



STARTEC MT-1
PRECISION GRINDING WHEELS
FOR PRODUCING
HIGH-PRECISION MICRO TOOLS

STARTEC MT-1

System solutions comprising high-precision grinding tools and specially designed dressing wheels make up the STARTEC MT-1 product line from TYROLIT. Bespoke diamond qualities and an innovative bond structure ensure low grinding forces and particularly high cutting efficiency during the grinding process. Minimal reject-part rates and optimum ground tool quality are the result.

+ Low grinding forces: Innovative specifications ensure particularly high cutting efficiency when grinding and simultaneously guard against tool breakage due to overload during the grinding process.

+ Optimum edge retention: The special combination of bond, diamond quality and grit size extends the dressing interval and guarantees consistently high tool quality, even with large batches.



Application

Flute and face grinding of micro tools



Photo: Rollomatic SA

+ Simple profilability: The adapted bond system enables highly accurate profiles to be created in an extremely short time. TYROLIT offers dressing wheels that are ideally suited for this application.

Example of application

Workpiece: Micro cutter $d = 1.0 \text{ mm}$ / Flute length $l = 5.0 \text{ mm}$
 Machine: Rollomatic Nano 6 / Cooling system: oil
 Grinding wheel: D20M MT-1

Stable edge radius of 0.025 mm on the grinding wheel across the 200-piece production lot with STARTEC MT-1.

Edge radius after 200 pieces [mm]



Recommended dressing wheels

A400V for grit sizes $> D15$
 A1200V for grit sizes $\leq D15$

Schematic diagram

■ = TYROLIT
 ■ = Competition

