

vDD-Dressing Tools in vitrified bond

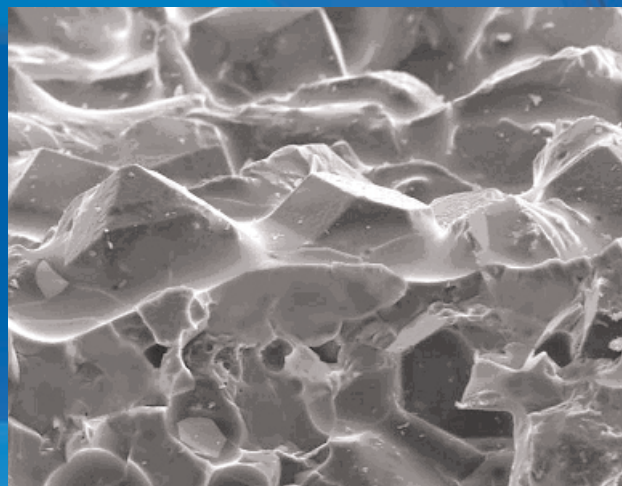
for dressing of VIT CBN grinding wheels

high grit protrusion and open structure matrix result in a free cutting dressing tool

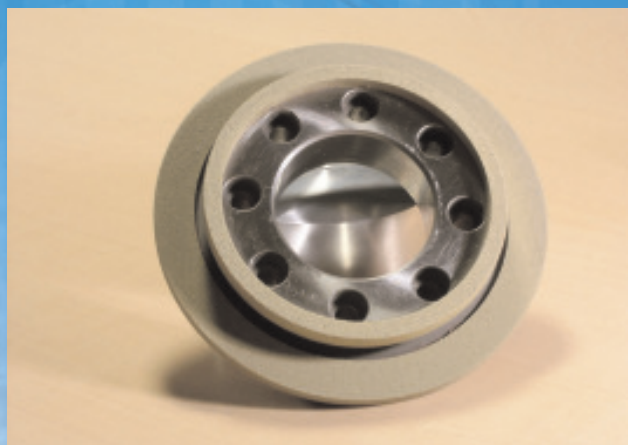
- no resharpener necessary
- excellent workpiece geometry

chemically fine tuned grit/bond interface increases grit retention forces and secures long dresser life

- stable dressing process



Specification: D11-170-P-8-280-X150-V88-39-2



SWISS MASTER vDD dressing tool with double layer for face and o.d. dressing



SWISS MASTER vDD dressing tool with single layer on periphery for o.d. dressing



vDD Case Study

dressing of VIT CBN grinding wheels



Application: bore and valve seat grinding

Grinding Tool: SWISS MASTER VIT CBN
IGA 143° 3.8x11/M2
CB5-500-Q-9-260-200-V55-32

Dressing Tool: SWISS MASTER vDD Dresser
D11-170-P-8-280-X150-V88-39-2

Result

Dresser Life:
**no. of components
out of tolerance
after wheel change:**

taper in bore:

surface finish achieved Rz:

SWISS MASTER vDD	metal bonded
110.000 parts	50.000 parts
nil	10 parts
< 1 µm	< 1 µm
0.5 - 1 µm	0.6 - 1.1 µm

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