TRUING AND DRESSING

Steps To Maximize The Life Of Your Resin Bonded Grinding Wheels
To achieve the best performance from a resin bonded Diamond or CBN grinding wheel, it must first be trued and then dressed on the machine it is to be used on. Truing involves grinding or wearing away of the abrasive surface, so that it will run concentric with the axis of rotation. Depending upon the type of abrasive, the following truing methods will apply.

Truing System	Diamond Wheels	CBN Wheels
Brake Controlled Truing Device (Cat no. 50010)	Yes	Yes
Single Point Diamond Dresser	No	No
Impregnated Diamond Dressing Tool (available call for more information)	Under certain conditions small contact areas	For wheels up to 8" diameter and no larger than 1” thick
Mild Steel Block - mount on grinder, take .001” passes over block with diamond or CBN wheels	Yes	Yes
Rotary Powered Truing Devices-equipped with metal bonded or electroplated diamond truing wheels.	Under certain conditions small contact areas	Best for larger diameter wheels (8" & larger)
Diamond Electroplated Blocks- may have a form to shape CBN wheel to a desired profile. (available, call for more information)	No	Yes
Tool Post Grinder - mounted on grinder, utilizing a silicon carbide wheel	Yes	Yes

Once truing has been completed, the surface of the grinding wheel face will be smooth, with few abrasive crystals protruding. It is imperative for the Diamond or CBN wheel to be dressed so that new cutting points can be exposed. This is accomplished by holding an aluminum oxide stick(catalogue numbers 50012 & 50013) firmly against the rotating wheel face, allowing the stick to remove some of the bond material. When the stick begins to wear rapidly, proper dressing has been accomplished, and the superabrasive wheel is ready for use.

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