

DIAMOND DRESSER

DIAMOND TOOLS

Complete product lines of Single-point, Forming, Multi-point, Cone and Impregnated diamond dressers.

■ Element that decide the diamond ct

When ordering a single-point diamond dresser, please provide the following information.

Type of abrasive grinding wheel:

Abrasive · Grit size · Hardness · Bonding material · Diameter and width.

Usage conditions:

- (a) Angle of attachment
- (b) Wet or dry
- (c) Depth of cut
- (d) Peripheral speed
- (e) Material to be worked and required face finish
- (f) Plane grinding or forming grinding
- (g) Machine and precision

For vitrified or resin-bonded wheels with a 25 mm width, a hardness of H~M, and a grit size of #40~#80, a diamond of a weight specified in table below is used, and for wheels with larger diameters and widths, please calculate using the following equations as a guide.

Grinding Wheel Diameter (mm)	75	150	225	375
ct	0.30	0.50	0.75	1.00

$$\frac{\text{Diameter (inches)} + 2 \times \text{Width (inches)}}{10} \text{ or } \frac{\text{Diameter (mm)} + 2 \times \text{Width (mm)}}{250} = \text{ct}$$

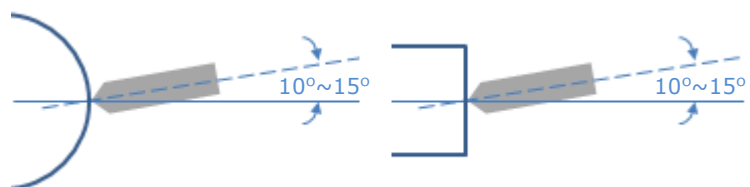
■ Dressing procedure

The roughness of the grinding edge depends on the peripheral speed and depth of cut, and the total depth of cut of the final dressing must not exceed 0.02mm.

When performing a rough dressing, you can increase this number a little, but you can also increase the life of a diamond by performing a number of light dressing passes rather than one heavy dressing pass. The wheel speed impacts directly on the roughness of the finished face, so please take care to select the right speed.

■ Angle of attachment

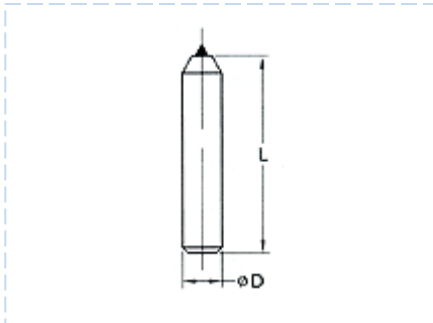
The diamond dresser should be attached at the angle of 10~15degrees from the horizontal axis of the grinding wheel, and at an angle of 10 degrees to the circumference of the wheel. If you rotate the dresser frequently, you can maintain a sharp point and perform ideal dressings.



SPECIFICATION

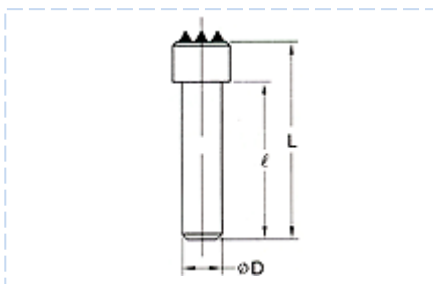
When ordering, please specify shank size or detail drawing.

SINGLE-POINT DRESSERS



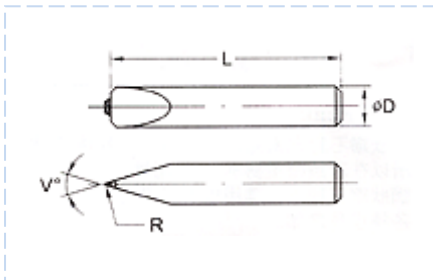
#Diamond	ct	#Diamond	ct
#2	0.10 carat	#20	0.35 carat
#3	0.12 carat	#25	0.50 carat
#4	0.15 carat	#33	0.75 carat
#5	0.18 carat	#50	1.00 carat
#10	0.20 carat	#75	1.50 carat
#15	0.25 carat	#100	2.00 carat

MULTI-POINT DRESSERS



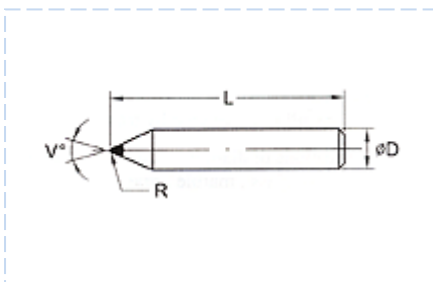
ct	Amount of Diamond	Diamond Layer
1.0 carat	3	1
1.0 carat	5	1
1.0 carat	6	1
1.4 carat	7	1
1.6 carat	3	1

FORMING DRESSERS



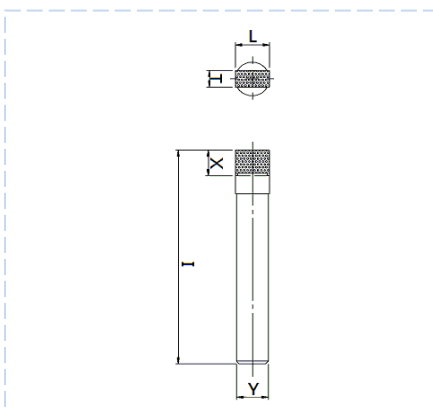
Angle (V°)	Radian (R)	Type of Diamond
55°	0.2R	Diamond
60°	0.5R	
45°	0.2R	Synthetic Diamond
55°	0.2R	
60°	0.5R	

CONE DRESSERS



Angle (V°)	Radian (R)	Size of Shank
60°	0.02R~0.03R	Ø1/8" x 1"L
60°	0.02R~0.03R	Ø1/8" x 2"L
60°	0.02R~0.03R	Ø1/4" x 2"L
60°	0.02R~0.03R	Ø3/8" x 2"L
60°	0.02R~0.03R	Ø10 x 50L (mm)

IMPREGNATED DRESSERS (BD1)

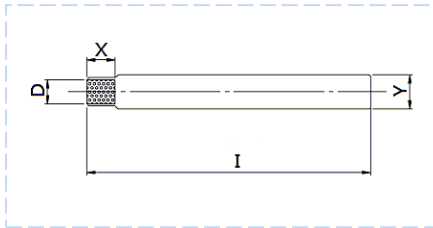


Specification	Size (mm)
SD 16/20 SP-8 100 M BD1	13×6×10×12×83
SD 16 SP-8 125 M BD1	13×6×10×12×83
SD 16 SP-8 150 M BD1	13×6×10×12×83
SD 16 SP-8 125 LM BD1	13×6×10×12×83
SD 16 SP-8 150 LM BD1	13×6×10×12×83
SD 30 SP-8 100 M BD1	13×6×10×12×83
SD 30 SP-8 125 M BD1	13×6×10×12×83
SD 40 SP-8 100 M BD1	13×6×10×12×83

SPECIFICATION

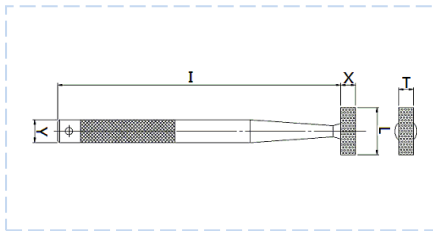
When ordering, please specify shank size or detail drawing.

IMPREGNATED DRESSERS (BD2)



Specification	Size (mm)
SD 16 SP-8 100 M BD2	8×10×12×100

IMPREGNATED DRESSERS (BD3)



Specification	Size (mm)
SD 30 SP-8 125 M BD3-B	25×10.5×10×16×200

- For any further inquiry, please contact us via the company information below.

COMPANY INFORMATION

CARBO TZUJAN INDUSTRIAL CO., LTD.

- For details, please contact the following agency.

Anchor[®]

INFORMATION:

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- While using grinding wheels, it is essential that you observe correct procedures and work safely to protect yourself.