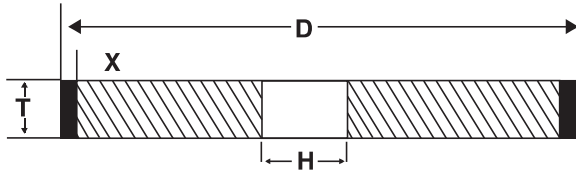


Solar
DIAMOND

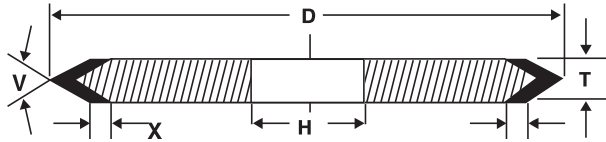


**Resin & Metal Bond Wheels
In Diamond & CBN**

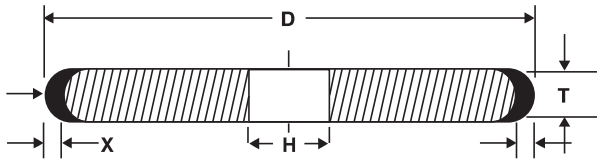
Resin & Metal Bond Wheels in Diamond & CBN



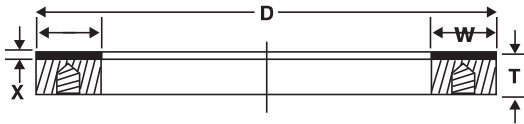
1 A 1 Straight-Diamond in Periphery



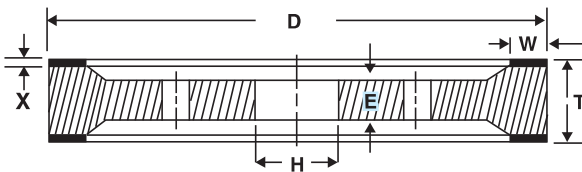
1EE1 Straight-Diamond in Periphery



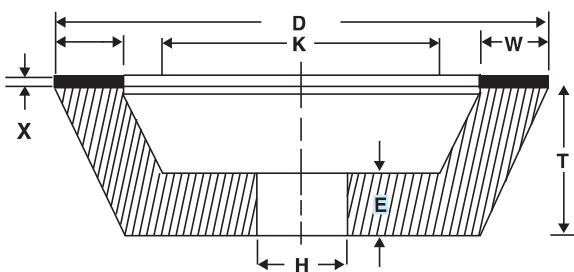
1FF1 Straight-Diamond in Periphery



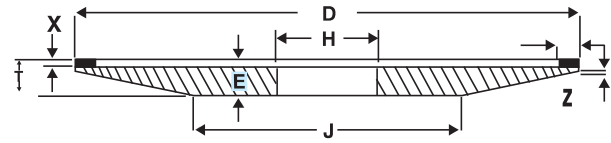
2 A 2T Cylinder-Diamond in Rim



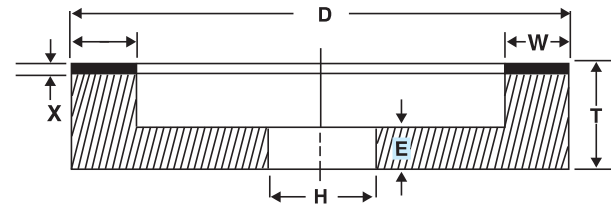
9A 3H Double Cup-Diamond in Rim



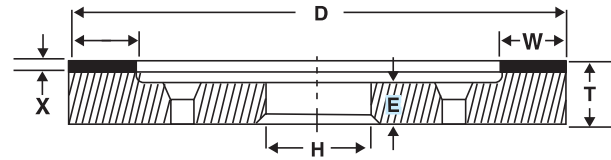
11 A 2 Double Cup-Diamond in Rim



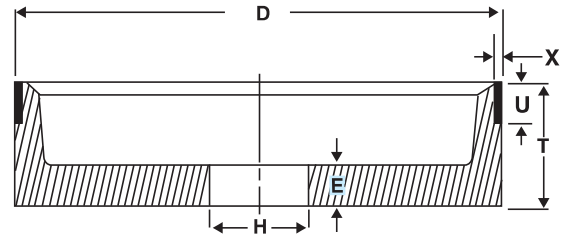
4 A 2 Dish-Diamond in Rim



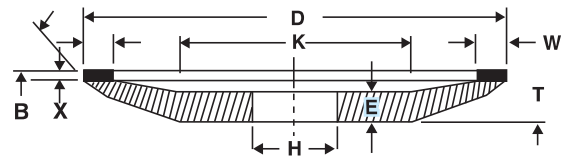
6 A 2 Plain Cup-Diamond in Rim



6 A 2 C Plain Cup-Diamond in Rim With Countersunk Bolt Holes

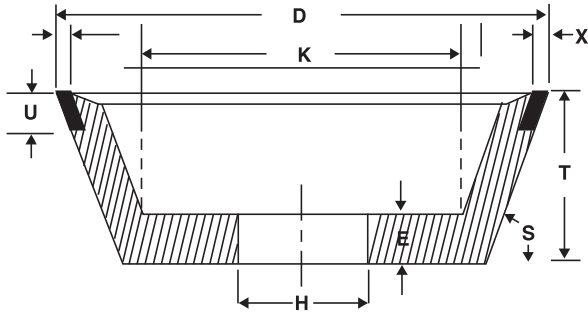


6 A 9 Plain Cup-Diamond in Corner

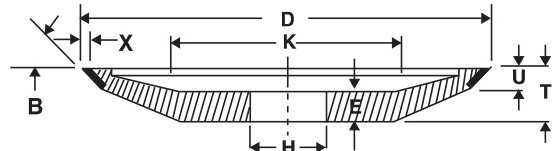


15 A 2 Dish-Diamond in Rim

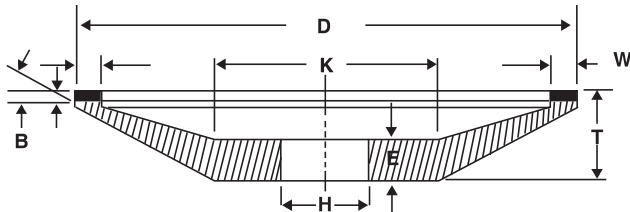
Resin & Metal Bond Wheels in Diamond & CBN



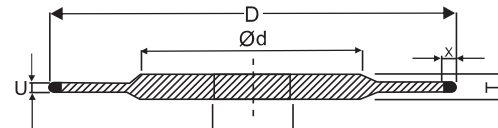
11 V 9 Flaring Cup-Diamond in Corner



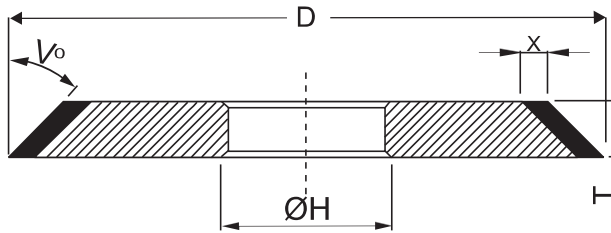
15 V 9 Dish-Diamond in Corner



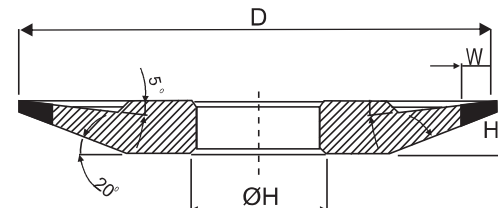
12 A 2-20° Dish-Diamond in Rim



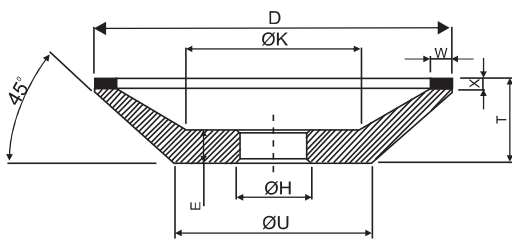
14F1



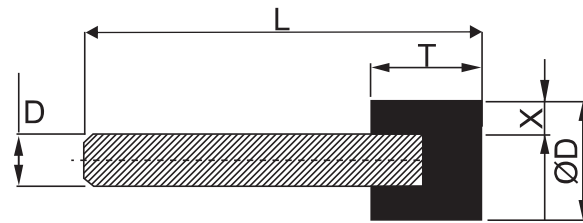
1V1-V°



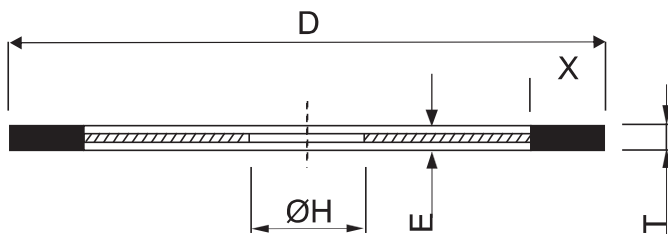
4B19



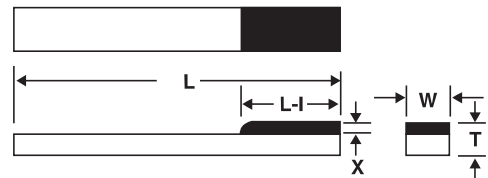
12A2-45°



1A8W



1A1R



HH1 Hand Hone-Diamond at one end

Resin & Metal Bond Wheels in Diamond & CBN



HOW TO ORDER

- (1) Select the type or shape of a wheel from the catalog, which fits to your application and machine.
- (2) Mention dimensions in the following order and fashion.
Diameter x Thickness (Width) x Hole x Depth of Imp.
- (3) Decide the specifications with the help of following table and guide-lines or you can fill in the Grinding Data Sheet and return to us with the order and we will recommend the specifications and supply you the wheel which suits to your application.

EXAMPLE : Wheel 1A1 150 x 10 x 31.75 x 3 mm D 120 R 75 BS 3 (bold letters in the table)

Abrasive	Grit Size	Grade	Concentration	Bond	Depth of Diamond
D-Diamond	100-120	L. Soft	100 High	BS	
	150-180			BF	
B-Borazon	220-270	G. Med.	75 Medium	BA	3
	320-400 or	H. Hard		BD	
	D30, D15			MI	

SELECTION GUIDE-LINES FOR SPECIFICATIONS

- (1) ABRASIVE: (a) Diamond for carbide grinding
(b) Borazon for Molybdenum and Tungsten type high speed steels
- (2) GRIT SIZE : Use the coarsest grit commensurate with finish from the table below :

GRIT SIZE in Mesh	120	150	180	220	325	400	D15
FINISH in Microinch	24	22	16	12	10	8	3
FINISH in Micron	0.6	0.55	0.4	0.3	0.25	0.2	0.08

- (3) GRADE : L.....G.....H.....

High wheel cost	→	→	→	→	Low wheel cost
Low time cost	←	←	←	←	High time cost
High cutting efficiency	→	→	→	→	Low cutting effi.

- (4) CONCENTRATION :

50 (Low)	75	100 (High)
Face grinding		Surface grinding
Internal grinding		Cylindrical grinding
Form grinding		Centreless grinding
Dry grinding		Wet grinding
Over 4000 ftjmt speed in dry		3000 ft / mt
Heavy infeed		Light infeed
Larger carbide		Small carbide
Finer grit		Coarser grit

- (5) BOND :

(a) General Purpose... .. G	(b) Finer Finish BF
(c) Mirror Finish (wet) H	(d) Mirror Finish (dry) BD
(e) General Purpose Metal... .. MI	(f) Non Metallic Materials MS

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