

Machining of Hollow Glass with Diamond

- Decorative Cutting

Surfacing Plates

- Continuous metal bond plates
- Continuous resin bond plates

Flat Surfacing Plate

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Flat surfacing plates



Machining of Hollow Glass with Diamond

Decorative cutting

Introduction

Formerly done on large diameter wheels with natural abrasive, the decorative cutting of crystal glass and sodic glass is now performed on diamond wheels, which have brought to this industry the technology associated with productivity and profitability.

In practice, the developments in diamond cutting wheels, now high-tech tool, evolve to meet the increasing requirements of modern industry.



The various cutting profiles

The various cutting profiles performed on crystal and soda glass products can be classified according to their cross section (in mm²), their shape and their aspect.

These three parameters will determine:

- the specification of the wheel
- the working sequence(s) or steps
- the form of the wheel.



Surfacing Plates

The ALTIFORT-BOART plates exist in two different types:

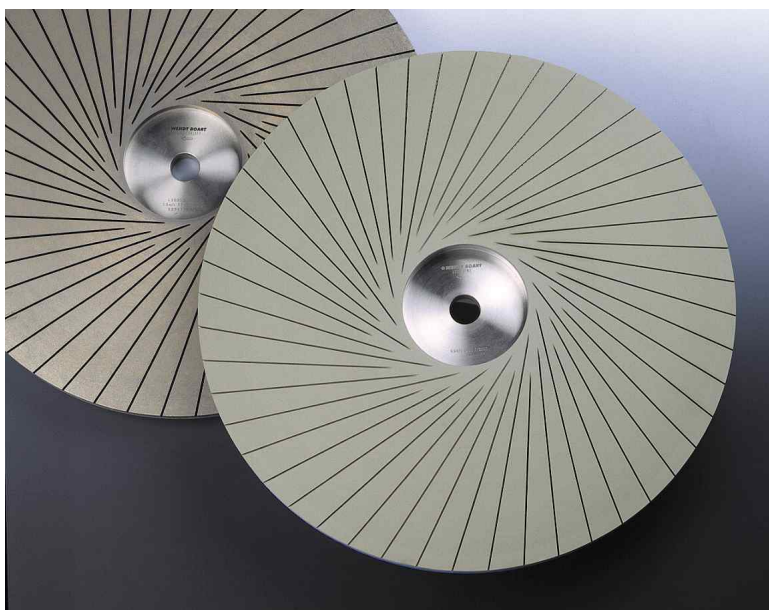
Continuous metal bond plates

They are used in medium roughing and semi-finishing. They often have radial slots that improve the cooling and removal of waste material.



Continuous resin bond plates

They are used in semi-finishing, finishing and super-finishing. They often have slots for the same reasons as above, but also to minimize the aquaplaning effect with fine diamond grits.



ALTIFORT-BOART Form

*30X-D-W-X-Specification-H/T-Type – FEPA L2, 1L2S

* L = metallic bond, K = resin bond

Types of execution

Three types of execution:

Continuous type (1L2): full diamond layer in metallic or resin bond.

Slotted type (1L2S): slotted diamond layer in metallic or resin bond.

Segmented type (1L2S): segments arranged in spirals in a resin bond.

Availability

Execution	Bond	ALTIFORT-BOART Form	FEPA	D	W	X	Recommended Grit
Segmented*	Metal	L30X	1L2S	600	230	4	Super-rough up to semi-rough
Continuous	Metal	L30X	1L2	300-700	120-230	3	Super-rough up to semi-rough
Continuous	Resin	K30X	1L2	300-700	120-230	5	Semi-rough up to super-finishing
Slotted**	Metal	L30X	1L2S	300-700	120-230	3	Super-rough up to semi-rough
Slotted**	Resin	K30X	1L2S	300-700	120-230	5	Semi-rough up to super-finishing

* 2 versions regarding the number of segments: normal density (ND) or high density (HD).

** standard number of slots: 12, 24, 36, 48.

Other executions on request.

Order example

*30X-D-W-X-Specification-H/T-Execution

K30X - 600 - 230 - 5 – finishing – 35/T42 – 48 slots