

For Repairing Welding Tips

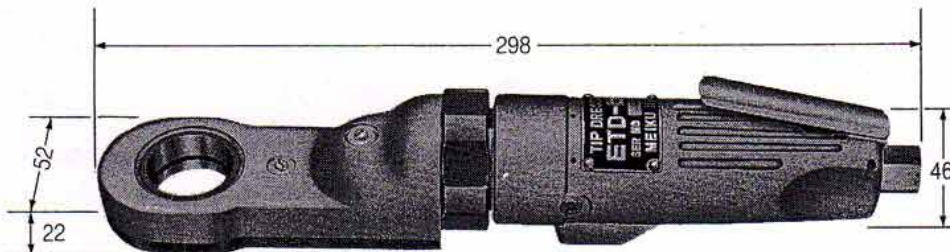
TIP DRESSER from Meiku

- ★ *Small, light and easy to handle*
- ★ *Quick and accurate work*
- ★ *Low air consumption*
- ★ *Easy to change cutter and cutter case*



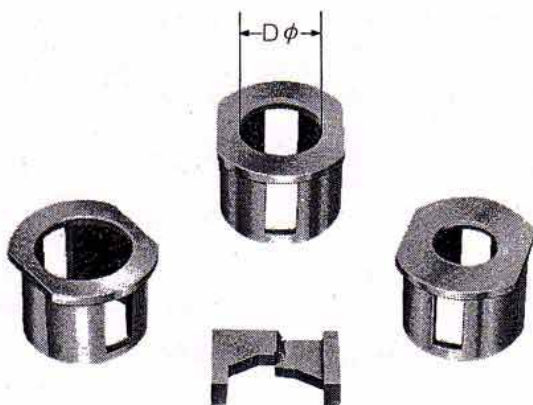
ETD-18F

Tip size	8 ~ 18 mm
No-load RPM	1,300 r.p.m.
Weight	1.65 kg



ETD-25F

Tip size	19 ~ 25 mm
No-load RPM	1,100 r.p.m.
Weight	1.68 kg



Cutter Cases and Cutter

Types of Cutter Cases

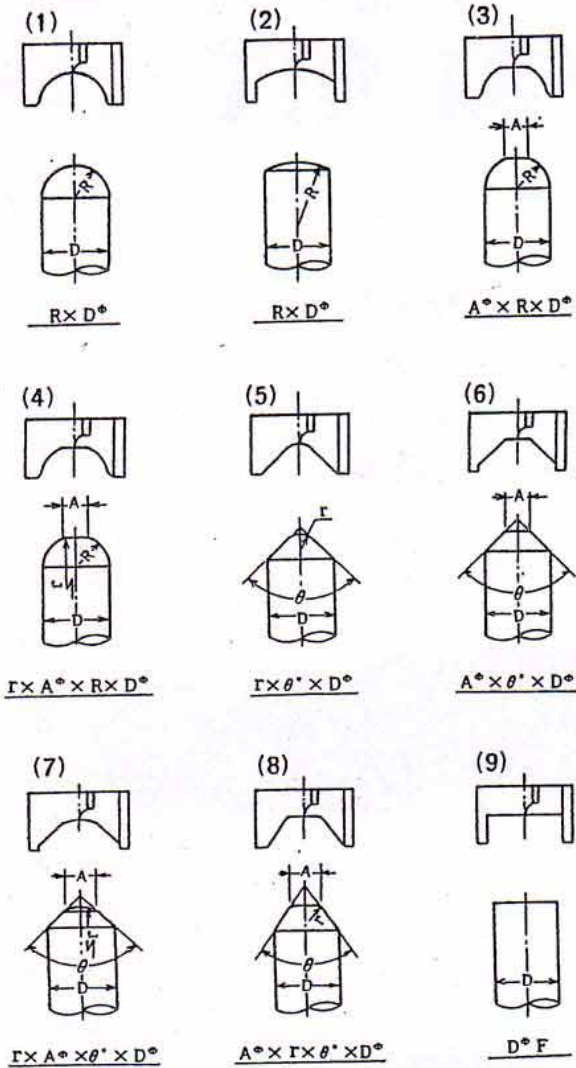
The cutter case bore diameter ($D\phi$) acts as a guide so that the cutter dresses at the correct location relative to the tip.

Please specify a cutter case that matches the tip size.

Note: The following cutter cases and cutters are available severally.

ETD-18F = ETD-0, ETD-25F = ETD-1

■ Shapes of Tip Cutters



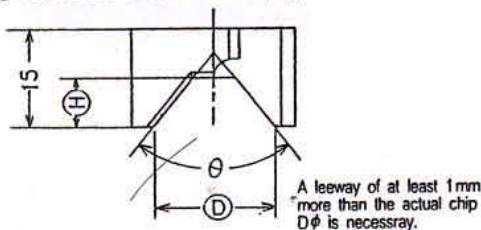
◇ ETD-18F Classification Table

cutter No.	Tip shape (Nominal)	Max. diameter that can be repaired ($D\phi$)	Reserve articles
(1)	5 R 6 R 6.5 R 8 R	10 ϕ 12 ϕ 13 ϕ 16 ϕ	6 R \times 12 ϕ 6.5 R \times 13 ϕ 8 R \times 16 ϕ
(2)	10 R or more ~150 R	18 ϕ	16 R \times 18 ϕ 20 R \times 18 ϕ
(3)	A ϕ \times 6 R A ϕ \times 6.5 R A ϕ \times 8 R	12 ϕ 13 ϕ 16 ϕ	5 ϕ \times 6.5 R \times 13 ϕ 5 ϕ \times 8 R \times 16 ϕ 6 ϕ \times 8 R \times 16 ϕ
(4)	r \times A ϕ \times 6 R r \times A ϕ \times 8 R	12 ϕ 16 ϕ	40 r \times 6 ϕ \times 8 R \times 16 ϕ
(5)	5~6 r \times 60° 3~4 r \times 90° 5r or more \times 90°	13 ϕ 16 ϕ 18 ϕ	
(6)	6~9 ϕ \times 50° 10 ϕ or more \times 50° 5~7 ϕ \times 60° 8~9 ϕ \times 60° 10 ϕ or more \times 60° 3~4 ϕ \times 75° 5~6 ϕ \times 75° 7 ϕ or more \times 75° 3 ϕ \times 90° 4 ϕ or more \times 90° 3 ϕ or more \times 120°	13 ϕ 16 ϕ 13 ϕ 16 ϕ 18 ϕ 13 ϕ 16 ϕ 18 ϕ 16 ϕ 18 ϕ 18 ϕ	6 ϕ \times 60° \times 13 ϕ 6 ϕ \times 75° \times 16 ϕ 4 ϕ \times 90° \times 18 ϕ 5 ϕ \times 90° \times 18 ϕ 6 ϕ \times 90° \times 18 ϕ 5 ϕ \times 120° \times 18 ϕ
(7)	r \times A ϕ \times θ°	D ϕ	
(8)	A ϕ \times r \times θ°	D ϕ	
(9)	F	18 ϕ	F \times 18 ϕ

※ ETD-25F is also classified the same as above. However there are no reserve.

■ Example of Cutter Manufacturing Limitations

(using No.6 above as an example)



- (1) The cutting edge depth (H) is limited to 7.5mm (which is $\frac{1}{2}$ of the total height of 15mm) or less due to strength considerations.
- (2) Should the cutting edge angle θ° on two-blade cutters get too small, chatter will result and the finished shape will be susceptible to breakage. Therefore we limit it to a minimum of 50 degrees.

※ We cannot make items that do not meet conditions (1) and (2).

■ Cutter Nominal Dimensions and Manufacturing Dimensions

When ordering, please use the above classification table with regards to tip shape when specifying the nominal dimensions for cutters. However, depending on the shape of the tip and as long as the cutting edge depth (H) is not exceeded, we make cutters that can be used up to the maximum diameter of the tip (ETD-0 \rightarrow 18 ϕ , ETD-1 \rightarrow 25 ϕ). For example, for an order for a cutter to handle 10R \times 16 ϕ tips, the cutter we make will be specified only as 10R. The cutter we supply will in fact be an item for 10R \times 18 ϕ . If the tip diameter is 18 ϕ or less, dressing can be performed with this cutter by merely replacing the cutter case with one that matches the tip diameter.

(Ordering example)	Cutter No.	Tip shape (Nominal)	Cutter Supplied
	(6)	6 ϕ \times 75° \times 12 ϕ	\rightarrow 6 ϕ \times 75° \times 16 ϕ
	(9)	16 ϕ F	\rightarrow 18 ϕ F

※ For difficult specifications, please send us a print or else an actual cutter.

■ Cutter Repair

The cutting edges can be repaired two to four times. Please send as many together at once as you can.