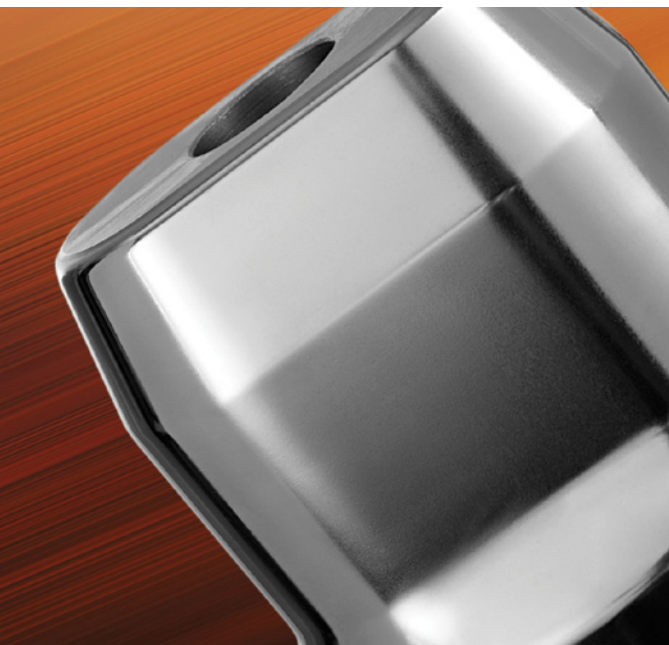




eifeler

CROSAL® - PLUS
COATING

THE CROSAL[®]-PLUS ADVANTAGE



CROSAL-plus is voestalpine eifeler Coatings' next generation AlCrN based hard coating. This new coating is an advanced development of our well established CROSAL coating.

In many manufacturing applications, localized extreme temperatures can be detrimental not only to the performance of tooling but also to the workpiece material and or finished product.

BENEFITS OF CROSAL-PLUS:

Our new CROSAL-plus coating meets the requirements of these demanding environments and applications to deliver:

- » **Extended Tooling and Coating Life**
- » **Improved Abrasion Resistance at High Temperatures**
- » **Increased Productivity in Demanding Applications**
- » **Decreased Tooling Cost**

FEATURES

As a result of optimizing process parameters to enhance the coating microstructure CROSAL-plus has several key characteristics:

- » **High Thermal Threshold**
- » **Excellent Wear Resistance**
- » **Outstanding Hot Hardness**
- » **Superior Coating Adhesion**

voestalpine eifeler Coatings CROSAL-plus is deposited using our unique PVD-Arc coating process which delivers maximum adhesive strength and optimized coating smoothness.



APPLICATIONS

CROSAL-plus is especially suited for the following applications:

Cutting Applications

- » High Performance Cutting and Milling
- » Gear Cutting and Hobbing, Including Stick Blades
- » Dry Broaching of Tough Alloys

Stamping/Forming Applications

- » Fine Blanking
- » Stamping and Forming
- » Hot Pressing
- » Aluminum Die Casting
- » Forging



PROPERTIES

Material: Aluminum Chromium Nitride Based, AlCrN

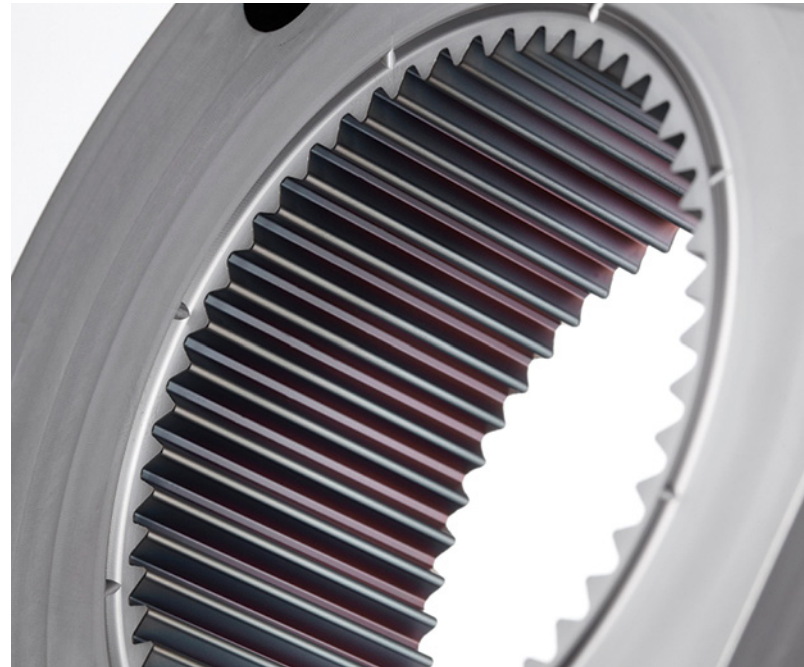
Micro-hardness: 3200 ± 300 HV

Maximum temperature of operation: $1100^{\circ}\text{C}/2012^{\circ}\text{F}$

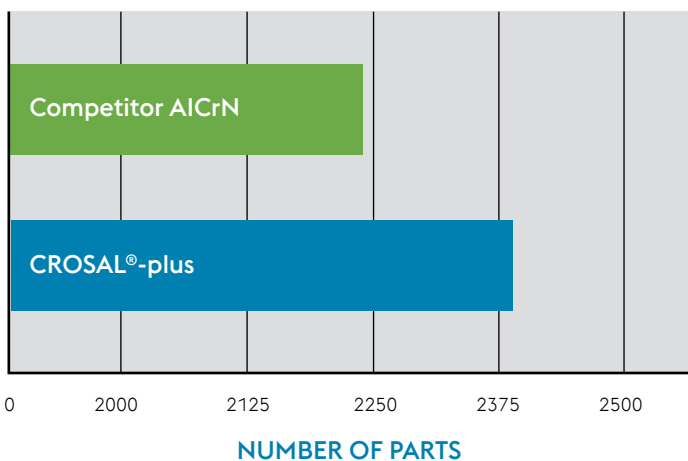
Coefficient of friction against steel: 0.45

Coating thickness: $2\text{-}5\text{ }\mu\text{m}$

Color: Slate-Grey



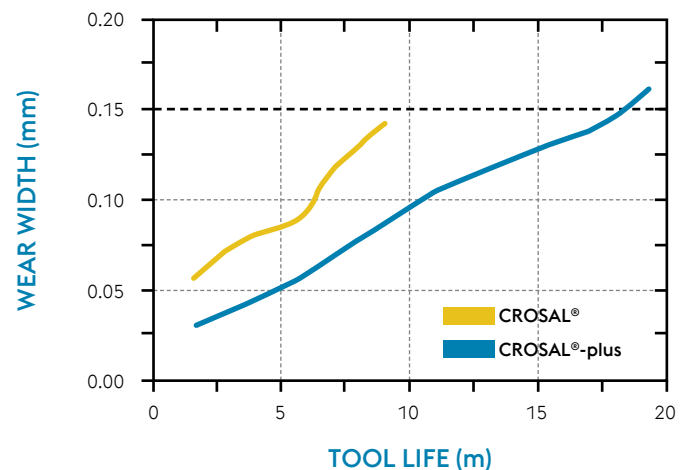
CROSAL-PLUS PRODUCTIVITY



Hobbing, 2-cutting technique,

PM-hob, dry, 5th speed, 16MnCr5 roughening: 180 m/min
refining: 360 m/min

CROSAL-PLUS TOOL LIFE



Hard cutting in VANADIS10,

H=61HRC, CC-end mill Z=6, $v_c=100$ m/min, $f_z=0.07$ mm/tooth, $v_f=1337$ mm/min, $a_p=10$ mm, $a_e=0.2$ mm

Locations:

Canada - voestalpine eifeler Coatings voestalpine High Performance Metals Ltd.

2645 Meadowvale Blvd.
Mississauga, ON L5N 7Y4
T. +1 (800) 665-8335
F. +1 (905) 812-9231
Email: sales.canada@voestalpine.com

USA

voestalpine eifeler Coatings - California

EDRO Engineering, Inc.
20492 Carrey Road
Walnut, CA 91789
T. +1 (909) 594-5751
Email: coatings@edro.com

voestalpine eifeler Coatings, Inc. - Illinois

3800 Commerce Drive
St. Charles, IL 60174
T. +1 (630) 587-1220
F. +1 (630) 587-1230
Email: sales.usa@eifeler.com

voestalpine eifeler Coatings, Inc. - Michigan

2222 Spikes Lane
Lansing, MI 48906
T. +1 (517) 708-7945
F. +1 (517) 913-6279

voestalpine eifeler Coatings, Inc. - Ohio

18687B Sheldon Road
Middleburg Heights, OH 44130
T. +1 (216) 658-3870
F. +1 (216) 658-3871

voestalpine eifeler Coatings, Inc. - Tennessee

3450 Old Tasso Road NE
Cleveland, TN 37312
T. +1 (423) 790-7382
F. +1 (423) 790-7386

Mexico - voestalpine eifeler Coatings voestalpine High Performance Metals S.A. de C.V.

Cerrada de la Noria No. 200 Int. A-14
Parque Industrial Querétaro, C.P. 76220.
Querétaro, México
T. +52 (442) 349-7949
Email: ventas.mexico@voestalpine.com

Bld. Milenium 5052
Parque Industrial Milenium Aeropuerto
Apodaca Nuevo Leon
66626 Monterey
T. +52 (818) 352-5239

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ONE STEP AHEAD.