

Technische Handelsonderneming

**Linders**



*Dress diamanten*



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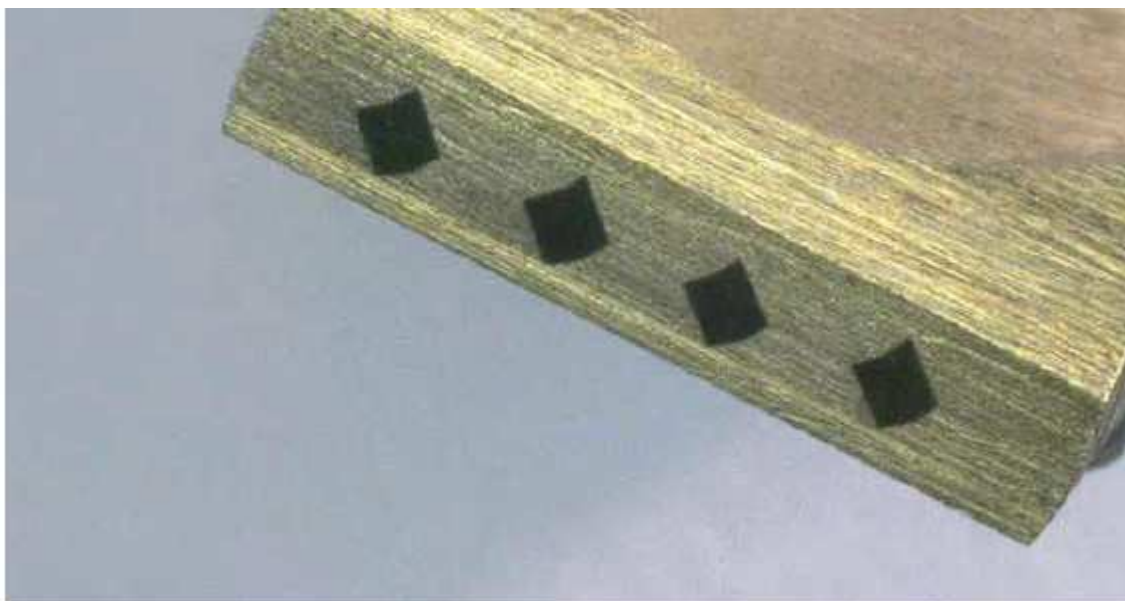


## DIAMOND DRESSERS FOR CONVENTIONAL GRINDING WHEELS

Norton stationary diamond dressing tools have a worldwide reputation for quality and technology. Ideal for profiling and straight dressing of all conventional grinding wheels.

### PRODUCT SELECTION GUIDE

APPLICATIONS	STRAIGHT PLUNGE GRINDING	ANGULAR PLUNGE / PROFILE GRINDING	CENTRELESS / THROUGH-FEED GRINDING	INTERNAL GRINDING	DIAFORM	SINTERED GRAINS
PROFILE AVAILABILITY						
Blade tool with CVD		●				●
Blade tool with natural grains	●	●	●			●
Profile dresser					●	
Multi point	●		●			
Single point				●		
Highly recommended ● Recommended ●						



## SELECTING A BLADE TOOL DRESSER

<b>Dressing of profiles with blade tools</b>	Dressing tools use a 'needle' form of natural or synthetic diamonds. Needle diamonds are especially suited to dressing profiles using infeeds and angular feeds.
<b>Natural diamonds</b>	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.
<b>Synthetic diamonds</b>	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 [mm]	Natural diamond size
46	0,8x0,8	D1181
60	0,8x0,8	D1001
80-120	0,6x0,6	D711

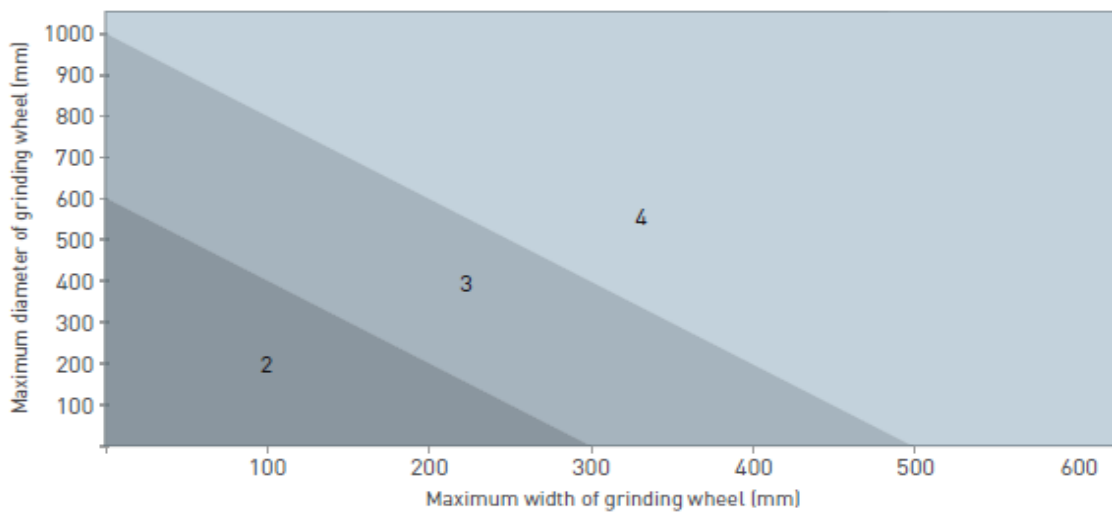


A new dressing tool should be put through at least 5 dressing cycles in order to fit the diameter of the grinding wheel.  
The lifetime of the dressing tool is extended by ensuring that adequate coolant pressure and volume are directed at the tool.

### SELECTION OF TOOL SIZE

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

**NUMBER OF CVD NEEDLES PER BLADE**



**SELECTING A SINGLE-POINT DRESSER**

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

**SELECTING A MULTI-POINT DRESSER**

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

Wheel abrasive	Diamond
80-120	D301
60-80	D711
46-60	D1001
36-46	D2240

## BLADE TOOL DRESSERS HPB-D 3565 & 3585 **+++++**

- Synthetic multi-crystalline diamond
- The most consistent dresser for demanding profiling and straight dressing

WxLxDL (mm)	GRIT	SPECIFICATION	PK QTY	ART NO.
10,5x28x4	0,6x0,6	HPB-D 3565 / 2	1	60157682820
10,5x28x4	0,6x0,6	HPB-D 3565 / 3	1	60157682856
10,5x28x4	0,6x0,6	HPB-D 3565 / 4	1	60157682895
10,5x28x4	0,8x0,8	HPB-D 3585 / 2	1	60157682899
10,5x28x4	0,8x0,8	HPB-D 3585 / 3	1	60157682902
10,5x28x4	0,8x0,8	HPB-D 3585 / 4	1	60157682904



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

- An economical dressing solution for all Al<sub>2</sub>O<sub>3</sub> and SiC wheels
- Natural diamond
- Needles are recommended for profile dressing

WxLxDL (mm)	GRIT	SPECIFICATION	PK QTY	ART NO.
10,5x28x12	D711	HPB-D 30	1	60157682759*
10,5x28x12	D1001	HPB-D 45	1	60157682782
10,5x28x12	D1181	HPB-D 60	1	60157682786
10,5x28x12	NEEDLE	HPB-D	1	60157682790
20,5x28x10	D711	HPB-C 30	1	60157682801
20,5x28x10	D1001	HPB-C 45	1	60157682806
20,5x28x10	D1181	HPB-C 60	1	60157682809
20,5x28x10	NEEDLE	HPB-C	1	60157682814



\* Made-to-order

## SCREWED SHANKS FOR BLADE TOOL DRESSERS **+++++**

DIA (mm)	L (mm)	SHANK CODE	SPECIFICATION	PK QTY	ART NO.
12,065	40	MT1	HPB-H3	1	60157682832
9,045	25,5	MT0	HPB-H4	1	60157682907
11,11	50	Z11,11	HPB-H2	1	60157682910
10,00	50	Z10	HPB-HX	1	60157682911

## SINGLE-POINT DRESSER BC SG

- Highest quality diamonds
- Specifically developed for dressing ceramic abrasive (SG/TG) wheels which require faster traverse speed dressing
- High performance tools
- Enables dressing costs to be reduced, specially 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)

- Standard diamonds
- Ideal for applications where it is difficult to measure the performance of the dressing tool
- Economy product
- 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)

- Commercial standard diamonds
- Standard dresser for conventional abrasive wheels

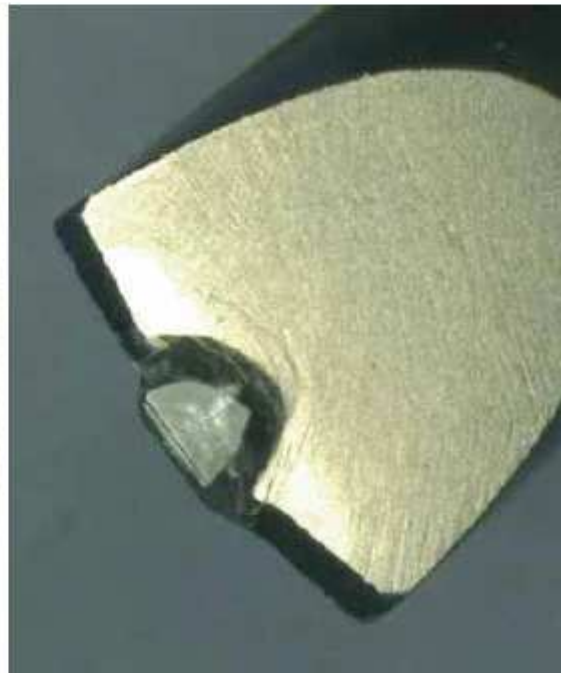
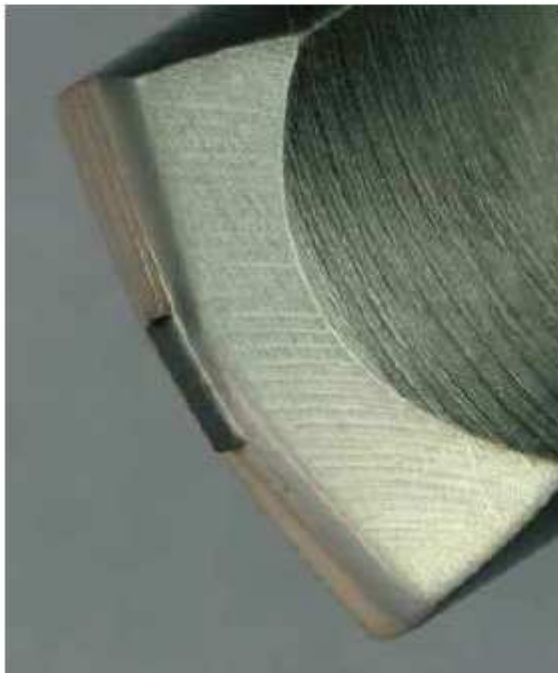
SHANK (mm)	CARAT	PK QTY	ART NO.
MK0	0,3	1	69014119596
	0,5	1	69014119598
	1,0	1	69014119599
	1,5	1	69014119600
MK1	0,3	1	69014119570
	0,5	1	69014119591
	1,0	1	69014119594
	1,5	1	69014119595



## PROFILE DRESSER

- Extremely high performance tools
- Used to meet extremely high profile accuracy requirements

SHANK (mm)	RADIUS (mm)	ANGLE	SPECIFICATION	ART NO.
Z9,52	0,13	40°	DC 40/130	60157 682850
	0,25	40°	DC 40/250	60157 682889
	0,50	40°	DC 40/500	60157 682901
	0,13	60°	DC 60/130	60157 682903
	0,25	60°	DC 60/250	60157 682905
	0,50	60°	DC 60/500	60157 682909



## MULTI-POINT DRESSER **+++++**

- Economical and robust
- 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





## HAND DRESSER **+++++**

- High diamond concentration
- Grit 18/25 SPC
- High wear resistance and long product life time
- Suitable for face and side dressing

SPECIFICATION	PK QTY	ART NO.
HD-150	1	60157682852



## BRAKE CONTROLLED TRUING DEVICE **+++++**

- For fast effective truing of diamond and CBN wheels with minimum loss of abrasive
- Ideal for truing 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

SPECIFICATION	PK QTY	ART NO.
BCTD	1	66260274459



## SCREWED SHANKS FOR BLADE TOOL DRESSERS **+++++**

DIA (mm)	T (mm)	B (mm)	SPECIFICATION	PK QTY	ART NO.
80	25	13	Wheel 37C60-NV	10	69936668764

## DRESSING STICKS **+++**

- High purity white aluminium oxide abrasive
- Friable abrasive
- Ideal for dressing CBN Super Abrasive wheels

DIA (mm)	SPECIFICATION	PK QTY	ART NO.	APPLICATION
13x25x150	38A 150 HVBE	10	61463605565	For SA wheels »D54
	38A 220 HVBE	10	61463605066	-
	38A 320 HVBE	10	69936684889	For SA wheels «D46



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.