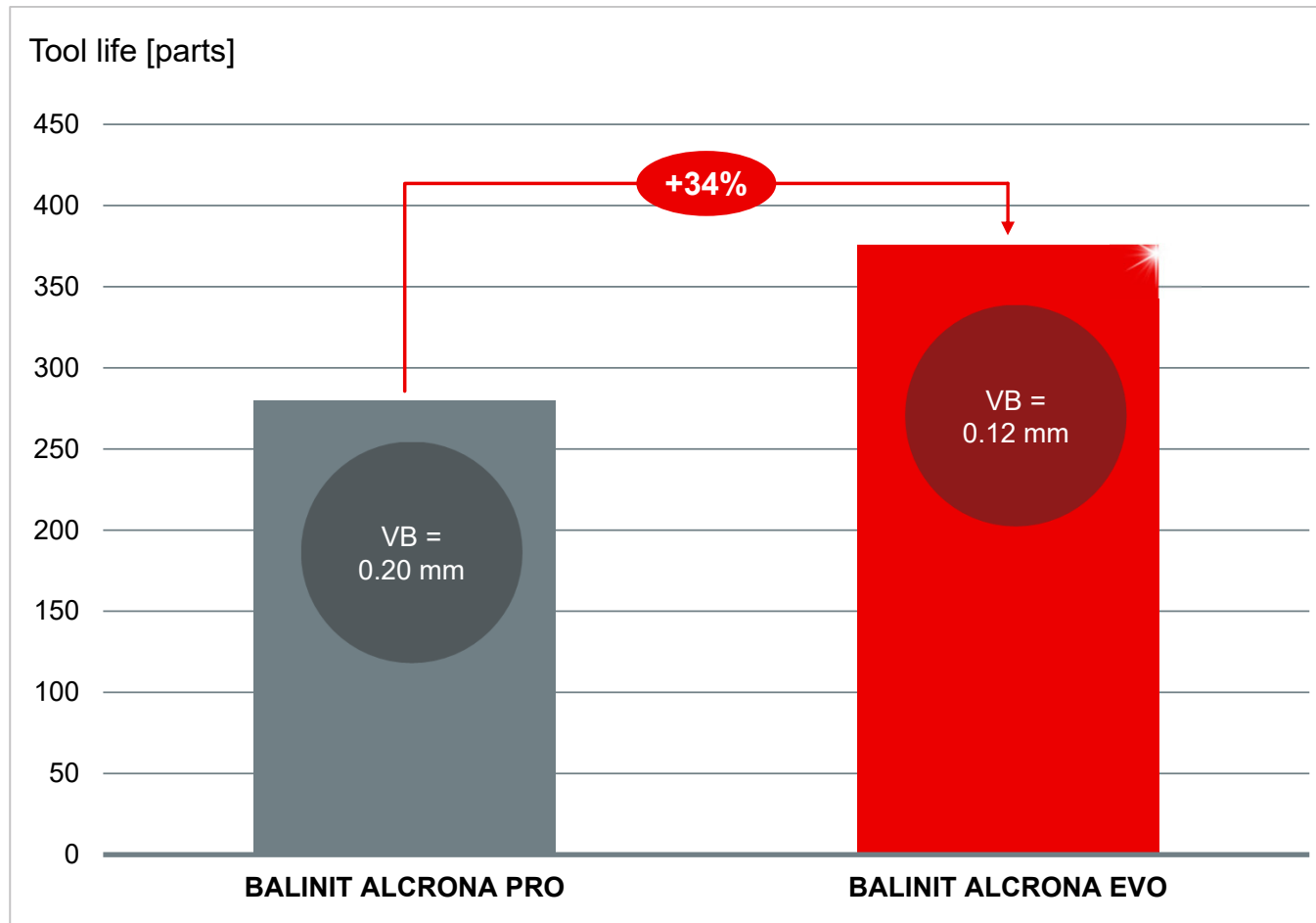


BALINIT ALCRONA EVO

Reduced flank wear for HSS skiving tools

oerlikon



Tool:

HSS skiving cutter
Module: 2.65
D = 112 mm

Workpiece:

Material: 42CrMo4
No. of teeth: 70
Face width: 48 mm
Tooth depth: 4.98 mm

Cutting data:

Dry cutting
 $v_c = 244$ m/min
 $f = 350$ to 550 mm/min
No. of passes: 15

Benefit:

- +34% longer tool life
- 40% less tip wear

Source:

Transmission gear manufacturer