

PD2i Coating Guide – Cutting Tools



Material	Choice	Application				
		Turning	Milling	Drilling	Tapping	Microtools
Steel < 35 HRC	Multipurpose	AlTiN nano	MpC+4	AlTiN nano	TIN / TIN HP	AlTiN Micro
	Best Choice	Micral Cast	Micral 5	HardDrill	Micral taps	Micral 5 Micro
Steel 35 to 52 HRC cast iron	Multipurpose	Micral 5	Micral Titan Plus	AlTiN nano	AlTiN	AlTiN Micro
	Best Choice	Micral Cast	Micral 5	HardDrill	Micral 5	Micral 5 Micro
Steel > 52 HRC	Multipurpose	MicralCast	-----	-----	-----	-----
	Best Choice	HardMill Plus	HardMill Plus	HardDrill	-----	HardMill Micro
Stainless Steel	Multipurpose	Micral Titan Plus	Micral Titan Plus	AlTiN nano	TiCN	-----
	Best Choice	Micral 5	Micral 5	HardDrill	TiCN+C	Micral 5 Micro
Titanium	Multipurpose	Micral 5	Micral 5	AlTiN nano	TiCN	-----
	Best Choice	Micral Titan Plus	Micral Titan Plus	HardDrill	Micral 5	Micral 5 Micro
Super Alloys	Multipurpose	Micral 5	Micral 5	AlTiN nano	Micral 5	-----
	Best Choice	Micral Titan Plus	Micral Titan Plus	HardDrill	Micral Titan	Micral 5 Micro
Aluminium < 12%	Multipurpose	ZrN	ZrN	ZrN	ZrN	ZrN
	Best Choice	Ta:C	Ta:C	Ta:C	TiCN+C	Ta:C
Aluminium > 12%	Multipurpose	TiCN+C	TiCN+C	-----	TiCN+C	-----
	Best Choice	Ta:C	Ta:C	Ta:C	Ta:C	Ta:C
Brass	Multipurpose	CrN	CrN	CrN	CrN	-----
	Best Choice	MpC+4	MpC+4	ZrCN	TiCN+C	Ta:C

Tool steel	Application	
	Gear cutting tools	
HSS / PM	dry	HardGearCut
	wet	GearCut
Carbide	dry	HardGearCut