

Attention to the use of Diamond Grinding tools

Written by YingLong

Saturday, 30 September 2006 12:27 - Last Updated Friday, 17 September 2010 17:01

2、 Selection of Granule-Degree

Coarse granule of abrasive materials bring better efficiency, while the surface of workpiece will be rough.

In the condition of satisfy the coarseness of surface, it is better to choose coarse Grit-size.

It is better for Resinoid binder grinding tools to choose 70/80 80# and following RVD(JR1) Diamond.

It is better for Metalic (bronze) binder grinding tools to choose MBD(JR2) Diamond.

Granularity number & Basal granule size of Synthetic Diamond or CBN will be seen in the former sheet(Page.2).

CBN tools process ordinary steels, carbon steel and varieties of alloyed steel precede Diamond.

The relationship between Diamond granularity and process coarse granularity

Granularity number

Reachable surface coarseness

Original criterion of Industry Department

Criterion of P.R.C.

Resin Binder

Metal Binder

80# 100#

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70/80 100/120

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6 8

100# 150#

100/120 140/170

8 9

7 9

180# 240#

140/170 230/270

9 10

8 9

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280# W20

230/270 12-22

10 11

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W14 W5

8-12 4-8

11 12

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W5 W0.5

4-8 0-0.5

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The relationship between grinding procedure and granularity

Grinding Procedure

Granularity selected

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Coarseness

80# □ 120#

70/80 □ 120/140

Coarseness&Precision

120# □ 180#

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120/140 □ 200/230

Precision

180# □ W40

200/230 □ 36-54

Grinding&Polishing

W40 □ W1

36-54 □ 0.5-1