

GRANMET SF + Mighty Shield Σ :

enhances your productivity

Shorter and shorter machining times are the most focusing requirement at time of gear cutting in In that case,
High speed material GRANMET SF and All-purpose coating Mighty Shield Σ is the solution.

PERFORMANCE

- > Capable of ultra-high-speed hobbing at a speed of 300 m/min or more,
- > Demonstrates performance in any cutting environment, dry or wet

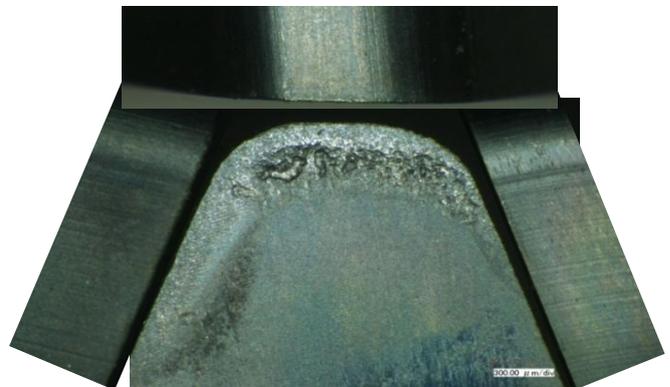
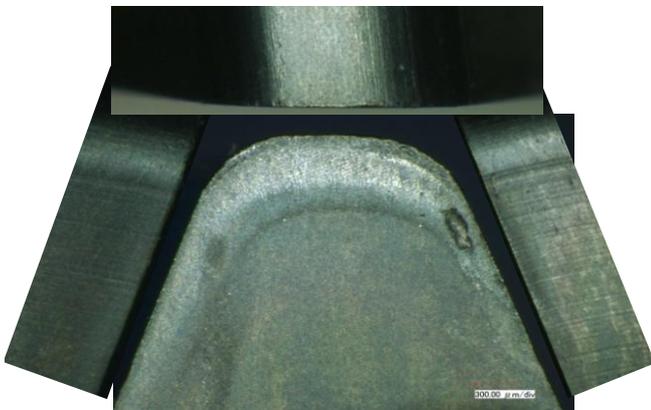
Part Spec		Tool Spec		Cutting condition	
Module	2.7	OD	ϕ 90	Cut speed	350 m/min
PA	20°	Starts	4	AX feed	2.3 mm/rev
HA	31° [RH]	Flutes	16	Hob shift	No shift
NT	69	Material	GRANMET SF	Nos of cut per	50 pcs
Width	25 mm	Coating	MightyShield Σ	Cutting length	100m
Material	SCM420H				

Dry cutting

Max. wear : 0.03mm

Wet cutting with
water-soluble cutting fluid

Max. wear : 0.02mm



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