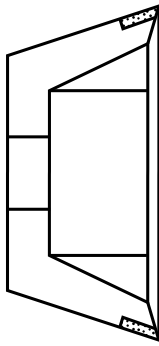


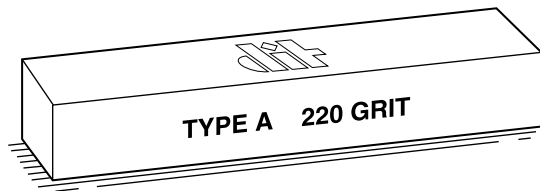
11A2



11V9

# How to square up and true 11A2 and 11V9 diamond wheels on single lip tool and cutter grinders.

One of the ways this is done is to take some silicon carbide 100 grit abrasive and, on a flat surface or lapping plate, do some figure eight strokes. After two or three strokes, index the diamond wheel one sixth of a turn. This keeps the wheel square with its centerline.



Soak the Type A (aluminum oxide) dressing stick in water to saturate it. A saturated stick has better action in removing the bond. Plunge the stick straight into the face of the wheel. Then at a rate of .001, true the face of the diamond wheel with the Moly Stick. Depending on how much needs to be removed to square up the face, it may be necessary to erode more bond to expose more diamond. For the Moly Stick to pull out and true the face, the diamond mesh must be exposed. After the face is true, dress open the wheel once again so it can grind cool and fast.

Squaring and truing can also be done with a DIT Moly Stick. Mount the DIT Moly Stick (3/8 x 3) into the tool compound. **FIRST**, before using it, expose the diamond mesh with a Type A dressing stick. The diamond mesh must be exposed in order for the Moly Stick to pull out the high diamonds and true the face.



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