

Flute Master



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Suitable for grooving with oil-based coolant

Flute Master was created to exhibit excellent heat resistance of metal bond and surpasses the grinding ability of the resin bond wheel.

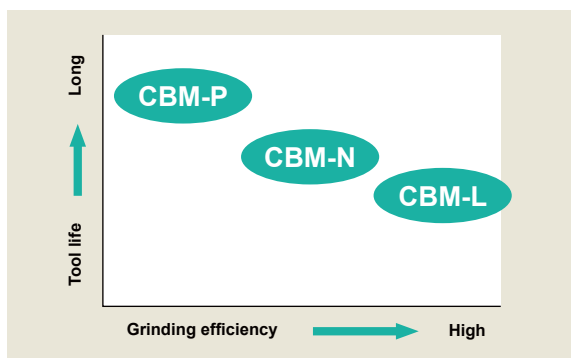
Features

Newly developed metal bond has both excellent grinding ability and provides long tool life. It also increases grinding efficiency, especially when used with oil-based coolant.

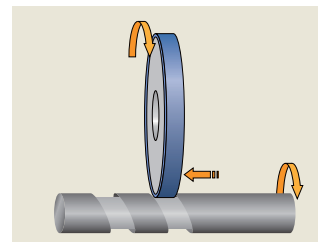
Applications

- Flute grinding of endmills, drills and reamers
- Chipbreaker grinding of inserts
- Heavy duty grinding of various tools, including special steel tools

Bond Line Up

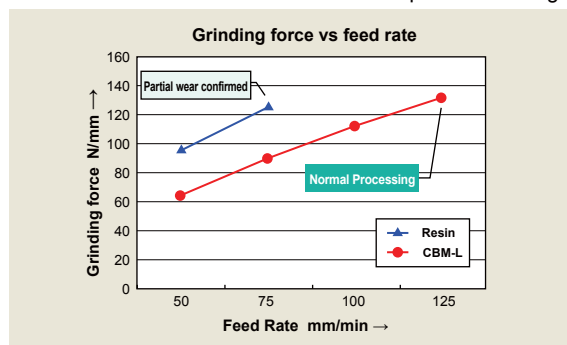


Flute Grinding



Relation between grinding force and feed rate

- 1) Wheel Specification Resin : SDC325N100B
CBM-L : SD325L100CBM
- 2) Work Material : Cemented Carbide
- 3) Conditions : Wheel Peripheral Speed : 1500m/min
D.O.C. : 3mm Coolant : Oil-based
Machine : Horizontal spindle surface grinder



Grinding performance

- 1) Wheel Specification Resin : BN140-100B
CBM-L : BN140L-100CBM
CBM-P : BN140P-100CBM
- 2) Work Material : SKH51(HRC60)
- 3) Conditions : Wheel Peripheral Speed : 1500m/min
D.O.C. : 1mm Feed rate : 40mm/min
Coolant : Oil-based
Machine : Horizontal spindle surface grinder

