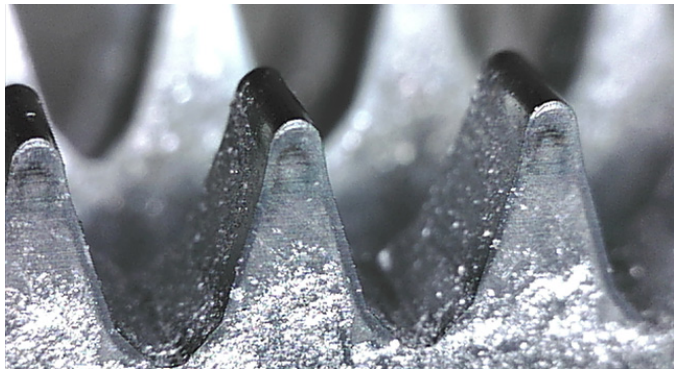
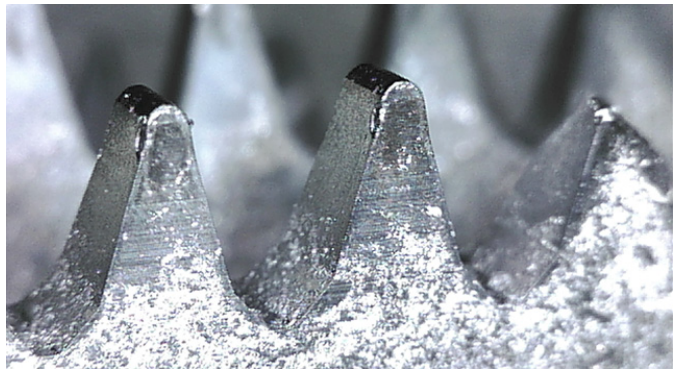
Dry Hobbing Solutions

Dry Hobbing Automotive Pinion





Work Piece

- 23 Tooth Pinion
- 1120 Blank Material
- Hardness 145 BHN

Work Conditions

- 1st Cut – SMM 375, 1.8 mm/rev, conv/radial combination
- 2nd Cut – SMM 400, 1.8 mm/rev, climb
- Shift amount – 3.7719 mm
- 98 Passes
- Dry Cutting

Tool Specifications

- Coating – Alcrona Pro
- Material – Carbide
- Number of Threads – 2

Improvements

- Improved Tool Life
- Improved Part Quality, Surface Finish
- Improved Part Quality, Dimensional

Results

- .325 / 19.5 second cycle time
- 5000 pinions per resharpening
- 2.34 LMT
- .124 mm Max Chip Thickness
- 3.33 um Scallops
- .37 um generating flats
- .175 mm maximum wear

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