

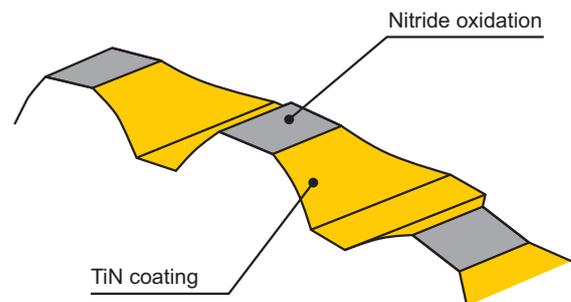
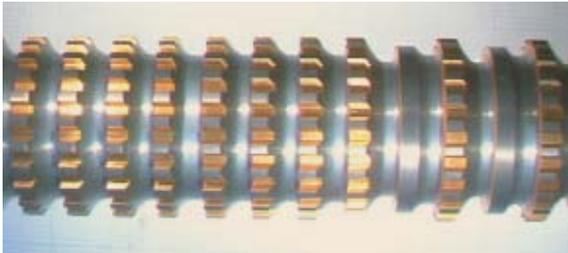
Gear Cutters

Tiger-Coat Spline Broach



Features

- Coating is only applied to the tooth face. In comparison to full coating, this results in lowering cutting resistance, reducing problems with surface finish and unstable dimensions.



Comparison of property with various type of surface treatment of a spline broach

	Adhesion resistance	Cutting resistance	Wear resistance	Finished surface quality
Non-coat	×	○	△	○
Nitride oxidation	△	○	○	○
TiN (coat)	◎	×	◎	△
Tiger-Coat	◎	○	○	○

Tiger-Coat Spline Broach

Machining Example

Gear Dimension

Module	1.0
Pressure angle	45°
Number of teeth	21
Cutting length	95 mm
Workpiece	JIS STKM15A

Broach Dimension

Outside dia	22.8 mm
Overall length	1120 mm

Result

Conventional broach (Nitride oxidation)	Adhesion on the tooth face is caused on at 400—1000 qty/reg.
Conventional broach (TiN)	Broaching is impossible due to over cutting force.
Tiger-Coat broach	Broaching is stably possible at 1500—2000 qty/reg.

For Your Safety

●Don't handle inserts and chips without gloves. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc. Ensure that the insert is correctly set in its location pocket. ●Before use, ensure that the tool setup and various settings (machining programme, etc) on the machine are suited to the tool specifications.

MITSUBISHI MATERIALS CORPORATION



MITSUBISHI MATERIALS CORPORATION Area Marketing & Operations Dept.

KFC bldg., 8F, 1-6-1, Yokoami, Sumida-ku, Tokyo 130-0015, Japan
TEL +81-3-5819-8772 FAX +81-3-5819-8774

MMC HARTMETALL GmbH

Comeniusstr.2, 40670, Meerbusch GERMANY
TEL +49-2159-9189-0 FAX +49-2159-918966

MITSUBISHI MATERIALS U.S.A. CORPORATION Headquarters

17401, Eastman Street, Irvine, California, 92614, USA
TEL +1-949-862-5100 FAX +1-949-862-5180

MMC METAL SINGAPORE PTE LTD.

10, Arumugam Road, #04-00 Lion Industrial Bldg.,409957, SINGAPORE
TEL +65-6743-9370 FAX +65-6749-1469

Mitsubishi Carbide Home page : <http://www.mitsubishicarbide.com>
(Tools specifications subject to change without notice.)