

## Coating Recommendations Chart

	Drilling	Turning	Milling	Tapping	Sawing	Reaming Broaching	Injection Molding	Stamping Punching	Forming
Steels	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACRo@-3, AlTiN	*AlTiN, nACVlc@	*nACRo@-3, AlTiN	*nACo@-3, AlTiN	*nACVlc@, nACRo@-3	nACRo@-3	*nACVlc@, nACRo@-3
Hardened Steels	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACRo@-3, nACVlc@	*nACRo@-3, nACo@-3	nACRo@-3
Alloyed Steels Superalloys	*nACRo@-3, AlTiN	*nACo@-3, AlTiN	*nACVlc@, AlTiN	*nACVlc@, AlTiN	*nACRo@-3, AlTiN	*nACo@-3, AlTiN	*nACVlc@, nACRo@-3	*nACVlc@, nACRo@-3	*nACVlc@, nACRo@-3
Cast Iron	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACo@-3, AlTiN	*nACRo@-3, AlTiN	*nACRo@-3, AlTiN	*nACo@-3, AlTiN			
Aluminium > 12% Si	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACRo@-3, TiCN	*nACVlc@
Aluminium < 12% Si	*TiCN, ZrN	*TiCN, ZrN	*TiCN, ZrN	*TiCN, ZrN	*TiCN, ZrN	*TiCN, ZrN	TiCN	TiCN	TiCN
Copper	CrN	CrN	CrN	CrN	CrN	CrN	CrN	CrN	CrN
Bronze, Brass Plastics	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3	*TiCN, nACRo@-3
Wood	nACVlc@	nACVlc@	nACVlc@	nACVlc@	nACVlc@	nACVlc@			

\* First Choice