

COATING PROCESS RECOMMENDATIONS*



VALLEY TOOL

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Workpiece Material	Applications				
	Drilling	Turning	Milling	Tapping	Reaming
Steels - General Types	TiALCN ALTiN TiALN	TiALCN ALTiN TiALN	TiALCN ALTiN Nano-Tek/CR	TiCN TiN	TiALN TiCN
Alloyed Steels Tool Steels Stainless Steel Super-Alloy (Ni-Based)	Nano-Tek/CR TiALCN ALTiN	Nano-Tek/CR TiALCN ALTiN	Nano-Tek/CR TiALCN ALTiN	TiCN TiALN	TiALN TiCN
Mg-Alloys	ALTiN TiALN	ALTiN TiALN	ALTiN TiALN	TiCN TiALN	TiALN TiCN
Cast Iron	Nano-Tek/CR ALTiN	Nano-Tek/CR ALTiN	Nano-Tek/CR TiALCN	TiALCN TiCN	Nano-Tek/CR TiALCN
Ti-Alloys	Nano-Tek/CR TiALCN	Nano-Tek/CR TiALCN	Nano-Tek/CR TiALCN	TiALCN TiCN	TiALN
Al-Alloys	ZrN TiCN	ZrN TiCN	ZrN TiCN	ZrN TiCN	ZrN TiCN
Copper	Nano-Tek/CR	Nano-Tek/CR	Nano-Tek/CR	Nano-Tek/CR	Nano-Tek/CR
Brass / Bronze	TiALCN TiCN	TiALCN TiCN	TiALCN TiCN	TiCN	TiCN
Plastics	TiCN ZrN	TiCN ZrN	TiCN ZrN	TiCN ZrN	
Graphite Ceramics Fiberglass	Amorphous Diamond	Amorphous Diamond	Amorphous Diamond	Amorphous Diamond	Amorphous Diamond

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