

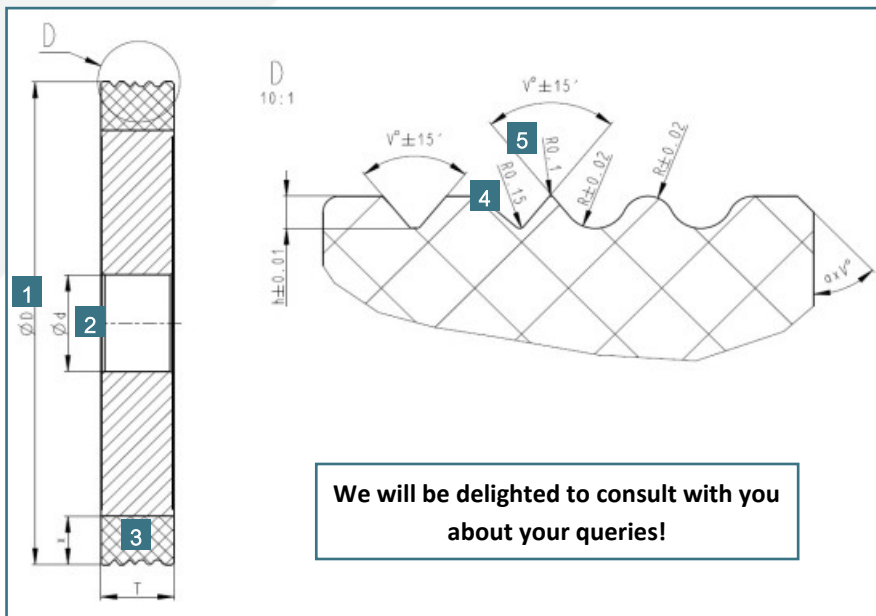
METAL-BONDED DIA AND CBN PROFILED GRINDING WHEELS

Grinding with a grinding wheel that is the negative to a ground workpiece is a very efficient method for mass-production of products with precise shape / profile. This machining method can be utilized in manufacture of various workpieces / products:

- Rotary Cutting Tools (reamers, thread cutters, chip breakers, specialty drills / end mills, etc.) - produced e.g. on grinding machines like WALTER, EWAG, ANCA, SCHNEEBERGER, etc.
- Indexable Inserts with special shapes (API threading inserts, shaped inserts, etc.) - produced e.g. on grinding machines HAAS, Kellenberger, Jung, etc.
- Any other workpieces

The above-described grinding applications are very demanding on grinding wheel's dimensional tolerances and wear durability. The solution we provide are metal-bonded grinding wheels, which embody a combination of our rich experience with metal bonds and newest technologies for electro erosive profiling of wheels. In terms of dimensional tolerances, our metal-bonded profiled wheels cannot match reverse plated dressers, but for many applications, the tolerances that we can achieve are perfect fit.

AVAILABLE SHAPES, DIMENSIONS, TOLERANCES AND SERVICES:



REMARKS:

- 1) Wheel's diameter (D)**
50 to 250 mm (+/- 0,02mm). Bigger \varnothing upon req.
- 2) Bore hole (d)**
Upon customer's request (toler. up to H2).
- 3) Grinding Layer (T / X)**
Max. 30 / X mm. Other dimensions upon req.
- 4) Convex radius**
Min. 0,15. Smaller radius upon req.
- 5) Concave radius**
Min. 0,1. Size of this radius depends on the grit size of the used abrasive. Final sharpness of the radius is 0,1 mm minus grit size of the abrasive.
For more accurate radius, contact us for individual consultancy.
- 6) Grit sizes**
D27 - 151. Upon individual consultancy.
- 7) Dimensional tolerances - general**
Presented dimensional tolerances are only orientational. Tighter tolerances upon individual consultancy.
In case the wheel will be out of agreed tolerances we automatically repair the wheel.

RE-TRUING WHEELS: after individual consultancy, we provide truing service to our customers*

* Currently we do not true / dress wheels on customers' tool holder / flange.

EXAMPLES OF OUR PRODUCTS



CONTACT US FOR MORE INFORMATION

E-mail: urdiamant@urdiamant.com
Landline: +420 583 366 603
Website: www.urdiamant.cz
Address: Dolnostudénská 715/3, 787 01 Šumperk, Czech Republic

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