



# PVD COATING PROCESS RECOMMENDATIONS\*

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Workpiece Material	Applications									
	Drilling	Turning	Milling	Tapping	Reaming	Broaching	Stamping	Deep Drawing	Forming	Injection Molding
Steels — general types	AlTiN ■ TiAlN ●	AlTiN ■ TiAlN ●	AlTiN ■ Nano-Tek/Cr*	TiCN-MP ■ TiN ■	TiAlN ● TiCN-MP ■	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiN ■ CrN ▸
Alloyed Steels • Tool steels • Stainless Steel • Super-Alloys (Ni-Based)	Nano-Tek/Cr* AlTiN ■	Nano-Tek ● AlTiN ■	Nano-Tek ● AlTiN ■	TiCN-MP ■ TiAlN ●	TiAlN ● TiCN-MP ■	TiCN-MP ■ TiAlN ●	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiN ■ CrN
Mg-Alloys	AlTiN ■ TiAlN ●	AlTiN ■ TiAlN ●	AlTiN ■ TiAlN ●	TiCN-MP ■ TiAlN ●	TiAlN ● TiCN-MP ■	TiCN-MP ■ TiAlN ●	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiCN-MP ■ TiN ■	TiN ■ CrN ▸
Cast Iron	Nano-Tek ● AlTiN ■	Nano-Tek ● AlTiN ■	Nano-Tek ● TiCN-MP ■	TiAlCN ✕ TiCN-MP ■	AlTiN ✕ TiCN-MP ■	TiAlN ● TiCN-MP ■				
Ti-Alloys	Nano-Tek ● ZrN ▲	Nano-Tek ● ZrN ▲	Nano-Tek ● ZrN ▲	ZrN ▲ TiCN-MP ■	ZrN ▲	ZrN ▲	ZrN ▲	ZrN ▲	ZrN ▲	TiN ■ CrN
Al-Alloys	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	ZrN ▲ CBC ◆	TiN ■ CrN ◆
Copper	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸	CrN ▸
Brass / Bronze	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	TiCN ■ TiCN-MP ■	CrN ▸ TiN ■
Plastics	TiCN-MP ■ TiCN ■	TiCN-MP ■ TiCN ■	TiCN-MP ■ TiCN ■	TiCN-MP ■ TiCN ■						TiN ■ CrN ▸

\*Recommendations are based on general machining conditions. Performance may be significantly influenced by factors such as rigidity of machine and setup, tool substrate, coolant conditions, etc.