

一、圆锥修刀 Cone Dressers

BD圆锥修刀 BD Cone Dressers

钻石规格 Diamond spec	d (mm)	钻石大小 (ct) Diamond size	标准尺寸(mm) Standard Dimension		V°	R(mm)
			D	L		
BD-30	0.5-0.8	1/60	3.15	25	60°	0.02-0.03
			6.33	50	90°	
		1/50	10.0			
BD-40	0.8-1.0	1/50	3.15	25	60°	0.02-0.03
			6.33	50	90°	
		1/40	10.0			
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	60°	0.01
			Ø6.33x50L	90°	

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 more aggressive. 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用。

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

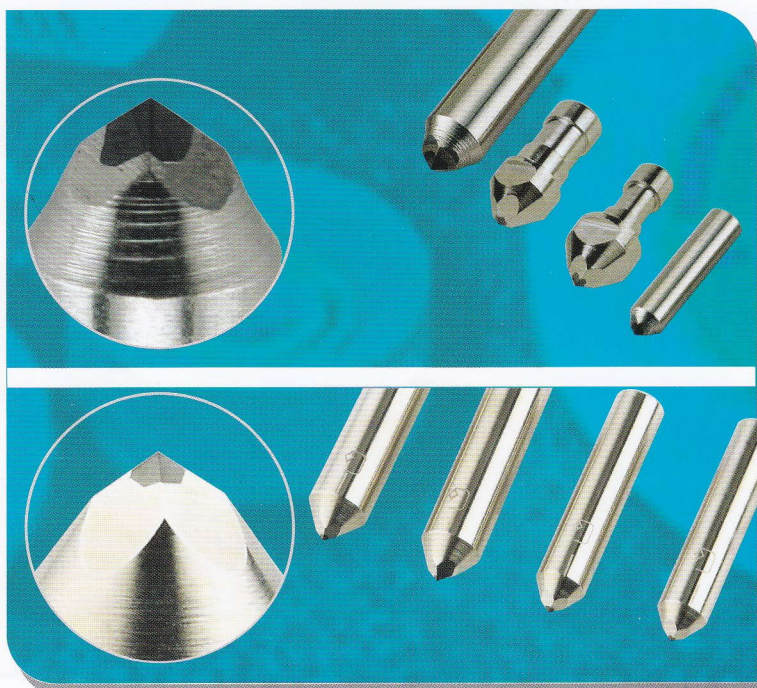
CD型角锥修刀是专门为自动型或数控磨床设计的修刀，因钻石经特殊筛选，单体间的寿命波动很小，有利于设定更换频率。

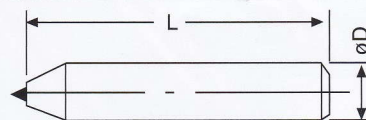
CD type is specially designed for automatic or CNC machines. Its life time is rather stable due to its selected diamond material. This makes it easier to set a replacing frequency.

3. 常见规格

Common specifications

Ø12x100L, Ø12x50L, Ø10x50L, Ø8x50L, Ø8x23L, Ø6x23L





三、刚果石修刀

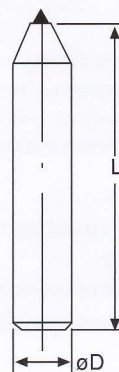
Congo Cube Dressers

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

四、天然修刀

Diamond Dressers

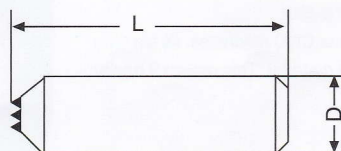
钻石番号 Diamond size	ø8X80L	ø10X60L	ø10X80L	ø12X60L	ø12X100L
#5		√	√	√	√
#10	√	√	√	√	√
#15		√	√	√	√
#20		√	√	√	√
#25		√	√		√
#33					√
#50					√



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 M 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	适用被修整砂轮粒度 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	