



DIAMOND AND CBN TOOLS FABRICANT

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Dressing

Dressing is used to correct diamond wheels by reducing wheel impacts.

Warning : Dressing is not better for cutting performance, you will have to sharpen the wheel after a sharpening operation to have a good cutting power.

Dressing works with a brake dresser which is installed on the machine.

Brake dresser is equipped with corundum grinding wheel and with an adjustment wheel use to set up with your hand before the contact with the diamond wheel.

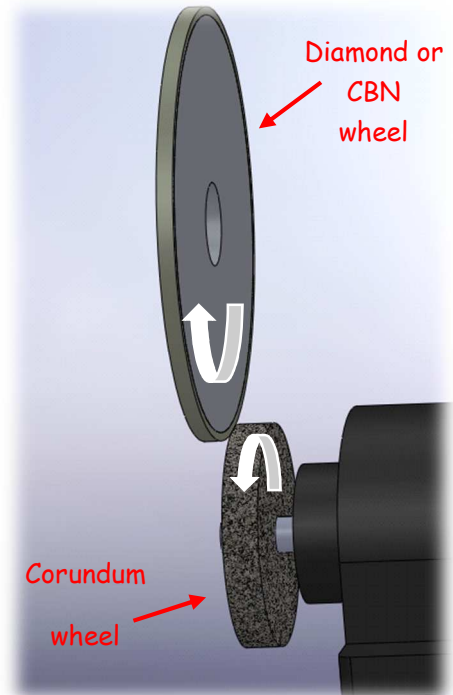
Please consider and respect the way of rotation of the corundum grinding wheel (visible on the dresser).

Dressing speed:

Diamond or CBN wheels : C50 to 75 : 6 to 8 m/s
C>100 : 3 to 5 m/s

Feed depth must be about 0,03mm.

For high concentrations, reduce the cutting speed of the diamond wheel.



Wheels used for brake dressers

Corundum wheels are less resistant than diamond or CBN wheels. For this reason, we propose replacement wheels.



NB : These products are available.



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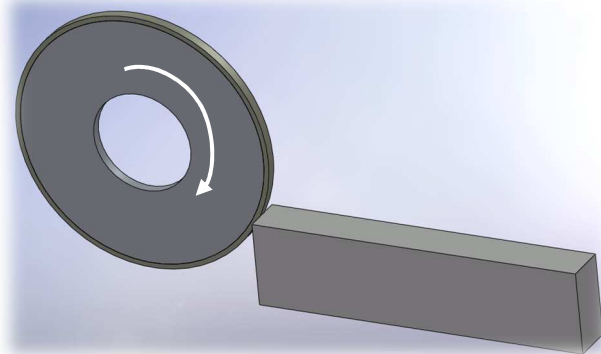


Sharpening

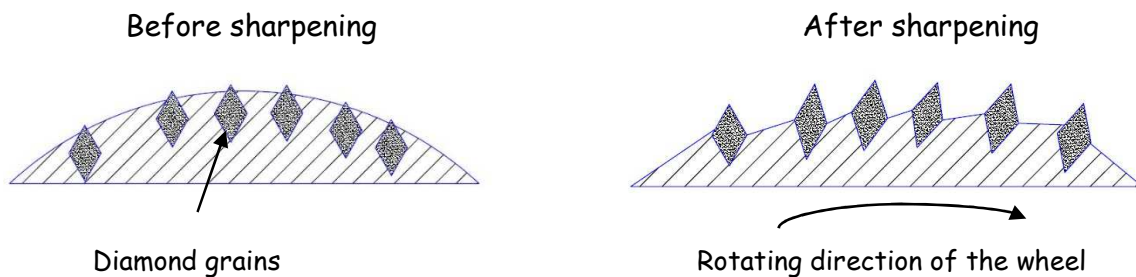
After a dressing operation, a sharpening operation is essential to get back the cutting power of the wheel. This operation is used to extrude diamond grain and remove the bond. Sharpening must be realised with sharpening stones according to the wheel and abrasive grain size.

Operating mode :

- A. Sharpening stones must be soaked inside water to be saturated.
- B. If possible, adjust the coolant of the machine by drip.
- C. Apply the humid stick on the wheel or the tool.
- D. A sludge is formed and cause a good ravelling of the diamond grain.
- E. The wheel can be considered as sharpen when the sharpening stone begin to melt without problems.
- F. Clean the wheel with the coolant.
- G. Begin to work.
- H. Start again this operation every time that we see an important degradation of the cutting power.



Aspect of the diamond part of a sharpening wheel :



CHOICE OF THE SHARPENING STONE			
DIAMOND WHEEL	STICK GRAIN SIZE	DIMENSIONS	ARTICLE CODE
>D181	120	200x50x25	PIEAVIG
D64 to D151	220	200x50x25	PIEAVI
≤D54	320	200x25x12	PIEAVIF

Sharpening speed : 4 to 8 m/s

NB : These products are available.