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RECENT DEVELOPMENTS IN SURFACE COATING TECHNOLOGIES FOR CUTTING TOOLS: A REVIEW

Vipin Sharma1 and Tilak Raj2

1 Department of Mechanical Engineering, J.C Bose University of Science and Technology YMCA, Faridabad, 121006, Haryana, India.

2 Tilak Raj. J.C Bose University of Science and Technology YMCA,
Faridabad, 121006, Haryana, India.
Phone: 9818562391. E-mail: TILAKRAJ64@rediffmail.com

Abstract

Coated cutting tool plays a vital role in high speed machining of hard materials and super alloys. In global and competitive world coated cemented carbide tools are frequently accepted. Surfaces coating increases the mechanical and thermo-physical properties of cutting tools. Coated tools can experience fundamentally higher cutting speed and feed which reduces machining time and expenses. The extraordinary wear resistance property broadens tool life which can fulfill the need of machining industry. Anisotropic properties of the tool materials influence tool life and depend upon the working conditions of the tool. Preconditioning of the tool surface, and coating are critical to control wear and fatigue .The present work shows the developments of coating technologies like PVD, CVD, PACVD, arc evaporation and sputtering. Some recently developed technologies are Scalable pulsed power plasma (S3P), Pulsed enhanced electron emission (P3E). Coating technologies can controlled the coating properties precisely such as hardness, structure, chemical and temperature, resistance, etc. In this thesis, I also focus on coating materials which are broadly classified in two types Monolayer coating (TiC, TiN,TiAlN, TiCN, CrN, ZrN, and more) and Multilayer coating (Ti-TiN-(TiCrAl)N, Zr-ZrN-(ZrCrAl)N, TiAlN/CrN , TiAlN-ZrNbN-CrN and more). This thesis gives detail overview on the coating materials with their properties and technologies for the film coating with the goal to provide a reference for further research.

Keywords: *Coating technologies, PVD, CVD, Monolayer coating, Multilayer coating, Pre and Post-treatment, Coating inspection.*

1. Introduction

Coated tool are generally used to build the cutting performance in the machining industry. The heat produced while machining can diminish the tool life and hinder the machined surface nature of the work piece. Coating innovation regularly used to secure the tool substrate, which is a successful method to expand the tool life. In regular machining, 80-85% of tools are coated to decrease wear. These covering upgrade tool life through a higher hardness, a higher abrasive wear, higher heat obstruction and a higher chemical stability .The cutting tool has two territory ,one is tool core zone and another is tool surface zone area. The property attractive at the surface: surface hardness, low friction, heat insulation, wear obstruction and synthetic inertness [1]. The part of the core material in cutting tool additionally assume an important part. Core material must hold the geometry. Core must have bulk hardness so it ought not experience any disfigurement. Coating of titanium nitride over the carbide device increase the performance, of coating material and enhancing its properties. Titanium diboride (TiB_2) coatings maintain the cutting capabilities with a high wear resistance at high speed machining. Due to the good surface adhesion, high hardness and the possibility to produce layers as small as 100 to 200 nm, it can enhance the quality of produced micro products or structures. The hardness of the coating is about 40% higher than that of the cemented carbide itself [2]. Tool coating structure decide the wear resistance and the tribological conditions in the contact zone. Coating structure depends on the coating material, layer growth during the process and structural design of single from multilayer [3].

1.1 Need of coating in cutting tool

Coating is essential to maintain the required cutting properties at elevated temperatures. Coating improves the tool life. Tungsten carbide coating increase the tool hardness .Cutting fluid is toxic in nature, by using coated cutting tools reduce the need of the coolant. Coated material can extract heat and lubricate the frictional area in the machining region. Soft coating like MoS_2 used to reduce the friction between the contact surfaces. The innovation of tool coating is constantly developing in the market for advancement of the machining capacity.

The importance of the coating are as follows:-

- Enhance the life of cutting tool.
- To improve the performance of machining.
- Reduce the requirement of coolant.
- To meet the growing demands for high productivity, quality and economy of machining.

1.1 1.2 Coating characteristics

Coating material should have following characteristics [58] :-

- High hardness (To resist wear at high temperature)
- Chemical stability and inertness (To resist wear)
- Low thermal characteristics (To prevent rise in tool temperature)
- Compatibility and good bonding (To prevent flaking)
- Little or no porosity (To provide high strength and integrity)

2. Type of coating

The different type of coating are:-

- Soft and Hard coating
- Hydrophobic and hydrophilic cutting tool coating
- Monolayer and Multilayer coating

2.1 Soft and Hard coating

With soft coatings, the purpose is to limit friction losses to a thin film of low shear strength intervened between the contacting surfaces. These coating reduce the coefficient of friction, but also confine the variation in friction which is unwanted in some applications **[4]**. Soft coatings are more susceptible to environmental factors, especially high humidity. Soft coatings have to go through extensive polishing after the lamination process. In soft coating manufacturing repeatability is low. Considerable thinning of the coating by plastic deformation will induce fracture of the substrate. Example of soft coating are Lead, MoS_2 and Graphite.

Hard coated films are produced utilizing a plasma deposition process that gives different advantages contrasted with soft coatings. Example of hard coating materials are generally nitrides, carbides, borides and the oxides of transition metals. Some of the coating materials are TiN, CrN, TiAlSiN, TiAlCrN and CBN.

2.2 Hydrophobic and hydrophilic cutting tool coating

Hydrophobic is a term used to explain a material that repels water. At the point when water is put on a surface with a hydrophobic coating it resist water droplet because it have a large contact angle. Hydrophobic coatings are non-polar in nature. Repulsive nature of hydrophobic coating is staying away the chips from the machined surface.

Hydrophilic coatings are precisely the inverse of hydrophobic. This influences the surface to pull in water and enables it to wet its surface. This high wet capacity causes a low contact point. This attribute can be connected to a surface by cleaning, actuating or by covering it with a thin hydrophilic layer. Hydrophilic coating benefits the cutting fluid to stick on the machined surface to cool the surface.

2.3 Monolayer and Multilayer coatings

Monolayer coatings are thin films which are stored on tool substrates with the end goal to enhance their surface properties, for example, hardness, friction, wear resistance, and corrosion resistance, while not changing properties of the bulk material. From a practical perspective the most critical coating properties are hot hardness, good bond to the substrate, and synthetic dependability. The coating performance can be additionally enhanced by ideal coating thickness, fine microstructure, and compressive residual stress. These properties can basically be satisfied just by ceramics materials. A monolayer layer on the surface of drill bits gives lubricity, heat resistance, and additionally corrosion resistance amid the drilling procedure. This outcomes in a more extended drill life than is obtained with typically uncoated drill tool. Ti-based coatings (titanium nitride (TiN), titanium carbon nitride (TiCN) and titanium aluminum nitride (TiAlN)) and diamond like-carbon (DLC) have been generally used to decrease the thrust force and to broaden the cutting life when drilling composite materials. The heat generation, heat segment, and heat conduction amid the machining depend fundamentally on instrument and work piece material, process parameters, and the material evacuates rate of the work piece. The large of number of hard mono layer coating utilized to improve the performance effectiveness of cutting procedure **[6].** These covering have great effect on wear obstruction and thermal stability. Covered devices are more compelling than uncoated instruments in lessening temperatures amid cutting. Al_2O_3 coating has preferable heat resistant boundary impact over TiN and TiC coatings **[1]**. The protection from wear, consumption, and oxidation of a tungsten carbide–cobalt material can be expanded by including 6– 30% of titanium carbide to tungsten carbide. Classical PVD layers like TiN, Ti–C–N, CrN, Ti–Al–N are based on a monolayer architecture where different features like structure, morphology, composition gradient, grain size and defects are influenced by the process parameters with an impact on the layer properties (e.g. hardness, phase stability, tribological properties). The incorporation of further additional elements opens new abilities to improve machining performance **[7].**

Table1 *– Properties of Monolayer coating*

Multilayered coatings are made out of an intermittently repeated structure of a thin layer of two or more materials. The application of multilayer coatings displays benefits in modifying stresses, upgrading substrate adhesion and improving the resistance for crack propagation. Additionally, a multifunctional coating design depending upon the alternating coating system is feasible. With the end goal to meet the prerequisites for a given cutting application, alteration of the layer composition and thickness is required. At the point when diverse alloyed systems are joined, each layer with improved compound and basic organization satisfies separate task to add to strengthening, controlled lubrication also, increase of oxidation resistance; it is accepted that modification of the diverse compositions and the control of the layer thicknesses will meet the necessities for given cutting applications. By developing of multilayer coatings making proper material combination wear, corrosion and oxidation resistance of hard coatings have been upgraded. The first multi-layer covering was delivered by CVD and after that PVD method. Nowadays, multilayer structure is utilized in a large portion of coatings industries. In multilayer coating each layer has particular capacity. External layer is wear opposition layer. Center layer is heat obstruction .Internal layer has great glue property **[15]**. The objective of multilayer coatings is to improve properties and performance of the coating by joining positive attributes of various coatings. As multilayered sandwich structure gives an increase in coating strength by methods for redirection and expanding of the crack energy between layers, the use of this structure has been helpful in cutting processes, for example, milling, where high dynamic loads exist.

Monolayer coating	Molar mass	Density	Modulus of elasticity	Melting point	Appearance	References
Titanium carbide	58.89 g/mol	4.93 g/cm^3	400 Gpa	3,160 ^{0}C	Black powder	[31]
Chromium nitride	66.003 g/mol	5.9 g/cm^3	200 Gpa	1770 ^{0}C	Black powder	[32]
Zirconium nitride	105.23 g/mol	7.09 g/cm^3	450 Gpa	2,952 ^{0}C	Yellow brown crystal	[33]
Titanium nitride	61.871 g/mol	5.22 g/cm^3	251 Gpa	2930 ^{0}C	Golden color	[34]
Titanium diboride	69.48 g/mol	4.52 g/cm^3	186.5 Gpa	3225 ^{0}C	Non lustrous metallic grey	[36]

2. 3. Surface coating technologies

Large number of processes are used to improve surfaces of tools and to improve their behavior and performance. Improvement of exploitative properties of ceramic cutting tools can be expert through production of hard coatings deposited by PVD and CVD techniques. In spite of the ongoing opinion, coating of hard ceramic tool materials is pointless, the improvement of such arrangements has been seen, in the field of logical research as well as in modern applications. Despite the fact that in modern applications on ceramic substrates CVD coatings still overwhelm, significant emphasis is put on look into research for the advancement of PVD strategies. The application of PVD techniques ranges over the wide variety of applications from decorative, to high temperature superconducting films. The thickness of the deposited layer can vary from angstroms to millimeters. Very high deposition rates (25µm/sec) have been achieved with the advent of electron beam heated sources**[19]**. In PVD techniques a lower temperature of the procedure is being utilized (in the run from 200 to 600 °C) than in the CVD technique (temperature can reach up to 1100 °C).

Types of surface coating technologies

1) CVD (chemical vapour deposition) based process
    - PACVD (plasma assisted chemical vapour deposition)
    - *MTCVD* (medium temperature chemical vapor deposition)
    - CVA (Chemical Vapor Aluminizing)

2) PVD (physical vapour deposition) based process
    - Arc Evaporation
    - Sputtering
    - Enhanced sputtering
    - S3p-Scalable pulsed power plasma
    - P3e-Pulse Enhanced Electron Emission

2.1 3.1 CVD (CHEMICAL VAPOUR DEPOSITION)

The term CVD outlines all strategies using gaseous precursor materials, which are introduced into a reaction chamber, to synthesize a coating. The vital surface reaction ordinarily is most often thermally initiated, for instance, by high temperatures or by laser assistance; however, kinetic activation by plasma in PACVD is utilized too. The feed of less steady precursor compounds (e.g., metal-organic CVD)induces chemical reactions that are initiated at lower temperatures, however the generally utilized halide precursor gases(e.g., $TiCl_4$, BCl_3, $AlCl_3$) are more steady and the deposition temperature regularly is in the scope of 950– 1150 ^{0}C(thermally activated CVD). Further, deposition are recognized, whether the reactor wall, the substrate, and the gas mixture are heated (hot-wall CVD, the reactor wall is also coated) or if just the substrate is heated (cold wall CVD).

a) PACVD (PLASMA-ASSISTED CHEMICAL VAPOUR DEPOSITION)

PACVD coating is stand for Plasma Assisted chemical vapor deposition. Plasma Assisted chemical vapor deposition actuates chemical reaction through plasma excitation and ionization. Utilizing this process, there is achievement deposition at temperature as low as around 200 ^{0}c utilizing pulsed glow or high frequency discharge. Working at these low temperatures permit the deposition of diamond like carbon (DLC) layers. DLC layers created utilizing PACVD are described by a low coefficient of friction and a scalable surface hardness. The set-up for this process is similar to sputtering, which is frequently used in combination with CVD. In PACVD, gas containing the coating elements is introduced into the vacuum chamber and a discharge powered by an AC voltage is ignited. This forms free hydrogen and carbon atoms (ions) that form a dense coating on the tools and components. Coating properties can be influenced by changing the applied voltage.

***Table 2** – Process basics of PACVD [47]*

Coating thickness	1 – 8 um
Hardness	1,000 – 3,500 HV
Temperature resistance	350 – 400 ^{0}C
Deposition temperature	180 – 350 ^{0}C

b) MTCVD (MEDIUM TEMPERATURE CHEMICAL VAPOR DEPOSITION)

Among the recently developed CVD coatings are those dependent on Ti, Zr, and Hf carbonitrides and combination thereof, kept at moderate temperatures, 700 to 900°C.The favorable circumstances of medium temperature CVD

(MTCVD) ZrCN and alloyed coatings of (Ti, Zr)CN for cutting tool applications. In general, MTCVD coatings have increased toughness and smoothness, over ordinary CVD coatings, without any degradation in wear and crater resistance.

All MTCVD coatings were deposited in the temperature extend 700 to 900°C at a reactor weight of 7.0 to 27.0 kPa (50 to 250 Torr).

c) CVA (CHEMICAL VAPOR ALUMINIZING)

CVA based on the CVD process and is utilized for the generation of diffusion aluminide coatings for high temperature applications. In the 900-1 050°C process, aluminum diffuses into the substrate to create intermetallic compounds — aluminides. The CVA process is intended to make homogeneous aluminide diffusion layers with controlled thickness, aluminum content and structure on extraordinary high temperature nickel composites. Both low and high activity aluminides can be saved on inner and outside areas of components. CVA process is capable of delivering precursors for the deposition of complex coatings with the addition of Cr, Si, Co, Hf, Y and different components.

The aluminides offer exceptional protection from high temperature oxidation and corrosion. Along these lines, they are appropriate for corrosion protection of blades in the hot section of turbines.

2.2 3.2 PVD (PHYSICAL VAPOUR DEPOSITION)

In PVD, physical injection of materials as atoms or molecules and condensation of these molecules onto the substrate. PVD stands for Physical Vapour Deposition. It is a process done at a high vacuum and at temperatures between 150 and 500 °C. In the PVD process the high purity coating material (metals such as titanium, chromium and aluminum) is either evaporated by heat or by bombing with ions (sputtering).**[48]** A uniform coating thickness is produce by rotating the parts at a uniform speed about several axes. In the1990s, PVD had a big impact in coating of metal cutting tool and new coating materials, for example, TiCN, TiAlN and TiB_2, were presented. The primary use for PVD is still in applications where sharp edges are required (threading, parting, grooving, end-milling, and so on.) and in applications with levels of popularity on a tough cutting edges (drilling). In strong carbide tools (end-mills and drills) PVD is the standard coating technology.

Coating properties (such as hardness, structure, chemical and temperature resistance, and adhesion) can be specifically controlled by the PVD process. PVD processes include Arc evaporation, Sputtering, and Enhanced sputtering. A strong driving force to discover coatings that could be deposited at lower temperatures with the end goal to enable tool with more keen edges to be coated with no embrittlement impact. The solution was PVD where statement temperature regularly can be kept around 500 ^{0}C.[48]. The principal PVD covering material to have a business application was TiN. Sandvik Coromant presented its first TiN covered instruments - the delta penetrate - in 1982. The principal review - GC 1020 - for insert was presented in 1990 and was particularly produced for threading. This was a normal for the primary PVD covered evaluations - they were regularly created as issue solvers for activities with special demand.

a) Arc Evaporation process

Arc Evaporation is a form of physical vapour deposition (PVD Coating).In this process, an arc is generated ranging from microns to just a few tenths of a micron, is spread over the s metallic coating

Material affecting it to evaporate. The high currents and power densities used to complete ionization of the evaporated material and, thereby, the formation of a high-energy plasma. The metal ions combine with a reactive gas such as argon that is passing into the chamber, strike the target tools or components with high energy which are deposited as a thin and highly adherent coating.

The metal to be evaporated is placed at a solid block (target) against inside of vacuum chamber. A discharge is ignited and runs on the target, leaving a footprint. Small spots of few um diameter target material are evaporated. The movement of arc can be guided by magnets.**[45]**

The evaporated, ionized material is used as plasma coating on a product which rotate inside the vacuum chamber. Arc coating are used as tool coating and component coating.

b) Sputtering process

In all PVD forms, the parts in the vacuum chamber to be covered are first heated, and afterward ion etched by bombing with argon particles, to make a pure and clean metal surface, free from any contamination - a essential condition for optimal coating adhesion.

A high negative voltage is then connected to the sputtering sources, which contain the coating material. The subsequent electrical gas release leads the arrangement of positive argon particles, which are accelerated towards, and atomize the coating material. Dissipated, atomized metal in the vaporous stage at that point responds with a gas containing the non-metallic component of the hard covering. The final product is the deposition of a thin, compact coating with the desired structure and composition.

c) Magnetron Sputtering

Magnetron sputtering is a form of PVD coating. Magnetron sputtering is a plasma coating process in which sputtering material is ejected due to bombardment of ions to the marked surface. The vacuum chamber of the PVD coating machine is filled with an inert gas like argon. By applying a high voltage, a discharge is created, resulting in acceleration of ions to the marked surface and a plasma coating. The argon ion will eject sputtering material from the marked material (sputtering), outcomes is sputtered coating layer on the products in front of the target. The plasma is confined nearby the cathode, argon ions cannot reach the substrate therefore magnetron sputtering does not damage the substrate and provides lower heating of its surface. The deposition rate of magnetron sputtered hard coatings reduced with increase of N_2 partial pressure [19].

d) Enhanced Sputtering

Enhanced sputtering employs a low-voltage arc discharge in the center of the chamber to create a plasma intensity several times greater than the basic sputtering procedure, and thus to produce a much higher degree of particle ionization in the gaseous phase.

e) S3p-Scalable pulsed power plasma or HIPIMS (High power impulse magnetron sputtering)

The high power connected to the metal target in HiPIMS permits a high level of ionization of the sputtered material giving expanded vitality at the substrate that prompts without pinhole, dense thin coating. In HiPIMS, the deposition flux is restricted by the duty cycle and electric field-driven attraction of metal ions back to the target. This leads to low deposition rates in comparison with those accomplished in traditional DC sputtering which is a generally recognized limitation of HiPIMS.

f) P3e-Pulse Enhanced Electron Emission

This progressive procedure allows for any conventional hard coating to be joined with an aluminum-oxide-based coating, which empowers coating properties to be changed over a remarkably wide range. Utilizing P3e coating technology, Blazers was the primary organization on the planet to store hard corundum composed aluminum-oxide based coatings in a PVD procedure at temperatures altogether underneath 600 °C. Such coatings could beforehand just be delivered by CVD at considerably higher temperatures. The CVD process is anyway connected with a danger of embrittlement for a few evaluations of solidified carbides, and it is difficult to utilize it to coat steels. P3e was fundamentally produced for tool, however they are additionally appropriate for mechanical components when both insulating properties and high temperature and corrosion resistance are required. P3e innovation depends on arc evaporation and pulse technology and can be kept running in a pure oxygen environment. Pulse current controls electron discharge and plasma thickness. The support layer and the aluminum oxide-based layer are applied in a single pass at temperatures well underneath 600°C. P3e technology permits the deposition of any metal oxide (Al_2O_3, ZrO_2, Cr_2O_3, Ta_2O_5, and so forth.) and any combination of metal oxides.

2.3 4. Pre-treatment processes

Mechanical surface pre-treatment by processes can improve the tribological properties and adhesion of coating systems. The purpose of using various pre-treatments was to produce substrate surfaces with varieties of surface roughness and morphology. In conclusion, the studied treatment processes gave coatings with good performance that are possible candidates for forming and cutting tools [20].

Some important process are –

- Micro shot peening
- Polishing and buffing

2.3.1 4.1 Micro shot peening

Micro shot peening is a cold working process which involves the bombardment of material surface utilizing minute spherical projectile. The projectile are referred to as shot. The shot is coordinated on to the surface of the material at high speed utilizing such methods of compressed impact or by centrifugal force from rotating wheel. Micro shot peening process was applied to a series of a standard rapid steel twist drills, carbide inserts for milling cutters, turning tools and EPDM (Ethylene Propylene Diene Monomers) material. Micro shot peening is proved to be a useful process in enhancing the life of cutting tool. The mechanical properties of the substrates will give the type of treatment, i.e. Duration of application, shot hardness and velocity in order to get maximum benefits from this process [21].

2.3.2 4.2 Polishing and buffing

Polishing and buffing are finishing processes for smoothing a work piece's surface utilizing a abrasive and a work wheel or a leather strop. Technically polishing refers to forms that utilization a grating that is glued to the work wheel, while buffing utilizes a loose abrasive connected to the work wheel. Polishing is a more forceful process while buffing is less harsh, which prompts a smoother, more brilliant finish. A typical misguided judgment is that a polish surface has a mirror bright finish, anyway most mirror bright finishes are really buffed. Polishing is regularly used to improve the appearance of a item, prevent contamination of instruments, remove oxidation, make an reflective surface, or prevent corrosion in pipes. In metallography and metallurgy, polishing is utilized to make a flat, defect free surface for examination of a metal's microstructure under a magnifying instrument like microscope. Silicon-based polishing pad or a diamond solution can be utilized in the polishing process.

2.4

2.5

2.6 4.3 Post-treatment processes

Post-treatment of coating surfaces improve erosion and corrosion resistance and cutting performance. In conclusion, the studied treatment processes gave coatings with good performance that are possible candidates for forming and cutting tools [20].The effect post-treatment processes on coating properties is an important factor to optimize the performance of hard coatings.

Some important process are –

- Plasma nitriding
- Argon Plasma etching

2.6.1 4.4 Plasma nitriding

Plasma nitriding/nitro-carburising is an advanced thermochemical treatment which is completed in a mixture of nitrogen, hydrogen and a optional carbon spending gas. In this low pressure process, a voltage is connected between the batch and the furnace wall. A spark release with a high ionization level (plasma) is created around the parts. At first glance zone that is specifically charged by the ions, nitrogen-rich nitrides are framed and decompose, discharging active nitrogen into the surface. Because of this system shielding is effortlessly done by covering the concerning areas with a metal blanket. Plasma nitriding permits adjustment of the surface as per the desired properties. Plasma nitriding pre-treatment of substrates prior to the AlCrSiN coatings resulted in superior adhesion strength [20].Typical applications include transmission gears, cold forming tools, injectors and plastic mould tools, long shafts, axis, clutch .crankshafts, camshafts, cam followers, valve parts, extruder screws, pressure die casting tools, forging dies, and engine parts. The use of special Cr and Al alloyed nitriding steels gives a large benefit as plasma nitriding generates a surface hardness of more than 1000 HV.

2.6.2 4.5 Argon plasma etching

Plasma etching is the material removal by plasma processes. It is additionally referred to as dry etching, since conventional etching processes are done with wet-chemical corrosive acids. The plasma of the process gases convert the material to be etched from the solid to the gaseous and the vacuum pump removes the gaseous products. The utilization of mask can likewise guarantee the etching of just parts of the surface or structures. The substrate pretreatment is performed in an argon glow discharge plasma whereby contamination is sputtered away by bombardment with Ar+ ions, which are accelerated towards the substrate with energies in the range of several hundred ev.[22]. Plasma etching is just executed as low-pressure plasma because

- Significant etching effects require longer treatment times.
- Almost all etching gases used in low-pressure plasma.

There are many applications for plasma etching. For application-specific optimization of the etching process a variety of possible process gases and the selection of 3 basic etching methods are available [24].

3. 5. Coating inspection techniques

A quality inspection is required after coating the cutting tools in every step of the manufacturing process. The quality inspection consist four areas of inspection are :-

- Layer thickness
- Layer adhesion
- Layer construction and structure
- Layer composition and distribution.

Some important techniques are-

- Transmission electron microscopy (TEM)
- scanning electron microscope(SEM)
- X-RAY photoelectron spectroscopy (XPS)
- X-ray powder diffraction (XRD)
- Micro Scratch Testing
- Pin on disc test

5.1 Transmission Electron Microscopy (TEM)

Transmission electron microscopy (TEM, also called as conventional transmission electron microscopy or CTEM) is a microscopy system in which a beam of electrons is transmitted through a specimen to form an image. The specimen is frequently a ultrathin area under 100 nm thick or a suspension on a grid. A image is shaped from the intersection of the electrons with the sample as the beam is transmitted through the specimen. The image is then amplified and focused onto an imaging device, such as a fluorescent screen.

3.1 5.2 Electron Microscope Scanning (SEM)

A scanning electron microscope (SEM) is a kind of electron microscope that produces images of an sample by scanning the surface with a focused beam of electrons. The electrons interact with atoms in the sample, creating different signals that contain information about the surface topography and composition of the sample. The electron beam is scanned in a raster scan pattern, and the position of the bar is combined with the detected signal to produce an image. SEM can achieve better to 1 nanometer. specimen are seen in high vacuum in traditional SEM, or in low vacuum or wet conditions in variable pressure or environment SEM, and at an wide variety of cryogenic or elevated temperatures with specialized instruments.

3.2 5.3 X-RAY Photoelectron spectroscopy (XPS)

X-RAY photoelectron spectroscopy (XPS) is a surface-sensitive quantitative spectroscopic technique that estimates composition at the parts per thousand range, empirical formula, chemical state and electronic state of the elements that exist within a material [26]. XPS is a valuable measurement technique be it not just shows what components are inside a film yet in addition what different components they are limited to. This implies in the event that you have a metal oxide and you need to know whether the metal is in a +1 or +2 state, utilizing XPS will enable you to find that proportion. Anyway at most the instrument will just test 20nm into an sample.

3.3 5.4 X-RAY Powder diffraction (XRD)

X-RAY powder diffraction (XRD) is a fast analytical technique fundamentally used for phase identification of a crystalline material and can give information on unit cell measurement. At that point material is finely ground, make uniform and average bulk composition is evaluated. Max von Laue, in 1912, discovered that crystalline substances go about as 3-dimensional diffraction gratings for X-beam wavelengths like the dispersing of planes in a crystal lattice.

5.5 Micro scratch testing

Amid Micro Scratch Testing, a cone shaped spherical tip, crystal of WC, is drawn over the coated surface with an expanding load, bringing about different types of failure at particular critical loads. Micro scale Scratch Adhesion Testing recognizes critical loads optically utilizing an inherent video magnifying instrument. These critical loads are utilized to evaluate the adhesive and cohesive properties of various film/substrate mixes. Moreover, failure points can be resolved utilizing frictional force and depth estimations. Depth estimations give the plastic and elastic portion of the distortion. Consistent load scratch testing can be utilized, in mapping, to check the surface uniformity. Genuine Depth Measurements dependent on giving exact elastic and plastic deformation [27].

3.4 5.6 Pin on disc test

A pin on disc tribometer comprises of a stationary pin that is normally loaded against a rotating disc. The pin can have any shape to simulate a particular contact, but spherical tips are regularly used to simplify the contact geometry. The coefficient of friction is dictated by the proportion of the frictional power to the loading power on the pin [28]. The pin on disc test has demonstrated valuable in giving a basic wear and grating test for low friction coatings, for example, diamond like carbon coatings on valve train components in internal combustion. Pin on disc wear testing is a strategy for describing the coefficient of friction, frictional force and rate of wear between two materials. As an Particularly versatile technique for testing wear resistance, Pin on disc can be designed in different situations relying upon goals of different task. Pin on disc testing can simulate different wear modes, including unidirectional, bidirectional, omnidirectional and quasi rotational wear.

4. 6. Conclusion

From this literature, the heat produce during machining can reduce the tool life. The coating can enhance the tool life through higher hardness, higher abrasive wear resistance, high heat obstruction and higher chemical stability. Noteworthy research is required for improvement new coating structures, which can give a reasonably good life at fast machining operation.

The following conclusion can be drawn from this research progress review –

1. The cutting tool has two zone, one is tool core zone and another is tool surface zone. Properties required for tool surface are surface hardness, low friction, heat insulation, wear opposition and chemical inertness. Tool core zone must hold the geometry. Tool has high bulk hardness.
2. Soft coating is used to reduced the coefficient of friction and low shear strength interposed between the contacting surfaces. Whereas hard coating is used to hardened the tool surface which is produce by plasma nitriding.
3. Hydrophobic coating is coating which is used to stay away the hot chips through the workpiece. Chips are not adhere to surface. Hydrophilic coating is coating which is used for sticking of cutting fluid.
4. The thickness of TiC coating increases monotonically with annealing time. The coating thickness reaches 23 mm when annealed for 10 h. Compared to the uncoated titanium alloy (~400 HV0.05), the coating hardness is improved by 5 times.
5. In AlTiN coating, As the %of Al increase lead to a softening of the coating due to formation of the hexagonal wurtizite phase.
6. Three coating systems, including single-layer AlCrSiN coatings, two-layer CrSiBN/CrN coatings, and single-layer TiAlN coatings were deposited using an arc evaporation system.
7. The deposition rate of magnetron sputtered hard coatings decreases with increase of N_2 partial pressure. It give excellent layer uniformity.
8. Shot peening was performed using steel balls and ceramic beads of 40 µm in diameter.
9. Plasma nitriding was performed using a mixture of nitrogen and hydrogen gases. The N2:H2 ratio was 1:100 for 100-µm-thick nitriding layer and 1:1 for 20-µm thick nitriding layer.
10. TEM is used to observe modulation in chemical identity, crystal orientation, electronic structure and sample induced electron phase shift and additionally regular absorption based imaging.
11. X-ray powder diffraction (XRD) is analytical technique primarily utilized for phase identification of a crystalline material and can give data on unit cell measurements
12. Micro scratch tester is used to estimate the depth. Depth estimations give the plastic and elastic portion of the distortion.
13. Pin on disc test is used to measure the coefficient of friction of the surface. The coefficient of friction is dictated by the proportion of the frictional power to the loading power on the pin.

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