



**RESIN & METAL BONDED PRODUCTS**



**abrasive  
technology**



Setting the global standards for superabrasive tooling

## Introduction

Abrasive Technology was founded in 1971 with the goal of manufacturing and marketing high quality diamond and CBN tooling. Since then, we have grown steadily by offering the very best quality, service and technical innovation to our customers. Our aim is to serve the industrial manufacturing marketplace with a complete line of superabrasive products.

This catalog covers our Resin and Metal Bonded product lines. For other superabrasive tooling, please contact customer service at any of the global locations listed on the back of this brochure or visit our website at [www.abrasive-tech.com](http://www.abrasive-tech.com).

## Why Superabrasives?

Diamond is the hardest material known to man and has unsurpassed resistance to wear. It is used to grind hard, brittle, highly abrasive materials such as glass, ceramic, quartz, carbide, cermets, ferrites, graphite, wear-resistant spray coatings, glass fiber reinforced plastics and similar hard-to-machine materials.

CBN (Cubic Boron Nitride), is the second hardest abrasive known to man. It offers many advantages when grinding ferrous materials, such as hardened steel or steel superalloys.

When compared to conventional abrasives, Diamond and CBN allow greater material removal rates, improved quality due to less damage of the workpiece, and longer wheel life, all of which will reduce overall grinding costs.

## How to Specify our Resin and Metal Bond Superabrasive Wheels

Our Diamond and CBN grinding wheels are built to exacting standards. Maintaining these standards is your best assurance of repeatability.

All relevant information is completely documented through unique part numbers consisting of the catalog number plus a 3 digit suffix which identifies the wheel formulation. Part numbers will be assigned by customer service associates at the time of the order and should be used when placing repeat orders.

We also identify each wheel we produce with a unique serial

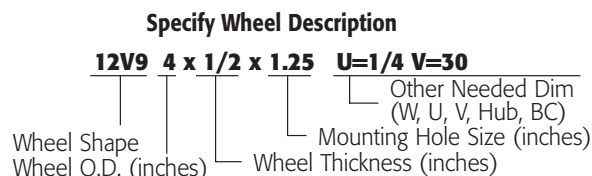
number. A detailed manufacturing record is kept for each wheel produced. This serial number can also be used to troubleshoot or improve product specifications to better meet the customer's performance needs.

The following table explains how to completely specify a wheel for your application.

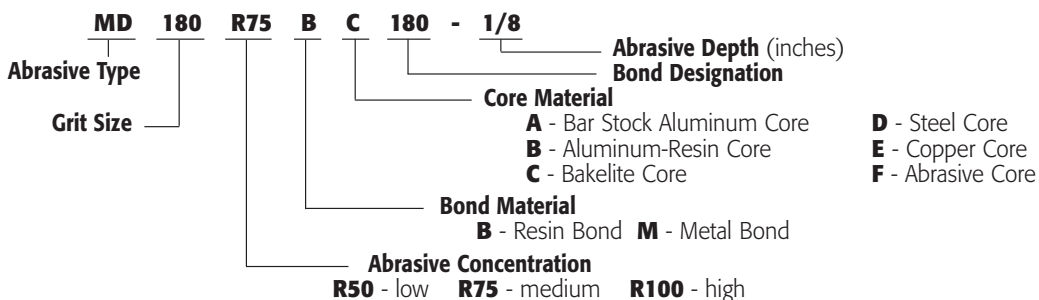
ALWAYS SPECIFY THE FOLLOWING:

1. Wheel Geometry
2. Mounting Hole Size
3. Application Number (p.6)
4. Finish Desired (Ra, RMS) or Coarse, Medium or Fine abrasive to be used
5. Quantity Desired

### Specifying Wheel Geometry and Mounting Hole Size:



### Specifying Wheel Abrasive, Bond and Core Type:



## Wheel Specifications/General Guidelines

When specifying Diamond or CBN wheel formulations to fit an application, four main factors are important: 1) Workpiece

material, 2) Coolant application, Wet vs. Dry grinding, 3) Grinding contact area, 4) Machine condition and available power.

## Diamond Types

Diamond abrasives are used for precise grinding and finishing of tungsten carbide and carbide tipped cutting and milling tools. Diamonds are also used for grinding carbide, carbide/steel combinations, PCD/PCBN, and ceramic components. The standard diamond types offered by Abrasive Technology are listed below.

Description
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**Uncoated friable diamond.** Recommended for dry grinding applications, low power machines and grinding heat sensitive carbide and ceramic materials.

**Nickel coated, friable diamond.** The metal coating improves diamond retention in bond, extending the life of the wheel. This is the most versatile and common diamond type used for wet/dry grinding applications. Works best in wet grinding applications.

Note: Customized specifications are required when horsepower requirements are a concern, or for dry grinding applications when 15-30% steel is present.

**Copper coated, friable diamond.** Used only for dry grinding carbide when no steel is present.

**Nickel coated semi-friable diamond.** Used only when more than 30% steel is ground with carbide.

**Blocky diamond.** Ideal for grinding tools requiring optimum crystal retention for high material removal ratios.

## CBN Types

Cubic Boron Nitride (CBN) abrasives are used for precise grinding of tool and die steels, superalloys, stainless steels, and other hardened alloy steels. Abrasive Technology offers the following standard CBN types:

Description
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**Uncoated CBN.** Used for light to medium duty applications or where the application involves large grinding contact areas. Also used in vitreous bond systems.

**Nickel coated CBN.** Most popular CBN abrasive used with the resin bond system. Well suited for most light to medium duty applications.

**Nickel coated semi-friable CBN.** Used for heavy-duty applications where extra long wheel life or fine surface finish is required.

## Grit Sizes

The following table lists the standard diamond and CBN sizes offered by Abrasive Technology. Other sizes are available upon request.

The general recommendation for selecting abrasive size is to use as coarse a grit size as possible which will provide the desired surface finish for the application.

The target surface finish provided in the following table serves as a guideline for selecting the appropriate grit size. However, there are other factors, such as machine condition, wheel and travel speed, workpiece material and coolant that will influence the surface finish actually achieved.

Sizes	US Mesh	FEPA (µm)	Approximate Surf. Finish (Ra)	
			Dia.	CBN
60	50/60	301		
80	60/80	252		
100	80/100	181	30	45
120	100/120	151	24	40
140	120/140	126	18	35
150	140/170	107	17	30
180	170/200	91	14	25
220	200/230	76	13	20
270	230/270	64	12	16
325	270/325	54	0	13
400	325/400	46	9	11
Micron Sizes	Range (µm)	Mean (µm)	Surf. Finish (AA)	
600	20-40µm	30µm	8	11
800	15-25µm	20µm	7	
1000	12-27µm	17µm	6	
1200	10-20µm	15µm	5	

## The Importance of Abrasive Concentration in Your Application

Increasing abrasive concentration will:

- 1) Increase wheel life
- 2) Improve surface finish
- 3) Reduce cut rate

However, it will make the wheel act “harder” while grinding. The degree to which wheel life will be improved also depends on the mesh size of the abrasive.

In general, high concentrations are recommended when coarse grits and/or small grinding contact areas are encountered. Low concentrations are recommended when large contact areas and fine grits are used. Higher concentrations could be used when there are high requirements for profile and edge stability, when using a hard bond and coarse grit sizes, or for creep-feed grind-

ing applications. Medium concentration levels are recommended for straight wheels for surface and cylindrical grinding, cup wheels, soft bonds, and finer grits. Low concentration levels are recommended for applications that use extremely fine grit sizes or have very large contact areas.

	Concentration	
	Low	High
Wheel life	Shorter	Longer
Surface	Rougher	Finer
Cut rate	Higher	Lower
Grit	Smaller	Larger
Contact area	Larger	Smaller

## Bond Systems

Abrasive Technology offers a complete range of high performance bond systems specifically designed to fit a wide variety of applications.

## Core Materials

Abrasive Technology offers a range of core materials to fit the requirements of a wide range of applications. The core material defines the rigidity, dimensional stability and dressability of the grinding wheel. Abrasive Technology offers the following core materials:

Type	Core Material	Application
A	Bar Stock Aluminum	Wet grinding periphery and form wheels up to 6" (150mm) diameter, and all face style wheels.
B	Aluminum-Resin Composite	Redressable wheels such as 11V9, 6A9, 12V9 cup style wheels. Also used for periphery and face wheels up to 12" (300mm) diameter.
C	Bakelite Resin	Wet grinding periphery wheels larger than 6" (150mm) diameter and for some redressable cup wheels.
D	Steel	Periphery and form wheels that require high degree of rigidity and dimensional stability.
E	Copper, Copper-Resin Composite	Dry grinding applications when a high degree of heat dissipation is required.
F	Abrasive-Resin Composite	Used only in dry grinding applications with 1A1, 3A1 and 14A1 style wheels.

Abrasive Technology Diamond & CBN Resin Bonded Applications							
		CONC.	GRIT	WHEEL SHAPE	MATERIAL	WET/DRY	OPERATION
<b>General HSS &amp; carbide/brazed/steel mix grinding</b>							
1	Ni coated CBN	75-100	80-200	1A1, A2	Hard steels	Wet	General HSS grinding
2	Ni semi-friable DIA	75	100-220	1A1, A2	Carbide/steel mix	Wet	Mixed metal component grinding
<b>General HSS grinding</b>							
3	Ni coated CBN	75-100	80-200	1A1, A2	Hard steels	Dry	General HSS grinding
<b>General carbide grinding</b>							
4	Ni friable DIA	50-75	100-400	All 1A1, 6A2	Carbide	Wet	General carbide grinding
<b>Blanchard &amp; double disc grinding</b>							
5	Ni friable DIA	50-75	120-220	2A2T	Carbide	Wet	Grinding flat carbide surfaces
6	Ni coated CBN	75-100	120-280	2A2T	Steel	Wet	Grinding flat steel surfaces
<b>Centerless grinding</b>							
7	Ni friable DIA	50-100	100-180	1A1	Carbide	Wet	Thrufeed grinding of carbide rods
8	Ni coated CBN	50-100	100-180	1A1	Steel	Wet	Thrufeed grinding of HSS rods
<b>Circuit board drill fluting</b>							
9	Uncoated or Cu friable DIA	100-125	400-1200	1A1, 1V1	Carbide	Wet	Fluting less than 1/8" (3mm) drills
<b>Fluting</b>							
10	Cu friable DIA	100-125	120-180	1A1, 1V1, 1FF1	Carbide	Wet	Water coolant
11	Ni friable DIA	100-125	120-180	1A1, 1V1, 1FF1	Carbide	Wet	Oil coolant
12	Ni coated CBN	100-125	120-180	1A1, 1V1, 1FF1	Steel	Wet	Oil coolant - grinding HSS
<b>Insert grinding</b>							
13	Ni friable DIA, Co friable DIA	75-125	180-320	2A2T, 6A2, 11A2	Carbide	Wet	Production carbide insert grinding
14	Ni friable DIA	75-125	180-320	2A2T, 6A2, 11A2	Ceramic	Wet	Production ceramic insert grinding
15	Ni friable DIA	75-125	180-320	2A2T, 6A2, 11A2	Cermet	Wet	Production cermet insert grinding

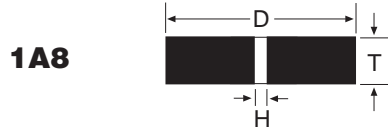
Abrasive Technology Diamond & CBN Resin Bonded Applications - Continued							
		CONC.	GRIT	WHEEL SHAPE	MATERIAL	WET/DRY	OPERATION
<b>O.D. grinding</b>							
16	Ni friable DIA	75-100	120-180	1A1	Carbide	Wet	General carbide OD grinding
17	Ni friable CBN	75-100	120-280	1A1	Steel	Wet	General HSS OD grinding
<b>Surface &amp; face grinding</b>							
18	Ni friable DIA	75-100	120-320	1A1, 3A1, 6A2, 14A1	Carbide	Wet or Dry	Size/flatness - carbide parts
19	Ni coated CBN	75	120-320	1A1, 3A1, 6A2, 14A1	Steel	Wet or Dry	Size/flatness - HSS parts
<b>Tool &amp; cutter grinding</b>							
20	Ni friable DIA	75-100	120-220	11A2, 11V9, 12A2, 12V9	Carbide	Wet or Dry	Sharpening carbide
21	Ni coated CBN	75	120-220	11A2, 11V9, 12A2, 12V9	Steel	Wet or Dry	Sharpening HSS
22	Ni semi-friable DIA	75	120-220	11A2, 11V9, 12A2, 12V9	Carbide/Steel	Wet or Dry	Sharp. carbide/steel combo tools
<b>Sprayed carbide coatings cylindrical grinding</b>							
23	Ni friable DIA	75	100-220	1A1	Sprayed carbide	Wet	Cylindrical grinding - sprayed carbide
<b>Slitting &amp; cut-off saws</b>							
24	Ni friable DIA	75-100	80-270	1A1R	Carbide	Wet	General carbide cutting
<b>Polishing &amp; surface preparation</b>							
25	Special wheels - uncoat. fria. DIA	25-50	Micron sizes	Any	Carbide	Wet or Dry	Fine polished finish

Abrasive Technology Diamond Metal Bonded Applications - Wet use ONLY!					
		CONC.	GRIT	WHEEL SHAPE	OPERATION
<b>Pencil edging</b>					
1	Blocky diamond	25-75	80-250	1FF1V, 1FF6Y	Automotive, decorative and laminated glass
<b>Arriasing</b>					
2	Blocky diamond	25-75	60-325	1EE1V	Standard 90° angle
3	Blocky diamond	25-50	60-300	6A2*	Cupwheel arriasing
<b>Flat grinding</b>					
4	Blocky diamond	25-75	60-325	1A1	Segmented or slotted for laminated glass
5	Blocky diamond	25-75	60-325	1A1	Finger grips grinding
6	Blocky diamond	25-50	60-300	6A2*	Cupwheel flat grinding
<b>Beveling</b>					
7	Blocky diamond	25-50	60-300	6A2*	Grinding and polishing positions
<b>Radius and brilliant cuts</b>					
8	Blocky diamond	25-75	60-300	1E1	Manual or CNC decorative cutting
<b>Miter wheels</b>					
9	Blocky diamond	25-75	60-325	1E1, 1F1, 1V1	Standard 30°, 45°, 60°, 90-140° angles, slotted for laminated glass
<b>Form wheels</b>					
10	Blocky diamond	25-75	60-325	1AH1	OG and other forms
<b>Trapezoidal grind (flat &amp; arri, flat &amp; chamfer)</b>					
11	Blocky diamond	25-50	100-270	1D6Y, 1DD6Y	2mm chamfers, 45° or 30° angles
<b>Drilling</b>					
12	Blocky diamond	25-75	100	6A8PW	6-150mm dia., thick/thin wall, 35mm drill length, matched set available
<b>Countersinks</b>					
13	Blocky diamond	25-75	100-270	1EAW	6-100mm dia., 90° angles, adjustable models
<b>Routers</b>					
14	Blocky diamond	50	100-200	1A2S	10-50mm diameter, straight or fluted segmented

\*Includes 6V4, 6V5, 11A2 & 12A2

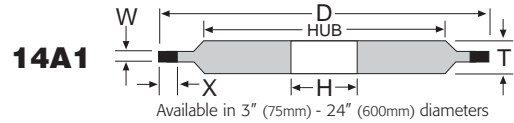
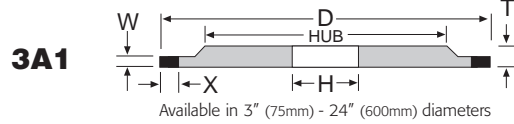
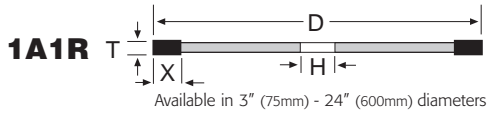
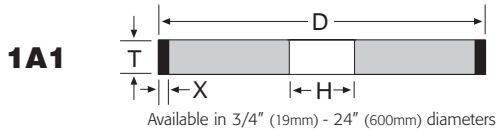
Note: Special sizes available upon request.

## Internal Wheels

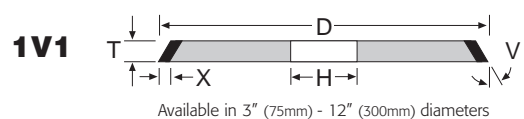
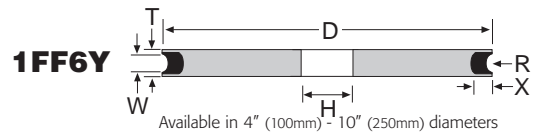
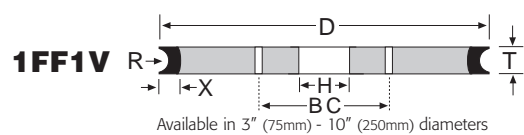
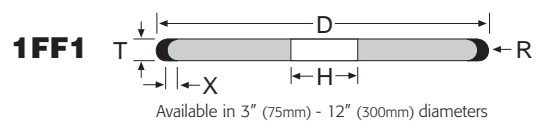
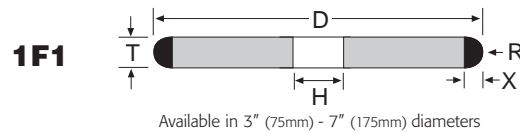
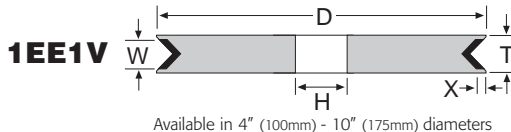
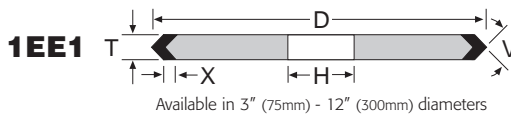
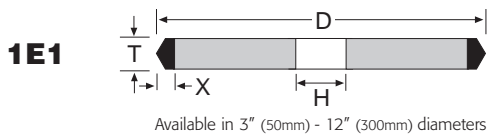
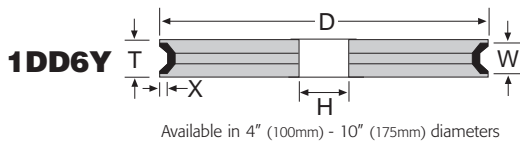
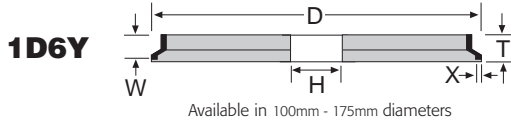
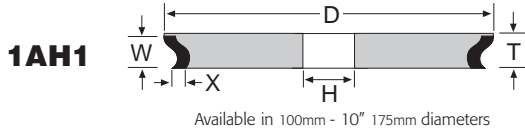


Available in 3/8" (8mm) - 1" (25mm) diameters  
\*1A8 wheels provided on brass bushings

## Straight Wheels

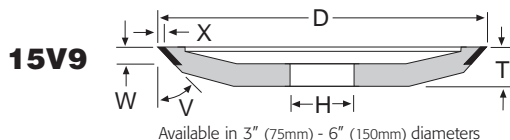
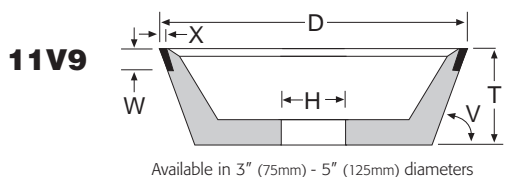
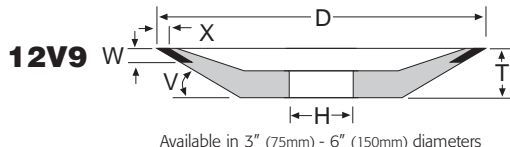
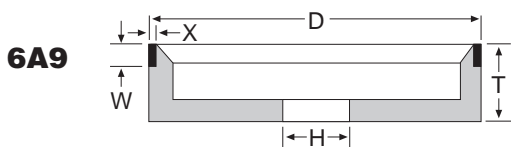


## Form Wheels

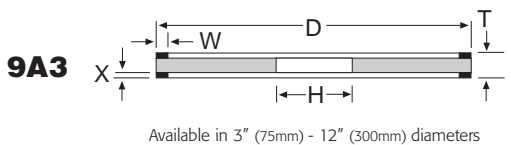
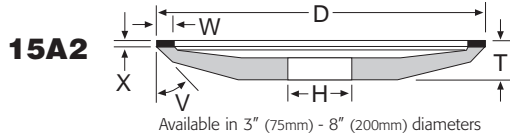
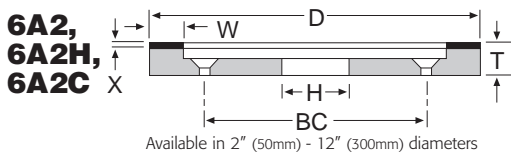
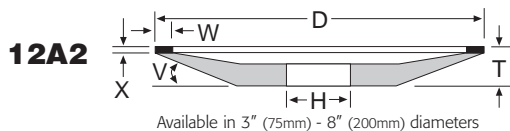
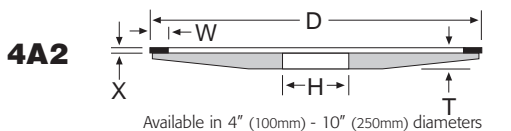
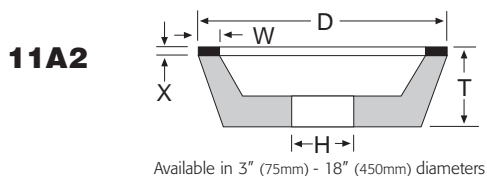
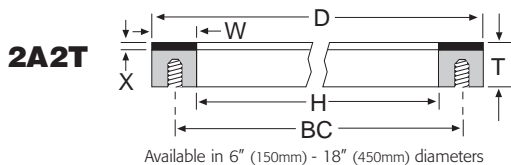


BC = bolt circle, D = diameter, H = hole size, R = radius, T = thickness, W = abrasive width, X = abrasive thickness

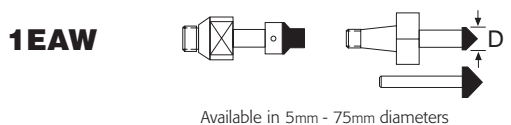
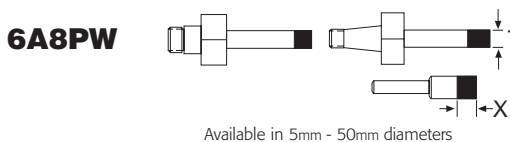
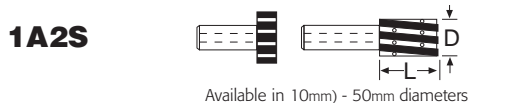
## Cup Wheels



## Face Wheels



## Specialty Tools



BC = bolt circle, D = diameter, H = hole size, R = radius, T = thickness, V = angle, W = abrasive width, X = abrasive thickness

## Truing, Dressing and Mounting Procedures

For diamond and CBN wheels to be most cost effective it is necessary to check:

- 1. Machine Spindle.** Any end or side play in the spindle will considerably reduce the life of the wheel.
- 2. Mounting Flanges.** Back plates and spacers should be clean and free from nicks and burrs.

Truing and Dressing are two distinct and necessary functions.

- Truing restores the shape of the diamond or CBN wheel.
- Dressing prepares the wheel for aggressive action. This function is necessary after a wheel is trued.

**AT offers specialized metal bond redressing services.**

### Dressing

When a wheel is trued, the abrasive surface should be dressed to condition it for aggressive stock removal. The bond material should be eroded to expose the grit.

**Dressing Sticks.** Aluminum oxide dressing sticks are hand held on the surface of the grinding wheel until the wheel consumes the dressing stick rapidly. The wheel is now ready.

### Truing periphery and form wheels

True wheels to .001" (.025mm) T.I.R. maximum. Hold a colored pencil against the rotating wheel until the surface is totally covered. Then true the wheel. When the color is gone the wheel is trued. Use coolant if the wheel is used with coolant. True grind dry.

## Truing straight wheels

There are six methods to consider:

- 1. Truing Devices.** The truing wheel should be coarse grit in the J to M hardness range. Use a series of rapid passes at .002" (.05mm) infeed.
- 2. Diamond Truing Tool.** Mount the impregnated dresser and use as you would dress an abrasive wheel. In this instance only infeed .0005" (.012mm). Use rapid strokes leaving the wheel surface in both directions.
- 3. Molybdenum Rods 1/4" (6.35mm)- 3/8" (9.52mm).** Mount the rod in the dressing fixture normally used for the diamond dressing tool. Downfeed .004" (.1mm) on coarse wheels, .002" (.05mm) on fine wheels. Table speed should be moderate to fast.
- 4. Steel Block.** This method is recommended for large wheels. A soft steel block with a surface area of 10 in<sup>2</sup> (250mm<sup>2</sup>) is ground using flood coolant. Downfeed .001" (.025mm) to .002" (.051mm) per pass. Crossfeed at least 1/2 the width of the wheel.
- 5. Tool and Cutter Grinding.** Mount the aluminum oxide or silicon carbide wheel on the grinding spindle. The diamond wheel is mounted on the rotary head. Turn at 100 to 200 RPM. Infeed .001" (.025mm). Take quick passes, leaving the abrasive surface on both ends of the stroke.
- 6. Tool Post Grinder.** The wheel is mounted on an arbor in between centers on a lathe. Use a coarse mesh silicon carbide wheel. The diamond or CBN wheel should turn at 200 RPM rotating against the silicon carbide wheel running at normal grinding speed. Use .001" (.025mm) infeed and take rapid passes leaving the abrasive area in both directions.

## ACCESSORIES

### Diamond Compound

Our diamond compound is a paste for use in all precision lapping and polishing procedures. It is available in syringe applicators. Diamond compound is available in standard sizes and concentrations.

MICRON	MESH	COLOR	CAT. NO. 5 GRAM
1/4	100,000	Green	C5410410
1/2	50,000	Gray	C5410430
1	14,000	Ivory	C5410450
3	8,000	Yellow	C5410470
6	3,000	Orange	C5410490
15	1,200	Blue	C5410510
30	600	Red	C5410530
45	325	Brown	C5410550
60	240	Purple	C5410570



## ACCESSORIES (Continued)

### Aluminum Oxide Dressing Stones

SIZE (12 pk)		GRIT	CAT. NO.
INCH	MM		
1/2 x 1/2 x 4	12.7 x 12.7 x 100	220	C6330008
1 x 1 x 8	25.4 x 25.4 x 200	220	C6330010
1/2 x 1/2 x 4	12.7 x 12.7 x 100	320	C6330009
1/2 x 1/2 x 4	12.7 x 12.7 x 100	1000	C6330011

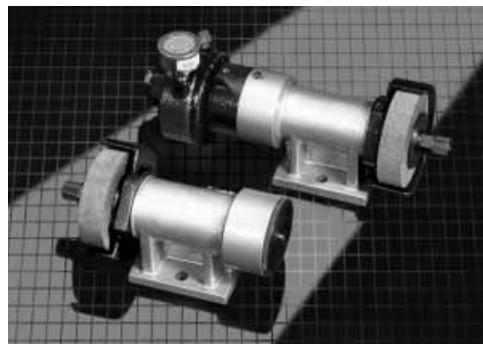
### Molybdenum Dressing Rods

FOR WHEEL WIDTHS		SIZE		CAT. NO.
INCH	MM	INCH	MM	
1/4	6	1/4 OD x 1 3/4 L	6.4 OD x 45 L	C6330005
3/8	10	3/8 OD x 1 3/4 L	9.5 OD x 45 L	C6330006

### Rotatrim™ Brand Devices for Dressing and Truing

For a fast, easy and cost effective way to restore, dress and true Diamond & CBN wheels.

ITEM	CAT. NO.
Centrifugal Braking - For general purpose use	C4710001
Air Driven - For large and very small dia. wheels	C4720001
Replacement wheel 60 SIC (5 pk)	C4730001



### ACCU•TRU® CBN Wheel Truing & Dressing Kit

Each kit contains one truing tool and one dressing stick. They can be used on resin, metal or vitrified CBN grinding wheels. For 7" (175mm) diameter wheels and larger, 3/8" (9.5mm) nibs are recommended. These are available in a 7/16" (11mm) shank. For wheel diameters smaller than 7" (175mm), a 1/4" (6.4mm) nib with either a 3/8" (9.5mm) or 7/16" (11mm) shank is recommended.

**Shank diameter    Machine application**

7/16" (11mm)    Brown & Sharp, Cincinnati, G&L, Heald, Norton, Thompson  
 3/8" (9.5mm)    Excello, Barber Coleman, Fellows, K.O. Lee

0° Drag Angle						15° Drag Angle						
C6350001000N		C6350002000N		C6350003000N		C6350004000N		C6350005000N		C6350006000N		
Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	
A	1/4	6.4	1/4	6.4	3/8	9.5	1/4	6.4	1/4	6.4	3/8	9.5
B	1/4	6.4	1/4	6.4	1/8	3.2	1/4	6.4	1/4	6.4	1/8	3.2
C	1 1/2	38	1 1/4	31.7	1 1/2	38	1 1/2	38	1 1/4	31.7	1 1/2	38
D	3/8	9.5	7/16	11	7/16	11	3/8	9.5	7/16	11	7/16	11

## Guidelines on Operational Speeds for Metal & Resin Bonded Diamond & CBN Wheels

	DIAMOND WHEELS		CBN WHEELS	
	Wet Grinding	Dry Grinding	Wet Grinding	Dry Grinding
<b>SFPM</b>	4000-8000	3000-4000	5500-7500	3000-6000
<b>m/s</b>	20-40	15-20	27-38	15-30

Note: NEVER exceed the maximum operating speed specified on the wheel. Serious injury may occur when operating a wheel outside its recommended speed range.

## Wheel Revolutions Per Minute for Different Wheel Diameters and Wheel Surface Speeds

Diam. (Inch)	Surface feet per minute (SFPM)					
	3,500	4,500	5,500	6,500	7,500	8,500
	Revolutions per minute					
1	13,369	17,189	21,008	24,828	28,648	32,468
2	6,685	8,594	10,504	12,414	14,324	16,234
3	4,456	5,730	7,003	8,276	9,549	10,823
4	3,342	4,297	5,252	6,207	7,162	8,117
5	2,674	3,438	4,202	4,966	5,730	6,494
6	2,228	2,865	3,501	4,138	4,775	5,411
7	1,910	2,456	3,001	3,547	4,093	4,638
8	1,671	2,149	2,626	3,104	3,581	4,058
9	1,485	1,910	2,334	2,759	3,183	3,608
10	1,337	1,719	2,101	2,483	2,865	3,247
12	1,114	1,432	1,751	2,069	2,387	2,706
14	955	1,228	1,501	1,773	2,046	2,319
16	836	1,074	1,313	1,552	1,790	2,029
18	743	955	1,167	1,379	1,592	1,804
20	668	859	1,050	1,241	1,432	1,623
22	608	781	955	1,129	1,302	1,476
24	557	716	875	1,035	1,194	1,353

Diam. (mm)	Meters per second (m/s)					
	15	20	25	30	35	40
	Revolutions per minute					
25	11,459	15,279	19,099	22,918	26,738	30,558
50	5,730	7,639	9,549	11,459	13,369	15,279
75	3,820	5,093	6,366	7,639	8,913	10,186
100	2,865	3,820	4,775	5,730	6,685	7,639
125	2,292	3,056	3,820	4,584	5,348	6,112
150	1,910	2,546	3,183	3,820	4,456	5,093
175	1,637	2,183	2,728	3,274	3,820	4,365
200	1,432	1,910	2,387	2,865	3,342	3,820
225	1,273	1,698	2,122	2,546	2,971	3,395
250	1,146	1,528	1,910	2,292	2,674	3,056
300	955	1,273	1,592	1,910	2,228	2,546
350	819	1,091	1,364	1,637	1,910	2,183
400	716	955	1,194	1,432	1,671	1,910
450	637	849	1,061	1,273	1,485	1,698
500	573	764	955	1,146	1,337	1,528
550	521	694	868	1,042	1,215	1,389
600	477	637	796	955	1,114	1,273

### Safety Considerations

- Always handle and store wheels carefully.
- Always inspect all wheels before mounting.
- Always make sure machine RPMs do not exceed maximum wheel operating speed.
- Always make sure mounting flanges are the correct diameter (At least 1/3 the diameter of the wheel and should be relieved around the mounting hole).
- Always properly adjust work rest.
- Always use a guard that covers at least half of the grinding wheel.
- Always run newly mounted wheels at full operating speed for one minute before use.
- Always wear proper eye protection.
- Never use a wheel that has been dropped.
- Never force a wheel onto the spindle or change the size of the mounting hole.
- Never exceed the maximum RPMs established for the wheel.
- Never use a mounting flange that has an uneven or dirty bearing surface.
- Never put excessive pressure on the mounting nut.
- Never start the machine without the wheel guard in place.
- Never force the workpiece into the wheel.
- Never stand directly in front of the wheel.
- Never grind unsuitable material.

Wheels must be mounted and used in accordance with American National Standards Institute Safety Code B 7.1





World headquarters in Lewis Center, Ohio USA

#### **ADDITIONAL PRODUCTS**

We develop, manufacture, and market superabrasive:

- Grinding wheels: Diamond/CBN electroplated, brazed, resin, metal and vitrified bonds
- Turning tools: PCD/PCBN
- Single point dressing tools

#### **MARKETS SERVED**

We serve the aerospace, automotive, bearing, ceramic, composite, electronics, glass, lapidary, medical, oil & gas, ophthalmic, stone, textile, tires, tool & die and toolroom markets with thousands of custom-engineered and in-stock products.

#### **CUSTOM-ENGINEERED TOOLING**

We welcome the opportunity to quote on any special superabrasive grinding wheels, PCD/PCBN or single point dressing tools you may need. Please send complete part drawings and tool specifications when requesting a quote. Call any of the numbers listed below for more information.



#### **WORLD HEADQUARTERS**

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Fax: 1.740.548.7617

#### **EUROPEAN HEADQUARTERS**

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#### **ASIAN HEADQUARTERS**

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