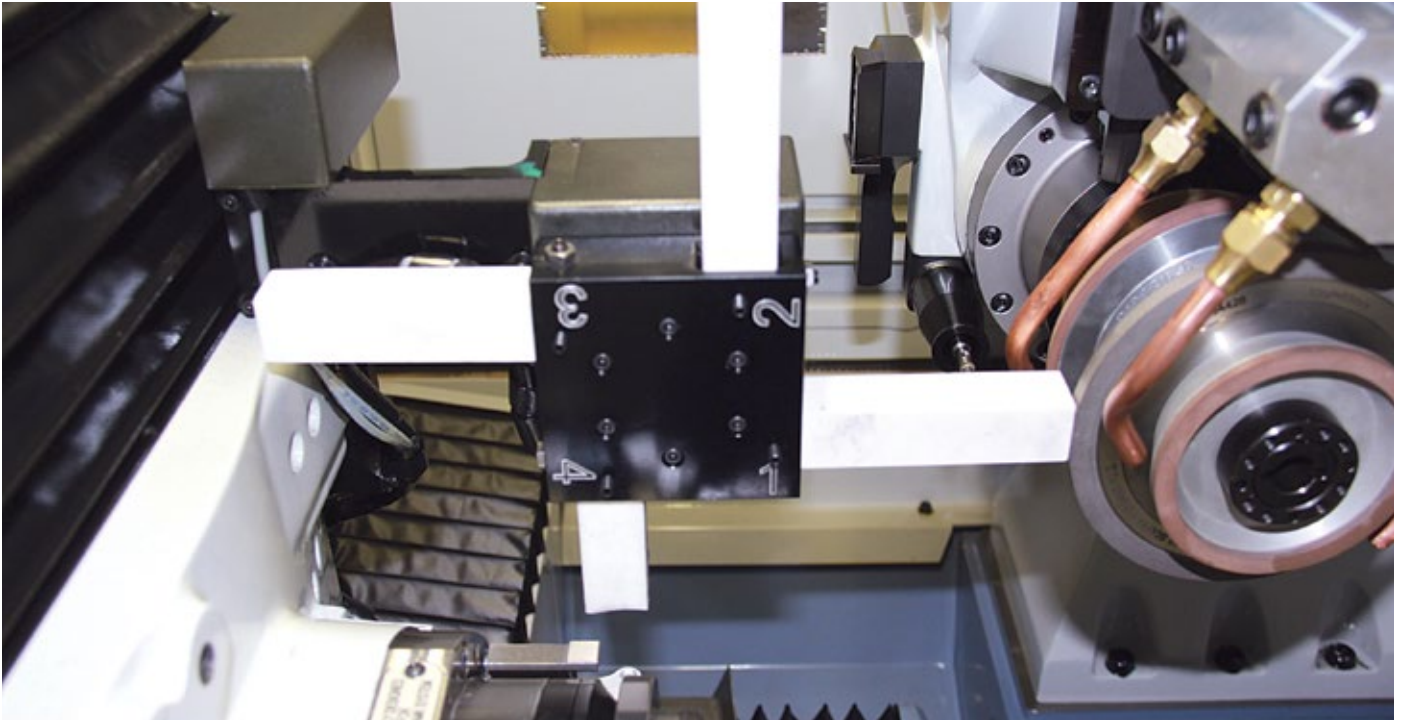


Auto-Stick

Automatic Wheel Conditioning System



ANCA have released an automated wheel-conditioning system for the MX tool grinder range.

The Auto-Stick system is used for in-between cycle conditioning (sticking) of resin bonded CBN and diamond grinding wheels. Auto-Stick is available in single and 4-station versions.

Save valuable time and increase operator safety by no longer having to perform this important task manually.

Regular sticking of grinding wheels will ensure maximum results from Diamond and CBN wheels.

When continually grinding, wheels become glazed, or loaded. Auto-Stick clears away small amounts of the resin bond in the wheel.

The sticking process exposes the diamond and removes chips (swarf) embedded in the wheel so the wheel cuts better.

A well-conditioned wheel grinds with lower grinding pressure. It will produce more parts in less time, and will LAST LONGER.

However, when wheel conditioning is not performed, a wheel can become loaded (with carbide or high speed steel chips). It will then grind with greater grinding pressure and have a lower grinding ratio.

The Grinding Ratio is the ratio of the volume of ground material removed from the workpiece, to the volume removed from the grinding wheel.

The Auto-Stick system provides automated in-between cycle sticking of grinding wheels which:

- Reduces tool burn and wheel glazing
- Improves feed rates, cycle times and life expectancy of the wheels
- Enables longer unmanned production runs

Wheel conditioning is accessed in the ANCA ToolRoom software under DRESS WHEEL.

In the software, the operator can set up the following operations for Auto-Stick:

- Wheel profile
- Wheel speed
- Frequency of sticking
- Depth of sticking via plunge/wipe
- Compensation for wheel wear
- Selection of wheel surface

The Auto-Stick system is set up in the software so the least amount of stick material is used.

Auto-Stick uses a rotary assembly that is pneumatically actuated. The holder on Auto-Stick rotates to hold the selected white-stick against the grinding wheel.

The Auto-Stick is available in four and single station versions with the following dimensions:

25mm x 25mm (1" x 1")

25mm x 20mm (1" x ¾")

Using Auto-Stick, any of the wheels mounted on a wheel pack can be conditioned quickly, easily and automatically.

Auto-Stick ensures greater productivity and increased profits when grinding cutting tools.

