



**DR. MÜLLER**  
**DIAMANTMETALL®**

INDIVIDUAL  
**PREMIUM**

For **MAXIMUM EFFICIENCY** in the grinding process



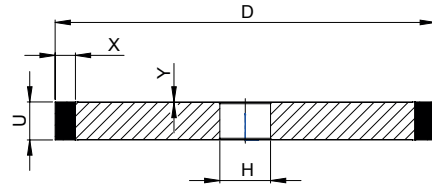
POLISHING OF FLUTE  
AND OD RELIEF  
**STELLARIS**

# STELLARIS

A brilliant idea for polishing chip flute and OD relief

## TECHNICAL FEATURES

Application:	Polishing chip flute and OD relief	Width of the coating:	U 2 mm to 30 mm
Material:	Tungsten carbide	Binding:	Synthetic resin (MDT-600)
Machines:	All tool grinding machine	Grain size:	D15
Coolant:	Oil, emulsion	Tool type:	1A1, 1B1, 1V1, 3A1, 3B1, 3VI, 11V9C, 12V9C, 14A1, 14B1, 14V1
Dimensions:	D 75 mm to 200 mm		



## FLUTE POLISHING APPLICATION PARAMETERS

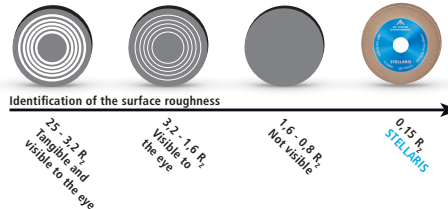
Cutting speed:	Vc = 25 – 28 m/s
Infeed:	ae = 0.1 – 0.2 mm
Feed:	Vf = 70 mm/min., with 280 pieces in series

## KEY FEATURES

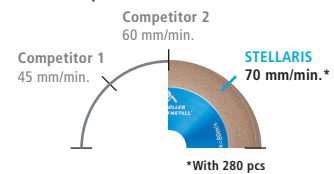
- ▲ Innovative binding concept with a new type of micro-grain for mirror-cut surfaces for chip flute and OD relief
- ▲ Infeed of up to 0.2 mm for the perfect final dimension of your workpiece
- ▲ Above-average long service life of the grinding wheel

## YOUR BENEFITS

- ▲ Improved surface quality



- ▲ Improved feed rate



Technical application information:  
Flute length = 50 mm Vc = 28 m/s

- ▲ Ultimate surface quality & improved chip formation
- ▲ Better cutting edge quality on the workpiece
- ▲ Reduced surface energy in carbide & improved process security
- ▲ Optimised grain protrusion for higher removal rates
- ▲ Low set-up costs & increased profitability

## BENEFITS FOR YOUR WORKPIECE

- ▲ No cobalt leaching
- ▲ Uniform surface quality through targeted self-sharpening effect

## RECOMMENDATIONS

### ▲ FLUTE OPERATION

High performance hybrid binding  
MDX-665 and MDX-587

\* Dimensions and grain size according to customer requirements.

### ▲ DRESSING

Silicon carbide grinding wheel, 320 grain

### ▲ PERIPHERAL AND FACE MACHINING

X17240, 11V9C,  
MDX-587 CS D54 (hybrid binding)

### ▲ SHARPENING

Whetstone X13169 (silicon carbide)