



STARTEC PG-1

GRINDING TOOLS FOR HIGH-SPEED
EXTERNAL CYLINDRICAL LONGITUDINAL
GRINDING

STARTEC PG-1

With the STARTEC PG-1 product line, for the first time TYROLIT is offering innovative roughing and finishing wheels for the peel grinding of tungsten carbide tool blanks in particular. A high-strength metal bond is used with the rough grinding wheel. This enables especially cost-effective and reliable process control. The finishing wheel is available with either long-life vitrified or metal bonds, which even smoothes out large allowance fluctuations after roughing and produces maximum surface quality.

Application

Grinding workpiece geometries using the contouring process



+ Highest stock removal performance: The use of new specifications enables a feed increase of up to 25 % when rough grinding.

+ Reduced grinding noise: New raw materials, a tailored wheel design and the optimal process setting selected by TYROLIT application engineers significantly reduce grinding noise.



+ Low wheel wear: The combination of process-optimised diamond quality and the new bond system reduces wheel wear by up to 10 % when rough grinding.

+ Rapid availability: Selected STARTEC PG-1 grinding and dressing tools are kept in stock and can therefore be supplied quickly.

Example of application

Blank: K10F/d = 13 mm
 Workpiece: Twist drill d = 10.2 mm / Cutting length l = 68 mm / Overall length lg = 115 mm
 Machine: Reinecker RS500 / Cooling system: oil

Cycle time reduced by 24 %



Extension of the dressing interval from 4 days to 5 (equivalent to +25 %)



Surface roughness

Rz = 1.2 µm

Recommended dressing wheels

C80V for grit sizes ≥ D54
 C120V for grit sizes < D54