



(22) Date de dépôt/Filing Date: 2000/01/25

(41) Mise à la disp. pub./Open to Public Insp.: 2001/07/25

(45) Date de délivrance/Issue Date: 2006/05/09

(51) Cl.Int./Int.Cl. *B24D 3/14* (2006.01),
C04B 41/52 (2006.01), *C04B 41/50* (2006.01)

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(54) Titre : OUTIL DE COUPE FABRIQUE DE MATERIAU FRITTE A BASE DE cBN ENDUIT D'Al₂O₃

(54) Title: CUTTING TOOL MADE OF Al₂O₃-COATED cBN-BASED SINTERED MATERIAL

(57) **Abrégé/Abstract:**

A cutting tool according to the present invention is coated with one or more Al₂O₃ layers on at least a part of the surface of a cBN-based sintered material substrate taking part in cutting. The sintered material substrate is made of cBN in an amount of from 20% to 99% by volume and Al₂O₃ having an average crystalline particle diameter of not more than 1 µm in an amount of from not less than 1.0% to less than 10% by volume. The Al₂O₃ layer has a thickness (d) of from 0.5 µm to 50 µm. The average crystalline particle diameter (s) of Al₂O₃ is from 0.01 µm to 4 µm if the thickness (d) of the Al₂O₃ layer is from 0.5 µm to 25 µm or from not less than 0.01 µm to not more than 10 µm if the thickness (d) of the Al₂O₃ layer is from more than 25 µm to 50 µm.

ABSTRACT OF THE DISCLOSURE

A cutting tool according to the present invention is coated with one or more Al_2O_3 layers on at least a part of the surface of a cBN-based sintered material substrate taking part in cutting. The sintered material substrate is made of cBN in an amount of from 20% to 99% by volume and Al_2O_3 having an average crystalline particle diameter of not more than 1 μm in an amount of from not less than 1.0% to less than 10% by volume. The Al_2O_3 layer has a thickness (d) of from 0.5 μm to 50 μm . The average crystalline particle diameter (s) of Al_2O_3 is from 0.01 μm to 4 μm if the thickness (d) of the Al_2O_3 layer is from 0.5 μm to 25 μm or from not less than 0.01 μm to not more than 10 μm if the thickness (d) of the Al_2O_3 layer is from more than 25 μm to 50 μm .

CUTTING TOOL MADE OF Al_2O_3 -COATED CBN-BASED SINTERED MATERIAL**BACKGROUND OF THE INVENTION****1. Field of the Invention**

The present invention relates to a cutting tool made of
5 a cubic boron nitride (CBN) sintered material substrate coated
with Al_2O_3 . More particularly, the present invention relates
to a cutting tool made of Al_2O_3 -coated CBN-based sintered
material having improved wear resistance and breakage
resistance.

2. Description of the Related Art

Al_2O_3 is a material optimum for cutting iron-based
materials because of its excellent chemical stability and
hardness. However, Al_2O_3 exhibits a poor toughness. Therefore,
a cutting tool mainly composed of Al_2O_3 has a deteriorated
15 stability against tool failure to disadvantage. In order to
overcome this difficulty, a cutting tool consisting of a
cemented carbide substrate having a relatively excellent
toughness coated with Al_2O_3 has been commercialized.

In recent years, there is a growing need for high speed
20 and efficiency and dry cutting in response to the trends of
environment-friendly production. In the conventional tools,
however, the cemented carbide substrate deforms excessively
plastically at high cutting temperature, resulting in that the
coating layer easily peels off or is destroyed.

25 As a means for solution to the problems, a method for
coating a CBN-based sintered material excellent in high
temperature hardness with Al_2O_3 has been proposed in JP-A-
59-8679 (The term "JP-A" as used herein means an "unexamined

published Japanese patent application"). However, since the
adhesion between cBN-based sintered material and Al_2O_3 coating
layer is insufficient and the optimization of the crystallinity
of Al_2O_3 is insufficient, a remarkable enhancement of wear
5 resistance and breakage resistance is not exhibited in cutting
of hard materials such as hardened steel or high speed and
efficiency cutting of steel.

SUMMARY OF THE INVENTION

10 It is an object of the present invention to provide a
cutting tool which exhibits an excellent flank wear resistance
and crater wear resistance particularly in cutting of high
hardness difficult-to-cut ferrous materials or high speed and
efficiency cutting of steel.

15 A cutting tool according to the present invention is
coated with one or more Al_2O_3 layers on at least a part of the
surface of a cBN-based sintered material substrate taking part
in cutting. The sintered material substrate comprises cBN in
an amount of 20% to 99% by volume and Al_2O_3 having an average
20 crystalline particle diameter of not more than 1 μm in an amount
of not less than 1.0% to less than 10% by volume. The Al_2O_3 layer
has a thickness (d) of 0.5 μm to 50 μm . The average crystalline
particle diameter (s) of Al_2O_3 is from 0.01 μm to 4 μm if the
thickness (d) of the Al_2O_3 layer is from 0.5 μm to 25 μm (0.5
25 $\mu\text{m} \leq d \leq 25 \mu\text{m}$), and that of Al_2O_3 is from 0.01 μm to 10 μm if
the thickness (d) of the Al_2O_3 layer is from more than 25 μm
to 50 μm ($25 \mu\text{m} < d \leq 50 \mu\text{m}$).

The incorporation of a proper amount of Al_2O_3 in a CBN-based sintered material substrate makes it possible to increase the adhesion of the Al_2O_3 layer or interlayer made of TiCxNyOz having an excellent bonding power with Al_2O_3 , thereby enhancing the cutting properties. A particularly preferred content of Al_2O_3 is from 3.0% to less than 5.0%. The reason why the adhesion of the Al_2O_3 layer or interlayer can be thus increased is presumably as follows:

(1) Al_2O_3 constituting the coating layer and TiCxNyOz undergo nucleation with Al_2O_3 contained in CBN-based sintered material substrate as a starting point; and

(2) the incorporation of Al_2O_3 in CBN-based sintered material substrate causes the residual stress characteristic to CBN-based sintered material substrate to change, thereby relaxing misfit of coating layer to residual stress (thermal stress, internal stress).

The homogeneous incorporation of fine Al_2O_3 particles having a particle diameter of not more than 1 μm in CBN-based sintered material substrate makes it possible to accelerate the formation of fine homogeneous nuclei during the formation of Al_2O_3 or TiCxNyOz layer and hence form an Al_2O_3 layer having an excellent crystallinity and adhesion. If the content of Al_2O_3 falls below 1.0% by volume, it causes uneven nucleation during the formation of coating layer, thereby exerting an insufficient effect. On the contrary, if the content of Al_2O_3 exceeds 10% by volume, the mechanical properties inherent to Al_2O_3 is presumably reflected in the mechanical properties of CBN-based sintered material, thereby drastically

deteriorating the breakage resistance of cBN-based sintered material substrate.

The Al_2O_3 layer is preferably mainly composed of $\alpha\text{-Al}_2\text{O}_3$. The coating of cBN-based sintered material substrate with $\alpha\text{-Al}_2\text{O}_3$ with a good adhesion makes it possible to inhibit wear on relieve face and crater wear and hence drastically prolong the life of tool. The coating of cBN-based sintered material substrate with $\kappa\text{-Al}_2\text{O}_3$ with a good adhesion, too, makes it possible to inhibit crater wear and prolong the life of tool. However, wear on relieve face can be little inhibited.

Further, the Al_2O_3 layer can be oriented on (012), (104), (110), (113), (024) or (116) plane with an orientation index of not less than 1.0 to form a coating layer excellent in wear resistance and strength. This orientation index can be defined by the following equation. The method for determining orientation index is described also in W096/15286 (PCT/SE95/01347), etc.

$$\text{TC}(\text{hkl}) = \text{I}(\text{hkl})/\text{Io}(\text{hkl}) \times [(1/n)\Sigma\{(\text{hkl})/\text{Io}(\text{hkl})\}]^{-1}$$

where $\text{I}(\text{hkl})$: Intensity of (hkl) diffraction ray in XRD;

$\text{Io}(\text{hkl})$: Diffraction intensity in ASTM card of XRD; and

n : Number of diffraction rays used in calculation ((hkl) diffraction rays used are (012), (104), (110), (113), (024) and (116))

In the foregoing cutting tool, the Al_2O_3 layer may be complexed with the TiCxNyOz layer to form a laminate. Specific examples of the composite structure include (1) structure comprising an interlayer made of TiCxNyOz formed on the interface of Al_2O_3 layer with cBN-based sintered material

substrate, (2) structure comprising a TiCxNyOz layer provided interposed between a plurality of Al_2O_3 layers, and (3) structure comprising a TiCxNyOz layer provided as an outermost layer.

Referring to the reason why the thickness of the Al_2O_3 layer is defined to a range of from 0.5 μm to 50 μm , if the thickness of the Al_2O_3 layer falls below the lower limit, the resulting coating effect is insufficient. On the contrary, if the thickness of the Al_2O_3 layer exceeds the upper limit, the coating layer is more liable to peeling, chipping or breakage.

The thickness of the Al_2O_3 layer is preferably from about 3 to 40 μm . In particular, if the thickness of the Al_2O_3 layer is not more than 25 μm and the average crystal particle diameter (s) of Al_2O_3 is from 0.01 μm to 4 μm , the resulting product is excellent in flank wear resistance. If the thickness of the Al_2O_3 layer is more than 25 μm and the average crystal particle diameter (s) of Al_2O_3 is from 0.01 μm to 10 μm , the resulting product is excellent in crater wear resistance. If there are a plurality of Al_2O_3 layers, the total thickness of these Al_2O_3 layers is used to see whether the thickness of the Al_2O_3 layer is not more than 25 μm .

The formation of the foregoing Al_2O_3 layer or TiCxNyOz layer can be accomplished by CVD method such as thermal CVD method, plasma CVD method and moderate temperature CVD method or PVD method such as sputtering method and ion plating method.

On the other hand, the sintered material substrate is composed of cBN and a binder phase. If the content of cBN is not less than 20% by volume, the production of a thick binder phase which forms a mechanically weak point can be inhibited.

The binder phase is preferably made of at least one of nitride, carbide and boride of metals belonging to the groups 4a, 5a and 6a in the periodic table and mutual solid-solution thereof as a main component besides Al_2O_3 . The binder phase may further
5 contains at least one of Al and Si incorporated therein. For the preparation of the sintered material substrate, a plasma sintering apparatus, hot press, ultrahigh pressure sintering apparatus, etc. may be used.

Since the cutting tool according to the present invention
10 is made of a CBN-based sintered material substrate mainly composed of CBN having a hardness next to diamond, it exhibits an excellent plastic deformation resistance. Further, the coating with $\alpha\text{-Al}_2\text{O}_3$, which is chemically stable, having a controlled structure makes it possible to improve crater
15 resistance without causing chipping or peeling. Accordingly, the cutting tool according to the present invention exhibits a prolonged life in cutting of high hardness materials such as hardened steel or high speed and efficiency cutting of steel, which is impossible with existing tools due to the rise in
20 cutting temperature.

DETAILED DESCRIPTION OF THE INVENTION

The present invention will be described in detail referring to the following specific examples.

25 (Example 1)

CBN-based sintered material substrates shaped according to SNGN120408 (ISO Specification) having different formulations set forth in Table 1 were prepared. Subsequently,

these cBN-based sintered material substrates were each coated with Al_2O_3 by an ordinary CVD method under the conditions set forth in Table 2 (Condition 1) and Table 3 (Condition 2). In some of these inserts, a $\text{TiC}_{0.5}\text{N}_{0.5}$ layer is provided by an ordinary CVD method as an interlayer between the cBN-based sintered material substrate and the Al_2O_3 layer.

Table 1

No.	Particle size (μm)		Composition (vol-%)	
	cBN	Al_2O_3	Others	Al_2O_3
A	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 15	0
B	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 14.1	0.9
C	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 14	1.0
D	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 11	4.0
E	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 6	9.0
F	≤ 8	< 1	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 5	10
G	≤ 8	1 - 1.5	cBN: 45; TiN: 30; TiB_2 : 5; AlN: 5; impurities such as W and Co: 11	4.0

Table 2

Details of Al_2O_3 coating method

Gas introduced	Step 1	Step 2
CO_2 (%)	-	5
AlCl_3 (%)	-	5
CO (%)	-	-
H_2S (%)	-	0.1
HCl (%)	-	5
H_2 (%)	100	74.9
Pressure (Torr)	80	80
Temperature ($^{\circ}\text{C}$)	920	920
Processing time (min)	10	1,000

Table 3

Details of Al₂O₃ coating method

Gas introduced	Step 1	Step 2	Step 3
CO ₂ (%)	5	5	5
AlCl ₃ (%)	—	5	5
CO (%)	2.5	2.5	—
H ₂ S (%)	—	—	0.1
HCl (%)	—	0.8	5
H ₂ (%)	92.5	86.7	74.9
Pressure (Torr)	80	80	80
Temperature (°C)	920	920	920
Processing time (min)	10	30	1,000

The Al₂O₃-coated sintered materials thus obtained were then each analyzed by electron microscope (SEM: scanning electron microscope) and EDS (energy-disperse X-ray spectroscopy). As a result, the Al₂O₃ layer was found to have a thickness of 25 μ m and contain Al₂O₃ particles having an average particle diameter (S) of 4.5 μ m.

The cutting tools made of Al₂O₃-coated cBN-based sintered material thus prepared were then each precisely examined for the conditions of face and flank taking part in cutting by XRD (X-ray diffraction). As a result, κ -Al₂O₃ was found to have been formed under Condition 1 set forth in Table 2. Under Condition 2 set forth in Table 3, α -Al₂O₃ which is oriented on (012) plane with an orientation index TC(012) of 1.1 was found to have been formed. The orientation index was determined by the previously described equation.

Subsequently, these inserts were each evaluated for cutting properties. Referring to the cutting conditions, the material to be cut was a round rod according to SUJ2 with a hardness HRC 65 having a V-shaped groove at two points along the longitudinal periphery thereof. The cutting speed was 150

m/min. The depth of cut was 0.2 mm. The feed rate was 0.1 mm/rev. The cutting was effected in a dry process. For the evaluation of cutting properties, a stereomicroscope and a surface profile measuring instrument were used to measure flank wear width and crater wear depth and observe how the insert had been worn. For comparison, a commercially available cBN-based sintered material for cutting hardened steel free of Al_2O_3 coating layer was similarly evaluated. The results are set forth in Table 4.

10

Table 4

Cutting properties of Al_2O_3 -coated cBN-based sintered material

No.	cBN-based sintered material substrate	Coating conditions	Flank wear width during 1 km cutting (μm)	Crater wear depth during 1 km cutting (μm)	Life against tool failure
1	A	Condition 2	-	-	Al_2O_3 layer peeled at 0.5 km
2	A	Interlayer + Condition 2	-	-	Al_2O_3 layer peeled at 0.6 km
3	B	Condition 2	41	12	Al_2O_3 layer peeled at 1.5 km
4	B	Interlayer + Condition 2	40	12	Al_2O_3 layer peeled at 1.4 km
5	C	Condition 2	40	11	Broken together with substrate at 5 km
6	C	Interlayer + Condition 2	40	12	Broken together with substrate at 5 km
7	D	Condition 2	38	11	Broken together with substrate at 8 km
8	D	Condition 1	58	13	Broken together with substrate at 4 km
9	E	Condition 2	42	12	Broken together with substrate at 7 km
10	F	Condition 2	59	12	Broken together with substrate at 3 km
11	G	Condition 2	41	12	Al_2O_3 layer peeled at 1.2 km
12*	D	Not coated	60	22	Broken at 3 km
13*	Commercially available cBN-based sintered material tool for cutting hardened steel		61	27	Broken at 3 km

*:Comparative Example

Summarizing Table 4, the following results were obtained.

If the substrate is free of Al_2O_3 or the content of Al_2O_3 falls below 1% by volume (Nos. 1 - 4), the adhesion of the coating layer is insufficient and a remarkable improvement of tool life cannot be observed. On the contrary, even if the content of Al_2O_3 is not less than 10% by volume (No. 10), the resulting improvement is insufficient. If the content of Al_2O_3 falls below 1.0% by volume, it causes uneven nucleation during coating, exerting an insufficient effect. On the contrary, if the content of Al_2O_3 is not less than 10%, the mechanical properties inherent to Al_2O_3 is presumably reflected in the mechanical properties of cBN-based sintered material, drastically deteriorating the breakage resistance of cBN-based sintered material substrate.

On the other hand, as can be seen in the results of Nos. 5, 6, 7 and 9, the incorporation of a proper amount of Al_2O_3 in a cBN-based sintered material substrate makes it possible to increase the adhesion of the Al_2O_3 layer or interlayer made of TiCxNyOz having an excellent bonding strength with Al_2O_3 , enhancing the cutting properties. The reason why the adhesion of the Al_2O_3 layer or interlayer can be thus increased is presumably as follows:

(1) Al_2O_3 constituting the coating layer and TiCxNyOz undergo nucleation with Al_2O_3 contained in cBN-based sintered material substrate as a starting point; and

(2) the incorporation of Al_2O_3 in cBN-based sintered material substrate causes the residual stress characteristic to cBN-based sintered material substrate to change, relaxing

misfit of coating layer to residual stress (thermal stress, internal stress).

If the particle diameter of Al_2O_3 particles in the substrate exceeds $1\text{ }\mu\text{m}$ (No. 11), the adhesion of Al_2O_3 coating layer is insufficient. This is because the homogeneous incorporation of finely divided Al_2O_3 particles having a particle diameter of not more than $1\text{ }\mu\text{m}$ in CBN-based sintered material substrate makes it possible to accelerate the formation of fine homogeneous nuclei during the formation of Al_2O_3 or TiC_xNyO_z layer and hence form an Al_2O_3 layer having an excellent crystallinity and adhesion.

As can be seen in the comparison of Nos. 7 and 8, the Al_2O_3 layer is preferably mainly composed of $\alpha\text{-Al}_2\text{O}_3$. The coating of CBN-based sintered material substrate with $\alpha\text{-Al}_2\text{O}_3$ with a good adhesion makes it possible to inhibit wear on relieve face and crater wear and hence drastically prolong the life of tool. The coating of CBN-based sintered material substrate with $\kappa\text{-Al}_2\text{O}_3$ with a good adhesion, too, makes it possible to inhibit crater wear and prolong the life of tool. However, wear on relieve face can be little inhibited.

(Example 2)

CBN-based sintered material substrates containing CBN particles having an average particle diameter of not more than $2\text{ }\mu\text{m}$ and Al_2O_3 particles having an average particle diameter of less than $1\text{ }\mu\text{m}$ incorporated therein were each coated with TiCN and TiN by an ordinary CVD method, and then coated with Al_2O_3 by the same CVD method as in Example 1. During this procedure, the disposition of the CBN-based sintered material,

the film-forming temperature, the carrier gas concentration, etc. were adjusted. In this manner, various cutting tools made of Al_2O_3 -coated cBN-based sintered material set forth in Tables 5, 6 and 7 were prepared.

5 These cutting tools made of Al_2O_3 -coated cBN-based sintered material were then each precisely examined for the conditions of face and flank taking part in cutting by XRD. As a result, it was found that an α - Al_2O_3 coating layer having TC(hkl) of not less than 0.9 had been formed. TC(hkl) is the
10 maximum orientation index of (hkl) plane among (012), (104), (110), (113), (024) and (116) planes.

Table 5

No.	Composition of cBN-based sintered material (vol-%)	Constitution of coating layer *1 (μm)	TC(hkl) *2	S *2
1	cBN: 55; TiN: 25; α - Al_2O_3 ; 0.9; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
2	cBN: 55; TiN: 25; α - Al_2O_3 ; 1.0; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
3	cBN: 55; TiN: 25; α - Al_2O_3 ; 1.0; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer/ $\text{TiC}_{0.5}\text{N}_{0.5}$ columnar crystal inhibition layer/ Al_2O_3 layer: 14/2/14	TC(012) 2	2.5
4	cBN: 55; TiN: 25; α - Al_2O_3 ; 1.0; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiN}_{0.5}$ surface layer	TC(012) 2	4.5
5	cBN: 55; TiN: 25; α - Al_2O_3 ; 3.0; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiN}_{0.5}$ surface layer	TC(012) 2	4.5
6	cBN: 55; TiN: 25; α - Al_2O_3 ; 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
7	cBN: 55; TiN: 25; α - Al_2O_3 ; 5.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
8	cBN: 55; TiN: 25; α - Al_2O_3 ; 9.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
9	cBN: 55; TiN: 24; α - Al_2O_3 ; 10.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5

* 1: Texture coefficient of α - Al_2O_3

* 2: Average crystal particle diameter of α -Al₂O₃

Table 6

No.	Composition of cBN-based sintered material (vol-%)	Constitution of coating layer *1 (μ m)	TC(hkl) *2	S *2
10	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 52	TC(012) 2	4.5
11	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 50; TiC _{0.5} N _{0.5} interlayer: 1	TC(012) 2	4.5
12	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 55; TiC _{0.5} N _{0.5} interlayer: 1	TC(012) 2	4.5
13	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 50; TiC _{0.5} N _{0.5} interlayer: 1	TC(012) 2	10
14	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 50; TiC _{0.5} N _{0.5} interlayer: 1	TC(012) 2	12
15	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 30	TC(012) 0.9	3.0
16	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 30	TC(012) 1.0	3.0
17	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 30	TC(012) 2	3.0
18	cBN: 55; TiN: 25; α -Al ₂ O ₃ : 4.5; TiB ₂ : 5; AlN: 5; impurities	Al ₂ O ₃ layer: 30	TC(012) 2.5	3.0

* 1: Texture coefficient of α -Al₂O₃

* 2: Average crystal particle diameter of α -Al₂O₃

Table 7

No.	Composition of cBN-based sintered material (vol-%)	Constitution of coating layer *1 (μm)	TC(hkl) *2	S *2
19	cBN: 20; TiN: 60; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(012) 2	4.5
20	cBN: 18; TiN: 60; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiC}_{0.5}\text{N}_{0.5}$ interlayer: 1	TC(012) 2	4.5
21	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiC}_{0.5}\text{N}_{0.5}$ interlayer: 1	TC(104) 2	4.5
22	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiC}_{0.5}\text{N}_{0.5}$ interlayer: 1	TC(116) 2	4.5
23	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30; $\text{TiC}_{0.5}\text{N}_{0.5}$ interlayer: 1	TC(110) 2	4.5
24	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(113) 2	4.5
25	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 30	TC(024) 2	4.5
26	Uncoated cBN sintered material/cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities			
27	Comparative: commercially available Al_2O_3 -coated cemented carbide for cutting steel			
28	Comparative: commercially available TiCN-coated cermet for cutting steel			

* 1: Texture coefficient of $\alpha\text{-Al}_2\text{O}_3$

* 2: Average crystal particle diameter of $\alpha\text{-Al}_2\text{O}_3$

5 Subsequently, these inserts were each evaluated for cutting properties. Referring to the cutting conditions, the material to be cut was a round rod according to SMC435 with a hardness HRC of 20 having a V-shaped groove at two points along the longitudinal periphery thereof. The cutting speed was 600
10 m/min. The depth of cutting was 0.5 mm. The feed rate was 0.5 mm/rev. The cutting was effected in a dry process. For the evaluation of cutting properties, a stereomicroscope and a surface profile measuring instrument were used to measure wear and observe how the insert had been worn. For comparison, a
15 commercially available sintered material for cutting hardened

steel free of Al_2O_3 coating layer was similarly evaluated. The results are set forth in Tables 8 and 9.

Table 8

Results of evaluation of cutting properties of various cutting
5 tools made of Al_2O_3 -coated cBN-based sintered material

No.	Flank wear width during 1 km cutting (μm)	Crater wear depth during 1 km cutting (μm)	Form of wear during 1 km cutting	Tool life
1	-	-	-	Coating layer peeled and broken at 0.5 km
2	140	7	Slightly chipped	Lost together with substrate at 5.5 km
3	140	7	Smooth	Broken together with substrate at 7 km
4	140	7	Slightly chipped	Broken together with substrate at 5.5 km
5	140	7	Slightly chipped	Broken together with substrate at 7 km
6	140	7	Slightly chipped	Broken together with substrate at 7 km
7	140	7	Slightly chipped	Broken together with substrate at 6 km
8	145	7	Slightly chipped	Broken together with substrate at 5.5 km
9	145	7	Slightly chipped	Broken together with substrate at 1.5 km
10	-	-	-	Peeled during film forming
11	140	8	Slightly chipped	Broken together with substrate at 6.5 km
12	140	12	Slightly chipped	Coating layer broken at 1.5 km
13	140	7	Slightly chipped	Broken together with substrate at 5.5 km
14	140	7	Drastically chipped	Coating layer broken at 1.8 km

Table 9

Results of evaluation of cutting properties of various cutting tools made of Al_2O_3 -coated CBN-based sintered material

No.	Flank wear width during 1 km cutting (μm)	Crater wear depth during 1 km cutting (μm)	Form of wear during 1 km cutting	Tool life
15	205	17	Slightly chipped	Cutting not allowed due to excessive wear at 2 km
16	150	9	Slightly chipped	Broken together with substrate at 5.5 km
17	130	6	Smooth	Broken together with substrate at 7.5km
18	125	5	Smooth	Broken together with substrate at 8 km
19	140	7	Slightly chipped	Broken together with substrate at 4.5 km
20	142	8	Slightly chipped	Broken together with substrate at 3.0 km
21	138	7	Slightly chipped	Broken together with substrate at 7 km
22	139	8	Slightly chipped	Broken together with substrate at 7 km
23	141	7	Slightly chipped	Broken together with substrate at 7 km
24	142	7	Slightly chipped	Broken together with substrate at 7 km
25	139	7	Slightly chipped	Broken together with substrate at 7 km
26	210	21	Smooth	Cutting not allowed due to excessive wear at 2 km
27	-	-	-	Substrate plastically deformed to cause peeling and breakage of coating layer at 1.4 km
28	250	-	Slightly chipped	Cutting not allowed due to excessive wear at 1.5 km

As compared with the conventional CBN-based sintered material tool, coated CBN-based sintered material tool, coated cemented carbide tool for cutting steel and TiCN-coated thermet, the examples of the present invention made of an $\alpha\text{-Al}_2\text{O}_3$ coating layer having TC(hkl) of not less than 1.0, TC(hkl) indicating the maximum orientation index of (hkl) plane among (012), (104), (110), (113), (024) and (116) planes, show a drastic improvement of flank wear resistance and crater wear resistance.

The reason why the examples of the present invention show a drastic improvement of flank wear resistance and crater wear resistance is presumably as follows:

5 α - Al_2O_3 is more excellent in mechanical properties such as hardness and toughness on (012), (104), (110), (113), (024) and (116) planes than on other crystal faces; and

10 Al_2O_3 grows as a columnar crystal. By allowing the columnar crystal to undergo orientation growth rather than random growth, the introduction of defects due to mechanical interference between crystalline particles can be inhibited, drastically enhancing the toughness of the coating layer.

On the other hand, the cutting tool of No. 15 having an orientation index $\text{TC}(012)$ of 0.9 exhibits a deteriorated wear resistance, showing no improvement of tool life.

15 When the thickness of the Al_2O_3 layer, if provided alone, exceeds 50 μm (No. 10), the cutting tool is liable to cracking or peeling, showing a drastic deterioration of cutting properties. On the other hand, the provision of a TiCxNyOz layer as an interlayer on the interface of the CBN-based
20 sintered material substrate with the Al_2O_3 coating layer makes it possible to inhibit the occurrence of cracking or peeling at the Al_2O_3 coating layer (No. 10). This is presumably because misfit of CBN-based sintered material substrate to the residual stress of the coating layer is relaxed by the TiCxNyOz layer
25 as an interlayer. However, even if the foregoing interlayer is interposed between the layers, when the thickness of the Al_2O_3 layer exceeds 50 μm (No. 12), the resulting cutting properties are drastically deteriorated similarly.

As in Example 1, the homogeneous incorporation of fine Al_2O_3 particles having a particle diameter of not more than 1 μm in CBN-based sintered material substrate makes it possible to accelerate the formation of fine homogeneous nuclei during the formation of Al_2O_3 or TiC_xNyO_z layer and hence form an Al_2O_3 layer having an excellent crystallinity and adhesion. The thickness of all the Al_2O_3 coating layers are defined to be not less than 25 μm . It can be presumed from Nos. 5 and 17 that if the average crystal particle diameter (s) of $\alpha\text{-Al}_2\text{O}_3$ particles constituting the $\alpha\text{-Al}_2\text{O}_3$ coating layer is great under these conditions, the resulting product exhibits a deteriorated toughness. It can also be presumed from Nos. 13 and 14 that if the thickness of the $\alpha\text{-Al}_2\text{O}_3$ coating layer is not more than 50 μm , when the average crystal particle diameter (s) of $\alpha\text{-Al}_2\text{O}_3$ particles constituting the $\alpha\text{-Al}_2\text{O}_3$ layer exceeds 10 μm , the $\alpha\text{-Al}_2\text{O}_3$ coating layer can be remarkably broken.

The comparison of Nos. 1 to 9 shows that if the content of Al_2O_3 falls below 1.0% by volume, it causes uneven nucleation sparsely scattered during the formation of coating layer. Thus, the content of Al_2O_3 needs to be not less than 1.0% by volume. In particular, if the content of Al_2O_3 is not less than 3%, the resulting cutting tool exhibits an excellent adhesion. On the contrary, if the content of Al_2O_3 exceeds 5% by volume, the density of nuclei thus formed is too great, causing the introduction of defects into the crystal due to mutual mechanical interference during the growth of Al_2O_3 or TiC_xNyO_z and hence deteriorating the toughness of the coating layer. In particular, if the content of Al_2O_3 exceeds 10%, the mechanical

properties inherent to Al_2O_3 is presumably reflected in the mechanical properties of CBN-based sintered material, drastically deteriorating the breakage resistance of CBN-based sintered material substrate. Accordingly, the content of Al_2O_3 in the CBN-based sintered material substrate is preferably from not less than 1.0% by volume to less than 10% by volume, more preferably from not less than 3% by volume to less than 5% by volume.

If the content of CBN in the CBN-based sintered material substrate falls below 20% by volume (No. 20), the resulting effect of CBN, which is inherently excellent in mechanical properties such as hardness and toughness, is presumably lessened, drastically deteriorating the breakage resistance of the CBN-based sintered material substrate.

The Al_2O_3 -coated tool according to the present invention, even if coated with a single α - Al_2O_3 layer, exhibits a better toughness than the conventional Al_2O_3 -coated tools. In particular, the α - Al_2O_3 coating layer of No. 3 provided as a columnar crystal inhibition layer between Al_2O_3 layers has fine columnar crystal particles homogeneously oriented and thus exhibits an excellent toughness. Accordingly, the α - Al_2O_3 coating layer of No. 3 presumably can be smoothly worn without slightly chipping itself and shows a prolonged life against loss as compared with other α - Al_2O_3 coating layers.

(Example 3)

CBN-based sintered material substrates made of CBN particles having an average particle diameter of not more than 5 μm and Al_2O_3 particles having an average particle diameter

of less than 1 μm incorporated therein were each coated with Al_2O_3 by the same CVD method as in Example 1. During this procedure, the disposition of the cBN-based sintered material, the film-forming temperature, the carrier gas concentration, etc. were adjusted. In this manner, various cutting tools made of Al_2O_3 -coated cBN-based sintered material set forth in Table 10 were prepared.

These cutting tools made of Al_2O_3 -coated cBN-based sintered material were then each precisely examined for the conditions of face and flank taking part in cutting by XRD. As a result, it was found that an $\alpha\text{-Al}_2\text{O}_3$ coating layer having TC(hkl) of not less than 0.9 had been formed. TC(hkl) is the maximum orientation index of (hkl) plane among (012), (104), (110), (113), (024) and (116) planes.

15

Table 10

No.	Composition of cBN-based sintered material (vol-%)	Constitution of coating layer *1 (μm)	TC(hkl) *2	S *2
1	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(012) 1.8	0.5
2	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(104) 1.8	0.5
3	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(116) 1.8	0.5
4	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(110) 1.8	0.5
5	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(113) 1.8	0.5
6	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(024) 1.8	0.5
7	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(104) 0.9	0.5
8	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(104) 1.1	0.5

* 1: Texture coefficient of $\alpha\text{-Al}_2\text{O}_3$

* 2: Average crystal particle diameter of $\alpha\text{-Al}_2\text{O}_3$

Table 11

No.	Formulation of cBN-based sintered material (vol-%)	Constitution of coating layer *1 (μm)	TC(hkl) *2	S *2
9	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 4	TC(104) 2.3	0.5
10	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 7	TC(104) 1.8	0.5
11	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 25	TC(104) 1.8	0.5
12	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 25	TC(104) 1.8	4.0
13	cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities	Al_2O_3 layer: 25	TC(104) 1.8	4.5
14	Uncoated cBN sintered material/cBN: 55; TiN: 25; $\alpha\text{-Al}_2\text{O}_3$: 4.5; TiB_2 : 5; AlN: 5; impurities			
15	Comparative: commercially available Al_2O_3 -coated cemented carbide for cutting steel			
16	Comparative: commercially available Al_2O_3 -TiC-based ceramics for cutting steel			

* 1: Texture coefficient of $\alpha\text{-Al}_2\text{O}_3$

* 2: Average crystal particle diameter of $\alpha\text{-Al}_2\text{O}_3$

Subsequently, these tips were each evaluated for cutting properties. The cutting conditions were the same as used in Example 2. In some detail, the material to be cut was a round rod according to SMC435 with a hardness HRC of 20 having a V-shaped groove at two points along the longitudinal periphery thereof. The cutting speed was 600 m/min. The depth of cut was 0.5 mm. The feed rate was 0.5 mm/rev. The cutting was effected in a dry process. For the evaluation of cutting properties, a stereomicroscope and a surface profile measuring instrument were used to measure wear and observe how the insert had been worn. For comparison, a commercially available sintered material for cutting hardened steel free of Al_2O_3 coating layer was similarly evaluated. The results are set forth in Table 12.

Table 12

Results of evaluation of cutting properties of various cutting tools made of Al_2O_3 -coated cBN-based sintered material

No.	Flank wear width during 1 km cutting (μm)	Crater wear depth during 1 km cutting (μm)	Form of wear during 1 km cutting	Tool life
1	110	15	Smooth	Broken together with substrate at 4.5 km
2	110	15	Smooth	Broken together with substrate at 4.5 km
3	110	14	Smooth	Broken together with substrate at 4.5 km
4	110	13	Smooth	Broken together with substrate at 4.5 km
5	110	14	Smooth	Broken together with substrate at 4.5 km
6	100	14	Smooth	Broken together with substrate at 4.5 km
7	200	17	Slightly chipped	Cutting not allowed due to excessive flank wear at 2.5 km
8	120	15	Smooth	Broken together with substrate at 4 km
9	100	15	Smooth	Broken together with substrate at 5 km
10	100	11	Smooth	Broken together with substrate at 5 km
11	100	7	Smooth	Broken together with substrate at 5 km
12	120	8	Smooth	Broken together with substrate at 5.5 km
13	145	7	Slightly chipped	Broken together with substrate at 4.5 km
14	210	20	Smooth	Cutting not allowed due to excessive wear at 1.9 km
15	-	-	-	Substrate plastically deformed to cause peeling and loss at 1.3 km
16	-	-	Slightly chipped	Heavily broken at 0.1km

The results in Table 12 gave the following discoveries.

- 5 The comparison of Nos. 11 to 13 shows that as the average crystal particle diameter of $\alpha\text{-Al}_2\text{O}_3$ particles constituting the $\alpha\text{-Al}_2\text{O}_3$ coating layer increases, the wear resistance and the smoothness of the worn surface are deteriorated. This is presumably attributed to the low toughness of coarse-grained $\alpha\text{-Al}_2\text{O}_3$. If
- 10 the thickness of the $\alpha\text{-Al}_2\text{O}_3$ coating layer is not more than 25 μm , when the average crystal particle diameter of $\alpha\text{-Al}_2\text{O}_3$

particles exceeds 4 μm , the resulting product exhibits a drastically deteriorated wear resistance. The product of No. 7, which exhibits TC(104) of less than 1.0, exhibits an excessive flank wear and thus shows a reduced tool life.

5 As compared with Example 2, Example 3 exhibits an increased crater wear mainly attributed to thermal wear by the factor corresponding to the reduction of the thickness of the $\alpha\text{-Al}_2\text{O}_3$ coating layer, which is excellent in thermal stability. However, Example 3 exhibits a reduction in flank wear mainly
10 attributed to mechanical wear by the factor corresponding to the reduction of the average crystal particle diameter of the $\alpha\text{-Al}_2\text{O}_3$ particles. Thus, the product of Example 3 shows a smoothly worn surface.

 Accordingly, in cutting requiring high dimensional
15 precision or high surface integrity, it is preferred that the thickness (d) of the $\alpha\text{-Al}_2\text{O}_3$ coating layer be from 0.5 μm to 25 μm ($0.5 \mu\text{m} \leq d \leq 25 \mu\text{m}$) and the average crystal particle diameter (s) of the $\alpha\text{-Al}_2\text{O}_3$ particles be from 0.01 μm to 4 μm . If the life against tool failure is emphasized, it is preferred
20 that the thickness (d) of the $\alpha\text{-Al}_2\text{O}_3$ coating layer be from 25 μm to 50 μm ($25 \mu\text{m} < d \leq 50 \mu\text{m}$) and the average crystal particle diameter (s) of the $\alpha\text{-Al}_2\text{O}_3$ particles be from 0.01 μm to 10 μm .

 As mentioned above, the present invention has the following effects:

25 (1) The incorporation of a proper amount of Al_2O_3 in the CBN-based sintered material substrate makes it possible to control the density of nuclei formed during the formation of Al_2O_3 coating layer and the crystallinity of the Al_2O_3 coating

layer thus formed and hence produce an Al_2O_3 coating layer having an excellent adhesion to the substrate and a good crystallinity.

(2) An Al_2O_3 coating layer oriented on (012), (104), (110), (113), (024) and (116) planes having an excellent
5 wear resistance and strength can be formed on the surface of the tool to be abraded by the material to be cut.

(3) The coated sintered material having the foregoing effects (1) and (2) can provide a cutting tool which exhibits a prolonged life in cutting of iron-based high hardness
10 difficultly-cuttable materials or high speed and efficiency cutting of steel, which can be effected over a reduced period of time or impossible with existing tools due to the rise in cutting temperature.

What is claimed is:

1. A cutting tool made of Al_2O_3 -coated CBN-based sintered material comprising:

CBN-based sintered material substrate;

5 one or more Al_2O_3 layers coating said CBN-based sintered material on at least a part of a surface of said CBN-based sintered material substrate taking part in cutting;

wherein said sintered material substrate comprises CBN in an amount of from 20% to 99% by volume and Al_2O_3 having an
10 average crystalline particle diameter of not more than 1 μm in an amount of from not less than 1.0% to less than 10% by volume, said Al_2O_3 layer has a thickness (d) of from 0.5 μm to 50 μm , and the average crystalline particle diameter (s) of Al_2O_3 is from 0.01 μm to 4 μm if the thickness (d) of said Al_2O_3 layer
15 is from 0.5 μm to 25 μm ($0.5 \mu\text{m} \leq d \leq 25 \mu\text{m}$) or the average crystalline particle diameter (s) of Al_2O_3 is from 0.01 μm to 10 μm if the thickness (d) of said Al_2O_3 layer is from more than 25 μm to 50 μm ($25 \mu\text{m} < d \leq 50 \mu\text{m}$).

20 2. The cutting tool made of Al_2O_3 -coated CBN-based sintered material according to claim 1, wherein said CBN sintered material substrate comprises Al_2O_3 in an amount of from not less than 3.0% to less than 5.0% by volume.

25 3. The cutting tool made of Al_2O_3 -coated CBN-based sintered material according to claim 1, wherein said Al_2O_3 layer comprises $\alpha\text{-Al}_2\text{O}_3$ as a main component.

4. The cutting tool made of Al_2O_3 -coated cBN-based sintered material according to claim 1, wherein said Al_2O_3 layer comprises α - Al_2O_3 having an orientation index $\text{TC}(012)$ of not less than 1.0, $\text{TC}(104)$ of not less than 1.0, $\text{TC}(110)$ of not less than 1.0, $\text{TC}(113)$ of not less than 1.0, $\text{TC}(024)$ of not less than 1.0 or $\text{TC}(116)$ of not less than 1.0 and said orientation index is defined by the following equation:

$$\text{TC}(\text{hkl}) = I(\text{hkl})/I_0(\text{hkl}) \times [(1/n)\sum\{I(\text{hkl})/I_0(\text{hkl})\}]^{-1}$$

where $I(\text{hkl})$: Intensity of (hkl) diffraction ray in XRD;

10 $I_0(\text{hkl})$: Diffraction intensity in ASTM card of XRD; and

n : Number of diffraction rays used in calculation ((hkl) diffraction rays used are (012), (104), (110), (113), (024) and (116))

15 5. The cutting tool made of Al_2O_3 -coated cBN-based sintered material according to any one of claims 1 to 4, further comprising an interlayer made of TiC_xNyO_z provided at the interface of said Al_2O_3 with said cBN-based sintered material substrate.

20

6. The cutting tool made of Al_2O_3 -coated cBN-based sintered material according to any one of claims 1 to 4, wherein a plurality of Al_2O_3 layers are provided, each of which are laminated with a TiC_xNyO_z layer interposed therebetween; and
25 the total thickness of the plurality of Al_2O_3 layers is used as the thickness of said Al_2O_3 layer.

7. The cutting tool made of Al_2O_3 -coated cBN-based sintered material according to any one of claims 1 to 4, wherein a TiC_xNyO_z layer is coated as an outermost layer thereof.

5 8. The cutting tool made of Al_2O_3 -coated cBN-based sintered material according to claim 1, wherein said cBN-based sintered material substrate comprises cBN and a binder phase, and said binder phase comprises at least one selected from the group consisting of nitride, carbide and boride of metals
10 belonging to the groups 4a, 5a and 6a in the periodic table and mutual solid-solution thereof.