

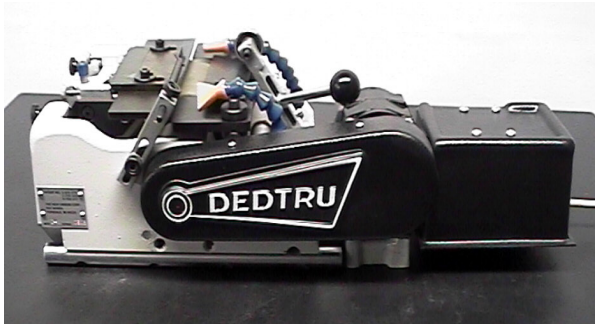


Unison Corporation

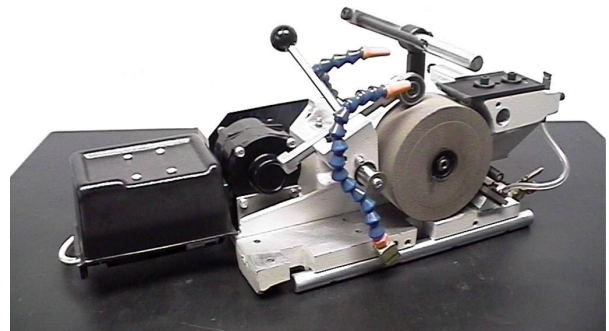
DedTru®

Centerless Grinding Product Line

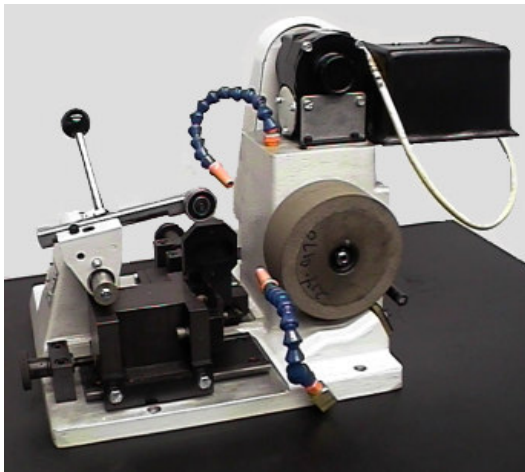
Model C
DedTru Grinding Fixture



Model PGF
Plunge Grind Fixture



Model IGF
Internal Grind Fixture



Model C6
DedTru Grinding Fixture



1601 Wanda Avenue
Ferndale, MI 48220
Phone: (248) 544-9500 Fax: (248) 544-7646
Email: sales@newunison.com Website: www.newunison.com

DedTru® Centerless Grinding Product Line

The prices for New Unison Corporation's DedTru Centerless Grinding product line are presented in the following information. Please contact any member of our Marketing Department to request a detailed quotation for each machine.

All prices are for equipment prepared for domestic shipment and are EXW Ferndale, Michigan, U.S.A. The company reserves the right to change prices as required without prior notification.

DedTru® Systems, 6x18 Grinder

DedTru Centerless Grinding Systems includes the DedTru Basic 6 x 18 Heavy-Duty Grinder with a hole through the column for longer parts; Model C DedTru Unit, dual sine base assembly, 3 hp spindle, coolant system with FilTru Tank Assembly and FilTru Coolant Settling Tank, 1/4" carbide blades for throughfeed (with guides), plunge and infeed work from 1/4" to 1-1/4" diameter, one part stop, one pressure roll assembly, work light and wheel guarding for up to 2" wide wheel. Arranged for 230 or 460 volt (when ordering specify voltage), 3 phase, 60 Hz power supply. For manual operation; maximum part diameter with optional accessories 4". (For diameters to 5" add increased height for grinder, page 9, and 078-0000(page 6), for diameters from .031" to 1/4" (tooling accessories, page 5). Item Number **388-0000**

Shipping Weight and Dimensions: 1345 lbs/46" x 56" x 82" high

DedTru Centerless Grinding System with Model PGF Unit is the same as a Model 388-0000 except it is equipped with a Model PGF DedTru Unit with quick change 5" x 2" regulating roll. This system includes a dual sine base. Maximum part diameter with optional accessories 2-3/4". (For diameters to 5" add increased height for grinder, page 9 and Special Blade Holder and Rest Assembly, page 6) Item Number **384-0000**

Shipping Weight and Dimensions: 1335 lbs/46" x 56" x 82" high

DedTru® Systems, 6x12 Grinder

DedTru Centerless Grinding System built for Tool Room and Job Shops includes the DedTru basic 6 x 12 Grinder with a hole through the column for longer parts, Model C DedTru Unit, sine base, 3 hp spindle, coolant system with FilTru Tank and Filter Assembly, 1/4" blades for throughfeed (with guide), plunge and infeed work from 1/4" to 1-1/4" diameter (from 0.031" to 5" diameter with standard optional tooling and machine options), one part stop, one pressure roll assembly, work light and wheel guarding for up to 2" wide wheel. The system is to be operated by 115 volts, single phase and 230 volts, 3 phase, 60 Hz incoming customer supply lines. Item Number **188-0000**

Shipping Weight and Dimensions: 1200 lbs/45" x 48" x 80" high

DedTru Centerless Grinding System equipped with a Model PGF DedTru Unit with quick change 5" x 2" regulating roll with associated accessories for plunge and infeed grind only. Maximum part diameter with optional accessories is 2-3/4". For diameter to 5" add increased height for grinder and special blade holder and rest plate assembly. Item Number **307-0000**

DedTru® Centerless Units

Model C DedTru Centerless Grinding Unit with 4-1/4" x 4" wide regulating roll for use with customer's grinder. Includes Model C DedTru Unit, DC controller, sine base, 1/4" carbide blades (and guides) for throughfeed, infeed and plunge work for parts ranging from 1/4" to 1-1/4" diameter, part stop, pressure roll, infeed slide assembly, coolant pump and hose. Maximum part diameter is 5" with optional accessories. Item Number **050-0000**

Shipping Weight and Dimensions: 140 lbs/13" x 32" x 13" high

Model C6 DedTru Centerless Grinding Unit with 6" x 6" wide regulating roll for use with customer's grinder. Includes the Model C6 DedTru Unit, DC controller, sine base, 1/4" carbide blades (and guides for throughfeed, infeed and plunge work for parts 1/4" to 1-1/4" diameter, part stop, pressure roll, infeed slide assembly, coolant pump and hose. Maximum part diameter with optional accessories is 4". Item Number **090-0000**

Shipping Weight and Dimensions: 175 lbs/35-3/4" x 15-3/4" x 12-1/2" high

Model PGF DedTru Centerless Grinding Unit with 5" x 2" wide regulating roll for use with customer's grinder. Includes Model PGF DedTru Unit, DC controller, sine base, 1/4" carbide blades for infeed and plunge work for parts 1/4" to 1-1/4" diameter, part stop, pressure roll, infeed slide assembly, coolant pump and hose. Maximum part diameter with optional accessories is 5". Item Number **141-0000**

Shipping Weight and Dimensions: 110 lbs/34" x 24" x 12" high

Model IGF DedTru Internal Grinding Unit includes a 5" x 2" wide regulating roll for use with customer's grinder. Also includes a DC controller, 1/4" carbide blade for ID grinding of parts 1/4" OD to 5" OD, part stop and pressure roll. NOTE: Contact factory for mounting dimensions. Item Number **350-0000**

DedTru® Basic Grinder

DedTru Basic 6 x 18 Grinder ask anyone in our Marketing Department for information or a quote. Item Number **235-0000**

Shipping Weight and Dimensions: 1220 lbs/46" x 56" x 82" high

DedTru Basic 6 x 12 Grinder ask anyone in our Marketing Department for information or a quote. Item Number **100-0000**

Shipping Weight and Dimensions: 1200 lbs/45" x 48" x 80" high

DedTru® CNC Flexible Grinding System

Model 2150 DedTru CNC Flexible Grinding System™ is a three axis CNC versions of our DedTru Centerless Grinders and as a standard feature is equipped with one of the DedTru Centerless Grinding Units.

The Model 2150's are highly precise flexible grinders which allows for precision OD, ID centerless grinding and are used for thrufeed, infeed and secondary operations such as plunge grinding, tapers and profile grinding for cylindrical parts with diameters from .005" (0.127mm) to 5" (127mm).

The Model 2150 CNC Grinders are ideal for prepping blanks used in the manufacture of precision cutting tools.

DedTru® Unit Tooling and Accessory Equipment

The prices in this section covers equipment for the DedTru Unit such as regulating rolls, blades, guides, work supports, etc which may be necessary to grind specific parts or a range of parts. These items are applicable to DedTru Centerless Grinding Systems and DedTru Units. Please refer to the specific descriptive specifications when ordering to assure proper part.

REGULATING ROLLS

Model C

Standard 4" wide with steel core (use after s/n 434)
Item Number 050-0110

Model C6

6" diameter by 6" wide (replacement part)
Item Number 090-6103

Model PGF

4" diameter x 2" wide with adaptor (replacement part for PGF s/n 330 and prior)
Item Number 140-0107

4" diameter x 3" wide with adaptor (replacement part for PGF s/n 330 and prior)
Item Number 140-1749

5" diameter x 2" wide with adaptor (replacement part for PGF s/n 331 and greater)
Item Number 140-1750

5" diameter x 3" wide with adaptor (replacement part for PGF s/n 331 and greater)
Item Number 140-1751

Model PGF Regulating Roll Kit includes a 4" diameter x 3" wide mounted regulating roll, 3" x 1/4" carbide blade, wiper and clamps. Item Number 219-0000

Model PGF Regulating Roll Kit includes a 5" diameter x 3" wide mounted regulating roll, 3" x 1/4" carbide blade, wiper and clamps. Item Number 319-0000

Tool Kit for Changing Model C and C6 Regulating Roll
Item Number 087-0000

Sine Bar Clamps to further secure the sine bar and angle setting blocks in position.
Item Number 085-0000

Sine Base Assembly includes cradle and P/T blocks
Item Number 065-0000

Work Blades – Carbide Tipped

Model C

Size	Thrufeed – 8" Blades	Plunge – 4" Blades
1"	045-0190	045-0189
1/4"	045-0192	045-0191
1/8"	045-0194	045-0193
1/16"	045-0196	045-0195

For diameters below 1/16" use Graphmo Steel 4" long for thrufeed, plunge and infeed:
1/32" Item Number 044-0187

Complete Set of Blades and Guides for part capacity from 1/32" to 2-1/4" diameter consisting of each of the 4" plunge and 8" thrufeed blade sizes (1", 1/4", 1/8" and 1/16") and one 4" x 1/32" Graphmo only plus one each of the guides (1", 3/64", 3/32", 1-16" and 1/32"). Item Number 045-0000

Model C6

Size	Thrufeed – 10" Blades	Plunge – 6" Blades
1"	093-6154	093-6153
1/4"	093-6156	093-6155
1/8"	093-6158	093-6157
1/16"	093-6160	093-6159

For diameters below 1/16" use Graphmo Steel 6" long for thrufeed, plunge and infeed:
1/32" Item Number 093-6161

Complete Set of Blades and Guides for part capacity from 1/32" to 2-1/4" diameter consisting of each of the 6" plunge and 10" thrufeed blade sizes (1", 1/4", 1/8" and 1/16") and one 6" x 1/32" Graphmo only plus one each of the guides (1", 3/64", 3/32", 1-16" and 1/32"). Item Number 210-0000

Model PGF

Size	Plunge – 2” Blades	Infeed –2” Blades
1”	143-0134	
1/4”	143-0135	197-0706
1/8”	143-0136	197-0707
1/16”	143-0137	197-0708

For diameters below 1/16” use Graphmo Steel. 1/32”
1/32” Plunge 143-0133 Infeed 197-0704

Model PGF

Size	Plunge – 3” Blades	Infeed – 3” Blades
1”	143-0157	197-0714
1/4”	143-0156	197-0715
1/8”	143-0155	197-0716
1/16”	143-0154	197-0717

For diameters below 1/16” use Graphmo Steel.
1/32” Plunge 143-0149 Infeed 197-0713

Work Guides used for throughfeed applications

Model C

1”	067-0178	1/16”	067-0176
1/8” (Std)	052-0128	3/64”	067-0175
3/32”	067-0177	1/32”	067-0174

Model C6

1”	093-6144	1/16”	093-6142
1/8” (Std)	090-6120	3/64”	093-6141
3/32”	093-6143	1/32”	093-6140

Guide Risers two required

1”	060-0171	1/2”	060-0173
1/8” (Std)	060-0172	1/4”	052-0127

DedTru® Unit Tooling and Accessory Equipment For Larger Diameter Work

Model C

Special Work Blade Holder and Rest Assembly allows through feed and plunge work to be performed on parts up to 4” diameter with 1/4” work blade and to 5” diameter with optional 1” blade. For these larger diameters check grinder to be sure proper wheel height is available. **Item Number 078-0000**

Model C6

Special Work Blade Holder and Rest Assembly allows through feed and plunge work to be performed on parts up to 3” diameter with 1/4” work blade and to 5” diameter with optional 1” blade. For these larger diameters check grinder to be sure proper wheel height is available. **Item Number 092-0000**

Model PGF

Special Work Blade Holder and Rest Assembly (3" regulating roll) allows plunge work to be performed on parts up to 5" diameter with optional 1" blade. For these larger diameters check grinder to be sure proper wheel height is available. **Item Number** 230-0000

Work Supports

Rest Plates are used for throughfeed applications to support work as it approaches and leaves the regulating roll (standard equipment).

Item Numbers

052-0000 (Model C)

090-6125 (Model C6)

Steady Rest Assembly is for grinding small diameter steps that are relatively long in length. The unit is of swivel construction with adjustable counterweight to control the supporting pressure.

Item Numbers

075-0000 (Model C)

243-0000 (Model C6)

Extension Arm and Roller Support Assembly designed to facilitate throughfeed and plunge of grinding longer parts. Also add Dual Roll Feed Assist option 068-0000 for Model C, 096-0000 for Model C6.

Item Numbers

081-0000 (Model C)

098-0000 (Model C6)

Outboard Roller Support for infeed grinding of longer parts.

Item Number

174-0000

Work Pressure Rolls

These units are for plunge grinding steps, forms, grooves or other secondary operations on either the OD or ID. They consist of one or more rollers that are spring loaded against and rolling on the part. They force the part into contact with the work blade and the regulating roll. Their attitude is adjustable to facilitate feeding the part against the end stop either in or out, according to the application requirements. For soft materials, to prevent marking, the nylon cover options should be ordered.

Pressure Roll Assembly supplied with one 1-1/4" diameter roll and one pressure arm which can be used for parts greater than 1/8" diameter. This part is furnished as standard equipment with machine.

Item Numbers

056-0000 (Model C & C6)

300-0387 (Model C & C6) complete with nylon cover (for use with parts of soft material)

378-0000 (Model PGF)

300-0396 (Model PGF) Complete with nylon cover (for use with parts of soft material)

Double Pressure Roll Assembly supplied with two rolls, 1-1/4" diameter.

Item Numbers

069-0000 (Model C, C6, PGF)

300-0156 (Model C & C6) Complete with arm to facilitate quick change over

300-0161 (Model PGF) Complete with arm to facilitate quick change over

300-0388 (Model C & C6) Complete with arm and nylon covers

300-0397 (Model PGF) Complete with arm and nylon covers

Small Pressure Roll Assembly supplied with one roll, 1/2" diameter used for parts smaller than 1/8"

Item Numbers

070-0000 (Model C, C6, PGF)

300-0157 (Model C & C6) Complete with arm to facilitate quick change over

300-0162 (Model PGF) Complete with arm to facilitate quick change over

300-0389 (Model C & C6) Complete with arm and nylon covers

300-0398 (Model PGF) Complete with arm and nylon covers

Small Double Pressure Roll Assembly supplied with two rolls, 1/2" diameter.

Item Numbers

071-0000 (Model C, C6, PGF)
300-0158 (Model C & C6) Complete with arm to facilitate quick change over
300-0163 (Model PGF) Complete with arm to facilitate quick change over
300-0390 (Model C & C6) Complete with arm and nylon covers
300-0399 (Model PGF) Complete with arm and nylon covers

Horseshoe Double Pressure Roll Assembly supplied with two 1/2" diameter rolls. This assembly is applied when it is desirable to capture the part at both ends and grind in the center. The rolls can be individually canted to push (for compression) or to pull so that very fine parts can be ground under tension.

Item Numbers

072-0000 (Model C & PGF)
300-0391 (Complete with nylon covers)
222-0000 (Model C6) 00
300-0394 (Complete with nylon covers)

Pressure Roll Arm for use with all pressure rolls to facilitate quick change-over.

Item Numbers

056-0129 (Model C & C6)
078-0289 (Model PGF)

Nylon Pressure Roll Covers for use with parts of soft material

Item Numbers

200-0207 for standard rolls, 1-1/4" diameter
200-0208 for small rolls, 1/2" diameter

Special Pressure Rolls are available for specific applications such as narrow rolls for use between spaced wheel etc.

Dual Roller Feed Assist for throughfeed of longer parts up to 1-3/4" diameter. Requires extension arm and roller support assembly (see work supports).

Item Numbers

068-0000 (Model C)
300-0392 Complete with nylon covers
096-0000 (Model C6)
300-0393 Complete with nylon covers

DedTru® Unit Tooling and Accessory Equipment

Infeed Slide Assembly used for parts, which come to the machine with a head or other projection that prevents feed through grinding. The assembly replaces the pressure roll and its use allows the part to be ground round and true, in an infeed setup, regardless of its condition when it comes to the machine.

Item Numbers

074-0000 (Model C, PGF)
374-0000 (Model C6)

Work Stops are supplied to locate the part end or shoulder to provide dimensional reference point.

Part Stop Carbide with 1/16" spherical radius brazed to cylindrical rod which is furnished standard with machine).

Item Numbers

048-0157 (Model C)
090-6130 (Model C6, PGF)

Roller End Stop is used with parts, which have center hole, or other condition that prevents using a stop pin on-center. The part is fed into the stop by pressure rolls. The stop provides the reference point from which the ground surfaces will be located.

Item Numbers

200-0205 (Model C)
093-6166 (Model C6, PGF)

Magnetic Ball Stop Assembly is a magnetic assembly that captures any steel ball to locate the part end. This option is used when a center hole, etc. prevents the use of an end stop at part center.

Item Numbers

066-0000 (Model C)

099-0000 (Model C6, PGF)

0.03" Diameter End Stop is a stop pin

Item Number

200-0297 (Model C)

0.06" Diameter End Stop is a stop pin

Item Number

200-0298 (Model C)

Work Adaptors

Collet Adaptor for 5C Collets grips parts to facilitate grinding steps (requires 1" work blade). Overall length is 5-3/16" body, 2.00" diameter and 4.25" long. Range of sizes are 1-1/16" to 1-1/16" in 1/64" steps. Supplied less collets.

Item Number

083-0000 (Model c, C6, PGF)

Double Ended Collet Adaptor grips the parts on both ends for the grinding of steps with more accuracy. Useful on many applications. (requires 1" work blade) Overall length is 4-1/4", body 1.375" diameter and 3" long. Range of sizes are 3/16" to 1/2" each end in 1/64" steps. Collets are actuated by a hex nut. Collets are Universal 90500 series. Supplied less collet.

Item Number

084-0000 (Model C, C6, PGF)

Collet Adaptor for 3AT Collets

Item Number

082-0000

Coolant Accessories and Miscellaneous

FilTru Tank and Filter Assembly with an 15 gallon capacity which includes one roll of filter paper. Standard on all complete DedTru Systems. *

Item Number

079-0000

FilTru Coolant Settling Tank with an 18 gallon capacity. This is standard on all complete systems equipped with a Basic 6 x 18 Grinders. *

Item Number

080-0000

Splash Pan - you must specify make & model of your surface grinder *

Price provided upon request.

Splash Pan Guard Assembly – Three piece guard for Splash Pan (does not include splash pan)*

Item Number

116-0000

Filter Paper 21" x 50 yards

Item Numbers

079-0306 one roll (minimum shipment, 2 rolls)

300-1308 Case of 10 rolls

Heavy Duty Coolant Pump Kit (340 GPH in lieu of standard 170 Gph) If ordered with Model C or PGF Units includes heavy duty hose valve.

Item Numbers

232-0000 (when ordered with Model C or PGF)

091-6429 (pump only)
Standard Coolant Pump 170 GPH (pump only)
Item Number
060-0426

Drain Hose (4 foot section)
Item Number
116-1412

Unilube Oil
Item Number
124-1479 (per gallon)

Wheel Puller Wrench takes adaptor from spindle
Item Number
025-1255

Spanner Wrench tightens wheel on adaptor
Item Number
060A-0400

* These items required when DedTru Units are purchased separately for mounting to existing surface grinders.

DedTru Grinding Machine Options

The prices listed in this section covers machine modifications or accessories equipment which will increase the degree of automation, provides improved operating characteristics in certain respects or otherwise provide necessary features for a specific application environment.

These prices are applicable (unless otherwise noted) when options are purchased with DedTru Centerless Grinding Systems and DedTru Basic Grinding machines and in some cases to other makes of grinding machines.

Some of the DedTru Systems include one or more of these options as standard equipment. Please refer to the specific descriptive specifications to assure no duplication when ordering.

Increased Height DedTru Grinder basic grinder is supplied with 3" riser to increase spindle's maximum height. Required for larger parts. Available for all DedTru Centerless Grinding Product Line (except units). Add "R" to model number (i.e. xxxRxxxx).
XxxRxxxx for increased spindle heights

Heavy Duty 2 hp, 1800 rpm Spindle to accommodate 14" wheels in lieu of standard 3600 rpm spindle. Includes spindle nut, woodruff nose key and 12-7/8" long steel barrel with heavy steel flange. (For 6 x 18 grinders only and requires option 288R-0000).
Item Number
100-2412 (in lieu of standard)

Precision Spindle 3 hp, 3600 rpm for 7" and 8" grinding wheels
Item Number
100-1404

Fine Downfeed Attachment 0.001" per turn (0.0001" graduation)
Item Number
300-0339

Metric Fine Downfeed Attachment 1.000mm per turn (0.002mm per graduation). Requires metric screw option (105-0425)
Item Numbers
300-0340

DedTru Grinding Machine Options

Metric Screws and Sliprings in lieu of standard
Item Number

105-0425

Oscillating Crossfeed Mechanism for improved finish and better control of wheel wear.

Item Numbers

102-0000

1102-0000 (Metric)

Automatic Longitudinal Feed Cycle provides rapid approach to work, slow down to feedrate, feed to positive stop, dwell for preset time and automatic rapid carriage return. Slow down position, feedrate, positive stop and dwell time are adjustable. Includes limit switch which gives you start and stop control of regulating wheel.

Item Numbers

389-0000 (6 x 18 grinders)

388-0000 (6 x 12 grinders)

Automatic Vertical Wheel Feed Cycle provides rapid approach to work, slow down to feedrate, feed to positive stop, dwell for preset time and automatic rapid wheel return. Slow down position, feedrate, positive stop and dwell time are adjustable.

Item Numbers

519-6 (6 x 18 grinder)

1519-5 (Metric, 6 x 18 grinder)

Limit Switch Control Assembly starts regulating roll at the beginning of operation and stops the roll at the end of the operation. (Not required if Automatic Feed Cycle is ordered)

Item Number

* 077-0000

Lubrication Systems is for extreme tolerances and finish. This option isolates the pump from the machine and cools oil to coolant temperatures.

Item Number

103-0000

Digital Readout is an 8-digit display, vertical and cross motion, with .00005" resolution.

Item Number

4322-0000

Non-standard Electrical Equipment..... Refer to Company

Wheel Guard Extension is supplied in 1" increments for the varying widths. The standard equipment includes one wheel extension to accommodate a 2" wheel. For wider wheels order the necessary number of 1" increments to accommodate the wheel width.

Item Number

117-1

TilTru Magnetic Chuck 6" x 10" is tilting and fits DedTru Model C sine base. Close pole permanent ceramic magnet and comes with two PT blocks. This chuck is instantly interchangeable with the DedTru Model C and PGF Units for conventional and angular precision surface grinding. This TilTru Magnetic Chuck is for use on our 6 x 12 grinders.

Item Number

107-0000

TilTru Magnetic Chuck 6" x 16" is tilting and fits DedTru Model C sine base. Close pole permanent ceramic magnet and comes with two PT blocks. This chuck is instantly interchangeable with the DedTru Model C and PGF Units for conventional and angular precision surface grinding. This TilTru Magnetic Chuck is for use on our 6 x 18 grinders.

Item Numbers

108-0000

108R-0000 (This model must be ordered for surface work with riser-equipped grinders)

Spindle Tooling (OD Work)

Grinding Wheels for customer's grinder (other than Unison's DedTru Grinder)

Starter Wheel Selection #1 is 7" diameter, 1-1/4" hole. All wheels are over 1/2" thick and are counterbored 4" diameter to half thickness (but not less than 1/2").

Item Number

204-0000

Part No.	Width	Specification	Application
119-8468	1/2"	16A120L9VG	Plunge-Hard Material Forms
119-2424	1/2"	39C46K6B	Dressing Colmonoy Work Rest Blades Only
119-2425	3/4"	38A120J8V	Thrufeed Hard Material
119-2427	1/4"	38A400-094	Plunge Fine Finish Small Diameters
119-2432	1/2"	16A220Q10VG	HSS-General Purpose
119-2433	3/4"	16A220Q10VG	HSS-General Purpose
119-2434	3/4"	39C120J8B	Soft Stainless Steel
119-2435	1/2"	23A60-M5VBE22TR	General Purpose – Hard & Soft
119-2437	3/4"	23A60-M5VBE22TR	General Purpose – Hard & Soft

Grinding Wheels for Unison DedTru Grinders or other makes which accept 8" diameter wheels.

Starter Wheel Selection #2 is 7" and 8" diameter with 1-1/4". All wheels over 1/2" thick are counterbored 4" diameter to half wheel thickness (but not less than 1/2").

Item Number

205-0000

Part No.	Width	Specification	Application
119-8467	1/2"	16A120L9VG	Plunge-Hard Material Forms
119-2424	1/2"	39C46K6B	Dressing Colmonoy Work Rest Blades Only
119-2426	3/4"	38A120J8V	Thrufeed- Hard Material
119-2427	1/4"	38A400-09V	Plunge Fine Finish-Small Diameters
119-2432	1/2"	16A220Q10VG	HSS- General Purpose
119-2433	3/4"	16A220Q10VG	HSS-General Purpose
119-2462	3/4"	37C80MVK	Soft Stainless Steel
300-1251	2"	38A120-J8V	Mounted & Balanced-Hard Material
119-2436	1/2"	23A60-M5VBE22TR	General Purpose-Hard & Soft
119-2437	3/4"	23A60-M5VBE	General Purpose-Hard & Soft

Wheel Selection #3 is 7" diameter, 1-1/4" hole. All wheels are counterbored 4" diameter to half wheel thickness (but not less than 1/2"). Wheels are mounted and balanced on hardened ground adaptors with DedTru balancing washers. They are mounted and counterbored side facing away from operator to minimize overhand. Wheel guard extensions are supplied in 1" increments. One extension is furnished with the basic machine to accommodate a 2" wide wheel. A second extension is provided in this option that will allow the use of the 3" wide wheel, which is also included.

Part No.	Width	Specification
300-1252	2"	38A80K8V
300-1253	2"	16A120J9VG
300-1255	3"	38A80K8V

Wheel Adaptors 1-1/4", 16LH hardened and ground adaptors for precision mounting of wheels to spindle.

Wheel Width (thickness)

Wheel Width (thickness)

Item Numbers

119-1428	1/2"	119-1430	1"
119-1434	1/2" Reversible	119-1477	1-1/2"
119-1435	1/2" Ext. Type	119-1431	2" (1-1/2" of thread)
119-1429	3/4"	119-1432	3" (1-1/2" of thread)

DedTru Grinding Machine Options And Miscellaneous

Wheel Gear Nut Set includes nut, washer and wrench for DedTru Grinders

Item Numbers

1127-0000 1-1/4" - 16LH

2127-0000 1-1/4" - 16 RH

3127-0000 1-1/4" - 18 LH

Wheel Balancing Washer

Item Number

122-0000

Standard Wheel Guard Assembly for up to 8" diameter

Item Number

114-1241

Wheel Guard for use with 12" to 14" diameter wheels for 6 x 18 grinders only.

Item Number

114-0000 (for 12" diameter wheels)

For 14" Diameter Wheels..... Refer to Company

ID Spindle

Speedgrind ID Spindle Attachment complete with 3/32, 1/8 Collect Bushing, 3/16, 1/4 Collet (spindle mounted, 1/4 x 2 Quill (mandrel) 3/8 x 1-5/8 (mandrel short), 3/8 x 2.00 Quill (mandrel long), two Wrenches 3/8 & 1/2, Wood Carrying Case. Developed for fast changeover from OD setup. Ideal for toolroom, short-lot job shop. The unit attaches to the machine spindle, is belt driven by the spindle at a speed of 18,000 rpm and utilizes transverse (cross slide) for work feed.

Item Numbers

207-0000

207-0456 3/32" Bushing

207-0458 3/16" Collet

207-0465 1/8" Bushing

207-0480 1/4" Collet

Quills for 1/4" ID Wheel

207-0459

Quills for 3/8" ID Wheel

207-0460 (long)

207-0461 (short)

Belt for ID Spindle

207-0463

Variable Frequency, Speed AC Motor Driven Spindle is liquid cooled, 1.7 hp, 20,000 – 66,000 rpm for 230 volts, 50 or 60 hz. Supplied with 1/4" diameter collet suitable for maximum wheel diameter of 1.25" and equipped with bracket for mounting parallel to longitudinal.

Item Number

9921-1

Variable Frequency, Variable Speed AC Motor Driven Spindle is liquid cooled, 0.25 hp, 60,000 – 100,000 rpm for 230 volts, 50 or 60 hz. Supplied with 1/8" diameter collet suitable for maximum wheel diameter of 5/16" and equipped with bracket for mounting parallel to longitudinal.

Item Number

992-1

Dressing Equipment

Kooldress Diamond Dressing Tool this triangular ½ carat impregnated, metal bonded diamond dressing tool is used to dress the face and both sides of the wheel. It can dress corners to 0.002” radius efficiently. Dresser is designed to force coolant at high velocity directly to the point of wheel and dresser contact. It eliminates wheel variations that result from uneven cooling of the diamond when conventional flood coolant procedures are used.

Item Number

200-1022 each

300-1307 for package of three

Dressing Equipment

Kooldress Dresser, with Compensation this straight dresser is designed for manual dressing and truing procedures while providing automatic compensation for wheel size. It incorporates the Kooldress Diamond Dressing Tool (200-1022). This dresser is designed to minimize the time dress. The dresser mounts on the DedTru Unit. It has provisions for locating the diamond to the same height as the work being performed. A coarse adjustment is provided for quickly locating the approximate height of the diamond nib and a fine differential screw adjustment is supplied for the precise final position. After the dressing tool is located at the proper height, the table is moved longitudinally to bring the dresser to the wheel. The wheel is lowered to the desired amount and the cross motion is then operated to dress.

Item Number

242-0000 (Model C Unit)

Adaptors are available for use with Model C6 and PGF Units.

Work Blade Re-Grind Wheel a diamond wheel, mounted and dressed on an adaptor for maintaining wear surface on carbide tipped work blades.

Item Numbers

200-1076M

Regulating Roll Dresser a diamond wheel is mounted and balanced on an adaptor for use on machine spindle (for Model C, C6 and PGF DedTru Units)

Item Numbers

200-1077

200-1077B for use with riser equipped machines

Contour Dressing

Radial Tangent Dresser manually operates with concave radii adjustable from 0 to 4 inches, convex from 0 to 2-1/4 inches. (Larger radii available with optional dovetail extension). Price does not include dressing diamond.

Item Number

300-0150

Dresser Support Plate required with ID and Plunge Grind Fixture to support Radius Tangent Dresser.

Item Number

142-0000