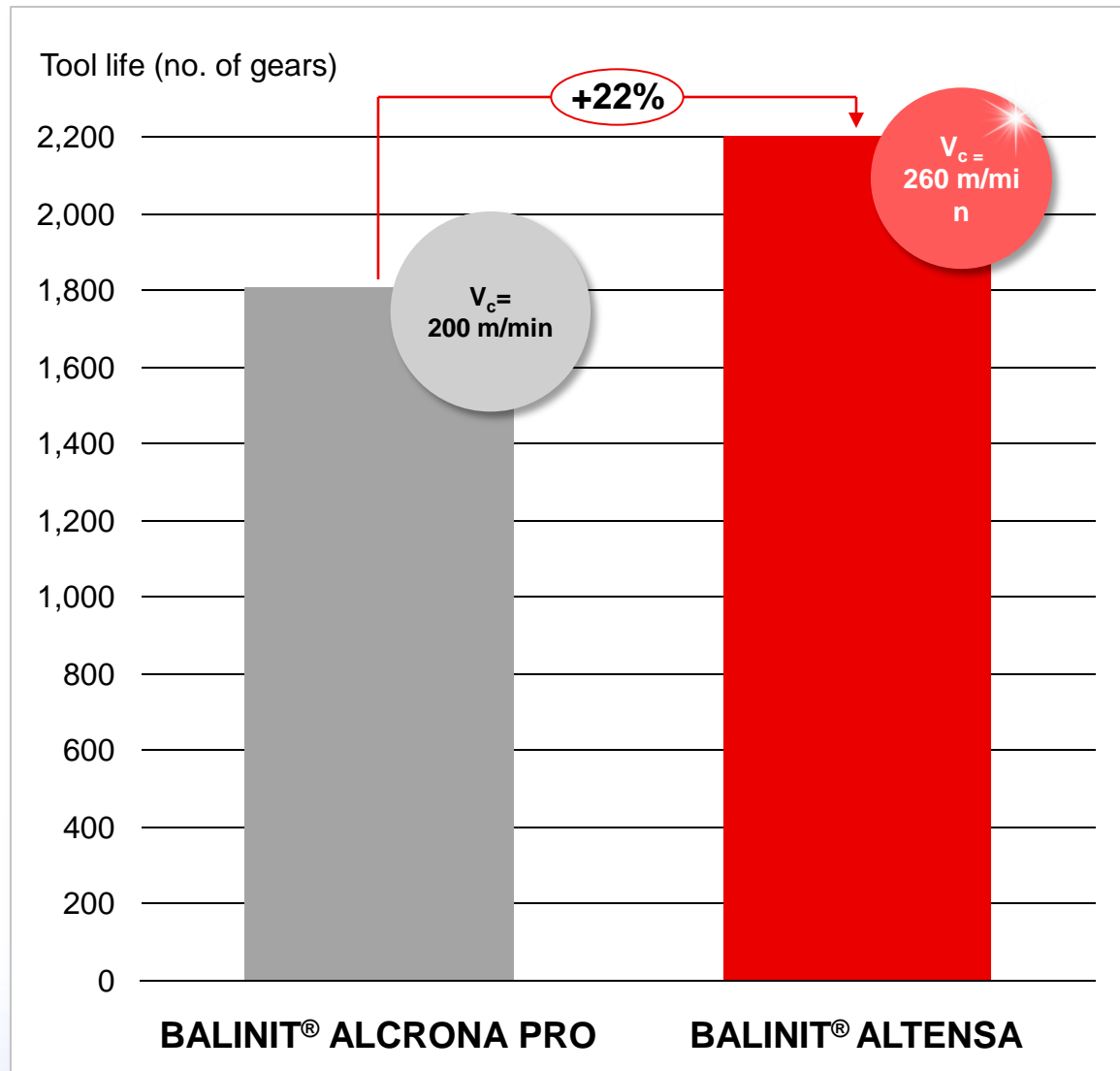


# Customer test 1: 30% increase in cutting speed results in 20% longer tool life



## Tool:

PM-HSS hob (S390)  
D = 90 mm

## Workpiece:

Steel 1.7131 (AISI 5115)

## Cutting data:

$v_c = 200 \rightarrow v_c = 260$

$m_n = 1.62$

$f_a = 6.0$  mm

dry

Gearbox for passenger car

## Benefit:

+30% cutting speed and > 20% longer tool life

## Source:

Oerlikon Balzers/  
Automotive  
Enduser

