

# HYBRIX WHEELS



## Glass grinding wheel

New diamond wheels modified Uplas bond, a composite of special ceramic bond and metal bond, specially designed for ceramics grinding such as quartz glass and soda glass.

## Characteristics of Hybrix Wheels

When glass grinding, there are many problems they are rough surface finish and large scratches. They are caused sharpness decreases and wheel loading. There for this leads to increased dressing time and greatly decreases the work efficiency and wheel life.

The new Uplas bond reduces wheel loading and keeps the wheel sharpness for longer to vastly reduce the dressing time and eliminate dressing completely, greatly improving work efficiency and stabilizing surface quality.

## Applications / Types of Bond

Bond Type	Grinding Type	Grain Size
KUB75G	Rough grinding	#60~325
UB75G	Medium grinding	#400~2000
UB73G	Finishing grinding	#1200~2500

\* Other grain sizes are also possible (please apply to us)

## ● Example Applications

### Work Material

#### ● Quartz glass

Vertical spindle surface grinder with round table (Sanshin Seiki SPG-750)

Wet (Water solution)

Allowance: 0.3mm Flatness: 5 $\mu$

Surface quality: Microscope (visual inspection)

Wheel speed: 15 m/s Work speed: 1 m/min

Depth of cut: 0.001 mm/s

Wheel: SD 1000 O UB73G 6A2M 350D x 75T x 250H x 5W x 5X

	Hybrix	Conv. Resin #800
Sharpness	Excellent (process as set)	Not completely ground
Surface finish	good	Unsatisfactory

### Work Material

#### ● Soda glass

Vertical spindle surface grinder with round table (Ichikawa Grinder Mfg.)

Wet (Water solution)

Allowance: 0.1mm Flatness: 1 $\mu$  Surface finish : Ra 0.4

Wheel speed: 10 m/s

Rough grinding Depth of cut: 20 $\mu$

Precision grinding Depth of cut: 4 $\mu$

Wheel: SD 1500 P UB73G 6A2M 250D x 60T x 80H x 10W x 10X

	Hybrix	Conv. Resin #1200
Sharpness	Excellent without wheel loading	—
Work quality	Flatness: good Surface finish: good Post processing: good	—
Dressing	Not required	2 times/day
Wheel life	1.2 times longer	—