

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)

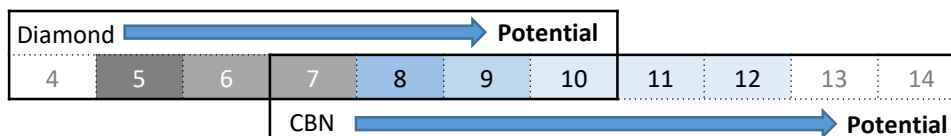
. . . MINIMUM DOWNTIME



| | | 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" |
| Inches | MM | 40 | 50 | 60 | 70 | 80 | 90 | 100 | 120 | 140 | 160 | 180 | 200 | 220 |
| Depth of Cut | 0.079" | 2 | | | | | | | 4 | 4.7 | 5.3 | 6 | 6.7 | 7.3 |
| | 0.098" | 2.5 | | | | | | 4.2 | 5 | 5.8 | 6.7 | 7.5 | 8.3 | 9.2 |
| | 0.118" | 3 | | | | | 4 | 4.5 | 5 | 6 | 7 | 8 | 9 | 10 |
| | 0.138" | 3.5 | | | | 4.1 | 4.7 | 5.3 | 5.8 | 7 | 8.2 | 9.3 | 10.5 | 11.7 |
| | 0.157" | 4 | | | 4 | 4.7 | 5.3 | 6 | 6.7 | 8 | 9.3 | 10.7 | 12 | 13.3 |
| | 0.177" | 4.5 | | | 4.5 | 5.3 | 6 | 6.8 | 7.5 | 9 | 10.5 | 12 | 13.5 | |
| | 0.197" | 5 | | 4.2 | 5 | 5.8 | 6.7 | 7.5 | 8.3 | 10 | 11.7 | 13.3 | | |
| | 0.217" | 5.5 | | 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 | | | | | | | |



GET IN TOUCH WITH US TODAY

TOGETHER WE WILL FIND A SOLUTION FOR YOUR REQUIREMENTS

ABRASIVE & TOOLING DIVISION

sales@pss-atd.com
www.pss-atd.com