

**NORTON**

SAINT-GOBAIN®

**WINTER**

TRUING AND DRESSING

**PARADIGM**®

## HOW TO TRUE AND DRESS YOUR PARADIGM DIAMOND WHEELS



ACHIEVE THE FASTEST  
CYCLE TIMES AND  
LOWEST COST PER PART

Use these performance-enhancing  
dressing systems and techniques with  
our new Norton Winter Paradigm wheels.

ONLINE TRUING & DRESSING CAPABILITY LOWER  
TOOLING COST | BETTER EDGE QUALITY

A **PARADIGM SHIFT** IN CUTTING TOOL MANUFACTURING™

The Saint-Gobain logo, featuring a stylized bar chart with red and blue bars above the text "SAINT-GOBAIN".

**SAINT-GOBAIN**

### BEST Truing Method



#### ONLINE TRUING USING A NORTON WINTER MAXTORQ TRUING SYSTEM

To maximize the performance and life of Paradigm wheels, use Norton Winter diamond rolls, in combination with MaxTorq spindles, which are offered in standard and custom-designed systems.

#### ONLINE COUNTER-DIRECTIONAL TRUING

Speed ratio of the diamond roll to be 3X the Paradigm wheel speed in SFPM or M/S True compensation: 0.00005" to 0.0001". Overlap ratio: < 20

Diamond roll to wheel ratio is measured in rotational velocities

True compensation = amount of infeed per pass of the diamond roll

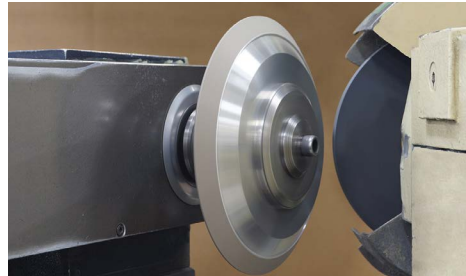
Overlap ratio = (diamond roll contact width x grinding wheel RPM) / diamond roll traverse rate

Additional sizes and specifications of online and offline truing wheels and dressing sticks are available.

For more information:

- Visit: [www.nortonabrasives.com](http://www.nortonabrasives.com)
- Contact your Norton representative
- Or request "The Diamond and cBN Superabrasive Standard Products Catalog" #8068

### BETTER Truing Method



#### OFFLINE UNI-DIRECTIONAL TRUING USING AN ALUMINUM OXIDE GRINDING WHEEL

Use a 38A80-IVBE aluminum oxide vitrified truing wheel, with a truing wheel to Paradigm wheel 3:1 surface speed ratio.

#### OFFLINE TRUING WHEELS

PART #	SIZE*	SPEC.
662529 <b>41048</b>	7 x 1/2 x 1-1/4	38A80-IVBE
662530 <b>43866</b>	8 x 1/2 x 1-1/4	38A80-IVBE

\* Other sizes available



#### ONLINE OR OFFLINE DRESSING USING A NORTON DRESSING STICK

Use an H grade vitrified aluminum oxide stick that is 1-2 grit sizes coarser than your Paradigm wheel.

PART #	PARADIGM DIAMOND WHEEL SPEC.	DRESSING STICK* SPEC. 1" x 1" x 6"
614636 <b>10405</b>	180, 220 Grit Wheels	38A150-H8VBE
614636 <b>10406</b>	320 Grit Wheels	38A220-H8VBE

\* Other sizes available

### GOOD Truing Method



#### ONLINE TRUING USING A NORTON WINTER BRAKE-CONTROLLED TRUING DEVICE

STOCK 4597 BRAKE-CONTROLLED TRUING DEVICE

The 4597 model is engineered for heavier and more frequent truing applications. The adjustable speeds allow for varying conditions (between 1,050 and 1,500 SFPM). It comes complete with a reusable case, two 3" 38A60-M8VBE vitrified wheels, Truing Device Tips book, and a dressing stick.

STOCK 3597 BRAKE-CONTROLLED TRUING DEVICE

(RECOMMENDED FOR WHEELS UP TO 12")

The 3597 model is ideal for light duty use. The pre-set brake speed requires no adjusting. This model includes one 3" 38A60-M8VBE vitrified wheel.

PART #	ITEM
66260195350	4597 Brake Controlled Truing Device
66260135578	3597 Brake Controlled Truing Device

#### REPLACEMENT ONLINE TRUING WHEELS

PART #	PARADIGM DIAMOND WHEEL SPEC.	TRUING WHEEL SPEC. 3" x 1" x 1/2**
662435 <b>29146</b>	180, 220 Grit Wheels	38A80-MVBE
662435 <b>29170</b>	320 Grit Wheels	37C80-HVK

\* Other sizes available

**BEST** – MaxTorq Device

**BETTER** – #4597 Device

**GOOD** – #3597 Device

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NO-RISK TEST

