

For MAXIMUM EFFICIENCY in the grinding process



GRINDING PCD/CBN
CUTTING INSERTS
STRIKER

STRIKER

The cool solution for high cutting edge quality

TECHNICAL FEATURES

Application: GRINDING PCD and CBN cutting inserts

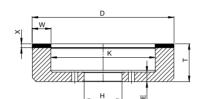
Material: PCD, PCBN, CVD, MCD, MCC, natural diamond

Maschinen CNC: **Ewag, Coborn**

Manual machines: Ewag, Coborn, Farment

Coolant CNC: Oil

Coolant, manual: Emulsion



Tool definition: 6A2: D 150mm, W 20mm, X 10mm

6A2: D 200mm, W 20mm, X 10mm

11A2: D 150mm, W 5mm, X 8mm 11A2: D 200mm, W 5mm, X 8mm

Hardness levels: Standard, soft, hard

Grain size: D15, D10, D6

X X X

KEY FEATURES

- ▲ Highest machining capacity thanks to free-cutting characteristics
- ▲ Novel bonding concept with increased porosity

YOUR BENEFITS

- ▲ 20 % reduction of process forces
- ▲ Noticeable 30 % reduction of grinding pressure
- ▲ Sensational G-ratio up to 5
- ▲ 100 % process security
- Minimisation of edge chipping on the PCD/CBN tools being ground
- ▲ No thermal edge zone damage on the PCD/CBN tool thanks to especially cool grinding
- ▲ Perfect machining properties for simultaneous processing of carbide
- ▲ Reduced infeed compensation minimises grinding wheel wear
- Minimised to no dressing cycles for guaranteed higher economic efficiency in series production

APPLICATION

▲ Cutting speed: 14 - 25 m/s

△ Oscillation/feed: 35 - 130 strokes/min

▲ Anpressdruck: 2 - 4 bar

DRESSING PROCESS RECOMMENDATION

▲ During or in between the grinding process

▲ Mechanical: White refined corundum grinding wheels, hardness H/I/J

▲ Grinding pressure: 0.3 - 0.8 bar

Individual tool configuration for roughing wheels on request

Phone: +49 (0) 881 / 90 11 55-0 Fax: +49 (0) 881 / 90 11 55-100 vertrieb@muedia.de www.diamantmetall.com

