



STARTEC RC
METAL-BONDED GRINDING TOOLS
FOR FLUTE GRINDING

A Company of the SWAROVSKI Group
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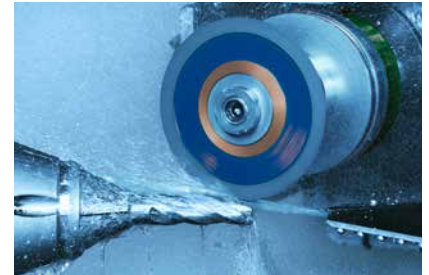
TYROLIT

STARTEC RC

Tyrolit is setting new standards in high performance flute grinding with the STARTEC RC product line. The new specifications feature impressively low grinding forces and maximum stock removal rates with little profile wear. The STARTEC RC grinding tools guarantee maximum precision for your tools and an optimum surface finish. This is all down to a tailored diamond quality, a new bond system and innovative production processes.

Application

High performance flute grinding of tungsten carbide shaft tools



+ Low grinding forces: The combination of process optimised diamond quality, the new metal bond system and innovative production technology guarantee low grinding forces.

+ Shorter grinding times: The optimum matching of the diamond concentration to the new bond properties delivers higher stock removal rates and shorter grinding cycles.



+ Reduced profile wear: The special combination of diamond and bond volume increases the edge stability and ensures a consistently high part quality with extended intervals between dressing.

+ Easy to profile : Due to the new metal bond, the grinding wheel can be trued in the shortest possible time.

Example application

Workpiece: VHM milling cutter d=20mm, z=4, flute length 70mm, KSM tungsten carbide Machine: ANCA TGX, Cooling system: oil | Grinding wheel: STARTEC RC D54-28-M1

Reduction in grinding normal force during flute grinding of 26 percent at $Q'w=9\text{mm}^3/\text{mm s}$



Profile wear during flute grinding lower by 38 percent with $Q'w=9\text{mm}^3/\text{mm s}$



Kr ... Edge radius measured after grinding

STARTEC RC Stock program

Shapes 1A1, 14A1 and 1V1

Diameter range from 75 to 150 mm

Specification D54-28-M1

Customer-specific wheel designs available on request