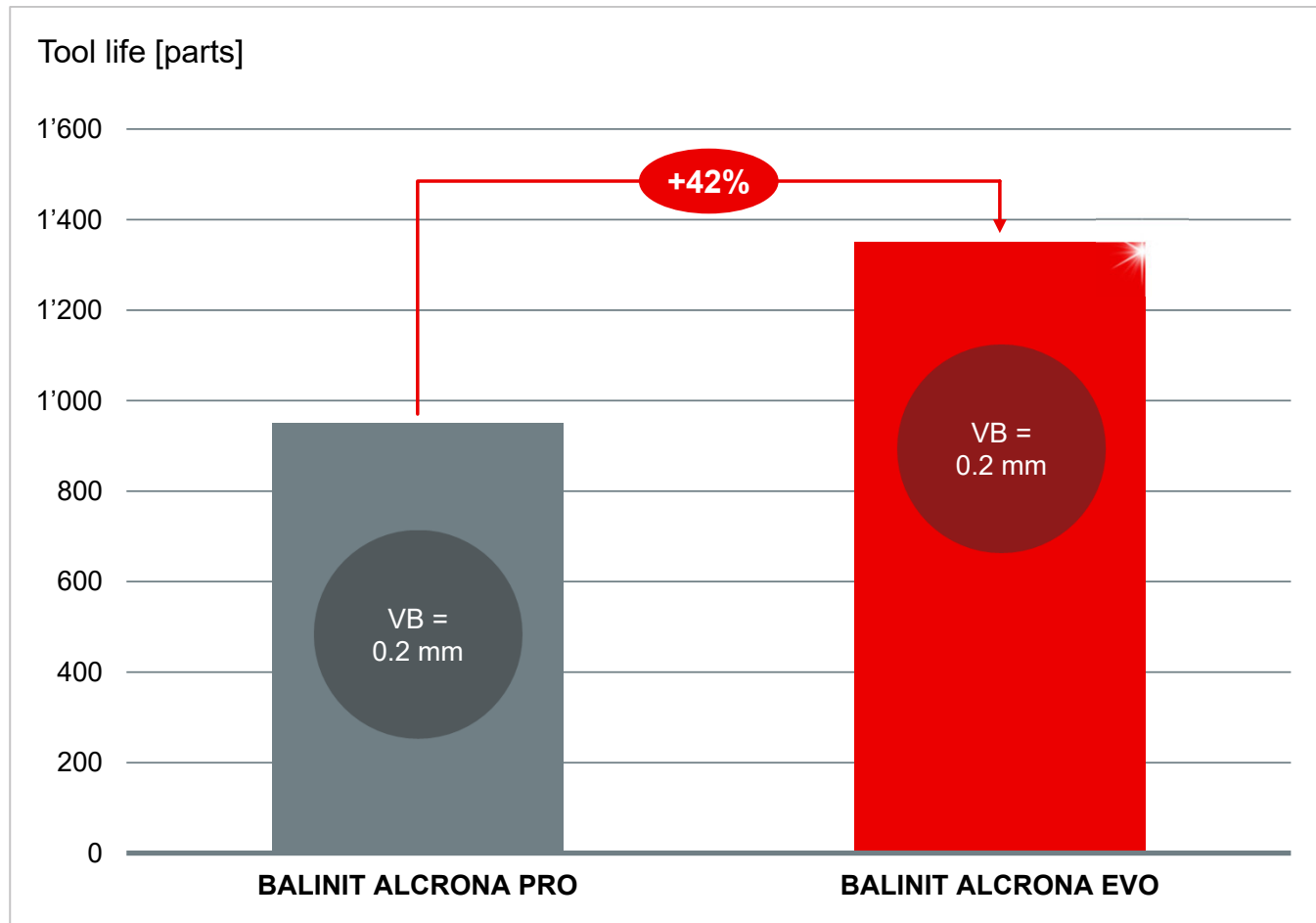


# BALINIT ALCRONA EVO

## Dry machining with HSS hobs

**oerlikon**



**Tool:**  
HSS hob

**Workpiece:**  
Internal – similar to 20MnCr5

**Cutting data:**  
Dry machining  
 $v_{c1} = 180$  m/min  
 $v_{c2} = 280$  m/min  
 $f = 2.55$  mm/rev.  
 $VB_{max.} = 0.2$  mm

**Benefit:**  
40% better performance

**Source:**  
Automotive industry