

THE EFFECT OF LFG PLASMA SPUTTERING POWER ON HARDNESS OF CARBON THIN FILMS ON SKD11 STEEL USING TARGET MATERIAL FROM BATTERY CARBON RODS

1. Registrasi (12 Maret 2020)
2. Journal submission "Eastern-European Journal of Enterprise Technologies" (13 Maret 2020)
3. First revision with major revision (13 Maret 2020)
4. Pengiriman kembali jurnal dengan perbaikan revisi (03 April 2020)
5. Second revision (09 April 2020)
6. Third revision (14 April 2020)
7. Accepted (20 April 2020)
8. Payment (29 April 2020)
9. Published (30 April 2020)

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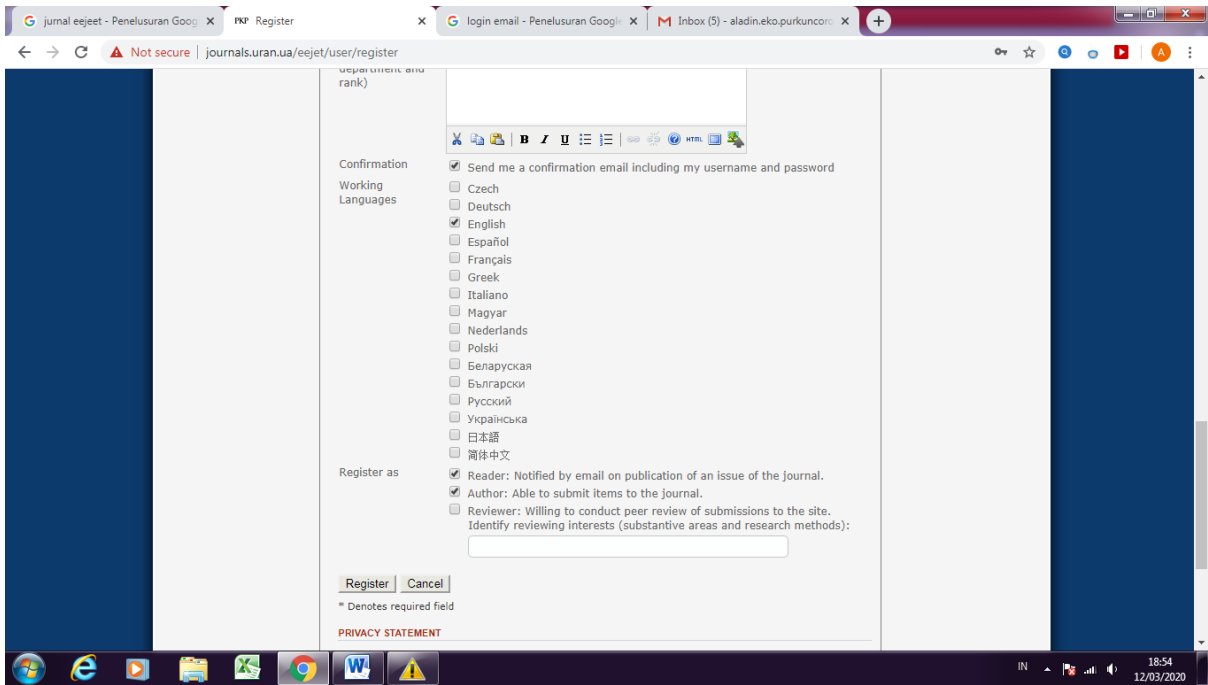
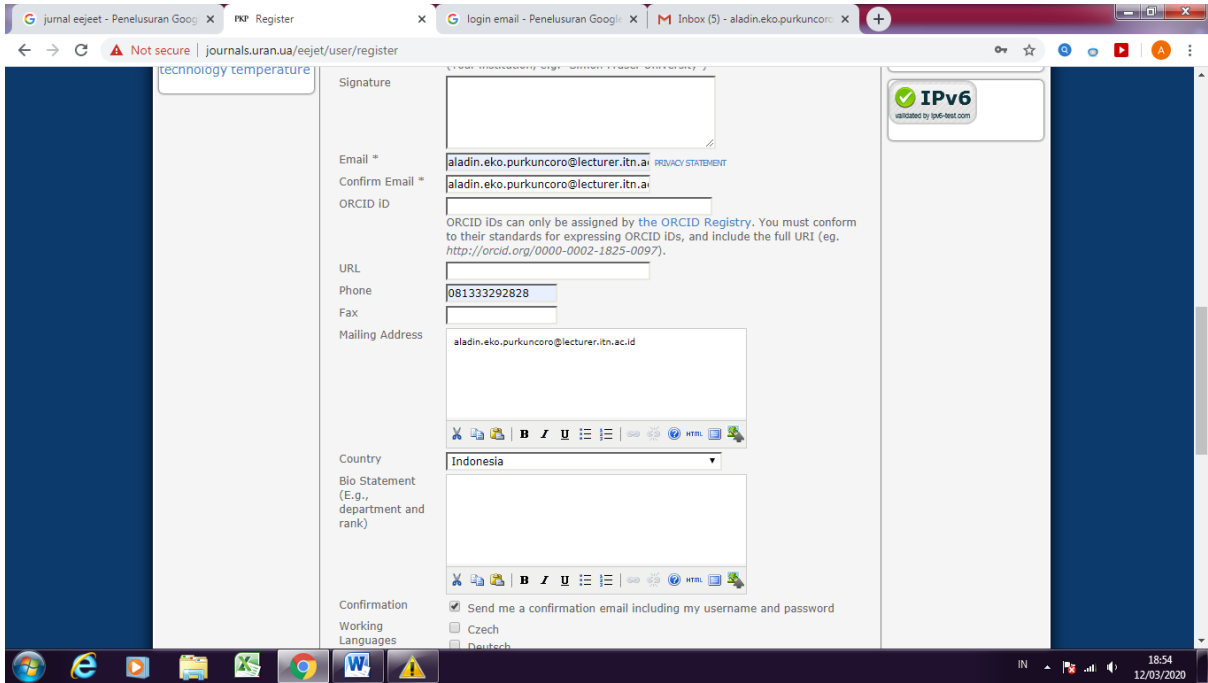
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[11] L. Anguilano, "Argon plasma treatment techniques on steel and effects on diamond-like carbon structure and delamination," *Brunel University*, vol. 20, pp. 1030-1035, 2011.

[12] W. Mróz, "Characteristics of carbon films deposited by magnetron sputtering," *Acta Physica Polonica A*, pp. 120-122, 2009.

[13] Muhammad, "Design of plasma generator driven by high-frequency high-voltage power supply," *Journal of Applied Research and Technology*, vol. 11, no. 2, p. 225-229, 2019.

[14] C. Jongvannasin and S. Watanabe, "Effects of RF Power and Treatment Time on Wettability of Oxygen Plasma-Treated Diamond-like Carbon Thin Films," *International Journal of Chemical Engineering and Applications*

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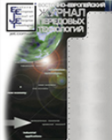
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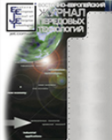
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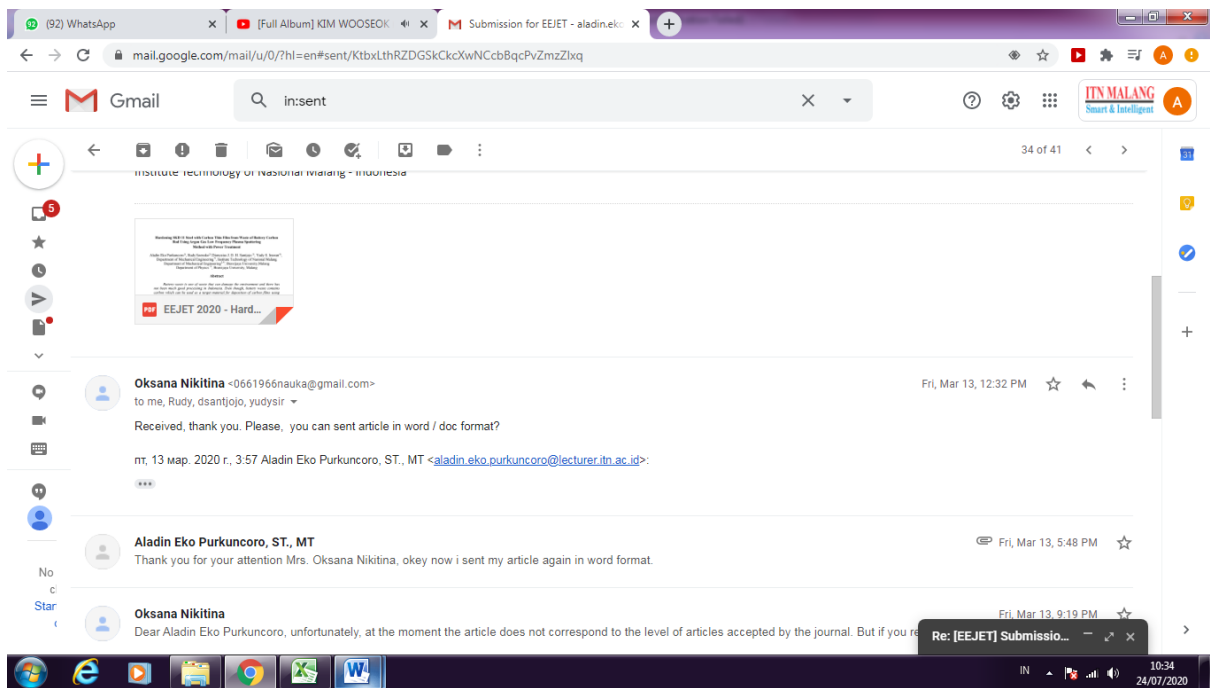
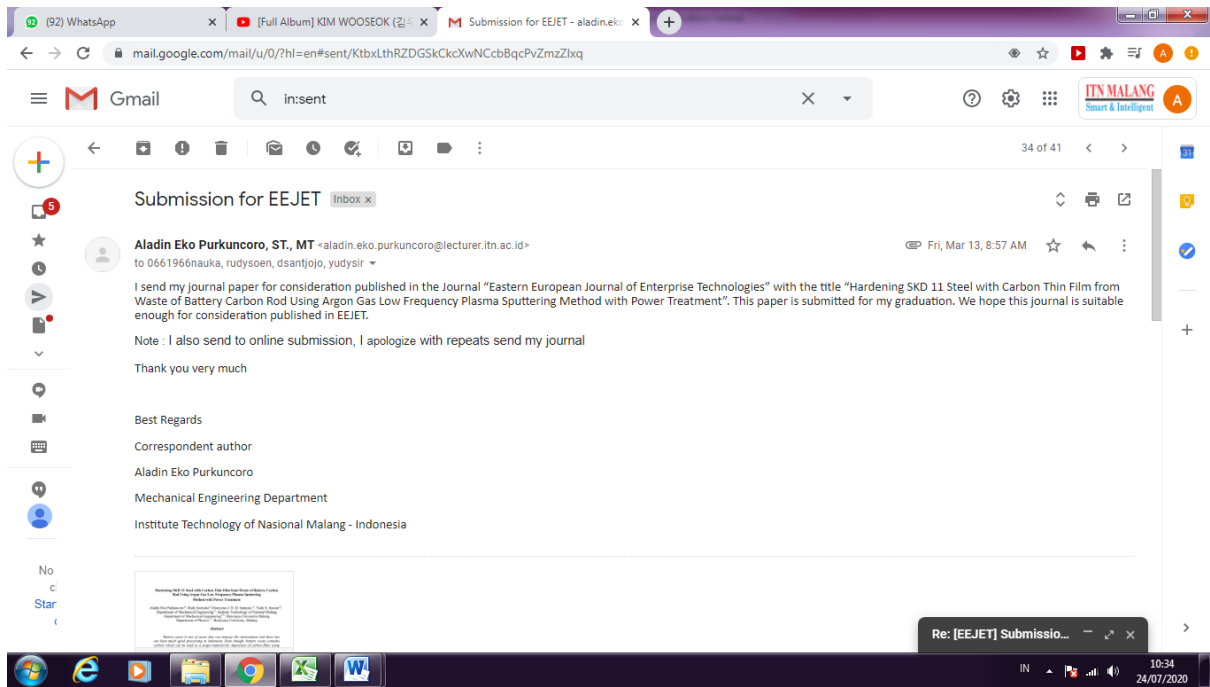
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Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana, Rudy, dsantjojo, ST.M.Eng Sat, Mar 14, 6:06 AM

Thank you for your information. I will revision this article exactly. I hope to be accepted in Eastern European Journal of Enterprise Technologies journal. Once again, thank you very much, Mrs. Oksana Nikitina. 🙏🙏

Oksana Nikitina to Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> Sat, Mar 14, 1:23 PM

You are welcome. с6, 14 мар. 2020 г., 1:06 Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana Mon, Mar 16, 1:56 AM

Good evening, Mrs. Oksana Nikitina, I am still in the process of working on revising my article, so I will send it back soon. I apologize for sending the wrong, Mrs. Oksana Nikitina, once again forgive me, Ms. Oksana Nikitina, as soon as I finish immediately.

Buttons: Reply, Forward

Taskbar: Re: [EEJET] Submissio... 10:35 24/07/2020

Browser tabs: (92) WhatsApp, [Full Album] KIM WOOSSEOK, [EEJET] Submission Acknowledg...

mail.google.com/mail/u/0/?hl=en#sent/FMfcgwHMPdPzIIISZBllsTrHlzKHVbX


Gmail search: in:sent

32 of 41

Без вирусов. www.avast.com

Oksana Nikitina <0661956nauka@gmail.com> to me Mon, Mar 16, 1:56 AM

Detect language > English > Translate message Turn off for: Russian x



Buttons: Reply, Forward

Taskbar: Re: [EEJET] Submissio... 10:36 24/07/2020

Browser tabs: (92) WhatsApp, [Full Album] KIM WOOSSEOK, [EEJET] Submission Acknowledge

mail.google.com/mail/u/0/?hl=en#sent/FMfcgxxwHMPdPzIISfZBIsTrHlzKHVbX

Gmail search: in:sent


32 of 41

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana

Fri, Apr 3, 7:53 AM

Good morning, Mrs. Oksana Nikitina, I send my article. I hope to be accepted in Eastern European Journal of Enterprise Technologies Journal. Once again, thank you very much, Mrs. Oksana Nikitina.

...



Oksana Nikitina <0661966nauka@gmail.com> to me

Fri, Apr 3, 6:00 PM

please send an article in doc/ dox format

No viruses found. www.avast.com

nt, 3 apr. 2020 r. a 03:53, Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>

Re: [EEJET] Submissio...

Windows taskbar: 10:36 24/07/2020

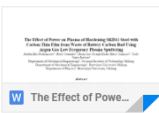
mail.google.com/mail/u/0/?hl=en#sent/KtbxLxGnPWsHRJXhtfpvSCMHGFFCKGMgdB

Gmail in:sent

31 of 41

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
 Fri, Apr 3, 6:46 PM

Good Night, Mrs. Oksana Nikitina, I send my article in doc/dx format. I hope to be accepted in Eastern European Journal of Enterprise Technologies journal. Once again, thank you Mrs. Oksana Nikitina 🙏🙏



Oksana Nikitina Received, thank you. Без вирысов. www.avast.com nt, 3 anp. 2020 r. v 14:46, Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>
 Fri, Apr 3, 6:51 PM

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
 Fri, Apr 3, 8:48 PM

You are welcome.

Re: [EEJET] Submissio...

mail.google.com/mail/u/0/?hl=en#sent/FMfcgxwHMjpZxJFmPCfkwTNmzxXfjTMV

Gmail in:sent

28 of 41

Oksana Nikitina <0661966nauka@gmail.com> to me, Rudy, dsantjojo, ST,M.Eng
 Thu, Apr 9, 2:13 AM

Good afternoon, Aladin Eko Purkuncoro.

The article was accepted for consideration of the possibility of publication in (No. 2(104) 2020).

At the 2 - stage of editing, please take into account the comments of the editor (article in the application, color notes are highlighted).

WE ASK YOU TO RIGHT STRICTLY IN THE OPTION WHICH IS IN THE APPENDIX (see appendix).

We ask you not to delete the comments so that we can see all your edits. All corrections by the author, please highlight in green.

WE REQUEST YOU THE EDITORED VARIANT OF THE ARTICLE SEND 14.04.2020.

We are in touch 24/7.

with respect, general manager
 Oksana Nikitina
 viber +38(050)303-38-01
 0661966nauka@gmail.com
 twitter_linkedin

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 Website: <http://journals.uran.ua/eejet/>

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28 of 41

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Purkuncoro 18-a- (...)

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana

Sun, Apr 12, 11:22 PM

Good Night, Mrs. Oksana Nikitina, I send my article revision . I hope for consideration of the possibility of publication in Eastern European Journal of Enterprise Technologies journal (No.2(104)2020). Once again thank you very much Mrs. Oksana Nikitina,

The Effect Of LFG ...

Re: [EEJET] Submissio...

10:38 24/07/2020

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mail.google.com/mail/u/0/?hl=en#sent/FFNDWMQTVcSkJMbzKktZkFZBpcwjZcQc

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26 of 41

I send my article revision ALADIN EKO PURKUNCORO

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana

Tue, Apr 14, 4:57 AM

Good Night, Mrs. Oksana Nikitina, I send my article revision . I hope for consideration of the possibility of publication in Eastern European Journal of Enterprise Technologies journal (No.2(104)2020). Once again thank you very much Mrs. Oksana Nikitina,

The Effect Of LFG ...

Oksana Nikitina <0661966nauka@gmail.com> to me

Tue, Apr 14, 9:08 PM

Hello!

Your article has been sent for review. The article is still in work. As soon as there is a response from reviewers, we will contact you (0.5-1.5 weeks).

Re: [EEJET] Submissio...

10:38 24/07/2020

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mail.google.com/mail/u/0/?hl=en#sent/FFNDWMQTvcSkjMbZKktZkFZBpcwjZcQc

Gmail search: in:sent

26 of 41

Oksana Nikitina <0661966nauka@gmail.com> to me
Tue, Apr 14, 9:08 PM

Hello!

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with respect,
general manager
Oksana Alexandrovna
=====

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Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>

Re: [EEJET] Submissio...

10:38 24/07/2020

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26 of 41

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Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Wed, Apr 15, 3:07 AM

Thank you very much. Mrs. Oksana Nikitina 🙏🙏

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Re: [EEJET] Submissio...

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23 of 41

Aladin Eko Purkuncoro reminds me that I expect an article from you today 25.04.2020. Inbox x

Oksana Nikitina <0661966nauka@gmail.com> to me Sat, Apr 25, 4:48 AM



Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana Sat, Apr 25, 5:52 AM

No c
Star

Yes, I'm ready, the article will be finished soon, have nice weekend thoo , Once again thank you very much Mrs. Oksana Nikitina 🙏🙏

On Sat, Apr 25, 2020 at 4:48 AM Oksana Nikitina <0661966nauka@gmail.com> wrote:

Re: [EEJET] Submisio...

10:39 24/07/2020


mail.google.com/mail/u/0/?hl=en#sent/FMfcgwxHMsXZLcbkGBGtVDMsbxbxsGV

Gmail in:sent

23 of 41

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana Sat, Apr 25, 9:34 PM

Good Night, Mrs. Oksana Nikitina, I sent the article revision and my article was finished, Once again thank you very much Mrs. Oksana Nikitina



Oksana Nikitina Sun, Apr 26, 2:06 AM

all corrections should be highlighted in green, I don't accept, I'm waiting for the article... c6, 25 anp. 2020 r. v 17:34, Aladin Eko Purkuncoro, ST., MT <alad

Aladin Eko Purkuncoro, ST., MT Sun, Apr 26, 4:09 AM

Ok, I will check. thank you very much Mrs. Oksana Nikitina

Aladin Eko Purkuncoro, ST., MT Sun, Apr 26, 7:17 AM

Good Moorning, Mrs. Oksana Nikitina, I sent the article revision and my article was finished, all corrections should be highlighted in green . Once aga

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23 of 41

Oksana Nikitina <0661966nauka@gmail.com> to me
Sun, Apr 26, 2:06 AM
all corrections should be highlighted in green, I don't accept, I'm waiting for the article...
сб, 25 апр. 2020 г. в 17:34, Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Sun, Apr 26, 4:09 AM
Ok, I will check. thank you very much Mrs. Oksana Nikitina

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Sun, Apr 26, 7:17 AM
Good Moorning, Mrs. Oksana Nikitina, I sent the article revision and my article was finished, all corrections should be highlighted in green, Once again thank you very much Mrs. Oksana Nikitina 🙏🙏🙏

Taskbar: Re: [EEJET] Submissio... 10:39 24/07/2020

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23 of 41

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Sun, Apr 26, 7:18 AM
Attachment: EEJET Purkuncoro ...

Oksana Nikitina <0661966nauka@gmail.com> to me
Sun, Apr 26, 7:20 AM
Russian → English Translate message Turn off for: Russian x

Image: THANK YOU!! HAVE A GREAT


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Gmail search: in:sent

23 of 41



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Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana

Sun, Apr 26, 7:28 AM

you are welcome , Have A Great Weekend Thoo , Mrs. Oksana Nikitina , Once again thank you very much Mrs. Oksana Nikitina 🙏🙏🙏🙏🙏🙏

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21 of 41

from "Eastern-European Journal of Enterprise Technologies"_invoice_Aladin Eko Purkuncoro

Oksana Nikitina <0661966nauka@gmail.com> to me

Tue, Apr 28, 3:48 PM

Hello, dear Aladin Eko Purkuncoro.

The article was adopted for publication in the April issue of the journal (№2(104)2020).

Invoice (invoice № 600/88-102-2020) in the application. The amount that you put up was taken into account: payment for an article (15 pages*15 euro=225 euro), payment for a hard copy of the journal with delivery to your postal address (0 euro), 160 euro - prepress (redistribution of literature on standards DSTU 2015, ARA (registration in accordance with standards, search for and addition of DOI identifiers), internal work of the editorial team over article, checking the translation of an article into a technical one professional English). The total amount to be paid is 390-50 advance payment = **340 euro euro to pay.**

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2. We ask you to prepare and send us a scan of the documents: The license agreement (see in the appendix, it is necessary to sign all the authors and put a seal).

Please confirm receipt of the letter.

We are in touch 24/7.

with respect, general manager
Oksana Nikitina
viber +38(050)303-38-01
0661966nauka@gmail.com
[twitter](#) [linkedin](#)

Taskbar: 10:40 24/07/2020

Browser tabs: (93) WhatsApp, [Full Album] KIM WOOSSEOK, from "Eastern-European Journal" | URL: mail.google.com/mail/u/0/?hl=en#sent/FMfcgwxHNCrXsfgyLcVDKtDfRZBLvSL

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From: 0661966nauka@gmail.com
Subject: Editorial staff of the "Eastern-European Journal of Enterprise Technologies"
Website: <http://journals.uran.ua/eejet/>

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3 Attachments:
- License_agreemen...
- Invoice_88_102_AL...
- Purkuncoro 15 прп...

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Tue, Apr 28, 4:30 PM

Good afternoon . Dear Oksana Nikitina , Thank you for the information. I will immediately pay my article, Once again thank you very much Mrs. Oksana Nikitina 🙏🙏🙏

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Browser tabs: (93) WhatsApp, [Full Album] KIM WOOSSEOK, from "Eastern-European Journal" | URL: mail.google.com/mail/u/0/?hl=en#sent/FMfcgwxHNCrXsfgyLcVDKtDfRZBLvSL

Gmail interface: Search: in:sent | ITN MALANG Smart & Intelligent | 21 of 41

From: Oksana Nikitina <0661966nauka@gmail.com> to me
Wed, Apr 29, 6:16 PM

Hello, dear Aladin Eko Purkuncoro please let me know when you can pay?

Без вирусів. www.avast.com

вт, 28 апр. 2020 г. в 11:48, Oksana Nikitina <0661966nauka@gmail.com>:

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Wed, Apr 29, 7:09 PM

Good Night, Dear Mrs. Oksana Nikitina, I sent proof of payment . Once again, thank you Mrs. Oksana Nikitina

2 Attachments:
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Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana Wed, Apr 29, 7:09 PM

Good Night, Dear Mrs. Oksana Nikitina, I sent proof of payment . Once again, thank you Mrs. Oksana Nikitina

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20 of 41

it's ok? Inbox x

Oksana Nikitina <0661966nauka@gmail.com> to me Wed, Apr 29, 7:27 PM

3 Attachments

- ABSTRACT AND R...
- Content.pdf
- Purkuncoro.pdf

Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana Wed, Apr 29, 7:51 PM

Once again thank you very much Mrs. Oksana Nikitina 🙏🙏🙏🙏

On Wed, Apr 29, 2020 at 7:27 PM Oksana Nikitina <0661966nauka@gmail.com> wrote:

Re: [EEJET] Submissio...

Taskbar: 10:40 24/07/2020

Browser tabs: (93) WhatsApp, [Full Album] KIM WOOSSEOK, it's ok? - aladin.eko.purkuncoro@...
Address bar: mail.google.com/mail/u/0/?hl=en#sent/FMfcgxwHNCsnkwFSTZwclzXfVPhRgWxB

Gmail interface: Search: in:sent, ITN MALANG Smart & Intelligent logo, 20 of 41 messages.

Message 1: From Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id> to Oksana
Wed, Apr 29, 7:51 PM
Once again thank you very much Mrs. Oksana Nikitina 🙏🙏🙏🙏
On Wed, Apr 29, 2020 at 7:27 PM Oksana Nikitina <0661966nauka@gmail.com> wrote:

Message 2: From Oksana Nikitina <0661966nauka@gmail.com> to me
Wed, Apr 29, 8:08 PM
You are welcome. 💜💜💜💜
cp. 29 anp. 2020 r., 15:51 Aladin Eko Purkuncoro, ST., MT <aladin.eko.purkuncoro@lecturer.itn.ac.id>

Reply suggestions: What are you doing? You are so sweet, thank you! Thank you!

Taskbar: Windows 10 taskbar with icons for File Explorer, Chrome, Word, and a notification for [EEJET] Submissio...
System tray: 10:41, 24/07/2020

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to use the work

Kharkiv

"Malang, Indonesia" April 29, 2020

Aladin Eko purkuncoro, Rudy Soenoko, Dionysius Joseph Djoko Herry Santjojo, Yudy Surya Irawan
(name of the author, co-authors)

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3. Territory of use

3.1. The territory on which it is allowed to use rights to the Work is not restricted.

4. The period, for which the rights are granted

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4.3. In the case when the Work has not been accepted for publication or the Licensor has withdrawn the manuscript, the present Agreement expires.

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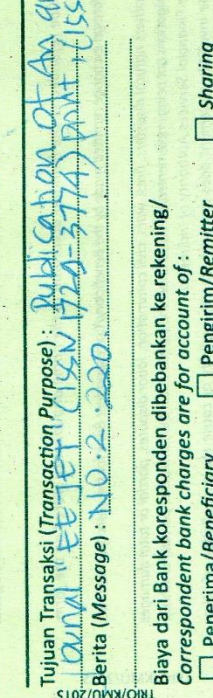
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:57D:JSC CB PRIVATEBANK

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Акумуляторні відходи – це відходи, які можуть завдати шкоди навколишньому середовищу, і в Індонезії досі не налагоджена їх якісна переробка. Хоча відходи батарей містять вуглець, який може бути використаний в якості цільового матеріалу для осадження вуглецевих плівок з використанням плазмового розширення. Метою даного дослідження є визначення ефекту і оптимального значення потужності генерації плазмового аргону для отримання максимального значення твердості сталі SKD11, що забезпечує вироблення потужності. В даному методі використовується плазма у вигляді аргону. Аргонова плазма генерується з використанням LGF 40 кГц. Тонка плівка вуглецю, що синтезується на сталі SKD11, була випробувана для визначення величини твердості з використанням мікротвердості по Віккерсу. Виходячи з результатів експерименту, оптимальна потужність, отримана при 340 Вт з найвищим середнім значенням твердості, становить 316,7 НВ. Грунтуючись на спостереженні SEM-EDX, можна описати, що порівняння атомарного вуглецю з вуглецевих стрижнів без обробки (1,5 %) і вуглецевих тонких плівок на SKD11 з оптимальною енергетичною обробкою (13,36 %) показує різні значення. Кількість атомарного вуглецю тонких плівок на SKD11 з енергетичною обробкою вище, ніж у атомарного вуглецю вуглецевих стрижнів без обробки, обумовлює більш високе значення твердості тонких плівок на сталі SKD11 після обробки плазмовим напленням за оптимальними енергетичними параметрами, ніж у сталі SKD11 без обробки. Сталь SKD11, що має високе значення твердості, що використовується в якості штампів і різання, вимагає високих показників твердості

Ключові слова: сталь SKD11, плазмове наплення, акумуляторні стрижні, потужність, LGF, твердість, аргон, осадження, тонкі плівки, вуглець

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1. Introduction

Zinc carbon battery rods have been widely used for several applications, such as toys, remote control, radio and cameras. Every year battery waste increases. But the increase in the amount of battery waste is not balance with recycle processing of battery waste. Even though, carbon rod from waste of Zinc-Carbon battery contains Aluminum (Al) and Iron (Fe) which are harmful to human health and the environment [1–3]. Actually in modern batteries don't use Pb and Hg already in water. This will certainly endanger to human health [4, 5]. Good recycling of carbon batteries will contribute to improving environmental quality. Previous studies used carbon rods for graphene oxide and biogas [3, 4]. Whereas carbon rods of batteries can be used for carbon layer deposition as a source of carbon.

Amorphous carbon layer has been widely used in industry and research. The amorphous carbon layer has a wide variety of properties of mechanical, physical, biomedical, and

THE EFFECT OF LFG PLASMA SPUTTERING POWER ON HARDNESS OF CARBON THIN FILMS ON SKD11 STEEL USING TARGET MATERIAL FROM BATTERY CARBON RODS

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tribological so that it can be utilized in broad applications as well [6–8]. Carbon atoms that have sp^3 hybridization have stronger bonds, so as to increase the hardness value of the thin layer of carbon material [7].

Previous research of carbon films were successfully synthesized using CVD plasma, hollow-cathode plasma and plasma sputtering [8]. Plasma sputtering has several advantages when compared to the other method, such as high deposition rate, low substrate temperature, and produce best quality thin film at lower substrate temperatures [10, 11]. Plasma sputtering bombards the target with energized particles, so that the ions from the carbon of the target material will come out and be deposited on the substrate. One of technique for carbon deposition in materials is low frequency 40 kHz plasma sputtering. The frequency is suitable for the plasma sputtering technique because the 40 kHz LFG generator has the highest ion density value of the two other plasma generator frequencies, 13.36 MHz and 2.45 GHz, so that more plasma particles are formed per square inch than

generators others [11]. Changes of ion density cause changes in ion bombardment of the target material for deposition of thin films [8, 10].

One of gas that is suitable for use in plasma sputtering is argon gas. Argon is an inert noble gas, which means it will form very little or no chemical compounds. In argon gas the dominant influence in plasma sputtering is a physical reaction. Argon atoms are heavy atoms with low reactive properties, so it would be more effective if used to target materials for deposition of thin films [8, 11].

Recently, the use of steel as a material in the industrial world and machinery has developed rapidly. Steel in the market generally has limited mechanical performance. One example is SKD11 steel which only has a hardness of 58–60 HV [13]. Though SKD11 steel is widely used as dies, forming, and cutting so it requires high hardness performance [13, 14].

The highest chemical content of SKD11 steel is carbon (C) [15]. The hardness of steel can also be increased by increasing the carbon content of the steel [16]. One of the ways to increase carbon content can be done by coating the steel with amorphous carbon [17]. The amorphous carbon layer is attractive to researchers because of its good mechanical properties such as low coefficient of friction, hardness and high durability [18]. The hardness performance of SKD11 steel can be improved by deposition of an amorphous carbon layer by plasma sputtering process [19].

Previous research on deposition of carbon thin film on glass substrate using material target from battery carbon rods with plasma sputtering show that the carbon was successfully deposited onto glass substrate. It was proved by FTIR results, C–C and C=C was formed [1]. In the view of all these, argon plasma sputtering to deposition carbon thin film using material target from battery carbon rods may provide a new efficient approach to improve the mechanical properties of films. There is great scope to work on this topic further.

In the other studies, microstructural changes and hardness variations in SKD11 steel have been investigated during the processes of carbide dispersion (CD). However, the process of carbide dispersion carburizing requires high temperatures at 980 °C and the process takes a long time for 120 min. The process certainly requires a greater cost than plasma sputtering. Even though, plasma sputtering is more simple and cheaper than carburizing method to improve hardness performance of SKD11 steel. However, the investigation plasma sputtering process for hardening SKD11 steel was limited. On the other sides, SKD11 steel has limited hardness performance of 58–60 HV. Even though, the steel is commonly used for industrial purposes which require a high hardness performance. Therefore, studies that are devoted to obtain the maximum average of hardness value of carbon thin films on SKD11 steel with optimization of argon gas power parameter on plasma sputtering.

2. Literature review and problem statement

Plasma is the fourth phase form of matter after solid, liquid, and gas [20]. Plasma is formed due to ionization. Plasma can be applied as a method for deposition of thin films [12]. One application of carbon deposition is carried out on steel. Synthesis of thin films has been carried out using plasma enhanced chemical vapor deposition, plate parallel hollow cathode plasma with radio frequency, and plasma sputtering.

Based on these 3 methods, plasma sputtering has several advantages compared to other methods such as high deposition rates, low substrate temperatures, and synthesis high quality of thin films [8, 11]. Plasma sputtering works by utilizing high energy of plasma species as bombers of target materials [21].

Steel that is often used for industry, generally has limited mechanical performance. Many of research are done to improve steel mechanical performance [19]. One of the examples is research of increasing the hardness value of AISI H13 steel. The results of research indicate that increasing the hardness value with the increasing carbon content of AISI H13 steel [22]. Besides AISI H13 steel, there is steel that often used in the industrial world, such as SKD11 steel [23]. SKD11 steel is often used for dies, forming, and cutting [15]. However, SKD11 steel still has weaknesses. SKD11 steel has low hardness, around 58–60 HV [13]. Based on these problems, research has to do to increase the value of steel hardness. One of the ways is deposition carbon thin films on SKD11 steel with plasma sputtering.

Power is an important role in the process of plasma sputtering [19, 23]. The higher the power, the stronger the electric field that is formed, and the greater ion energy. If the energy of ion is greater than the binding energy of the target material's atoms, the atoms of the target material will be detached from the bonds of the atoms and move in all directions. The atom of the target material that comes out is called a sputtered atom [10]. Sputtered atom will be deposited on surface substrate and thin films structure that is formed will affect to the hardness of substrate [1].

A similar study about the effect of plasma sputtering RF power on diamond-like carbon thin films was previously had been carried out by Jongwannasiri et al. Based on the results of the study showed plasma treatment on DLC films surface influenced to thickness change, but not affect to structure of the films with various RF powers [24]. However, the limitation of this result didn't discuss about the effect of various plasma power on hardness of DLC films and only discuss the thickness of DLC films. Even though, Björling et al, found that the thicker deposited carbon thin film on substrate will have a high probability of carbon content [25]. In addition, Concepción et al, also found that the greater value of carbon content in carbon thin films, the greater value of hardness [16]. Therefore in this study, deposition carbon thin films with plasma sputtering for hardening SKD11 is done by using material target from battery carbon rods and determine effect power of plasma connected with hardness of carbon thin films on SKD11.

3. The aim and objectives of research

The aim of research is to investigate plasma sputtering process to increasing hardness of carbon thin films on SKD11 steel.

To achieve this aim, the following objectives are accomplished:

- to observe plasma power affected on hardness of carbon thin films on SKD11 steel.

4. Experimental method

4.1. Sample preparation

Material target that used in this research was prepared by carbon rod from zinc-carbon ABC battery waste

(ABC Battery Industry, made in Indonesia). The carbon rod was cut into reach diameter 8 mm and length 55 mm. Then, the carbon rod was cleaned by ultrasonication with 40 kHz and 360 W in soap, solution for 1 minute. The cleaned carbon rod was dried in the oven at 300 °C for 2 hours. The substrate used is SKD11 steel. Before plasma sputtering process, the substrate was cleaned by technical alcohol.

4. 2. Deposition thin film

Carbon films were deposited using plasma sputtering. Plasma is generated by low frequency generator (LFG) 40 KHz. The plasma system has diameter chamber of 250 mm. The carbon rod as material target was placed at the electrode. Carbon rods as a target material are placed on the electrodes. The distance between the target material and SKD11 steel is kept at 1.7 cm. The argon gas was introduced with flow rate of 20 mL/min into the chamber after vacuum process of 1.5 hours. The power used for generation varies 300 W, 340 W, 380 W, 420 W and 460 W. The deposition is done for 2 hours, keeping the temperature at 300 °C. The illustration scheme of the plasma sputtering system used in this research is shown in Fig. 1 and plasma sputtering process on vacuum chamber shown in Fig. 2.

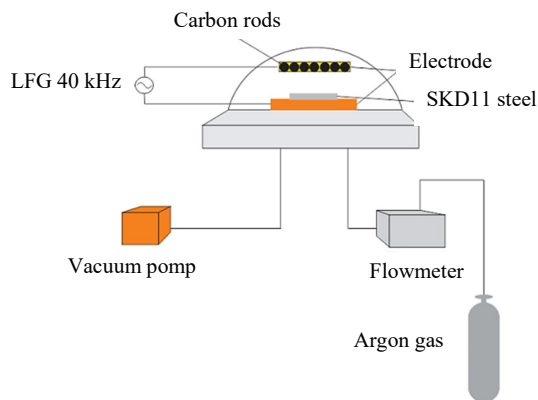


Fig. 1. Scheme of the plasma sputtering system

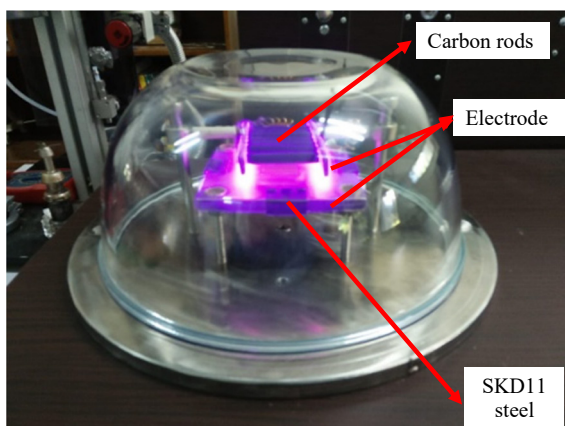


Fig. 2. Plasma sputtering process on vacuum chamber

4. 3. Characterization

The hardness value of SKD11 steel that has been deposited with carbon thin films on SKD11 with power treatment was tested using micro hardness Vickers at three different test points as Fig. 3. The hardness value of SKD11 steel is obtained by taking the average hardness value from measurements at three test points that have been done pre-

viously. The content and morphology of the carbon rod and thin films carbon on SKD11 steel with plasma sputtering treatment on optimum power parameters of 340 W was measured using scanning electron microscope/energy dispersive using X-ray (SEM-EDX).

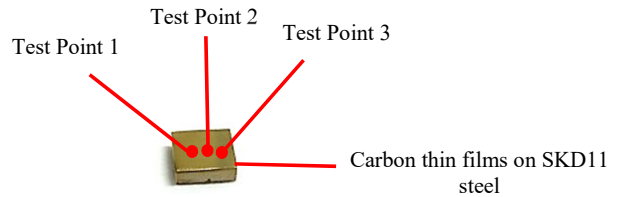


Fig. 3. Micro hardness vickers at three different test points on carbon thin films on SKD11 steel

5. Research results of hardness value of carbon thin films on SKD11 steel and SEM EDX

The hardness value of SKD11 steel that has been deposited with carbon film with power variations was tested with micro hardness Vickers to determine the effect of power on the plasma sputtering process on the hardness of SKD11 steel. The results of the SKD11 steel hardness test using micro hardness Vickers are shown in Table 1, Fig. 4.

Table 1

The hardness value of carbon thin films on SKD 11 steel after power of plasma sputtering treatment based on the microhardness Vickers test

Test Point	Hardness Value (HV) Carbon thin films with Power				
	300 W	340 W	380 W	420 W	460 W
1	253.1	328.3	279.8	265.3	248.8
2	262.2	309.1	268.1	260.2	247.7
3	262.8	312.7	283.2	271.5	256.4
Average of hardness	259.3	316.7	277.0	265.7	251.0

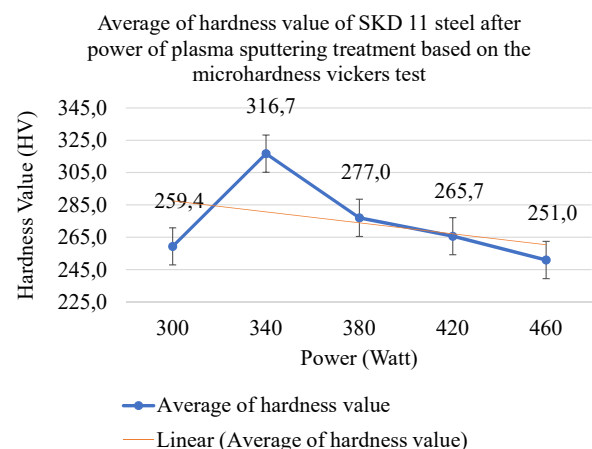


Fig. 4. Graph of hardness value of SKD11 Steel with power treatment

SEM imaging of carbon rods and carbon thin film on SKD11 after plasma treatment with optimum power parameter of 340 W shown in Fig. 5, 6.

SEM observation was carried out on the outermost part of carbon rods from ABC battery waste shown as Fig. 5. The red line of Fig. 5 is an area that shows composition of battery carbon rods shown as Table 2. Based on SEM-EDX results shown as Table 2, atomic carbon level of carbon rods has 81.94 %.

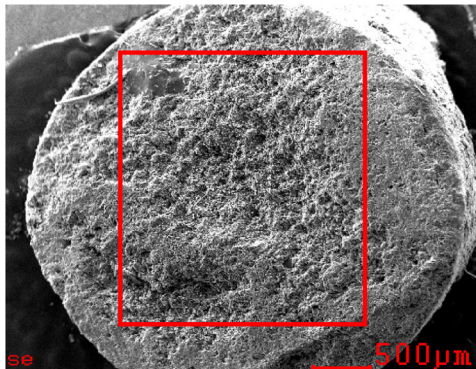


Fig. 5. SEM imaging of carbon rods outer layer from ABC battery waste

Table 2
Compositions of battery carbon rods based on SEM-EDX results

Element	Atomic %
C	81.94
O	13.98
Al	0.98
Si	1.16
Cl	0.54
K	0.34
Ca	0.43
Fe	0.63

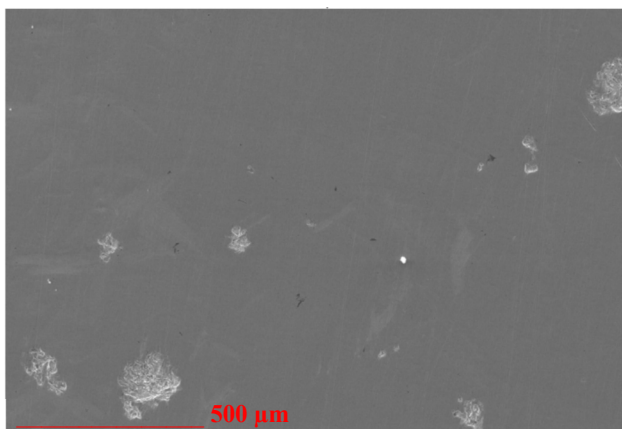


Fig. 6. SEM imaging of carbon thin film on SKD11 steel after plasma sputtering treatment with optimum power parameter of 340 W

Table 3 shown carbon purity level of thin film on SKD11 steel after plasma sputtering treatment with optimum parameter of 340 W.

Table 3

Compositions of carbon thin film on SKD11 steel after plasma sputtering treatment with optimum power parameter of 340 W based on SEM-EDX results

Element	Atomic %
Cr	15,76
Mn	1,32
Fe	54,51
Ni	5,73
Si	0,90
O	8,32
C	13,36
V	0,11

6. Discussion of the research results of hardness value of carbon thin films on SKD11 steel and SEM EDX

It follows from Table 1 that the variation of power on plasma from 300 to 340 Watt increases the average of hardness value of carbon thin films on SKD11 steel, from 259.3 HV increased to 316.7 HV. However, power variations from 380 W, 420 W and 460 W have decreased hardness at 380 W to 460 W, from 277 HV to 251 HV. The treatment of power on plasma sputtering with highest average hardness value is obtained at power of 340 W with 361.7 HV. Fig. 4 shows that downtrend on graph of relationship SKD11 steel with power treatment. Based on the graph shown as Fig. 4, the hardness value has a tendency to decrease when the power on plasma sputtering increases. This is because power is related to plasma energy. The greater the power causes the greater argon ion energy. It causes the transfer of energy from plasma to carbon atoms. As a consequence, carbon atoms have more energy when the power on plasma sputtering is greater. High-energy carbon atoms will tend to re-reflect or reflect rather than forming bonds or deposited on the surface. While at too low a power the carbon atom does not have enough energy to form carbon bonds on surface of SKD11 steel. At optimum power, the carbon atom is not too energetic but the energy it possesses is also not too small. As a result, the carbon bonds formed on the surface SKD11 steel are higher than the other power parameters. It can be seen in Fig. 7 which shows an illustration of the movement of carbon atoms from carbon rods on SKD11 steel substrates.

As follows from the Table 2 and Fig. 4, however, if this refers to previous research that solved the problem of successfully depositing carbon of carbon rod from waste of ABC battery which has 81.94 % of atomic carbon on a glass substrate using plasma sputtering [1]. Based, on these results, the carbon of carbon rods from ABC battery waste has potential to be used as a target material for deposition of carbon thin films on SKD11 steel substrate.

Based on surface morphology, the outer surface of the carbon rod has a rougher shape than the outer surface of carbon thin films on SKD11 (Fig. 5, 6.). Based on the previous reference, the atomic carbon of SKD11 steel without treatment is 1.5 %. Table 3 shows that if the atomic carbon of thin film on SKD11 after plasma treatment with optimum power parameter of 340 W compared with the carbon con-

tent of SKD11 steel without treatment based on reference. Atomic carbon content in thin films on SKD11 with power treatment (13.36 %) is higher than atomic carbon content on SKD11 steels without treatment (1.5 %). Carbon impurities in thin films affect the value of hardness. High carbon impurities indicate that concentrations of atoms that are not same type are high. The higher carbon impurities deposited on SKD11 steel, cause more smaller possibility bonding between carbon and carbon on SKD11 steel. This bond is covalent bonds which is a strong bond and requires high energy to break the bond. More covalent bonds cause increasing the hardness of carbon thin films on SKD11.

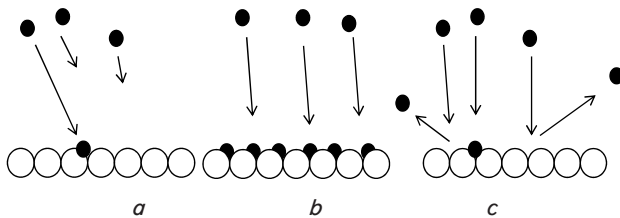


Fig. 7. Main signature: *a* – deposition of carbon atoms at low power; *b* – deposition of carbon atoms at optimum power; *c* – deposition of carbon atom at high power; ● – carbon atom; → – direction of carbon atom; ○ – atom of SKD11 steel

The advantages of this research compared to the other similar research, studies that are more discuss the effect of LFG plasma sputtering power with hardness value of SKD11 steel and obtain the maximum average of hardness value of carbon thin films on SKD11 steel with optimization of argon gas power parameter on plasma sputtering. Previous research, about the effect of plasma sputtering RF power on diamond-like carbon thin films had been carried out. However, the limitation of this result didn't discuss about the effect of various plasma power on hardness of DLC films and only discuss the thickness of DLC films [25]. The other

studies also have been carried out by deposition of carbon thin film with LFG plasma sputtering power treatment of 220 W, 260 W, 320 W, and 340 W on glass using battery carbon rods as target. But, the result only discuss about FTIR results of carbon sputtering with various power [1].

The shortcomings and restrictions of the research, SKD11 without treatment are not tested by micro hardness Vickers to determine the hardness value. So that comparison of the hardness value of SKD11 steel without treatment is based on previous research as references and SEM-EDX is only tested on the most optimum power parameters of 340 W. Plasma sputtering system in this study still uses manual systems and there are no pressure gauge sensors of plasma sputtering system.

There are several things that can be developed in this research. Increased range of power variations (100–500 W) and measure the hardness value for each power variations. Pressure gauge can be added to know the value of pressure in the chamber of plasma sputtering system.

7. Conclusion

Experiment study of deposition carbon thin film on SKD11 with power on plasma sputtering treatment had been investigated to determine hardness performance. Based on micro hardness test, the optimum power treatment obtained at 340 Watt with the highest average hardness value is 316.7 HV. At optimum power, the carbon atom is not too energetic but the energy it possesses is also not too small. Based on SEM-EDX observation, it can be described that comparison of atomic carbon from carbon rods without treatment (1.5 %) and carbon thin films on SKD11 with optimum power treatment (13.36 %) show different value. Number of atomic carbon of thin films on SKD11 with power treatment is higher than atomic carbon of carbon rods without treatment.

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THE EFFECT OF LFG PLASMA SPUTTERING POWER ON HARDNESS OF CARBON THIN FILMS ON SKD11 STEEL USING TARGET MATERIAL FROM BATTERY CARBON RODS

by Aladin Eko Purkuncoro

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Акумуляторні відходи – це відходи, які можуть завдати шкоди навколишньому середовищу, і в Індонезії досі не налагоджена їх якісна переробка. Хоча відходи батарей містять вуглець, який може бути використаний в якості цільового матеріалу для осадження вуглецевих плівок з використанням плазмового розпилення. Метою даного дослідження є визначення ефекту і оптимального значення потужності генерації плазмового аргону для отримання максимального значення твердості сталі SKD11, що забезпечує вироблення потужності. В даному методі використовується плазма у вигляді аргону. Аргонна плазма генерується з використанням LGF 40 кГц. Тонка плівка вуглецю, що синтезується на сталі SKD11, була випробувана для визначення величини твердості з використанням мікротвердості по Віккерсу. Виходячи з результатів експерименту, оптимальна потужність, отримана при 340 Вт з найвищим середнім значенням твердості, становить 316,7 HV. Грунтуючись на спостереженні SEM-EDX, можна описати, що порівняння атомарного вуглецю з вуглецевих стрижнів без обробки (1,5 %) і вуглецевих тонких плівок на SKD11 з оптимальною енергетичної обробкою (13,36 %) показує різні значення. Кількість атомарного вуглецю тонких плівок на SKD11 з енергетичної обробкою вище, ніж у атомарного вуглецю вуглецевих стрижнів без обробки, обумовлює більш високе значення твердості тонких плівок на сталі SKD11 після обробки плазмовим напиленням за оптимальними енергетичними параметрами, ніж у сталі SKD11 без обробки. Сталь SKD11, що має високе значення твердості, що використовується в якості штамів і різання, вимагає високих показників твердості

Ключові слова: сталь SKD11, плазмове напилення, акумуляторні стрижні, потужність, LGF, твердість, аргон, осадження, тонкі плівки, вуглець

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1. Introduction

Zinc carbon battery rods have been widely used for several applications, such as toys, remote control, radio and cameras. Every year battery waste increases. But the increase in the amount of battery waste is not balance with recycle processing of battery waste. Even though, carbon rod from waste of Zinc-Carbon battery contains Aluminum (Al) and Iron (Fe) which are harmful to human health and the environment [1–3]. Actually in modern batteries don't use Pb and Hg already in water. This will certainly endanger to human health [4, 5]. Good recycling of carbon batteries will contribute to improving environmental quality. Previous studies used carbon rods for graphene oxide and biogas [3, 4]. Whereas carbon rods of batteries can be used for carbon layer deposition as a source of carbon.

Amorphous carbon layer has been widely used in industry and research. The amorphous carbon layer has a wide variety of properties of mechanical, physical, biomedical, and

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tribological so that it can be utilized in broad applications as well [6–8]. Carbon atoms that have sp^3 hybridization have stronger bonds, so as to increase the hardness value of the thin layer of carbon material [7].

Previous research of carbon films were successfully synthesized using CVD plasma, hollow-cathode plasma and plasma sputtering [8]. Plasma sputtering has several advantages when compared to the other method, such as high deposition rate, low substrate temperature, and produce best quality thin film at lower substrate temperatures [10, 11]. Plasma sputtering bombards the target with energized particles, so that the ions from the carbon of the target material will come out and be deposited on the substrate. One of technique for carbon deposition in materials is low frequency 40 kHz plasma sputtering. The frequency is suitable for the plasma sputtering technique because the 40 kHz LFG generator has the highest ion density value of the two other plasma generator frequencies, 13.36 MHz and 2.45 GHz, so that more plasma particles are formed per square inch than

generators others [11]. Changes of ion density cause changes in ion bombardment of the target material for deposition of thin films [8, 10].

One of gas that is suitable for use in plasma sputtering is argon gas. Argon is an inert noble gas, which means it will form very little or no chemical compounds. In argon gas the dominant influence in plasma sputtering is a physical reaction. Argon atoms are heavy atoms with low reactive properties, so it would be more effective if used to target materials for deposition of thin films [8, 11].

Recently, the use of steel as a material in the industrial world and machinery has developed rapidly. Steel in the market generally has limited mechanical performance. One example is SKD11 steel which only has a hardness of 58–60 HV [13]. Though SKD11 steel is widely used as dies, forming, and cutting so it requires high hardness performance [13, 14].

The highest chemical content of SKD11 steel is carbon (C) [15]. The hardness of steel can also be increased by increasing the carbon content of the steel [16]. One of the ways to increase carbon content can be done by coating the steel with amorphous carbon [17]. The amorphous carbon layer is attractive to researchers because of its good mechanical properties such as low coefficient of friction, hardness and high durability [18]. The hardness performance of SKD11 steel can be improved by deposition of an amorphous carbon layer by plasma sputtering process [19].

Previous research on deposition of carbon thin film on glass substrate using material target from battery carbon rods with plasma sputtering show that the carbon was successfully deposited onto glass substrate. It was proved by FTIR results, C–C and C=C was formed [1]. In the view of all these, argon plasma sputtering to deposition carbon thin film using material target from battery carbon rods may provide a new efficient approach to improve the mechanical properties of films. There is great scope to work on this topic further.

In the other studies, microstructural changes and hardness variations in SKD11 steel have been investigated during the processes of carbide dispersion (CD). However, the process of carbide dispersion carburizing requires high temperatures at 980 °C and the process takes a long time for 120 min. The process certainly requires a greater cost than plasma sputtering. Even though, plasma sputtering is more simple and cheaper than carburizing method to improve hardness performance of SKD11 steel. However, the investigation plasma sputtering process for hardening SKD11 steel was limited. On the other sides, SKD11 steel has limited hardness performance of 58–60 HV. Even though, the steel is commonly used for industrial purposes which require a high hardness performance. Therefore, studies that are devoted to obtain the maximum average of hardness value of carbon thin films on SKD11 steel with optimization of argon gas power parameter on plasma sputtering.

2. Literature review and problem statement

Plasma is the fourth phase form of matter after solid, liquid, and gas [20]. Plasma is formed due to ionization. Plasma can be applied as a method for deposition of thin films [12]. One application of carbon deposition is carried out on steel. Synthesis of thin films has been carried out using plasma enhanced chemical vapor deposition, plate parallel hollow cathode plasma with radio frequency, and plasma sputtering.

Based on these 3 methods, plasma sputtering has several advantages compared to other methods such as high deposition rates, low substrate temperatures, and synthesis high quality of thin films [8, 11]. Plasma sputtering works by utilizing high energy of plasma species as bombers of target materials [21].

Steel that is often used for industry, generally has limited mechanical performance. Many of research are done to improve steel mechanical performance [19]. One of the examples is research of increasing the hardness value of AISI H13 steel. The results of research indicate that increasing the hardness value with the increasing carbon content of AISI H13 steel [22]. Besides AISI H13 steel, there is steel that often used in the industrial world, such as SKD11 steel [23]. SKD11 steel is often used for dies, forming, and cutting [15]. However, SKD11 steel still has weaknesses. SKD11 steel has low hardness, around 58–60 HV [13]. Based on these problems, research has to do to increase the value of steel hardness. One of the ways is deposition carbon thin films on SKD11 steel with plasma sputtering.

Power is an important role in the process of plasma sputtering [19, 23]. The higher the power, the stronger the electric field that is formed, and the greater ion energy. If the energy of ion is greater than the binding energy of the target material's atoms, the atoms of the target material will be detached from the bonds of the atoms and move in all directions. The atom of the target material that comes out is called a sputtered atom [10]. Sputtered atom will be deposited on surface substrate and thin films structure that is formed will affect to the hardness of substrate [1].

A similar study about the effect of plasma sputtering RF power on diamond-like carbon thin films was previously had been carried out by Jongwannasiri et al. Based on the results of the study showed plasma treatment on DLC films surface influenced to thickness change, but not affect to structure of the films with various RF powers [1]. However, the limitation of this result didn't discuss about the effect of various plasma power on hardness of DLC films and only discuss the thickness of DLC films. Even though, Björling et al, found that the thicker deposited carbon thin film on substrate will have a high probability of carbon content [25]. In addition, Concepción et al, also found that the greater value of carbon content in carbon thin films, the greater value of hardness [16]. Therefore in this study, deposition carbon thin films with plasma sputtering for hardening SKD11 is done by using material target from battery carbon rods and determine effect power of plasma connected with hardness of carbon thin films on SKD11.

3. The aim and objectives of research

The aim of research to investigate plasma sputtering process to increasing hardness of carbon thin films on SKD11 steel.

To achieve this aim, the following objectives are accomplished:

– to observe plasma power affected on hardness of carbon thin films on SKD11 steel.

4. Experimental method

4.1. Sample preparation

Material target that used in this research was prepared by carbon rod from zinc-carbon ABC battery waste

(ABC Battery Industry, made in Indonesia). The carbon rod was cut into reach diameter 8 mm and length 55 mm. Then, the carbon rod was cleaned by ultrasonication with 40 kHz and 360 W in soap, solution for 1 minute. The cleaned carbon rod was dried in the oven at 300 °C for 2 hours. The substrate used is SKD11 steel. Before plasma sputtering process, the substrate was cleaned by technical alcohol.

4. 2. Deposition thin film

Carbon films were deposited using plasma sputtering. Plasma is generated by low frequency generator (LFG) 40 KHz. The plasma system has diameter chamber of 250 mm. The carbon rod as material target was placed at the electrode. Carbon rods as a target material are placed on the electrodes. The distance between the target material and SKD11 steel is kept at 1.7 cm. The argon gas was introduced with flow rate of 20 mL/min into the chamber after vacuum process of 1.5 hours. The power used for generation varies 300 W, 340 W, 380 W, 420 W and 460 W. The deposition is done for 2 hours, keeping the temperature at 300 °C. The illustration scheme of the plasma sputtering system used in this research is shown in Fig. 1 and plasma sputtering process on vacuum chamber shown in Fig. 2.

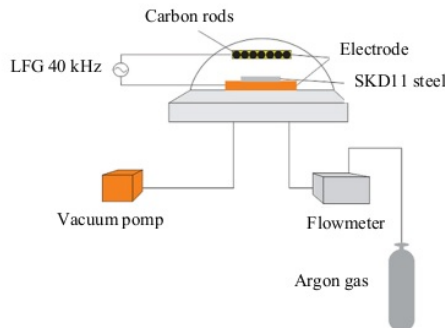


Fig. 1. Scheme of the plasma sputtering system

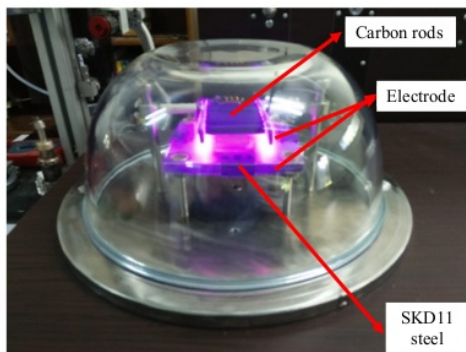


Fig. 2. Plasma sputtering process on vacuum chamber

4. 3. Characterization

The hardness value of SKD11 steel that has been deposited with carbon thin films on SKD11 with power treatment was tested using micro hardness Vickers at three different test points shown as Fig. 3. The hardness value of SKD11 steel is obtained by taking the average hardness value from measurements at three test points that have been done pre-

viously. The content and morphology of the carbon rod and thin films carbon on SKD11 steel with plasma sputtering treatment on optimum power parameters of 340 W was measured using scanning electron microscope/energy dispersive using X-ray (SEM-EDX).

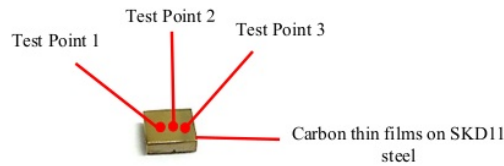


Fig. 3. Micro hardness vickers at three different test points on carbon thin films on SKD11 steel

5. Research results of hardness value of carbon thin films on SKD11 steel and SEM EDX

The hardness value of SKD11 steel that has been deposited with carbon film with power variations was tested with micro hardness Vickers to determine the effect of power on the plasma sputtering process on the hardness of SKD11 steel. The results of the SKD11 steel hardness test using micro hardness Vickers are shown in Table 1, Fig. 4.

Table 1
The hardness value of carbon thin films on SKD 11 steel after power of plasma sputtering treatment based on the microhardness Vickers test

Test Point	Hardness Value (HV) Carbon thin films with Power				
	300 W	340 W	380 W	420 W	460 W
1	253.1	328.3	279.8	265.3	248.8
2	262.2	309.1	268.1	260.2	247.7
3	262.8	312.7	283.2	271.5	256.4
Average of hardness	259.3	316.7	277.0	265.7	251.0

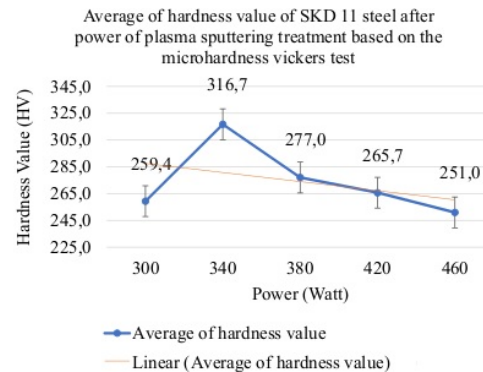


Fig. 4. Graph of hardness value of SKD11 Steel with power treatment

SEM imaging of carbon rods and carbon thin film on SKD11 after plasma treatment with optimum power parameter of 340 W shown in Fig. 5, 6.

SEM observation was carried out on the outermost part of carbon rods from ABC battery waste shown as Fig. 5. The red line of Fig. 5 is an area that shows composition of battery carbon rods shown as Table 2. Based on SEM-EDX results shown as Table 2, atomic carbon level of carbon rods has 81.94 %.

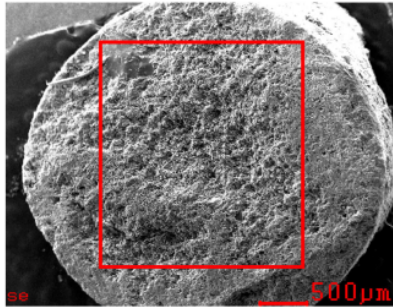


Fig. 5. SEM imaging of carbon rods outer layer from ABC battery waste

Table 2
Compositions of battery carbon rods based on SEM-EDX results

Element	Atomic %
C	81.94
O	13.98
Al	0.98
Si	1.16
Cl	0.54
K	0.34
Ca	0.43
Fe	0.63

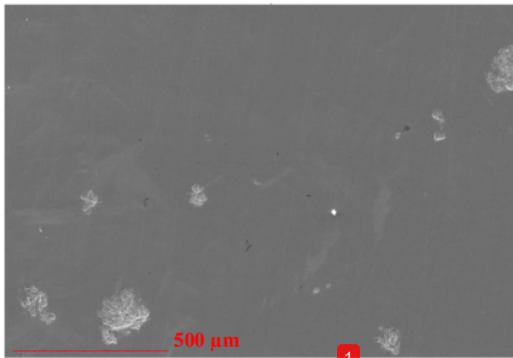


Fig. 6. SEM imaging of carbon thin film on SKD11 steel after plasma sputtering treatment with optimum power parameter of 340 W

Table 3 shown carbon purity level of thin film on SKD11 steel after plasma sputtering treatment with optimum parameter of 340 W.

Table 3
Compositions of carbon thin film on SKD11 steel after plasma sputtering treatment with optimum power parameter of 340 W based on SEM-EDX results

Element	Atomic %
Cr	15,76
Mn	1,32
Fe	54,51
Ni	5,73
Si	0,90
O	8,32
C	13,36
V	0,11

6. Discussion of the research results of hardness value of carbon thin films on SKD11 steel and SEM EDX

It follows from Table 1 that the variation of power on plasma from 100 to 340 Watt increases the average of hardness value of carbon thin films on SKD11 steel, from 259.3 HV increased to 316.7 HV. However, power variations from 380 W, 420 W and 460 W have decreased hardness at 380 W to 460 W, from 277 HV to 251 HV. The treatment of power on plasma sputtering with highest average hardness value is obtained at power of 340 W with 361.7 HV. Fig. 4 shows that downtrend on graph of relationship SKD11 steel with power treatment. Based on the graph shown as Fig. 4, the hardness value has a tendency to decrease when the power on plasma sputtering increases. This is because power is related to plasma energy. The greater the power causes the greater argon ion energy. It causes the transfer of energy from plasma to carbon atoms. As a consequence, carbon atoms have more energy when the power on plasma sputtering is greater. High-energy carbon atoms will tend to re-reflect or reflect rather than forming bonds or deposited on the surface. While at too low a power the carbon atom does not have enough energy to form carbon bonds on surface of SKD11 steel. At optimum power, the carbon atom is not too energetic but the energy it possesses is also not too small. As a result, the carbon bonds formed on the surface SKD11 steel are higher than the other power parameters. It can be seen in Fig. 7 which shows an illustration of the movement of carbon atoms from carbon rods on SKD11 steel substrates.

As follows from the Table 2 and Fig. 4, however, if this refers to previous research that solved the problem of successfully depositing carbon of carbon rod from waste of ABC battery which has 81.94 % of atomic carbon on a glass substrate using plasma sputtering [1]. Based, on these results, the carbon of carbon rods from ABC battery waste has potential to be used as a target material for deposition of carbon thin films on SKD11 steel substrate.

Based on surface morphology, the outer surface of the carbon rod has a rougher shape than the outer surface of carbon thin films on SKD11 (Fig. 5, 6.). Based on the previous reference, the atomic carbon of SKD11 steel without treatment is 1.5 %. Table 3 shows that if the atomic carbon of thin film on SKD11 after plasma treatment with optimum parameter of 340 W compared with the carbon con-

tent of SKD11 steel with **1** treatment based on reference. Atomic carbon content in thin films on SKD11 with power treatment (13.36 %) is higher than atomic carbon content on SKD11 steels without treatment (1.5 %). Carbon impurities in thin films affect the value of hardness. High carbon impurities indicate that concentrations of atoms that are not same type are high. The higher carbon impurities deposited on SKD11 steel, cause more smaller possibility bonding between carbon and carbon on SKD11 steel. This bond is covalent bonds which is a strong bond and requires high energy to break the bond. More covalent bonds cause increasing the hardness of carbon thin films on SKD11.

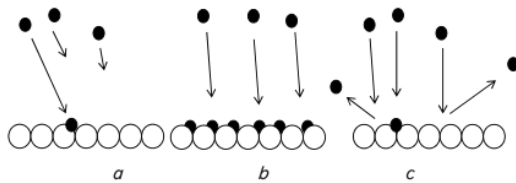


Fig. 7. Main signature: *a* – deposition of carbon atoms at low power; *b* – deposition of carbon atoms at optimum power; *c* – deposition of carbon atom at high power; ● – carbon atom; → – direction of carbon atom; ○ – atom of SKD11 steel

The advantages of this research compared to **1** the other similar research, studies that are more discuss the effect of LFG plasma sputtering power with hardness **1** value of SKD11 steel and obtain the maximum average of hardness value of carbon thin films on SKD11 steel with optimization of argon gas power **1** parameter on plasma sputtering. Previous research, about the effect of plasma sputtering RF power on diamond-like carbon thin films had been carried out. **1** However, the limitation of this result didn't discuss about the effect of various plasma power on hardness of DLC films and only discuss the thickness of DLC films [25]. The other

studies also have been carried out by deposition of carbon thin film with LFG plasma sputtering power treatment of 220 W, 260 W, 320 W, and 340 W on glass using battery carbon rods as target. But, the result only discuss about FTIR results of carbon sputtering with various power [1].

The shortcomings and restrictions of the research, SKD11 without treatment are not tested by micro hardness Vickers to determine the hardness value. So that comparison of the hardness value of SKD11 steel without treatment is based on previous research as references and SEM-EDX is only tested on the most optimum power parameters of 340 W. Plasma sputtering system in this study still uses manual systems and there are no pressure gauge sensors of plasma sputtering system.

There are several things that can be developed in this research. Increased range of power variations (100–500 W) and measure the hardness value for each power variations. Pressure gauge can be added to know the value of pressure in the chamber of plasma sputtering system.

7. Conclusion

Experiment study of deposition carbon thin film on SKD11 with power on plasma sputtering treatment had been investigated to determine hardness performance. Based on micro hardness test, the optimum power treatment obtained at 340 Watt with the highest average hardness value is 316.7 HV. At optimum power, the carbon atom is not too energetic but the energy it possesses is also not too small. Based on SEM-EDX observation, it can be described that comparison of atomic carbon from carbon rods without treatment (1.5 %) and carbon thin films on SKD11 with optimum power treatment (13.36 %) show different value. Number of atomic carbon of thin films on SKD11 with power treatment is higher than atomic carbon of carbon rods without treatment.

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THE EFFECT OF LFG PLASMA SPUTTERING POWER ON HARDNESS OF CARBON THIN FILMS ON SKD11 STEEL USING TARGET MATERIAL FROM BATTERY CARBON RODS

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