

## Coating Recommendations Chart

	Drilling	Turning	Milling	Tapping	Sawing	Reaming Broaching	Injection Molding	Stamping Punching	Forming
Steels	*nACo, AlTiN	*nACo, AlTiN	*nACRo, AlTiN	*AlTiN, nACVlc	*nACRo, AlTiN	*nACo, AlTiN	nACRo	nACRo	nACRo
Hardened Steels	*nACo, AlTiN	*nACo, AlTiN	*nACo, AlTiN	*nACo, AlTiN	*nACo, AlTiN	*nACo, AlTiN	*nACRo,	*nACRo, nACo	nACRo
Alloyed Steels Superalloys	*nACRo, AlTiN	*nACo, AlTiN	*nACVlc, AlTiN	*nACVlc, AlTiN	*nACRo, AlTiN	*nACo, AlTiN	nACRo	nACRo	nACRo
Cast Iron	*nACo, AlTiN	*nACo, AlTiN	*nACo, AlTiN	*nACRo, AlTiN	*nACRo, AlTiN	*nACo, AlTiN			
Aluminium > 12% Si	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	*nACRo, TiCN	
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	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo	*TiCN, nACRo

\* First Choice