

**STARTEC XP-F**  
GRINDING WHEELS FOR  
POLISHING SHANK TOOLS

A Company of the SWAROVSKI Group  
[www.tyrolit.com](http://www.tyrolit.com)



# STARTEC XP-F

The STARTEC XP-F product line from TYROLIT provides innovative polishing wheels for the cost-efficient polishing of the functional surfaces of shank tools. These tools feature a new resinoid bond with a high wear resistance combined with tailored micro-diamonds. These new specifications can also be produced in customer-specific shapes and dimensions. They guarantee the best surface finish while at the same time delivering maximum precision for the polished tools.

## Application

STARTEC XP-F grinding wheel for polishing shaft tools made of tungsten carbide



### + Best surface finish:

The combination of process-optimised diamond quality and the new bond system guarantees the best surface finish.

+ **Low wheel wear:** The new bond system boasts impressively high strength, thereby reducing the wheel wear by up to 40%



+ **Highest precision:** The use of this new specification ensures complete stock removal up to 0.2mm during the polishing process. Complete stock removal is also guaranteed in the case of stock fluctuations after the grinding process.

## Example application

Workpiece: VHM drill, CTS 20D, d=8.5mm, flute length 130mm  
Machine: Walter Helitronic Vision / Cooling system: oil

### Improvement in surface finish

**STARTEC XP-F** Rz= 0,2µm Visual assessment: mirror-finish

**COMPETITION** Rz=0,45µm Visual assessment: semi-matt surface

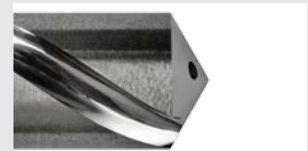
Feed increased during polishing by 40% at ae=0.15mm

**STARTEC XP-F** vt=210mm/min

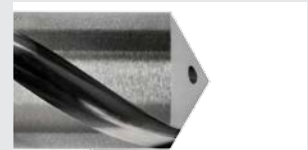
**COMPETITION** vt=150mm/min

Recommended dressing wheel A400V for grit size ≤D20

## Polished chip flutes of a VHM drill



Visual assessment: mirror-finish



Visual assessment: semi-matt