



Hybrid Bond Wheels

DIAMOND AND CBN WHEELS FOR CUTTER GRINDING



MAXIMUM PERFORMANCE FOR THE
MANUFACTURE AND RECONDITIONING OF
TUNGSTEN CARBIDE AND HSS ROTARY
CUTTING TOOLS!

MAXIMUM VALUE . . .

- Highest Cutting Rates (Q'_w)
- Lowest Forces (Spindle Load)
- Highest Profile Retention (Corner Holding)
- Longest Interval Between Profiling (Wheel Truing)
- Longest Interval Between Dressing (Stick Dressing)
- Suitable for Unattended Operation (Lights Out Manufacturing)

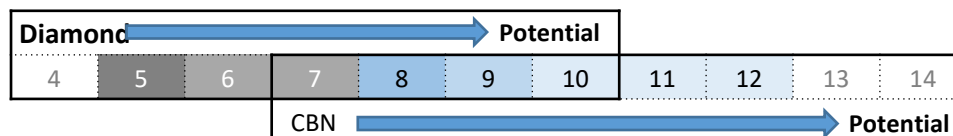
. . . MINIMUM DOWNTIME



		Diamond			CBN		
		Flute	Gash	Relief	Flute	Gash	Relief
	m/s	16	20	25	30	35	40
	SFPM	3,150	3,937	4,921	5,906	6,890	7,874
Wheel O.D.	75mm (3")	4,074	5,093	6,366	7,639	8,913	10,186
	100mm (4")	3,056	3,820	4,775	5,730	6,685	7,639
	125mm (5")	2,445	3,056	3,820	4,584	5,348	6,112
	150mm (6")	2,037	2,546	3,183	3,820	4,456	5,093
		RPM			RPM		

Specific Material Removal (Q'w)
mm³/mm * s

		Through Feed / min												
		1.575"	1.969"	2.362"	2.756"	3.15"	3.543"	3.937"	4.724"	5.512"	6.299"	7.087"	7.874"	8.661"
		40	50	60	70	80	90	100	120	140	160	180	200	220
Inches	MM													
Depth of Cut	0.079"								4	4.7	5.3	6	6.7	7.3
	0.098"							4.2	5	5.8	6.7	7.5	8.3	9.2
	0.118"					4	4.5	5	6	7	8	9	10	11
	0.138"				4.1	4.7	5.3	5.8	7	8.2	9.3	10.5	11.7	12.8
	0.157"			4	4.7	5.3	6	6.7	8	9.3	10.7	12	13.3	
	0.177"			4.5	5.3	6	6.8	7.5	9	10.5	12	13.5		
	0.197"		4.2	5	5.8	6.7	7.5	8.3	10	11.7	13.3			
	0.217"		4.6	5.5	6.4	7.3	8.3	9.2	11	12.8				
	0.236"	6	4	5	6	7	8	9	10	12	14			
	0.256"	6.5	4.3	5.4	6.5	7.6	8.7	9.8	10.8	13				
	0.276"	7	4.7	5.8	7	8.2	9.3	10.5	11.7	14				
	0.295"	7.5	5	6.3	7.5	8.8	10	11.3	12.5					
	0.315"	8	5.3	6.7	8	9.3	10.7	12	13.3					
	0.335"	8.5	5.7	7.1	8.5	9.9	11.3	12.8						
	0.354"	9	6	7.5	9	10.5	12	13.5						
	0.374"	9.5	6.3	7.9	9.5	11.1	12.7							



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ABRASIVE & TOOLING DIVISION

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