

# WEINIG GRINDING ATTACHMENT TO DRESS DIAMOND / CBN WHEELS



WEINIG

## Observe the following installation instructions for item VEN700073SMPK

- Loosen, or back off, the slotted set screw which tensions the holder.
- Break 13mm jamb nut loose from the threaded diamond dresser, and thread diamond dresser out of the holding/advancing unit.
- Remove black, knurled holding/advancing unit that holds the threaded dresser.
- Thread in the replacement unit (VEN700073SMPK) with the collar closest to the wheel dressing area.
- Re-tension the slotted set screw (with nylon on the end) tight enough that it will not allow the new unit to rotate during dressing, but loose enough that you can still make adjustments by hand.
- Now, you may install and use the non-threaded multi-point diamond dresser when dressing standard grinding wheels, or use the moly-stick to redress superabrasive wheels. Replacement multi-point diamond dresser is item VEN700085, replacement moly-stick is VEN700070. On some models, you will possibly need to cut the moly stick by 1/4" for a proper fit to redress the wheel.
- Always reduce the grinding wheel speed to approximately 1000 RPM (or lowest possible speed for your grinder) when dressing any grinding wheel.

## General Guidelines For Grinding With Diamond or CBN Wheels:

1. Select the wheel that has the proper characteristics for the particular job being done. No single wheel should be used with the intention of being an all-purpose wheel. Consult the Weinig Tooling & Supplies catalog for recommendations.
2. Flood coolant extends wheel life and improves finish quality if applied to the point of cut properly. Look for the stream coming through the cut.
3. Maintain manufacturer's speed recommendation for maximum efficiency. Wheels that are run at a lower speed act softer, cut slow, and wear away rapidly. Wheels that are run at a higher speed act harder, usually glaze, and sometimes cause knife burn and premature knife wear. The initial recommended wheel speed for Weinig profile grinders is 3000 RPM, with speed deviations to be made from that point according to operator technique and the material being cut.
4. Adjustment of the traverse rate should be faster for roughing, slower for finishing.
5. A wheel whose pores become loaded with the metal being ground must be cleaned by periodically holding a cleaning stick against the face of the running wheel.

