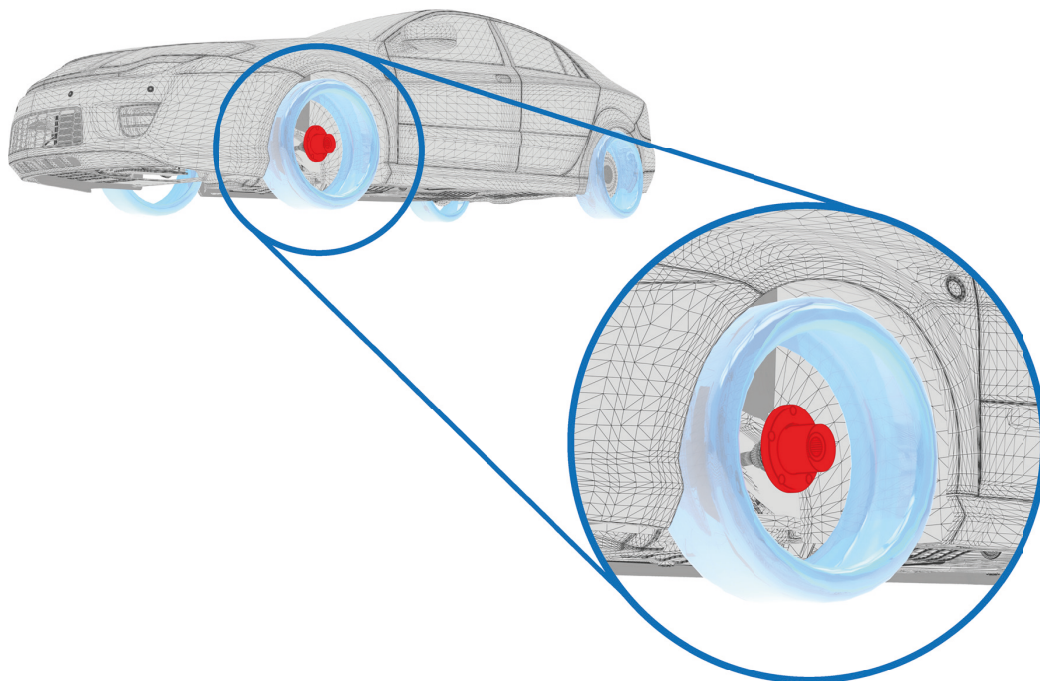


APPLICATION EXAMPLE ▶ Automotive ▶ Wheel hub



Task

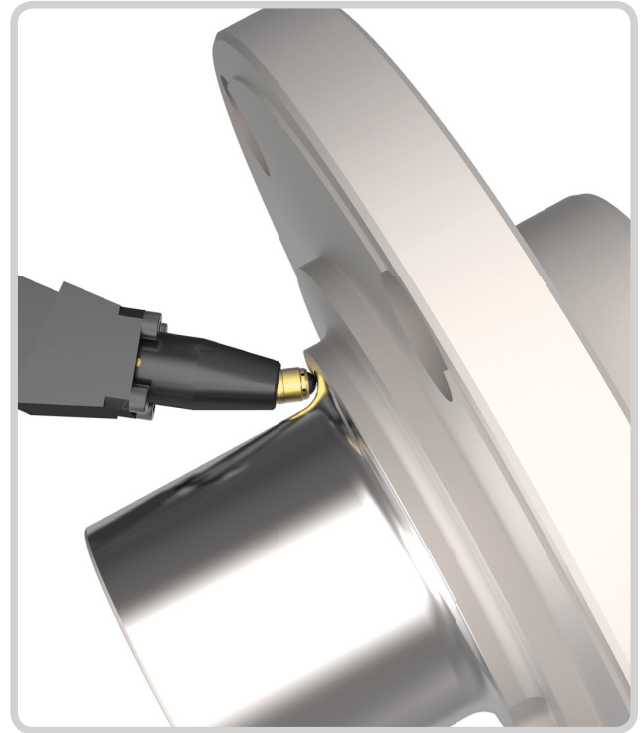
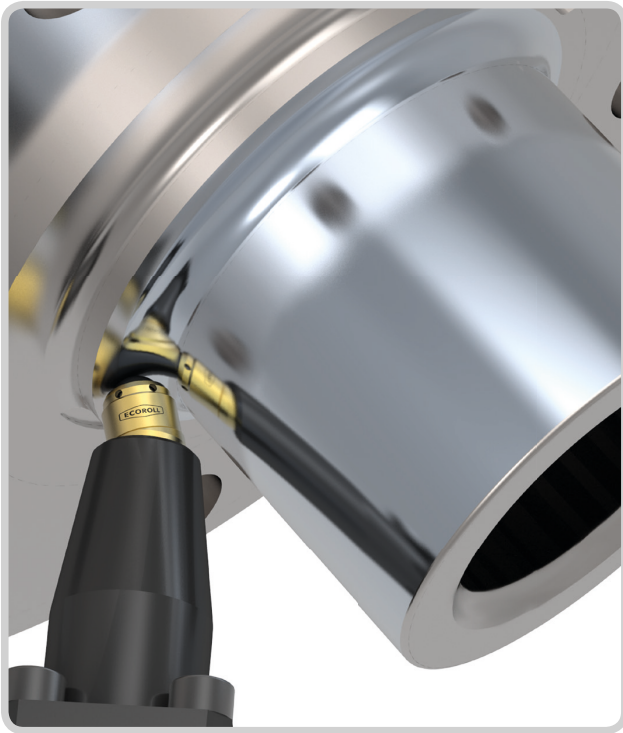
Achievement of fatigue strength on wheel hub





Solution

Deep rolling of transition radius and plane surface with HG6-9 tool



User benefit

- Achievement demanded **fatigue strength**
- Reduction of process costs by about **17 %**

Details

- Workpiece Wheel hub
- Part of Front axle
- Material Heat-treated steel
- Tensile strength 1000 N/mm²
- Hardness..... 32 HRC

Parameter

- Tool HG6-9R30°+ R90°
- Circumferential speed 150 m/min
- Feed rate 0,1 mm/rev.
- Rolling force 625 N / 250 bar