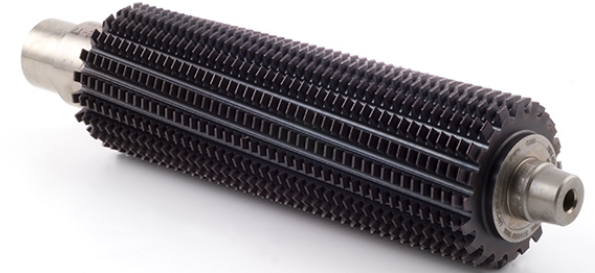
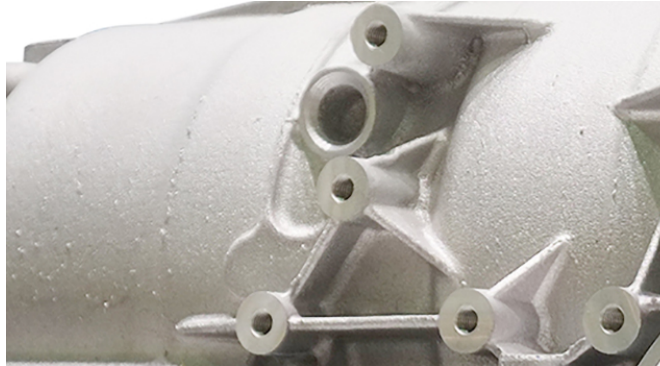
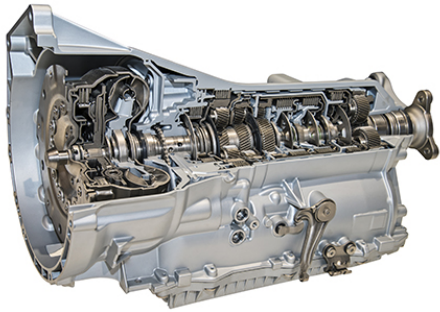


Dry Hobbing Solutions

Dry Hobbing Automotive Sun Gear



Work Piece

- 47 Tooth Sun Gear
- 5130 Blank Material
- Hardness 220 BHN

Work Conditions

- 200 SMM, 2.5 mm/rev
- Shift Amount – 5 mm
- 90 Passes
- Dry Cutting
- Sustained application

Tool Specifications

- Coating – Alcrona
- Material – HSS
- Material Grade – PM6
- Number of Threads – 3

Results

- 27.42 second cycle time
- 3500 gears per resharpener
- 5.5 LMT
- 0.154 mm Max Chip Thickness
- 7.3 um Scallops depth on Flank
- 0.6 um Generating Flats
- 0.254 mm Maximum Wear