

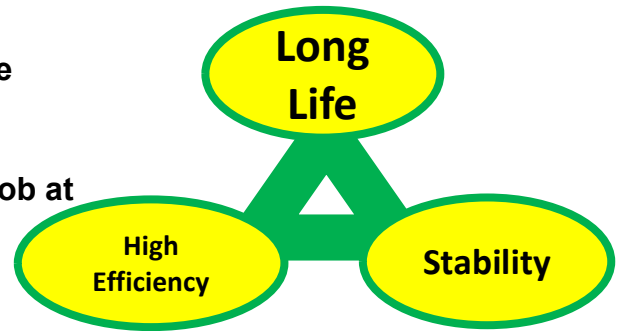
GRANMET SF

A material that takes durability to new frontiers

(Trademark Registration pending)

Characteristic

- New material with excellent temperature resistance (Hot-hardness) and wear resistance
- Tremendous improvement against crater-wear
- High efficiency machining, equivalent to carbide hob at cutting **Speeds** of 300 m/min or more.



Example Cutting speed 400m/min hobbing

【Work spec】

m 2.25 NT 46 PA 17.5°
HA 23° 15CrMo4

【Hob spec】

3-starts 16-gashes
Material : GRANMET SF, MACH11
Coating: Super Dry III

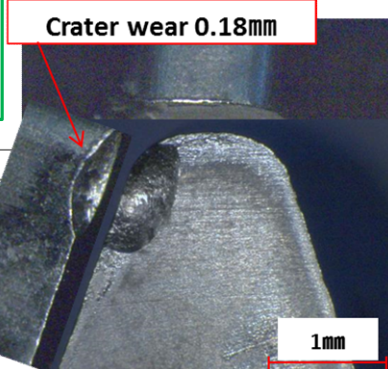
【Cutting condition】

Cutting speed **400m/min**
Ax feed 1.7mm/rev
Dry/No shift 40pcs.

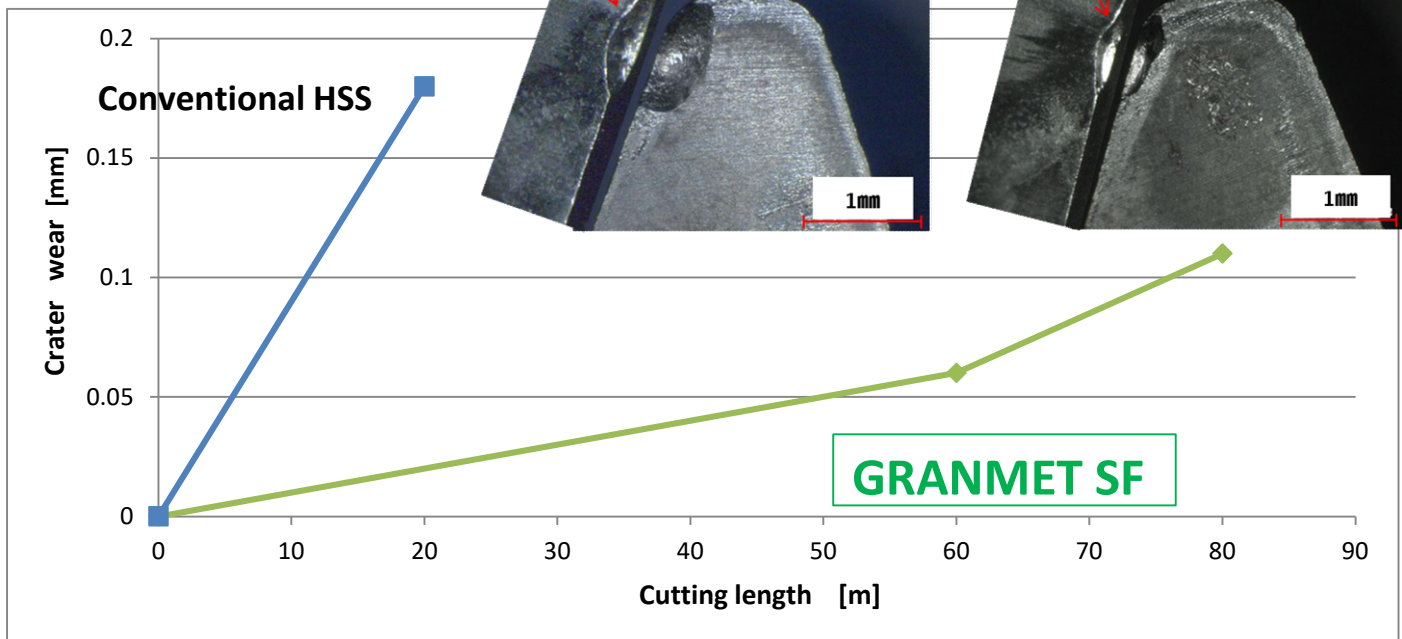
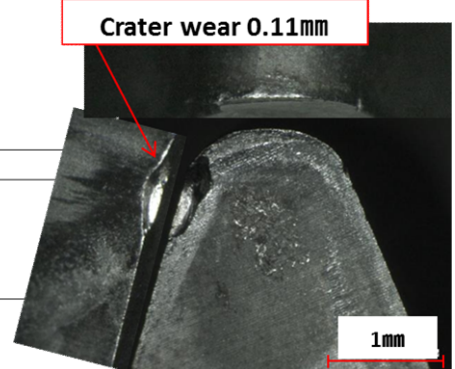
Tremendous improvement against crater-wear

**Tool Life 4 times
Wear 30% Down**

**Cutting length 20m
(No shift 10pcs.)**



**Cutting length 80m
(No shift 40pcs.)**



NIDEC MACHINE TOOL CORPORATION