

# Dressing of diamond and CBN grinding wheels with conventional NORTON dressing tools

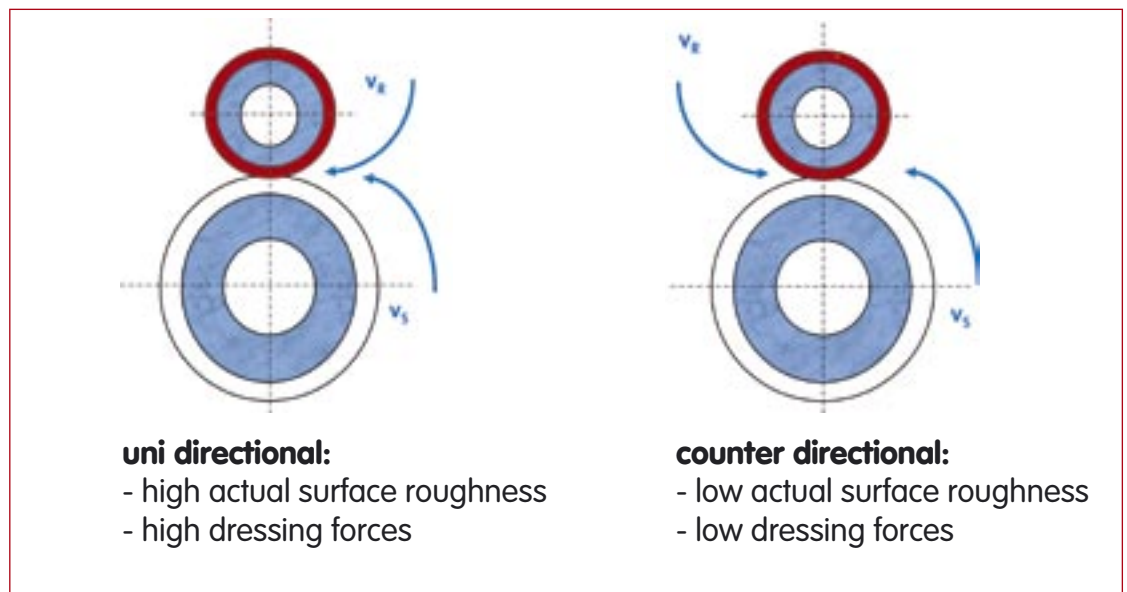
## General Information

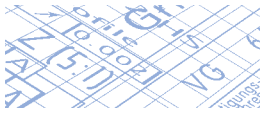
For dressing on cylindrical-surface and profile grinding machines with NORTON dressing wheels:

Grit size	Bond		
	K-plus / KSS	GRESSO	BZ
D7 / B6			39C400 FB5
D15 / B15	39C400 FB5	39C400 FB5	39C400 FB5
D20 / B30	39C240 HB5	39C320 HB5	39C320 HB5
D25	39C240 HB5	39C320 HB5	39C320 HB5
D54 / B54	39C180 HB5	39C240 HB5	39C150 HB5
D76 / B76	39C150 HB5	39C240 HB5	39C80 HB5
D91 / B91	39C150 HB5	39C240 HB5	39C80 JB5
D107 / B107	39C120 HB5	39C180 HB5	39C80 JB5
D126 / B126	39C120 HB5	39C180 HB5	39C80 JB5
D151 / B151	39C80 HB5	39C150 HB5	39C80 KB5
D181	39C80 HB5		

## Recommended operating parameters

RPM grinding wheel:	$n_s$	250-1000 rpm
RPM dressing wheel:	$n_r$	1000-2000 rpm
Traverse rate:	$v_{fad}$	200 mm/min
Dressing infeed:	$a_{ed}$	0,4 mm per stroke





# Dressing of diamond and CBN grinding wheels with WINTER dressing tools

## WINTER dressing device and WINTER stones

### WINTER dressing device

The WINTER dressing device allows accurate dressing of diamond and CBN grinding wheels. During the dressing process the grinding wheel remains on the spindle which guarantees best concentricities.

The dressing device can only be used dry.

If the grinding wheel acts too dull after dressing it needs to be sharpened with a wet WINTER stone No. 1AW, No.2 or No.5.



## Recommended operating parameters

Dressing infeed:	$a_{ed}$	10-25 $\mu\text{m}$
Traverse rate:	$v_{rad}$	0,75-1,5 m/min
Dressing wheel speed:	$v_r$	5-7,5 m/s
Dressing direction:	-	uni directional

<b>WINTER dressing device</b> with rotating SiC wheel (break-controlled) for dressing diamond and CBN wheels. Complete with 1 wheel 37 C602 N5V and 37 C802-15V.	<b>Order no.</b>  66260195821
<b>37C46 - N5V</b> to dress grinding wheels D/B91 to D/B181	69936679412
<b>37C602 - N5V</b> to dress grinding wheels D/B64 to D/B126	66253051624
<b>37C802 - 15V</b> to dress grinding wheels D/B64 or finer	69936639815
Equipment 1 set consisting of: 3 brake disks, clips and screws	66260274670
<b>WINTER Stone No. 1AW</b> (100 x 20 x 20) for resin bond fine grit grinding wheels <D46	66260395639
<b>WINTER Stone No. 2</b> (100 x 24 x 13), universal sharpening stone	66260195816
<b>WINTER Stone No. 5</b> (100 x 50 x 25), universal sharpening stone	66260389054

# Dressing of diamond and CBN grinding wheels with WINTER dressing tools

## WINTER dressing Tools

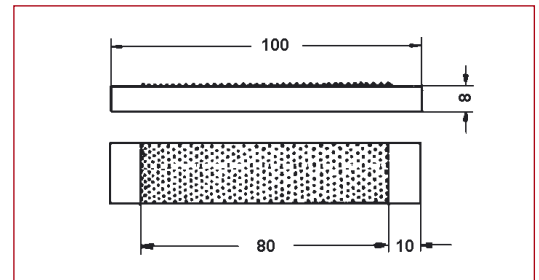
### 1S 09 H-80-20-8

#### WINTER Diamond Dressing Stick

for dressing CBN wheels (KSS) on surface grinding machines.

Use with coolant, subsequent sharpening with WINTER Stone necessary.

Order No.: 66260134287



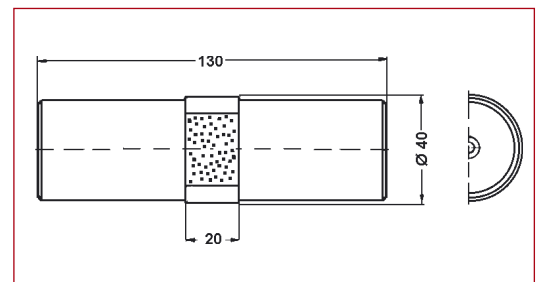
### 1S 44 B-40-20

#### WINTER Dressing Cylinder

for dressing CBN wheels (KSS) on cylindrical grinding machines.

Use with coolant, subsequent sharpening with WINTER Stone necessary.

Order No.: 60157642712



  
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ABRASIVES

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