

### SINGLE POINT DIAMOND DRESSERS:



**Details:** Single point "brutted diamond" dressers are made with selected "Congo Rounds" mounted in a matrix. A single cutting edge is presented to the grinding wheel.

Diamonds for single point dressers are selected in accordance with quality and size. The question of using a superior, average or commercial quality, depends on the grinding finish required, and the machines and working parameters.

We offer three grades namely A, B & C for all the diamond size, i.e. from 0.15 to 5.00 carat size.

#### **Guideline for single -point diamond dressers:**

Considerable care should be taken in mounting the diamond dresser in position. Diamonds are sensitive to shock and impact.

The dresser must be clamped rigidly in place to avoid vibration once dressing begins.

An ample supply of coolant should be directed to contact at the diamond point before dressing begins, as the sudden application of coolant to the diamond once it has heated up can cause it to shatter.

The diamond holder should not be set directly on the centre of the grinding wheel, but at an angle of  $5^{\circ}$  -  $15^{\circ}$  to the direction of rotation of the wheel so that it appears to be "trailing".


At normal wheel peripheral speeds dressing rates of approximately 20-25 m/sec can be achieved.

The maximum depth of cut achieved per dressing pass is 0.03 mm or on fine grit wheels, approximately 0.005-0.01 mm.

The cross feed rate is dependent upon grit size and can have a marked influence on the quality of the finish imparted to the grinding wheel surface. The lower the feed rate, the finer the surface finish. We would recommend the following feed rates per revolution of the grinding wheel.

Grinding wheel grit size	Feed rate in mm / rew
30 - 46	0.60 - 0.30
50 - 120	0.30 - 0.10
180 - 320	0.10 - 0.02

**Technical Details:** Standard Shanks 1/2" x 7" upto 2.50cts. Standard shanks 5/8" x 7" over 2.50 cts. Shanks are also fabricated according to your blue prints. While ordering specify grade & ct. wt.

Ct. Size	Grade	Dimension
0.15	A	
0.25	B	
0.35	C	
0.50		
0.75		
1.00		
1.50		
2.00		
2.50		
3.00		
3.50		
4.00		
4.50		
5.00		