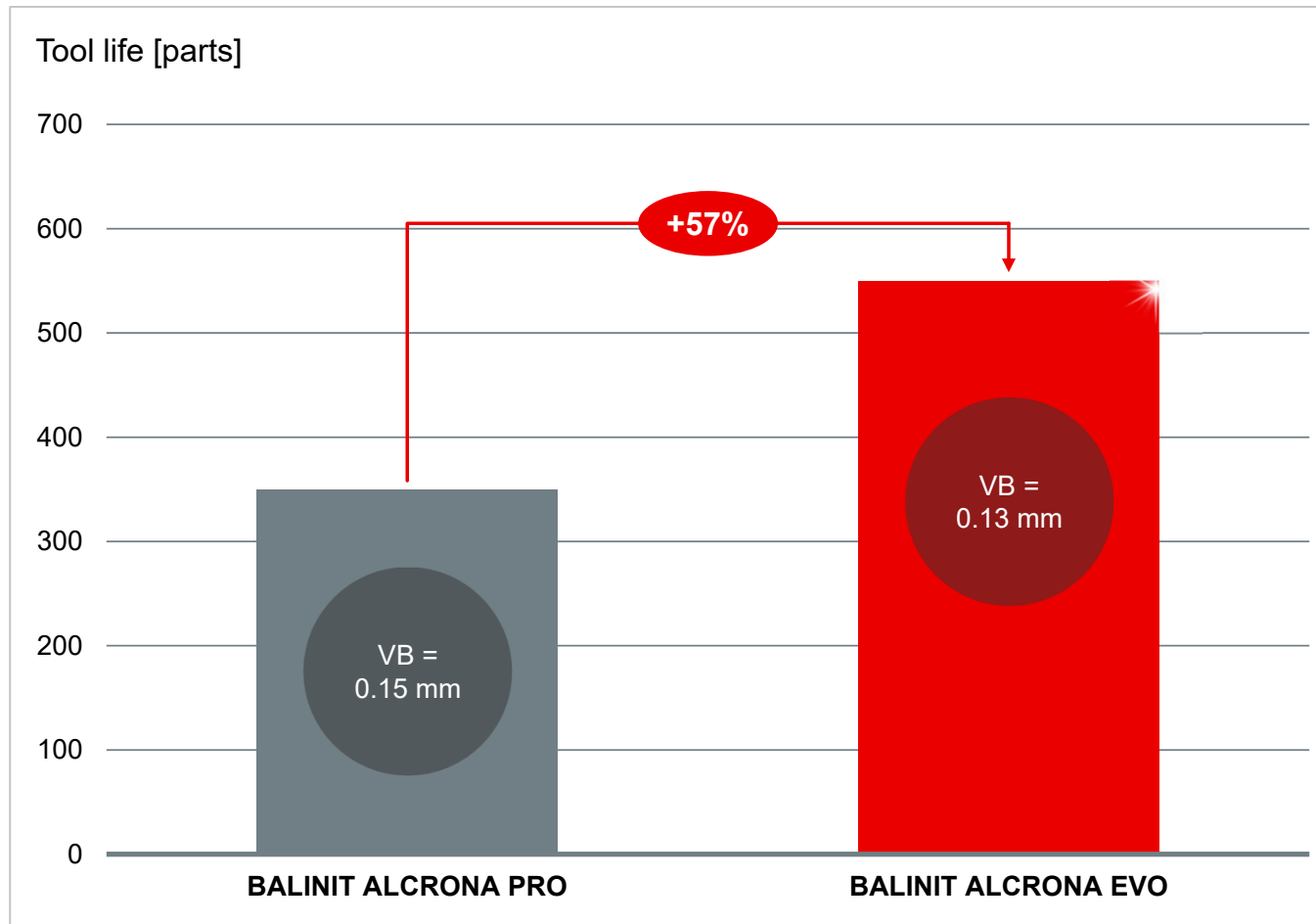


BALINIT ALCRONA EVO

Wet gear hobbing with lower cutting speed

oerlikon



Tool:

Bore type hob HSS M35,
D = 100 x L = 120 mm

Workpiece:

Material SAE8620H
Module: 3.5

Cutting data:

Wet machining
 $v_c = 63$ mm/min
 $f = 2.0$ mm/rev
 $VB_{max} = 0.15$ mm

Results:

Improved performance while retaining
the same pull-out criteria

Source:

Automotive tier 1 supplier