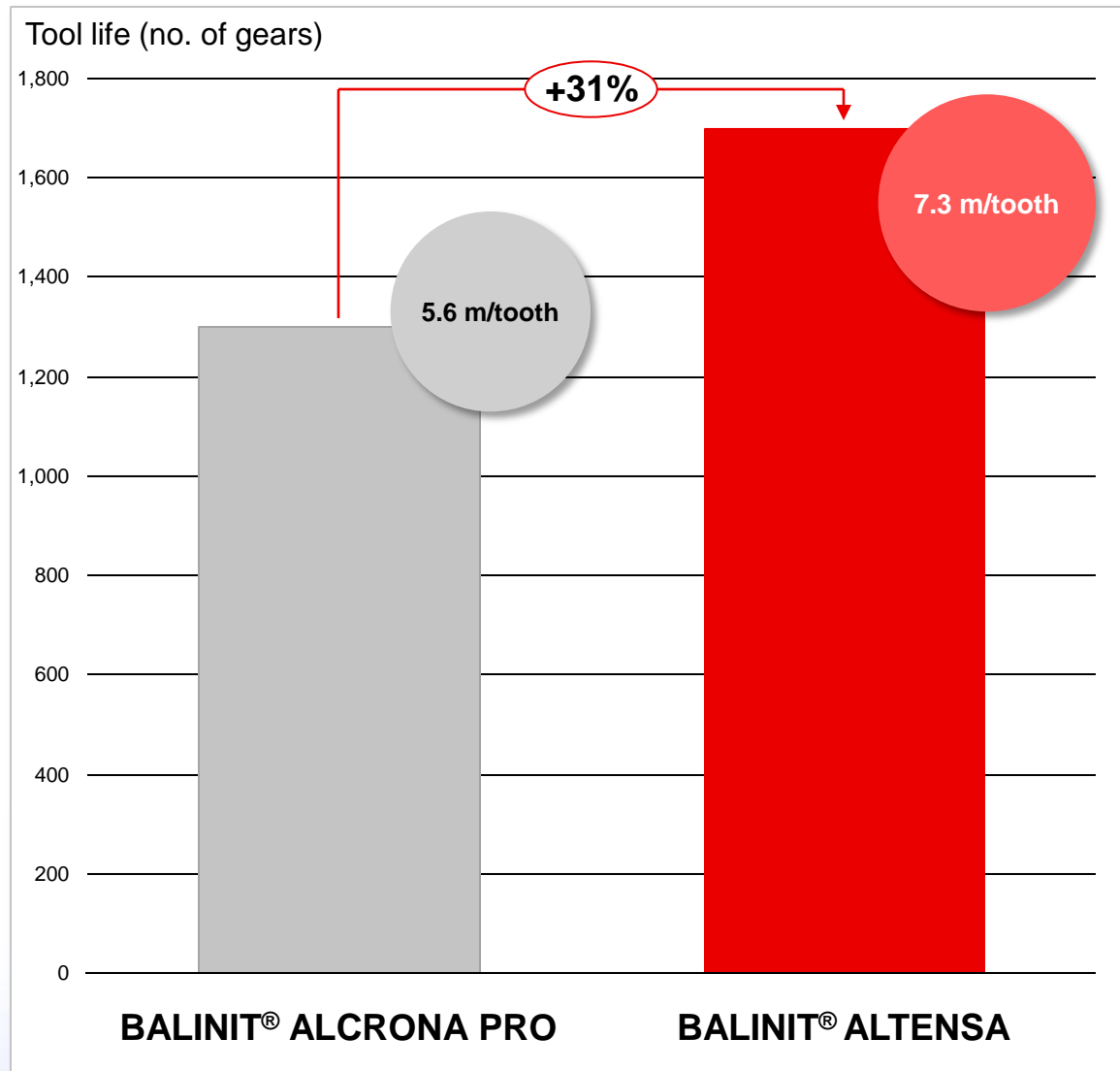


# Carbide hobs: 30% tool life increase



## Tool:

Carbide hob  
D = 90 mm

## Workpiece:

Steel 1.7149 (~AISI 5120, ~JIS SMnC420(H))

## Cutting data:

$v_c = 480$  m/min

$m_n = 2.6$

$f_a = 2.6$  mm

dry

Gearbox for passenger car

## Benefit:

+30% tool life at high-speed conditions

## Source:

Oerlikon Balzers/  
Automotive  
Enduser

