STELLA GRUPPE

German Precision Grinding Wheels

Conditioning of Diamond and CBN wheels

Dressing machines e. g.: Winter, KW-Abrichttechnik, Geiger, Agathon



WE MANUFACTURE AT THE HIGHEST QUALITY LEVEL – CHOOSE FROM OUR WIDE RANGE OF PRODUCTS

The conditioning of Diamond and CBN wheels is divided in dressing and sharpening. Dressing means the restoration of the desired form of the axial and concentric run-out. Sharpening by means of corundum sticks opens respectively restores the bond, to set free again sharp cutting edges of the abrasive grain. As a reference point some examples:

Dressing wheels

Specification	Grit size CBN resp. Diamond
60C 60/5 L7 V30	181 - 126
60C 100 Jot14P02 V31	126 – 64
60C 120 Jot7 V30	91 – 46
60C 220 i7 V30	64 – 46
60C 320 i7 V62A	46 – 25
60C 500 i7 V62A	25 – 3

Sharpening sticks

Specification	Grit size CBN resp. Diamond
20A 80 i-Jot7 V3	251 – 107
20A 120 F8P1 V1Y	126 – 64
20A 180 i7 V55	126 – 46
20A 180 F8P1 V8	91 – 39
20A 320 E8P1 V8	46 – 20
20A 900/225/8 V511M	25 – 3

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