

Flute MAX



FluteMAX

Suitable for grooving with water-soluble coolant

Flute MAX applies super heat resistant resin with a special filler to achieve both superior cutting ability and long tool life.

Suitable for grooving applications such as endmills, drills, reamers, and creep feed grinding for various other tools.

Features

- Super heat resistant resin helps to reduce deterioration under high temperature.
- Excellent cutting ability and shape retention even for heavy load grinding such as creep feed grinding.
- High feed rate and long dressing interval compared to conventional wheels which lead to high efficiency and cost reduction.

Applications

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

3 different bond types

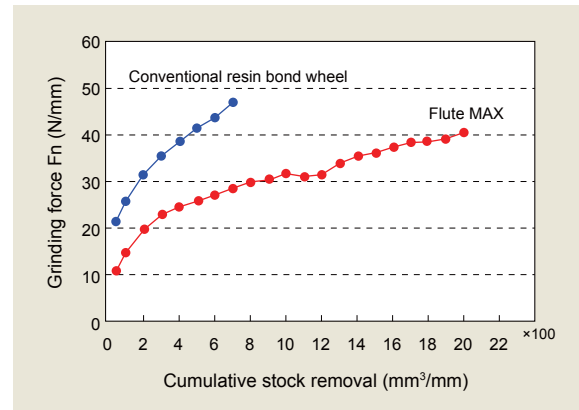
Bond grade	Special feature
L	Superior cutting ability
N	Standard
P	Superior shape retention



Creep feed grinding of cemented carbide

Conditions

Workpiece	Cemented carbide
Wheel specification	SDC140-100B
Wheel speed	V=1600m/min
Work speed	F=80mm/min
Depth of cut	a=0.5mm/pass
Coolant	water-soluble



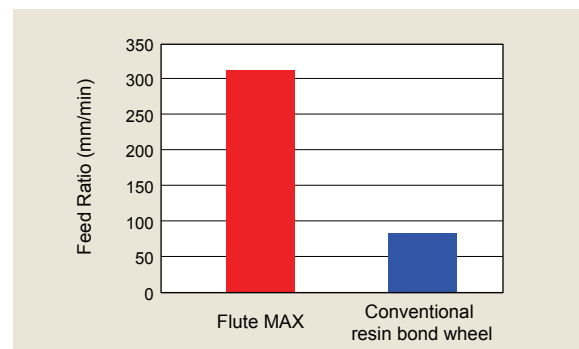
Result

Compared to conventional resin bond wheel Flute MAX can maintain low grinding force and cutting ability.

Flute Grinding of Cemented Carbide Endmill

Conditions

Workpiece	8D 2-flute endmill
Wheel specification	SDC270-100B
Wheel speed	V=1,600m/min
Depth of cut	a=1.5mm (1st time) 0.5mm (2nd time)
Coolant	water-soluble



Result

Flute MAX can achieve grinding by 4 times faster feed ratio than conventional resin bond wheel in same tool life.

