

# Anwendungs- tabellen. *Application guides.*

Zerspanung /  
*Chipping*

Stanzen und  
Umformen /  
*Punching and  
forming*

Kunststoff-  
technik /  
*Plastics  
Technology*

## Zerspanung / Chipping

Material / Material	Drehen / Turning	Bohren & Reiben / Drilling & reaming	Fräsen / Milling
niedrig legierter Stahl / low-alloy steel	ALLCUT, TiN	ALLCUT, TiN	ALLCUT, TiN
hoch legierter Stahl / high-alloy steel	ALLCUT, TiAlN	AL66CUT, ALLCUT	ALLCUT, TiCN
gehärteter Stahl / harde- ned steel	AL66NANO, METASPEED	AL66NANO, METASPEED	METASPEED, HIGHCUT
rostfreier Stahl / stain- less steel	TiCN, ALLCUT	TiCN, ALLCUT	TiCN, ALLCUT
Gusseisen / cast iron	ALLCUT, AL66CUT	ALLCUT, AL66CUT	ALLCUT, AL66CUT
Al-Legierungen / alumini- um alloys	TRIPLECUT, CrN	TRIPLECUT, CrN	TRIPLECUT, CrN
Ti-,Ni Legierungen / tita- nium and nickel alloys	TRIPLECUT, AL66NANO	TRIPLECUT, AL66NANO	TRIPLECUT, AL66NANO
Kupfer, Messing, Bronze / copper, brass, bronze	CRN, TOPCUT	CRN, TOPCUT	CRN, TOPCUT
Graphit / graphite	TRIPLECUT	TRIPLECUT	TRIPLECUT
Kunststoff / plastics	AL66NANO, METASPEED	AL66NANO, METASPEED	AL66NANO, METASPEED
CFK / CFK	AL66NANO, TRIPLECUT	AL66NANO, TRIPLECUT	AL66NANO, TRIPLECUT
Kunststoff / plastics	TINALOX SN <sup>2</sup> , HYPERLOX, ALSIDUR	TINALOX SN <sup>2</sup> , HYPERLOX, ALSIDUR	TINALOX SN <sup>2</sup> , HYPERLOX, ALSIDUR
CFK	HYPERLOX, ALSIDUR, DIAMANT	HYPERLOX, ALSIDUR, DIAMANT	HYPERLOX, ALSIDUR, DIAMANT

Material / Material	Sägen / Sawing	Wälzfräsen / Hobbing	Gewindeschneiden / Threading
niedrig legierter Stahl / low-alloy steel	ALLCUT, TiN	METASPEED, TiN	TiN, TiCN
hoch legierter Stahl / high-alloy steel	AL66CUT, TiN	METASPEED, ALLCUT	TiCN, TiN
gehärteter Stahl / harde- ned steel	METASPEED, AL66NANO	METASPEED, AL66NANO	AL66CUT, AL66NANO
rostfreier Stahl / stainless steel	TiCN, ALLCUT	METASPEED, TiCN	TiCN, ALLCUT
Gusseisen / cast iron	ALLCUT, AL66CUT	METASPEED, ALLCUT	ALLCUT, AL66CUT
Al-Legierungen / alumini- um alloys	CrN, TRIPLECUT	-	CrN, TRIPLECUT
Ti-,Ni Legierungen / tita- nium and nickel alloys	CrN, TRIPLECUT	-	TRIPLECUT, AL66NANO
Kupfer, Messing, Bronze / copper, brass, bronze	CRN, TOPCUT	-	CrN, TOPCUT
Graphit / graphite	TRIPLECUT	-	-
Kunststoff / plastics	AL66NANO, METASPEED	-	-
CFK / CFK	AL66NANO, TRIPLECUT	-	-
Kunststoff / plastics	---	---	---
CFK	---	---	---

## Stanz- und Umformung / Punching and forming

<b>Material / Material</b>	<b>Stanz- und Schneiden / Punching &amp; cutting</b>	<b>Umformen / Forming</b>
Stahl / steel	TiCN, TiAlN	TiCN, ALMULTI
Edelstahl / stainless steel	TiAlN, TiCN	TiCN, ALMULTI
hochfester Stahl / high-strength steel	AL66NANO, METASPEED	ALMULTI, TiCN
verzinkter Stahl / zink coated steel	TiAlN, TiCN	TiCN, ALMULTI
Al-Legierungen / aluminium alloys	TRIPLECUT, CrN	TRIPLECARBON, CrN
Kupfer, Messing, Bronze / copper, brass, bronze	CrN, TOPCUT	CrN, TOPCARBON
Ti-Legierungen / titanium alloys	TiAlN, TiCN	ALMULTI, TiCN

<b>Material / Material</b>	<b>Massivumformung / Massive forming</b>	<b>Warmumformung / Hot forming</b>
Stahl / steel	HE+TiCN, HE+ALMULTI	METASPEED, MULTICUT
Edelstahl / stainless steel	HE+ALMULTI, HE+TiCN	METASPEED, MULTICUT
hochfester Stahl / high-strength steel	HE+ALMULTI, HE+TiCN	METASPEED, MULTICUT
verzinkter Stahl / zink coated steel	HE+ALMULTI, HE+TiCN	METASPEED, MULTICUT
Al-Legierungen / aluminium alloys	CrN, TRIPLECARBON	HIGHCUT
Kupfer, Messing, Bronze / copper, brass, bronze	CrN, TOPCARBON	CrN
Ti-Legierungen / titanium alloys	HE+ALMULTI, HE+TiCN	METASPEED, MULTICUT

# Kunststofftechnik / Plastics Technology

## 1 Entformung und Belagsbildung / Demolding and deposit formation

Kunststoffart / Category of plastic	Kunststoffsorte / Type of plastic	Schichtempfehlung / Recommended coating
Polyolefine / polyolefine	PE, PP, PB	CrN, TOPCARBON
Chlor-Polymerisate / chlorine-based polymerisates	PVC	CrN
Styrol-Polymerisate / styrol-based polymerisates	PS, SAN, SB, ABS, ASA	TiN
Acetalharze / acetal resins	POM	CrN
Polyacrylate / polyacrylate	PMMA	TiN
Polyamide / polyamides	PA6, PA66, PA12	TiN, CrN
Lineare Polyester / linear polyesters	PC, ABS, PBT	CrN, TiN
Blends / blends	PC/ABS, PC/PBT	CrN, TiN
Polymide / polyimides	PEI, PAI, PMI	CrN, TOPCARBON
Polyarylenethene / polyarylenethene	PEEK, PPS, PSU, PES, PPE, PPO	CrN
Fluor-Polymerisate / fluorine-based polymerisates	PTFE, PVDF	CrN
Elastomere / elastomers	PUR, TPU, TPE, EPDM, NBR, FDM	CrN
Duroplaste / duroplasts	PF, MF, MP, UF, UP, EP	CrN

## 2 Verschleiß allgemein / Wear in general

Verschleissart / Type of wear	Schichtempfehlung / Recommended coating
Abrasion / abrasion	TiAIN, TiCN
Korrosion / corrision	CrN, TOPCARBON
Entformung / demolding	HARD EDGE (*) (*) or see table above

## 3 Verschleiß bewegliche Teile / Wear moveable parts

Verschleissart / Type of wear	Schichtempfehlung / Recommended coating
Schieber / sliders	TOPCARBON
Auswerfer / ejectors	TOPCARBON
Kerne / cores	TOPCARBON



**WWW.**  
**wolf-coating.de**



## WOLF coating plus GmbH

📍 Industriestraße 57  
D-44894 Bochum

☎ +49 (0) 234 - 32 59 95 - 0  
📠 +49 (0) 234 - 32 59 95 - 50

✉ info@wolf-coating.de  
🌐 wolf-coating.de