DIANAMIC® Abrasive Products Inc.
2566 Industrial Row • Troy, Michigan 48084, USA

Superabrasive Bonded Grinding Wheel Specification Questionnaire

The following questions should be answered as completely as possible. Your response will allow us to design and manufacture an **"application oriented"** Superabrasive grinding wheel best suited to your specific requirements and environment.

If you are currently using a superabrasive bonded grinding wheel, please provide the current type of bond and wheel specifications which are always located on the grinding wheel and the packaging as well as the manufacturers' name. This information will allow us to cross reference your current product to the Dianamic **"application oriented"** Superabrasive bonded products.

Often times the type of grinding wheel you are currently using is not the best for your specific application. We will analyze the information you provide us concerning the type of product you are grinding as well as the grinding environment and recommend the appropriate **"application oriented"** bond system and mesh / micron size for your specific micro finish requirements.

When evaluating competitive products and quotes; please note that often times Dianamic is not the least expensive supplier, although we are the highest quality supplier. Keep in mind that we use in our manufacturing processes only the highest quality available ingredients in our bond systems and never use any reclaim or mixed product (Diamond or cBN). We use only Virgin Diamond (synthetic and natural) and various types of cBN which are selected on an **"application oriented"** basis.

What is **"application oriented"** superabrasive grinding wheel? Since 1985, Dianamic selects not only the highest quality Diamond and cBN, but also selects the most appropriate type of superabrasive to be used on an application case by case basis, based on customer requirements and specifications.

Not all Diamond and cBN is created equal. Each type of superabrasive has very specific ways it reacts during grinding / machining processes. Our selection process for the **"application oriented"** is based on 29+ years of actual manufacturing experience.

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Please answer questions as completely as possible

Company Name_____

Ship to Address_____

Bill to Address if different_____

City_____State / Province_____

Zip Code / Postal Code_____Country_____

Telephone_____Facsimile_____

Company Web site_____

Contact Name_____

Contact Email_____

Contact Telephone and Extension and Facsimile if different from Company

_____

Superabrasive Grinding Wheel Specifications in Inches or Metric or submit wheel prints in AutoCAD to info@dianamic.com

1. Grinding Wheel Shape (if available)_____
   (For mountable OD type wheels)
2. ID Style Grinding Wheels- Head Diameter_____Head Length_____

   Shank Size_____OAL_____Other_____
3. Bond Type

   RESIN METAL VITRIFIED HIGH TEMP POLYAMIDE SINGLE LAYER / PLATED

   (For plated / single layer products, please fill out the Plated Questionnaire)
4. Bond specifications_____
   (Bond specifications can be found on your existing grinding wheel or packaging)
5. Current Supplier's Name / Manufacturers Name_____
   a. Diameter _____
   b. Thickness_____

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Please answer questions as completely as possible

c. Bore Diameter_____Expected Tolerance or + -_____

d. Bolt Hole Circle if applicable_____

e. Mounting Hole thread size and pattern if applicable_____

f. Bond Depth_____

g. Mesh Size or Micron Size_____

h. Superabrasive Type (please circle)

Natural Diamond Synthetic Diamond cBN

If you know if the Synthetic Diamond is Crystalline (which offers a more uniform shape and size controlled crystal) or Non Crystalline (which is a free cutting crystal), please list below:

_____

If you know what type of superabrasive by manufactures name and if there is any subsequent coating such as Nickel, Copper, Chromium, Copper Alloy – Bronze and Cobalt, Silicon Based or Titanium, please list below:

_____

i. Any additional information that may be useful, please describe:_____

_____

j. If you do not have the wheel shape, please describe as completely as possible, include any angle / angles; radius / radii or any form per print specifications that can be dressed. Advise if there are any hub on either or both sides and diameter and thickness or if the wheels are to be mounted on standard Sopko adaptors.

_____

_____

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Product being ground

Steel Grade_____Rockwell Hardness C_____

Carbide Grade and Cobalt content_____

Ceramic Grade_____

Friction Material type_____

Glass or other type of material_____

Machine, Coolant and Filtration Specifications

Type of machine used and brand name_____

Spindle HP / KW_____Is spindle constant velocity YES or NO

Coolant use and type_____Is a coolant chiller used YES or NO

Filtration type and to what micron filtered_____

Do you have high pressure coolant velocity system? YES or NO

Type, brand, flow rate, velocity, pressure, temperature_____

_____

Grinding Parameters – Type of Grind Process

OD ID SURFACE FORM CNC CREEP FEED HEDGE GRIND PROFILE OPG OTHER
(Please circle)

In feed depth_____Cross feed speed_____

Spindle speed_____RPM /SFM _____Variable speed YES or NO

Stock removal per pass_____Total Stock Removal_____

Size of part being ground_____

Dresser type_____Frequency of Dressing_____