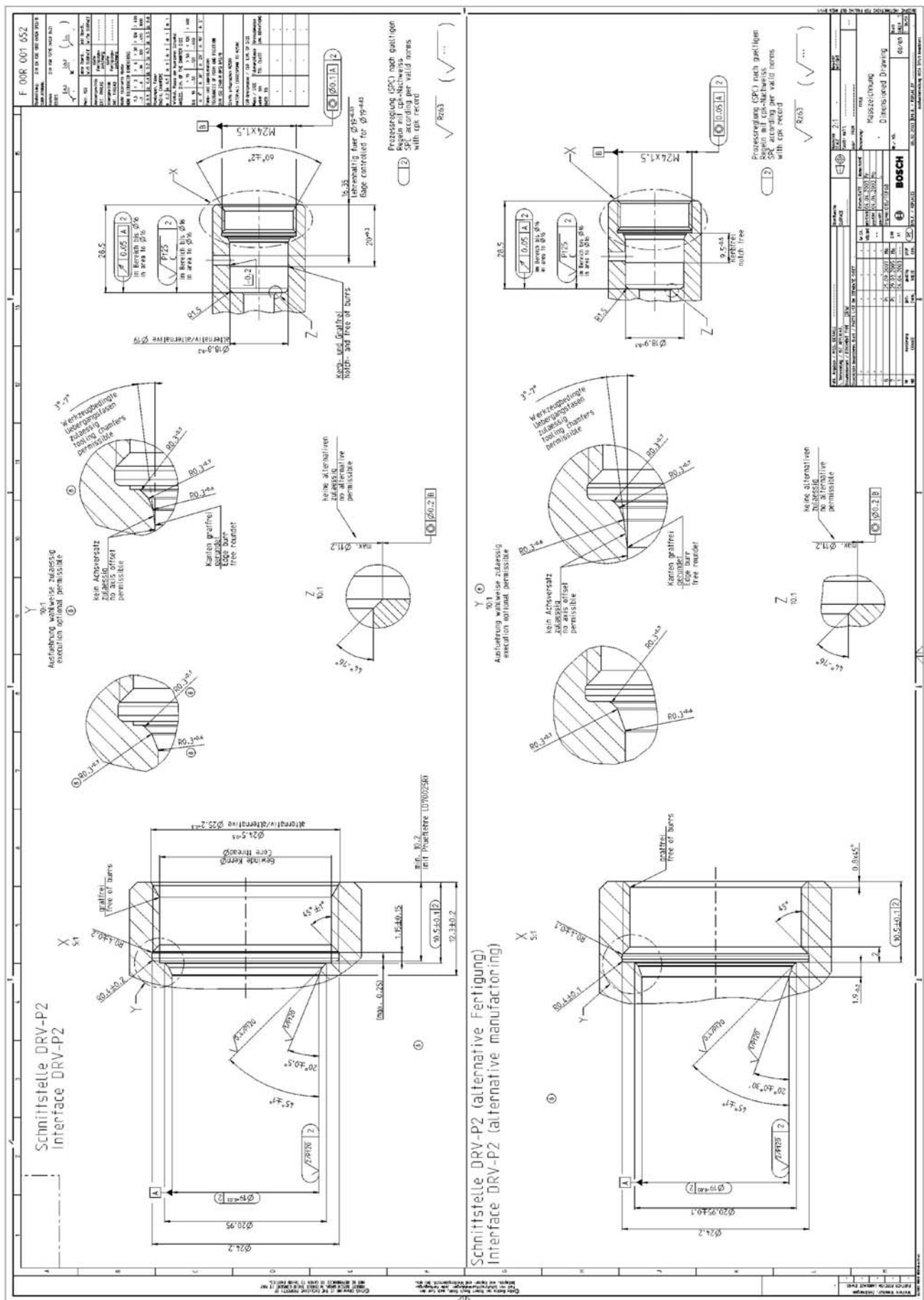


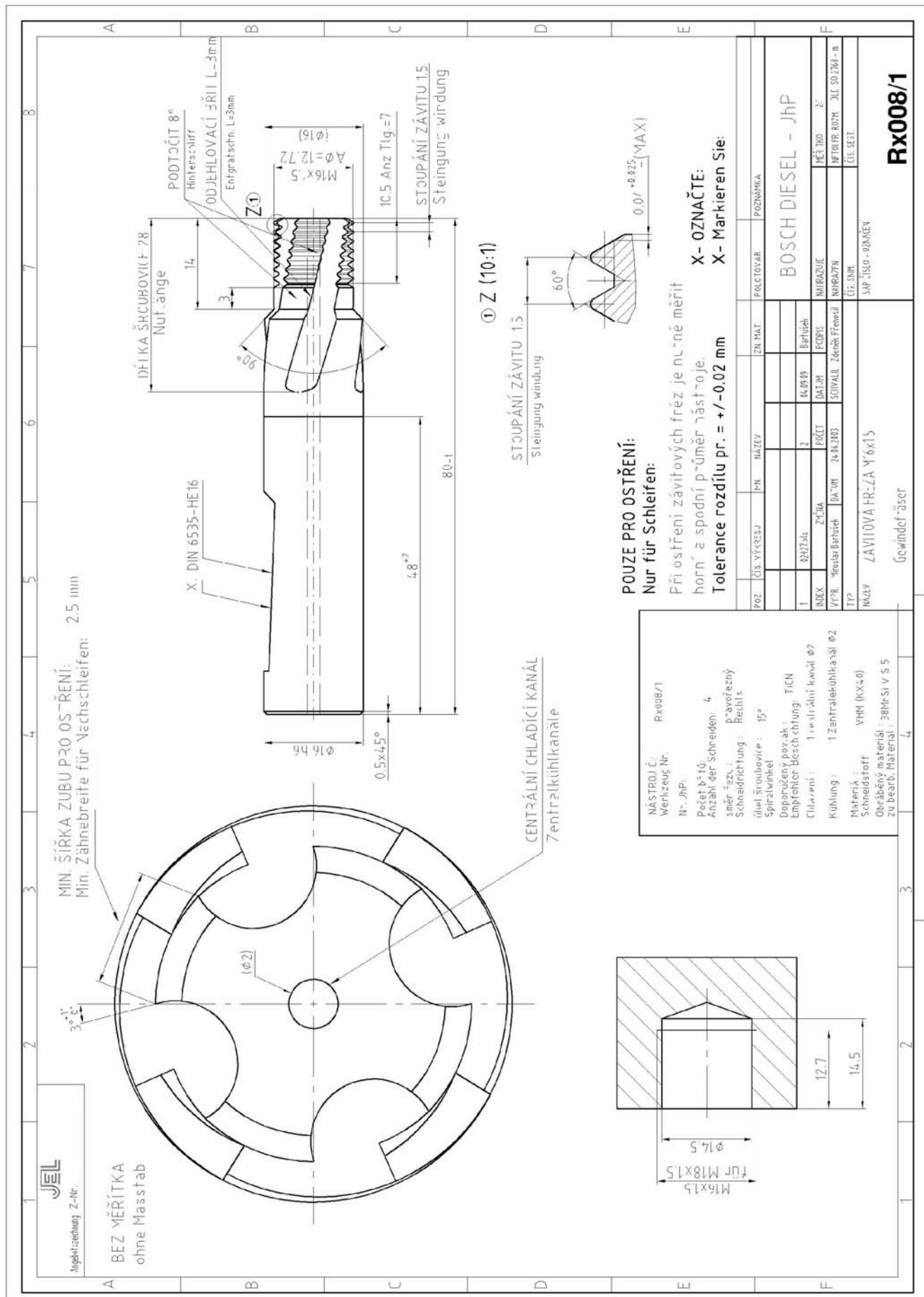
6.1 Frézovaný Závít M18x1,5 ve vývodu vysokotlakého zásobníku Bosch



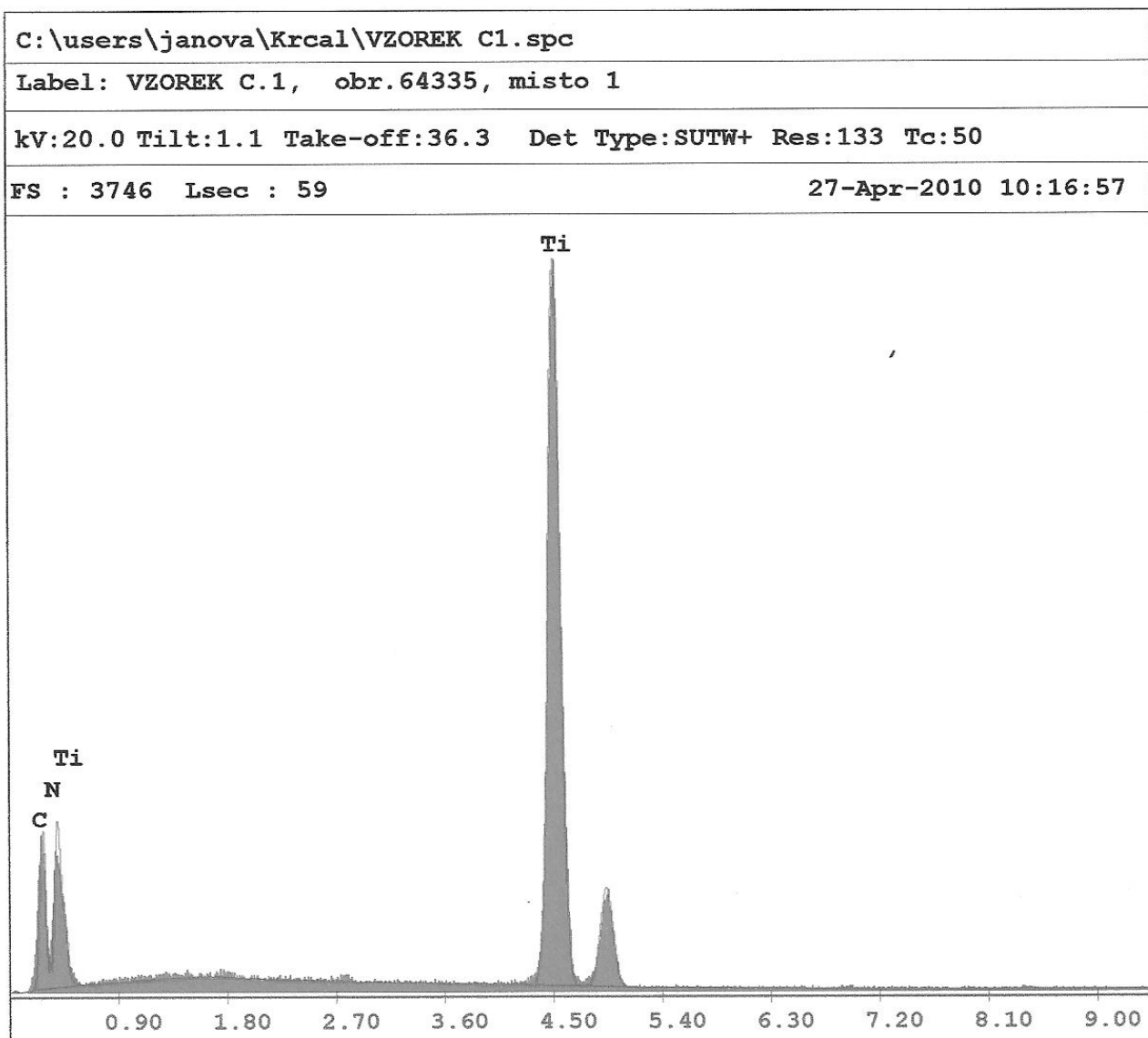
6.2 Frézovaný Závít M24x1,5 ve vývodu vysokotlakého zásobníku Bosch



6.3 Závitová fréza M16x1,5



6.4 Polokvantitativní disperzní analýza povrchu prvního nástroje- Povlak TiCN



EDAX ZAF Quantification (Standardless)

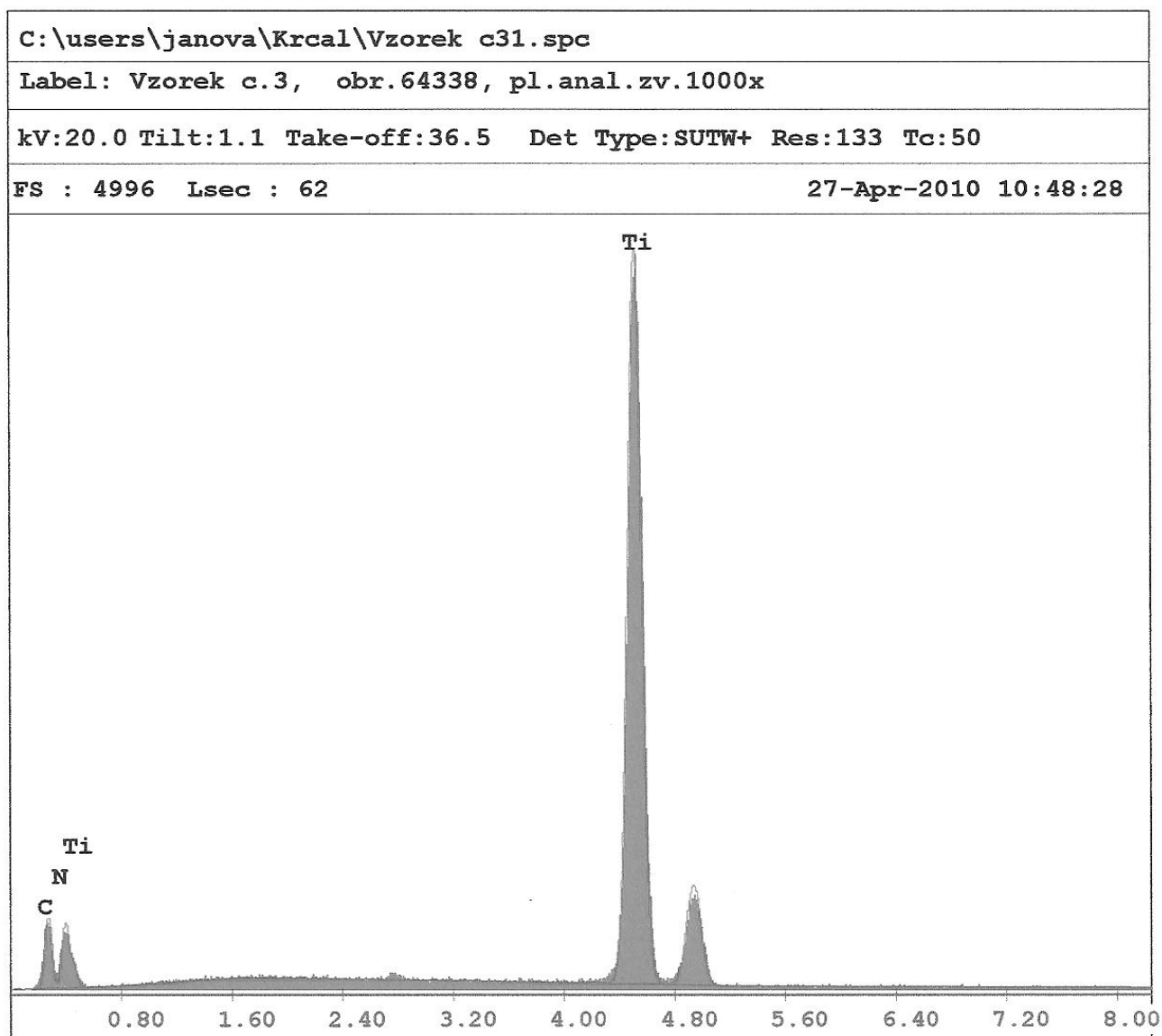
Element Normalized

SEC Table : Default

Element	Wt %	At %	K-Ratio	Z	A	F
C K	22.73	42.59	0.0976	1.1004	0.3902	1.0007
N K	18.56	29.82	0.0465	1.0906	0.2294	1.0011
TiK	58.71	27.59	0.5495	0.9212	1.0159	1.0000
Total	100.00	100.00				

Element	Net Inte.	Bkgd Inte.	Inte. Error	P/B
C K	62.60	1.70	1.68	36.86
N K	37.77	2.79	2.26	13.53
TiK	607.94	5.95	0.53	102.13

6.5 Polokvantitativní disperzní analýza povrchu třetího nástroje- Povlak TiCN



EDAX ZAF Quantification (Standardless)

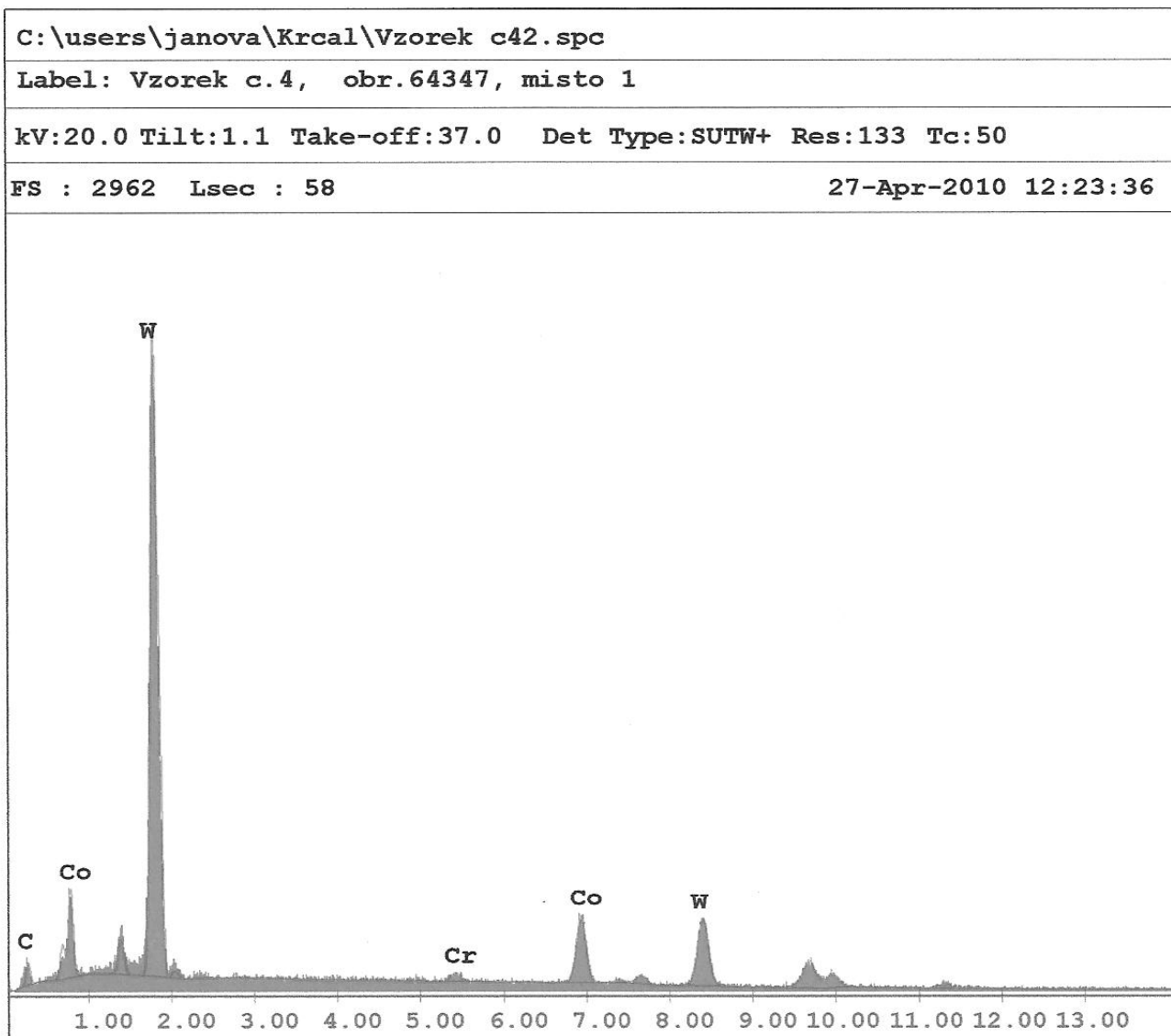
Element Normalized

SEC Table : Default

Element	Wt %	At %	K-Ratio	Z	A	F
C K	15.11	36.62	0.0580	1.1370	0.3376	1.0008
N K	8.01	16.64	0.0242	1.1269	0.2682	1.0020
TiK	76.89	46.74	0.7396	0.9532	1.0092	1.0000
Total	100.00	100.00				

Element	Net Inte.	Bkgd Inte.	Inte. Error	P/B
C K	35.61	0.69	2.16	51.74
N K	18.83	1.17	3.09	16.12
TiK	779.32	7.23	0.46	107.72

6.6 Polokvantitativní disperzní analýza povrchu čtvrtého nástroje- základní substrát



EDAX ZAF Quantification (Standardless)

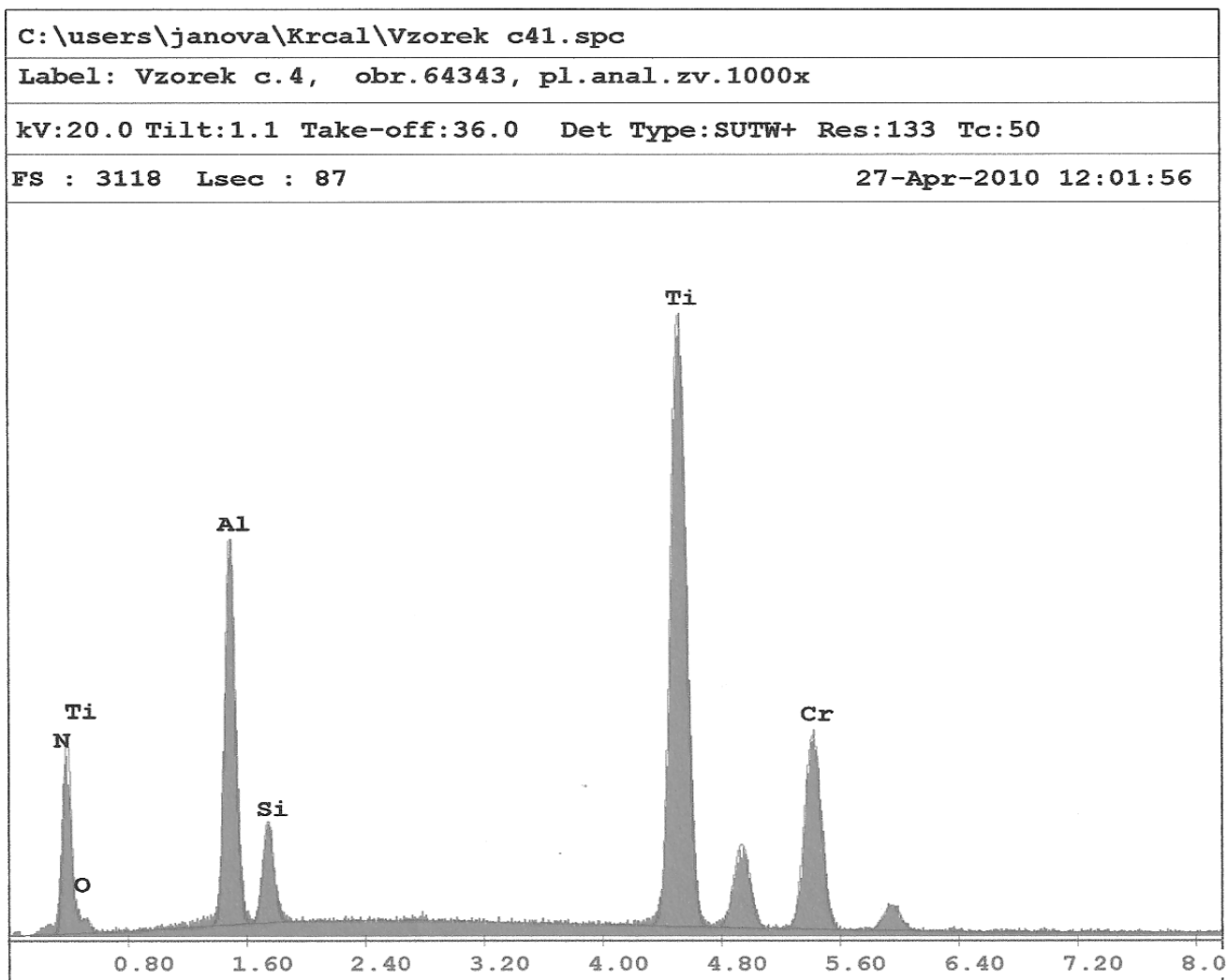
Element Normalized

SEC Table : Default

Element	Wt %	At %	K-Ratio	Z	A	F
C K	7.86	48.98	0.0178	1.3118	0.1730	1.0000
CrK	1.33	1.91	0.0136	1.1247	0.8810	1.0331
CoK	14.07	17.87	0.1596	1.1231	0.9436	1.0702
W L	76.74	31.24	0.6955	0.9072	0.9990	1.0000
Total	100.00	100.00				

Element	Net Inte.	Bkgd Inte.	Inte. Error	P/B
C K	6.79	2.50	6.60	2.71
CrK	6.79	8.10	9.21	0.84
CoK	50.19	8.14	2.12	6.17
W L	58.01	4.85	1.85	11.96

6.7 Polokvantitativní disperzní analýza povrchu čtvrtého nástroje- povlak TiAlCrN



EDAX ZAF Quantification (Standardless)

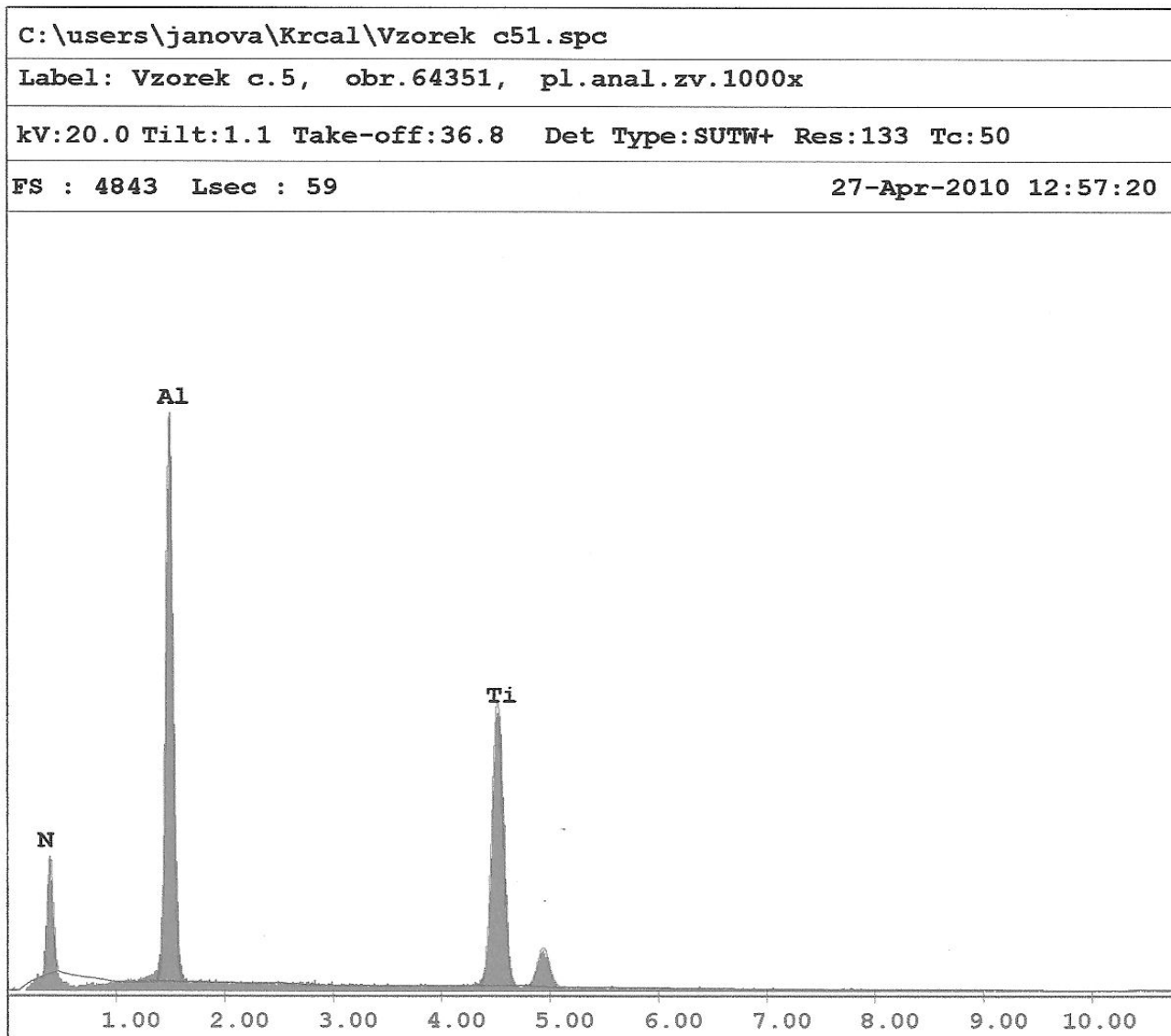
Element Normalized

SEC Table : Default

Element	Wt %	At %	K-Ratio	Z	A	F
N K	20.01	41.34	0.0753	1.1122	0.3380	1.0012
O K	2.68	4.84	0.0033	1.1031	0.1120	1.0006
AlK	13.84	14.85	0.0772	1.0265	0.5417	1.0026
SiK	3.67	3.79	0.0221	1.0562	0.5666	1.0029
TiK	40.09	24.22	0.3835	0.9404	0.9901	1.0274
CrK	19.70	10.96	0.1691	0.9375	0.9158	1.0000
Total	100.00	100.00				

Element	Net Inte.	Bkgd Inte.	Inte. Error	P/B
N K	43.85	0.62	1.63	71.29
O K	3.99	0.95	6.49	4.22
AlK	132.25	4.76	0.96	27.78
SiK	35.22	5.71	2.07	6.17
TiK	305.30	5.67	0.62	53.82
CrK	103.88	4.23	1.09	24.58

6.8 Polokvantitativní disperzní analýza povrchu páteho nástroje- povlak TiAlN



EDAX ZAF Quantification (Standardless)

Element Normalized

SEC Table : Default

Element	Wt %	At %	K-Ratio	Z	A	F
N K	29.63	51.44	0.0978	1.0866	0.3035	1.0008
AlK	32.60	29.39	0.2174	1.0033	0.6636	1.0014
TiK	37.77	19.17	0.3416	0.9174	0.9859	1.0000
Total	100.00	100.00				

Element	Net Inte.	Bkgd Inte.	Inte. Error	P/B
N K	65.22	12.30	1.89	5.30
AlK	422.66	8.52	0.65	49.60
TiK	307.60	6.39	0.76	48.16