

SUPER ABRASIVE WHEEL GENERAL INFORMATION

DIAMOND WHEELS are used to grind carbide only. CBN WHEELS are used to grind M-2 steel for superior finish. CDX WHEELS are used to grind carbide inlay, Bak-Pak, Double Back & other sandwich type carbide knife systems and steel body at the same time on corrugated and flat planer knives. See page 104 for more information.

WHEEL TYPE - D1A1 for straight knife grinding. D1FF1, D3F1 or D14F1 for profiling applications. (D3F1 is a wheel with a raised hub on one side for better stability on thinner wheels, D14F1 with raised hub on both sides.)

GRIT SELECTION - For fast stock removal where finish is not critical, use grits between 60 and 100. When finish is a consideration, along with stock removal - use grits between 120 and 180. When finish is critical with little stock removal, use grits of 220 and above.

HARDNESS - For Wet grinding use a medium hardness (R Hardness)

CONCENTRATION RECOMMENDATIONS:

- Diamond Wheels – 100 concentration
- CBN and CDX Wheels – 75 concentration

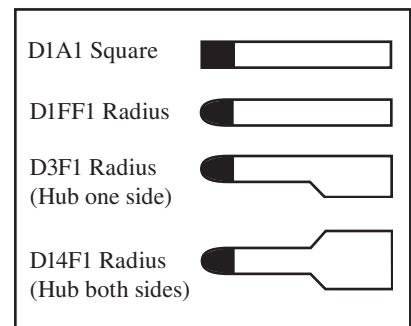
BOND RECOMMENDATIONS - For wet grinding a resinoid bond.

PROFILE GRINDER RECOMMENDATIONS:

Run the grinding wheel at maximum wheel speed of not more than 3,000 RPMs. As carbide is a much harder material than standard HSS, a faster wheel speed will allow more efficient grinding. Allow the grinding wheel to do the work, as forcing the wheel will create unnecessary heat buildup. Heat buildup can cause the carbide to crack or delaminate.

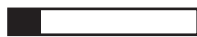









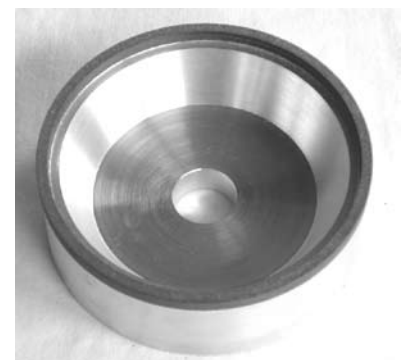
Super Abrasive Wheel



Typical Wheel Shapes.
Other shapes available.

Wadkin Superabrasive Wheels and Cups

Part #	Description
GW209 	4.7mm flat diamond wheel
GW211 	3mm round diamond wheel
GW213 	3mm 30° diamond wheel
GW214 	3mm 45° diamond wheel
GW215 	3mm radius diamond wheel
GW216 	3mm 45° diamond wheel
GW231 	8 mm borazon wheel
GW241 	3 mm borazon wheel
GW301	8mm borazon cup wheel for NZ/NU
GW303	8mm diamond cup wheel for NZ/NU



Part # GW301