

Coating	Appearance	Composition	Recommendation	Application
IG3_		TiAlSiN	Best: P M K Secondary: N S	Groove finishing at high cutting speeds, in addition to dry machining
IG6_		TiAlSiN	Best: P M K Secondary: S	Groove roughing and finishing at high cutting speeds, in addition to dry machining
AS4_ AS6_		TiAlN	Best: P M Secondary: K	Groove finishing at medium cutting speeds, in addition to dry machining
DD2_		TiB2	Best: N	Groove roughing and finishing
TH3_		TiAlN	Best: P M Secondary: K S	Groove roughing and finishing at high cutting speeds, in addition to dry machining
EG3_		AlTiN + TiN	Best: P M Secondary: K	Finishing and parting at high cutting speeds
EG5_		AlTiN + TiN	Best: P M Secondary: K	Roughing at high cutting speeds
ES1_		AlTiN	Best: P M Secondary: N S	Finishing and superfinishing, no cutting interruptions

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AN2_ AN4_		AlCrSiN	Best: P M Secondary: K S	Groove roughing and finishing, broaching
TI2_		TiCn	Best: P M Secondary: N	Groove roughing and finishing at moderate cutting speeds, reduction of built-up edge
TN3_		TiN	Best: P K Secondary: N	Groove roughing and finishing at moderate cutting speeds
P20 K10 MG12		Uncoated	Best: N	

ISO Material Group	P Mild, Carbon, Alloyed, Cast, Sintered Steels	M Stainless Steels	K Grey, Spheriodal Graphite, Malleable Cast Irons	N Non-Ferrous, Al-Alloys, Cu-Alloys, Graphite	S Heat resistant, Super alloys, Titanium	H Hardened Steels
First choice	EG35/55 AlTiN + TiN	IG35 TiAlSiN	IG35 TiAlSiN	DD25 TiB2	IG65 TiAlSiN	-
Second	IG35 TiAlSiN	EG35/55 AlTiN + TiN	TH35 TiAlN	ES15 AlTiN	IG35 TiAlSiN	-
Third	TH35 TiAlN	TI25 TiCn	TN35 TiN	MG12 Uncoated	AN45 AlCrSiN	-