

## ES-CUT HOB SUCCESS REPORTS

Module	4.8		2.25		1.25		1.25		3		4		2.54	
Pressure Angle	22.5°		20°		20°		30°		20°		20°		12°	
Component teeth	39		32		68		26		45		17		114	
Face Width (mm)	31		10		8		18.5		19		43.5		168	
-	Existing	Proposed	Existing	Proposed	Existing	Proposed	Existing	Proposed	Existing	Proposed	Existing	Proposed	Existing	Proposed
Hob Material	ASP2052	<b>ES65</b>	Speed core	<b>ES90</b>	Speed core	<b>ES90</b>	Speed core	<b>ES90</b>	PM35	<b>ES65</b>	MACH-6	<b>ES65</b>	PM14	<b>ES65</b>
Coating	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro	Al Pro
Hob Size in mm (Diameter X Length X Bore)	100x180x3 2	90x180x3 2	60x160x27	60x160x2 7	60x160x27	60x160x2 7	55x160x27	55x160x2 7	90x180x4 0	90x180x4 0	90x180x4 0	90x180x4 0	90x180x4 0	90x180x4 0
Starts	2	1	3	3	3	3	1	1	2	2	2	1	4	4
Flutes	14	14	15	15	15	15	15	15	16	16	16	15	19	19
Cutting Speed	90/100	160/180	150	225	300	300	280	320	100/140	160	170/180	160	120	175
Axial Feed (mm / work revolution)	1.5/1.8	2.8/3.0	0.5	0.8	1.8	1.8	1.8	2.1	1.2/1.4	1.6	1.0/1.2	2	1.8	2
Cutting time (Seconds)	282	165	56	33	22	22	21	18	210	85	110	65	455	281
Life per sharpening (numbers)	600	950	6000	8100	7000	12000	9000	15000	1200	2000	500	1160	1200	1848
Time Reduction	-41%		-41%		0%		-14%		-60%		-41%		-38%	
Life Increase	58%		35%		71%		67%		67%		132%		54%	