STARTEC XP-P+
METAL BONDED GRINDING TOOLS FOR
FLUTE GRINDING
STARTEC XP-P+

With the STARTEC XP-P+ product line, TYROLIT defines a new performance level for flute grinding on cemented carbide cutting tools. Two different diamond qualities and the innovative bond structure lead either to a significant reduction in grinding forces or to a major increase in profile retention. The precision of the processed tools remains at the same familiar high level.

+ **Increased traverse speed:** DC diamond quality enables increases in traverse speed of up to 30 percent to be achieved.

+ **Simple profilability:** The innovative metal bond means that the grinding wheel can be profiled in a very short time.

+ **Extended dressing intervals:** The use of diamond quality DP reduces grinding wheel wear by up to 20 percent and increases profile retention.

Example of application

Workpiece: twist drill d = 8.5 mm K30F cemented carbide
Machine: ANCA MX7 / coolant: oil
Grinding wheel: DC54 MXPP+

25% increase in traverse speed and 15% reduction in contact time.

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<thead>
<tr>
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<th>STARTEC XP-P+</th>
<th>COMPETITION</th>
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</thead>
<tbody>
<tr>
<td>Time</td>
<td>164 s</td>
<td>192 s</td>
</tr>
<tr>
<td>Reduced power consumption</td>
<td>371 N</td>
<td>708 N</td>
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</table>

Diamond qualities

DC – for reduced grinding forces
DP – for increased profile retention

Both diamond qualities are available in grain sizes from 35 to 181 µm.