

# MX-1 HOB

The resistance for the wear and the chipping get elevated to the next level.

### Characteristics

It combines the toughness of Powder HSS and the wear resistance of Dissolution HSS.

**Dissolution HSS** 

The carbide particle is bigger, so it has better wear resistance whereas the dropping off the particle leads the severe chipping.



Powder HSS

The carbide particle is smaller and evenly placed, so it has lesser wear resistance whereas the dropping off the particle doesn't lead the severe chipping.



The carbides are uniformly dispersed, and the particle size is maintained almost same as the dissolution HSS.

## Cutting result

#### [Workpiece Dimensions]

Module 2.25 PA 17.5°

NT 46 HA 23°

Material SCM415

[Hob Dimensions]

3 starts 16 flutes

MACH7 (HSS) / NEW MATERIAL MX-1

SuperDryIII PVD

(Coat on the cutting face and flank)

#### [Cutting Conditions]

Dry cut Cutting speed 250m/min Axial feed 2.4mm/rev Climb cut Cutting length 80m ( No shift)

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FLANK WEAR COMPRISON / mm

		NO9	NO10	NO11	NO12	
	MACH 7				HIPPING	>
	+ SuperDryIII	0.12	0.07	0.17	0.11	
$\langle$	NO CHIPPING					
	MX-1 + SuperDrylll		UNDER 0.05			