

# COATING PROCESS RECOMMENDATIONS\*



## VALLEY TOOL

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