



## **STARTEC RC+**

Metal-bonded grinding tools for flute grinding

# STARTEC RC+

The STARTEC RC+ product line sets new performance standards for flute grinding on tungsten carbide tools. By using new diamond types and a specially developed metal bond system, the product portfolio guarantees huge benefits – the proven Tyrolit production technology stands for the highest product quality. Low grinding forces and significantly reduced grinding wheel wear are particularly impressive when grinding trued chip flutes, with the entire abrasive layer in contact.

**Application:** High performance flute grinding of rotating cutting tools made of solid carbide.



**+ Low profile wear**

The new composition of the grinding layer and the sintering technology used provide for significantly reduced wheel wear and high profile retention, which clearly extends the dressing interval.

**+ Low grinding forces**

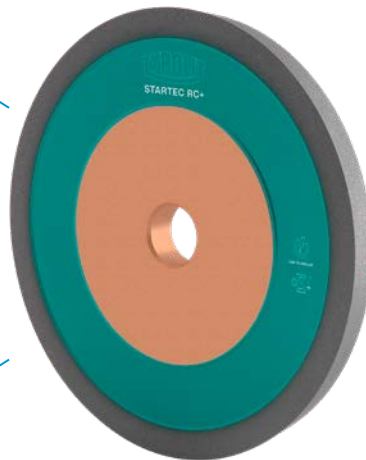
The unique combination of a new diamond type and a modified bond system significantly reduces grinding forces, which in turn leads to a lower temperature increase.

**+ Shorter grinding times**

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

**+ Easy to profile**

Due to the new metal bond, the grinding wheel can be trued in the shortest possible time. Electro erosion is also possible.



## Application example

Workpiece: drill made of solid tungsten carbide, d = 18 mm, z = 2, l<sub>n</sub> = 370 mm, tungsten carbide with 10% Co, ultra-fine grain  
Machine: Rollomatic 830XW, cooling system: oil / STARTEC RC+ D54-28-M-2 grinding wheel

Reduction in grinding normal force during flute grinding of 17 percent at Q<sup>w</sup> = 8,33 mm<sup>3</sup>/mm s



40 percent less wear on the overall profile at Q<sup>w</sup> = 8.33 mm<sup>3</sup>/mm s and an overall grinding length of 740 mm



VPR ... Total wear of the grinding layer

### STARTEC RC+ Stock program

Shapes 1A1, 14A1 und 1V1

Diameter range from 75 to 150 mm

Specification D54-28-M-2

Customer-specific wheel designs available on request