

Grit Impregnated Dressers

Diamond Grit Impregnated Dressers also called Nib dressers are made with a number of fractional carat diamonds set in a matrix bond. The cost per carat of crushed diamonds used in these dressers is lower than the whole diamond crystal used in single point dressers. These dressers dress quickly as a number of diamonds work on the wheel face simultaneously. These dressers produce an even, rib free grinding wheel face. Since the amount of exposed diamond remains the same throughout the life of the dresser, the dressing action is consistent and generates uniform dressing surface. This means that the grinding wheel is consistently sharp and cuts freely even after repeated dressing. The work piece is ground to the same tolerance and surface finish.



TYPICAL APPLICATIONS

- ▶ Cylindrical Wheels
- ▶ Centreless Wheels
- ▶ Roll Grinding Wheels
- ▶ Side Dressing Crank Wheels
- ▶ OD Dressing Thread & Gear
- ▶ Dressing Rubber Bond Wheels

ADVANTAGES/BENEFITS

- ▶ Long life with reduced dressing costs
- ▶ Self sharpening ensuring complete use
- ▶ Fast dressing as diamond is continuously exposed
- ▶ Less abrasive lost due to dressing - More parts per dress
- ▶ Need no resetting and truing
- ▶ Entire diamond matrix is usable

PARAMETERS

- ▶ Traverse rates: 5 mm/sec to 10 mm/sec
- ▶ Depth of cut: 50 to 70 microns for initial dressing
- ▶ 15-35 microns for regular

STOCK AVAILABILITY

Stk Code	Head Dia	Wheel Dia	Wheel Thickness
HSG6	6	<300	<40
HSG8	8	300-400	40-50
HSG10	10	400-500	50-75
HSG12	12	500-600	75-100
HSG15	15	>660	>100

TechTips



Carat selection - The diamond used in the dresser should be large enough so that it has enough surface area to be held well in the shank. Where higher dressing infeeds and traverse rates are required, the carat size of diamond must be higher. Multiply the diameter (in mm) of the wheel by its thickness (in mm). Refer the above value to the chart that follows and select the carat size of diamond. This is a rough method.

Carat	0.35	0.5	0.75	1.0
Upto	6000	12000	25000	and above
	6000	to 12000	to 25000	

Given above is a rough guide. Use multipoint dressers above 1.0 carat for best results.