

**CASE STUDY**

Norton Winter



Application **FLUTE GRINDING OF TWO FLUTE**  
Market **TOOLS**

**THE CUSTOMER'S CHALLENGE**

A leading tool manufacturer was looking for a fluting wheel to improve their flute grinding applications and boost productivity.

MATERIAL **Solid carbide**  
DIMENSION **Ø 25 two flute end mill**  
STOCK REMOVAL **9,25 mm per flute**  
  
MACHINE **WZS 700**  
COOLANT **Oil**  
DRESSER **Off-machine with SIC**

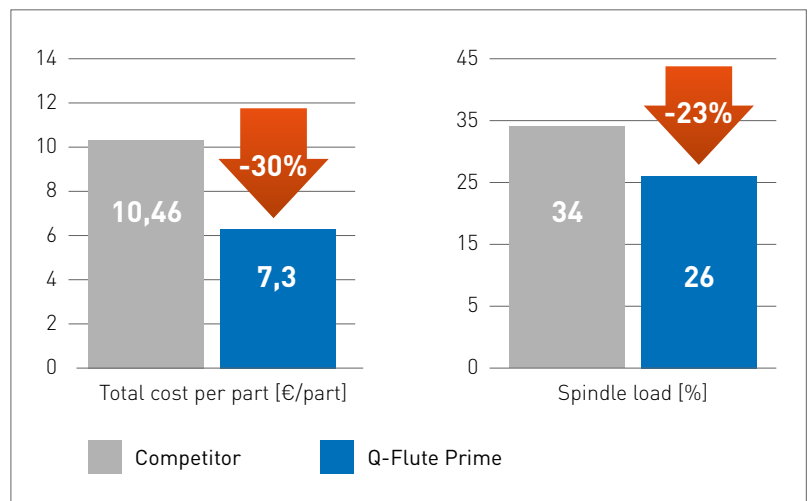
**COMPETITOR**  
DIMENSION **100-15-10-20**  
SPECIFICATION **standard**

**NORTON**  
PRODUCT **Norton Winter Q-Flute PRIME**  
SHAPE/DIMENSION **SP1V1-100-15-10-20 20\* D54**  
WHEEL SPEED **17 M/S**  
PROCESS PARAMETERS **Ae = 9,25 mm, 1 pass,  
Vf = 30 mm/min**

**RESULTS**

- **30 % reduction of total cost per part**
- **50 % increase of Q'w max**
- **50 % feed rate increase**

Thanks to the new, outstanding free sharpening bond system, Q-Flute Prime enables a 23% reduction in spindle load despite an increased feed rate. This results in higher productivity and longer machine life.



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