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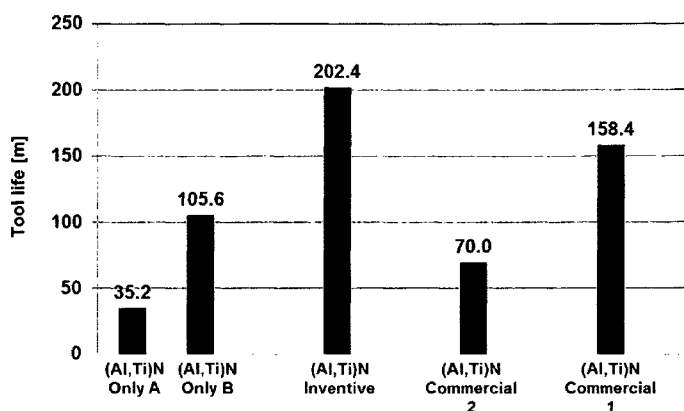
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ISTANCE IN MACHINING OPERATIONS AND METHOD THEREOF

Fig. 3

(57) Abstract: The present invention relates to an (Al,Ti)N coating exhibiting at least two different coating portions, A and B, hav-
ing grain size in nanometer magnitude order characterized in that the coating portion A exhibit larger grain size and higher elastic
modulus than the coating portion B. The present invention relates as well to a method for coating a substrate with a coating as de-
scribed above whereby at least the coating portion A and/or the coating portion B of the (Al,Ti)N coating are/is deposited by means
of PVD techniques.