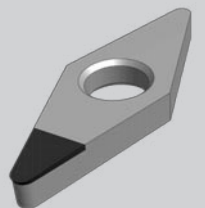
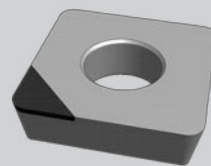
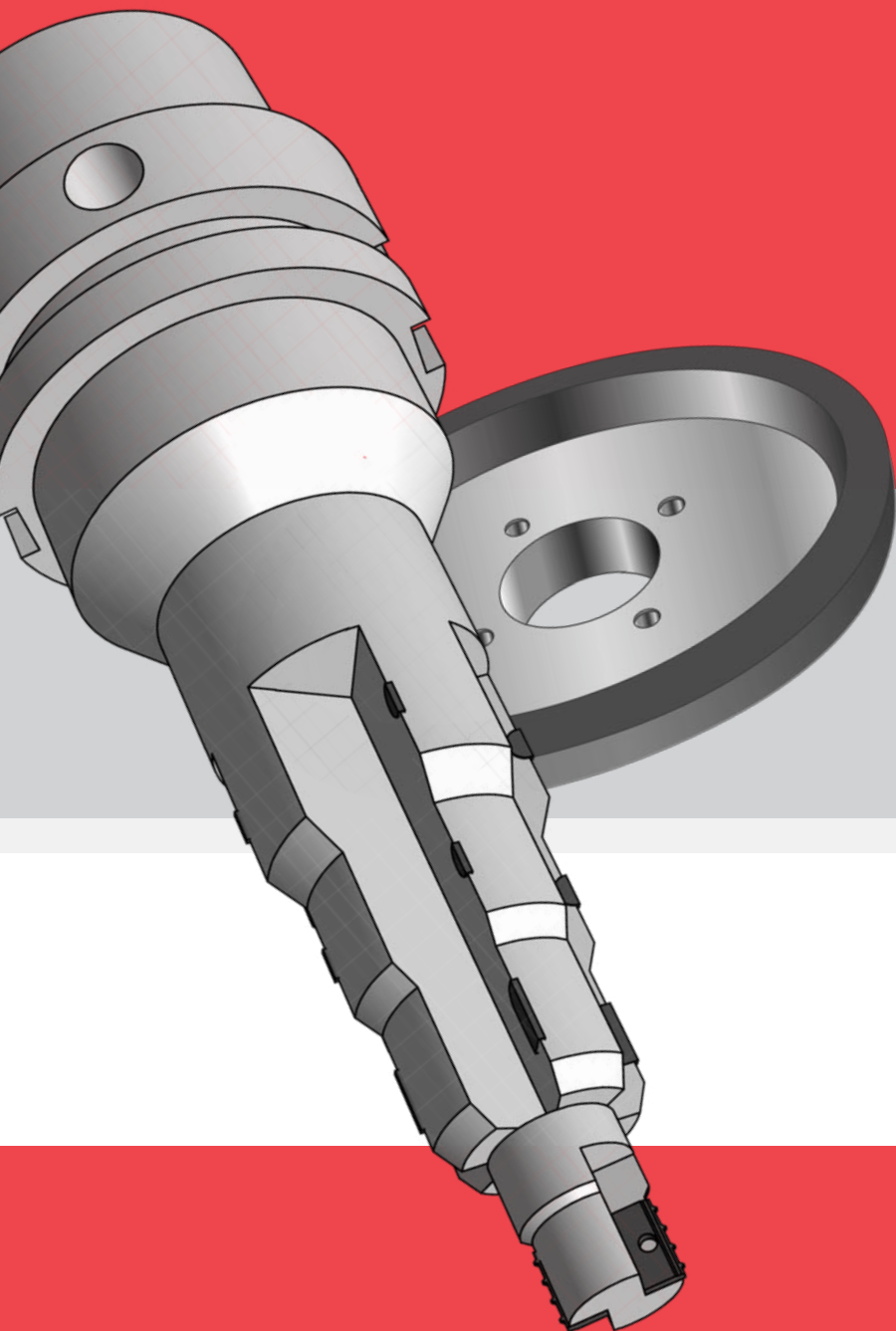


VITRIFIED
SUPERABRASIVES
PCD / PCBN
GRINDING

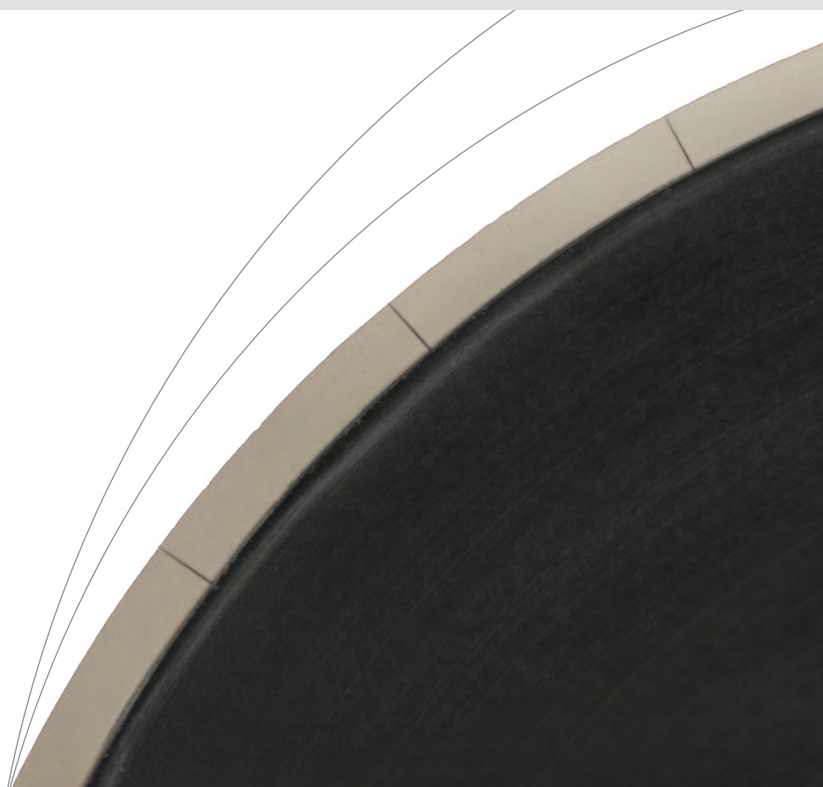
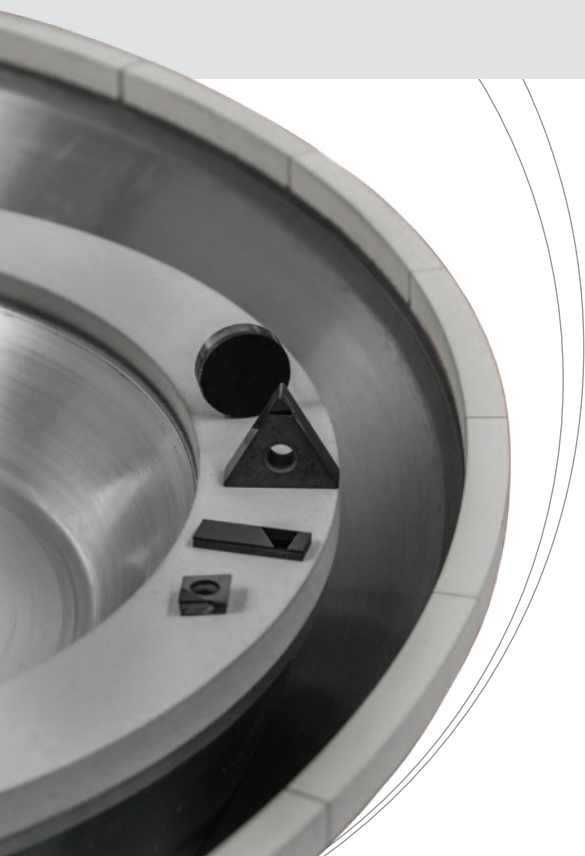
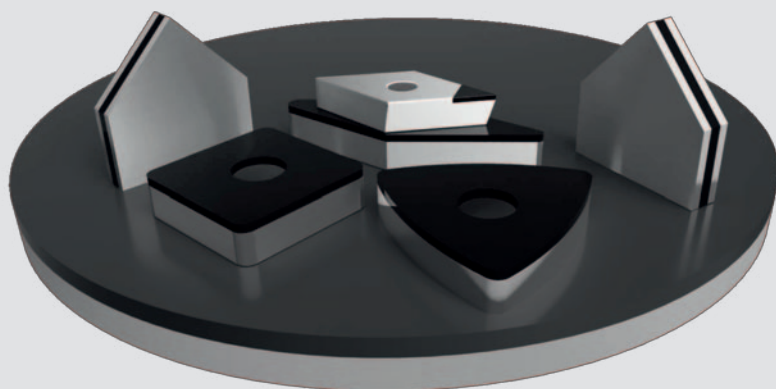


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we shape your world

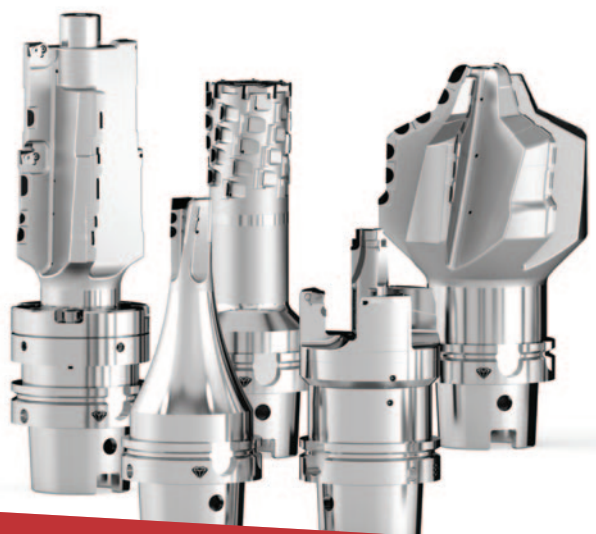


VITRIFIED SUPERABRASIVES PCD / PCBN GRIN

A full selection of PCD grinding wheels for manual precision applications for example on Ewag, Coburn, and similar machines is available from molemab. Grit sizes range from standard Macro grits (D46 and larger) for roughing and Micron grit sizes of ten microns and under are used for finishing operations. These wheels are designed to significantly limit vibration thus enabling high-precision grinding.



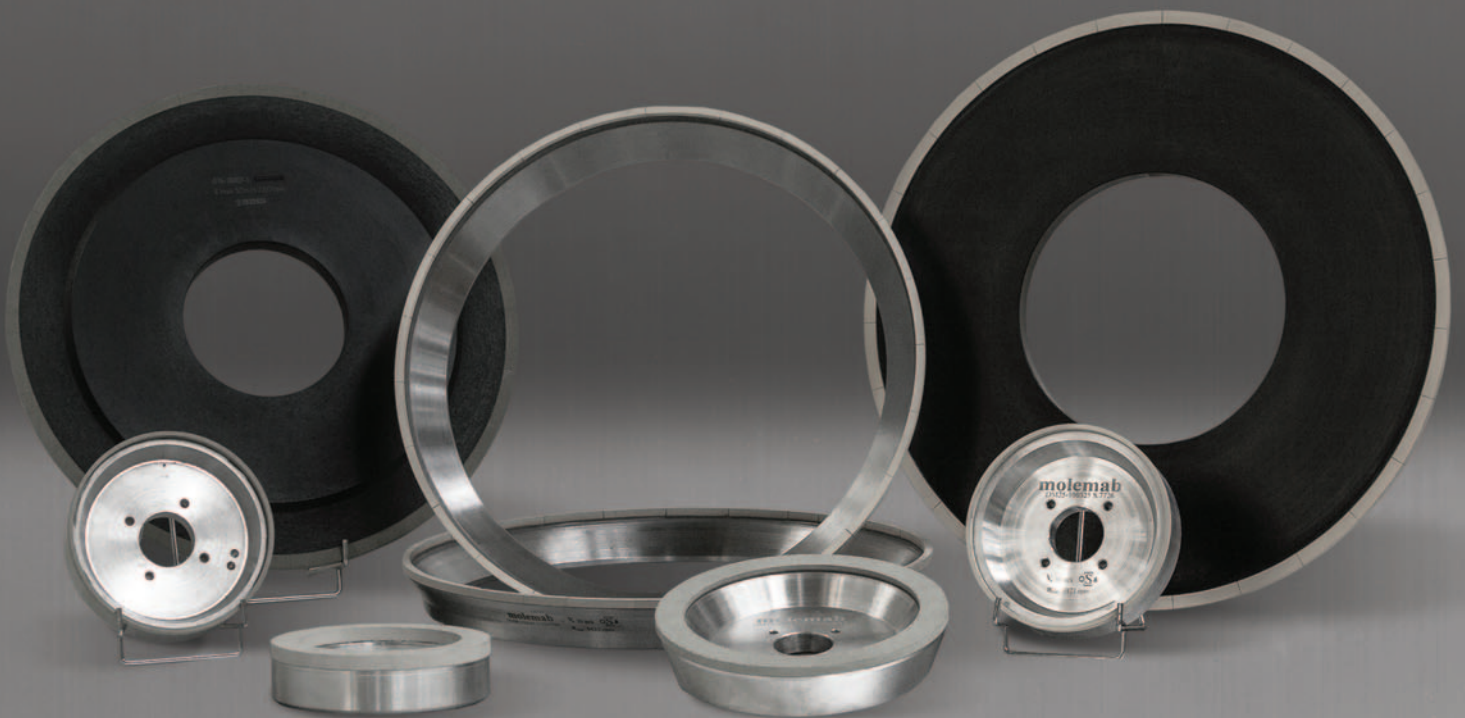
High precision OD grinding of PCD Rotary tools also has its challenges. Requirements are again for an optimum cutting edge quality but this may include overcoming a heavily interrupted cut on a workpiece that may tend to deflect or vibrate if grinding pressure becomes too high. The molemab OD-PCD grinding wheel series has also proven itself a top quality product on this application with grit sizes ranging from D64 to under 10 microns.



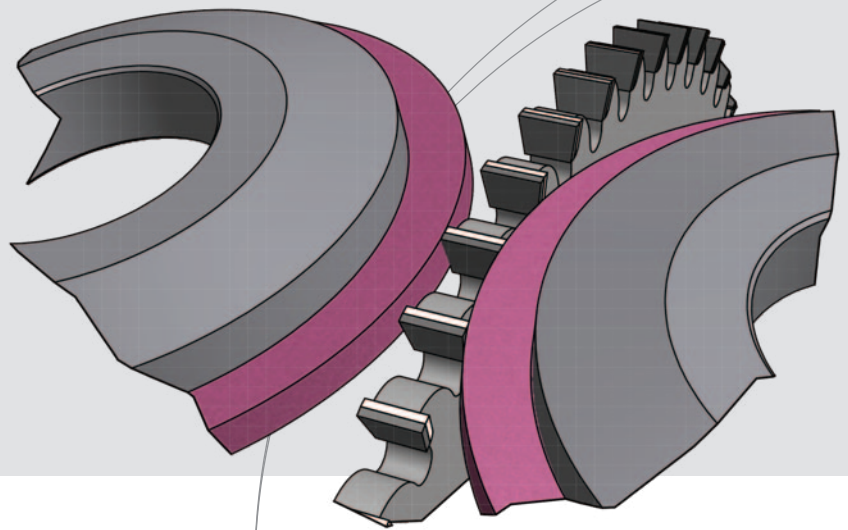
Molemab Vitrified Diamond for PCD / PCBN grinding

To the "Verge of Perfection" is the destination of this product line from molemab. As PCD tool life is directly dependant on the cutting edge quality, this product line has been specifically developed for perfect edge generation on PCD and PCBN tools. These advanced grinding wheels are symbolic of a product that diverges from standard products and are molemab's answer to the requirement for a high performance grinding wheel in one of the fastest growing tool markets in recent years.

The utmost care has been given to the selection of diamond quality for this application. Not only is the grit quality of fundamental importance but also the grit shape and size distribution is critical for the manufacture of these top quality PCD/PCBN grinding wheels. Grinding wheel production with micron size grits has special requirements, however, this product from molemab combines a delicate but nevertheless aggressive cutting action yielding an impressive cutting capacity despite the fine micron sized diamond grits used.



PCD and PCBN inserts are now being used on an ever-increasing variety of cutting tools so the requirements for the corresponding grinding wheels has become more challenging. Significant material removal rates are expected while maintaining edge integrity in the continuous battle of “Diamond against Diamond”.

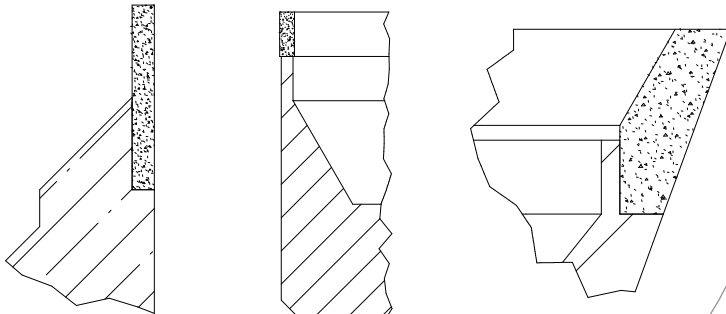


At molemab we pride ourselves in being able to offer our customers “Specials” in the area of PCD grinding that are not available elsewhere.

3A1

6A9

11V9



SPECIALS

(including ultra thin diamond layers)



A selection of suitable dressing sticks for conditioning of molemab PCD grinding wheels is available.



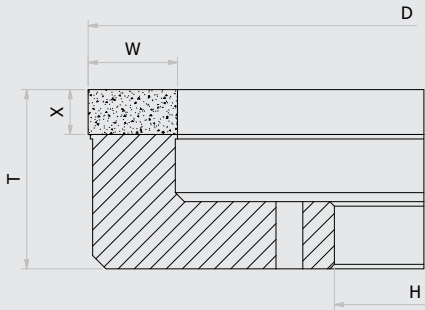
6A2 Typical grinding machines:
Ewag RS12/15, Coburn, Rush, Farman

Ø	T	W	X	H	E	
150	40	25	10	40	15	
150	40	20	10	40	15	
150	40	15	10	40	15	
150	40	10	10	40	15	

Typical Grit sizes
 Roughing: D46, D30,
 D25, D64

Typical Grit sizes
 Semi finishing: DM20,
 DM17, DM15

Typical Grit sizes
 Finishing: DM12, DM09,
 DM07



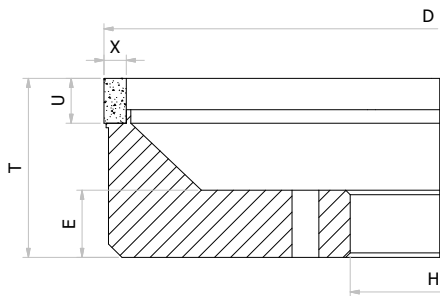
6A9 Typical grinding machines:
Ewag RS12/15, Coburn, Rush, Farman

Ø	T	U	X	H	E	
150	40	10	5	40	15	
150	40	10	4	40	15	
150	40	10	3	40	15	

Typical Grit sizes
 Roughing: D46, D30,
 D25, D64

Typical Grit sizes
 Semi finishing: DM20,
 DM17, DM15

Typical Grit sizes
 Finishing: DM12, DM09,
 DM07



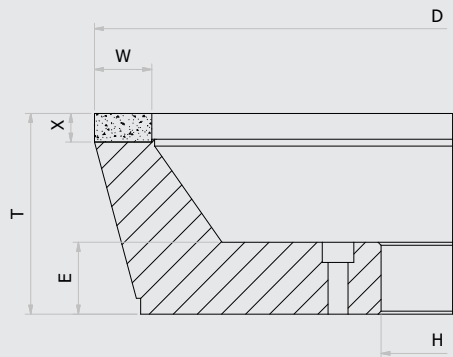
11A2 Typical grinding machines: Ewamatic

Ø	T	W	X	H	E	
200	50	6	6	40		
250	50	20	10	40		
250	50	10	10	40		
250	50	5	10	40		

Typical Grit sizes
 Roughing: D46, D30,
 D25

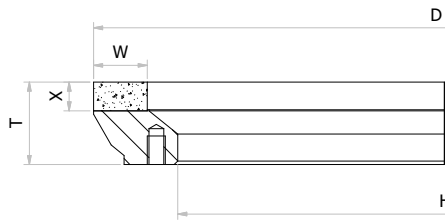
Typical Grit sizes
 Semi finishing: DM20,
 DM17, DM15

Typical Grit sizes
 Finishing: DM12, DM09,
 DM06



2A2 Grinding Cup. Typical grinding Machines: Wendt, Agathon

Ø	T	W	X			
400	50	20	10			
400	50	10	10			
350	26	10	5			
350	26	8	5			



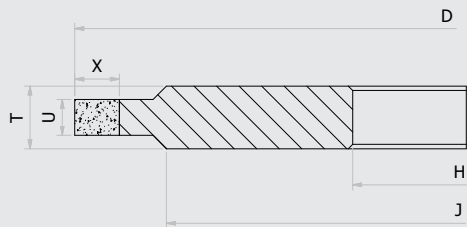
3A1/14A1 OD Grinding on Studer, Danobat or similar

Ø	T	U	X	H		
500	20	6	10	203,2		
450	20	10	10	203,2		
400	20	8	10	127		
400	20	5	10	127		
400	20	3	10	127		

Typical Grit sizes
 Roughing: D76, D64, D46

Typical Grit sizes
 Semi finishing: DM25, DM15

Typical Grit sizes
 Finishing: DM12, DM09



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