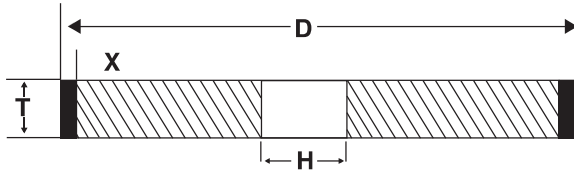


**Solar**  
DIAMOND

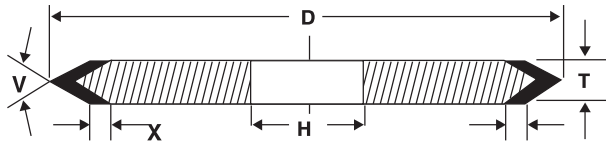


**Resin & Metal Bond Wheels  
In Diamond & CBN**

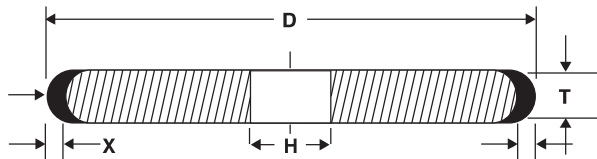
# Resin & Metal Bond Wheels in Diamond & CBN



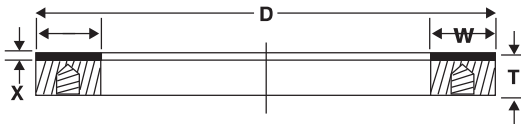
**1 A 1** Straight-Diamond in Periphery



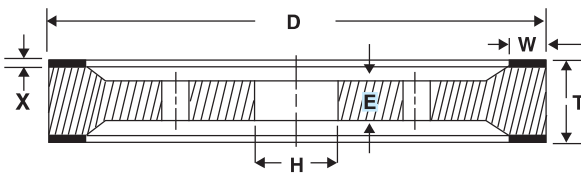
**1EE1** Straight-Diamond in Periphery



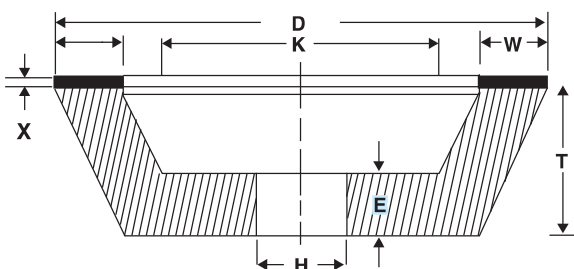
**1FF1** Straight-Diamond in Periphery



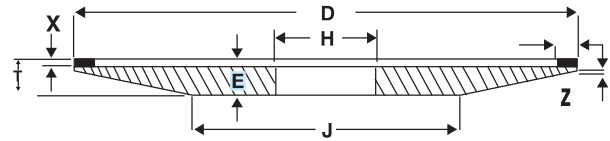
**2 A 2T** Cylinder-Diamond in Rim



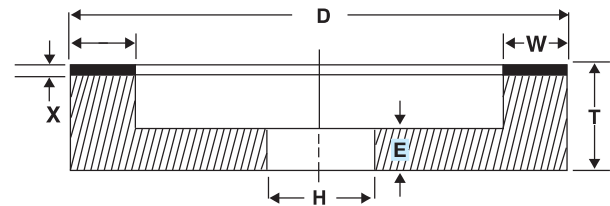
**9A 3H** Double Cup-Diamond in Rim



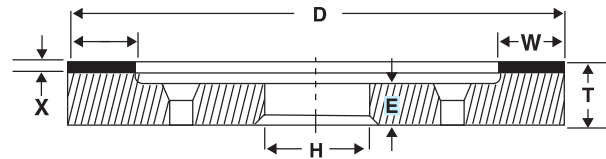
**11 A 2** Double Cup-Diamond in Rim



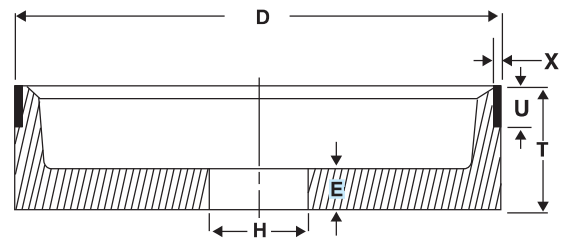
**4 A 2** Dish-Diamond in Rim



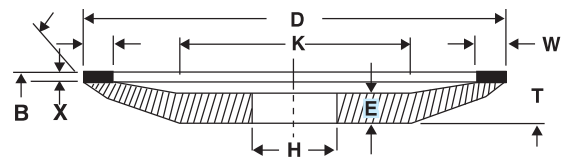
**6 A 2** Plain Cup-Diamond in Rim



**6 A 2 C** Plain Cup-Diamond in Rim With Countersunk Bolt Holes

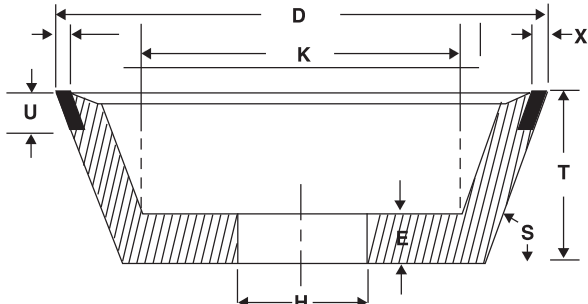


**6 A 9** Plain Cup-Diamond in Corner

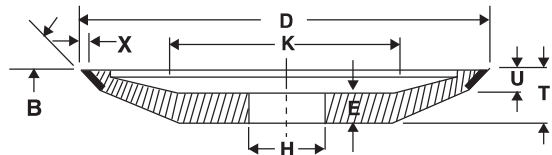


**15 A 2** Dish-Diamond in Rim

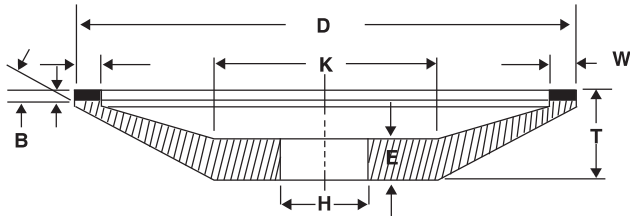
# Resin & Metal Bond Wheels in Diamond & CBN



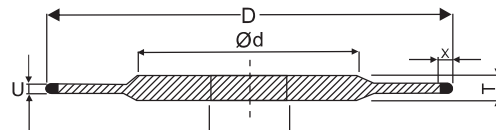
**11 V 9** Flaring Cup-Diamond in Corner



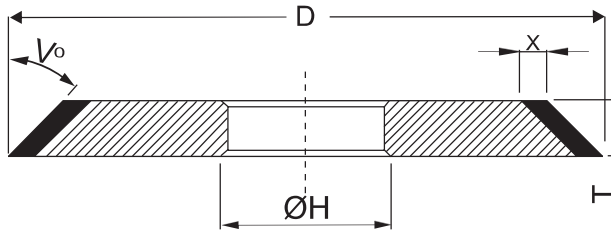
**15 V 9** Dish-Diamond in Corner



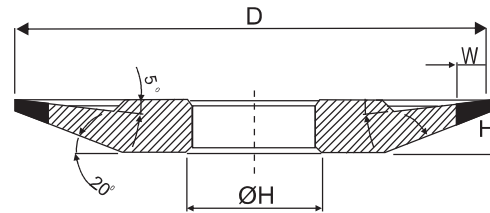
**12 A 2-20°** Dish-Diamond in Rim



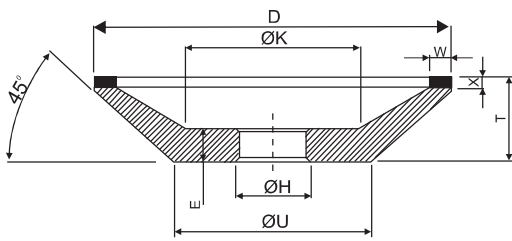
**14F1**



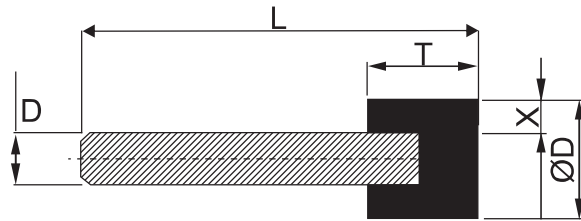
**1V1-V<sup>0</sup>**



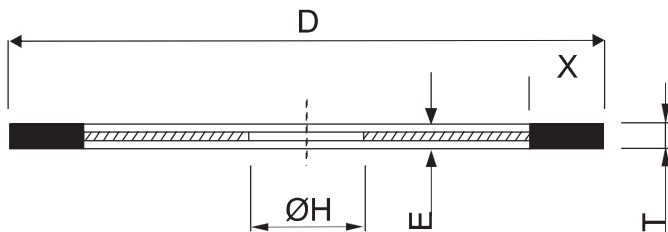
**4B19**



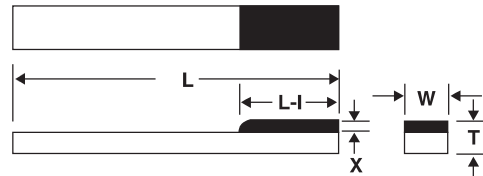
**12A2-45°**



**1A8W**



**1A1R**



**HH1** Hand Hone-Diamond at one end

# Resin & Metal Bond Wheels in Diamond & CBN



## HOW TO ORDER

- (1) Select the type or shape of a wheel from the catalog, which fits to your application and machine.
- (2) Mention dimensions in the following order and fashion.  
Diameter x Thickness (Width) x Hole x Depth of Imp.
- (3) Decide the specifications with the help of following table and guide-lines or you can fill in the Grinding Data Sheet and return to us with the order and we will recommend the specifications and supply you the wheel which suits to your application.

EXAMPLE : Wheel 1A1 150 x 10 x 31.75 x 3 mm D 120 R 75 BS 3 (bold letters in the table)

Abrasive	Grit Size	Grade	Concentration	Bond	Depth of Diamond
D-Diamond	100-120	L. Soft	100 High	BS	
	150-180			BF	
B-Borazon	220-270	G. Med.	75 Medium	BA	3
	320-400 or	H. Hard		BD	
	D30, D15			MI	

## SELECTION GUIDE-LINES FOR SPECIFICATIONS

- (1) ABRASIVE: (a) Diamond for carbide grinding  
(b) Borazon for Molybdenum and Tungsten type high speed steels
- (2) GRIT SIZE : Use the coarsest grit commensurate with finish from the table below :

GRIT SIZE in Mesh	120	150	180	220	325	400	D15
FINISH in Microinch	24	22	16	12	10	8	3
FINISH in Micron	0.6	0.55	0.4	0.3	0.25	0.2	0.08

- (3) GRADE : L.....G.....H.....  

High wheel cost	→	→	→	→	→	→	→	Low wheel cost
Low time cost	←	←	←	←	←	←	←	High time cost
High cutting efficiency	→	→	→	→	→	→	→	Low cutting effi.

- (4) CONCENTRATION :

50 (Low)	75	100 (High)
Face grinding		Surface grinding
Internal grinding		Cylindrical grinding
Form grinding		Centreless grinding
Dry grinding		Wet grinding
Over 4000 ftjmt speed in dry		3000 ft / mt
Heavy infeed		Light infeed
Larger carbide		Small carbide
Finer grit		Coarser grit

- (5) BOND :

- |                                  |                                   |
|----------------------------------|-----------------------------------|
| (a) General Purpose... .. G      | (b) Finer Finish ... .. BF        |
| (c) Mirror Finish (wet) ... .. H | (d) Mirror Finish (dry) ... .. BD |
| (e) General Purpose Metal... MI  | (f) Non Metallic Materials ... MS |

## Corporate Office:

213, Bhaveshwar Complex, Opp. Railway Station, Vidyavihar (West), Mumbai - 400 086. India.

Tel. : +91-22-2513 6660 / +91-22-2511 4744 / +91-22-2511 3166

Email : solardiamondtools@gmail.com • Web : www.solardiamondtools.com