

PC
Primus Vietnam

HP Dura



HP Dura

Suitable in a wide range of materials and machining application.

HP Dura has excellent lubricity and wear resistance to suit a wide range of milling applications. Ideal for machining steels and non-ferrous materials up to 50 HRC.



Composition	Color	Structure	Hardness (GPa)	Thickness (μm)	Oxidation Temperature (°C)	Coefficient of Friction	Surface Roughness (Ra)	Properties	Application
AlCr Based	Dark Grey	Multilayer	38 GPa	2 ~ 3 μm*	1,100°C	0.33	0.10 ~0.25	High Temperature oxidation resistance. Good for machining high hardness materials.	High efficiency milling, high speed machining for gear generation, dry/wet machining.

* Thickness for rotative cutting tools, for other types of tools the thickness is different. Please consult our sales department.

P		H				M	K7	N			S			-
Carbon Steel	Alloy Steel	Pre-Hardened Steel				Stainless Steel	Cast Iron	Copper Alloy	Aluminum Alloy	Plastic	Titanium Alloy	Heat Resistant Alloys	Inconel	Graphite
Pre-Hardened Steel	Tool Steel	~45 HRC	~55 HRC	~60 HRC	~65 HRC	~35 HRC	~350 HB							
~40 HRC														
⊙		⊙	○			⊙	⊙		○		○			

⊙ Excellent ○ Good

Wear and damage after milling 84m linear



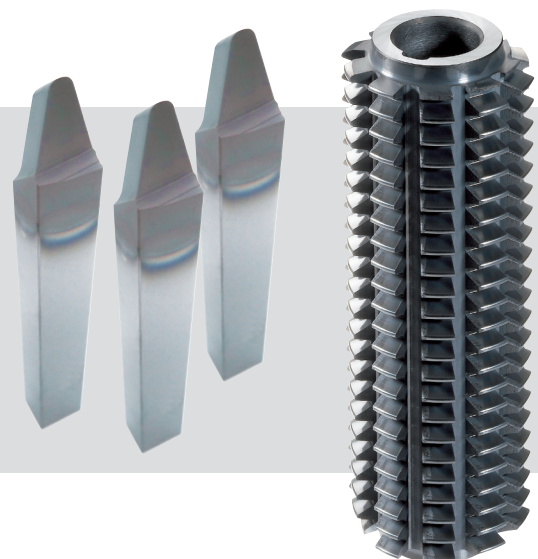
HP Dura



TiAlN coating

The wear pattern differs from conventional coating. When cutting carbon steel and alloyed steel the cutting edge wear with **HP Dura** coating is very minimal, resulting in superior wear resistance!

HP Dura is ideal for dry cutting in gear generation processes



Test Data

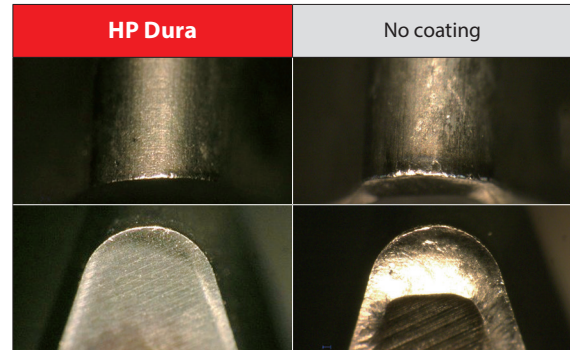
Hob cutter: Cutting SCM420

Tool	Hob cutter m6×PA20°PSP RH-1
Coolant	Water soluble

Process	Cutting data	TiN	HP Dura	Efficiency
Roughing	Cutting speed (m/min)	100	130	130%
	Feed (mm/rev)	2	2	
Finishing	Cutting speed (m/min)	200	250	125%
	Feed (mm/rev)	3,5	3,5	

Tool	Hob cutter m2,5×PA20°
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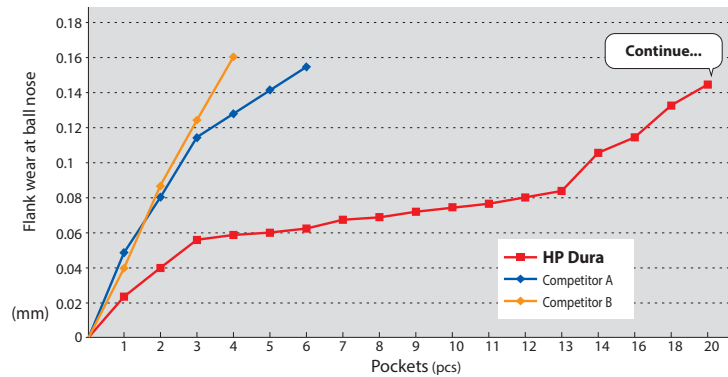
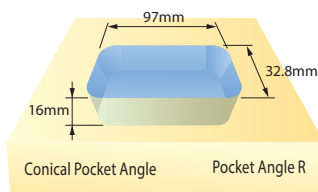
Wear after Milling 108 pieces



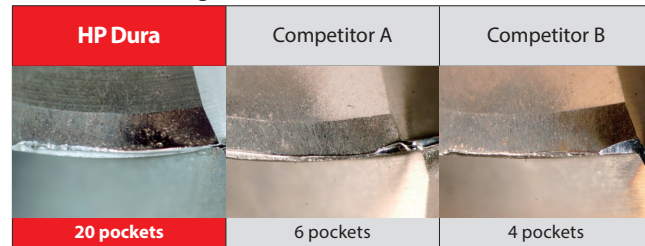
Provides three times longer life in wet and dry machining

Dry milling

Tool	Ball nose Endmill R5×18
Work Material	S50C
Cutting speed	200m/min (6.366min ⁻¹)
Feed	1.604mm/min (0,126mm/t)
Milling process	Pocket milling
Depth cut	a _p = 1mm P _f = 2mm
Length	4D
Coolant	Air blow
Machine	Vertical Machining Center

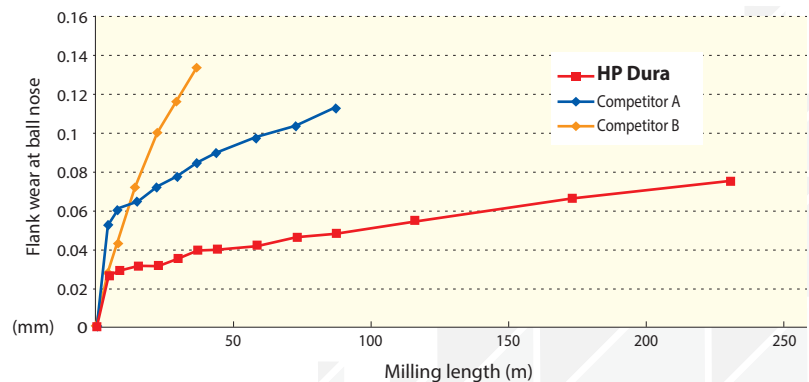


After Pocket Milling

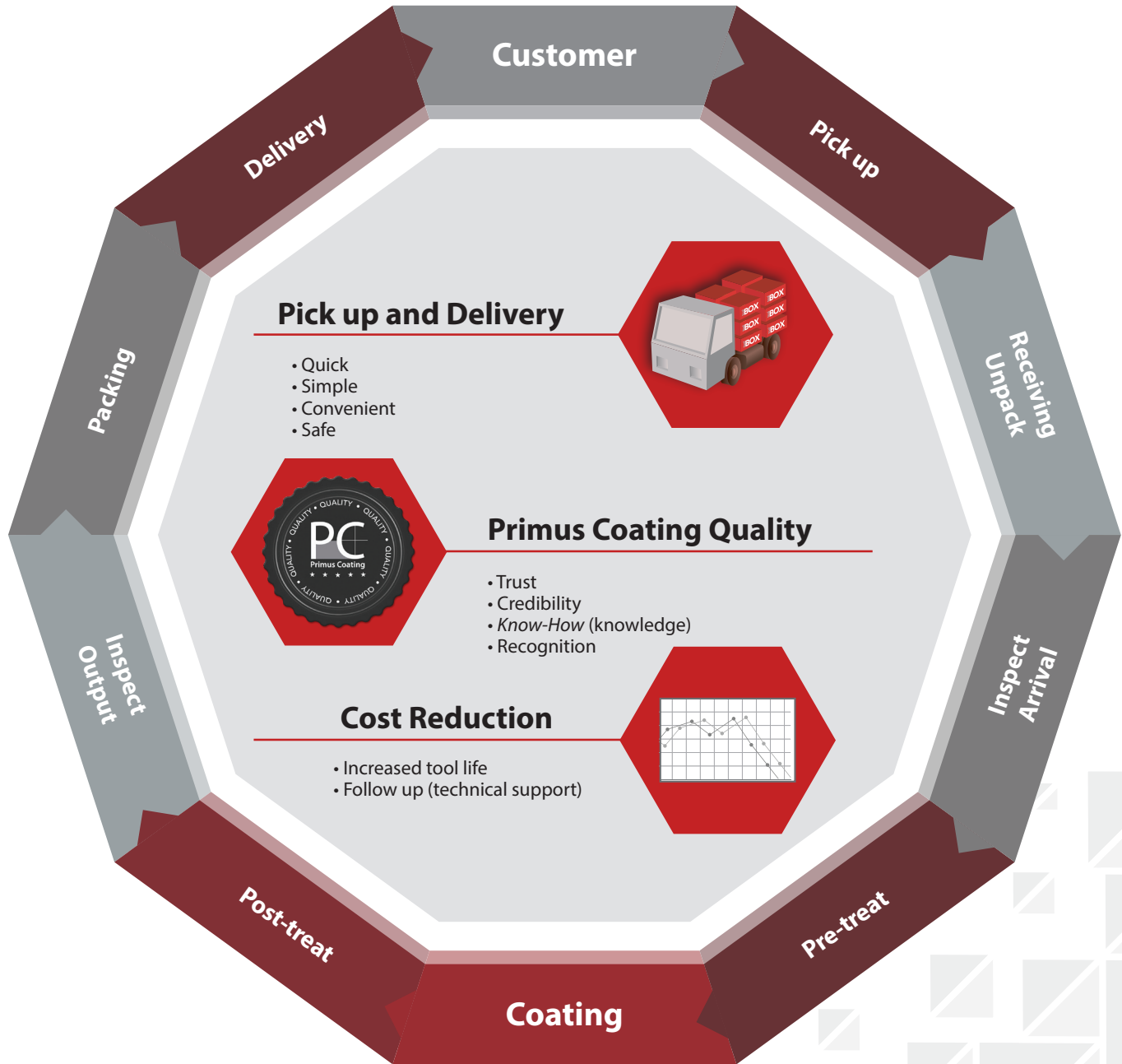


Coolant milling

Tool	Ball nose Endmill R5×18
Work Material	S50C
Cutting speed	199,7m/min (10.600min ⁻¹)
Feed	2.570mm/min (0,121mm/t)
Milling process	Profile Milling
Depth cut	a _p = 0.3mm P _f = 0.6mm
Coolant	Water soluble (emulsion)
Machine	Vertical Machining Center



■ PRIMUS COATING QUALITY ASSURANCE



PrimusCoating

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We listen
 understand
 deliver

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