

EXXTRAL®-ULTRAFINE

The innovative AlTiN high-performance coating for cutting tools

The aluminium titanium nitride-based EXXTRAL®-ultrafine coating was specially developed for hard, dry and high-speed machining. Through the use of SPCS (Strongly Poisoned Cathode Surface) technology, EXXTRAL®-ultrafine exhibits what is for arc coatings an exceptionally smooth coating surface. This results in reduced formation of build-up

on cutting edges during the cutting and also fosters improved chip removal.

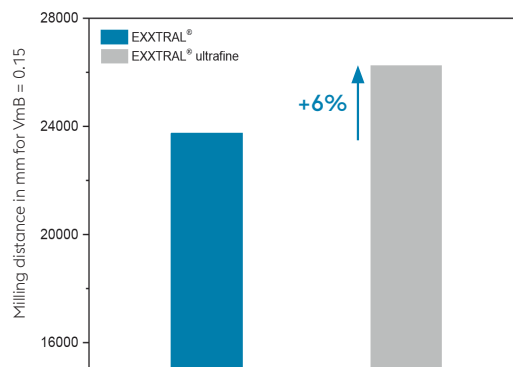
The low-defect layer structure of the EXXTRAL®-ultrafine layer, as well as its high hardness and excellent adhesive strength, provides significantly improved durability with dry cutting as compared to the conventional EXXTRAL® arc layer.

APPLICATIONS

Cutting	Preferred areas of application for the EXXTRAL®-ultrafine layer are thus metal cutting tasks such as milling, drilling and turning, which are performed under high mechanical and thermal stresses up to max. 800 °C.
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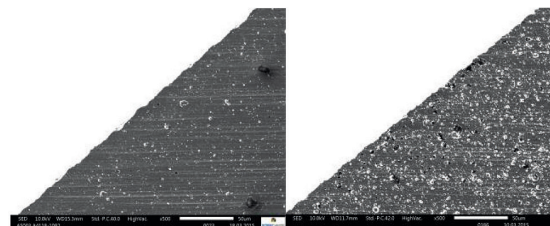
With EXXTRAL®-ultrafine coated solid carbide finishing cutter (Ø 10 mm).



Maximally achieved milling distance for a wear mark width of 0.15 mm for EXXTRAL®-ultrafine compared to EXXTRAL® for hard milling of Vanadis 10 (62 HRC). Cutting parameters: $v_c=100$ m/min, $v_f=1337$ mm/min, $a_p=10$ mm, $a_e=0.02$ mm.

COATING PROPERTIES

Hardness	3,300 ± 300 HV
Max. application temperature	800 °C / 1,470 °F
Coating thicknesses	2 - 3 µm
Colour	anthracite



Scanning electron microscope images of a milling cutter coated with EXXTRAL®-ultrafine (left) and EXXTRAL® (right).