

## Series Selector

Reference the chart below to select the best series for your application

Material Group	ISO Code	Material Examples	Finish Cuts	Medium D.O.C.	Heavy D.O.C.	Slotting	Facing	Circular Interpolation	High Feed / High Speed Machining (HSM)
Steel	P	1018 thru 1095, 12L14, A-36, Hot Rolled	SM5F SM4F	SM4F	XPVS	XPVS	SAP	XPVS XP	TC5F
Steel Alloys	P	4140 thru 8820 Steel Alloys <45 HRC, Cobalt Chrome	SM5F						
Tool & Mold Steels	P	H-13, O-1, A-2, D-2, S7, P20	SM6F	XP	XP-NB	XP-NB	SM5F SAP	XP	
	H	AR-450, Steels >45 HRC	SM6F-NB	SM5F-NB XP-NB			SAP-NB	XP-NB	
Stainless Steel	M	303,304, 316	SM3F	SM3F	XPVS XP	XPVS XP	SAP	XPVS	
		410, 420, 440, 13-8, 15-5, 17-4 Ph	SM5F	XPVS			SM5F	XP	
High Temp Titanium Alloys	S	6Al4V, 5553, 99	SM7F SM5F	XPV	XPV	XPV	XPV	XPV	SM7F
High Temp Nickel Based Alloys	S	Inconel 100, 625, 718, 925, Hastelloy-B, Rene 77, Jethete M252, Haynes 75, Waspalloy, Monel 400	SM6F-NB SM5F-NB SAP-NB	SM5F-NB XP-NB	XP-NB	XP-NB	SM5F-NB SM6F-NB SAP-NB	XP-NB	SM6F-NB
High Temp Iron Based Alloys	S	Aeromet 100, A286, Jethete M152	SM5F-NB SM6F-NB	SM5F-NB SM6F-NB					
High Temp Cobalt Based Alloys	S	Kovar, L-405, L-605, Stellite SF-12	SM5F-NB SM6F-NB	SM5F-NB SM6F-NB					
Cast Iron	K	Gray Cast, Malleable & Ductile Iron	SM6F	XP	XPVS	XPVS	SM5F SAP	XPVS XP	TC5F
Non-Ferrous Materials	N	Aluminium, Copper, Brass, Bronze	AL3F	AL3F	AL3F	AL3F	AL3F	AL3F	AL3F
		Plastics, Fibreglass	SM3F	SM3F	SM3F	SM3F	SM3F	SM3F	SM3F

**NOTE:** For best results when facing, use tools with a corner radius or a chamfer