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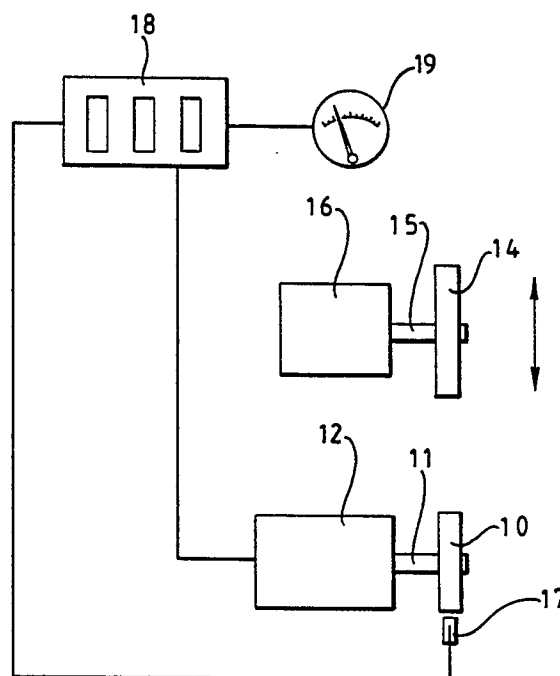
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08.03.89 Bulletin 89/10(71) Applicant: **UNICORN INDUSTRIES PLC**
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Cheltenham GL50 1RQ Gloucestershire(GB)(54) **Improvements in or relating to the dressing of grinding wheels.**

(57) In a method of dressing a grinding wheel 14 to form thereon a peripheral surface of a required cross-sectional profile, the grinding wheel is rotated at a predetermined speed, and rotated about a parallel axis is a dressing wheel (10) having a hard peripheral forming surface the cross-sectional profile of which is the complementary inverse of said required cross-section profile. The peripheral surface of the grinding wheel 14 is brought into pressing engagement with the peripheral surface of the dressing wheel 10, and while maintaining the pressing engagement the speed of rotation of the dressing wheel is controlled in a manner to provide a difference in speed between the engaging peripheral surfaces. The speed of rotation may be controlled by direct control of an electric servo-motor 12 driving the dressing wheel 10, or by controlled braking of the dressing wheel. For a given composition of grinding wheel and dressing wheel the surface characteristics of the finished wheel may thus be determined in a predictable fashion by pre-setting an appropriate predetermined speed of rotation for the dressing wheel.

**FIG 1****EP 0 255 267 A3**



DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	EP-A-0 083 672 (E.WINTER) * Claims 1,22,14 * ---	1,3,5,6 ,11,17	B 24 B 53/00 B 24 B 53/14
X	EP-A-0 048 356 (E.WINTER) * Page 7; claims 1-3 * ---	1,2,4, 11,17	
A	US-A-2 787 095 (N.M.LOVETT) * Column 2, lines 36-48; figure 2 * ---	8,12,13	
A	US-A-2 528 621 (C.E.SWEETSER) * Column 3, line 20 - column 4, line 26; figures 3,4 * ---	8,12	
A	US-A-4 222 362 (KAISER) ---		
A	FR-A-2 227 091 (E.WINTER) -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 24 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 14-12-1988	Examiner ESCHBACH D.P.M.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			