



STARTEC

Anwendungshinweise zum Schärfen | Sharpening instructions

Premium grinding tools since 1919
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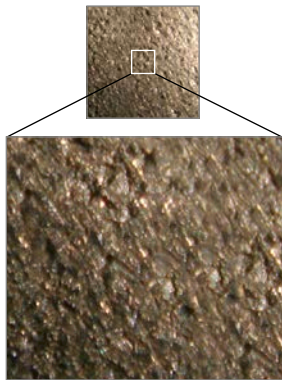


Fig. 1

Schleifbelag nicht geschärft
Grinding layer not sharpened
Fascia non ravvivata
Bandeau abrasif non avivé
Capa de rectificado no afilada

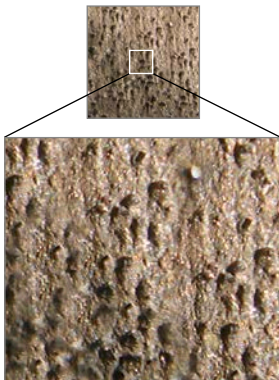


Fig. 2

Schleifbelag geschärft
Grinding layer sharpened
Fascia ravvivata
Bandeau abrasif avivé
Capa de rectificado afilada

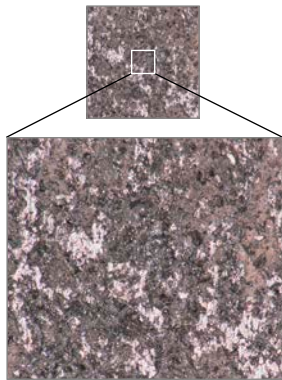


Fig. 3

Schleifbelag nicht erodiert
Grinding layer not eroded
Fascia non ravvivata
Bandeau abrasif non érodé
Capa de rectificado no electroerosionada

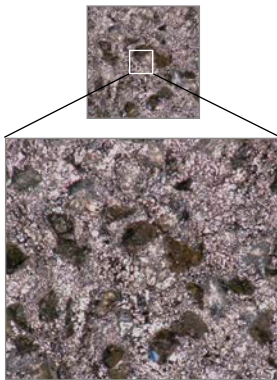


Fig. 4

Schleifbelag erodiert
Grinding layer eroded
Fascia ravvivata con elettroerosione
Bandeau abrasif érodé
Capa de rectificado electroerosionada

Instructions for sharpening and eroding STARTEC grinding tools

THE ENCLOSED GRINDING WHEEL HAS NOT BEEN SHARPENED!

The aim of sharpening is to produce a process-orientated micro-geometry of the grinding tool's contact surface. Sufficient grain protrusion and chip spaces must be created. Only through correct sharpening an optimum cutting ability of the grinding wheel can be achieved.

There are two common sharpening methods:

1. Electrically non-conductive grinding tools must be sharpened with conventional aluminum oxide tools. In this case, sharpening takes place in three steps:
 - Soak the sharpening stone with cooling lubricant
 - Feed the sharpening stone radially to the running grinding wheel by applying gentle pressure. Take the wear of the sharpening stone into account according to the applied scale
 - Select the direction of rotation and cutting speed of the grinding wheel during sharpening fitting to the subsequent grinding operation

Order information

Enclosed sharpening stick, length 100mm:

90AS 24x13x100 STARTEC – TN678952

Optional sharpening stick with length 200mm:

90AS 24x13x200 STARTEC – TN678953

Please use exclusively the enclosed or the optional STARTEC sharpening stick to sharpen the grinding wheel BEFORE use.

2. Electrically conductive grinding tools are clearly labelled with the sign shown below. This ensures that there is sufficient electrical conductivity and that the grinding wheel can be dressed by EDM Technology.



Pay attention to the machine manufacturer's recommendations for dressing and sharpening the grinding tools.





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