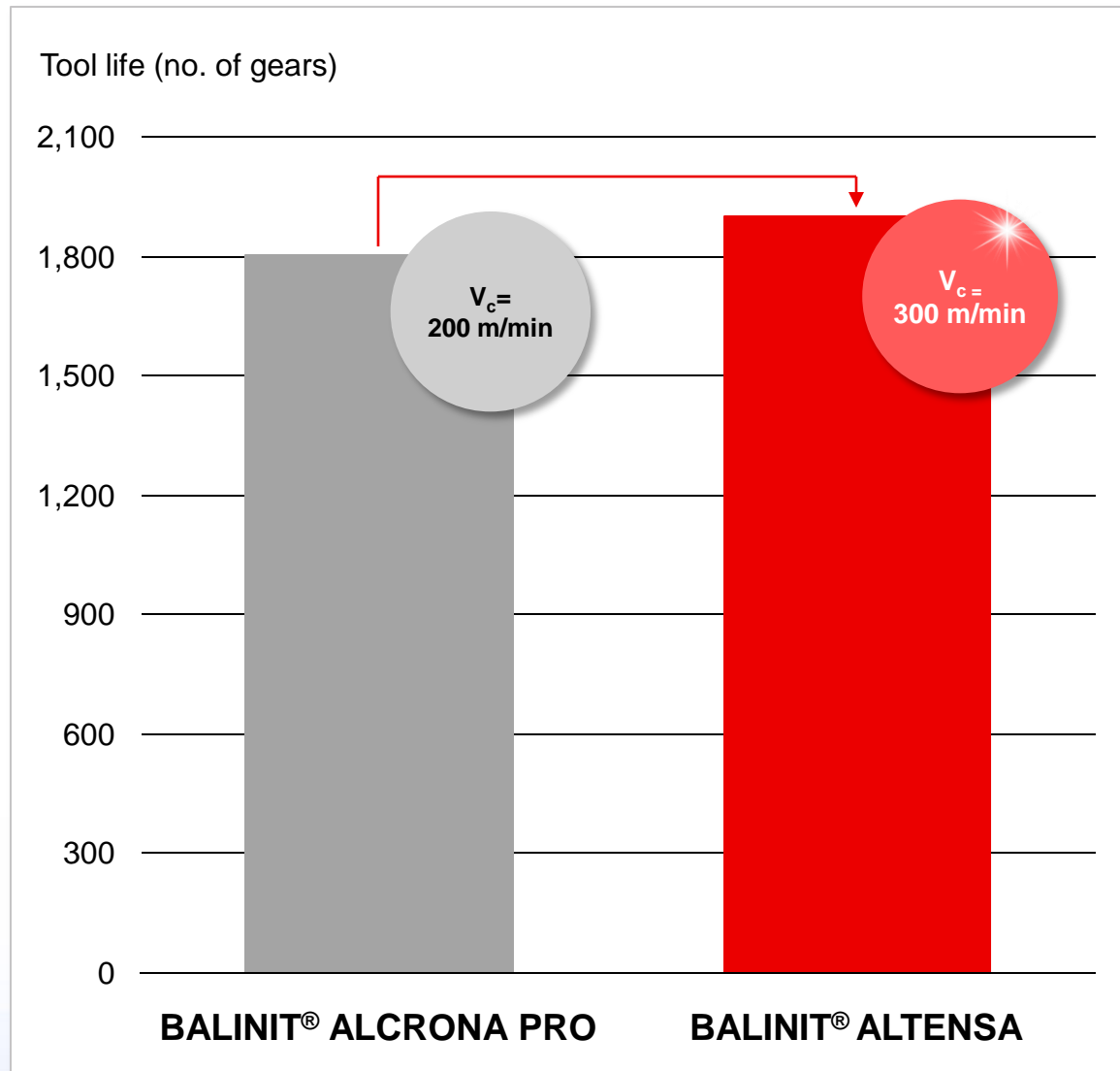


# Customer test 2: Increasing the speed to 300 m/min – still the same long tool life



## Tool:

PM-HSS hob (S390)  
D = 90 mm

## Workpiece:

Steel 1.7131 (AISI 5115)

## Cutting data:

$v_c = 200 \rightarrow v_c = 300$

$m_n = 1.62$

$f_a = 6.0$  mm

dry

Gearbox for passenger car

## Benefit:

+50% cutting speed at same tool life

## Source:

Oerlikon Balzers/  
Automotive  
Enduser

