

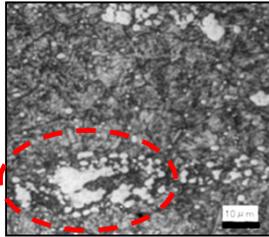
MACH11 HOB

This dissolution HSS provides excellent resistance against, heat, wear, and chipping.

● Characteristics

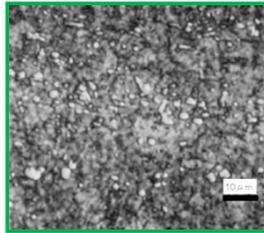
1. The fine particle with uniform placement enhances the chipping resistance.
2. Strengthening of substrate binding with salt heat treatment performs the resistance against chipping and wear.
3. The optimum heat treatment conditions leads the resistance against heat and wear.

Dissolution HSS



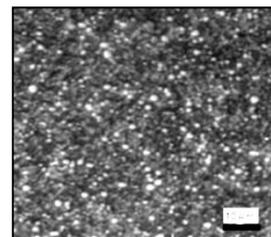
Forming coarse carbide particles over 10μm attracts severe chipping when the particles drop off.

MACH11



Forming the finest carbide particles uniformly as 10 μm or less.

Powder HSS



The finest carbide particles as (3 μm or less) are uniformly formed and excellent in chipping resistance however it has lower wear resistance than Dissolution HSS.

● Cutting result

Result 1 / Recoat use

[Part dimensions]

m2.25 PA17.5° 23° LH
NT46 SCM415

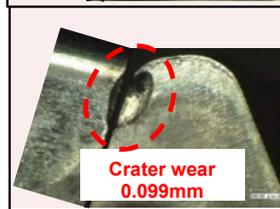
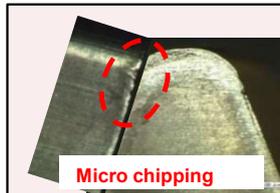
[Hob dimensions]

Φ75 × 150L
3starts 16flutes

[Cutting condition]

Cut speed 300m/min
Axial feed 2.4mm/rev
Cut length 40m
(Non shift)
Climb, Dry cut

MACH7/SuperDryIII



MACH11/SuperDryIII



Result 2 / Non Recoat use

[Part dimensions]

m2.25 PA17.5° 23° LH
NT52 SCM415

[Hob dimensions]

Φ75 × 150L
3starts 16flutes

[Cutting condition]

Cut speed 150m/min
Axial feed 2.4mm/rev
Cut length 50m
(Non shift)
Climb, Dry cut

