

## 鑽石與氮化硼砂輪 / Diamond & CBN Grinding Wheels

訂購砂輪時請指明下列事項：

1. 砂輪之形狀及各部尺寸：如1A1、14A1
2. 磨料種類：鑽石或氮化硼
3. 粒度：例如：#150
4. 集中度：例如：C-75
5. 結合劑：例如：樹脂結合劑或金屬結合劑
6. 冷卻方式：乾磨或濕磨
7. 數量及交期：
8. 轉速及加工條件：
9. 多數製造商都會在砂輪上標示以下資訊：

When ordering, please specify：

1. Shape & dimensions of wheel：Ex. 1A1, 14A1
2. Abrasive：Diamond or CBN
3. Grit size：Ex. #150
4. Concentration：Ex. C-75
5. Bond of wheel：Ex. Resin bond or Metal bond
6. Coolant：Dry or wet grinding
7. Quantity & Delivery date：
8. Spindle speed & grinding conditions：
9. Most of makers marked following information：

SDC 磨料種類 Abrasive	150 粒度 Grit Size	N 結合度 Grade	75 集中度 Concentration	R 結合劑 Bond	3.0 磨料層厚度 Rim thickness
D：天然鑽石 Natural diamond	#60 #80	J 軟 / Soft L ↓	25 50	R：樹脂結合 Resin bond	1.0mm 1.5mm
SD：人造鑽石 Synthetic diamond	#100 #150	N ↓	75 100	M：金屬結合 Metal bond	2.0mm 3.0mm
SDC：人造金屬披覆鑽石 Synthetic metal coating diamond	#200 #270	P ↓	125 150	P：電鑄法 Electroplated	5.0mm 10.0mm
B：氮化硼 Cubic boron nitride (CBN)	#325 #400	R 硬 / Hard		V：陶瓷法 Vitrified	. .
BC：金屬披覆氮化硼 CBN with metal coating	#600 .				. .

### 使用鑽石與氮化硼時機 / Choosing Diamond or CBN ?

#### \* 鑽石

- 碳化鎢，半燒結碳化鎢工具及另件
- 陶瓷工具及另件
- 氧化鐵等之磁性材料
- 耐火材料及其製品
- 石材、寶石及半寶石、貝殼
- 玻璃、石英、瓷器
- 矽、鍺等電子另件
- 碳、石墨及其製品
- 磁磚、瀝青、混凝土、石棉
- 塑膠、加強塑料 (F.R.P.)
- 耐磨耗披覆材料

#### \* Diamond

- Tungsten carbide, presintered carbide metal tools & construction units.
- Oxide ceramic materials.
- Ferrite, ceramic magnetic materials.
- Refractory products.
- Stones, gem & semi-precious stones, shell.
- Glass, porcelain, quartz.
- Graphite, carbon.
- Tiles, asbestos, asphalt, concrete.
- Plastics, F.R.P.
- Wear resistant coatings.

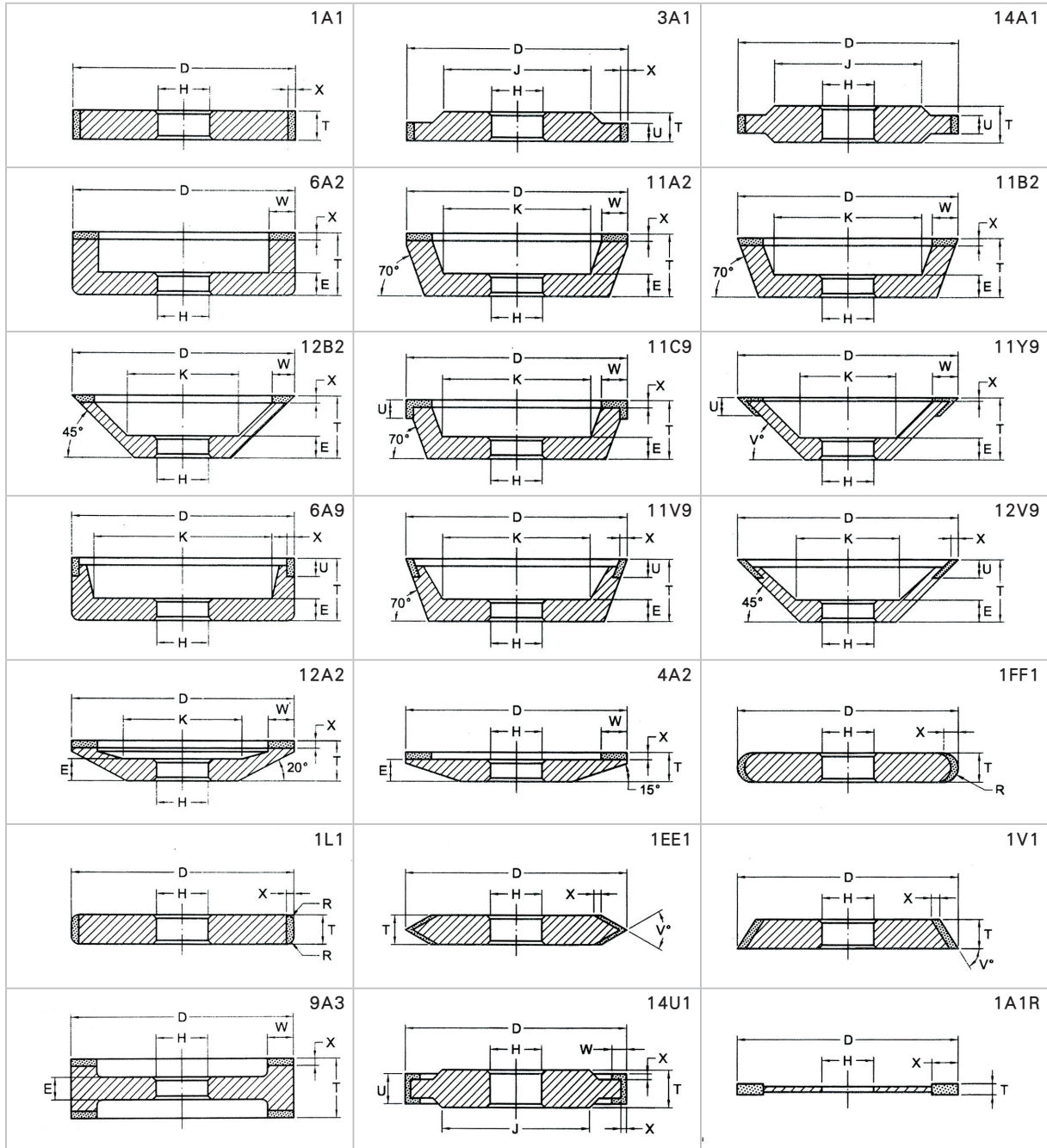
#### \* 氮化硼

- SK, SKS, SKH等切削工具及另件
- SKD, Stellite等耐磨工具鋼材
- SCM, SNCM, SCr, SUJ等構造用鋼
- SUS (不鏽鋼)等之耐蝕金屬
- SUH鈦合金等之耐熱金屬
- 鑄鐵

#### \* CBN

- High alloy steels.
- High speed tool steels.
- Hot & cold working steels.
- Tempering steels, Spring steel.
- Ball bearing steel.
- Cast iron.

## 砂輪形狀及尺寸標示 / Shape & Dimensions of wheels



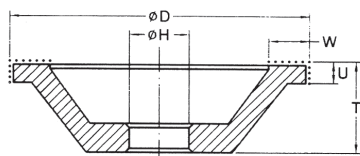
### 砂輪訂製方法 / How to order a wheel?

1. 若是重覆訂製,請告知工作單編號即可。 / For repeated order, just tell us the manufacturing number.
2. 若需我們為您設計砂輪,則請告知: / If you require us to design the wheels for you, please specify:
  - a.) 工件名稱,材質,硬度 / Name, materials, hardness of work-piece.
  - b.) 機器名稱,型式,轉速及馬力 / Name, type, horse power, spindle speed of machine.
  - c.) 加工條件及加工精度 / Grinding conditions.
3. 若自行設計砂輪,則告知如下例: / If you have your own design, please order as below:
 

14A1, 350D-10U-5X-25T-250J-127H, SDC 150N75R5.0, 溼磨 / Wet grinding

# 電鑄鑽石砂輪 / Electroplated Diamond wheels

## 11C9碗型砂輪

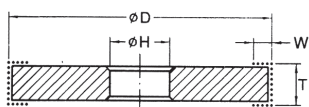


適合鑄鋼工具之研磨，成型用。

Ideal for carbide tool's grinding, forming and sharpening.

編號 Order no.	D	T	W	H	U	粒度 Grit size
WC-1005A	100	22	10	20	5	#100*
WC-1005B	100	35	10	20	5	#100*
WC-1005C	100	35	10	19.05	5	#100*
WC-1605A	100	35	16	20	5	#200*
WC-2005A	100	35	20	20	5	#200*

## 1A1U

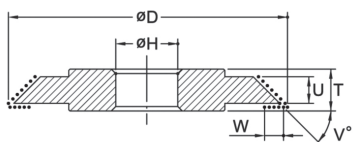


適合鑄鋼刀具之研磨，成型用。

Ideal for carbide tool's sharpening.

編號 Order no.	D	T	W	H	粒度 Grit size
WS-6105A	150	10	5	31.75	#200*
WS-6105B	150	10	5	12.70	#200*
WS-6105C	150	10	5	15.88	#200*

## 14Y1

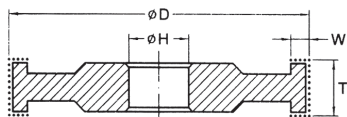


適合鑄鋼刀具之研磨，成型用。

Ideal for carbide tool's sharpening.

編號 Order no.	D	U	T	W	H	V°	粒度 Grit size
WV-6645A	150	6	10	5	12.70	45	#200*
WV-6645B	150	6	10	5	15.88	45	#200*
WV-6660A	150	6	10	5	12.70	60	#200*
WV-6660B	150	6	10	5	15.88	60	#200*

## 14A1,14A1U

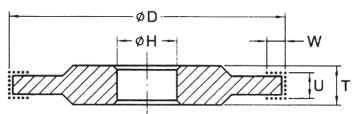


適合寶石、半寶石、石材研磨，成型用。

Ideal for carbide gem stone and stones grinding.

編號 Order no.	D	T	W	H	粒度 Grit size
WS-0625A	150	25	-	25.4	#60*
WS-0625B	150	25	5	25.4	#60*

## 14A1U

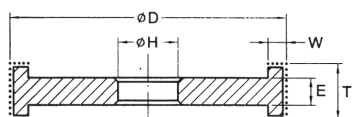


適合鐵粉心之研磨，成型用。

Ideal for ferrite core grinding.

編號 Order no.	D	U	T	E	W	H	粒度 Grit size
WS-7063A	175	6	10	-	3	31.75	#200*
WS-7073A	175	7	10	-	3	31.75	#200*
WS-7083A	175	8	10	-	3	31.75	#200*
WS-7093A	175	9	10	-	3	31.75	#200*
WS-7103A	175	-	10	9.8	3	31.75	#200*
WS-7113A	175	-	11	10	3	31.75	#200*
WS-7123A	175	-	12	10	3	31.75	#200*
WS-7133A	175	-	13	10	3	31.75	#200*
WS-7143A	175	-	14	10	3	31.75	#200*
WS-7153A	175	-	15	10	3	31.75	#200*
WS-7163A	175	-	16	10	3	31.75	#200*

## 9A1U

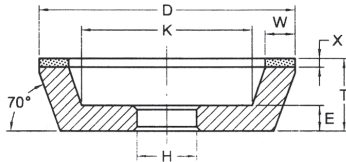


說明 / Note : “\*” 標準粒度,其餘粒度請指明訂購。

“\*” Standard grit size,others depend on your request.

# 樹脂鑽石砂輪 / Resinoid Diamond & CBN Wheels

11A2

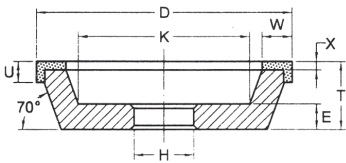


適用於工具磨床，鑄鋼刀具研磨及成型。

Apply on tool grinding machine, to grind or form the carbide tools.

編號 Order no.	D	W	X	T	H	粒度 Grit size
RD-04082A	100	8	2	40	20	SDC-150*
RD-04103A	100	10	3	30	20	SDC-200*
RD-04103C	100	10	3	30	19.05	SDC-200*

11C9

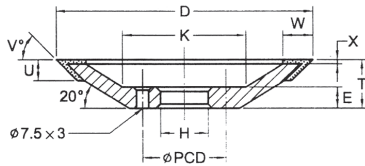


適用於工具磨床，鑄鋼刀具研磨及成型。

Apply on tool grinding machine, to grind or form the carbide tools.

編號 Order no.	D	W	X	U	T	H	粒度 Grit size
RD-04815A	100	8	1	5	40	20	SDC-150*

12Y9C

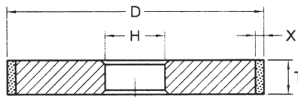


適用於自動車床刀具研磨機、鑄鋼車刀研磨。

For tool grinding machine, to sharpen the carbide turning tools.

編號 Order no.	D	W	U	X	T	H	V	形狀 Shape	粒度 Grit size
RD-05815A	125	8	-	1	16	25	-	12A2C	SDC-400*
RD-05815B	125	8	5	1	16	25	60°	12Y9C	SDC-600*
RD-05815C	125	8	5	1	16	25	45°	12Y9C	SDC-400*

1A1

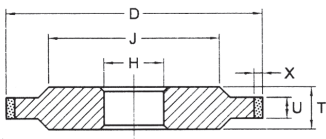


適用於平面磨床、研磨鑄鋼、陶瓷(SDC)或硬化鋼材(BC)。

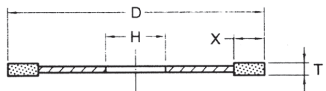
Apply on surface grinding machine, to grind carbide(SDC) or hardened steels(BC).

編號 Order no.	D	U	X	T	H	形狀 Shape	粒度 Grit size
RD-06033A	150	3	3	10	31.75	14A1	SDC-150*
RB-06033A	150	3	3	10	31.75	14A1	BC-150*
RD-06063A	150	6	3	10	31.75	14A1	SDC-150*
RB-06063A	150	6	3	10	31.75	14A1	BC-150*
RD-06083A	150	8	3	10	31.75	14A1	SDC-150*
RD-06103A	150	-	3	10	31.75	1A1	SDC-150*
RB-06103A	150	-	3	10	31.75	1A1	BC-150*
RD-07063A	175	6	3	10	31.75	14A1	SDC-150*
RD-07103A	175	-	3	10	31.75	1A1	SDC-150*
RB-07103A	175	-	3	10	31.75	1A1	BC-150*
RB-07133A	175	-	3	13	31.75	1A1	BC-150*

14A1



1A1R



適用於平面磨床(φ31.75孔)或沖頭切斷機(φ19.05孔)，用於切斷鑄鋼、陶瓷(SDC)或硬化鋼材(BC)。

Apply on surface grinding machine or cutting machine, to cut the carbide, ceramics(SDC) or hardened steels(BC)

編號 Order no.	D	T	X	H	粒度 Grit size
RD-06017A	150	1.0	7	31.75	SDC-120*
RB-06017A	150	1.0	7	31.75	BC-120*
RD-06017B	150	1.0	7	19.05	SDC-120*

說明 / Note : “\*” 標準粒度,其餘粒度請指明訂購。

“\*” Standard grit size, others depend on your request.