

GENERAL
INFORMATION
ABOUT
DRESSING,
DIAMOND
TOOLS





GENERAL CONSIDERATIONS

In all grinding operations a correct dressing is essential to obtain the maximum performance of the grinding wheel.

Dressing of conventional abrasive and microcrystalline Aluminium Oxide wheels is carried out using:

- single point diamond dressers
- manually mounted multi point blade type diamond dressers
- PBP type multi point impregnated diamond dressers
- chisel type MCD monocrystalline diamond dressers
- diamond rollers

GENERAL TIPS FOR DRESSING

The dressing operation must always be carried out in the presence of an abundant flow of coolant. To avoid thermal shocks on the diamond, direct the coolant to the dressing area before starting the operation.

The tool carrier must be free from vibrations. Limit the protrusion of the dresser to less than twice the diameter of the shank. Ensure the correct positioning and the correct 10-15° angle of single point diamonds.

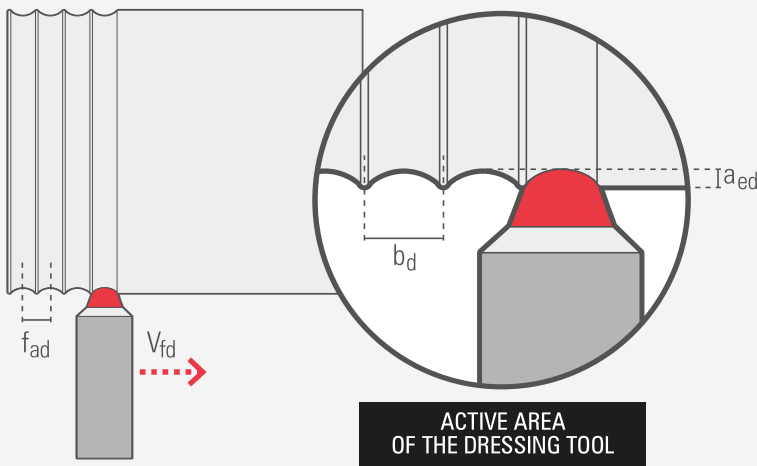
Choose the shape and size of the tool based on the size and specification of the grinding wheel and the type of grinding. The carat weight of the diamond must never be less than the recommended value.

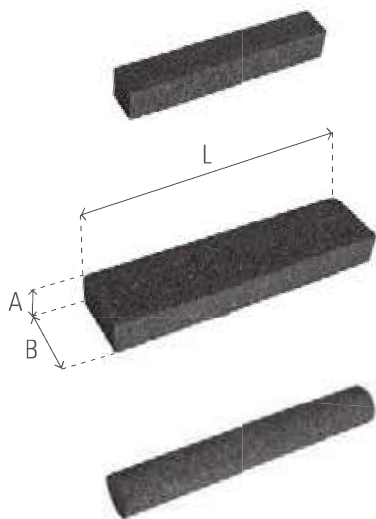
The diamond must always be well sharpened.

Single diamond tools have a more marked action on the abrasive

grain and are therefore more suitable for profiled and roughing wheels.

Multiple diamond tools are preferable to single diamond tools for dressing grinding wheels with linear peripheral banding, since they are less susceptible to the risk of breakage and cheaper (at the same carat weight).





DRESSING STICKS - SHAPES AND DIMENSIONS

Shape	A	B	L	Specification
Square	15	15	150	04C020S05V55
	20	20	200	
	25	25	150-200	
	50	50	200	
Rectangular	13	25	150	04C020S05V55
	25	50	200	
Round	15		100-150	04C020S05V55
	20		150-200	
	25		150-200	
	30		200	

TREBEL DRESSERS - SHAPES AND DIMENSIONS

Shape	D	T	H	Specification
T1	90	40	22,2	04C020S05V55

ALUMINIUM OXIDE DRESSING STICKS FOR DIAMOND WHEELS - SHAPES AND DIMENSIONS



Code	A	B	L	Specification	Grit
A1RTA13251001	13	25	100	9A120G8V86	120
A1RTA13251005	13	25	100	9A240J8V86	240
A1RTA25502001	25	50	100	9A120J7V86	120



RESIN-BONDED SILICON CARBIDE DRESSING STONES FOR DIAMOND WHEELS SHAPES AND DIMENSIONS

Code	A	B	L	Specification	Grit
A1RTA50252001	50	25	200	08C150G07B	150



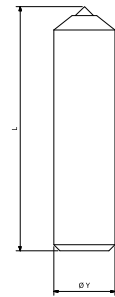
SINGLE POINT DRESSERS WITH CYLINDRICAL SHANK

Code	Ø Y	L	diamond
	mm	mm	ct
STANDARD U1SST050G10	10	40	0.5
U1SST100G10	10	40	1,0
U1SST150G10	10	40	1.5
U1SST200G10	10	40	2,0
U1SST250G10	10	40	2.5
U1SST300G10	10	40	3,0
HIG QUALITY U4SST025G10	10	40	0.25
U4SST050G10	10	40	0.5
U4SST100G10	10	40 square head	1,0
U4SST150G10	10	40 square head	1.5
U4SST200G10	10	40 square head	2,0

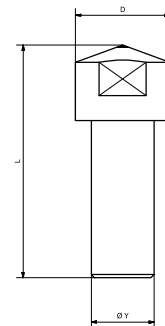
SINGLE POINT DRESSERS WITH MORSE TAPER 1 SHANK

Code	Ø Y	L	diamond
	gambo		ct
STANDARD U1SST050CM1	CM1 x 40		0.5
U1SST100CM1	CM1 x 40		1,0
U1SST150CM1	CM1 x 40		1.5
U1SST200CM1	CM1 x 40		2,0
U1SST250CM1	CM1 x 40		2.5
HIG QUALITY U4SST025CM1	CM1 x 40		0.25
U4SST050CM1	CM1 x 40		0.5
U4SST100CM1	CM1 x 40		1,0
U4SST150CM1	CM1 x 40		1.5
U4SST200CM1	CM1 x 40		2,0

Cylindrical Shank



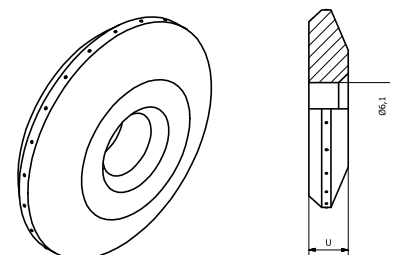
Square head



Morse Taper 1



Circular rotary dresser



CIRCULAR ROTARY DRESSER

Code	Ø D	u	Bore	diamond ct	
U1MRO4F20	20	9	6,1	2,0	STANDARD
U4MRO4FD18	21	7	6,1	2,0	HIG QUALITY



POINT ROTARY DRESSER $V=25^\circ$ (NATURAL STONES)					
Code	$\varnothing D$	u	N° points	Bore	
U4MR08PPN2	25	5	8	6,1	HIG QUALITY

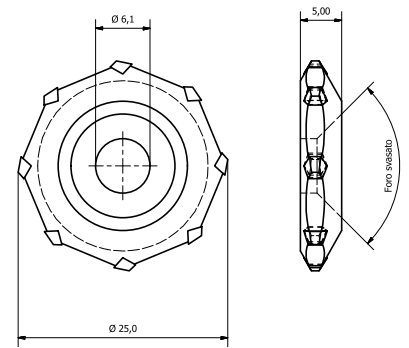
POINT ROTARY DRESSER $V=25^\circ$ (CVD)					
Code	$\varnothing D$	u	N° points	Bore	
U4MR08PCVD2	25	5	8	6,1	HIG QUALITY

IMPREGNATED CIRCULAR ROTARY DRESSER						
Code	$\varnothing D$	u	x	H		Diamond grit
U4-14-ROL1	22	7	x	6,1		600/800 20/30MESH

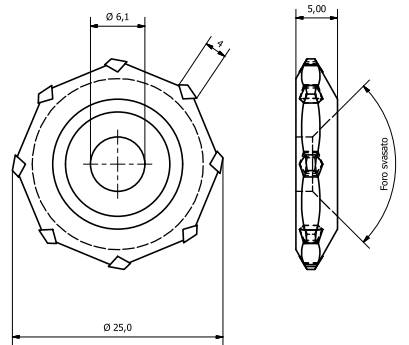
ROTARY DRESSER WITH CYLINDRICAL SHANK						
Code	$\varnothing D$	u	x	$\varnothing y$	L	Diamond grit
U4-14-ROL1G10	22	7	3	10	48	600/800 20/30MESH

ROTARY DRESSER WITH MORSE TAPER 1 SHANK						
Code	$\varnothing D$	u	x			Diamond grit
U4-14-ROL1CM1	22	7	3	CM1 x 48		600/800 20/30MESH

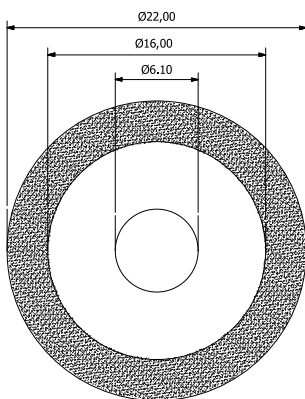
8 point rotary dresser $v=25^\circ$
(natural stones)



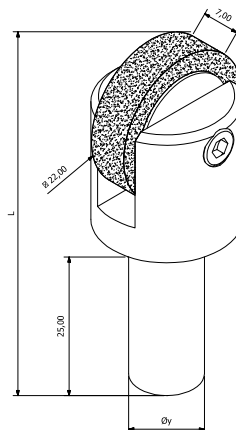
8 point rotary dresser $v=25^\circ$
(synthetic diamond)



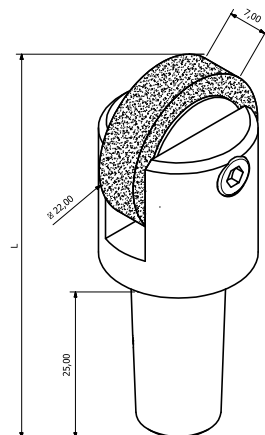
Impregnated circular rotary dresser



Rotary dresser with cylindrical shank



Rotary dresser with Morse taper 1 shank



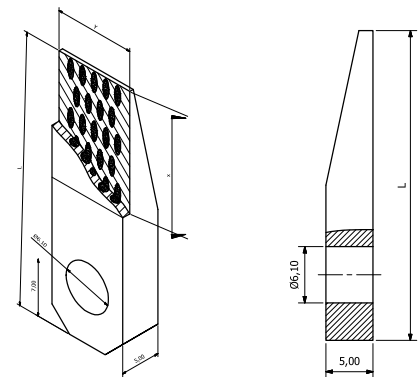


HANDSET BLADE DIAMOND DRESSERS

STANDARD

Code	y	x	L		Diamond Ct
U1MSC1015	10	15	33		1.5
U1MSC1020	10	15	33		2.0
U1MSC1025	10	15	33		2.5
U1MSC1030	10	15	33		3.0
U1MSC1515	15	15	33		1.5
U1MSC1520	15	15	33		2.0
U1MSC1525	15	15	33		2.5
U1MSC1530	15	15	33		3.0
U1MSC2015	20	15	33		1.5
U1MSC2020	20	15	33		2.0
U1MSC2025	20	15	33		2.5
U1MSC2030	20	15	33		3.0

Handset blade natural diamond dressers

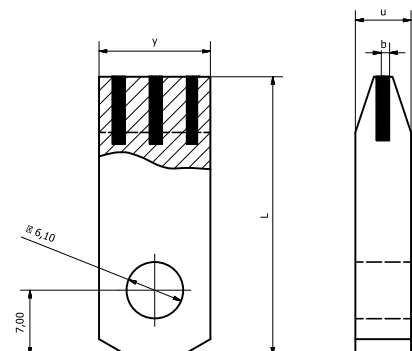


SA HANDSET BLADE NATURAL DIAMOND DRESSERS

HIG QUALITY

Code	Y	X	U	L	TIPO	Grit of conventional wheel
U4MSC1020F	10	10	5	30	F	80 and higher
U4MSC1020M	10	10	5	30	M	60 - 80
U4MSC1020G	10	10	5	30	G	54 and lower
U4MSC1520F	15	15	5	30	F	80 and higher
U4MSC1520M	15	15	5	30	M	60 - 80
U4MSC1520G	15	15	5	30	G	54 and lower
U4MSC2020F	20	15	5	30	F	80 and higher
U4MSC2020M	20	15	5	30	M	60 - 80
U4MSC2020G	20	15	5	30	G	54 and lower

Blade dressers with CVD bar synthetic diamond



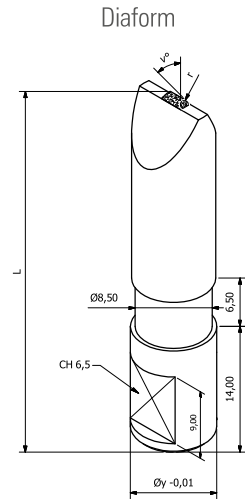
BLADE DRESSERS WITH CVD BAR SYNTHETIC DIAMOND

HIG QUALITY

Code	Y	X	U	L	B	Grit of conventional wheel
U4MSC1006MDL	10	4	5	30	0,6	80 and higher
U4MSC1008MDL	10	4	5	30	0,8	60 and lower

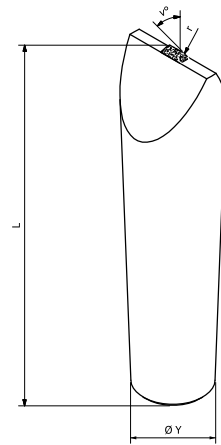


TOOLS FOR FORMING (DIAFORM)						
			CYLINDRICAL SHANK			
Code	V°	r	ø y	L	Type	
STANDARD	U1D40R125	40°	0,125	9.52	45	Diaform
	U1D40R250	40°	0,250	9.52	45	Diaform
	U1D60R250	60°	0,250	9.52	45	Diaform
	U1D60R500	60°	0,500	9.52	45	Diaform
HIGH QUALITY	U4D40R125	40°	0,125	9.52	45	Diaform
	U4D40R250	40°	0,250	9.52	45	Diaform
	U4D40R500	40°	0,500	9.52	45	Diaform
	U4D60R125	60°	0,125	9.52	45	Diaform
	U4D60R250	60°	0,250	9.52	45	Diaform
	U4D60R500	60°	0,500	9.52	45	Diaform



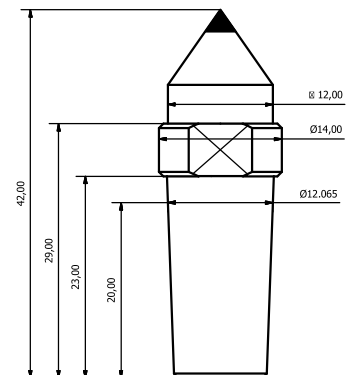
CHISEL TOOLS						
			CYLINDRICAL SHANK			
Code	V°	r	ø y	L	Machine	
HIGH QUALITY	U4D40R125G850	40°	0,125	8	50	MORARA
	U4D40R250G850	40°	0,250	8	50	MORARA
	U4D40R500G850	40°	0,500	8	50	MORARA
	U4D60R125G850	60°	0,125	8	50	MORARA
	U4D60R250G850	60°	0,250	8	50	MORARA
	U4D60R500G850	60°	0,500	8	50	MORARA
	U4D40R125G1050	40°	0,125	10	50	TACHELLA
	U4D40R250G1050	40°	0,250	10	50	TACHELLA
	U4D40R500G1050	40°	0,500	10	50	TACHELLA
	U4D60R125G1050	60°	0,125	10	50	TACHELLA
	U4D60R250G1050	60°	0,250	10	50	TACHELLA
	U4D60R500G1050	60°	0,500	10	50	TACHELLA

Chisel Cylindrical Shank



CHISEL TOOLS					
Code	V°	r	MORSE TAPER 1	Machine	
HIGH QUALITY	U4D40R125CM1	40°	0,125	CM1 x 23	STUDER
	U4D40R250CM1	40°	0,250	CM1 x 23	STUDER
	U4D40R500CM1	40°	0,500	CM1 x 23	STUDER
	U4D60R125CM1	60°	0,125	CM1 x 23	STUDER
	U4D60R250CM1	60°	0,250	CM1 x 23	STUDER
	U4D60R500CM1	60°	0,500	CM1 x 23	STUDER

Chisel Morse taper 1



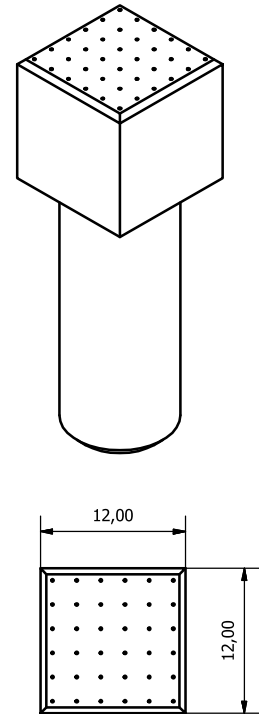


SQUARE HEAD DRESSERS (HANDSET)

CYLINDRICAL SHANK

	Code	Section		Grit wheel	ϕ y	L	Diamond Ct
STANDARD	U1MTQ4S20G10	15	15		10	50	2,0
	U1MTQ4S25G10	15	15		10	50	2,5
	U1MTQ4S30G10	15	15		10	50	3,0
	U1MTQ4S50G10	15	15		10	50	5,0
HIGH QUALITY	U4MTQ12Y46G1050	12	12	46	10	50	2,0
	U4MTQ12Y46G1250	12	12	46	12	50	2,0
	U4MTQ12Y60G1050	12	12	60	10	50	2,0
	U4MTQ12Y60G1250	12	12	60	12	50	2,0
	U4MTQ12Y80G1050	12	12	80	10	50	2,0
	U4MTQ12Y80G1250	12	12	80	12	50	2,0
	U4MTQ15Y4625G1050	15	15	46	10	50	2,5
	U4MTQ15Y4625G1250	15	15	46	12	50	2,5
	U4MTQ15Y6025G1050	15	15	60	10	50	2,5
	U4MTQ15Y6025G1250	15	15	60	12	50	2,5
	U4MTQ15Y8025G1050	15	15	80	10	50	2,5
	U4MTQ15Y8025G1250	15	15	80	12	50	2,5
	U4MTQ15Y4630G1050	15	15	46	10	50	3,0
	U4MTQ15Y4630G1250	15	15	46	12	50	3,0
	U4MTQ15Y6030G1050	15	15	60	10	50	3,0
	U4MTQ15Y6030G1250	15	15	60	12	50	3,0
	U4MTQ15Y8030G1050	15	15	80	10	50	3,0
	U4MTQ15Y8030G1250	15	15	80	12	50	3,0

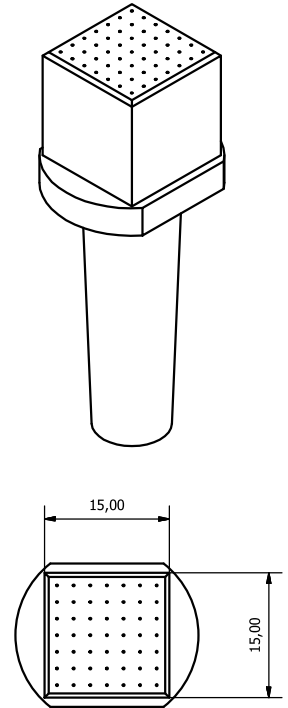
Cylindrical shank





SQUARE HEAD DRESSERS (HANDSET)						
					MORSE TAPER 1	
Code	Section		Grit wheel		Diamond Ct	
STANDARD	U1MTQ4S20CM1	15	15		CM1 x 50mm	2,0
	U1MTQ4S25CM1	15	15		CM1 x 50mm	2,5
	U1MTQ4S30CM1	15	15		CM1 x 50mm	3,0
	U1MTQ4S50CM1	15	15		CM1 x 50mm	5,0
HIGH QUALITY	U4MTQ12Y46CM125	12	12	46	CM1 x 25mm	2,0
	U4MTQ12Y60CM125	12	12	60	CM1 x 25mm	2,0
	U4MTQ12Y80CM125	12	12	80	CM1 x 25mm	2,0
	U4MTQ12Y46CM1	12	12	46	CM1 x 50mm	2,0
	U4MTQ12Y60CM1	12	12	60	CM1 x 50mm	2,0
	U4MTQ12Y80CM1	12	12	80	CM1 x 50mm	2,0
	U4MTQ12Y46CM180	12	12	46	CM1 x 80mm	2,0
	U4MTQ12Y60CM180	12	12	60	CM1 x 80mm	2,0
	U4MTQ12Y80CM180	12	12	80	CM1 x 80mm	2,0
	U4MTQ1525Y46CM125	15	15	46	CM1 x 25mm	2,5
	U4MTQ1525Y60CM125	15	15	60	CM1 x 25mm	2,5
	U4MTQ1525Y80CM125	15	15	80	CM1 x 25mm	2,5
	U4MTQ1525Y46CM1	15	15	46	CM1 x 50mm	2,5
	U4MTQ1525Y60CM1	15	15	60	CM1 x 50mm	2,5
	U4MTQ1525Y80CM1	15	15	80	CM1 x 50mm	2,5
	U4MTQ1525Y46CM180	15	15	46	CM1 x 80mm	2,5
	U4MTQ1525Y60CM180	15	15	60	CM1 x 80mm	2,5
	U4MTQ1525Y80CM180	15	15	80	CM1 x 80mm	2,5
	U4MTQ1530Y46CM125	15	15	46	CM1 x 25mm	3,0
	U4MTQ1530Y60CM125	15	15	60	CM1 x 25mm	3,0
	U4MTQ1530Y80CM125	15	15	80	CM1 x 25mm	3,0
	U4MTQ1530Y46CM1	15	15	46	CM1 x 50mm	3,0
	U4MTQ1530Y60CM1	15	15	60	CM1 x 50mm	3,0
	U4MTQ1530Y80CM1	15	15	80	CM1 x 50mm	3,0
	U4MTQ1530Y46CM180	15	15	46	CM1 x 80mm	3,0
	U4MTQ1530Y60CM180	15	15	60	CM1 x 80mm	3,0
	U4MTQ1530Y80CM180	15	15	80	CM1 x 80mm	3,0

Morse taper 1



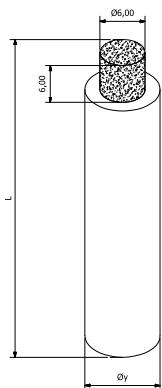


ROUND HEAD DRESSERS (CONCRETION)

CYLINDRICAL SHANK						
Code	$\varnothing d$	x	$\varnothing y$	L	Shape	Grit Diamond
U1820G10	10	10	10	40	PBP-8	600/800 20/30MESH STANDARD
U4720G10	6	6	10	45	PBP7	600/800 20/30MESH HIGH QUALITY
U4820G10	10	10	10	48	PBP8	600/800 20/30MESH
U48S20G10	10	10	10	48	PBP8S-15°	600/800 20/30MESH

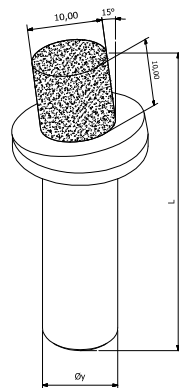
MORSE TAPER 1						
Code	$\varnothing d$	x			Shape	Grit Diamond
U1820CM1	10	10	CM1 x 40		PBP-8	600/800 20/30MESH STANDARD
U4720CM1	6	6	CM1 x 48		PBP7	600/800 20/30MESH HIGH QUALITY
U4820CM1	10	10	CM1 x 48		PBP8	600/800 20/30MESH
U48S20CM1	10	10	CM1 x 48		PBP8S-15°	600/800 20/30MESH

Cylindrical shank



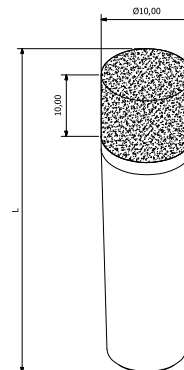
PBP7 - PBP8

Cylindrical shank 15°



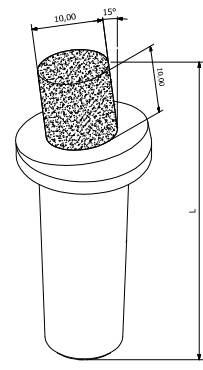
PBP8S-15°

Morse taper 1



PBP7 - PBP8

Morse taper 1 15°



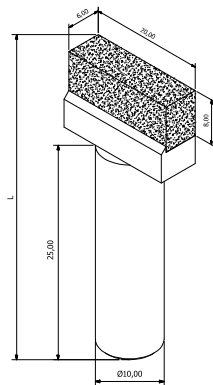
PBP8S-15°



RECTANGULAR HEAD DRESSERS (CONCRETION)						
			CYLINDRICAL SHANK			
Code	Section	x	ϕ y	L	Shape	Grit Diamond
U4320G10	6 x 12	10	10	40	PBP3	600/800 20/30MESH HIGH QUALITY
U43S20G10	6 x 12	10	10	40	PBP3S-15°	600/800 20/30MESH
U4120G10	6 x 20	10	10	40	PBP1	600/800 20/30MESH
U41S20G10	6 x 20	10	10	40	PBP1S-15°	600/800 20/30MESH

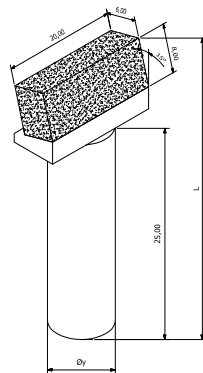
			MORSE TAPER 1			
Code	Section	x		V°	Grit Diamond	
U4320CM1	6 x 12	10	CM1 x 40	PBP3	600/800 20/30MESH	HIGH QUALITY
U43S20CM1	6 x 12	10	CM1 x 40	PBP3S-15°	600/800 20/30MESH	
U4120CM1	6 x 20	10	CM1 x 40	PBP1	600/800 20/30MESH	
U41S20CM1	6 x 20	10	CM1 x 40	PBP1S-15°	600/800 20/30MESH	

Cylindrical shank



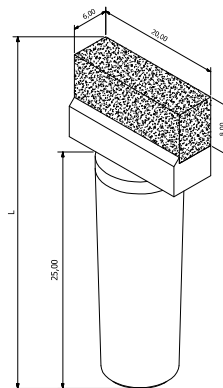
PBP1 - PBP3

Cylindrical shank 15°



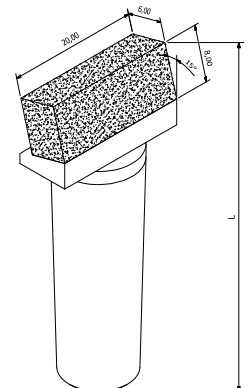
PBP1S-15° - PBP3S-15°

Morse taper 1



PBP1 - PBP3

Morse taper 1 15°



PBP1S-15° - PBP3S-15°