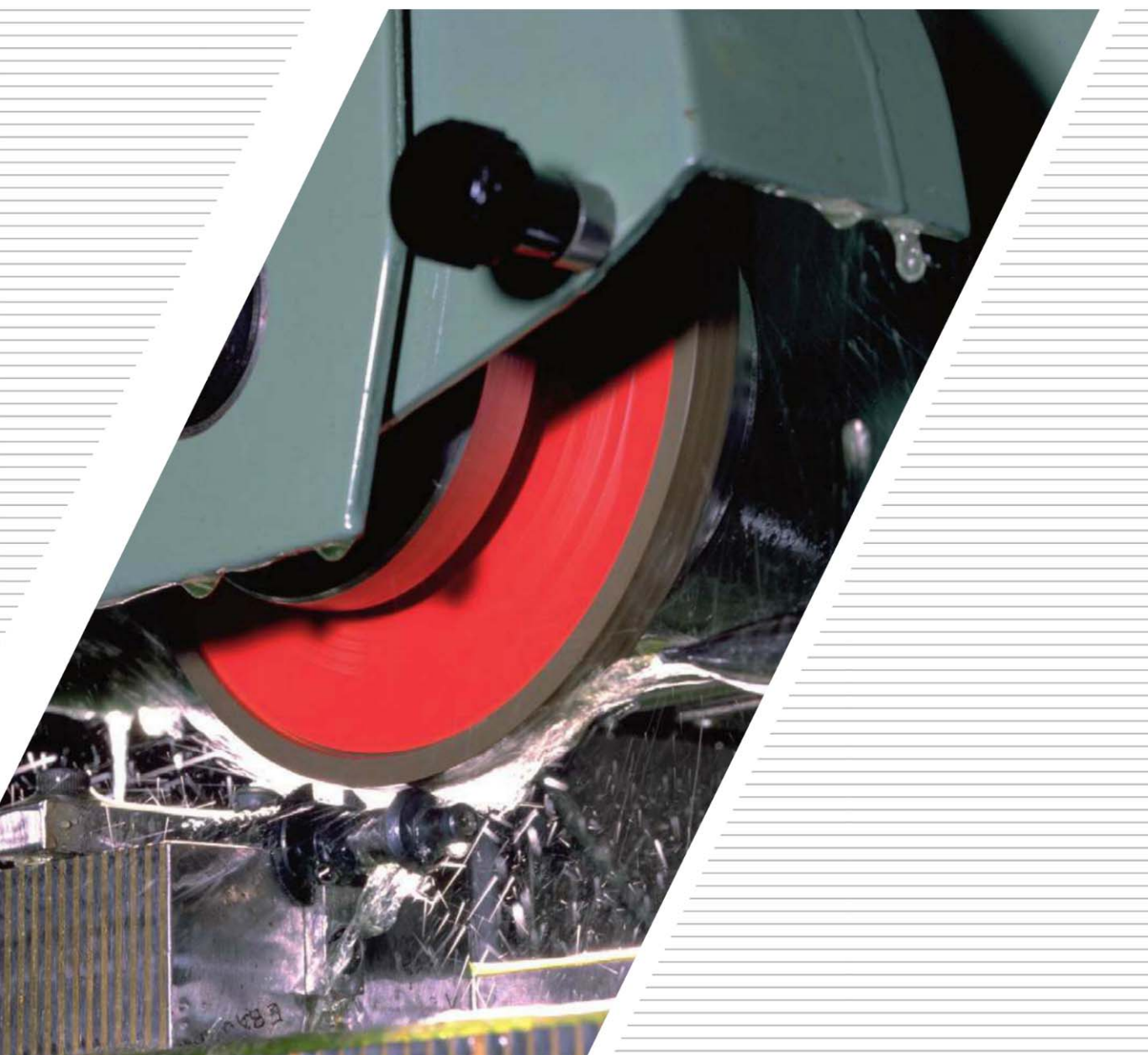


349-384 SUPER ABRASIVES



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SUPER
ABRASIVES

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INTRODUCTION

Diamond is the hardest material known to man, closely followed by Cubic Boron Nitride (CBN). As a result of their hardness these materials are used extensively in the most demanding precision grinding, slicing, and cutting applications. Super Abrasive wheels use diamond and CBN technology to cut demanding materials such as carbide, high speed steel, ceramics, and glass.

Norton provides ultimate, high performance Super Abrasive solutions for the cutting tools industry, offering products specifically designed to deal with the hardest and most challenging materials.

UNDERSTANDING THE PRODUCT

ASD	151	R	75	B99
ABRASIVE TYPE	GRIT SIZE	GRADE	CONCENTRATION	BOND
Both diamond & CBN have distinctive characteristics that meet the most demanding applications.	Size of the Super Abrasive particles according to FEPA standards. The smaller the number, the finer the grit size.	Refers to the degree of durability of the wheel, progressing alphabetically from A (softest, least durable) to Z (hardest, most durable).	Indicates the amount of Super Abrasive grits in the wheel. For CBN wheels the concentration number is included in the grade (Q=50, T=75, W=100, Z=125), concentration 100~4,4 ct/cm ³ , & accordingly 50~2,2 ct/cm ³ . The optimum concentration depends upon the application.	The element in a grinding wheel that holds the diamond or CBN grains together.
ASD: Synthetic diamond, armoured, high quality, versatile.				
CB: Cubic boron nitride, armoured, durable.				

WHEEL COLOUR



GRIT SIZE

The grit size selection depends on the required stock removal rate and the required surface finish.

EUROPEAN (FEPA) SIZE	U.S. STANDARD	US NORTON GRIT SIZE [MESH]	
	MESH	DIAMOND	CBN
1182	16/20	16	–
852	20/30	24	24
602	30/40	36	36
501	35/40	–	–
427	40/50	46	46
301	50/60	60	60
251	60/70	–	–
–	50/80	80	80C
252	60/80	100	80
213	70/80	–	–
181	80/100	105	100
–	80/120	100S	120C
151	100/120	110	120
126	120/140	120	150
107	140/170	150	180
91	170/200	180	220
76	200/230	220	230
64	230/270	240	240
54	270/325	320	320
46	325/400	400	400

APPROXIMATE EUROPEAN (FEPA) SIZE	NOMINAL MICRON SIZE	NORTON GRIT SIZE [MESH]
M63	40/60	–
M40	30/40	500
M25	20/30	–
M16	10/20	600
M10	6/12	800
M6,3	4/8	–
M4,0	2/4	–
M1,0	0/2	–

CONCENTRATION

The concentration influences the stock removal rate and the geometry of the workpiece.

DIAMOND 50/75/100/125 **CBN** Q/T/W/Z

BOND TYPES

B99 Extremely versatile resin bond used in advanced products both for wet and dry applications.

Aztec IV Premium teflon/silver bond used for dry grinding on in typical tool room applications.

ECO line Especially designed resin bonds for saw blade applications.

APPLICATIONS & MARKETS

Although both diamond and CBN are Super Abrasives, the areas of usage varies dramatically depending on the workpiece material.

DIAMOND

- Cemented carbide
- Glass
- Ceramics
- Fibreglass
- Plastics
- Stone
- Abrasives
- Electronic components and materials

CBN

- High speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hard stainless steel
- Abrasion-resistant ferrous materials

SUPER
ABRASIVES

DIAMOND
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POLISHING & MASKING



PROTECTION EQUIPMENT

- High quality synthetic diamond
- Pre-engineered resin bond - B99
- Optimised design

TECHNICAL INFORMATION

- High material removal rates. Longer wheel life using conventional silicon carbide wheels
- Free cutting; superior form holding. Efficient wet or dry
- Ideal for dry tool room reconditioning applications
- Ideal for 1A1R cut-off applications and grinding glass or ceramic materials
- Fast stock removal, cool cutting; excellent for dry off-hand finishing of carbide tools, no wheel dressing required
- Durable under high grinding forces. Excellent for wet off-hand finishing of carbide tools

A red circular abrasive disc, likely a flap wheel, with a central hole and a small label in the center. The disc is shown at an angle, highlighting its thickness and the texture of the abrasive material.

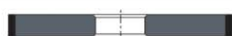
BENEFITS

- High quality durable CBN abrasive
- Pre-engineered resin bond - B99
- High performance Aztec IV bond
- Optimised design

- Easily cuts difficult to grind steel parts, HRC 50 or harder
- Highly wear resistant and thermally stable
- Free cutting, superior form holding
- Larger cutting depth
- Extremely efficient for dry tool re-sharpening especially when heavy stock removal is required

WHEEL SHAPES

1A1



Pages 355, 358, 367, 368

1A1R



Page 370

1A1W



Pages 364, 369

1V1



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4A2



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6A2



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14M1



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ROUND TOOLS

DIAMOND AND CBN GRINDING WHEELS FOR THE MACHINING OF ROUND TOOLS

Norton offers a comprehensive, newly designed product range for work on round tools such as drills, end mills and reamers. Diamond and CBN grinding wheels are ideal for producing and re-sharpening tungsten carbide and HSS tools.

The following sections are arranged by application for easy identification of the correct grinding wheel for fluting, gashing, grinding of clearance angles and re-sharpening. Within the sub-chapters the grinding wheels are ordered by FEPA code.



BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
R100 B99	↑	For CNC grinding operations (wet)
R75 B99		For universal grinding (wet or dry)
R50 B99		For universal grinding (wet or dry)

BOND OVERVIEW CBN

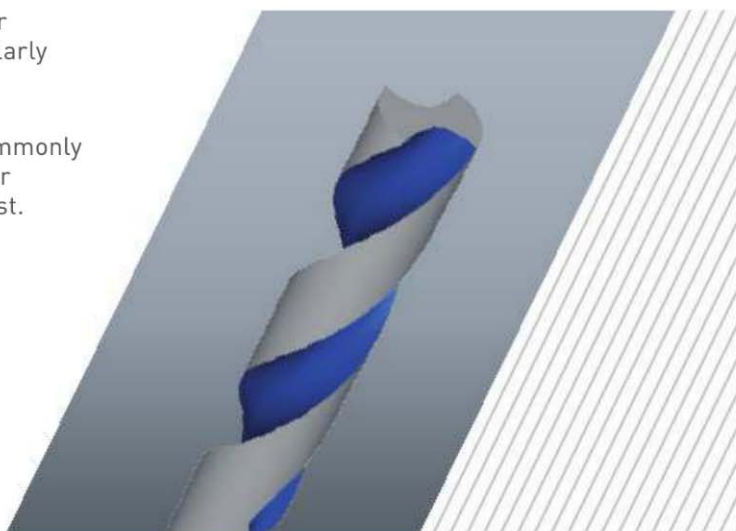
BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
W B99	↑	For CNC grinding operations (wet)
T B99		For universal grinding (wet or dry)
Aztec IV		Very free grinding dry grinding bond



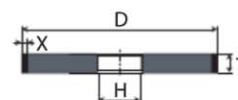
ROUND TOOLS CNC GRINDING

The Norton B99 resin bonded wheel is ideal for flute grinding on CNC machines and is particularly suitable for applications on standard tools.

D64R100B99 and B107 W B99 are the most commonly used products for flute grinding, however other specifications can be made available on request.

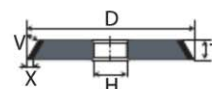


1A1 FLUTING



D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND						
100	6	3	32	1	ASD91 R100 B99	7958732719
	10	5	20	1	ASD64 R100 B99	7958732706
	12	5	20	1	ASD64 R100 B99	7958732713
	15	5	20	1	ASD64 R100 B99	7958732714
125	5	3	20	1	ASD126 R100 B99	7958732469
	10	10	20	1	ASD64 R100 B99	7958732470
	12	10	20	1	ASD64 R100 B99	7958732471
150	12	10	20	1	ASD64 R100 B99	7958732727
CBN						
100	10	5	20	1	CB107 W B99	7958732712
125	10	10	20	1	CB107 W B99	7958728828
100	15	5	20	1	CB107 W B99	7958732716

1V1 FLUTING



D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND							
100	10	5	10	20	1	ASD64 R100 B99	7958732976
	15	5	20	20	1	ASD64 R100 B99	7958732974
125	10	5	30	20	1	ASD64 R100 B99	7958732984
CBN							
100	15	5	20	20	1	CB107 W B99	7958732994

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& MASKING

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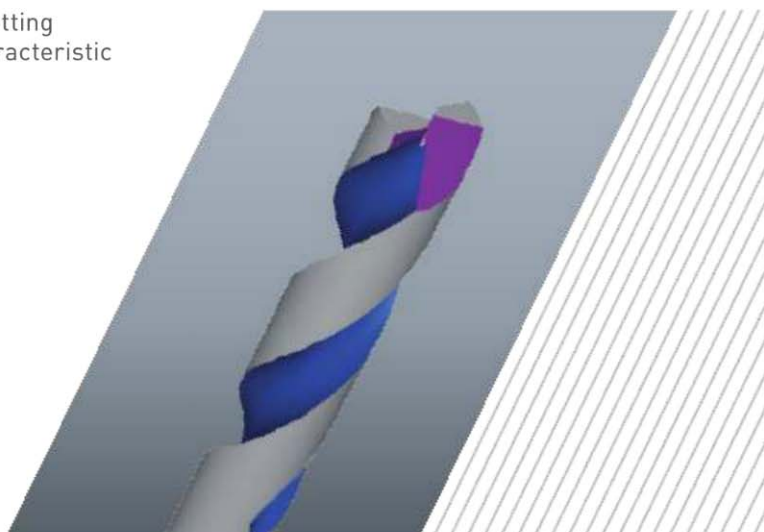
The state-of-the-art Norton B99 resin bond is free cutting and has good corner stability, the most essential characteristic required for CNC gashing.

Two standard specifications are offered:

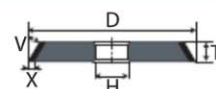
- for tungsten carbide tools: ASD64 R100 B99
- for HSS-tools: CB107 W B99.

Both are available in 12V9 as well as in 1V1 shape.

Further combinations of dimensions, grit sizes and concentrations are available on request.

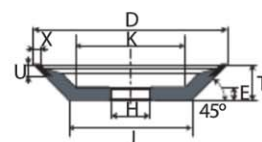


1V1 GASHING



D (mm)	T (mm)	X (mm)	V (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND								
100	15	5	45	20	1	ASD64 R100 B99	7958732996	
125	15	5	45	20	1	ASD64 R100 B99	7958733015	
CBN								
100	15	5	45	20	1	CB107 W B99	7958733013	
125	12	5	45	20	1	CB107 W B99	7958733017	

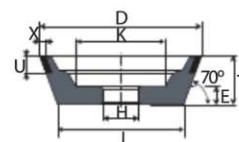
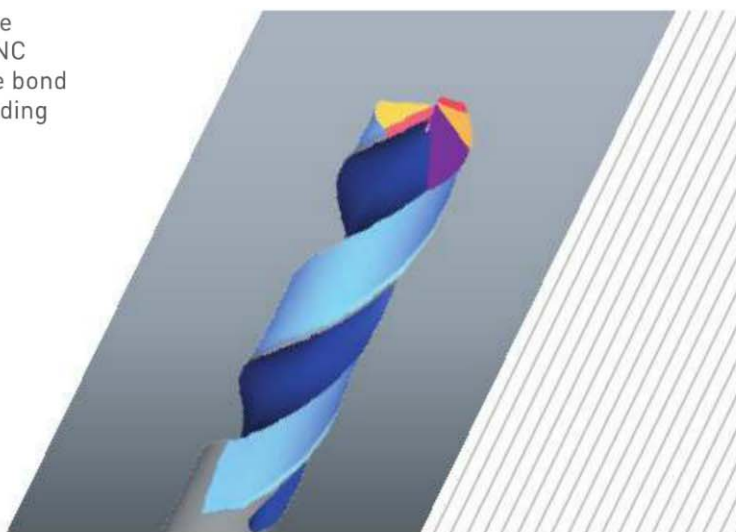
12V9 GASHING



D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND											
100	2	10	20	20	52	11	60	1	ASD64 R100 B99	7958732837	Stiffened body
	3	10	20	20	52	11	60	1	ASD64 R100 B99	7958732832	Stiffened body
125	2	10	20	25	60	12	74	1	ASD64 R100 B99	7958733019	Stiffened body
150	3	10	20	25	81	15	99	1	ASD64 R100 B99	7958732919	Stiffened body
CBN											
100	3	10	20	20	52	11	60	1	CB107 W B99	7958732826	Stiffened body
125	3	10	20	25	71	14	74	1	CB107 W B99	7958732814	Stiffened body
150	3	10	20	25	81	15	99	1	CB107 W B99	7958732920	Stiffened body

Norton B99 resin bond tools are an ideal choice for grinding clearances and relief angles on CNC machines. With excellent cutting behaviour the bond produces a good surface finish. The listed grinding wheels are suitable for the production and re-sharpening of tungsten carbide and HSS round tools.

D64 R100 and B107 W are the most common specifications for clearance angle grinding applications, however, other specifications are available on request.



11V9 CLEARANCE ANGLE GRINDING

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND											
75	2	10	20	30	40	10	53	1	ASD64 R100 B99	7958732849	Stiffened body
100	2	10	20	35	59	15	74	1	ASD64 R100 B99	7958732876	Stiffened body
	3	10	20	35	53	15	74	1	ASD64 R100 B99	7958732877	Stiffened body
125	3	10	20	40	70	18	95	1	ASD64 R100 B99	7958732856	Stiffened body
CBN											
75	2	10	20	30	40	10	53	1	CB107 W B99	7958732851	Stiffened body
100	2	10	20	35	59	15	74	1	CB107 W B99	7958732874	Stiffened body
	3	10	20	35	53	15	74	1	CB107 W B99	7958732844	Stiffened body
125	3	10	20	40	70	18	95	1	CB107 W B99	7958732854	Stiffened body

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PROTECTION
EQUIPMENT

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ROUND TOOLS UNIVERSAL GRINDING

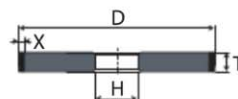
Norton offers a comprehensive selection of different bonds and concentrations for re-sharpening applications on universal machines. The B99 grinding wheels can be used wet or dry.

The lower the diamond or CBN concentration the more suited the product will be to grinding large contact areas.

Aztec IV is a special free cutting resin bond which is designed for dry grinding operations and enables high material removal.

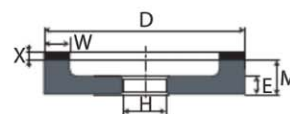


1A1 RE-SHARPENING

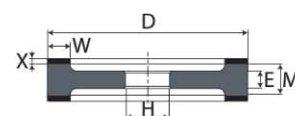


D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND						
100	4	3	20	1	ASD91 R75 B99	7958732717
	10	5	20	1	ASD91 R75 B99	7958732711
125	10	5	20	1	ASD126 R100 B99	7958732466
150	10	3	20	1	ASD126 R50 B99	7958732724
	10	3	32	1	ASD126 R75 B99	7958732726
CBN						
100	10	3	20	1	CB126 T B99	7958732704
150	10	3	20	1	CB126 T B99	7958732725

6A2 RE-SHARPENING

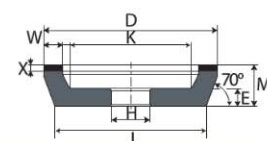


D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND								
100	6	4	20	23	10	1	ASD151 R75 B99	7958732881
	12	2	20	18	10	1	ASD54 R50 B99	7958732886
	12	2	20	18	10	1	ASD107 R50 B99	7958732879
125	6	5	20	25	10	1	ASD64 R75 B99	7958732922
	10	2	70	23	10	1	ASD107 R50 B99	7958732882
150	10	2	20	23	10	1	ASD91 R50 B99	7958732932
	15	2	32	23	10	1	ASD107 R50 B99	7958732933
	20	2	20	20	10	1	ASD126 R75 B99	7958732934
CBN								
125	6	4	20	23	10	1	CB151 T B99	7958732925
150	6	4	20	23	10	1	CB151 T B99	7958732936
	6	4	32	23	10	1	CB151 T B99	7958732935



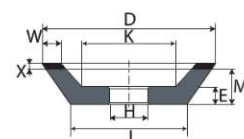
9A3 RE-SHARPENING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND								
175	5	2	20	30	14	1	ASD64 R50 B99	7958733005
	5	2	20	30	14	1	ASD126 R50 B99	7958733002



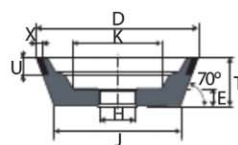
11A2-70° RE-SHARPENING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
100	5	4	20	20	75	10	88	1	ASD151 R75 B99	60157682163
CBN										
100	5	4	20	20	75	10	88	1	CB126 T B99	60157682165



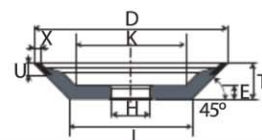
11V2 RE-SHARPENING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
100	5	3	20	20	72	8	82	1	ASD91 R75 B99	7958733007
	5	3	20	20	72	8	82	1	ASD126 R75 B99	7958733011



11V9 RE-SHARPENING

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
75	2	10	20	30	40	10	53	1	ASD107 R75 B99	7958732857
	2	10	20	30	40	10	53	1	ASD126 R75 B99	7958732859
100	2	10	20	35	55	10	74	1	ASD126 R75 B99	7958732867
	3	10	20	35	60	10	74	1	ASD126 R75 B99	7958732862
	3	10	32	35	60	10	74	1	ASD126 R75 B99	7958732865
125	3	10	20	40	81	10	96	1	ASD126 R75 B99	7958732847
	3	10	32	40	81	10	96	1	ASD126 R75 B99	7958732848
CBN										
75	1,5	10	20	30	40	10	53	1	BN181 Aztec IV	69014152323
	2	10	20	30	40	10	53	1	CB126 T B99	7958732853
100	1,5	10	20	35	55	10	75	1	BN126 Aztec IV	69014152115
	1,5	10	20	35	55	10	75	1	BN181 Aztec IV	69014152118
	1,5	10	32	35	55	10	75	1	BN181 Aztec IV	69014152120
	2	10	20	35	55	10	74	1	CB126 T B99	7958732869
	2	10	32	35	55	10	74	1	CB126 T B99	7958732871
	2	10	32	35	55	10	74	1	CB126 T B99	7958732871



12V9 RE-SHARPENING

D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
75	2	10	20	25	34	10	39	1	ASD64 R75 B99	7958732816
	2	6	20	20	45	10	42	1	ASD126 R75 B99	7958732811
	3	6	20	20	45	10	42	1	ASD76 R75 B99	7958732890
100	2	6	20	20	64	10	59	1	ASD126 R75 B99	7958732821
	3	10	20	20	65	10	59	1	ASD46 R75 B99	7958732885
CBN										
75	2	6	20	20	45	10	42	1	CB107 T B99	7958732813
100	2	6	20	20	65	10	59	1	CB126 T B99	7958732818
	3	10	20	20	65	10	59	1	CB126 T B99	7958732880

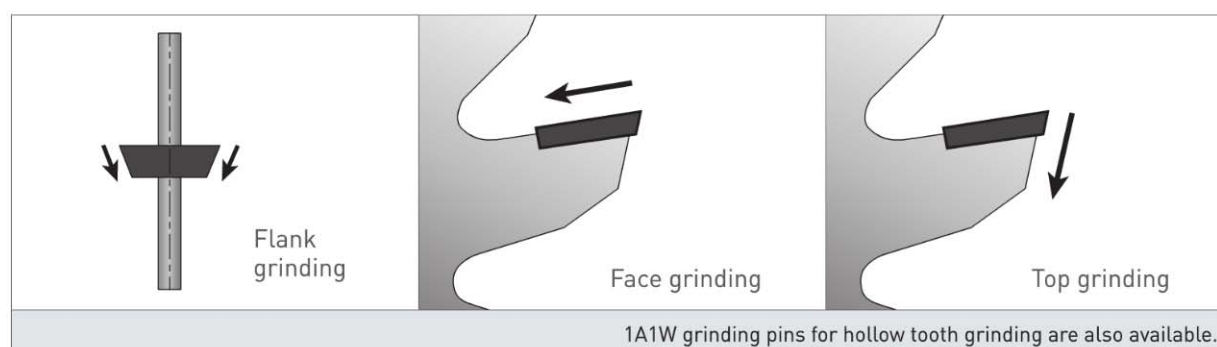
SAW BLADES

DIAMOND AND CBN GRINDING WHEELS

FOR THE SAW BLADE INDUSTRY

Norton provides a comprehensive range of diamond and CBN grinding wheels. With an emphasis on excellent price vs. performance ratios, the saw blade programme aims to provide the best solutions for grinding tungsten carbide tipped saw blades and one-piece HSS saws.

The tungsten carbide tipped circular saw blade grinding wheels have been specifically designed for face grinding and flank grinding. Norton offers grinding wheels for the most common machine types required for these applications.



BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Face	↑	Face grinding of tungsten carbide tipped saw blades
ECO Flank		Flank grinding of tungsten carbide tipped saw blades
ECO Top-AW		Top-grinding of tungsten carbide tipped saw blades on AKEMAT and WOODTRONIC machines
ECO Top		Universal top-grinding of tungsten carbide tipped saw blades
ECO Top-R		Top-grinding of tungsten carbide tipped saw blades, especially re-sharpening
ECO Top-P		Top-grinding of tungsten carbide tipped saw blades, especially production
B99		Universal resin bond for wet and dry grinding

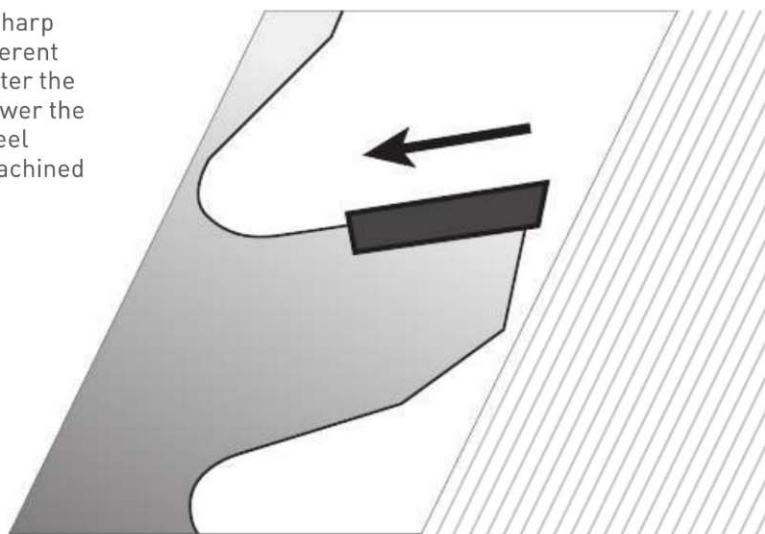
BOND OVERVIEW CBN

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
ECO Curve		Profiling and re-sharpening of HSS saw blades

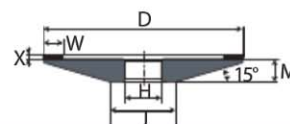
SAW BLADES TUNGSTEN CARBIDE TIPPED SAWS

The tooth face of circular saw blades is ground with sharp angled cup wheels. Depending on the tooth pitch, different angles and wheel thicknesses are required. The greater the number of teeth around the circumference, the narrower the space between them and the thinner the grinding wheel needs to be. Even the narrowest tooth gaps can be machined with our 12V9 **ECO** Face wheels.

For reasons of stability, conventional tooth gaps are mainly ground using 4A2 or 12V2 grinding wheels.



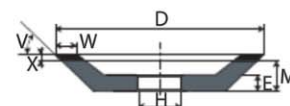
4A2 FACE GRINDING



D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND									
100	5	2	25*	7	51,5	1	ASD91 R75 B99	7958725784	For conventional tooth gaps

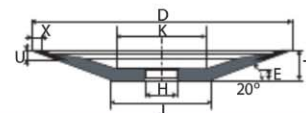
*4A2K (with Keyway)

12V2 FACE GRINDING



D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	V (mm)	E (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND										
125	4	2	32	11	30	9	1	ASD46 R125 B99	60157682189	For conventional tooth gaps
	4	2	32	11	30	9	1	ASD76 R125 B99	60157682188	For conventional tooth gaps
200	4	2	32	13	30	11	1	ASD46 R125 B99	7958725781	For conventional tooth gaps
	4	2	32	13	30	11	1	ASD76 R125 B99	7958725780	For conventional tooth gaps

12V9 FACE GRINDING

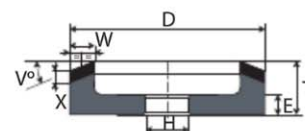
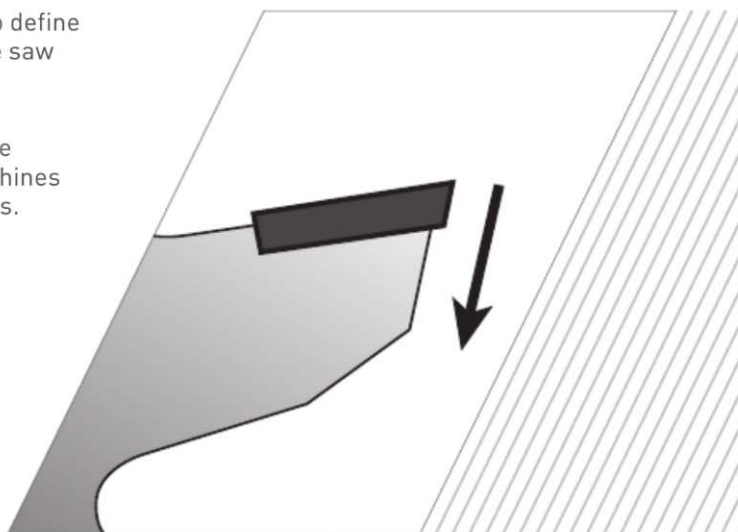


D (mm)	X (mm)	U (mm)	H (mm)	T (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND											
100	2,3	4	25*	10	77	7	51	1	D46 ECO Face	7958717431	For narrow tooth gaps
125	2,3	4	25*	10	101	7	76	1	D46 ECO Face	7958714565	For narrow tooth gaps
	2,3	4	32	13	101	10	70	1	D46 ECO Face	69014148184	For narrow tooth gaps
150	2,3	4	32	13	126	10	95	1	D46 ECO Face	7958719191	For narrow tooth gaps
200	2,3	4	32	13	173	10	145	1	D46 ECO Face	69014148205	For narrow tooth gaps

*12V9K (with keyway)

To ensure the circular nature of the saw and to define the wedge and clearance angles, the top of the saw blade needs to be ground.

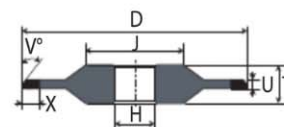
Vollmer and Widma machines normally require 6VV5 cup wheels Akemat and Woodtronic machines require 14M1 state of the art peripheral wheels.



6VV5 TOP GRINDING

D (mm)	W (mm)	X (mm)	V (mm)	H (mm)	T (mm)	E (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND										
100	5	10	8	25*	24	7	1	ASD126/46 R100/R75 ECO TOP	7958725658	Universal use
125	5	10	8	32	22	11	1	ASD126/46 R100/R75 ECO TOP	7958725660	Universal use
	5	10	8	32	22	11	1	ASD126/46 R100/R75 ECO TOP-P	7958725661	For production, oil
	5	10	8	32	22	11	1	ASD126/46 R125/R100 ECO TOP-R	7958725663	For re-sharpening

*6VV5K (with keyway)



14M1 TOP GRINDING

D (mm)	U (mm)	X (mm)	V (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND										
150	5	8	8	32	10	119	1	ASD107/46 R100/R75 ECO TOP-AW	7958725785	D126/D46: U=2,5/2,5
200	5	8	8	32	10	156	1	ASD126/46 R100/R75 ECO TOP-AW	7958725786	D126/D46: U=2,5/2,5

COLOUR CODES FOR MACHINE MANUFACTURERS

Vollmer-Biberach

Vollmer-Dornhan

Woodtronic

Akemat

Widma

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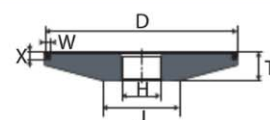
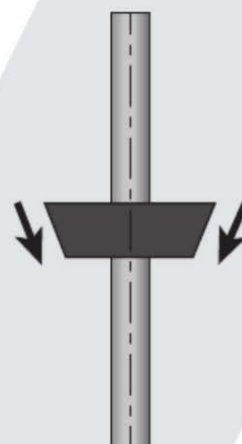
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During the flank grinding process the cutting width of the circular saw blade is defined. Therefore, typically two 4A9 grinding wheels are simultaneously fed from both sides.

When manufacturing saw blades there is a wide variety of tooth geometries and designs to choose from. Depending on the intended use of the saw, the tooth design can be flat, alternate, trapezoid or any combination of these. Hollow ground teeth are very common to achieve finer cuts with no burrs.

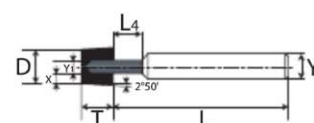
The rounded shape of hollow ground teeth is produced with 1A1W grinding pins.



4A9 FLANK GRINDING

D (mm)	X (mm)	W (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION			
DIAMOND												
80	4	5	32	10	53	1	ASD64 ECO Flank	7958725778			Universal use	
86	4	5	32	10	59	1	ASD64 ECO Flank	7958725779			Universal use	
100	4	4,5	20*	14	35	1	ASD64 ECO Flank	7958725739			Universal use	
	4	4,5	20*	14	35	1	ASD126 ECO Flank	7958725744			Universal use	
	4	5	32	10	55	1	ASD64 ECO Flank	7958725737			Universal use	
	4	5	32	10	55	1	ASD126 ECO Flank	7958725738			Universal use	

*4A9K (with Keyway)



1A1W HOLLOW TOOTH GRINDING

D (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	Y ₁ (mm)	L ₄ (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND										
6,5	3	1,75	6	42	4,1	10	1	ASD76 R125 B99	7958725782	For all common machines
7	3	2	6	42	5,1	10	1	ASD76 R125 B99	7958725783	For all common machines

COLOUR CODES FOR MACHINE MANUFACTURERS

Vollmer-Biberach

Vollmer-Dornhan

Woodtronic

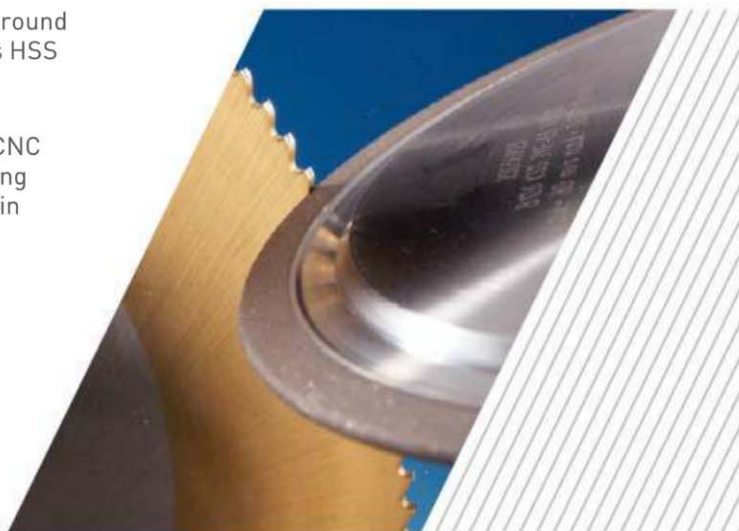
Akemat

Widma

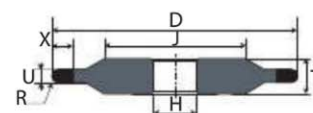
SAW BLADES HSS SAWS

HSS saw blades are one-piece saws that are ground from one solid piece of metal. For this process HSS saws require special grinding machines.

14F1 wheels grind the required profile under CNC control. Wheels are ideal for both initial profiling and re-sharpening thanks to the advanced resin bond systems which ensure the wheels are economic and extremely wear resistant.



14F1 INITIAL PROFILING AND RE-SHARPENING



D (mm)	U (mm)	X (mm)	R (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
CBN										
200	1,3	6,5	0,65	32	8	169	1	CB107 ECO Curve	7958706686	For Loroach machines
	1,6	7	0,8	32	8	164	1	CB107 ECO Curve	7958714307	For Loroach machines
	2	8	1	32	8	164	1	CB107 ECO Curve	7958706684	For Loroach machines
	2,5	8	1,25	32	8	159	1	CB107 ECO Curve	7958716444	For Loroach machines
	3	10	1,5	32	8	160	1	CB107 ECO Curve	7958718179	For Loroach machines
	4	12,5	2	32	8	157	1	CB107 ECO Curve	7958716216	For Loroach machines



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GENERAL ENGINEERING

DIAMOND AND CBN GRINDING WHEELS

FOR GENERAL ENGINEERING

Norton diamond and CBN wheels for general engineering are suitable for many grinding applications like OD-, ID-, and flat grinding, machining of knives, milling cutters and polishing.

Most of the bonds listed in this section are made with ASD (armoured synthetic diamonds) grit and are suitable for wet and dry grinding applications. Some wheels use AMD (armoured metal bond diamonds) which are more wear resistant but require a coolant.

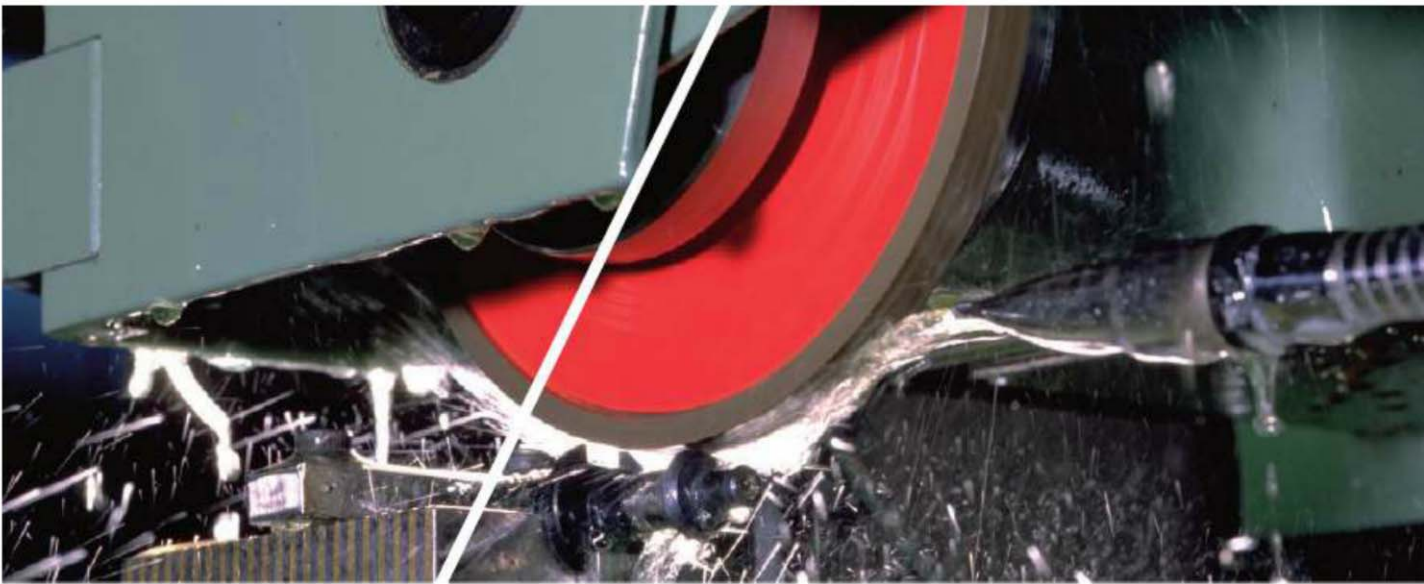
More information about the application can be found in the relevant sub-chapters.

BOND OVERVIEW DIAMOND

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
R100 B99	↑	For universal grinding (wet or dry)
R75 B99		For universal grinding (wet or dry)
R50 B99		For universal grinding (wet or dry)

BOND OVERVIEW CBN

BOND	WEAR RESISTANCE	RECOMMENDATION FOR USE
W B99	↑	For universal grinding (wet or dry)
T B99		For universal grinding (wet or dry)
Q B99		For universal grinding (wet or dry)



GENERAL ENGINEERING

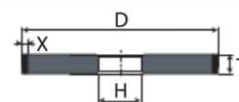
Norton offers a comprehensive stock programme for resin bonded 1A1 standard grinding wheels designed for OD- and flat grinding tungsten carbide and steel parts.

All specified grinding wheels can be used for OD- and flat grinding. However wheels (R50) with lower concentration have been specifically designed for flat grinding operations.

Other specifications are available on request.



1A1 OD- AND FLAT GRINDING



D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND						
175	15	3	32	1	ASD126 R50 B99	7958732730
200	10	3	32	1	ASD126 R75 B99	7958732731
	10	3	51	1	ASD126 R75 B99	7958732732
	15	3	32	1	ASD126 R75 B99	7958732840
250	15	3	76,2	1	ASD126 R75 B99	7958732804
300	10	3	127	1	ASD126 R75 B99	7958732824
	15	3	127	1	ASD126 R75 B99	7958732810
	20	3	127	1	AMD126 R50 B99	7958732812
350	15	3	127	1	ASD126 R50 B99	7958788919*
	20	3	127	1	ASD126 R50 B99	7958788920*
	30	3	127	1	ASD126 R50 B99	7958788921*
400	15	3	127	1	ASD126 R50 B99	7958788923*
	20	3	127	1	ASD126 R50 B99	7958788924*
	30	3	127	1	ASD126 R50 B99	7958788925*
CBN						
200	10	3	51	1	CB126 T B99	7958732803
	15	3	32	1	CB126 Q B99	7958732838
	15	3	76,2	1	CB126 T B99	7958732835
250	20	3	76,2	1	CB126 Q B99	7958732802
300	15	3	127	1	CB126 T B99	7958732808
	20	3	127	1	CB126 Q B99	7958732815
	15	3	127	1	CB126 Q B99	7958788927*
350	20	3	127	1	CB126 Q B99	7958788928*
	30	3	127	1	CB126 Q B99	7958788929*
	15	3	127	1	CB126 Q B99	7958788930*
400	20	3	127	1	CB126 Q B99	7958788932*
	30	3	127	1	CB126 Q B99	7958788933*

* Made-to-order

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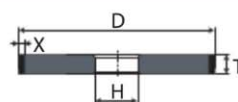
TECHNICAL
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GENERAL ENGINEERING

Resin bonded grinding pins and grinding wheels can be used for wet or dry applications, either manually or on automatic grinding machines.

To avoid burning and to ensure stable grinding conditions the diameter must be carefully selected. It is highly recommended to choose a diameter no bigger than 70% of the bore. When using grinding pins it is very important to follow the permitted speed instructions, which are engraved on the grinding tool.

If the permitted speed is slower than the adjustable speed of the grinding spindle, a different technical solution is required.



1A1 ID- GRINDING

D (mm)	T (mm)	X (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND						
15	12	2	6	1	ASD126 R100 B99	7958732728
20	10	2	6	1	ASD126 R100 B99	7958732950
25	10	2	6	1	ASD126 R75 B99	7958732942
30	10	3	6	1	ASD126 R75 B99	7958732952
	10	3	10	1	ASD126 R75 B99	7958732956
40	15	3	10	1	ASD126 R75 B99	7958732971
50	15	3	20	1	ASD126 R75 B99	7958732977
CBN						
12	10	2	6	1	CB126 W B99	7958732722
15	12	2	6	1	CB126 W B99	7958732729
20	10	2	6	1	CB126 W B99	7958732948
	15	2	6	1	CB126 W B99	7958732957
25	10	2	10	1	CB126 W B99	7958732945
	12	2	10	1	CB126 W B99	7958732939
30	15	3	10	1	CB126 W B99	7958732937
40	15	3	10	1	CB126 W B99	7958732961
50	15	3	20	1	CB126 W B99	7958732981

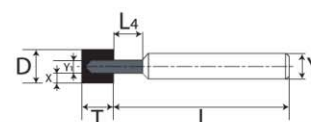
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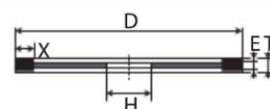
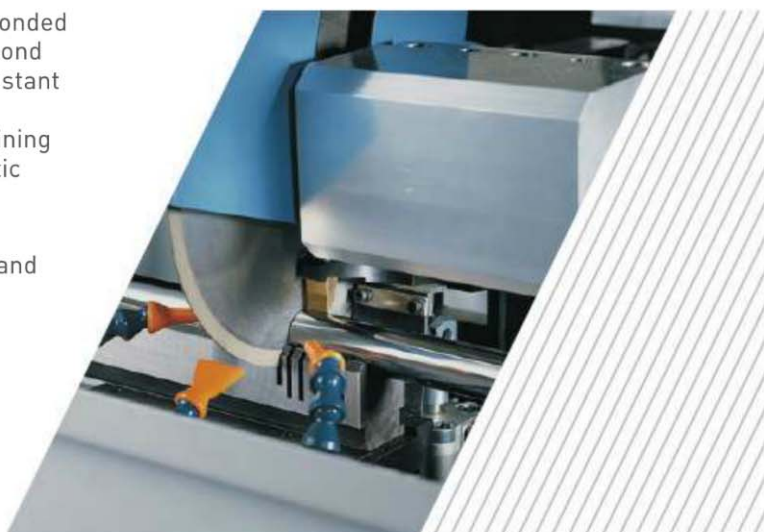
1A1W ID- GRINDING

D (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	Y ₁ (mm)	L ₄ (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND									
3	6	0,65	3	60	1,7	8	1	ASD64 R100 B99	7958732951
	6	0,65	3	60	1,7	8	1	ASD126 R100 B99	7958732949
5	6	1,5	3	60	2,1	8	1	ASD64 R100 B99	7958732944
	6	1,5	3	60	2,1	8	1	ASD126 R100 B99	7958732943
6	6	1,5	6	60	3,1	8	1	ASD64 R100 B99	7958732940
	6	1,5	6	60	3,1	8	1	ASD126 R100 B99	7958732941
8	10	2	6	60	4,1	12	1	ASD64 R100 B99	7958732954
	10	2	6	60	4,1	12	1	ASD126 R100 B99	7958732953
10	10	2	6	60			1	ASD64 R100 B99	7958732959
	10	2	6	60			1	ASD126 R100 B99	7958732960
12	12	2	6	60			1	ASD64 R100 B99	7958732963
	12	2	6	60			1	ASD126 R100 B99	7958732964
CBN									
3	6	0,65	3	60	1,7	8	1	CB126 W B99	7958732947
5	6	1,5	3	60	2,1	8	1	CB126 W B99	7958732946
6	6	1,5	6	60	3,1	8	1	CB126 W B99	7958732938
8	10	2	6	60	4,1	12	1	CB126 W B99	7958732955
10	10	2	6	60			1	CB126 W B99	7958732958
12	12	2	6	60			1	CB126 W B99	7958732962

GENERAL ENGINEERING

Norton offers a small assortment of standard resin bonded cut-off grinding wheels (ex stock). The specified diamond cut-off wheels cut hard, short-chipping and wear resistant materials such as glass, ceramics and carbide. The contained CBN cut-off wheels are ideal for machining high speed steel, hardened steel, 55 HRC and magnetic materials.

Further specifications for resin bond, sintered metal and electroplated metal bond are available on request.



1A1R CUT-OFF

D (mm)	T (mm)	X (mm)	E (mm)	H (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND							
100	0,9	5	0,7	20	1	ASD126 R75 B99	60157681683
125	1	5	0,7	20	1	ASD126 R75 B99	60157681686
150	1	5	0,8	20	1	ASD126 R75 B99	60157681688
CBN							
100	0,9	5	0,7	20	1	CB151 T B99	60157681767
125	1	5	0,7	20	1	CB151 T B99	60157682094
150	1	5	0,8	20	1	CB151 T B99	60157682103

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GENERAL ENGINEERING KNIFE GRINDING

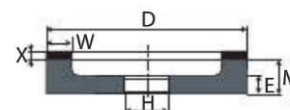
Norton offers a range of resin bonded grinding wheels for machining flat, circular and profile knives (ex stock).

The 6A2 grinding wheels are specifically designed for wet grinding of circular knives with tungsten carbide-steel combinations on Göckel and Reform machines.

The 14F1 grinding wheels are designed for use on Weinig machines for grinding profile knives for the wood industry.

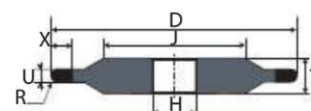


6A2 FLAT GRINDING



D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	E (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND									
200	8	4	50	31	23	1	AMD126 R100 B99	7958732926	For Göckel machines
	8	4	75	31	23	1	AMD126 R100 B99	7958732850	For Reform machines

14F1 PROFILE GRINDING



D (mm)	U (mm)	X (mm)	R (mm)	H (mm)	T (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.	ADDITIONAL INFORMATION
DIAMOND										
200	2	7	1	60	10	129	1	ASD64 R100 B99	7958732992	For Weinig machines
	4	7	2	60	10	134	1	ASD151 R100 B99	7958732986	For Weinig machines
CBN										
200	2	7	1	60	10	129	1	CB126 T B99	7958732990	For Weinig machines
	4	7	2	60	10	134	1	CB151 W B99	7958732988	For Weinig machines

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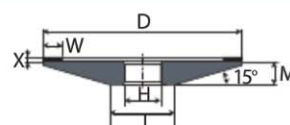
TECHNICAL
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GENERAL ENGINEERING MILLING CUTTER

Grinding tool faces and clearances are the main applications of the milling cutter.

Norton offers a diverse range of grinding wheels to enable excellent performance in both applications. A comprehensive range of grit sizes and concentrations provides the ideal solution for each application (ex stock).

The price vs. performance ratio of these tools is the underlying benefit of this product range.



4A2 FACE GRINDING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND								
100	5	2	20	6	66	1	ASD64 R75 B99	7958732965
125	5	2	20	7	84	1	ASD64 R75 B99	7958732868
	5	2	20	7	84	1	ASD126 R75 B99	7958732870
	5	2	32	7	84	1	ASD91 R75 B99	7958732866
	10	2	20	7	84	1	ASD107 R75 B99	7958732873
	10	2	32	7	84	1	ASD107 R75 B99	7958732873
150	5	2	32	9	94	1	ASD64 R75 B99	7958732863
	5	2	20	9	94	1	ASD126 R75 B99	7958732864
	5	2	32	9	94	1	ASD54 R50 B99	7958732858
	5	2	32	9	94	1	ASD91 R75 B99	7958732855
	5	2	32	9	94	1	ASD91 R75 B99	7958732855
175	5	4	32	11	104	1	ASD126 R75 B99	7958732929
CBN								
100	5	2	20	6	66	1	CB126 T B99	7958732884
150	5	4	20	9	94	1	CB107 T B99	7958732852
175	5	4	20	11	104	1	CB126 T B99	7958733000

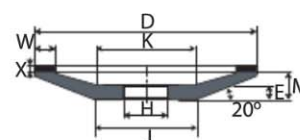
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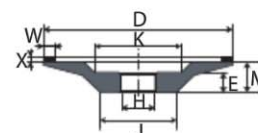
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12A2-20° FACE GRINDING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
125	5	2	20	14	54	8	54	1	ASD126 R75 B99	69014151721
	6	4	20	14	54	8	54	1	ASD126 R100 B99	60157682171
	6	4	32	14	54	8	54	1	ASD91 R75 B99	60157682172
150	5	2	20	16	68	9	68	1	ASD64 R50 B99	69014151397
	5	2	20	16	68	9	68	1	ASD126 R75 B99	69014151961
	5	2	32	16	68	9	68	1	ASD126 R75 B99	69014151963
	5	3	32	16	68	9	68	1	ASD64 R100 B99	60157682177
	5	3	32	16	68	9	68	1	ASD91 R100 B99	60157682176
	6	4	32	16	68	9	68	1	ASD91 R75 B99	60157682179
175	5	2	20	18	82	10	82	1	ASD126 R75 B99	69014151422
	5	2	32	18	82	10	82	1	ASD126 R75 B99	69014151424
CBN										
150	5	4	20	16	68	9	68	1	CB126 Q B99	69014151412
	6	4	32	16	68	9	68	1	CB126 T B99	60157682182
175	5	4	20	18	82	10	82	1	CB126 T B99	69014151427



13A2 FACE GRINDING

D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
125	5	4	20	19	50	9	73	1	ASD64 R50 B99	7958732980
	5	4	20	19	50	9	73	1	ASD126 R50 B99	7958732995
	5	4	20	19	50	9	73	1	ASD126 R75 B99	7958732991
CBN										
125	5	4	20	19	50	9	73	1	CB64 Q B99	7958732973
	5	4	20	19	50	9	73	1	CB107 Q B99	7958732979
	5	4	20	19	50	9	73	1	CB151 Q B99	7958732978

SUPER
ABRASIVES

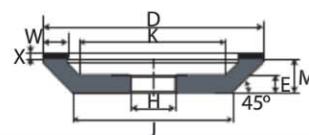
DIAMOND
TOOLS

CLEANING,
POLISHING
& MASKING

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INFORMATION

12A2-45° TOP GRINDING



D (mm)	W (mm)	X (mm)	H (mm)	M (mm)	K (mm)	E (mm)	J (mm)	PK QTY	SPECIFICATION	ART. NO.
DIAMOND										
100	5	2	20	23	54	10	56	1	ASD107 R50 B99	7958732999
	6	3	20	20	64	10	62	1	ASD76 R75 B99	7958732968
	6	3	20	20	64	10	62	1	ASD126 R75 B99	7958732966
125	6	3	32	23	83	10	81	1	ASD126 R75 B99	7958732969
CBN										
100	5	2	20	23	54	10	56	1	CB126 Q B99	7958732997
125	6	2	20	23	83	10	81	1	CB126 T B99	7958732970

GENERAL ENGINEERING DIAMOND LAPPING COMPOUNDS

Norton lapping compounds are supplied in a standard concentration of 5g dispenser syringes. Perfectly sized synthetic diamond powder is mixed with a paste. When used, this compound should be diluted with water or alcohol.

APPLICATIONS & MARKETS

- Used for lapping an extremely wide range of parts by hand
- Superfinishing of electronic components, semi-conductors, magnetic heads, rigid discs and optical discs
- Finishing for routine operations
- Preparatory lapping
- Fast removal of material, roughing



DIAMOND COMPOUND PASTE



FEATURES

- Optimised diamond grit distribution

BENEFITS

- Easy and safe application

GRADE (MICRONS)	COLOUR	CONTENTS	PK QTY	ART. NO.
1/4	GREY	5g	1	69014154990
1/2	LIGHT GREY	5g	1	69014154991
1	IVORY	5g	1	69014154992
3	YELLOW	5g	1	69014154993
6	ORANGE	5g	1	69014154994
9	GREEN	5g	1	69014154995
12	LIGHT BLUE	5g	1	69014154996
15	BLUE	5g	1	69014154997
20	BROWN	5g	1	69014154998
30	RED	5g	1	69014154999
45	CHESTNUT	5g	1	69014155000
60	VIOLET	5g	1	69014155001

GENERAL ENGINEERING DIAMOND FILES

Norton offers a range of diamond files in various shapes.

APPLICATIONS & MARKETS

- Deburring
- Tool profiling
- Touching up hardened steels and metal carbides
- Glass
- Ceramics
- Hard plastics



FILES



FEATURES

- Several shapes available

BENEFITS

- Free cutting and very high wear resistant, requiring only low contact pressure

SHAPE	T (mm)	H (mm)	L (mm)	PK QTY	ART. NO.
	1,4	4,8	140	6	60157636812
	1,9	5,3	140	6	60157636813
	3,6	3,6	140	6	60157636814
	2,5	2,5	140	6	60157636815
	Ø	3,0	140	6	60157636816*
	1,4	4,8	140	6	60157636817
Set - all above				6	60157636811

* Made-to-order

Dimensions Key: T = Thickness, H = Height, L = Length

DIAMOND DRESSERS

Norton stationary diamond dressing tools have a worldwide reputation for quality and technology.

APPLICATIONS & MARKETS

- For the profiling and straight dressing of all conventional grinding wheels



PRODUCT SELECTION

Usage Key • Highly recommended ◦ Recommended	GENERAL CHOICE					
	STRAIGHT GRINDING WHEELS WITH NO PROFILE	PROFILED GRINDING WHEELS	GRIT	AUTOMATIC DRESSING PROCESS	ECONOMICAL DRESSING	HIGH REMOVAL RATE
DRESSING TOOL						
Single-point	◦		All			
Multi-point	•		36-180		•	•
Blade tool dresser	•	◦	36-180	•	•	◦
Profile dresser		•	80-180			

SUPER ABRASIVES

DIAMOND TOOLS

CLEANING, POLISHING & MASKING

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SPEC CHECK

- A new dressing tool should be put through at least 5 dressing cycles in order to fit the diameter of the grinding wheel
- The lifetime of the dressing tool is extended by ensuring that adequate coolant pressure and volume are directed at the tool.

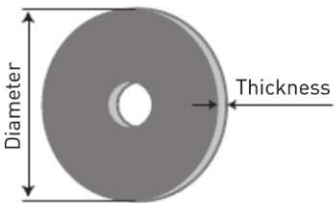
SELECTION OF BLADE TOOL DRESSERS

Dressing of profiles with blade tools	Dressing tools use a 'needle' form of natural or synthetic diamonds. Needle diamonds are especially suited to dressing profiles using infeds and angular feeds.
Natural diamonds	An effective diamond layer with a length of up to 15mm creates an economical dressing solution. Using precise diamond setting patterns, with overlapped rows of stones, ensures that consistent dressing results are achieved.
Synthetic diamonds	The constant cross section given by synthetic diamonds, guarantees a constant dressing behaviour through the complete life of the dressing tool.

SELECTION OF GRIT SIZE

Grit size of grinding wheel	Synthetic diamond size	Natural diamond size
46	0,8x0,8	D1181
60	0,8x0,8	D1001
80-120	0,6x0,6	D711

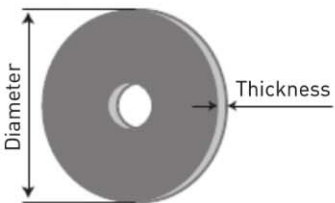
SELECTION OF TOOL SIZE

	Diameter x Thickness (mm)	No. of synthetic needles	Dimensions
	<35000	2	10,5x28
	35000-60000	3	20,5x28
	60000-100000	4	20,5x28

CHOICE OF SINGLE-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed. In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS

	Diameter x Thickness (mm)	Carat
	< 6000	0,33 Carat
	6000 - 18000	0,50 Carat
	> 18000	1,0 Carat

For best results, always use a coolant when dressing

BLADE TOOL DRESSERS HPB-D 3565 & 3585

BEST +++++



FEATURES

- Synthetic multi-crystalline diamond

BENEFITS

- Gives the most repeatable and consistent dresser for the highest demands in profiling and straight dressing

W (mm)	L (mm)	DL (mm)	GRIT	PK QTY	SPECIFICATION	ART. NO.
10,5	28	4	0,6x0,6	1	HPB-D 3565 / 2	60157682820
	28	4	0,6x0,6	1	HPB-D 3565 / 3	60157682856
	28	4	0,6x0,6	1	HPB-D 3565 / 4	60157682895
	28	4	0,8x0,8	1	HPB-D 3585 / 2	60157682899
	28	4	0,8x0,8	1	HPB-D 3585 / 3	60157682902
	28	4	0,8x0,8	1	HPB-D 3585 / 4	60157682904

BLADE TOOL DRESSERS HPB-D & -C 30, 45, 60

BETTER ++++



FEATURES

- Natural diamond

BENEFITS

- An economical dressing solution for all Alox and SiC wheels. Needles are recommended for profile dressing

W (mm)	L (mm)	DL (mm)	GRIT	PK QTY	SPECIFICATION	ART. NO.
10,5	28	12	D711	1	HPB-D 30	60157682759*
	28	12	D1001	1	HPB-D 45	60157682782
	28	12	D1181	1	HPB-D 60	60157682786
	28	12	NEEDLE	1	HPB-D	60157682790
20,5	28	10	D711	1	HPB-C 30	60157682801
	28	10	D1001	1	HPB-C 45	60157682806
	28	10	D1181	1	HPB-C 60	60157682809
	28	10	NEEDLE	1	HPB-C	60157682814

* Made-to-order

SCREWED SHANKS FOR BLADE TOOL DRESSERS

DIA (mm)	L (mm)	SHANK CODE	PK QTY	BEST	
12,065	40	MT1	1	HPB-H3	60157682832
9,045	25,5	MT0	1	HPB-H4	60157682907
11,11	50	Z11,11	1	HPB-H2	60157682910
10,00	50	Z10	1	HPB-HX	60157682911

Dimensions Key: DIA = Diameter, W = Width, L = Length, DL = Diamond Length

SUPER ABRASIVES

DIAMOND TOOLS

CLEANING, POLISHING & MASKING

PERSONAL PROTECTION EQUIPMENT

TECHNICAL INFORMATION

SINGLE-POINT DRESSER BC SG

BEST +++++



FEATURES

- Highest quality diamonds
- High performance tools

BENEFITS

- Specifically developed for dressing ceramic abrasive (SG/TG) wheels which require faster traverse speed dressing
- Enables dressing costs to be reduced, especially at production grinding stations

SHANK (mm)	CARAT	PK QTY	ART. NO.
Z8	0,50	1	66260161757
	1,00	1	66260161755
Z10	0,33	1	66260161769
	0,50	1	66260161768
	1,00	1	66260161766
Z11,11	0,33	1	66260156906
	0,50	1	66260156907
	1,00	1	66260157010
Z12	0,50	1	66260161779
	1,00	1	66260161777

SINGLE-POINT DRESSER BC (CYLINDRICAL SHANK)

BETTER ++++



FEATURES

- Standard diamonds
- Economy product

BENEFITS

- Ideal for applications where it is difficult to measure the performance of the dressing tool
- Suitable for dressing conventional abrasive wheels

SHANK (mm)	CARAT	PK QTY	ART. NO.
Z8	0,33	1	66260161753
	0,50	1	66260161752
	1,00	1	66260161750
Z10	0,33	1	66260161764
	0,50	1	66260161763
	1,00	1	66260161761
Z11,11	0,33	1	66260195003
	0,50	1	66260195005
	1,00	1	66260195009
Z12	0,33	1	66260161775
	0,50	1	66260161774

SINGLE-POINT DRESSER SP (MK- SHANK)

GOOD +++



FEATURES

- Commercial standard diamonds

BENEFITS

- Standard dresser for conventional abrasive wheels

SHANK (mm)	CARAT	PK QTY	ART. NO.
MK0	0,3	1	69014119596
	0,5	1	69014119598
	1,0	1	69014119599
	1,5	1	69014119600
MK1	0,3	1	69014119570
	0,5	1	69014119591
	1,0	1	69014119594
	1,5	1	69014119595

PROFILE DRESSER

BEST +++++



FEATURES

- Extremely high performance tools

BENEFITS

- Used to meet extremely high profile accuracy requirements

SHANK (mm)	RADIUS (mm)	ANGLE	SPECIFICATION	ART. NO.
Z9,52	0,13	40°	DC 40/130	60157682850
	0,25	40°	DC 40/250	60157682889
	0,50	40°	DC 40/500	60157682901
	0,13	60°	DC 60/130	60157682903
	0,25	60°	DC 60/250	60157682905
	0,50	60°	DC 60/500	60157682909

SUPER ABRASIVES

DIAMOND TOOLS

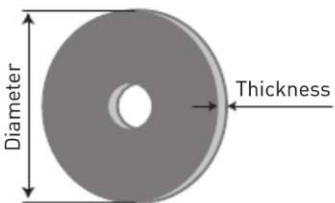
CLEANING, POLISHING & MASKING

PERSONAL PROTECTION EQUIPMENT

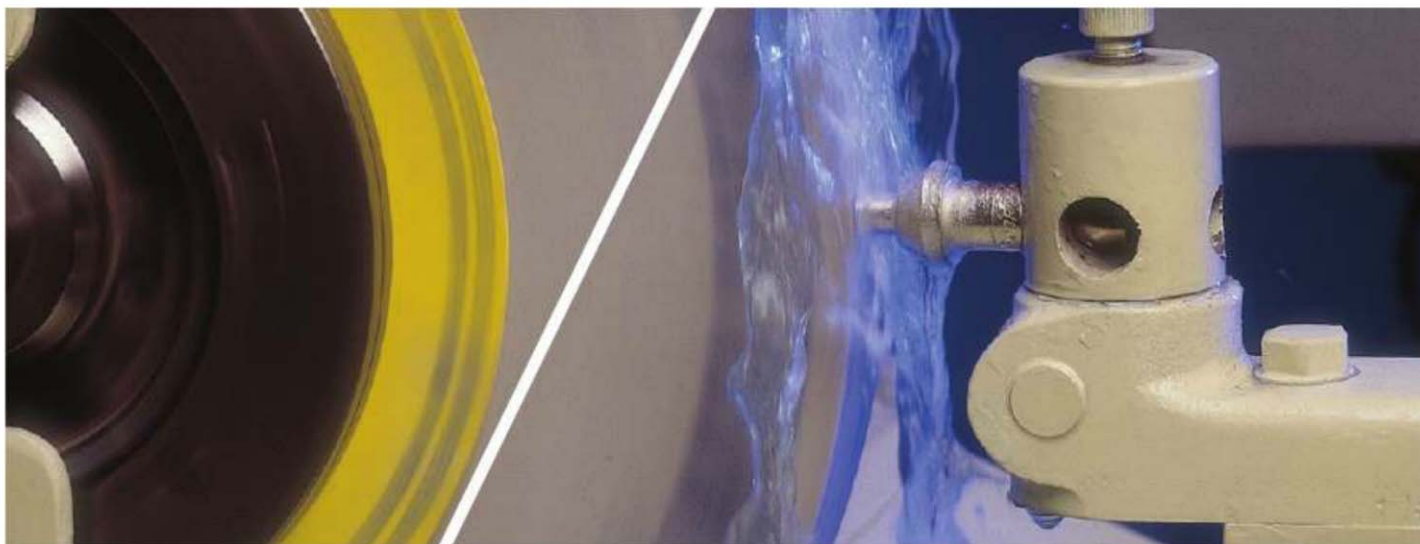
TECHNICAL INFORMATION

CHOICE OF MULTI-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed.
In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS		
	Diameter x Thickness (mm)	Carat
	< 30000	1,3 Carat
	30000 – 60000	2,5 Carat
	> 60000	5,0 Carat
For best results, always use a coolant when dressing		

CHOICE OF DIAMOND GRIT	
Wheel abrasive	Diamond
80-120	D301
60-80	D711
46-60	D1001
36-46	D2240



MULTI-POINT DRESSER

BEST +++++



FEATURES

- Economical and robust tool

BENEFITS

- Ideal for straight dressing at high speed with low technical demands

TYPE	SHANK (mm)	GRIT	PK QTY	ART. NO.
D11X11 (5 CARAT)	Z8	D2240	1	60157682849
		D1001	1	60157682896
		D711	1	60157682906
	Z10	D2240	1	60157682892
		D1001	1	60157682897
		D711	1	60157682908
	Z11,11	D2240	1	60157682893
		D1001	1	60157682898
		D711	1	60157682912
	MT1 12,065	D2240	1	60157682894
		D1001	1	60157682900
		D711	1	60157682914
D8X11 (2,5 CARAT)	Z8	D2240	1	60157682915
		D1001	1	60157682920
		D711	1	60157682970
	Z10	D2240	1	60157682916
		D1001	1	60157682922
		D711	1	60157682968
	Z11,11	D2240	1	60157682917
		D1001	1	60157682923
		D711	1	60157682977
	MT1 12,065	D2240	1	60157682918
		D1001	1	60157682925
		D711	1	60157682981
D6X8 (1,3 CARAT)	Z8	D711	1	60157682986
		D301	1	60157683153
	Z10	D711	1	60157682990
		D301	1	60157683154
	Z11,11	D711	1	60157682992
		D301	1	60157683155
	MT1 12,065	D711	1	60157682996
		D301	1	60157683156

SUPER
ABRASIVES

DIAMOND
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HAND DRESSER



FEATURES

- High diamond concentration
- Grit 18/25 SPC

BENEFITS

- High wear resistance and long product life time
- Suitable for face and side dressing

PK QTY	SPECIFICATION	ART. NO.
1	HD-150	60157682852

BRAKE CONTROLLED TRUING DEVICE



FEATURES

- For fast effective truing of Diamond and CBN wheels with minimum loss of abrasive

BENEFITS

- Ideal for truing the following diamond and CBN wheel types: straight wheels with diamond in the periphery, tool and cutter grinding wheels, wheels used on surface and cylindrical grinding machines, cut-off wheels and internal grinding wheels and cup wheels with diamonds in the rim, as used on vertical spindle surface grinders

PK QTY	SPECIFICATION	ART. NO.
1	BCTD	66260274459

REPLACEMENT WHEELS

DIA (mm)	T (mm)	B (mm)	PK QTY	BEST	
80	25	13	10	Wheel 37C60-NV	69936668764

Dimensions Key: DIA = Diameter, T = Thickness, B = Bore



SPEC CHECK

- Mount the device spindle parallel to the wheel spindle to ensure correct straight face truing
- For cup shaped wheels, the device spindle will be mounted perpendicularly to the wheel spindle
- Use appropriate traverse rates.