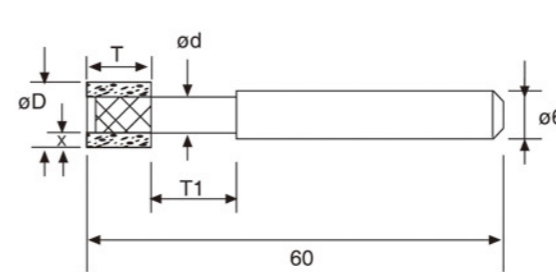
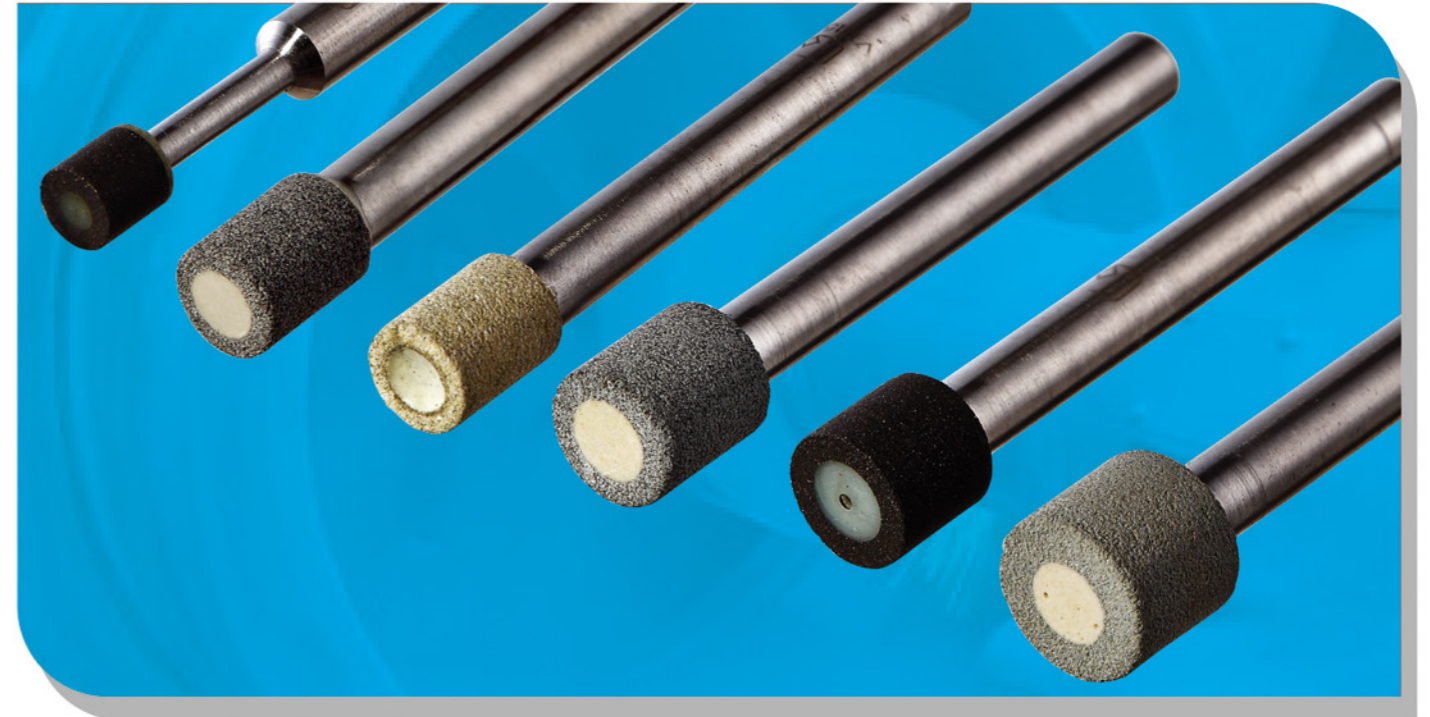


单位:mm
Unit:mm

编码/Order no.		ϕD	T	N	L	$\phi B/\phi H$	粒度 Grit size
钻石/Diamond	氮化硼/CBN						
ID-3004	IB-3004	0.4	5	5	45	3.0B	#600
ID-3005	IB-3005	0.5	5	5	45	3.0B	#400
ID-3006	IB-3006	0.6	5	5	45	3.0B	#200
ID-3007	IB-3007	0.7	6	6	45	3.0B	#200
ID-3008	IB-3008	0.8	6	6	45	3.0B	#200
ID-3009	IB-3009	0.9	6	6	45	3.0B	#200
ID-3010	IB-3010	1.0	8	8	45	3.0B	#200
ID-3015	IB-3015	1.5	5	8	45	3.0B	#150
ID-3020	IB-3020	2.0	5	12	45	3.0B	#150
ID-3025	IB-3025	2.5	5	15	45	3.0B	#150
ID-3030	IB-3030	3.0	5	15	45	3.0B	#150
ID-3040	IB-3040	4.0	5	-	50	3.0B	#150
ID-3050	IB-3050	5.0	8	-	50	3.0B	#150
ID-3060	IB-3060	6.0	8	-	50	3.0B	#150
ID-6040	IB-6040	4.0	10	22	80	6.0B	#100
ID-6050	IB-6050	5.0	10	22	80	6.0B	#100
ID-6060	IB-6060	6.0	10	22	80	6.0B	#100
ID-6070	IB-6070	7.0	10	-	80	6.0B	#100
ID-6080	IB-6080	8.0	10	-	80	6.0B	#100
ID-6090	IB-6090	9.0	10	-	80	6.0B	#100
ID-6100	IB-6100	10	10	-	80	6.0B	#100
ID-6120	IB-6120	12	10	-	80	6.0B	#100
ID-6140	IB-6140	14	10	-	80	6.0B	#100
ID-6160	IB-6160	16	12	-	80	6.0B	#100
ID-10200	IB-10200	20	12	-	80	6.0B	#100

标准粒度外其他粒度请指明订购。
Others available upon your request.

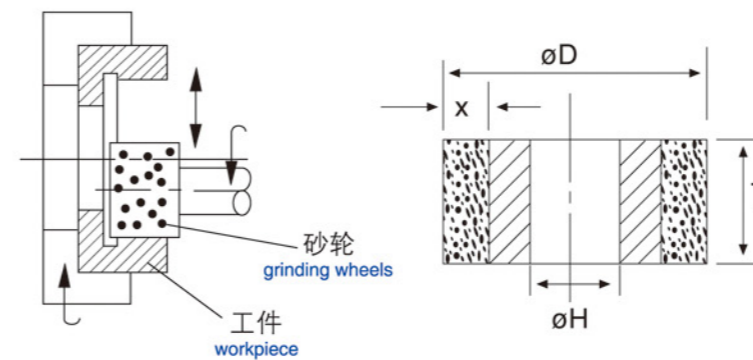
注: CBN磨棒柄部增加小沟以区分
Note: CBN wheel will have a small groove on the shank



带柄型
With shank

型号 Order No.	D	T	X	d	T1	结合剂 Bond	粒度 Grit
D8	8	10	1.5	4.5	15	V(陶瓷) Vitrified	D150
D10	10	10	2	6	/	R(树脂) Resin	B150
D12	12	10	3	6	/		

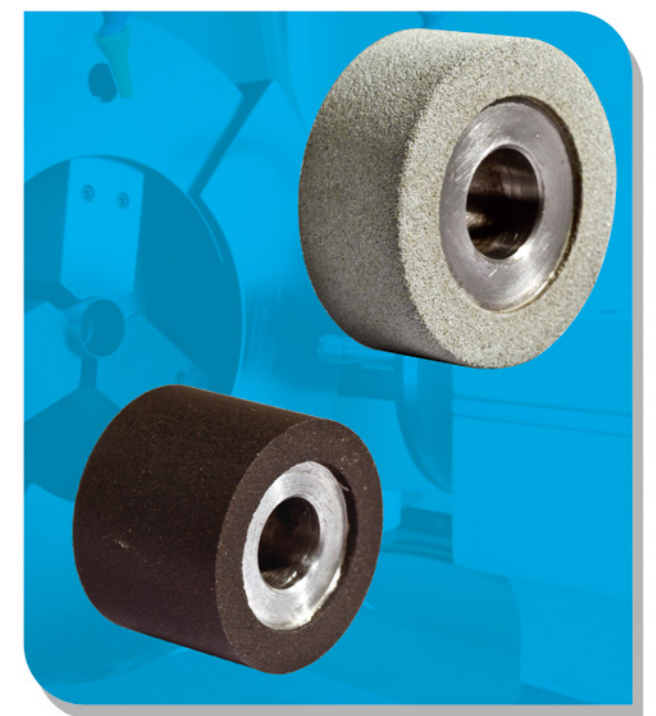
同心度 $\leq 0.01\text{mm}$
Concentricity $\leq 0.01\text{mm}$



拆换型
Replaceable type

型号 Order No.	D	T	X	H	结合剂 Bond	粒度 Grit
D16	16	12	2.5	6	V(陶瓷) Vitrified	D150
D20	20	12	2.5	10		
D25	25	12	4	10	R(树脂) Resin	B150
D30	30	12	5	10		

装夹后务必妥善修整以确保同心度
After clamping you will have to dress it until the concentricity is below 0.01mm.



BH 系列磨棒—柄径为 $\phi 2.34\text{mm}$
BH Series- $\phi 2.34\text{mm}$ shank



单位:mm
Unit:mm

Order no.	BH11A*	BH14A*	BH19A*	BH24A*	BH27A*	BH32A*	BH39A	BH49A	BH14R	BH24R
ϕD	1.1	1.4	1.9	2.4	2.7	3.2	3.9	4.9	1.4	2.4
T	7	7	7	7	7	7	10	10	10	13

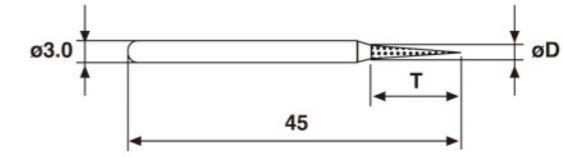
Order no.	BH20B*	BH24B*	BH30B	BH35B	BH39B	BH14C*	BH19C*	BH29C	BH39C	BH49C
ϕD	2.0	2.4	3.0	3.5	3.9	1.4	1.9	2.9	3.9	4.9
T	-T	-	-	-	-	7	7	7	10	10

Order no.	BH18P*	BH24P*	BH29P	BH42P*	BH14T*	BH19T*	BH26T*	BH30S*	BH30Y*	BH17J*
ϕD	1.8	2.4	2.9	4.2	1.4	1.9	2.6	3.0	3.0	1.7
T	10	12	14	6	7	7	7	6	-	10

BHS-30: 套装30支组。以上各一支 (30pcs/set, contains one each of above point).
BHS-300: 套装30支组 (以下每种两支)(30pcs/set, contains two each as below).
 BH-11A, 14A, 19A, 24A, 27A, 14C, 19C, 18P, 24P, 20B, 24B, 14T, 19T, 26T, 17J

BHS-20: 套装20支组。内容如下(20pcs/set, Contains one each as below):
 BH-11A, 14A, 19A, 24A, 27A, 32A, 20B, 24B, 35B, 14C, 19C, 18P, 24P, 42P, 14T, 19T, 26T, 30S, 30Y 17J

BM 系列磨棒—柄径为 $\phi 3.0\text{mm}$
BM Series- $\phi 3.0\text{mm}$ shank



单位:mm
Unit:mm

ϕD	$\phi 1$	$\phi 1.5$	$\phi 2$	$\phi 2.5$	$\phi 3$	$\phi 3.5$	$\phi 4$	$\phi 5$	$\phi 6$	$\phi 1$	$\phi 1.5$	$\phi 2$	$\phi 2.5$	$\phi 3$	$\phi 3.5$	$\phi 4$	$\phi 5$	$\phi 6$
T	8	8	8	8	10	10	10	10	10	8	8	8	8	10	10	10	10	10
NO.	10A	15A	20A	25A	30A	35A	40A	50A	60A	10C	15C	20C	25C	30C	35C	40C	50C	60C

ϕD	$\phi 2$	$\phi 3$	$\phi 3$	$\phi 1.2$	$\phi 1.5$	$\phi 1.5$	$\phi 2$	$\phi 3$	$\phi 3.3$	$\phi 3.3$	$\phi 2$	$\phi 3$	$\phi 4$	$\phi 5$	$\phi 6$	$\phi 2$	$\phi 3$	$\phi 3.3$
T	10	10	10	16	13	10	12	14	15	10	12	15	15	15	13	10	10	15
NO.	20T	30T	30V	13R	14R	15R	20R	30R	31R	32R	20P	30P	40P	50P	60P	20F	30F	33F

ϕD	$\phi 4$	$\phi 5$	$\phi 6$	$\phi 6$	$\phi 2$	$\phi 3$	$\phi 4$	$\phi 5$	$\phi 5$	$\phi 6$	$\phi 1$	$\phi 1.5$	$\phi 2$	$\phi 2.5$	$\phi 3$	$\phi 4$	$\phi 5$	$\phi 6$
T	10	10	12	10	6	14	9	10	13	13	-	-	-	-	-	-	-	-
NO.	40F	50F	60F	61F	20J	30J	40J	50J	51J	60J	10B	15B	20B	25B	30B	40B	50B	60B

ϕD	$\phi 8$	$\phi 3$	$\phi 4$	$\phi 5$	$\phi 5$	$\phi 6$	$\phi 6$	$\phi 2$	$\phi 3$	$\phi 3$	$\phi 3$	$\phi 3$	$\phi 3$	$\phi 3$	$\phi 3$	$\phi 4$	$\phi 5$	$\phi 6$
T	-	5	7	9	12	10	12	4	6	5.5	6	6	6	6	5	8	10	12
NO.	80B	30Q	40Q	50Q	51Q	60Q	61Q	20S	30S	31S	32S	33S	34S	35S	36S	40S	50S	60S

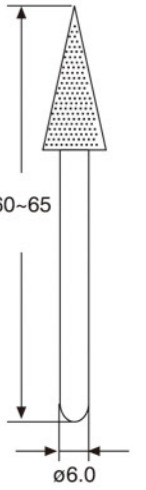
ϕD	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 10$	$\phi 12$	$\phi 13$	$\phi 13$
T	1	1.5	2	2.5	3	3.5	4	4	4	2	2	1
NO.	1310U	1315U	1320U	1325U	1330U	1335U	1340U	100Y	120X	130X	1310E	

ϕD	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 13$	$\phi 6$	$\phi 8$	$\phi 13$	$\phi 6$	$\phi 8$	$\phi 13$
T	1.5	2	2.5	3	3.5	4	3.5	4.5	3.4	3.5	4.5	3.4
NO.	1315E	1320E	1325E	1330E	1335E	1340E	60W	80W	130W	60M	80M	130M

粒度: 外径 $\phi 6.0\text{mm}$ 以上:#100, $\phi 2.0\text{--}5.0\text{mm}$: #120, $\phi 1.5\text{以下}$: #150
 Grit size: ϕD over $\phi 6.0\text{mm}$: #100, $\phi 2.0\text{--}5.0\text{mm}$: #120, $\phi 1.5\text{mm}$ & under: #150



BC 系列—柄径为 $\phi 6.0\text{mm}$
BC Series- $\phi 6.0\text{mm}$ shank



单位:mm
Unit:mm

30 BMS-30: 30支组(30pcs/set)

组装内容如下

Contains one each of below:

- BM-10A, 15A, 20A, 25A, 30A, 35A, 40A
- 50A, 20B, 30B, 50B, 15C, 20C, 25C
- 30C, 35C, 40C, 50C, 20P, 30P, 15R
- 20R, 30R, 30S, 20F, 30F, 50F, 20T
- 30T, 30V.



20 BMS-20: 20支组(20pcs/set)

组装内容如下

Contains one each of below:

- BM-10A, 15A, 20A, 25A, 30A, 35A
- 15C, 20C, 25C, 30C, 20P, 30P
- 15R, 20R, 30R, 20B, 30B, 20F
- 30F, 20T.

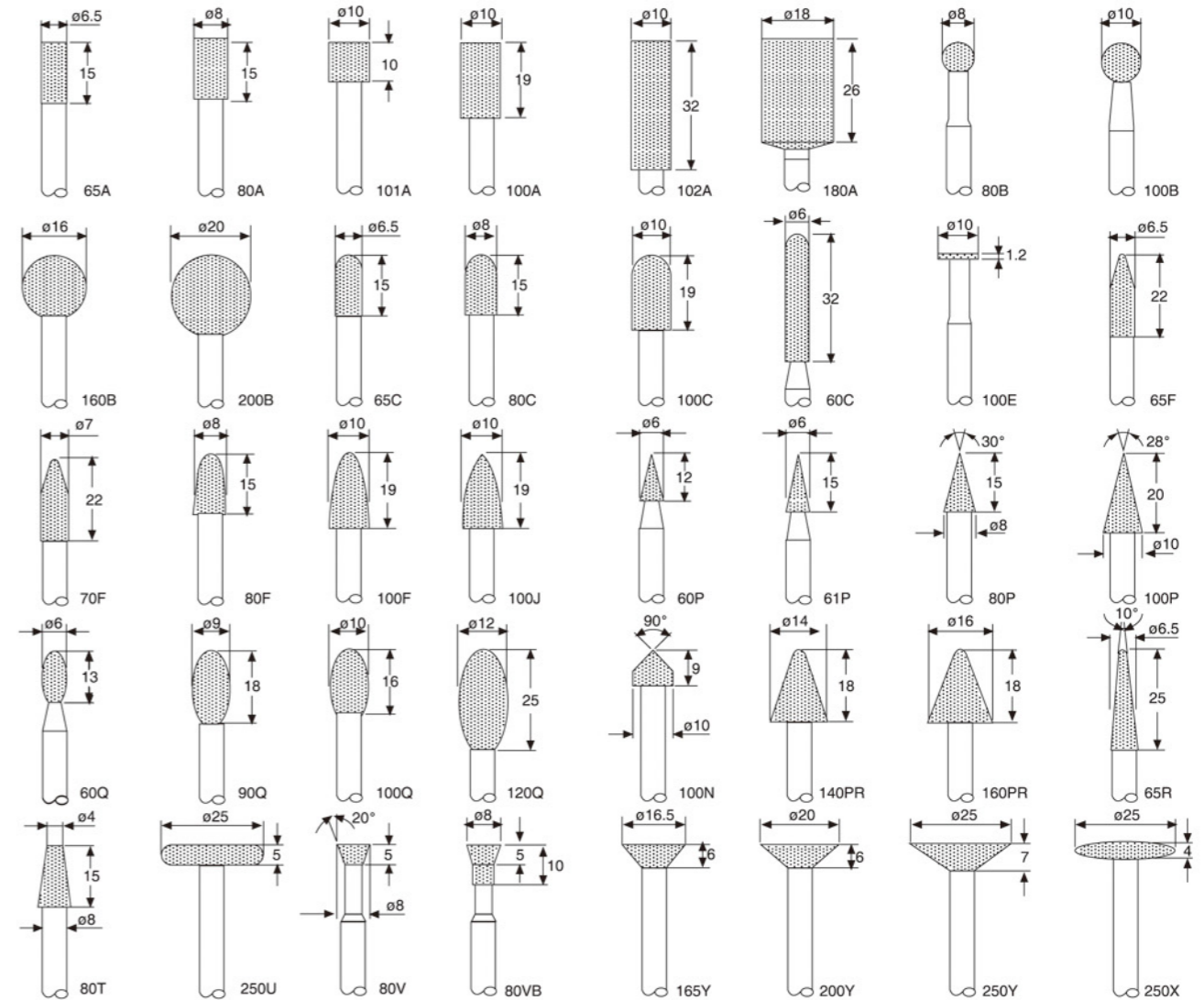


30 BMS-300: 30支组(30pcs/set)

组装内容如下

Contains one each of below:

- BM-10A, 15A, 15A, 20A, 20A, 25A
- 30A, 35A, 10C, 15C, 15C, 20C
- 20C, 25C, 30C, 35C, 20B, 30B
- 20P, 30P, 15R, 20R, 30R, 20F
- 20F, 30F, 20T, 30T 30V, 30S

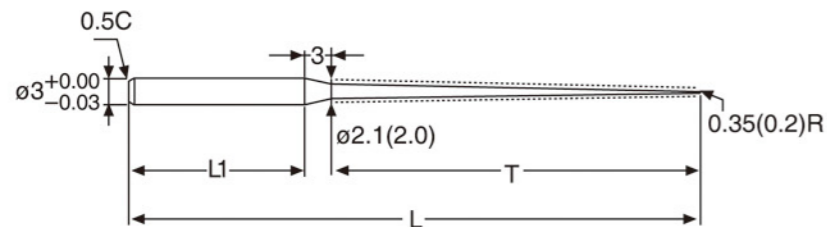


粒度: #40, #60, #100, 订购时请注明
Grit size: #40, #60, #100. When ordering, Please specify.



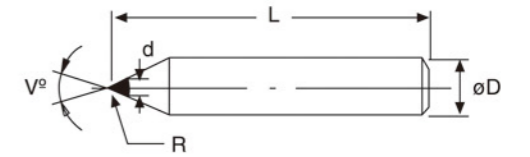
在一些特殊模具和机械零件的加工中,往往会碰到细长的孔洞或窄深的沟槽等需要研磨,这时候就必须使用一些细长的钻石研磨棒才能完成此类任务.由于机械尺寸的限制,这类的磨棒必须采用较硬的材料才能保证其强度。

With special hardened steel to meet the requirements of special moulds and parts which needs deeper grinding and finishing.



注: 1、同心度:0.005mm。
2、材料硬度:HRC40~50。
Note:1、Concentricity:0.005mm。
2、Hardness of shank:HRC40~50。

型号 Order No.	T	L	L1
20Px17T	17	50	30
20Px22T	22	50	25
20Px27T	27	50	20
20Px32T	32	65	30
20Px37T	37	65	25
20Px42T	42	65	20



一、圆锥修刀 Cone Dressers

BD圆锥修刀 BD Cone Dressers

钻石规格 Diamond spec	钻石大小 d (mm) Diamond size	标准尺寸(mm) Standard Dimension	标准尺寸(mm) Standard Dimension			
			D	L	V° R(mm)	
BD-30	0.5-0.8	1/60	3.15	25	60°	0.02-0.03
		1/50	10.0	50	90°	
BD-40	0.8-1.0	1/50	3.15	25	60°	0.02-0.03
		1/40	10.0	50	90°	
BD-50	1.0-1.3	1/30	3.15	25	60°	0.02-0.03
BD-60	1.3-1.5	1/20	6.33	50	90°	
BD-70	1.5-1.8	1/15	10.0			

用途: 用于普通砂轮的精密成型, 减薄
Application: dressing of ceramic wheels

CD 圆锥修刀/CD Cone Dressers

型号 Order No	d (mm)	钻石大小 (mm) Diamond size	标准尺寸(mm) Standard Dimension	V°	R(mm)
CD-40	1.0	1.2	Ø3.15x50L	60°	0.01
			Ø3.15x25L		
			Ø6.33x50L		

备注: 精选特殊钻石, 尖端较"BD"圆锥修刀不易破碎。
Note: selected diamond, the tip of diamond is stronger than "BD"

二、角锥修刀/Pyramid dressers

角锥修刀因其尖端被精确加工成规则的四角锥形, 可修出非常锐利的砂轮, 特别适合高精度内孔研磨砂轮的修形和修锐, 同时相较圆锥修刀, 尖端的抗冲击强度提高了30%左右。

Because of its exactly ground pyramid diamond tip, this kind of dresser is able to make grinding wheels to be very sharp. This feature is a key factor to make it possible for higher precision internal grinding. Compared with cone dressers, its impact toughness is raised by 30%.

1. BD 型角锥修刀/BD Pyramid dressers

BD型角锥修刀由高品质的天然钻石制作而成, 具有较高的平均寿命, 但个体间的寿命波动较大, 较适合手动型机床配备。

The BD type is made of high quality natural diamond, the average life is longer. It's better to suit manual grinding machine due to its tool life fluctuates big.

2. CD 型角锥修刀/CD Pyramid dressers

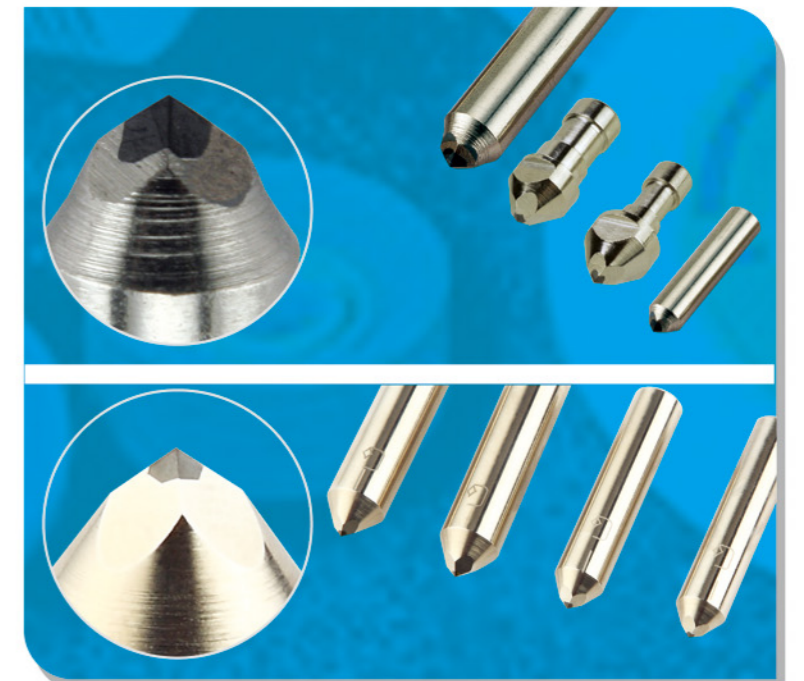
CD型角锥修刀是专门为自动型或数控磨床设计的修刀, 因钻石经特殊筛选, 个体间的寿命波动很小, 有利于设定更换频率。

CD type is specially designed for automatic or CNC machines. Its life time is rather stable due to its selected diamond material. This makes it easier to set a replacing frequency.

3. 常见规格

Common specifications

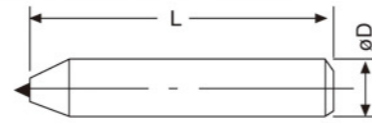
Ø12x100L, Ø12x50L, Ø10x50L, Ø8x50L, Ø8x23L, Ø6x23L





三、刚果石修刀
Congo Cube Dressers

规格 Shank	规格 Diamond size	ø8X80L	ø9.5X150L	ø10X50L	ø10X80L	ø12X50L	ø12X80L	ø12X100L	ø12.7X150L	ø12.7X200L
0.25CT		√	√	√	√	√	√	√	√	√
0.5CT			√			√	√	√	√	√



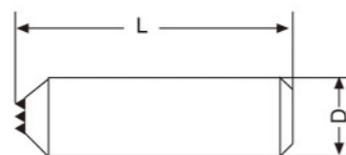
四、天然修刀
Diamond Dressers

钻石番号 Diamond size	规格/Shank	ø8X80L	ø10X60L	ø10X80L	ø12X60L	ø12X100L
#5			√	√	√	√
#10		√	√	√	√	√
#15			√	√	√	√
#20			√	√	√	√
#25			√	√		√
#33						√
#50						√



五、多石修刀
Multi Point Diamond Dressers

钻石颗数 Diamond quantity	规格 Shank	钻石分布 Diamond distribution
3	ø12x100L	▲▲▲ ▲
5	ø12x100L	▲▲▲▲▲
6	ø12x100L	▲▲▲▲▲▲
7	ø12x100L	▲▲▲▲▲▲▲

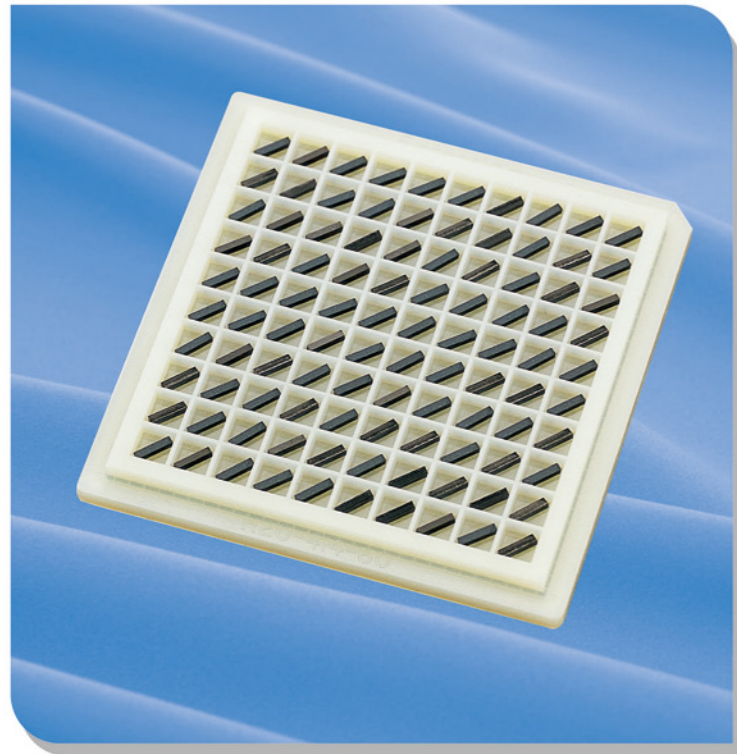


六、结合修刀
Impregnated diamond dressers

修刀名称 Type of dressers	图 形 Dresser drawing	柄尺寸(mm) Dimension of shank	节块尺寸(mm) Dimension of segments	备选粒度 Grit size
方形结合修刀 Cuboid impregnated diamond dressers		ø12 x 100L	12.7W x 6.3T x (8.5+5)H 10W x 4T x (8.5+5)H 10W x 2.5T x (8.5+5)H	R,M,F,F1
圆柱形结合修刀 Cylinder impregnated diamond dressers		ø12 x 50L ø10 x 50L	ø8 x (8+5)H ø6 x (8+5)H ø4 x (8+5)H	R M,F1 F1
手持式结合修刀 Handheld impregnated diamond dressers		ø12 x 150L	20W x 6T x (6+5)H	R,M

备选粒度说明
Instruction for selecting

备选粒度 Dresser grit	钻石粒度 Diamond grit size	适用修整砂轮粒度 Grinding wheel grit size
R	#16/20+#20/30	#60以粗(and coarser)
M	#30/40	#80---#120
F	#40/50	#150以细(and finer)
F1	#60/80	



一、CDD修刀特点:

此为人造单晶钻石, 尺寸, 硬度, 方向性, 皆一致。所以损耗是稳定, 一致的。

适用于数控磨床之自动进给磨修设定。

CDD dresser feature:

Synthetic monocrystalline diamond, which the size, hardness and directivity are same. So the lifetime is steady and identical. Applied on CNC grinding machine for automatic feed-in.

二、材料尺寸:

Material size:

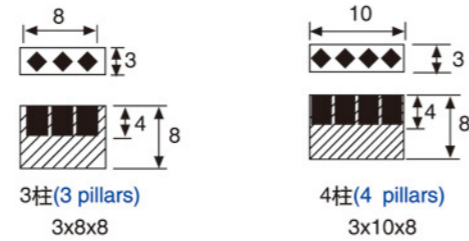
CDDL401212	4.0x1.2x1.2mm
CDDL401010	4.0x1.0x1.0mm
CDDL400808	4.0x0.8x0.8mm
CDDL400606	4.0x0.6x0.6mm
CDDL400404	4.0x0.4x0.4mm

此项为主

The main spec. →

三、节块尺寸:(使用于板修刀, 成型板修刀)

Segment size: For plate dressers and profile plate dressers



四、成型板修刀

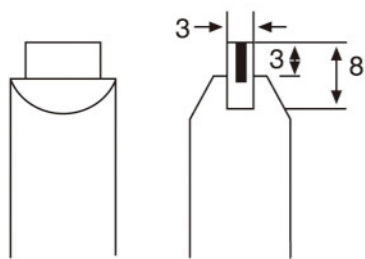
Profile plate dressers

标准规格 Standard specification	55°x0.2R	80°x0.2R
用途 Application	用于数控磨床成型研磨砂轮之修整	用于修砂轮的平面或斜面

Applied on CNC grinder to dress the grinding wheels to be a pre-set or inclined shape profile

五、板修刀:(3柱修刀)

Plate Dresser:(three CDD pillars dressers)

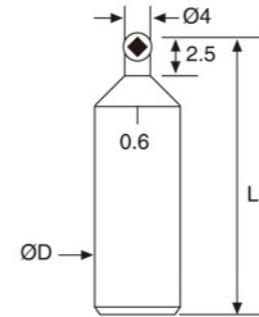


寿命为单柱式修刀的3倍
The lifetime is three times of single pillar dresser



CDD 单柱修刀

CDD Single Pillar Dressers



规格 Specification	尺寸 Dimension
CDD 0.4	Ø12 x 100L
CDD 0.6	Ø12 x 50L
CDD 0.8	Ø10 x 80L
CDD 1.0	Ø10 x 50L
CDD 1.2	



钻石修刀选用指南

Recommendation of dresser selection

参照项目 Considered items	砂轮外径 Diameter of wheel	砂轮修整长度 Dressed width	砂轮粒度 Grit size of wheel
砂轮参数 Wheels' parameters	① Ø100 以下(and under) ② Ø125~Ø200 ③ Ø254~Ø350 ④ Ø400~Ø700	① 15m/m 以下(and under) ② 20~40mm ③ 40~65mm ④ 65mm (and above)	① #100 以细(and finer) ② #80~#60 ③ #46 以粗(and coarser)
砂轮举例 Example	Ø 254x25T #100		
对应的系数 Relevant parameters	Ø 254 ⇒ ③	25T ⇒ ②	#100 ⇒ ①
根据系数和应选用的修刀 Selected dressers	③+②+①=6 We recommend CDD0.6 or Single point #15 and #20 for your selection. Please refer to following table.		

砂轮系数 Relevant parameters of grinding wheels	修刀选用/Chosen dresser	
	CDD 单柱修刀 CDD pillar dresser	单石修刀 Single point dresser
3,4	CDD 0.4	#5,#10
5,6	CDD 0.6	#15,#20
7,8	CDD 0.8	#25
9,10	CDD 1.0	#33
11	CDD 1.2	#50

注/Remark:

砂轮
grinding wheel

如此修整之砂轮较锐利

砂轮
grinding wheel

如此修整之砂轮较光滑

The grinding wheel on the left would be dressed sharper than the right one when you set the CDD dresser's corner as the left drawing.



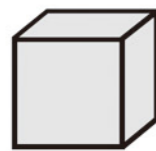
1. 人造单晶与天然钻石成型修刀的比较

Comparison of the Mono & Natural Diamond Dressers

比较项目 Comparative Items	人造单晶成型修刀 Mono Chisel Type Dressers	天然单晶成型修刀 Natural Diamond Chisel Type Dressers
磨耗比 Lifetime	相同 Identical	每颗不尽相同 Different
钻石尺寸 Size of diamond	一致 Pretty uniform	无法一致 Difficult to be uniform
产品尺寸 Size of product	每支一致, 钻石尖点位于柄中心 Diamond tip in the shank's center	无法保证尖点位于柄中心 Difficult to control
品质稳定性 Stability of quality	使用中钻石不会脱落 Diamond is combined firmly	使用中钻石可能会脱落 Diamond may drop when dressing

2. 人造单晶的规格

Size of diamond



Mono. 3.0x1.6x3.0

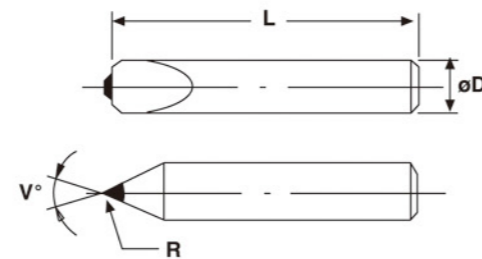
CDD 3.0x2.0x5.0

CDD 3.6x2.2x5.0

3. 人造单晶成型修刀标准规格

Standard Specification

尺寸规格 Specification	R	V°
ø12x100L	0.2	55°
ø10x80L	0.2	
10x5x32L	0.5	



一、CDD钻石修整轮 CDD Rotary Dressers

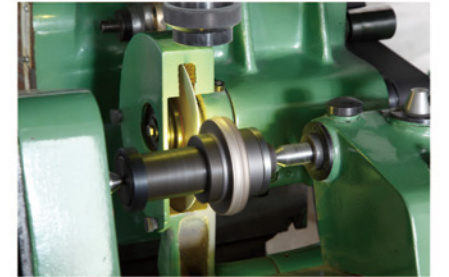


特点:

- 加工精度高
- 稳定的消耗速度
- 更低的使用成本

Features:

- High working precision
- Stable wearing rate
- Lower cost



简图 Diagram	形状代号 Shape code	尺寸 Dimension	粒度 Grit size	用途 Applications
	6A2Q	Ø 40x18 ^T x2.5-3 ^W x15 ^H (Taper)	CDD 0.4x0.4x4 0.6x0.6x4 0.8x0.8x4 1.0x1.0x4	大尺寸砂轮精密修整 Accurate dressing of big volume abrasive wheels
	4V9B	Ø 50.8x12.7 ^T x12.7 ^W x6°	CDD1.2x1.5x2.5	CNC磨床砂轮在线修整 On-site dressing for CNC forming machine grinding wheels.
	14J1	Ø80x35 ^T x14 ^U x25.4 ^H xR	D25	导轨磨床砂轮的高精度成型修整滚轮 High-accuracy dressing of abrasive wheels running on lead screw guide rail grinding machines
	14J1Y	Ø100x23 ^T x18 ^U x52 ^H xR	D25	
	14K1	Ø85x10 ^T x7 ^U x21 ^H xR(Taper)x55° x0.1R Ø100x18 ^T x6 ^U x25.4 ^H x50° x0.1R	CDD 0.8x0.8x4 CDD 1.0x1.0x4	CNC蜗杆磨床砂轮成型修整 High-precision dressing of abrasive wheels working on worm grinders, gear grinders etc.
	15V9T	Ø100x21 ^T x40 ^H x70° x0.5R Ø130x21 ^T x40 ^H x70° x0.5R	CDD 1.2x1.2x4 CDD 1.5x1.5x4	