

CVD

Roller dresser



UNICORN



Anchor[®]

UNICORN series

CVD Roller dresser / CVD修整輪

Anchor UNICORN-CVD roller dresser is used to dress the oxide aluminum and silicon carbide bonded, diamond and CBN superabrasive precision grinding wheels. It could be used to dress various shape and high precision grinding wheels, applied in precision components grinding processes such as gear, linear guide way, ball screw, bearing and so on.

嘉寶UNICORN系列CVD修整輪可用於修整各種形狀及高精密的傳統氧化鋁、碳化矽砂輪以及鑽石、CBN超級磨料砂輪，廣泛應用於精密加工研磨製程，如齒輪、線性滑軌、滾珠螺桿以及培林等等。

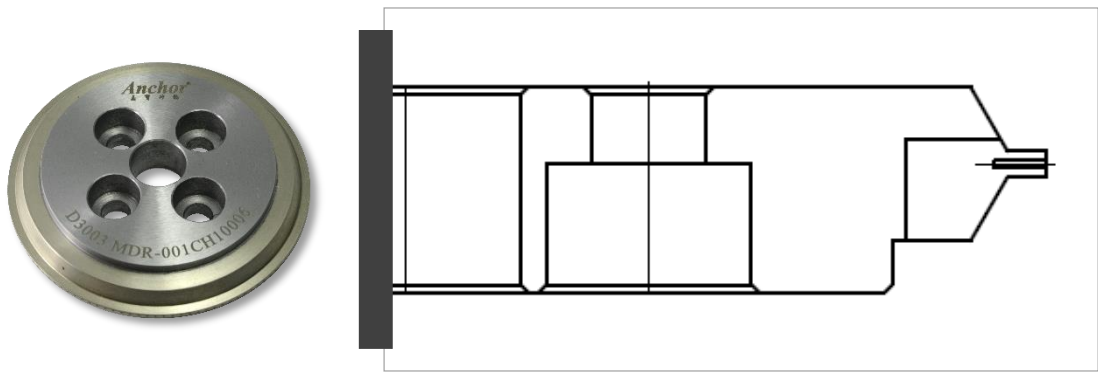
APPLICATION



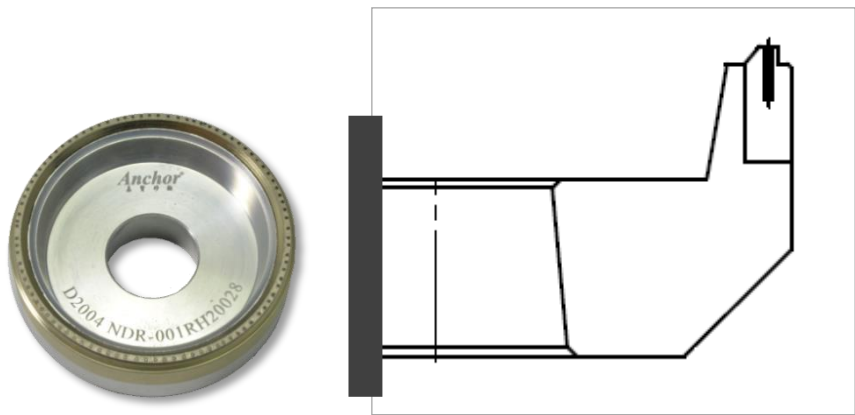
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Shapes of CVD Roller dresser / 常見修整輪形緣



Grit 磨粒	Wheel size 尺寸	Tolerance 公差
CVD	Customized (40 to 150 mm)	parallelism (//) 5um verticality (⊥) 5um runout (↗) 5um



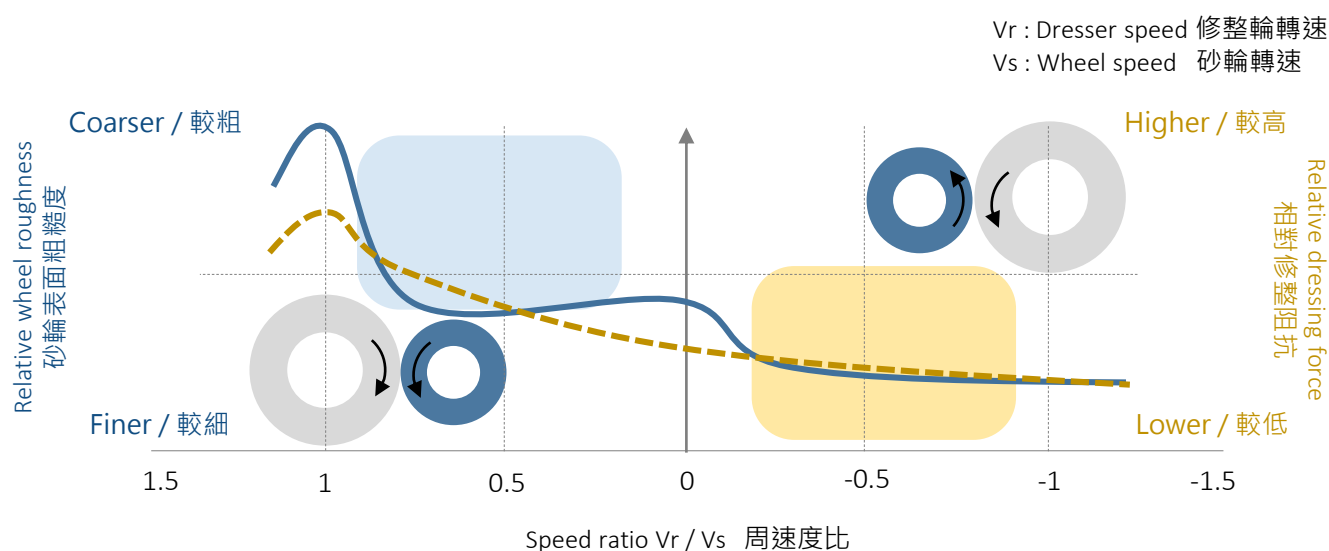
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- According to the application, the wheel shape and size, the amount, length, diameter, radius of CVD pillar could also be customized.
- 依修整用途不同，修整輪尺寸型緣、晶柱排列角度、數量、大小及R角均可客製化訂製。

Precautions for use / 使用注意事項

- Be careful while operating, avoid to make impact on wheels.
 - Sufficient coolant is necessary during the dress processing.
 - The surface roughness of work-piece could be affected by the dressing direction, infeed speed and speed ratio between dresser and grinding wheel.
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- 操作時請注意使用安全，避免撞擊修整輪及砂輪
 - 修整時，請務必搭配使用足量的研削液
 - 研磨工件表面粗糙度，會因修整方向，或修整時在不同的進給速度與速度比的條件下，而有所變化

Speed ratio and roughness / 周速比與面粗度



Wheel sharpness
砂輪銳利度

Dressing force
修整阻抗

Better cutting force
砂輪切削力佳

Finer surface finish
工件表面粗度佳

Uni directional / 順向
 $0.2 < Vr / Vs < 0.8$

- ✓ Coarser wheel roughness with better cutting ability
砂輪表面粗糙銳利，切削力較好
- ✓ The dresser wears faster
修整輪消耗較快
- ✓ Coarser surface finish for work piece
工件研磨表面粗度較差

Counter directional / 逆向
 $-0.2 > Vr / Vs > -0.8$

- ✓ Finer wheel roughness with lower cutting ability
砂輪表面較細，切削力較差
- ✓ The dresser wears slower
修整輪消耗較慢
- ✓ Finer surface finish for work piece
工件研磨表面粗度較好



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