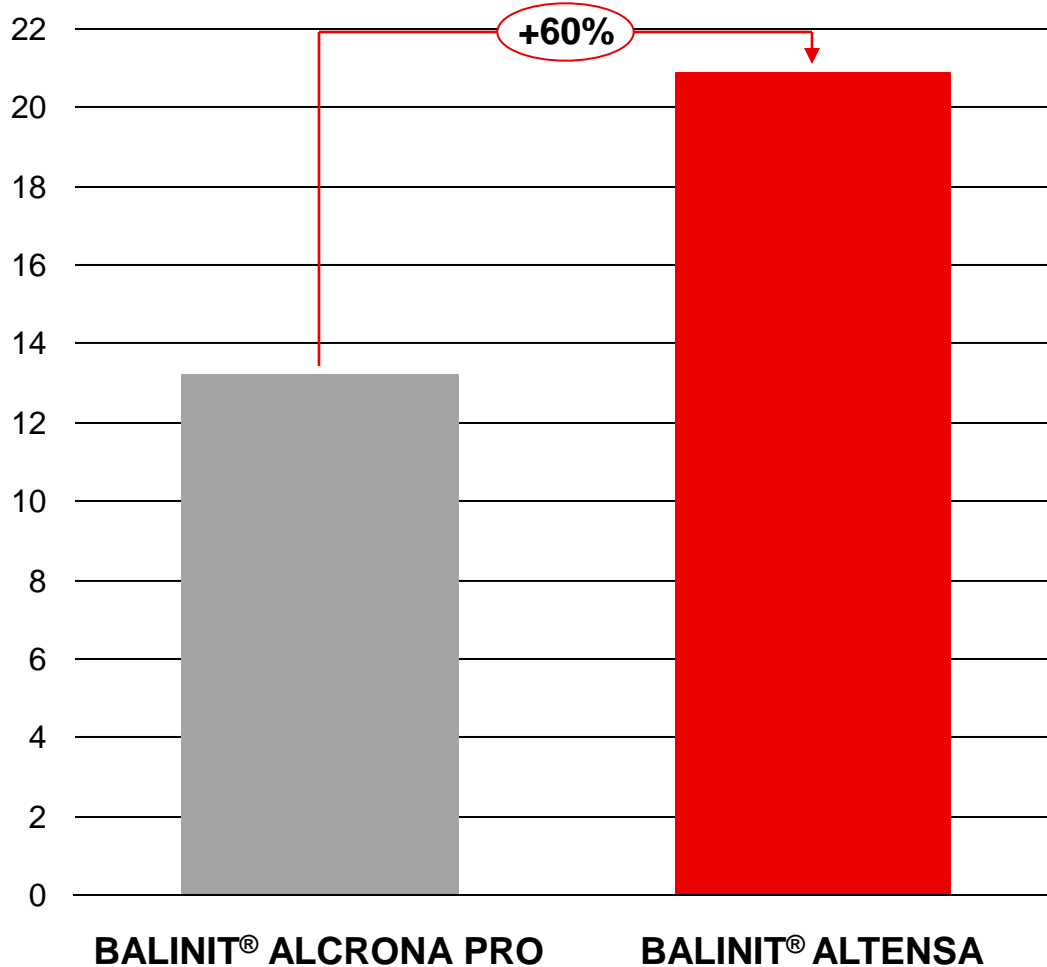


# Lab tests: convincing results at high-speed cutting

Tool life (m/tooth)



**Tool:**

PM-HSS hob (S390)

**Workpiece:**

Steel 1.7131 (AISI 5115)

**Cutting data:**

$v_c = 260$  m/min

$m_n = 2.56$

$f_a = 4.8$  mm

$H_{cu,max} = 0.25$  mm

dry

**Benefit:**

+60% tool life at high cutting speed

**Source:**

Oerlikon Balzers  
WZL Aachen

