

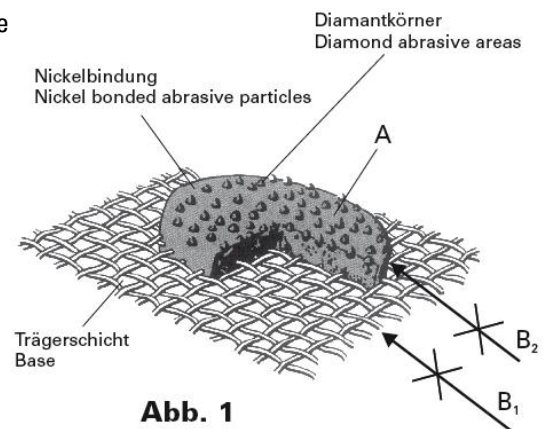
Instructions for Use of Diamond Abrasive Belts

With this diamond abrasive belt, you have purchased a valuable tool.
In order to achieve maximum usage, the following instructions should be followed.

Construction of belt (Fig. 1)

On an infinitely welded, robust fabric base, there are regularly arranged areas of nickel bonded abrasive particles. As these particles are arranged vertically to the belt surface, grinding should only be done on the surface and never at the edge of the belt. (A)

Lateral strain to the edge of the belt (B1) and to the abrasive areas (B2) must be avoided at all times!



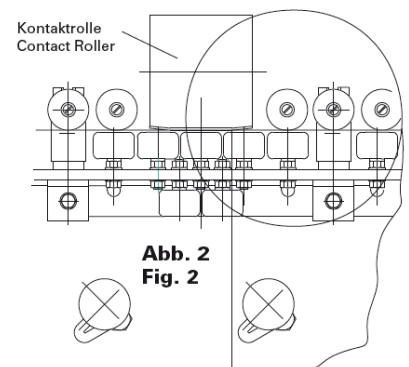
**Abb. 1
Fig. 1**

Grinding Machine - Contact Roller

Measures to avoid above mentioned, unwanted strains are:

- # Use specially shaped contact roller for the belt edges (Fig. 2a)*
- # Do not adjust depth too large to avoid damage of the belt edges (Fig. 2b)
- # Guiding rolls for glass must be adjusted precisely
- # Grinding without guidance of glass will lead to damaged belt edges.

* The contact roller is part of the standard equipment of all Bohle belt glass grinding machines.

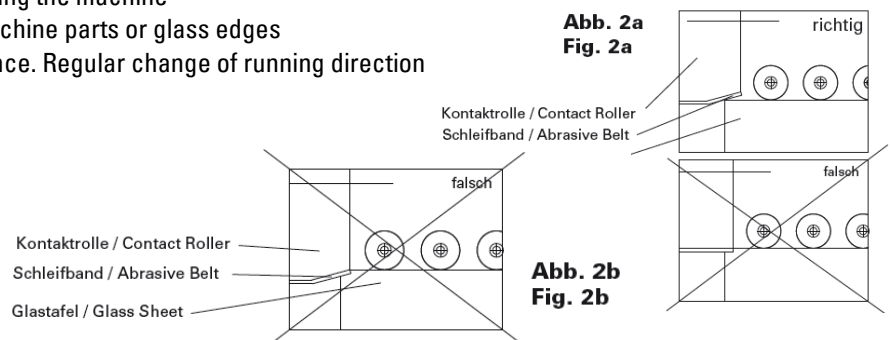


**Abb. 2
Fig. 2**

Usage of Belt

Attention!

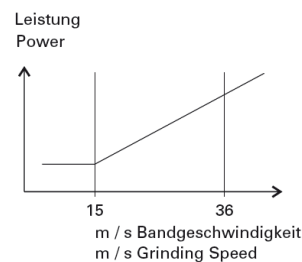
- # Ensure correct position of belt before starting the machine
- # Make sure belt edges do not touch any machine parts or glass edges
- # Running direction of belt makes no difference. Regular change of running direction will guarantee even wear and long life span
- # Do not fold diamond belts, suitable belt holders should be used for storage.



**Abb. 2b
Fig. 2b**

Grinding speed

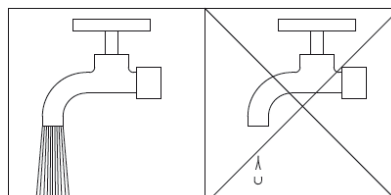
High grinding speed (more than 11 m/s) results in higher efficiency and longer life span.



Cooling

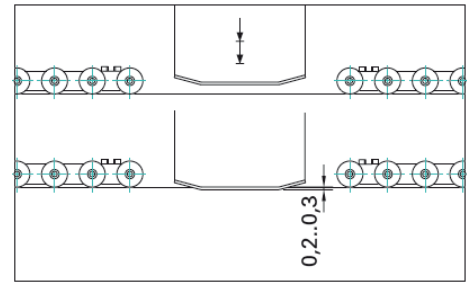
Never grind without cooling!

Higher grinding speeds require more cooling.
Cooling must be effected directly on the grinding spot!



Grinding

1. Move contact roller backwards slightly
2. Position glass sheet to the buffer stops and in front of the contact roller
3. Make contact between glass sheet and running grinding belt. Remove glass sheet slightly and adjust depth to approx. 0,2 mm - 0,3 mm
4. Move glass sheet to and fro to grind. The end of the glass sheet should be moved no further than to the middle of the contact roller



Choice of grinding belt

- # Diamond belts produce a grinding surface which is comparable to a two times coarser silicium carbide belt (i.e. a diamond belt with grit 200 corresponds to a silicium carbide belt with grit 150)
- # Intermediate grit sizes are not necessary when grinding longer with the following grit size. This promotes time saving by skipping one grinding step
- # Use high grinding speed for polishing with cork belts. Before polishing use diamond belt with grit 800 (corresponds to silicium carbide belt with grit 400)

Soak cork polishing belt for at least 1/2 hour in water before use!