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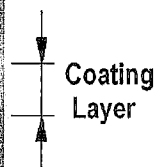
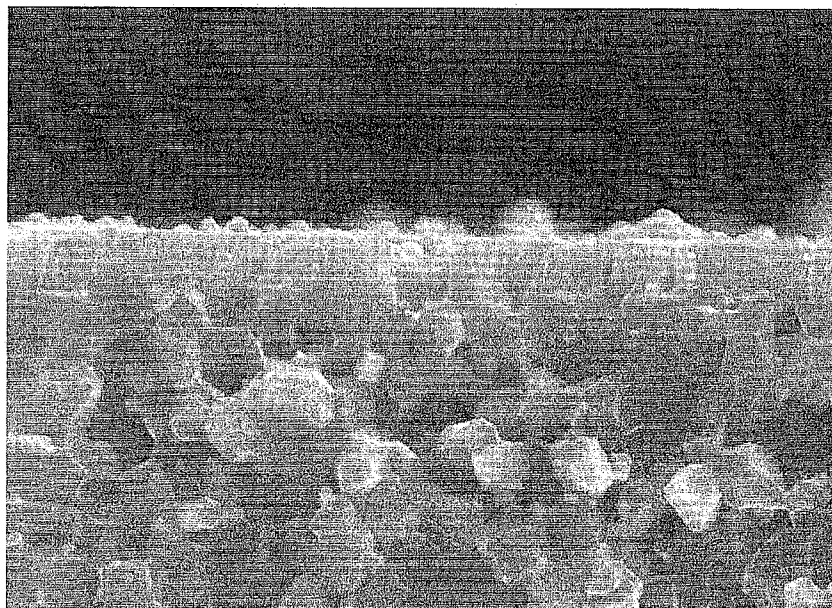
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(57) Abstract: The present invention relates to a whiskered porous body, wherein whiskers are grown in the pores of the porous body, and a method of manufacturing the same. Whiskers of a prior art whiskered porous body were not sufficiently formed at the deeper places of the ceramic porous body. The present invention is directed to solving such a problem. The whiskered porous body of the present invention is manufactured by infiltrating slurry containing a whisker source into a porous body and growing whiskers inside the porous body under a non-oxidizing gas atmosphere by means of carbothermal reduction. According to the present invention, the whiskers are grown uniformly up to the interior of the porous body.

WO 2008/078845 A1

CUTTING TOOL

TECHNICAL FIELD

The present invention generally relates to an alumina-based ceramic cutting tool,
5 and more particularly to an alumina-based ceramic cutting tool with coating layers
formed on its surface.

BACKGROUND ART

Alumina is widely used as a material for substrates of cutting tools due to its
10 excellent mechanical properties and thermal resistance. A TiN coating layer is formed
on the surface of an alumina cutting tool to improve surface roughness, reduce cutting
resistance and prevent adhesion of workpiece on the cutting tool. However, the TiN
coating layer has a low hardness and thus may be easily worn out due to the friction
occurring during a cutting operation. When cutting hard materials such as a cast iron,
15 the TiN coating layer tends to wear out more easily. Further, the TiN coating layer is
easily oxidized at above 1000°C under an atmospheric exposure. Thus, when the
cutting tool performs a high-speed cutting, the TiN coating layer, which is subjected to a
high temperature, tends to be easily oxidized and peeled off from the substrate.

The removal of the TiN coating layer causes the cutting edges to wear out
20 rapidly. Further, it causes an increase in cutting resistance, thereby accelerating the
abrasion of the cutting tool. This shortens the service life of the cutting tool.

DISCLOSURE

TECHNICAL PROBLEM

25 It is an object of the present invention to provide a coated alumina-based
ceramic cutting tool having an improved wear resistance.

It is another object of the present invention to provide a coated alumina-based
ceramic cutting tool having an improved mechanical performance under high-speed
cutting.

30 It is yet another object of the present invention to provide a coated alumina-
based ceramic cutting tool having an enhanced tool life.

TECHNICAL SOLUTION

In order to achieve the above objects and other objects, the cutting tool
35 according to the present invention comprises an alumina-based substrate. Preferably,
the substrate includes 0.1 to 25% by volume of one or more metal oxides, or 5 to 80% by

volume of metal carbonitride and 0.01 to 10% by volume of one or more metal oxides. Metal comprising said metal oxide and said metal carbonitride is selected from a group consisting of elements of Groups III to VI (including La group and Ac group) in the periodic table of elements, Mg and Co. Said metal oxides added to alumina reside at the boundaries of alumina grains, thereby prohibiting the alumina grains from growing excessively during a sintering process. As a result, a fine and uniform alumina-based substrate may be obtained.

Further, when 5 to 80% by volume of metal carbonitride is added to alumina, fine alumina grains and uniform microstructure may be obtained with the same principle. Moreover, metal carbonitride provides a much increased toughness than metal oxides, thereby expanding the applications of the alumina-based ceramic cutting tool including the high-speed cutting of high-hardness steels.

Also, one or more Al-Ti-Cr based nitride coating layers are formed on the substrate of the cutting tool. The one or more Al-Ti-Cr based nitride coating layers are formed on the substrate of the cutting tool with a thickness of 0.3 to 5.0 μ m, preferably 0.5 to 2.0 μ m. The composition of said Al-Ti-Cr based nitride coating layer may be $Al_wTi_xCr_ySi_zC_vN_{1-v}$ ($W+X+Y+Z=1$, $V=0\sim 1$).

Moreover, the coating layer may be formed by a physical vapor deposition (PVD) method.

DESCRIPTION OF DRAWINGS

Fig. 1 is a photograph showing various types of cutting inserts where the present invention may be applied.

Fig. 2 is an electron microscopic photograph showing a cross-section of a cutting tool in accordance with a first embodiment of the present invention.

Fig. 3 is an electron microscopic photograph showing a cross-section of a conventional cutting tool.

Fig. 4 is an optical microscopic photograph of the cutting tool of Fig. 2 after a Vickers hardness test is conducted to compare adhesion strength of the coating layer to the substrate.

Fig. 5 is an optical microscopic photograph of the cutting tool of Fig. 3 after a Vickers hardness test is conducted to compare adhesion strength of the coating layer to the substrate.

Fig. 6 is an electron microscopic photograph showing a cross-section of a cutting tool in accordance with a second embodiment of the present invention.

Figs. 7 and 8 are electron microscopic photographs showing cross-sections of

conventional cutting tools.

Fig. 9 is an optical microscopic photograph of the cutting tools of Fig. 6 after a Vickers hardness test is conducted to compare adhesion strength of the coating layer to the substrate.

5 Fig. 10 is an optical microscopic photograph of the cutting tool of Fig. 7 after a Vickers hardness test is conducted to compare adhesion strength of the coating layer to the substrate.

10 Fig. 11 is an optical microscopic photograph of the cutting tools of Fig. 8 after a Vickers hardness test is conducted to compare adhesion strength of the coating layer to the substrate.

Fig. 12 is a graph comparing tool lives of the cutting tool in accordance with the first embodiment of the present invention and conventional cutting tools.

15 Fig. 13 is an optical microscopic photograph of the cutting tool in accordance with the first embodiment of the present invention, showing wear extent of a cutting edge after use.

Figs. 14 to 16 are optical microscopic photographs of conventional cutting tools, showing their respective wear extents of cutting edges after use.

Fig. 17 is a graph comparing tool lives of the cutting tool in accordance with the second embodiment of the present invention and conventional cutting tools.

20 Fig. 18 is an optical microscopic photograph of the cutting tool in accordance with the second embodiment of the present invention, showing wear extent of a cutting edge after use.

Figs. 19 to 21 are optical microscopic photographs of conventional cutting tools, showing their respective wear extents of cutting edges after use.

25

BEST MODE FOR CARRYING OUT THE INVENTION

According to a first embodiment of the present invention, an alumina-based ceramic cutting insert comprises alumina and 0.1 to 25% by volume of one or more metal oxides. Metal composing said metal oxide is selected from a group consisting of elements of Groups III to VI (including La group and Ac group) in the periodic table of elements, Mg and Co. The cutting insert has one or more Al-Ti-Cr based nitride coating layers formed on the surface. Preferably, the one or more Al-Ti-Cr based nitride coating layer have a thickness of 0.3 to 5.0 μ m, preferably 0.5 to 2.0 μ m. When the thickness of the coating layer is less than 0.3 μ m, the coating layer is easily worn out and peeled off during a cutting process. Thus, the effect of the coating layer of enhancing tool life is not provided. Further, when the coating layer is thicker than

35

0.5 μ m, the adhesion strength between the substrate and the coating material becomes weak, and the coating layer is easily peeled off or damaged. This shortens the tool life.

Fig. 1 is a photograph showing various types of cutting inserts, to which the present invention may be applied. While the present invention is described with reference to embodiments of cutting tools, it is appreciated that the present invention may also be applied to various mechanical structures or functional parts which are made from ceramic.

Figs. 2 and 3 are photographs of cross-sections of said cutting insert and a conventional cutting insert, respectively, taken by an electron microscope at a magnification of 7000 to compare the adhesion strengths of coating layers to substrates. Fig. 2 shows a cross-section of a cutting insert in accordance with the present invention, wherein a coating layer having a composition of (TiAlCrN + TiN) is PVD coated with a thickness of about 1.2 μ m on an alumina-based substrate having a composition of (Al₂O₃ + 8.0% ZrO₂ + 0.3% MgO). Fig. 3 shows a cross-section of a conventional cutting insert, wherein a coating layer having a composition of TiN is PVD coated with a thickness of about 1.0 μ m on an alumina-based substrate having a composition of (Al₂O₃ + 3.0% ZrO₂ + 0.3% MgO).

As can be seen through comparing Figs. 2 and 3, the cutting insert of Fig. 2 has the coating layer closely adhered to the substrate without any gap, whereas the cutting insert of Fig. 3 shows a number of irregular gaps existing between the coating layer and the substrate (as indicated by arrows).

Fig. 4 is a photograph for comparing the adhesion strength of the coating layer to the substrate, taken by an optical microscope at a magnification of 200. Fig. 4 shows a surface of the cutting insert according to the first embodiment of the present invention after it is subjected to a Vickers hardness test. Fig. 5 is a photograph taken by an optical microscope at a magnification of 200 and shows a surface of a conventional cutting insert after it is subjected to the same Vickers hardness test. A diamond pyramid (indenter) having an angle of 136° between the two faces was used in the Vickers hardness test.

By comparing Figs. 4 and 5, it is confirmed that the coating layer of the cutting tool of Fig. 4 is not peeled off from the substrate and a pyramid-shaped indentation similar to the shape of the indenter is formed on its surface. The coating layer of the cutting tool of Fig. 5 is heavily peeled off from the substrate due to the pressure of the indenter. Such removal of the coating layer occurs due to the weak adhesion strength between the coating layer and the substrate.

According to a second embodiment of the present invention, an alumina-based

ceramic cutting insert comprises alumina, 5 to 80 % by volume of metal carbonitride, and 0.1 to 10 % by volume of one or more metal oxides. Metal composing said metal carbonitride and said metal oxide is selected from a group consisting of elements of Groups III to VI (including La group and Ac group) in the periodic table of elements, Mg and Co. The cutting insert has one or more Al-Ti-Cr based nitride coating layers formed on the surface. Preferably, the one or more Al-Ti-Cr based nitride coating layer have a thickness of 0.3 to 5.0 μm , preferably 0.5 to 2.0 μm .

Figs. 6 to 8 are photographs taken by an electron microscope at a magnification of 7000 for comparing the adhesion strengths of the coating layers to the substrates, which show cross-sections of said cutting insert and a conventional cutting insert, respectively. Fig. 6 shows a cross-section of a cutting insert constructed in accordance with the second embodiment of the present invention, wherein a coating layer having a composition of TiAlCrN is PVD coated with a thickness of about 1.2 μm on an alumina-based substrate having a composition of ($\text{Al}_2\text{O}_3 + 35\% \text{TiCN} + 0.5\% \text{MgO} + 1.0\% \text{Y}_2\text{O}_3$). Fig. 7 shows a cross-section of one of the conventional cutting inserts, wherein a coating layer having a composition of TiN is PVD coated with a thickness of about 0.2 μm on an alumina-based substrate having a composition of ($\text{Al}_2\text{O}_3 + 26\% \text{TiCN} + 0.5\% \text{MgO}$). Fig. 8 shows a cross-section of another conventional cutting insert, wherein a coating layer having a composition of TiN is PVD coated with a thickness of 0.2 μm on an alumina-based substrate having a composition of ($\text{Al}_2\text{O}_3 + 30\% \text{TiCN} + 0.3\% \text{MgO}$).

As can be seen by comparing Figs. 6 to 8, the cutting insert of Fig. 6 has the coating layer closely adhered to the substrate without any gap, whereas the coating layers of the cutting tools of Figs. 7 and 8 are peeled off from several places of the surfaces (as indicated by arrows).

Fig. 9 is a photograph for comparing the adhesion strength of the coating layer to the substrate, which was taken by an optical microscope at a magnification of 200. Fig. 9 shows a surface of the cutting insert according to the second embodiment of the present invention after it is subjected to a Vickers hardness test. Figs. 10 and 11 are photographs taken through an optical microscope at a magnification of 200, which show the surfaces of the cutting inserts shown in Figs. 7 and 8, respectively, after they are subjected to the Vickers hardness test.

By comparing Figs. 9 to 11, it is confirmed that the coating layer of the cutting tool of Fig. 9 is not peeled off from the substrate and a pyramid-shaped indentation similar to the shape of the indenter is formed on its surface. The coating layers of the cutting tools of Figs. 10 and 11 are heavily peeled off from the substrates of the cutting

tools around the indenter.

The test examples of the cutting inserts, which are constructed in accordance with the present invention, are described below.

[TEST EXAMPLE 1]

5 A cutting performance test of the cutting insert, which is constructed in accordance with the present invention, was conducted as described below.

The tool life of each cutting insert was measured, wherein the tool life is the time spent for a wear amount of a flank face of the cutting tool to reach 0.25mm.

10 In said cutting performance test, the following is used: a cutting insert A comprising a substrate having a composition of ($\text{Al}_2\text{O}_3 + 8.0\% \text{ZrO}_2 + 0.3\% \text{MgO}$) without any coating layer formed thereon; a cutting insert B comprising a first TiAlCrN coating layer and a second TiN coating layer on a substrate having the same composition as that of the cutting insert A; a cutting insert C comprising a TiN coating layer on a
15 substrate having a composition of ($\text{Al}_2\text{O}_3 + 3.0\% \text{ZrO}_2 + 0.3\% \text{MgO}$); and a cutting insert D comprising a substrate having a composition of ($\text{Al}_2\text{O}_3 + 10.0\% \text{ZrO}_2 + 0.5\% \text{MgO}$) without any coating layer formed thereon. The cutting inserts are SNGN120412 turning inserts according to the ISO standards. The cutting insert B is in accordance with the present invention, whereas the cutting inserts C and D are conventional.

20 The cutting conditions were as follows: cutting speed (v) = 600rpm; feed rate (f) = 0.3mm/rev; and depth of cut (d) = 2mm. Furthermore, each cutting insert was tested to cut a gray cast iron rod having a diameter of 150mm and a length of 700mm. Test results are shown in [Table 1] below and Fig. 12.

[Table 1]

Cutting Insert	Substrate	Coating Layer (Thickness μm)		Cutting Result	
		First Layer	Second Layer	Tool Life (min)	Remarks
A	$\text{Al}_2\text{O}_3 + 8\% \text{ZrO}_2 + 0.3\% \text{MgO}$	-	-	15	
B	$\text{Al}_2\text{O}_3 + 8\% \text{ZrO}_2 + 0.3\% \text{MgO}$	TiAlCrN (1.0)	TiN (0.2)	26	small amount of notch wear
C	$\text{Al}_2\text{O}_3 + 3.0\% \text{ZrO}_2 + 0.3\% \text{MgO}$	TiN (1.2)	-	14	
D	$\text{Al}_2\text{O}_3 + 10.0\% \text{ZrO}_2 +$	-	-	12	

	0.5% MgO			
Insert Type: SNGN120412 Work Material: Gray Cast Iron (HB190-200)				
Cutting Condition: v=600rpm, f=0.3mm/rev, d=2mm, dry				

As can be seen from Table 1, the tool life of the coated cutting insert B according to the present invention was about twice longer than that of the uncoated cutting insert A having the same substrate. Further, it can be seen that the tool life of the cutting insert B according to the present invention was notably increased over those of conventional cutting inserts C and D. On the other hand, it can be seen that the TiN coating layer of the cutting insert C scarcely contributes to the enhancement of the tool life.

Furthermore, the present inventors proceeded with cutting the cutting inserts A to D for 15 minutes under the same conditions as above [TEST EXAMPLE 1] and measured a flank and a notch wear amounts of the cutting inserts after the cutting. The notch wear amount indicates a wear amount of the deepest worn section. The flank wear amount indicates an average wear amount of worn sections without the notch wear amount.

[Table 2]

Cutting Insert	Substrate	Coating Layer (Thickness μm)		Cutting Result(mm)	
		First Layer	Second Layer	Flank Wear (Vb)	Notch Wear (Vn)
A	$\text{Al}_2\text{O}_3 + 8\% \text{ZrO}_2 + 0.3\% \text{MgO}$	-	-	0.25	0.50
B	$\text{Al}_2\text{O}_3 + 8\% \text{ZrO}_2 + 0.3\% \text{MgO}$	TiAlCrN (1.0)	TiN (0.2)	0.13	0.29
C	$\text{Al}_2\text{O}_3 + 3.0\% \text{ZrO}_2 + 0.3\% \text{MgO}$	TiN (1.2)	-	0.18	0.40
D	$\text{Al}_2\text{O}_3 + 10.0\% \text{ZrO}_2 + 0.5\% \text{MgO}$	-	-	0.27	0.75
Insert Type: SNGN120412 Work Material: Gray Cast Iron (HB190-200)					
Cutting Condition: v=600rpm, f=0.3mm/rev, d=2mm, dry					

According to the cutting result, the cutting insert B according to the present invention has the smallest flank wear amount and notch wear amount.

Figs. 13 to 16 are photographs taken by an optical microscope at a magnification

of 200, which show the worn features of the cutting inserts A to D [Table 2], respectively. It is observed that the wear amount of the cutting insert B is remarkably smaller than those of other cutting inserts A, C and B. This is due to the excellent adhesion strength of the coating layer of the cutting insert B to the substrate, which prohibits the coating layer from easily peeling off from the substrate. The coating layer reduces friction coefficient between the cutting insert and workpiece (even in cast iron cuttings), thereby suppressing the wear of a cutting tool.

[TEST EXAMPLE 2]

The tool life of each cutting insert was measured, wherein the cutting inserts are: a cutting insert E comprising a substrate having a composition of ($\text{Al}_2\text{O}_3 + 1.0\% \text{Y}_2\text{O}_3 + 35.0\% \text{TiCN} + 0.5\% \text{MgO}$) without any coating layer formed thereon; a cutting insert F comprising a TiAlCrN coating layer formed on a substrate having the same composition as the cutting insert E; a cutting insert G comprising a TiN coating layer formed on a substrate having a composition of ($\text{Al}_2\text{O}_3 + 26.0\% \text{TiCN} + 0.5\% \text{MgO}$); and a cutting insert H comprising a TiN coating layer formed on a substrate having a composition of ($\text{Al}_2\text{O}_3 + 30.0\% \text{TiCN} + 0.3\% \text{MgO}$). The cutting inserts are CNGA120408 turning inserts according to the ISO standards. The cutting insert F is in accordance with the present invention, whereas the cutting inserts G and H are conventional.

The cutting conditions were: cutting speed (v) = 270rpm; feed rate (f) = 0.1mm/rev; and depth of cut (d) = 2mm. Further, each cutting insert was tested to cut a hardened alloy steel rod having a diameter of 150mm and a length of 700mm. The results of such test are shown [Table 3] below and Fig. 17.

[Table 3]

Cutting Insert	Substrate	Coating Layer (Thickness μm)	Cutting Result	
			Tool Life (min)	Remark
E	$\text{Al}_2\text{O}_3 + 1.0\% \text{Y}_2\text{O}_3 + 35.0\% \text{TiCN} + 0.5\% \text{MgO}$	- (-)	20	-
F	$\text{Al}_2\text{O}_3 + 1.0\% \text{Y}_2\text{O}_3 + 35.0\% \text{TiCN} + 0.5\% \text{MgO}$	TiAlCrN (1.2)	45	show slow tool wear
G	$\text{Al}_2\text{O}_3 + 26.0\% \text{TiCN} + 0.5\% \text{MgO}$	TiN (0.2)	25	-
H	$\text{Al}_2\text{O}_3 + 30.0\% \text{TiCN} + 0.3\% \text{MgO}$	TiN (0.2)	27	-

Insert Type: CNGA120408 Work Material: Hardened Alloy Steel (HRc 45-50)
 Cutting Condition: v=270rpm, f=0.1mm/rev, d=0.5mm, wet

As can be seen from above [Table 3], the tool life of the coated cutting insert F according to the present invention was about twice longer than that of the uncoated cutting insert E having the same substrate. Further, it can be seen that the tool life of the cutting insert F according to the present invention was significantly increased over those of conventional cutting inserts G and H.

Furthermore, cutting was performed with the cutting inserts E to H for 15 minutes under the same conditions as above [TEST EXAMPLE 2] and each feature of the cutting inserts was observed. The wear amount of each cutting insert is shown below.

[Table 4]

Cutting Insert	Substrate	Coating Layer (Thickness μm)	Wear Amount (mm)
E	$\text{Al}_2\text{O}_3 + 1.0\% \text{Y}_2\text{O}_3 + 35.0\% \text{TiCN} + 0.5\% \text{MgO}$	- (-)	0.25
F	$\text{Al}_2\text{O}_3 + 1.0\% \text{Y}_2\text{O}_3 + 35.0\% \text{TiCN} + 0.5\% \text{MgO}$	TiAlCrN (1.2)	0.13
G	$\text{Al}_2\text{O}_3 + 26.0\% \text{TiCN} + 0.5\% \text{MgO}$	TiN (0.2)	0.22
H	$\text{Al}_2\text{O}_3 + 30.0\% \text{TiCN} + 0.3\% \text{MgO}$	TiN (0.2)	0.20

Insert Type: CNGA120408 Work Material: Hardened Alloy Steel (HRc 45-50)
 Cutting Condition: v=270rpm, f=0.1mm/rev, d=0.5mm, wet

As a cutting result, the cutting insert F showed the smallest wear amount.

Figs. 18 to 21 are photographs taken by an optical microscope at a magnification of 200, which show the worn features of the cutting inserts E to H [Table 4], respectively. The cutting insert E with an uncoated substrate is in black, while other cutting inserts with the coating layers made from TiAlCrN or TiN are in yellow. In case of cutting hardened alloy steel, uniform wear occurs in the cutting sections and notch wear is not observed, unlike in the case of cutting cast iron. This is due to the excellent adhesion strength of the coating layer of the cutting insert F to the substrate, which prohibits the coating layer from easily peeling off from the substrate. The coating layer reduces friction coefficient between the cutting insert and workpiece (even in cast iron cuttings),

thereby suppressing the wear of a cutting tool.

While the present invention has been particularly shown and described with reference to exemplary embodiments thereof, it will be understood by those skilled in the art that various alternations or modifications can be made without departing from the
5 scope of the present invention.

INDUSTRIAL APPLICABILITY

According to the alumina-based ceramic cutting tool of the present invention, the coating material is maintained with firm adhesion on the substrate and is not peeled
10 off therefrom during high-speed cutting of a high hardness material such as cast iron or hardened steel. Thus, a cutting tool with a superior wear resistance and a greatly enhanced tool life is provided.

CLAIMS

1. A cutting tool comprising an alumina-based substrate and one or more Al-Ti-Cr based nitride coating layer formed on a surface of the substrate.
- 5
2. The cutting tool of Claim 1, wherein the alumina-based substrate comprises alumina and 0.1 to 25% by volume of one or more metal oxides, wherein metal composing said metal oxide is selected from a group consisting of elements of Groups III to VI (including La group and Ac group) in the periodic table of elements, Mg and Co.
- 10
3. The cutting tool of Claim 1, wherein the alumina-based substrate comprises alumina, 5 to 80% by volume of metal carbonitride and 0.01 to 10% by volume of one or more metal oxides, wherein metal composing said metal carbide and said metal oxide is selected from a group consisting of elements of Groups III to VI (including La group and
- 15 Ac group) in the periodic table of elements, Mg and Co.
4. The cutting tool of any one of Claims 1 to 3, wherein the one or more Al-Ti-Cr based nitride coating layer is $Al_WTi_XCr_YSi_ZC_VN_{1-V}$ ($W+X+Y+Z=1$, $V=0\sim 1$).
- 20
5. The cutting tool of any one of Claims 1 to 3, wherein the one or more Al-Ti-Cr based nitride coating layer has a thickness of 0.3 to 5.0 μm .
6. The cutting tool of any one of Claims 1 to 3, wherein the one or more Al-Ti-Cr based nitride coating layer has a thickness of 0.5 to 2.0 μm .
- 25
7. The cutting tool of any one of Claims 1 to 3, wherein the one or more Al-Ti-Cr based nitride coating layer is formed by a PVD method.

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Figure 1

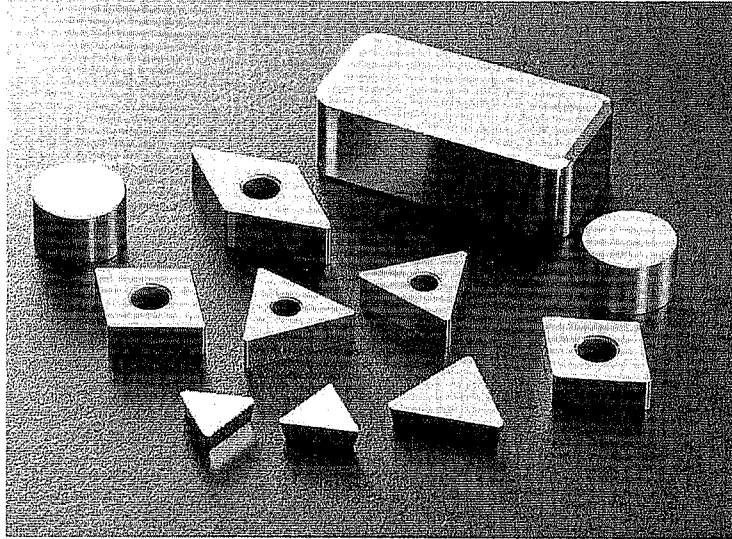
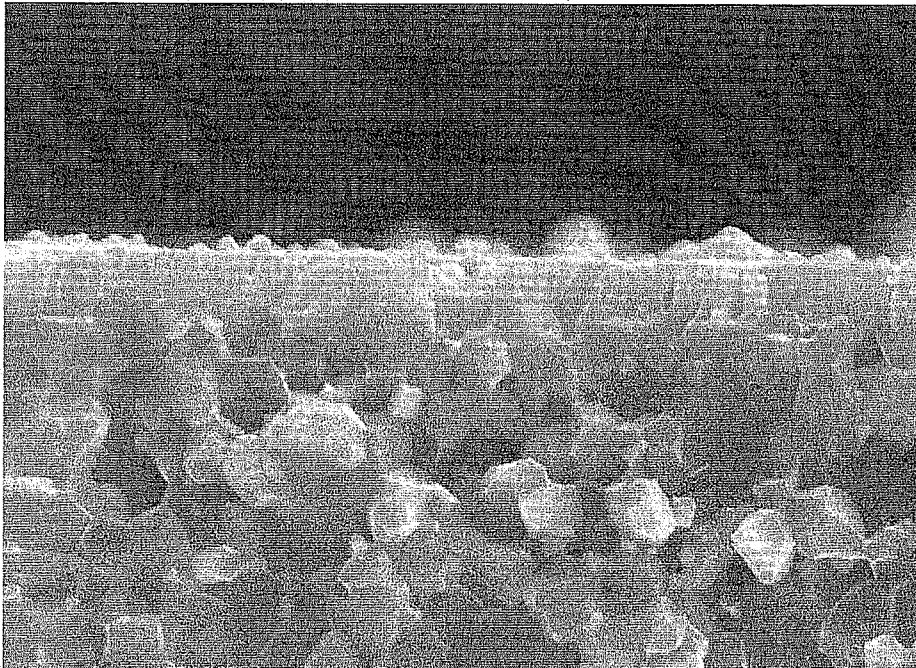


Figure 2



2/10

Figure 3

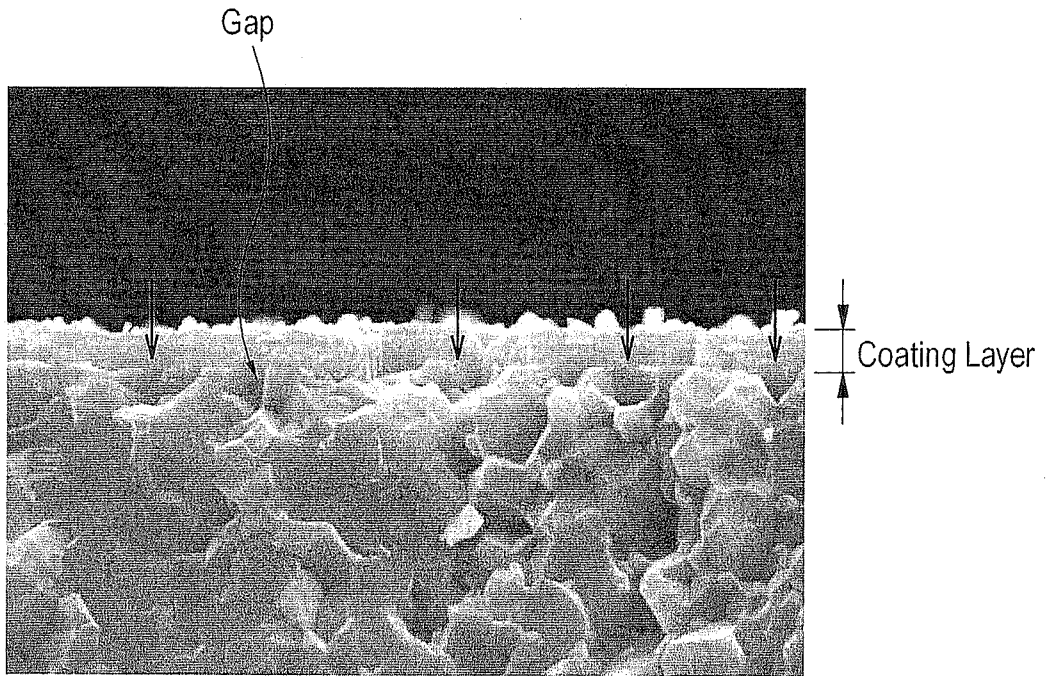
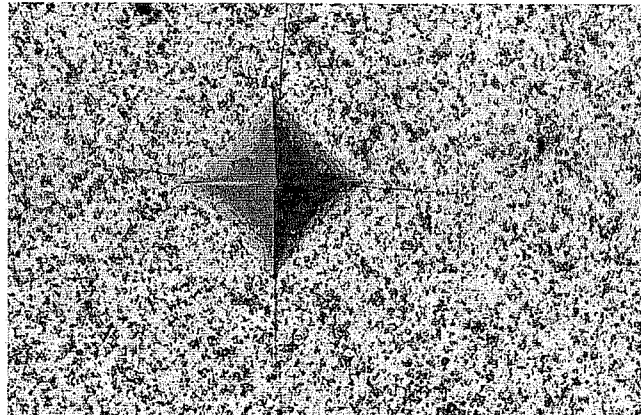


Figure 4



3/10
Figure 5

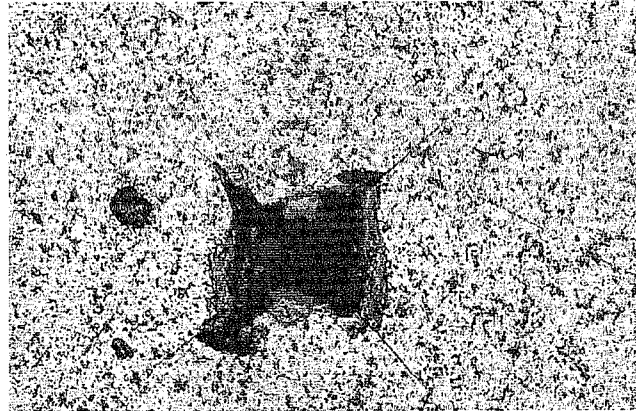
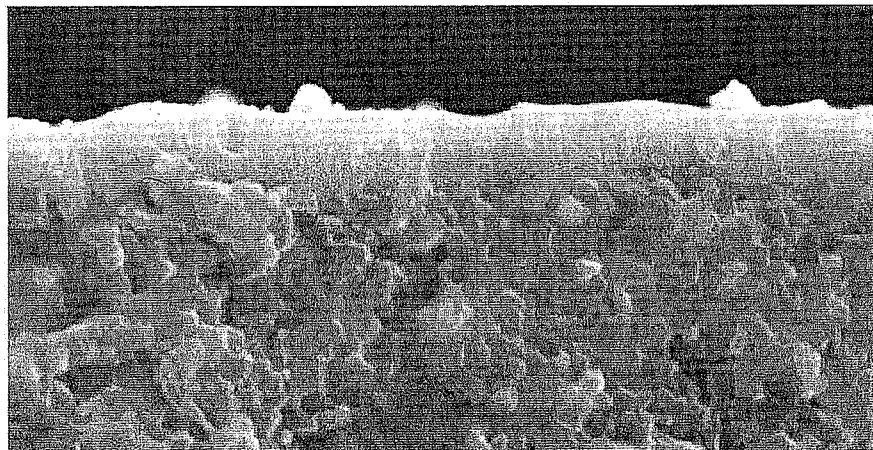


Figure 6



Coating
Layer

4/10

Figure 7

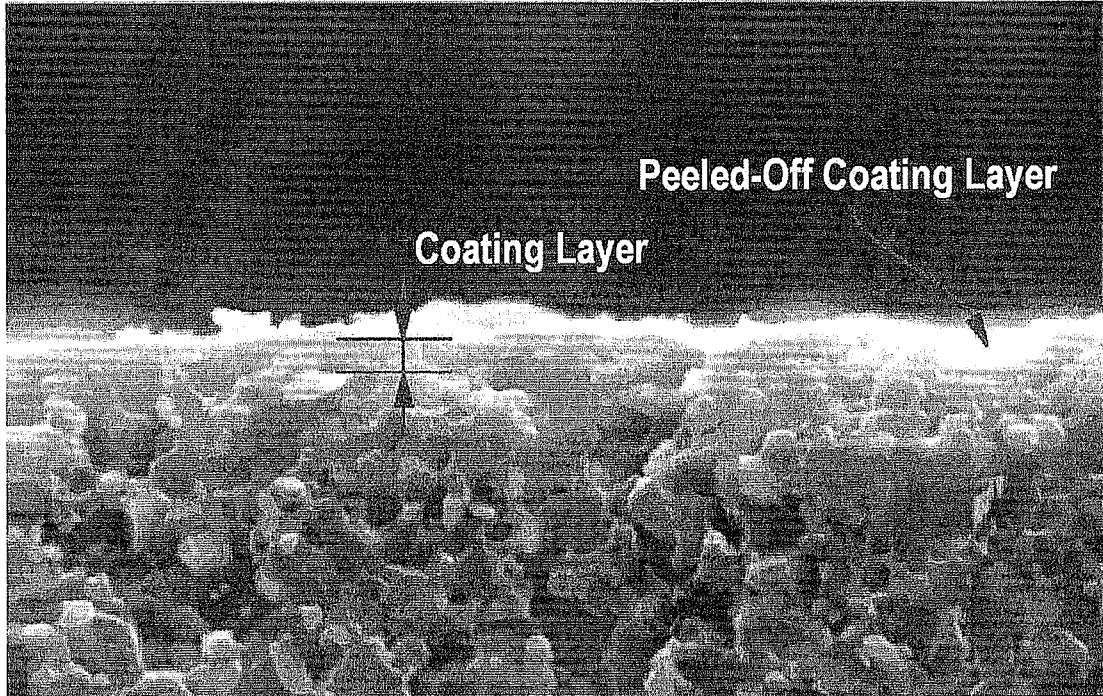
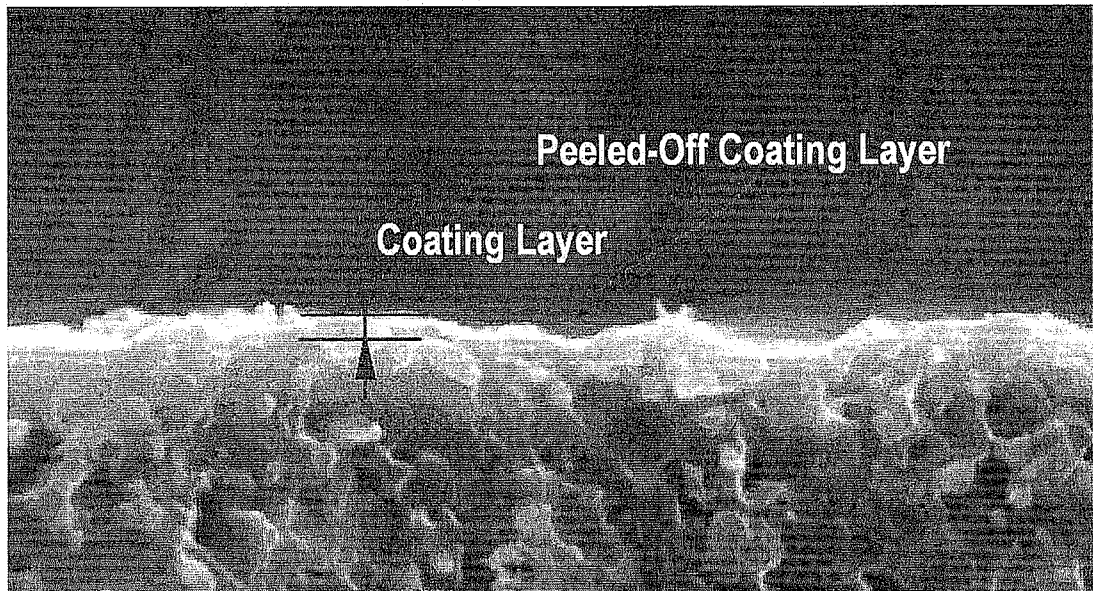


Figure 8



5/10

Figure 9

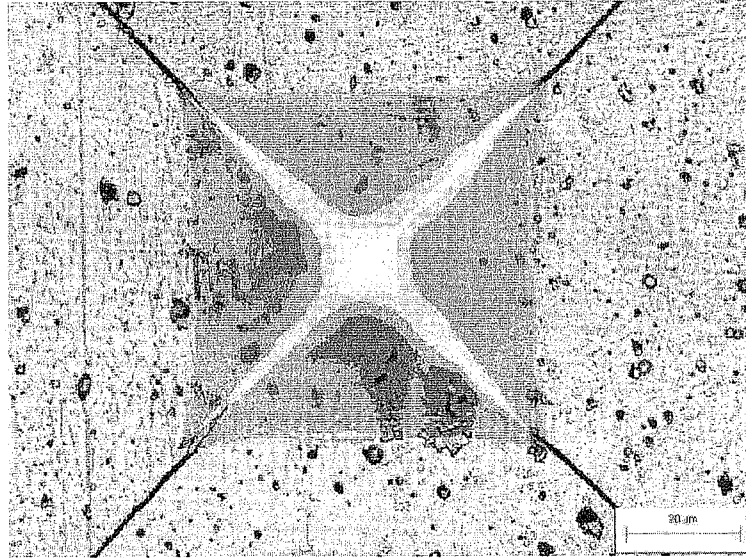
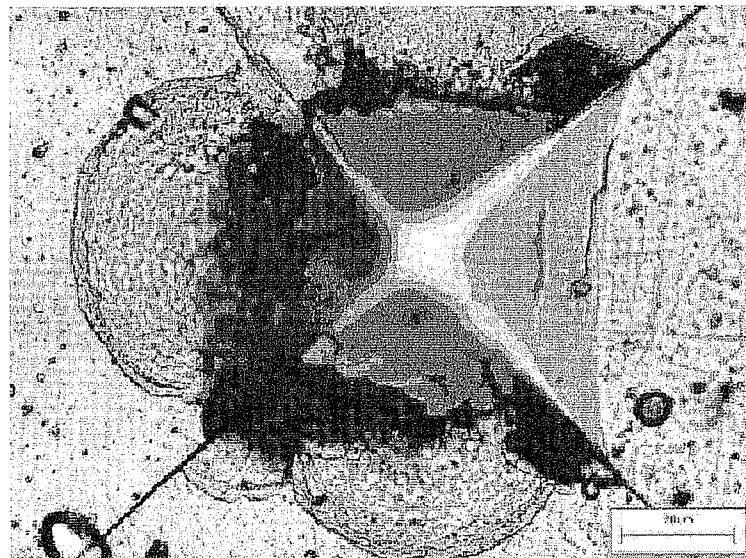


Figure 10



6/10

Figure 11

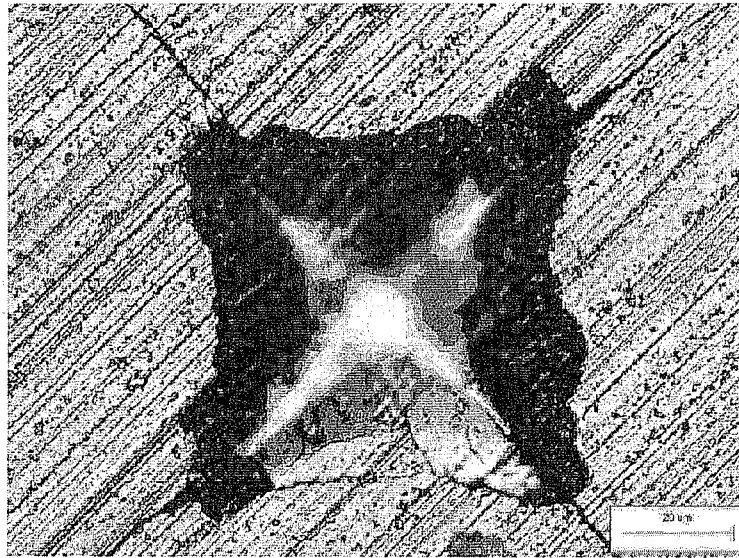
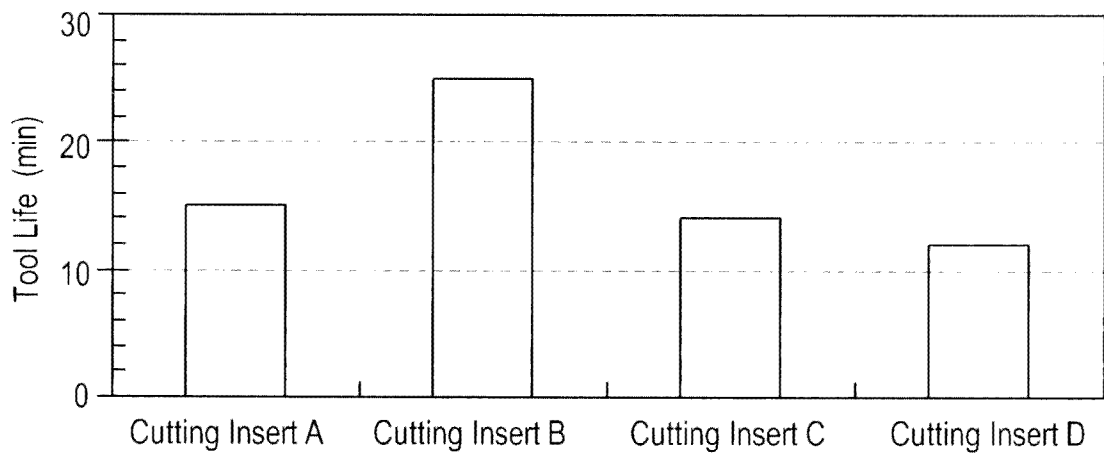
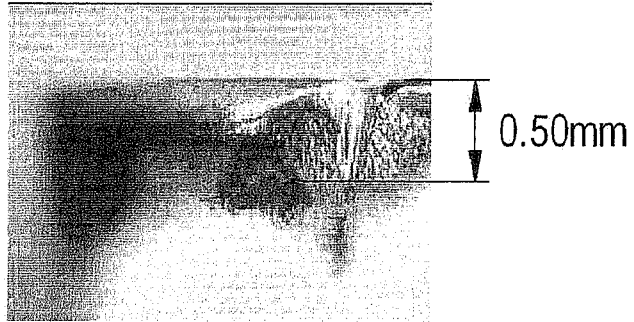


Figure 12



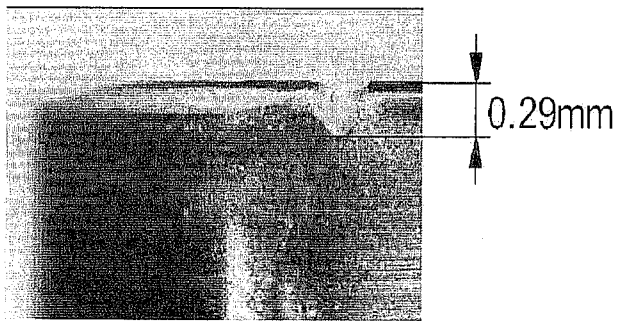
7/10

Figure 13



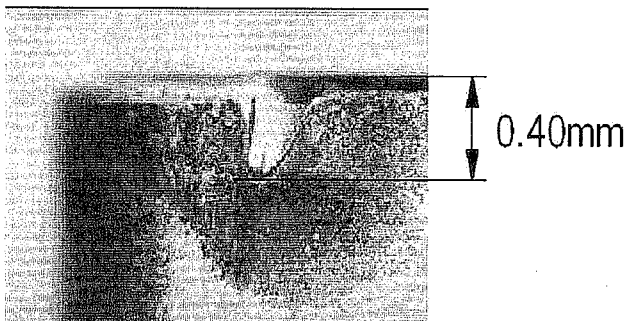
Cutting Insert A

Figure 14



Cutting Insert B

Figure 15



Cutting Insert C

8/10
Figure 16

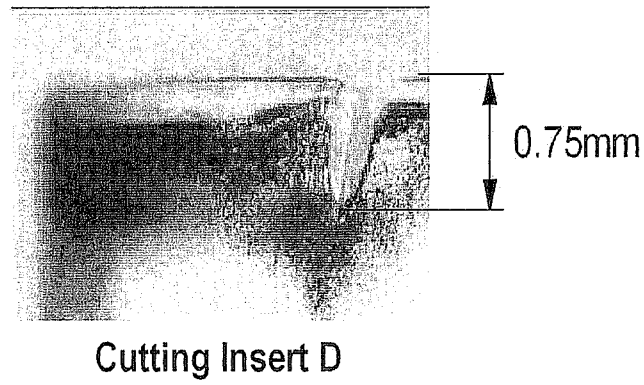
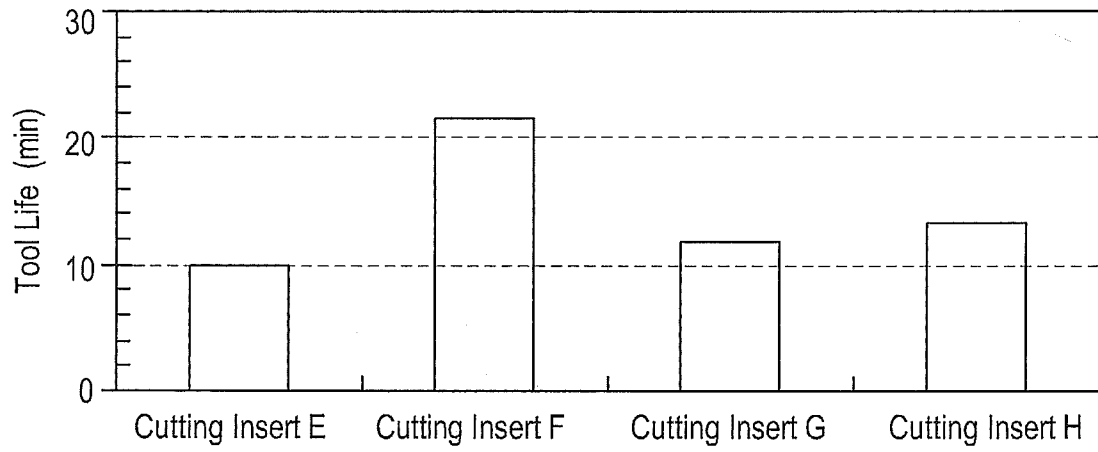
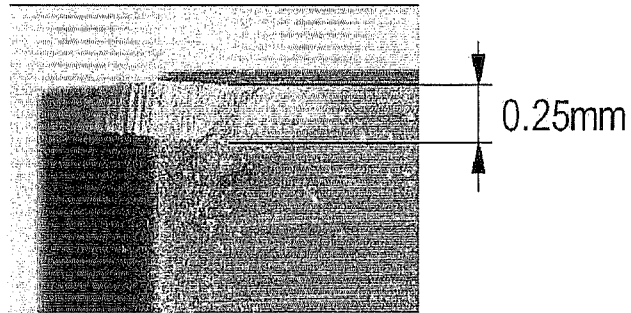


Figure 17

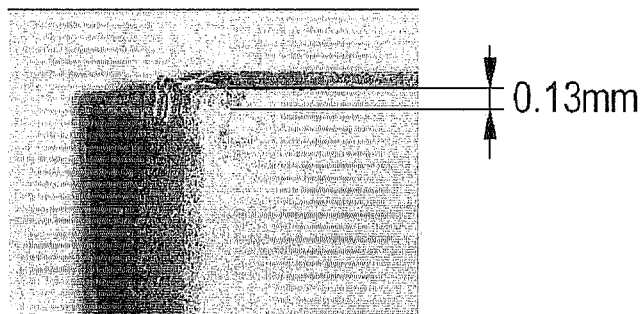


9/10
Figure 18



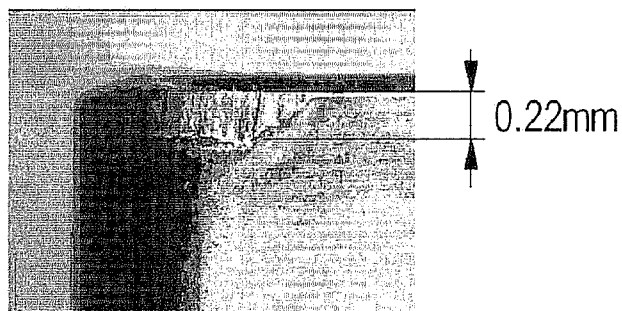
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Figure 19



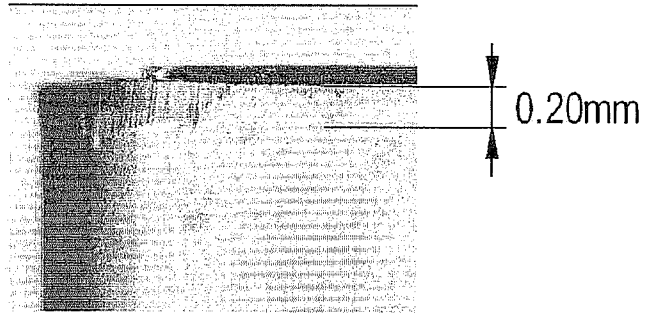
Cutting Insert F

Figure 20



Cutting Insert G

10/10
Figure 21



Cutting Insert H

A. CLASSIFICATION OF SUBJECT MATTER***B23B 27/14(2006.01)i***

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC8: B23B, B23C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Korean Utility models and applications for Utility models since 1975

Japanese Utility models and applications for Utility models since 1975

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKIPASS (KIPO internal) & keywords: "alumina", "coating", "substrate", and "ceramic"

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	JP 10-094905 A (NGK SPARK PLUG CO., LTD.) 14 April 1998 See paragraphs 3-18 and claims 1-7; Figures 1-3.	1, 5, 6, 7
A		2, 3, 4
A	US 6,811,580 B1 (LITTECKE, PETER) 02 November 2004 See claims 1 and 8.	1-7
A	KR 10-2006-0006835 A (DIAMOND INNOVATIONS, INC.) 19 January 2006 See claims 1, 5, and 8; Figures 4 and 5.	1-7
A	KR 10-2004-0093468 A (SUMITOMO ELECTRIC INDUSTRIES, LTD.) 05 November 2004 See abstract; Figures 1 and 2.	1-7

 Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

18 SEPTEMBER 2007 (18.09.2007)

Date of mailing of the international search report

18 SEPTEMBER 2007 (18.09.2007)

Name and mailing address of the ISA/KR

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Facsimile No. 82-42-472-7140

Authorized officer

KIM Sung Ho

Telephone No. 82-42-481-8548



INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/KR2006/005707

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