DIAMOND DRESSERS

Norton stationary diamond dressing tools have a worldwide reputation for quality and technology.

APPLICATIONS & MARKETS

- For profiling & straight dressing of all conventional grinding wheels

PRODUCT SELECTION

USAGE KEY

■ Highly recommended

▰ Recommended

DRESSING TOOL	GENERAL CHOICE					
	STRAIGHT GRINDING WHEELS WITH NO PROFILE	PROFILED GRINDING WHEELS	GRIT	AUTOMATIC DRESSING PROCESS	ECONOMICAL DRESSING	HIGH REMOVAL RATE
Single-point	▰		All			
Multi-point	■		36-180		■	■
Blade tool dresser	■	▰	36-180	■	■	▰
Profile dresser		■	80-180			

SPEC CHECK

- A new dressing tool should be put through at least 5 dressing cycles in order to fit the diameter of the grinding wheel
- The lifetime of the dressing tool is extended by ensuring that adequate coolant pressure & volume are directed at the tool

BEST

BLADE TOOL DRESSER HPB-D 3565 & 3585

FEATURES	BENEFITS
■ Synthetic multi-crystaline diamond	■ Gives the highest repeatability & consistency of dressing for the highest demands for profiling & straight dressing

BETTER

BLADE TOOL DRESSER HPB-D & -C 30, 45, 60

FEATURES	BENEFITS
■ Natural diamond	■ For an economical dressing solution of all Alox & SiC wheels. Needles are recommended for profile dressing

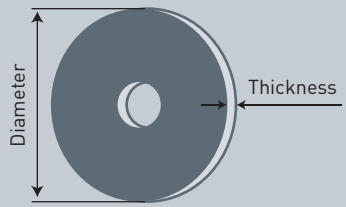
SELECTION OF BLADE TOOL DRESSERS

Dressing of profiles with blade tools	Dressing tools use "needle" form natural or synthetic diamonds Needle diamonds are especially suited to dressing profiles using infeed & angular feed
Natural diamonds	An effective diamond layer with a length up to 15mm gives a very economical dressing solution. Using precise diamond setting patterns, with overlapped rows of stones ensures that consistent dressing results are achieved
Synthetic diamonds	The constant cross section given by synthetic diamonds, guarantee a constant dressing behaviour through the complete life of the dressing tool

SELECTION OF GRIT SIZE

Grit size of grinding wheel	Synthetic diamond size	Natural diamond size
46	0,8x0,8	D1181
60	0,8x0,8	D1001
80-120	0,6x0,6	D711

SELECTION OF TOOL SIZE



Diameter x Thickness (mm)	No. of synthetic needles	Dimensions
<35000	2	10,5x28
35000-60000	3	20,5x28
60000-100000	4	20,5x28

BLADE TOOL DRESSERS

W (mm)	L (mm)	DL (mm)	GRIT	PK QTY	BEST		BETTER	
10,5	28	12	D711	1			HPB-D 30	601576**82759**
	28	12	D1001	1			HPB-D 45	601576**82782**
	28	12	D1181	1			HPB-D 60	601576**82786**
	28	12	NEEDLE	1			HPB-D	601576**82790**
20,5	28	10	D711	1			HPB-C 30	601576**82801**
	28	10	D1001	1			HPB-C 45	601576**82806**
	28	10	D1181	1			HPB-C 60	601576**82809**
	28	10	NEEDLE	1			HPB-C	601576**82814**
10,5	28	4	0,6x0,6	1	HPB-D 3565 / 2	601576**82820**		
	28	4	0,6x0,6	1	HPB-D 3565 / 3	601576**82856**		
	28	4	0,6x0,6	1	HPB-D 3565 / 4	601576**82895**		
	28	4	0,8x0,8	1	HPB-D 3585 / 2	601576**82899**		
	28	4	0,8x0,8	1	HPB-D 3585 / 3	601576**82902**		
	28	4	0,8x0,8	1	HPB-D 3585 / 4	601576**82904**		

SCREWED SHANKS FOR BLADE TOOL DRESSERS

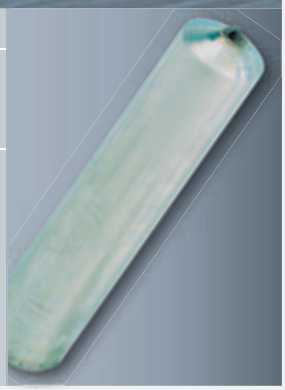
DIA (mm)	L (mm)	SHANK CODE	PK QTY	BEST	
12,065	40	MT1	1	HPB-H3	601576**82832**
9,045	25,5	MT0	1	HPB-H4	601576**82907**
11,11	50	Z11,11	1	HPB-H2	601576**82910**
10,00	50	Z10	1	HPB-HX	601576**82911**

Dimensions Key: DIA = Diameter, W = Width, L = Length, DL = Diamond Length

BEST

SINGLE-POINT DRESSER BC SG

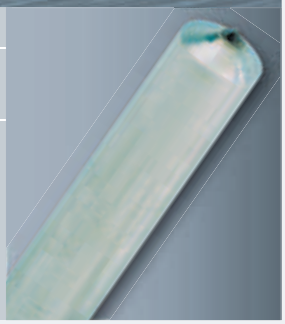
FEATURES	BENEFITS
■ Highest quality diamonds	■ Especially developed for dressing ceramic abrasive (SG/TG) wheels which require faster traverse speed dressing
■ High performance tools	■ Enables dressing costs to be reduced, especially at production grinding stations



BETTER

SINGLE-POINT DRESSER BC

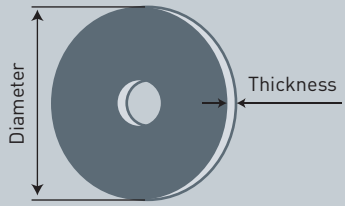
FEATURES	BENEFITS
■ Feature standard diamonds	■ Ideal for applications where it's difficult to measure the performance of the dressing tool
■ Economy product	■ Suitable for dressing conventional abrasive wheels



CHOICE OF SINGLE-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed.
In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
< 6000	0,33 Carat
6000 – 18000	0,50 Carat
> 18000	1,0 Carat

For best results, always use a coolant when dressing

SINGLE-POINT DRESSERS

SHANK (mm)	CARAT	PK QTY	BEST	BETTER
			BC SG	BC
Z8	0,33	1		66260161753
	0,50	1	66260161757	66260161752
	1,00	1	66260161755	66260161750
Z10	0,33	1	66260161769	66260161764
	0,50	1	66260161768	66260161763
	1,00	1	66260161766	66260161761
Z11,11	0,33	1	66260156906	66260195003
	0,50	1	66260156907	66260195005
	1,00	1	66260157010	66260195009
Z12	0,33	1		66260161775
	0,50	1	66260161779	66260161774
	1,00	1	66260161777	

BEST

PROFILE DRESSER

FEATURES

- Extremely high performance tools

BENEFITS

- Used to meet extremely high profile accuracy requirements

PROFILE DRESSER

SHANK (mm)	RADIUS (mm)	ANGLE	BEST	
Z9,52	0,13	40°	DC 40/130	60157682850
	0,25	40°	DC 40/250	60157682889
	0,50	40°	DC 40/500	60157682901
	0,13	60°	DC 60/130	60157682903
	0,25	60°	DC 60/250	60157682905
	0,50	60°	DC 60/500	60157682909

BEST

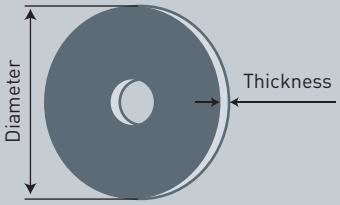
MULTI-POINT DRESSER

FEATURES	BENEFITS
■ Economical & robust tool	■ Ideal for straight dressing at high speed with low technical demands

CHOICE OF MULTI-POINT DRESSERS

Which tool to choose depends mainly on the dimensions of the wheel to be dressed.
In order to calculate this, it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS



Diameter x Thickness (mm)	Carat
<30000	1,3 Carat
30000 –60000	2,5 Carat
>60000	5,0 Carat

For best results, always use a coolant when dressing

CHOICE OF A DIAMOND GRIT	
Wheel abrasive	Diamond
80-120	D301
60-80	D711
46-60	D1001
36-46	D2240

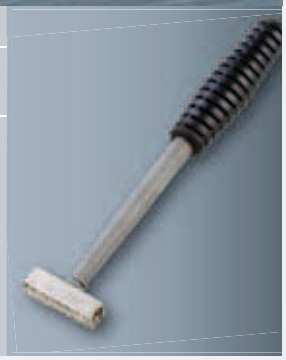
MULTI-POINT DRESSERS

SHANK (mm)	GRIT	PK QTY	BEST		
			D11x11 (5 CARAT)	D8x11 (2,5 CARAT)	D6x8 (1,3 CARAT)
Z8	D2240	1	601576**82849**	601576**82915**	
	D1001	1	601576**82896**	601576**82920**	
	D711	1	601576**82906**	601576**82970**	601576**82986**
	D301	1			601576**83153**
Z10	D2240	1	601576**82892**	601576**82916**	
	D1001	1	601576**82897**	601576**82922**	
	D711	1	601576**82908**	601576**82968**	601576**82990**
	D301	1			601576**83154**
Z11,11	D2240	1	601576**82893**	601576**82917**	
	D1001	1	601576**82898**	601576**82923**	
	D711	1	601576**82912**	601576**82977**	601576**82992**
	D301	1			601576**83155**
MT1 12,065	D2240	1	601576**82894**	601576**82918**	
	D1001	1	601576**82900**	601576**82925**	
	D711	1	601576**82914**	601576**82981**	601576**82996**
	D301	1			601576**83156**

BEST

HAND DRESSER

FEATURES	BENEFITS
■ High diamond concentration	■ High wear resistance & long lifetime
■ Grit 18/25 SPC	■ Suitable for face & side dressing



HAND DRESSER

PK QTY	BEST	
1	HD-150	601576**82852**

BEST

BRAKE CONTROLLED TRUING DEVICE

FEATURES	BENEFITS
■ For fast effective truing of Diamond & CBN wheels with minimum loss of abrasive	■ Ideal for truing the following Diamond & CBN wheel types: straight wheels with diamond in the periphery, tool & cutter grinding wheels, wheels used on surface & cylindrical grinding machines, cut-off wheels, internal grinding wheels & cup wheels with diamond in the rim as used on vertical spindle surface grinders

BRAKE CONTROLLED TRUING DEVICE

PK QTY	BEST	
1	BCTD	662602**74459**

REPLACEMENT WHEELS

DIA (mm)	T (mm)	B (mm)	PK QTY	BEST	
80	25	13	10	Wheel 37C60-NV	699366**68764**

SPEC CHECK

- Mount the device spindle parallel to the wheel spindle to ensure proper straight face truing
- For cup shaped wheels, the device spindle will be mounted perpendicular to the wheel spindle
- Use appropriate traverse rates

Dimensions Key: DIA = Diameter, T= Thickness, B = Bore