

Impregnated Diamond Dresser



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Impregnated Diamond Dresser

Impregnated diamond dresser is quite similar to that of Multipoint diamond dresser. In this dresser the crushed diamond grit in both Natural & Synthetic grades are set in a several layers in random pattern. With this type of tool, the dressing work is carried out by several small diamonds which together result in excellent performance. To achieve good results, the diamond particles must have at least double the grinding wheel grain to be dressed. Tools with higher diamond content are more efficient in this case. These tools are more suitable for fine and sensitive grinding wheels where a lower surface finish is required.

Advantages of Impregnated tool

- Dressing time is reduced as higher feed rates can be used.
- They are tougher & more wear resistance.
- These tools can be used completely without any requirement of maintenance.
- Extend wheel life by less stock removal per dressing.
- No resetting or re-lapping required.
- These tools are inexpensive and easy to use.

To get the maximum tool life

- ☞ Set the multipoint tool into the center of the grinding wheel so that tool face gets completely in contact with the wheel. (Fig. 1)
- ☞ Depth of cut should not exceed more than 0.02-0.04 mm.
- ☞ Use plenty of coolant to increase the tool life.
- ☞ The mounting must be vibration free, with the clamping length as short as possible.
- ☞ Multi-point dressers must be used with higher crossfeed velocity rates than single point or blade dressing tools as their effective width is generally much greater.
- ☞ Slower crossfeed rates would lead to high overlap ratios and thus may blunt the grinding wheel.

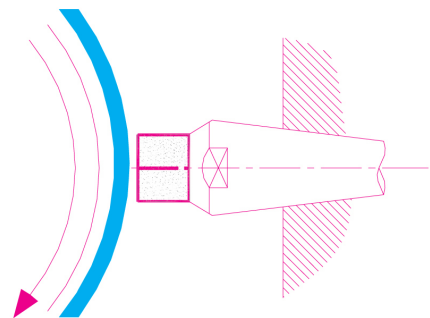
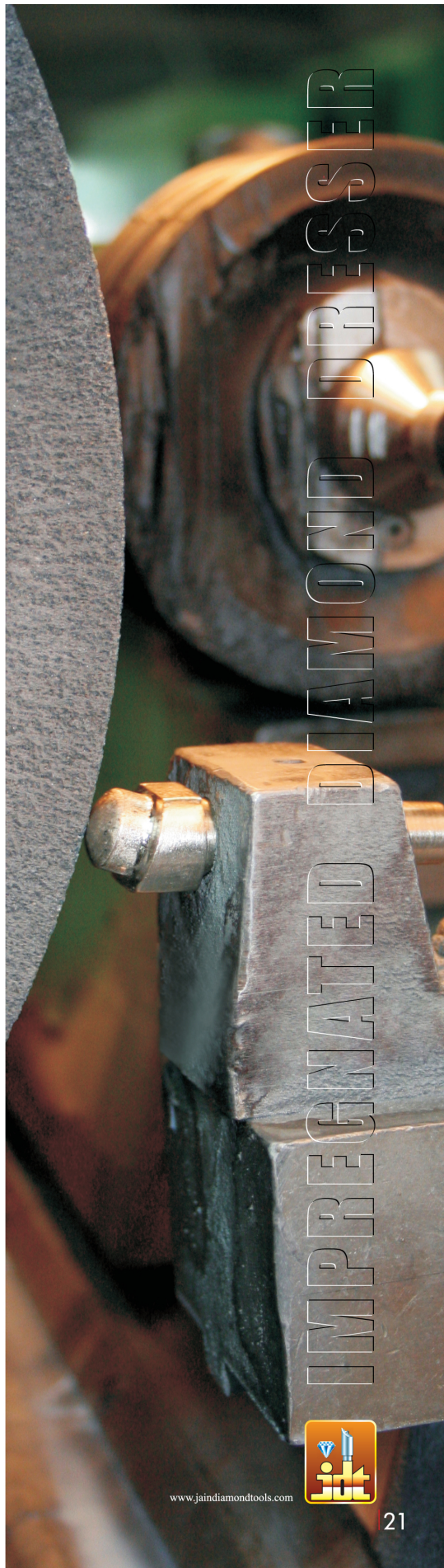
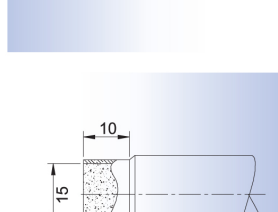
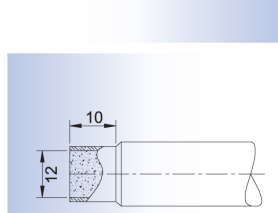
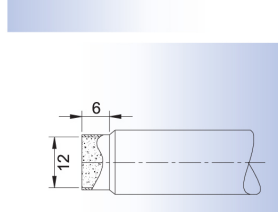
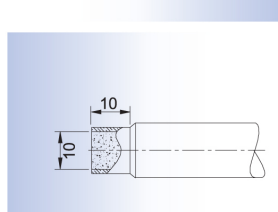
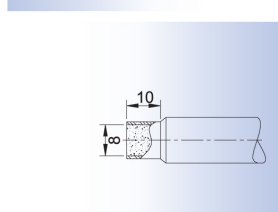
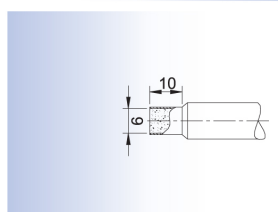
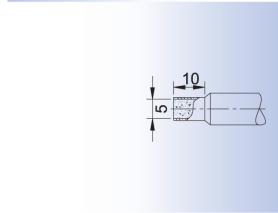
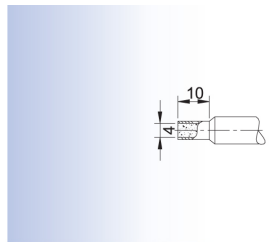


Fig.1

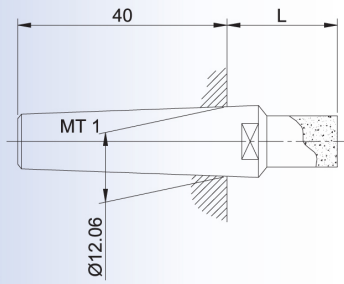
Tool	US Mesh	Tool Code
ID 4 4 x 10 mm	25 / 30	ID 4A
	40 / 50	ID 4B
	60 / 70	ID 4C
	80 / 100	ID 4D
ID 5 5 X 10 mm	25 / 30	ID 5A
	40 / 50	ID 5B
	60 / 70	ID 5C
	80 / 100	ID 5C
ID 6 6 X 10 mm	18 / 20	ID 6A
	25 / 30	ID 6B
	40 / 50	ID 6C
	50 / 60	ID 6D
	70 / 100	ID 6E
	100 / 120	ID 6F
ID 8 8 X 10 mm	18 / 20	ID 8A
	25 / 30	ID 8B
	40 / 50	ID 8C
	50 / 60	ID 8D
	70 / 100	ID 8E
ID 10 10 X 10 mm	100 / 120	ID 8F
	18 / 20	ID 10A
	25 / 30	ID 10B
	40 / 50	ID 10C
	50 / 60	ID 10D
	70 / 100	ID 10E
ID 12 12 X 6 mm	100 / 120	ID 10F
	18 / 20	ID 12A
	25 / 30	ID 12B
	40 / 50	ID 12C
	50 / 60	ID 12D
	70 / 100	ID 12E
ID 12 L 12 X 10	100 / 120	ID 12F
	18 / 20	ID 12LA
	25 / 30	ID 12LB
	40 / 50	ID 12LC
	50 / 60	ID 12LD
	70 / 100	ID 12LE
ID 15 15 X 6 mm	100 / 120	ID 12LF
	18 / 20	ID 15A
	25 / 30	ID 15B
	40 / 50	ID 15C
	50 / 60	ID 15D
	70 / 100	ID 15E
100 / 120	ID 15F	

Note:

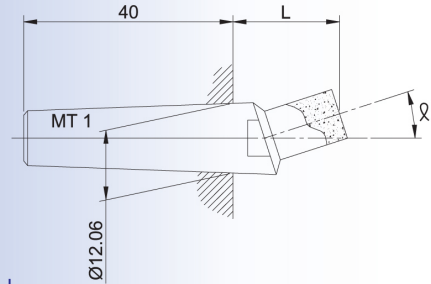
Above tools can be manufactured in two bonds
H-Hard Bond S-Soft Bond



Impregnated tools in different holders

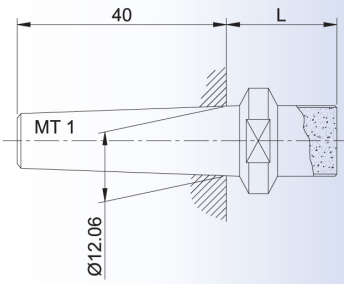


Tool Code
IDS1

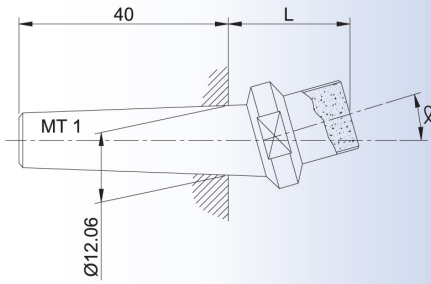


Tool Code
IDS2

α -10°or15°

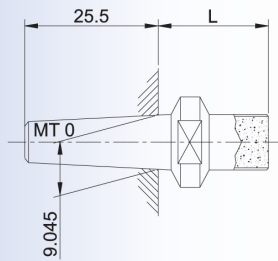


Tool Code
IDS3

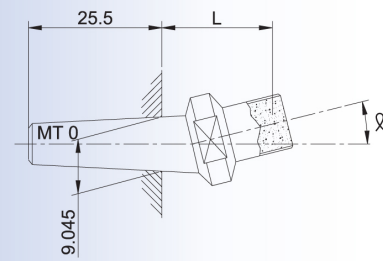


Tool Code
IDS4

α -10°or15°

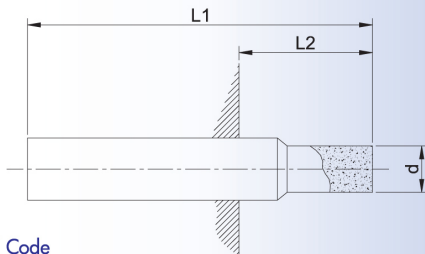


Tool Code
IDS5

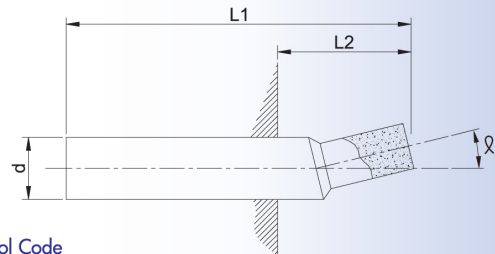


Tool Code
IDS6

α -10°or15°



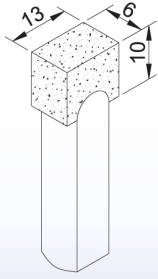
Tool Code
IDS7



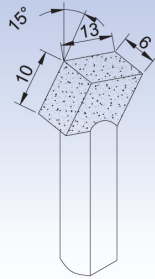
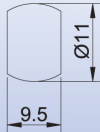
Tool Code
IDS8

α -10°or15°

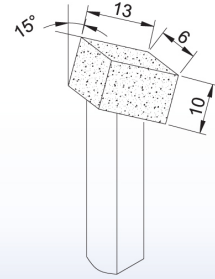
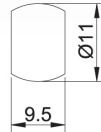
Impregnated Blocks



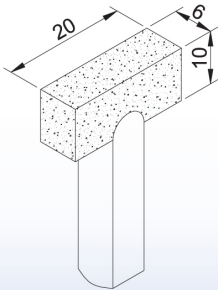
Tool Code
IDBS1



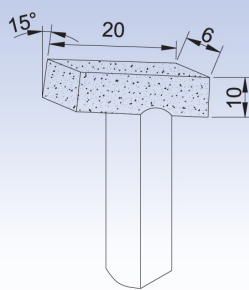
Tool Code
IDBS2



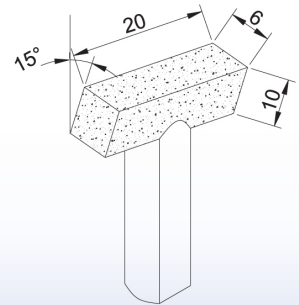
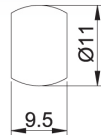
Tool Code
IDBS3



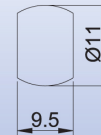
Tool Code
IDBS4



Tool Code
IDBS5



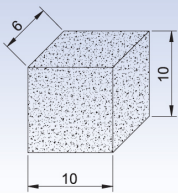
Tool Code
IDBS6



Special Block

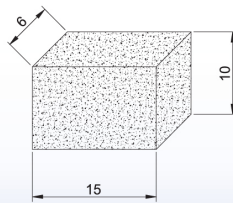
As the name indicates it's an only block of crushed diamond grit. These dressing blocks are manufactured in a similar pattern as Impregnated dresser. These blocks are made for dressing large diameter grinding wheels of surface grinding machine.

Block : 10 X 10 X 6



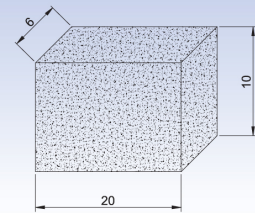
Tool Code
ID BL10

Block : 15 X 10 X 6



Tool Code
ID BL15

Block : 20 X 10 X 6



Tool Code
ID BL20

Note: All tools can be available in two bonds
H-Hard Bond S-Soft Bond