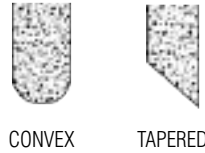


## Cluster Tools

Norton Cluster tools are designed specifically for straight face dressing of large diameter, coarse grit grinding wheels on single or double disc, centerless, or surface grinders.

Wheel Forms Dressed by These Tools

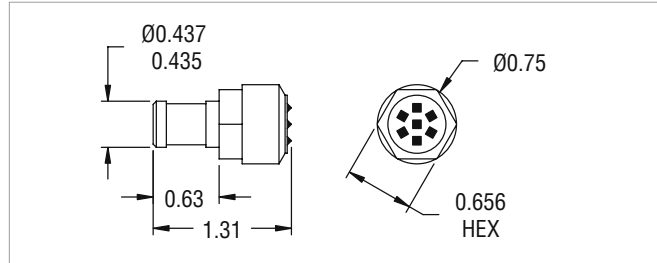


### Multi-Point Cluster Tools

Multi-Point Cluster tools are typically used for straight face dressing on disc and centerless operations. For greatest efficiency, these tools should be mounted at a 15° angle so that three diamonds are in contact with the wheel face at all times. The tool should be rotated at frequent intervals. Not resettable.

TIER: BETTER				
DIAMONDS ON FACE	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	NON-RESETTABLE PART #
<b>Stock Multi-Point Cluster Tools</b>				
7	7/16"	1-5/16"	NC7K7	66260195206

Standard Package = 1 Tool

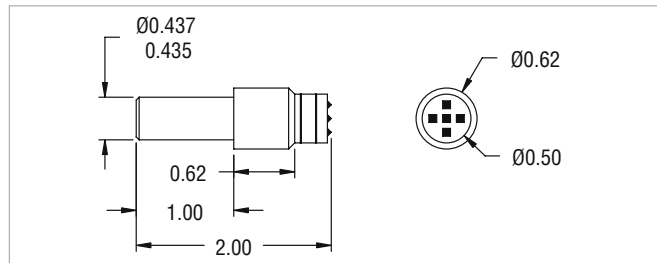


### Dia-Pak Tools

Dia-Pak tools are primarily used in straight face disc grinding, but are extremely versatile and may also be used in centerless and surface operations. Designed for maximum economy, three layers of diamond are carefully arranged so that a new layer is exposed before the previous layer is completely worn away. Not resettable.

TIER: BETTER					
FOR WHEEL DIAMETERS	DIAMONDS PER LAYER	SHANK DIAMETER	TOOL LENGTH	PRODUCT #	NON-RESETTABLE PART #
<b>Stock Dia-Pak Tools</b>					
Up to 14"	5-4-5	7/16"	2"	DP20	66260195200
Up to 20"	7-6-7	7/16"	2"	DP30	66260195201
Any	7-6-7	7/16"	2"	DP35	66260195202

Standard Package = 1 Tool



## TECH TIP

Cluster and Dia-Pak Tools – Straight face dressing of hard / coarse wheels:

Tool should approach the wheel at a 15° angle and be rotated periodically to keep three diamonds in contact with the wheel at all times.

Tools can also be used at a 90° to the wheel face.

Multi-Point Cluster tools should be rotated at frequent intervals.

Infeed per pass should not exceed .0015" (.001" with ceramic – Norton SG, Quantum, Targa TG, etc. – wheels).

Use coolant whenever possible.

These tools permit a faster traverse rate providing a freer cutting wheel than when dressed by a conventional single-point tool.