



STARTEC MT-2

Grinding wheels for manufacturing high precision cutting tools
for the 3C industry

STARTEC MT-2

The new TYROLIT STARTEC MT-2 assortment is dedicated to all manufacturers of high precision cutting tools made of solid carbide which are finally used in the 3C industry. The grinding wheels are specially designed for a tool diameter smaller than 6mm which are mainly used in the 3C industry.

The new specifications cover the rough grinding as well as the finishing process of the tools. Highly efficient grinding processes, minimal edge chipping and ideal surface finish are the result of intensive development efforts.

Application:

Flute grinding of a cutting tool used in the 3C industry



+ High cutting edge quality:

The high quality requirements on cutting tools for the 3C industry can be optimally met through the innovative combination of diamond quality, grit size and bond system.

+ Low Grinding forces:

The combination of process optimized diamond quality, new bonding systems and an innovative production technology guarantee low grinding forces.

+ **System solution:** The specifications of STARTEC MT-2 products are perfectly suitable for use with TYROLIT dressing wheels.



+ High edge retention:

The combination of an innovative bonding system, highest diamond quality and the used grit size extend the dressing interval and guarantees consistently high tool quality with large production outputs.

Example application

Work piece: End mill d = 4 mm, z = 4, flute length 12 mm, solid carbide
Machine and coolant: Rollomatic 629XS, oil coolant

Reduction of the total grinding time of 50 s = -17%

STARTEC MT-2	251 s
COMPETITION	301 s

Conclusion:

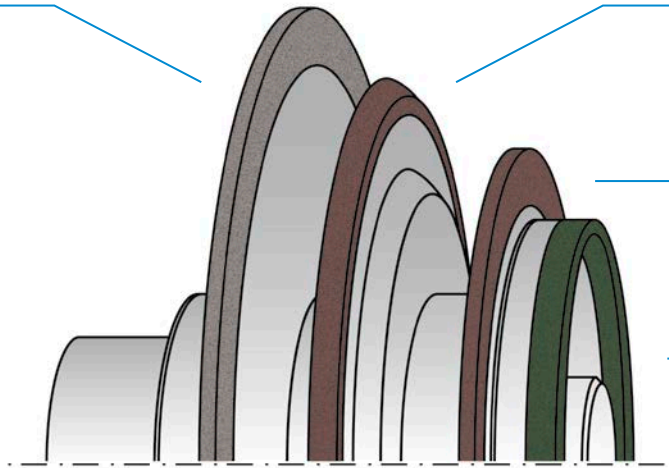
Reduction of the grinding time for roughing of 17 s = -15 %
Reduction of the grinding time for polishing of 33 s = -18 %
Optimum surface finish, no edge chipping

1 Flute grinding wheel
Shape 1A1, 3A1, 4A9

2 Gashing wheel
Shape 1V1, 3V1, 4B9

3 OD grinding wheel
Shape 3A1, 4A9

4 Face grinding wheel
Shape 1A2, 11V9



Application recommendation

		Wheel package for ROLLOMATIC		Wheel package for ANCA		Wheel package for WALTER	
Wheel	Application	One step solution	Two step solution	One step solution	Two step solution	One step solution	Two step solution
1	Flute grinding	Roughing	3A1 150x8x50 U-5 X-10 D54-M TN 34410227 D46-B TN 34411254	4A9 150x8x31,75 W-10 X-3 D25-B TN 34411265	1A1 125x6x31,75 U-6 X-10 D54-M TN 34410230 D46-B TN 34330954	4A9 125x6x20 W-10 X-3 D25-B TN 34411281	1A1 125x6x20 U-6 X-10 D54-M TN 34410229 D46-B TN 34286294
			4A9 150x8x50 W-10 X-3 D25-B TN 34411259				
	Finishing		4A9 150x8x50 W-10 X-3 D15-B TN 34411261	4A9 150x8x31,75 W-10 X-3 D15-B TN 34411267	4A9 150x8x31,75 W-10 X-3 D15-B TN 34411267	4A9 100x6x20 W-10 X-2 D15-B TN 34411284	
2	Gashing	Roughing	1V1 125x6x20 U-6 X-10 V-45 D46-B TN 34411251	3V1 125x6x31,75 U-4 X-6 V-45 D25-B TN 34429415	1V1 125x6x31,75 U-6 X-10 V-45 D46-B TN 34365164	3V1 125x6x20 U-4 X-6 V-45 D25-B TN 34411334	1V1 125x6x20 U-6 X-10 V-45 D46-B TN 34411251
			3V1 125x6x20 U-4 X-6 V-45 D25-B TN 34411334				
	Finishing		4B9 100x6x35 W-10 X-3 D15-B TN 34411336	3V1 100x6x20 U-4 X-6 V-45 D15-B TN 34411336	3V1 100x6x31,75 U-4 X-6 V-45 D15-B TN 34429413	3V1 100x6x20 U-4 X-6 V-45 D15-B TN 34411336	
			4B9 100x6x35 W-10 X-3 D15-B TN 34411342				
3	OD grinding	Roughing	4A9 100x6x25 W-10 X-3 D46-B TN 34383484	4A9 100x6x31,75 W-10 X-3 D20-B TN 34411329	4A9 100x6x31,75 W-10 X-3 D46-B TN 34411325	3A1 100x6x20 U-4 X-6 D20-B TN 34411315	3A1 100x6x20 U-4 X-6 D46-B TN 34397903
			4A9 100x6x25 W-10 X-3 D20-B TN 34411322				
	Finishing		4A9 100x6x25 W-3 X-10 D15-B TN 34411323	4A9 100x6x31,75 W-10 X-3 D15-B TN 34411330	4A9 100x6x31,75 W-10 X-3 D15-B TN 34411330	3A1 100x6x20 U-4 X-6 D15-B TN 34411316	
4	Face grinding	Roughing	1A2 75x11x25 W-3 X-5 D46-B TN 34342142	11V9 100x35x31,75 W-3 X-10 D25-B TN 34429416	11V9 100x35x31,75 W-3 X-10 D46-B TN 34156731	11V9 100x35x20 W-3 X-10 D25-B TN 34387223	11V9 100x35x20 W-3 X-10 D46-B TN 34065402
			1A2 75x11x25 W-3 X-5 D25-B TN 34411302				
	Finishing		1A2 75x11x25 W-3 X-5 D15-B TN 34406766	11V9 100x35x31,75 W-3 X-10 D15-B TN 34425002	11V9 100x35x31,75 W-3 X-10 D15-B TN 34425002	11V9 100x35x20 W-3 X-10 D15-B TN 34411308	

Order of Dimensions: DxTxH

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