



Standard Coating Application Chart

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MATERIAL	HARDNESS	SUGGESTED COATING	PREMIUM COATING
ALUMINUM		TiCN	TiCN
ALLOY STEEL	160-240 HBn	TiN	AlTiN
	23-38	AlTiN	nACo
	Less than 38	AlTiN	nACo
CARBON STEEL	160-240 HBn	TiN	AlTiN
	23-38	TiN	AlTiN
	Less than 38	AlTiN	nACRo
LOW CARBON STEEL	130-240 HBn	TiCN	TiCN
	23-38	TiN	AlTiN
	Less than 38	AlTiN	nACRo
GRAY CAST IRON	180-220 HBn	AlTiN	nACRo
NODULAR CAST IRON	220-320 HBn	AlTiN	nACRo
AUSTENETIC STAINLESS STEEL	180-220 HBn	TiCN	TiCN
	Less than 35	AlTiN	nACRo
MARTINSITIC STAINLESS STEEL	Less than or = 35	AlTiN	nACRo
PH STAINLESS STEEL	Greater than 35	AlTiN	nACRo
	Less than or = 35	AlTiN	nACRo
NI, CO, FE, BASED SUPERALLOYS		AlTiN	nACRo
TITANIUM		AlTiN	nACRo
COPPER		TiCN	TiCN
BRASS	65-135 HBn	TiCN	TiCN

* Depending on Application

SYMBOL	CHEMICAL	THERMAL STABILITY	THICKNESS	NAM HARDNESS (GPA)
TiN	Titanium Nitride	500°C (950°F)	1 - 5	24
TiCN	Titanium Carbonitride	400°C (750°F)	1 - 4	37
AlTiN	Aluminum Titanium Nitride	800°C (1450°F)	1 - 3	38
nACRo	Aluminum Silicon Chromium	1100°C (2012°F)	1 - 7	40
nACo	Aluminum Silicon & Titanium	1200°C (2192°F)	1 - 4	45