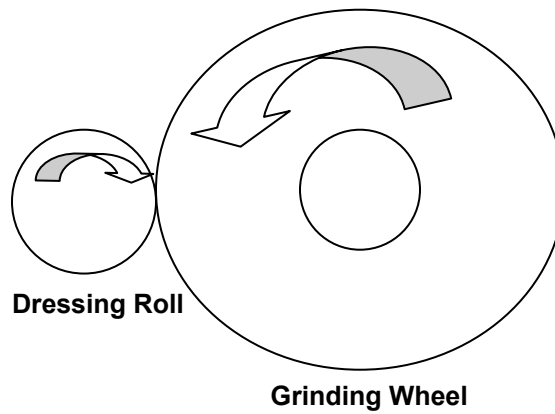
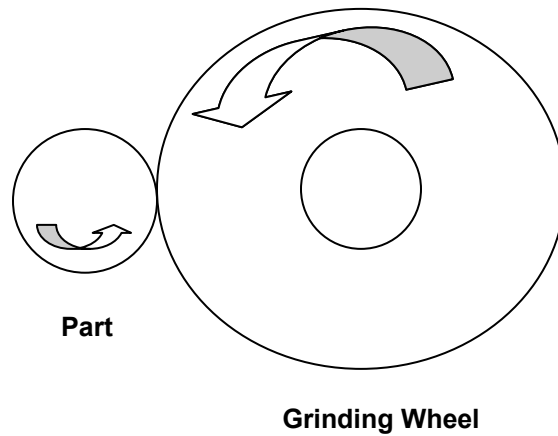


Directional process for grinding and dressing

Grinding wheel and part are rotating counterclockwise creating an opposite direction at wheel to work contact.



Grinding wheel and dressing roll rotate in opposite directions (wheel counterclockwise and dressing roll clockwise) creating a same direction at wheel to roll contact or braking affect.