

# Contents

1	State of the art	1
1.1	Basic principle of powder metallurgy	1
1.1.1	Forming of the powders	1
1.1.2	Sintering	3
1.1.3	Production of diamond composites	4
1.2	Basic friction and wear mechanisms	7
1.3	Wear resistant materials	8
1.4	Surface treatments	11
1.4.1	Plasma nitriding	11
1.4.2	Physical vapor deposition (PVD)	14
Evaporation		14
Sputtering		15
Magnetron sputtering deposition		15
High ionization sputtering (H.I.S) and high ionization pulsing (H.I.P)		16
Ion beam plating		18
1.4.3	Tribological PVD-coating systems	18
Diamond-like carbon		18
Multilayer coating systems		22
Nanocomposites		24
1.4.4	Combination of plasma nitriding and PVD coating	26
2	Experimental details	29
2.1	Steel substrates	29
2.2	Plasma nitriding	30

## Contents

2.3	Deposition of PVD coatings . . . . .	30
2.3.1	Multilayer coatings . . . . .	31
2.3.2	Diamond-like carbon coatings (DLC) . . . . .	32
2.3.3	Titanium aluminum supernitride . . . . .	32
2.4	Finite element modeling of residual stress in multilayer coatings . . . . .	35
	Thermal residual stress . . . . .	35
	Intrinsic stress . . . . .	35
2.5	Mechanical and tribological characterization of PVD coatings . . . . .	40
2.5.1	Thickness measurements . . . . .	40
2.5.2	Hardness measurements . . . . .	41
2.5.3	Adhesion test . . . . .	42
	Buckling/spallation . . . . .	44
	Wedge spallation . . . . .	44
	Recovery spallation . . . . .	45
2.5.4	Tribology test . . . . .	45
2.5.5	Roughness and profile measurements . . . . .	46
2.5.6	Scanning electron microscopy (SEM), Energy-dispersive X-ray spectroscopy (EDX), X-ray diffractometry . . . . .	46
2.6	Production and characterization of diamond composites . . . . .	47
2.6.1	Cold compaction . . . . .	47
2.6.2	Hardness and porosity measurements . . . . .	50
3	Finite element simulation of residual stresses in multilayer coatings	51
4	Surface treatments	57
4.1	Plasma nitriding of the substrates . . . . .	57
4.2	PVD coating characterization . . . . .	62
4.2.1	Multilayer coatings . . . . .	62
	Morphology, thickness and hardness . . . . .	62
	Adhesion characterization . . . . .	63
	Tribological characterization . . . . .	74
4.2.2	Diamond-like carbons . . . . .	82
	Morphology, thickness and hardness . . . . .	82
	Adhesion characterization . . . . .	84

Tribological characterization . . . . .	90
4.2.3 Titanium aluminum supernitride . . . . .	95
Morphology, thickness and hardness . . . . .	95
Adhesion characterization . . . . .	95
Tribological characterization . . . . .	102
4.3 Summary and the discussion of the surface treatments . . . . .	105
4.3.1 Plasma nitriding . . . . .	105
4.3.2 Multilayers . . . . .	105
4.3.3 Diamond-like carbon . . . . .	105
4.3.4 Titanium aluminum supernitride . . . . .	106
5 Wear resistant press dies	109
5.1 Coating systems employed . . . . .	109
5.2 Wear rate and the lifetime . . . . .	110
5.3 Failure modes . . . . .	114
5.4 The interaction between diamonds and the die surface . . . . .	120
6 Characterization of the sintered bodies	129
7 Summary and outlook	137