

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.

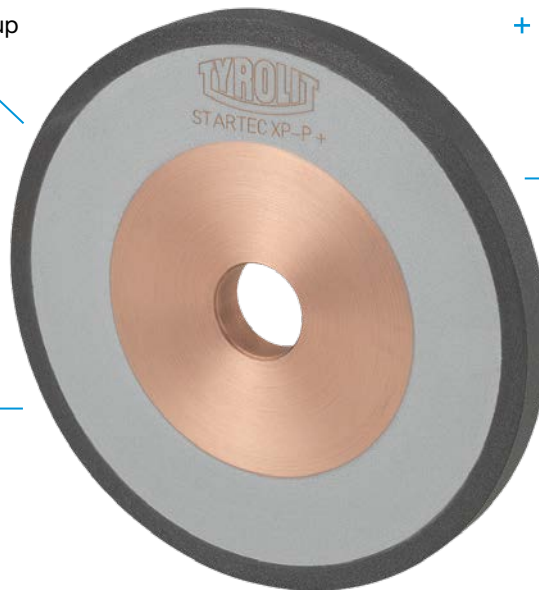
Application

Flute grinding of cemented carbide round tools



+ 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.



Reduced power consumption approx. -50% (with flute 8)



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.