



NORTON

148 DIAMOND & CBN
GRINDING WHEELS

166 ELECTROPLATED PINS

170 DIAMOND DRESSERS

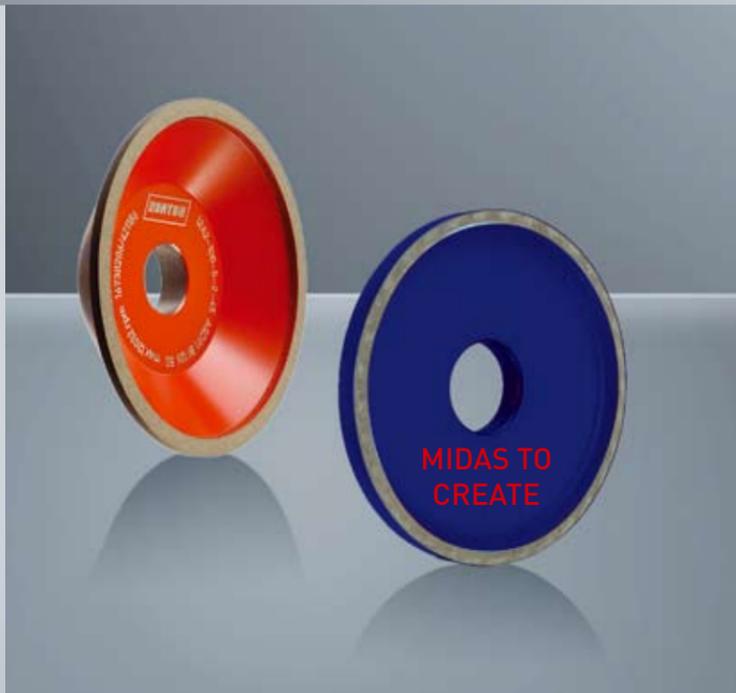
180 DIAMOND LAPPING
COMPOUNDS

181 FILES



**Super
Abrasives**

Norton Diamond and CBN wheels are designed to grind and cut the hardest materials known to man, helping make “difficult-to-grind” applications routine operations. The hardness, abrasion resistance, compressive strength and thermal conductivity of Super Abrasive wheels make them a logical choice for many applications in order to achieve a high level of precision and quality.



APPLICATIONS & MARKETS

Although both Diamond and CBN are Super Abrasives, the areas of usage for diamond and CBN varies dramatically depending upon the material to be ground

DIAMOND

- Cemented carbide
- Glass
- Ceramics
- Fibreglass
- Plastics
- Stone
- Abrasives
- Electronic components & materials

CBN

- High speed tool steels
- Die steels
- Hardened carbon steels
- Alloy steels
- Aerospace alloys
- Hard stainless steel
- Abrasion-resistant ferrous materials

UNDERSTANDING THE PRODUCT

ASD 151 R 75 B99

ASD - ABRASIVE TYPE

- Both diamond & cubic boron nitride have distinctive characteristics that provide a Super Abrasive product for the most demanding applications
- ASD: Synthetic diamond, armoured, high quality, versatile
- CB: Cubic boron nitride, armoured, durable

151 - GRIT SIZE

- Size of the Super Abrasive particles according to the FEPA standard. The smaller the number, the finer the grit size (diameter approximately: 151~60µm, 46~15µm)

R - GRADE

- The term grade refers to the degree of durability of the wheel, progressing alphabetically from A (softest, least durable) to Z (hardest, most durable)

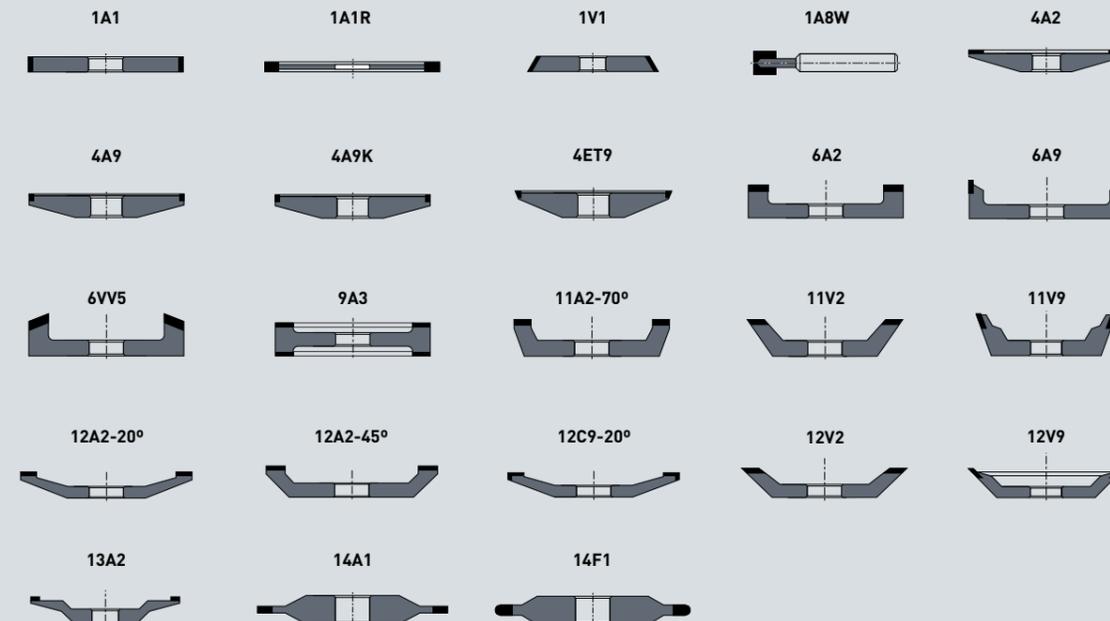
75 - CONCENTRATION

- Indicates the relative amount of Super Abrasives in the wheel. For CBN wheel the concentration number is included in the grade (Q=50, T=75, W=100), concentration 100~4,4 ct/cm³, & accordingly 50~2,2 ct/cm³. The optimum concentration depends upon the application.

B99 - BOND

- The bond is the element in a grinding wheel that holds the diamond or CBN grains together:
- B99: High quality resin bond for wet & dry grinding
- Aztec IV: Premium dry grinding bond for CBN wheels
- XLB4847: Premium bond for specific diamond wheels

WHEEL SHAPES



DIAMOND WHEELS

FEATURES

- High quality synthetic diamond
- Pre-engineered resin bond - B99
- Optimised design

BENEFITS

- High material removal rates; longer wheel life versus conventional silicon carbide wheels
- Free cutting; superior form holding; efficient wet or dry
- Ideal for dry toolroom reconditioning applications
- Ideal for 1A1R cut-off applications & grinding glass or ceramic materials
- Fast stock removal, cool cutting; excellent for dry off-hand finishing of carbide tools, no wheel dressing required
- Most durable under high grinding forces; excellent for wet off-hand finishing of carbide tools



CBN WHEELS

FEATURES

- CBN abrasive material is 2nd in hardness to diamond
- High quality durable CBN abrasive
- Pre-engineered resin bond - B99
- Optimised design
- High performance Aztec IV bond

BENEFITS

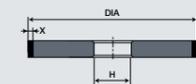
- Easily cuts difficult to grind steel parts, RC 50 or harder
- Highly wear resistant & thermally stable
- Free cutting, superior form holding
- Most efficient for dry tool reshaping especially where heavy stock removal is required
- Larger cutting depth



PRODUCT SELECTION

APPLICATION	TYPE	APPLICATION VARIABLES	RECOMMENDED SPECIFICATION
DIAMOND WHEELS STARTING RECOMMENDATIONS			
Cutting-off	1A1R		ASD126R75B99
Cylindrical grinding OD	1A1, 14A1		ASD126R75B99
Cylindrical grinding ID	1A1, 1A8W		ASD126R75B99 ASD126R100B99
Tool sharpener grinder	6A2, 4A2, 11V2, 11A2, 12A2		Roughing: ASD151R75B99 ASD126R75B99 General purpose: Durable ASD107R100B99 Small contact ASD91R100B99 Free cutting ASD107R75B99 Larger contact ASD107R50B99 ASD91R50B99 Finishing: ASD64R75B99 ASD64R50B99 ASD54R50B99
Surface grinding	1A1	(Wet) Rough grinding of cemented carbides & hard (→55HRc) plasma & ceramic spray coatings (Wet) Rough grinding of combination of cemented carbide & steel (→35%)	ASD126R75B99 ASD126R75B99
Tool & cutter grinding	11V9, 12V9, 1A1, 1V1	Manual (dry) CNC (wet)	ASD126R75B99 ASD64R100B99
Woodworking	12V2, 12A2-20°, 13A2 6A2, 12A2-45°, 11A2, 14A1, 14F1, 1A8W, 4A9, 4A9k, 6VV9	Face grinding Tooth top	ASD46R75B99 ASD107R75B99
CBN WHEELS STARTING RECOMMENDATIONS			
Cutting-off	1A1R		CTB151B99
Cylindrical grinding OD	1A1, 14A1		CB126TB99
Cylindrical grinding ID	1A1, 1A8W		CB126TB99
Tool Sharpener grinder	6A2, 4A2, 11A2, 12A2		CB126TB99
Surface grinding	1A1		CB126TB99
Tool & cutter grinding	11V9, 12V9 1A1, 1V1	Manual (dry) CNC (wet)	AZTEC IV (dry) CB126TB99 CB107WB99
Woodworking	12V2, 12A2-20°, 13A2 6A2, 12A2-45°, 11A2, 14A1, 14F1, 1A8W	Face grinding Tooth top	CB126TB99 CB126TB99

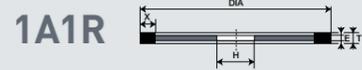
1A1



DIAMOND

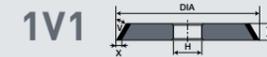
DIA (mm)	T (mm)	H (mm)	X (mm)	PK QTY	BEST		BETTER	
15	12	6	2	1	ASD126R100B99	69014151486	ASD126R100B99	
20	10	6	2	1	ASD126R100B99	69014151728		
25	10	6	2	1			ASD126R75B99	69014151498
	12	6	23	1	ASD126R100B99	69014151503		
30	10	6	3	1			ASD126R75B99	69014151508
	10	10	3	1			ASD126R75B99	69014151510
40	15	10	3	1			ASD126R75B99	69014151516
50	15	20	3	1			ASD126R75B99	69014151521
100	4	20	3	1			ASD91R75B99	69014151528
	6	32	3	1	ASD91R100B99	69014152303		
	10	20	5	1			ASD91R75B99	60157681620
	10	20	5	1	ASD64R100B99	60157681660		
	12	20	5	1	ASD64R100B99	60157681662		
125	15	20	5	1			ASD91R75B99	60157681667
	15	20	5	1	ASD64R100B99	60157681669		
	5	20	3	1			ASD126R75B99	69014151531
	10	20	5	1	ASD126R100B99	60157682091		
	10	20	10	1	ASD64R100B99	60157681670		
150	12	20	10	1	ASD64R100B99	60157681672		
	16	20	10	1	ASD64R100B99	60157681674		
	10	20	3	1			ASD126R50B99	60157636274
175	10	32	3	1			ASD126R75B99	69014151540
	12	20	10	1	ASD64R100B99	60157681675		
	15	32	1,5	1			ASD126R50B99	69014151545
200	10	32	3	1			ASD126R75B99	69014151550
	10	51	3	1			ASD126R75B99	69014152165
	15	32	3	1			ASD126R75B99	69014151558
250	15	76,2	3	1			ASD126R75B99	69014151560
	10	76,2	3	1			ASD126R75B99	69014151565
	15	76,2	3	1			ASD126R75B99	60157636276
300	20	76,2	1,5	1			AMD126R50B99	69014151567
	10	127	5	1			ASD126R75B99	69014151570
	15	127	5	1			ASD126R75B99	60157636277
	20	127	1,5	1			AMD126R50B99	69014151576

CBN								
DIA (mm)	T (mm)	H (mm)	X (mm)	PK QTY	BEST		BETTER	
12	10	6	2	1	CB126WB99	69014151482		
15	10	6	2	1	CB126WB99	69014151484		
	12	6	2	1	CB126WB99	69014151487		
20	10	6	2	1	CB126WB99	69014151492		
	15	6	2	1	CB126WB99	69014151495		
25	10	10	2	1	CB126WB99	69014151502		
	12	10	2	1	CB126WB99	69014151507		
30	15	10	3	1	CB126WB99	60157636271		
40	15	8	3	1	CB126WB99	69014151518		
	15	10	3	1	CB126WB99	69014151519		
50	15	20	3	1	CB126WB99	69014151524		
60	15	20	3	1	CB126WB99	60157636272		
100	10	20	3	1			CB126TB99	69014151529
	10	20	5	1	CB107WB99	60157681762		
125	15	20	5	1	CB107WB99	60157681763		
	10	20	10	1	CB107WB99	60157681764		
150	10	20	3	1			CB126TB99	69014151529
	12	20	10	1	CB107WB99	60157681765		
175	8	31,75	5	1	CB107WB99	60157682092		
200	10	32	3	1			CB126TB99	69014151552
	10	51	3	1			CB126TB99	60157636302
	15	32	3	1			CB126QB99	69014151556
	15	76,2	3	1			CB126TB99	69014151562
250	20	76,2	1,5	1		CB126QB99	69014151569	
300	15	76,2	5	1			CB126TB99	69014151573
	15	127	5	1			CB126TB99	69014151574
300	20	127	1,5	1			CB126QB99	69014151578



DIAMOND								
DIA (mm)	T (mm)	H (mm)	X (mm)	E (mm)	PK QTY	BETTER		
100	0,9	20	5	0,7	1	ASD126R75B99	60157681683	
125	1	20	5	0,7	1	ASD126R75B99	60157681686	
150	1	20	5	0,8	1	ASD126R75B99	60157681688	
200	1,2	25,4	5	0,9	1	ASD126R75B99	60157681690	
250	1,2	32	5	0,9	1	ASD126R75B99	60157681691	
300	1,5	32	5	1,2	1	ASD126R75B99	60157681692	

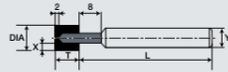
CBN								
DIA (mm)	T (mm)	H (mm)	X (mm)	E (mm)	PK QTY	BETTER		
100	0,9	20	5	0,7	1	CB151TB99	60157681767	
125	1	20	5	0,7	1	CB151TB99	60157682094	
150	1	20	5	0,8	1	CB151TB99	60157682103	
200	1,2	25,4	5	0,9	1	CB151TB99	60157681768	
250	1,2	32	5	0,9	1	CB151TB99	60157681769	
300	1,5	32	5	1,2	1	CB151TB99	60157681770	



DIAMOND								
DIA (mm)	T (mm)	H (mm)	X (mm)	V (mm)	PK QTY	BEST		
100	10	20	5	10°	1	ASD64R100B99	60157681694	
	15	20	5	10°	1	ASD64R100B99	60157681695	
	15	20	5	20°	1	ASD64R100B99	60157681696	
	15	20	5	30°	1	ASD64R100B99	60157681697	
	15	20	5	45°	1	ASD64R100B99	60157681698	
125	6	20	5	20°	1	ASD64R100B99	60157681700	
	10	20	5	10°	1	ASD64R100B99	60157681701	
	10	20	5	20°	1	ASD64R100B99	60157681702	
	10	20	5	30°	1	ASD64R100B99	60157681703	
	15	20	5	20°	1	ASD64R100B99	60157681704	
150	15	20	5	45°	1	ASD64R100B99	60157681705	
	12	20	5	15°	1	ASD64R100B99	60157681706	

CBN								
DIA (mm)	T (mm)	H (mm)	X (mm)	V (mm)	PK QTY	BEST		
100	10	20	5	10°	1	CB107WB99	60157681771	
	15	20	5	10°	1	CB107WB99	60157681772	
	15	20	5	20°	1	CB107WB99	60157681773	
	15	20	5	30°	1	CB107WB99	60157681774	
	15	20	5	45°	1	CB107WB99	60157681775	
125	12	20	5	10°	1	CB107WB99	60157681776	
	12	20	5	45°	1	CB107WB99	60157681777	
150	12	20	5	15°	1	CB107WB99	60157681778	

1A8W



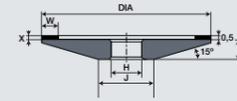
DIAMOND

DIA (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	PK QTY	BEST	BETTER
3	6	0,65	3	40	1		ASD126R75B99 60157681708
4	6	1,15	3	40	1		ASD126R75B99 60157681709
5	6	1,5	3	40	1		ASD126R75B99 60157681710
6	3	1,5	6	40	1	ASD76R125B99	60157681711
	6	1,5	6	40	1	ASD126R75B99	60157681713
	6	1,5	6	70	1	ASD64R125B99	60157681714
8	10	2	6	70	1	ASD126R75B99	60157681717
	6	2	6	70	1	ASD64R125B99	60157681718
10	10	2	6	70	1	ASD126R75B99	60157681720
	6	2	6	70	1	ASD64R125B99	60157681721
12	10	3	6	70	1	ASD126R75B99	60157681722
	6	3	6	70	1	ASD64R125B99	60157681723

CBN

DIA (mm)	T (mm)	X (mm)	Y (mm)	L (mm)	PK QTY	BEST	BETTER
3	6	0,65	3	40	1		CB126TB99 60157681779
4	6	1,15	3	40	1		CB126TB99 60157681780
5	6	1,5	3	40	1		CB126TB99 60157681781
6	6	1,5	6	40	1		CB126TB99 60157681782
	6	1,5	6	70	1	CB126WB99	60157681783
8	10	2	6	70	1		CB126TB99 60157681784
	6	2	6	70	1	CB126WB99	60157681785
10	10	2	6	70	1		CB126TB99 69014151061
	6	2	6	70	1	CB126WB99	60157681786
12	10	3	6	70	1		CB126TB99 60157681787
	6	3	6	70	1	CB126WB99	60157681788

4A2



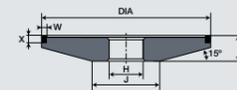
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	J (mm)	PK QTY	BETTER
100	7	20	5	2	51	1	ASD64R75B99 69014151677
	7	25	5	2	51	1	ASD126R75B99 69014155411
125	8	20	5	2	69	1	ASD126R75B99 60157681726
	8	20	5	2	69	1	ASD64R75B99 69014151949
	8	32	5	2	69	1	ASD91R75B99 69014151954
150	8	20	10	2	69	1	ASD107R75B99 60157682109
	9	20	5	2	87	1	ASD126R75B99 60157636295
	9	20	5	2	87	1	ASD64R75B99 69014151955
	9	32	5	2	87	1	ASD91R75B99 69014151957
	9	32	5	2	87	1	ASD54R50B99 69014155611
175	10	20	5	4	104	1	ASD64R50B99 60157681727
	10	32	5	4	104	1	ASD126R75B99 69014151709

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	J (mm)	PK QTY	BETTER
100	7	20	5	2	51	1	CB126TB99 69014151685
125	8	32	5	2	69	1	CB151TB99 69014151695
150	9	20	5	2	87	1	CB126TB99 60157636297
	9	20	5	4	87	1	CB107TB99 60157682111
175	10	20	5	4	104	1	CB126TB99 60157636298
200	9	20	6	4	137	1	CB107TB99 60157682113

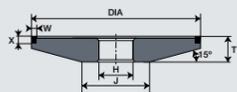
4A9



DIAMOND

DIA (mm)	T (mm)	H (mm)	W (mm)	X (mm)	J (mm)	PK QTY	BETTER
80	10	32	4,7	4	38	1	ASD107R75B99 60157681731
100	10	32	4,7	4	55	1	ASD107R75B99 69014151711

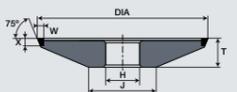
4A9K



DIAMOND

DIA (mm)	T (mm)	H (mm)	W (mm)	X (mm)	J (mm)	PK QTY	BETTER	
75	14	20	4	4	35	1	ASD126R75B99	60157682214
100	14	20	4	4	35	1	ASD126R75B99	69014151981

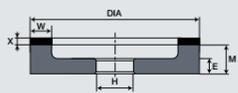
4ET9



DIAMOND

DIA (mm)	T (mm)	H (mm)	W (mm)	X (mm)	J (mm)	PK QTY	BEST		BETTER	
100	8	25	3	1,8	54	1			ASD54R75B99	69014151366
	8	25	3	3,3	54	1			ASD76R50B99	60157681732
125	11,5	32	2,5	1,2	63	1	ASD54R75XLB4847	69014151979		
	12	32	3	1,8	63	1	ASD91R100B99	66260165128		
	12	32	3	1,8	63	1	ASD54R75XLB4847	69014151369		
	14	32	3	3,8	63	1	ASD54R75XLB4847	69014151980		

6A2



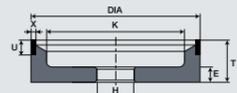
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	E (mm)	PK QTY	BEST		BETTER	
100	20	20	6	4	10	1			ASD151R75B99	60157681733
	20	25	6	4	10	1	ASD91R100B99	60157682114		
	20	20	8	2	10	1	ASD107R100B99	60157681734		
	20	25	8	2	10	1			ASD107R75B99	69014151608
	20	15	12	2	10	1			ASD107R50B99	60157636304
	20	20	12	2	10	1			ASD107R50B99	60157636282
	20	20	12	2	10	1			ASD54R50B99	69014151610
125	20	20	5	2	10	1			ASD64R50B99	60157682115
	40	20	6	5	10	1			ASD64R75B99	60157682117
	20	20	10	2	10	1			ASD107R50B99	69014151615
	20	70	10	2	10	1			ASD107R50B99	69014152087
150	50	20	6	4	10	1			ASD126R75B99	69014151618
	50	50	6	4	10	1	ASD126R100B99	60157681735		
	20	20	10	2	10	1			ASD91R50B99	69014151624
	20	32	15	2	10	1			ASD107R50B99	69014151629
200	20	20	20	2	10	1			ASD126R75B99	69014151631
	50	105	15	6	13	1	ASD151R100B99	60157682118		

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	E (mm)	PK QTY	BEST		BETTER	
125	40	20	6	4	10	1			CB151TB99	60157681789
150	50	20	6	4	10	1			CB151TB99	60157681791
	50	32	6	4	10	1			CB126TB99	69014151623
200	50	105	15	6	13	1	CB107WB99	60157682119		

6A9



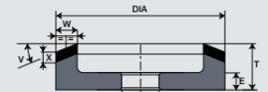
DIAMOND

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	K (mm)	E (mm)	PK QTY	BEST		
100	20	25	3	6	80	7	1	ASD54R100B99		69014153087
	20	20	3	10	80	7	1	ASD64R100B99		60157682122
125	18	20	3	6	112	11	1	ASD54R100B99		69014151637
	18	32	3	6	112	11	1	ASD54R100B99		69014151638
	30	20	3	10	105	10	1	ASD126R100B99		60157681803

CBN

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	K (mm)	E (mm)	PK QTY	BEST		
100	20	20	3	10	80	7	1	CB151WB99		60157682123

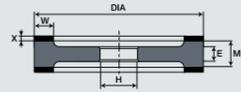
6VV5



DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	V (mm)	E (mm)	PK QTY	BEST		BETTER	
100	20	25	5	8	10°	10	1			ASD126R100/46R75XLB4847	69014151090
	18	25	5	6	8°	10	1			ASD126R100/46R75B99	60157682125
	18	32	5	6	8°	10	1			ASD126R100/46R75B99	60157682126
125	18	32	5	6	8°	10	1	ASD126R125/46R100B99	60157681736		
	18	32	5	6	8°	10	1			ASD91BR100/20BR75B99	60157681737
	22	32	5	10	8°	10	1			ASD126R100/46R75B99	60157681738
	22	32	5	10	8°	10	1	ASD126R125/46R100B99	60157681739		
	22	32	5	10	8°	10	1			ASD91BR100/20BR75B99	60157681740

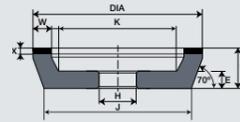
9A3



DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	E (mm)	PK QTY	BETTER	
175	30	20	5	2	14	1	ASD126R50B99	69014151640
	30	20	5	2	14	1	ASD64R50B99	69014151639

11A2-70°



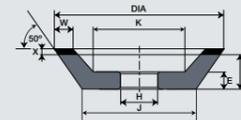
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
100	20	20	5	4	75	10	88	1		ASD151R75B99 60157682163
	20	25	5	4	75	10	88	1	ASD126R100B99 60157682164	

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
100	20	20	5	4	75	10	88	1		CB126TB99 60157682165
150	23	32	6	4	122	10	135	1		CB151TB99 60157682166

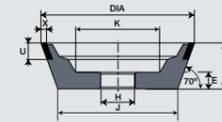
11V2



DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BETTER	
100	25	20	5	3	60	12	58	1	ASD126R75B99	60157636285
	25	20	5	3	60	12	58	1	ASD91R75B99	60157636284

11V9



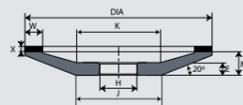
DIAMOND

DIA (mm)	T (mm)	H (mm)	X (mm)	W (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST		BETTER	
75	30	16	1.5	10	40	10	53	1			ASD54R75B99	69014152028
	30	20	2	10	40	10	53	1			ASD126R75B99	69014151377
	30	20	2	10	40	10	53	1			ASD107R75B99	60157682168
100	30	20	2	10	40	10	53	1	ASD64R100B99	60157681746		
	35	20	1.5	10	55	10	75	1			ASD76R75B99	69014151656
	35	20	2	10	55	10	75	1			ASD126R75B99	69014151386
	35	20	2	10	55	10	75	1			ASD76R75B99	69014151383
	35	20	2	10	55	10	75	1	ASD64R100B99	60157681747		
	35	20	3	10	55	10	75	1			ASD126R75B99	60157681748
125	35	20	3	10	55	10	75	1	ASD64R100B99	60157681749		
	40	20	3	10	75	10	96	1			ASD126R75B99	69014151667
	40	20	3	10	75	10	96	1	ASD64R100B99	60157681750		
	40	32	3	10	75	10	96	1			ASD126R75B99	69014151674

CBN

DIA (mm)	T (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST		BETTER	
75	30	20	1.5	10	40	10	53	1	AZTECIV181TBX104	69014152323		
	30	20	2	10	40	10	53	1			CB126TB99	69014151379
	30	20	2	10	40	10	53	1			CB91TB99	60157681792
100	35	20	1.5	10	55	10	75	1	AZTECIV181TBX104	69014152118		
	35	20	1.5	10	55	10	75	1	AZTECIV126TBX104	69014152115		
	35	32	1.5	10	55	10	75	1	AZTECIV181TBX104	69014152120		
	34	20	2	10	55	10	75	1			CB126TB99	69014151944
	34	20	2	10	55	10	75	1			CB91TB99	60157681793
125	35	20	3	10	55	10	75	1	CB107WB99	60157681794		
	40	20	1.5	10	75	10	96	1	AZTECIV126TBX104	69014152326		
	40	20	3	10	75	10	96	1			CB107TB99	60157681795

12A2-20°



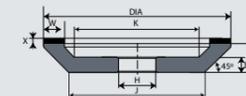
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
125	14	20	5	2	54	8	54	1		ASD126R75B99 69014151721
	14	20	5	2	54	8	54	1		ASD64R75B99 60157687009
	14	20	6	2	54	8	54	1		ASD126R50B99 60157682169
	14	20	6	2	54	8	54	1		ASD91R50B99 60157682170
	14	20	6	4	54	8	54	1	ASD126R100B99 60157682171	
	14	32	6	4	54	8	54	1		ASD91R75B99 60157682172
150	16	20	5	2	68	9	68	1		ASD126R75B99 69014151405
	16	20	5	2	68	9	68	1		ASD64R50B99 69014151397
	16	32	5	2	68	9	69	1		ASD126R75B99 69014151963
	16	32	5	3	68	9	68	1	ASD91R100B99 60157682176	
	16	32	5	3	68	9	68	1	ASD64R100B99 60157682177	
	16	32	6	4	68	9	68	1		ASD126R75B99 60157682178
175	16	32	6	4	68	9	68	1		ASD91R75B99 60157682179
	16	32	10	4	68	9	68	1		ASD126R50B99 60157682180
	18	20	5	2	82	10	82	1		ASD126R75B99 69014151422
	18	20	5	2	82	10	82	1		ASD64R50B99 69014151415
	18	32	5	2	82	10	82	1		ASD126R75B99 69014151424

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
125	14	32	6	4	54	8	54	1		CB107TB99 60157682173
	14	20	10	4	54	8	54	1	CB126WB99 60157682174	
150	16	32	5	3	68	9	68	1	CB126WB99 60157682181	
	16	20	5	4	68	9	68	1		CB126QB99 69014151412
	16	32	6	4	68	9	68	1		CB126TB99 60157682182
	16	32	10	4	68	9	68	1	CB151WB99 60157682183	
175	18	20	5	4	82	10	82	1		CB126TB99 69014151427

12A2-45°



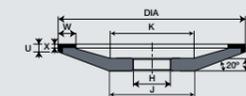
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BETTER
100	23	20	5	2	54	10	62	1	ASD107R50B99 60157636265
	23	20	6	3	54	10	62	1	ASD126R75B99 69014151437
	23	20	6	3	54	10	62	1	ASD76R75B99 69014151434
	23	32	6	3	79	10	81	1	ASD126R75B99 60157636267

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BETTER
100	23	20	5	2	54	10	62	1	CB126QB99 69014151432
125	23	20	6	2	79	10	81	1	CB126TB99 69014151441

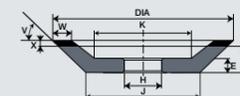
12C9-20°



CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	U (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST
150	16	20	5	2	3	68	9	68	1	AZTECIV126QBX104 69014154415
	16	32	5	2	3	68	9	68	1	AZTECIV126QBX104 69014154417
175	18	20	5	4	5	82	10	82	1	AZTECIV126QBX104 69014154420

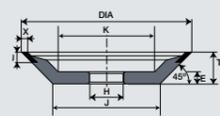
12V2



DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	V (mm)	E (mm)	PK QTY	BEST	BETTER
125	11	20	4	2	30°	9	1	ASD76R125B99 60157682187	
	11	32	4	2	30°	9	1	ASD76R125B99 60157682188	
	11	32	4	2	30°	9	1	ASD46R125B99 60157682189	
150	13	25	4	2	20°	11	1	ASD76R125B99 60157681805	
	13	32	4	2	15°	11	1	ASD76R125B99 60157681807	
	13	32	4	2	15°	11	1		ASD64R75B99 60157682185
	13	32	4	2	15°	11	1	ASD46R125B99 60157681808	

12V9



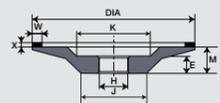
DIAMOND

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
75	20	20	2	6	35	10	35	1		ASD126R75B99 69014151966
	20	20	3	6	35	10	35	1		ASD76R75B99 69014151462
	20	20	2	10	35	10	35	1		ASD64R75B99 60157681752
100	20	20	2	6	60	10	60	1		ASD126R75B99 69014151464
	20	20	2	6	60	10	60	1		ASD64R75B99 60157681753
	20	20	2	10	60	10	60	1	ASD64R100B99	60157681754
	20	20	3	10	60	10	60	1	ASD64R100B99	60157681755
	20	20	3	10	60	10	60	1		ASD46R75B99 60157681756
	20	20	3	10	60	10	60	1	ASD46R100B99	60157681757
125	25	20	2	6	75	10	75	1		ASD126R75B99 60157681758
	25	20	2	6	75	10	75	1		ASD64R75B99 60157681759
	25	20	3	10	75	10	75	1	ASD64R100B99	60157681760

CBN

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BEST	BETTER
75	20	20	2	6	35	10	35	1		CB107TB99 60157681797
100	20	20	2	6	60	10	60	1		CB126TB99 69014151973
	20	20	3	10	60	10	60	1	CB107WB99	60157681799
125	25	20	2	6	75	10	75	1		CB126TB99 69014151975
	25	20	2	6	75	10	75	1		CB107TB99 60157681800
	25	20	3	10	75	10	75	1	CB107WB99	60157681801

13A2



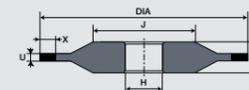
DIAMOND

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BETTER
125	18	32	5	1,5	50	9	70	1	ASD107R75B99 60157682191
	18	20	5	4	50	9	70	1	ASD126R75B99 69014151473
	18	20	5	4	50	9	70	1	ASD64R75B99 60157687068
	18	20	5	4	50	9	70	1	ASD46R75B99 60157681810
150	20	32	5	1,5	60	9	82	1	ASD107R75B99 60157682192
	20	20	5	4	60	9	82	1	ASD151R75B99 60157681815
	20	20	5	4	60	9	82	1	ASD64R75B99 60157681820
175	22	20	5	4	70	10	100	1	ASD126R75B99 60157681827

CBN

DIA (mm)	M (mm)	H (mm)	W (mm)	X (mm)	K (mm)	E (mm)	J (mm)	PK QTY	BETTER
125	18	20	5	4	50	9	70	1	CB151TB99 60157681812
	18	20	5	4	50	9	70	1	CB107QB99 60157681814
150	20	20	5	4	60	9	82	1	CB151TB99 60157681825
	20	20	5	4	60	9	82	1	CB126QB99 69014151479
	20	20	5	4	60	9	82	1	CB107QB99 60157681826

14A1



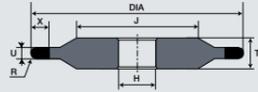
DIAMOND

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	J (mm)	PK QTY	BEST
200	10	32	7	3	160	1	ASD126R100B99 60157682194
	10	60	5	4	160	1	ASD151R100B99 60157682195
	10	32	6	4	160	1	ASD46R100B99 60157681830
	10	60	6	4	160	1	ASD46R100B99 60157681831
	10	32	7	5	160	1	ASD126R100B99 60157682196
	10	60	7	5	160	1	ASD126R100B99 60157682197

CBN

DIA (mm)	T (mm)	H (mm)	X (mm)	U (mm)	J (mm)	PK QTY	BEST
200	10	60	5	2	160	1	CB181WB99 60157682198
	10	32	6	4	160	1	CB151WB99 60157681832
	10	32	6	4	160	1	CB91WB99 60157681833
	10	32	6	4	160	1	CB64WB99 60157681835
	10	60	6	4	160	1	CB151WB99 60157681836
	10	60	6	4	160	1	CB126WB99 60157681837
	10	60	6	4	160	1	CB64WB99 60157681838

14F1



DIAMOND

D (mm)	T (mm)	H (mm)	X (mm)	U (mm)	R (mm)	J (mm)	PK QTY	BEST		BETTER	
100	6	20	6	4	2	70	1	ASD64R100B99	60157681846		
125	10	20	10	8	4	100	1			ASD65R75B99	60157681848
150	10	20	5	2	1	120	1	ASD64R100B99	60157681850		
	10	20	5	4	2	120	1	ASD64R100B99	60157681851		
200	10	50	5	2	1	160	1	ASD151R100B99	60157682201		
	10	32	6	2	1	160	1	ASD126R100B99	60157681853		
	10	60	7	2	1	160	1	ASD64R100B99	60157681855		
	10	60	7	2	1	160	1	ASD126R100B99	60157682202		
	10	20	5	2,4	1,2	160	1	ASD64R100B99	60157682204		
	10	60	6	3	1,5	160	1	ASD126R100B99	60157681856		
	10	32	7	3	1,5	160	1	ASD126R100B99	60157683136		
	10	20	5	4	2	160	1	ASD64R100B99	60157682205		
	10	20	6	4	2	160	1	ASD151R100B99	60157681857		
	10	32	6	4	2	160	1	ASD151R100B99	60157681858		
	10	60	6	4	2	160	1	ASD151R100B99	60157681859		
	10	60	7	4	2	160	1	ASD126R100B99	60157682208		
10	60	5	5	2,5	160	1	ASD126R100B99	60157682209			
10	32	6	5	2,5	160	1	ASD151R100B99	60157681862			

CBN

D (mm)	T (mm)	H (mm)	X (mm)	U (mm)	R (mm)	J (mm)	PK QTY	BEST				
100	6	20	5	4	2	70	1	CB107WB99				60157681847
125	10	20	5	4	2	100	1	CB107WB99				60157681849
150	10	20	5	4	2	120	1	CB107WB99				60157681852
200	10	20	5	2,4	1,2	160	1	CB91WB99				60157682210
	10	32	7	3	1,5	160	1	CB126WB99				60157682211
	10	60	5	4	2	160	1	CB151WB99				60157682212
	10	32	6	4	2	160	1	CB151WB99				60157681863

SGA TO PROVIDE

Electroplated pins with high quality diamond and CBN grits

APPLICATIONS & MARKETS

Internal grinding of:

- Carbides
- Short chipping materials
- HSS/high-alloy hardened steel



SGA TO CHECK DIMENSIONS

E1A8W SGA TO TO SEND NEW IMAGE

DIAMOND

DIA (mm)	T (mm)	Y (mm)	L (mm)	L ₂ (mm)	PK QTY	BEST	
1,5	5	3	40	7	4	DPS 76M	69014151200
	5	3	40	7	4	DPS 181M	69014151199
2	5	3	40	12	4	DPS 76M	69014151168
	5	3	40	12	4	DPS 181M	60157637973
2,5	5	3	40	12	4	DPS 76M	69014151201
3	5	3	50	15	4	DPS 76M	69014151170
	5	3	50	15	4	DPS 181M	69014151169
3,5	5	3	50		4	DPS 76M	69014151205
	5	3	50		4	DPS 76M	69014151173
4	5	3	50		4	DPS 181M	69014151172
	5	3	50		4	DPS 76M	69014151207
5	5	3	50		4	DPS 181M	69014151206
	6	6	64	14	3	DPS 76M	69014151178
6	6	6	64	14	3	DPS 181M	69014151177
	8	6	62		2	DPS 76M	69014151192
8	8	6	62		2	DPS 181M	69014151191
	10	6	80		2	DPS 76M	69014151195
10	10	6	80		2	DPS 181M	69014151194
	12	6	80		2	DPS 76M	60157636808

CBN

DIA (mm)	T (mm)	Y (mm)	L (mm)	L ₂ (mm)	PK QTY	BEST	
0,7	3	3	32	4	4	XBS 76M	69014151184
1	4	3	31	5	4	XBS 76M	69014151183
	4	3	31	5	4	XBS 181M	69014151188
1,2	4	3	31	8	4	XBS 181M	69014151190
1,5	5	3	40	7	4	XBS 76M	69014151203
	5	3	40	7	4	XBS 181M	69014151176
2	5	3	40	12	4	XBS 76M	69014151202
	5	3	40	12	4	XBS 181M	69014151180
2,5	5	3	40	12	4	XBS 76M	69014151197
	5	3	40	12	4	XBS 181M	69014151198
3	5	3	50	15	4	XBS 76M	69014151171
	5	3	50	15	4	XBS 181M	60157636804
3,5	5	3	50		4	XBS 76M	69014151185
	5	3	50		4	XBS 181M	69014151186
4	5	3	50		4	XBS 76M	69014151175
	5	3	50		4	XBS 181M	69014151174
5	5	3	50		4	XBS 76M	69014151179
	5	3	50		4	XBS 181M	60157636809

DIAMOND PINS DPS

FEATURES

- Electroplated pins with high quality diamond in 2 grit sizes

BENEFITS

- High material removal
- For use dry or wet
- Ideal for carbides & short chipping material



CBN PINS XBS

FEATURES

- Electroplated pins with high quality CBN in 2 grit sizes

BENEFITS

- High material removal rate
- For use dry or with straight oil
- Ideal for HSS & high-alloy hardened steels



BEST

Norton stationary diamond dressing tools have a worldwide reputation for quality and technology.

APPLICATIONS & MARKETS

- For profiling & straight dressing of all conventional grinding wheels



BEST

BLADE TOOL DRESSER HPB-D 35 & 3585

FEATURES	BENEFITS
<ul style="list-style-type: none"> Synthetic multi-crystalline diamond 	<ul style="list-style-type: none"> Gives the highest repeatability & consistency of dressing for the highest demands for profiling & straight dressing

BETTER

BLADE TOOL DRESSER HPB-D & -C 30, 45, 60

FEATURES	BENEFITS
<ul style="list-style-type: none"> Natural diamond 	<ul style="list-style-type: none"> For an economical dressing solution of all AL203 & SiC wheels. Needles are recommended for profile dressing

PRODUCT SELECTION

USAGE KEY	GENERAL CHOICE					
	STRAIGHT GRINDING WHEELS WITH NO PROFILE	PROFILED GRINDING WHEELS	GRIT	AUTOMATIC DRESSING PROCESS	ECONOMICAL DRESSING	HIGH REMOVAL RATE
DRESSING TOOL						
Single-point	▣		All			
Multi-point	▣		36-180		▣	▣
Blade tool dresser	▣	▣	36-180	▣	▣	▣
Profile dresser		▣	80-180			

TIPS

- A new dressing tool should be put through at least 5 dressing cycles in order to fit the diameter of the grinding wheel
- The finer the dressing tool grit, the higher the surface roughness & cutting capability
- The lifetime of the dressing tool is extended by ensuring that adequate coolant pressure & volume are directed at the tool
- The coarser the grit, the smoother the surface roughness

SELECTION OF BLADE TOOL DRESSERS

Dressing of profiles with blade tools	Dressing tools use "needle" form natural or synthetic diamonds. Needle diamonds are especially suited to dressing profiles using infeed & angular feed	
Natural diamonds	An effective diamond layer with a length up to 15mm gives a very economical dressing solution. Using precise diamond setting patterns, with overlapped rows of stones ensures that consistent dressing results are achieved	
Synthetic diamonds	The constant cross section given by synthetic diamonds, guarantee a constant dressing behaviour through the complete life of the dressing tool	
SELECTION OF GRIT SIZE		
Grit size of grinding wheel	Synthetic diamond size	Natural diamond size
46	0,8x0,8	D1181
60	0,8x0,8	D1001
80-120	0,6x0,6	D711
SELECTION OF TOOL SIZE		
Diameter x Thickness	No of synthetic needles	Dimensions
<35,000	2	10,5x28
35,000-60,000	3	20,5x28
60,000-100,000	4	20,5x28

BLADE TOOL DRESSERS

W (mm)	L (mm)	DL (mm)	GRIT	PK QTY	BEST		BETTER	
10,5	28	5	D711	1			HPB-D 30	60157682759
	28	5	D1001	1			HPB-D 45	60157682782
	28	5	D1181	1			HPB-D 60	60157682786
	28	5	NEEDLE	1			HPB-D	60157682790
20,5	28	5	D711	1			HPB-C 30	60157682801
	28	5	D1001	1			HPB-C 45	60157682806
	28	5	D1181	1			HPB-C 60	60157682809
	28	5	NEEDLE	1			HPB-C	60157682814
10,5	28	5	0,6x0,6	1	HPB-D 3565 / 2	60157682820		
	28	5	0,6x0,6	1	HPB-D 3565 / 3	60157682856		
	28	5	0,6x0,6	1	HPB-D 3565 / 4	60157682895		
	28	5	0,8x0,8	1	HPB-D 3585 / 2	60157682899		
	28	5	0,8x0,8	1	HPB-D 3585 / 3	60157682902		
	28	5	0,8x0,8	1	HPB-D 3585 / 4	60157682904		

SCREWED SHANKS FOR BLADE TOOL DRESSERS

DIA (mm)	L (mm)	SHANK CODE	PK QTY	BEST	
12,065	40	MT1	1	HPB-H3	60157682832
9,045	25,5	MT0	1	HPB-H4	60157682907
11,11	50	Z11,11	1	HPB-H2	60157682910
10,00	50	Z10	1	HPB-HX	60157682911

BEST

SINGLE-POINT DRESSER BC SG

FEATURES	BENEFITS
■ Three working points	■ Resetable due to three working points

SGA TO SUPPLY NEW TEXT

BETTER

SINGLE-POINT DRESSER BC

FEATURES	BENEFITS
■ Two working points	■ Resetable due to two working points

SGA TO SUPPLY NEW TEXT

CHOICE OF SINGLE-POINT DRESSERS

To dress vitrified wheels both tapered & straight shank points are available. The choice of shank depends on the type of dresser holder.

Which tool to choose depends mainly on the dimensions of the wheel to be dressed. In order to calculate this it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS

	Diameter x Thickness (mm)	Carat
	<3000	033 Carat
	3000 – 12000	05 Carat
	>12000	1 Carat

For best results, always use a coolant when dressing

SINGLE-POINT DRESSERS

SHANK (mm)	CARAT	PK QTY	BEST BC SG	BETTER BC
8	0.33	1	60157682943	60157682843
	0.50	1	60157682944	60157682939
	1.00	1	60157682945	60157682942
10	0.33	1	60157682955	60157682946
	0.50	1	60157682958	60157682951
	1.00	1	60157682960	60157682954
11,11	0.33	1	60157683025	60157683013
	0.50	1	60157683030	60157683016
	1.00	1	60157683033	60157683019
MT1	0.33	1	60157683052	60157683037
	0.50	1	60157683058	60157683043
	1.00	1	60157683062	60157683048

SGA TO SUPPLY NEW TABLE

BEST

PROFILE DRESSER

FEATURES	BENEFITS
<ul style="list-style-type: none"> Extremely high performance tools 	<ul style="list-style-type: none"> Used to meet extremely high profile accuracy requirements



PROFILE DRESSER

DIA (mm)	RADIUS (mm)	ANGLE	BEST	
			Part Number	Product Code
9,52	0,13	40	DC 40/130	60157682850
	0,25	40	DC 40/250	60157682889
	0,50	40	DC 40/500	60157682901
	0,13	60	DC 60/130	60157682903
	0,25	60	DC 60/250	60157682905
	0,50	60	DC 60/500	60157682909

BEST

MULTI-POINT DRESSER

FEATURES	BENEFITS
<ul style="list-style-type: none"> Economical & robust tool 	<ul style="list-style-type: none"> Ideal for straight dressing at high speed with low technical demands

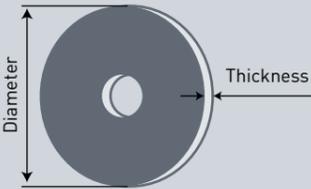



CHOICE OF MULTI-POINT DRESSERS

To dress vitrified wheels both tapered & straight shank points are available. The choice of shank depends on the type of dresser holder

Which tool to choose depends mainly on the dimensions of the wheel to be dressed. In order to calculate this it is best to use the following method:

MULTIPLY THE DIAMETER OF THE WHEEL BY ITS THICKNESS

	Diameter x Thickness (mm)	Carat
	<30000	13 Carat
	30000 -60000	25 Carat
	>60000	5 Carat

For best results, always use a coolant when dressing

CHOICE OF A DIAMOND GRIT

Wheel abrasive	Diamond
80-120	D301
60-80	D711
46-60	D1001
36-46	D2240

MULTI-POINT DRESSERS

DIA (mm)	GRIT	PK QTY	BEST		
			D11x11 (5 CARAT)	D8x11 (2.5 CARAT)	D6x8 (1.3 CARAT)
8	D2240	1	60157682849	60157682915	
	D1001	1	60157682896	60157682920	
	D711	1	60157682906	60157682970	60157682986
	D301	1			60157683153
10	D2240	1	60157682892	60157682916	
	D1001	1	60157682897	60157682922	
	D711	1	60157682908	60157682968	60157682990
	D301	1			60157683154
11,11	D2240	1	60157682893	60157682917	
	D1001	1	60157682898	60157682923	
	D711	1	60157682912	60157682977	60157682992
	D301	1			60157683155
MT1	D2240	1	60157682894	60157682918	
	D1001	1	60157682900	60157682925	
	D711	1	60157682914	60157682981	60157682996
	D301	1			60157683156

