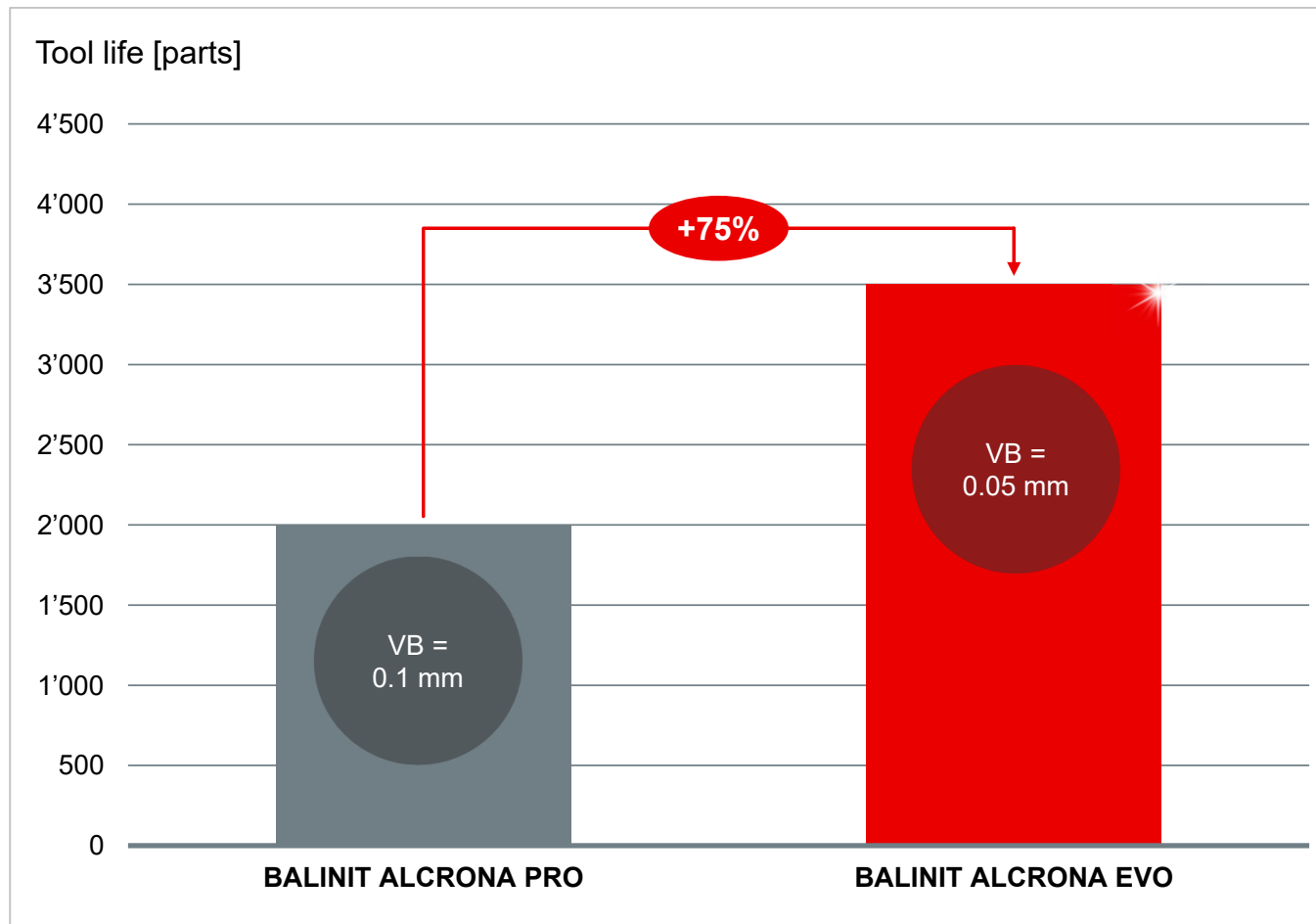


BALINIT ALCRONA EVO

Dry machining with carbide hobs

oerlikon



Tool:

Solid carbide hob with shaft
D = 70 mm X L = 240 mm

Workpiece:

20MnCrS5
Module: 2.2

Cutting data:

Dry machining
 $v_c = 350$ m/min
 $f = 1,7$ mm/rev.
 $a_p = 6,75$ mm
 $VB_{max} = 0.1$ mm

Benefit:

Improved performance with less flank wear → reduction of regrinding stock

Source:

Automotive OEM