

Diamond/cBN Lapping Plate

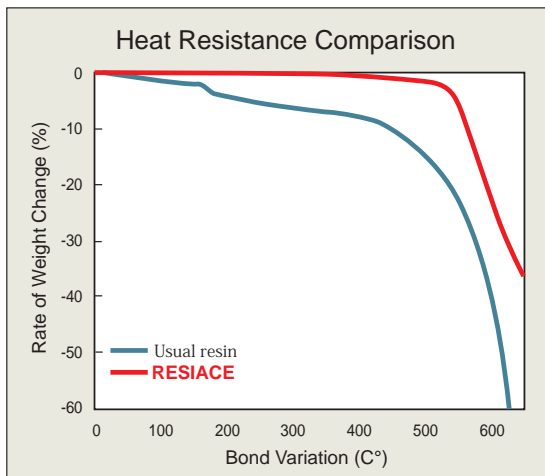
RESIACE

MB Spark was developed to meet the needs of surface quality improvement of elements used in automotive and household appliance in the progress of energy saving and miniaturization. MB Spark changes the world of double disc grinding by improving the trueing interval over a conventional resin bond grinding wheel, in combination with electro-discharge trueing.

Heavy Duty Grinding

Ultimate superheat resin bond

RESIACE exhibits high performance in heavy duty grinding, particularly in cemented carbide or cermet applications. It performs especially well in heat resistant grinding processes without experiencing deformation.



Special Features

- **High Heat Resistance**
Bond does not experience heat deterioration even under severe grinding conditions
- **Superior Grinding**
Highly efficient grinding due to superior ability and exceptional durability
- **High Shape Retention**
No need for shape correction

Usage

- Flute grinding for carbide drill, endmill, and PCD drill
- Chipbreaker grinding for insert
- Other tool grinding (cylindrical grinding, surface grinding, etc.)

Bond Variation

Three types are available, depending on usage and conditions

Bond Strength	Special Features
BRA10	Focus on sharpness
BRA20	Standard
BRA30	Focus on tool life

Data /Water-soluble Coolant

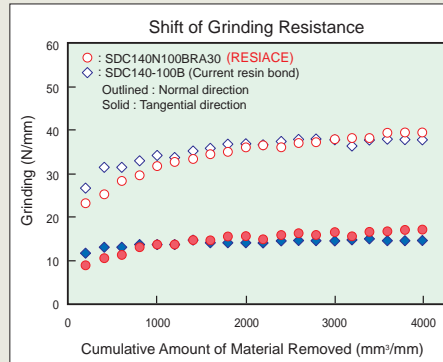
Grinding Test Conditions

Work Material: Tungsten carbide
 Specification: SDC140-100B
 Peripheral Speed: 1600m/min
 Depth of Cut: 2mm
 Feed Rate: 50mm/min
 Coolant: Water soluble

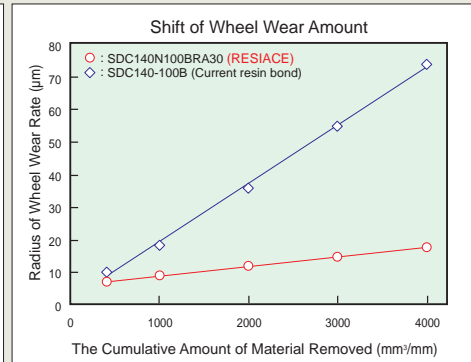
Results

Equivalent grinding ability (grinding resistance) and 6 times tool life (grinding ratio) compared to current resin bond. Significant improvement of interval for shape correction is possible for flute grinding of carbide drill or endmill.

Grinding Ability



Wear Amount



Data /Oil Based Coolant

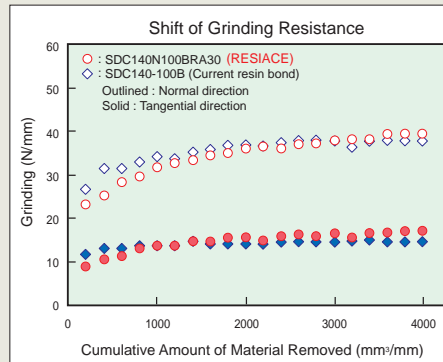
Conditions of Grinding Test

Specification: SDC140-100B
 Peripheral Speed: 1600m/min
 Depth of Cutting: 1mm
 Feed Rate: 30mm/min
 Coolant: Oil based

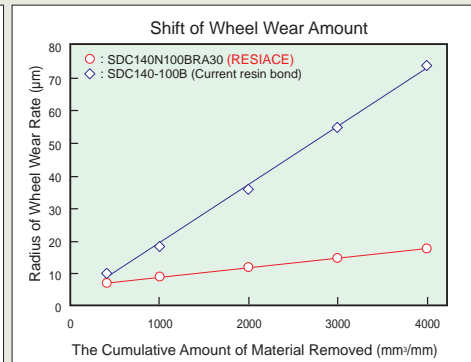
Results

RESIACE achieved significant grinding ratio (about six times) by maintaining superior grinding ability, even in the range where current resin bond shows signs of excessive wear due to heat deterioration. The combination of grinding ability and shape maintenance makes flute grinding of carbide drill or endmill possible.

Grinding Ability



Wear Amount



Process Results

Process: PCB flute grinding
 Evaluation: Interval of shape correction
 Results:

