Carbide hobs: 30% tool life increase

Tool:
Carbide hob
D = 90 mm

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

Cutting data:
\( v_c = 480 \text{ m/min} \)
\( m_n = 2.6 \)
\( f_a = 2.6 \text{ mm} \)
dry

Gearbox for passenger car

Benefit:
+30% tool life at high-speed conditions

Source:
Oerlikon Balzers/Automotive Enduser