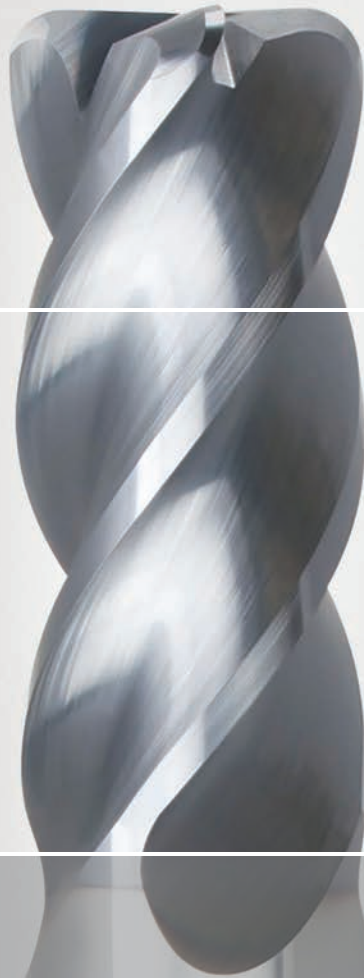


**NIAGARA  
CUTTER™  
STABILIZER™  
2.0**



**DOUBLE YOUR  
FEED RATES**



**Niagara Cutter**

# DOUBLE YOUR FEED RATES

# STABILIZER™ 2.0

US Patent number 6,991,409

The **Stabilizer 2.0** family of end mills raises the bar in high performance milling by incorporating a patented continuously varying asymmetrical geometry which helps create a smooth chatter free milling condition. This configuration, along with a specially engineered flute shape, allow for feed rates twice that of the current Stabilizer.

The ST430.2 series of end mills are specifically designed for machining steels, alloy steels, copper alloys and cast iron. The ST440.2 HT series of end mills are specifically designed for machining ISO-S materials such as stainless steel, steels over 42 Rc, titanium and Inconel. These end mills also feature an AlTiN coating that offers high heat resistance and superior abrasion resistance to maximize tool life.

## PRODUCT OVERVIEW

- Solid carbide high performance tools excel in slot and side milling
- 2x the feed rate of the current Stabilizer yields significant productivity gains
- Longer tool life than previous tool types even when applied at 2x the feed rates
- Continuously varying asymmetrical geometry provides smooth, chatter free cutting
- Wide application area covered, from steel to exotic materials
- ST430.2 (4-flutes) high performance series, 1, 2 and 3 x diameter flute length, diameters range from (0.125" - 1.00", 3 mm - 25 mm), cylindrical and weldon shank, sharp, corner radius and ball nose
- ST440.2 HT (4-flutes) high performance series, 1, 2 and 3 x diameter flute length, diameters range from (0.125" - 1.00", 3 mm - 25 mm), cylindrical shanks and weldon for 3/8" shank diameter and larger, standard aerospace radii (0.010", 0.020", 0.030", 0.060", 0.120"), and ball nose

## KEY BENEFITS

- Double the feed rates compared to current Stabilizer
- Reduced cycle times with higher metal removal rates
- Minimized harmonics
- High heat and abrasion resistance
- Smooth chatter free cutting
- Long and predictable tool life
- Consistent performance in all applications

## RANGE OVERVIEW

- 4-flute, patented continuously varying asymmetrical flute geometry with end mill diameters from 1/8" - 1" and 3 mm - 25 mm
- 1 x D, 2 x D and 3 x D length versions available
- Corner radius and ball nose necked versions with 2 x D flute length and 3 x D of reach

## SOLID END MILLING

STS430.2 .....	3-4
STR430.2 & STRN430.2 .....	4-5
STB430.2 & STBN430.2 .....	6
STR440.2 & STRN440.2 .....	7-9
STB440.2 .....	9

## CUTTING DATA

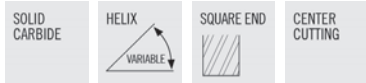
STS430.2, STR430.2 & STB430.2 .....	10-11
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# SOLID END MILLING - STABILIZER™ 2.0



## NEW NIAGARA CUTTER STABILIZER 2.0 - STS430.2



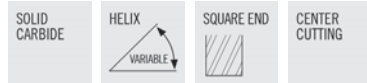
EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
	Inch									
N09696	STS430.2-0.125-D1-S.0-Z4	1/8	1/8	1/8	1 1/2	4	AITIN	-	■	
N09697	STS430.2-0.125-D2-S.0-Z4	1/8	1/8	1/4	1 1/2	4	AITIN	-	■	
N09698	STS430.2-0.125-D3-S.0-Z4	1/8	1/8	3/8	1 1/2	4	AITIN	-	■	
N09699	STS430.2-0.156-F1-S.0-Z4	5/32	3/16	5/32	2	4	AITIN	-	■	
N09702	STS430.2-0.156-F2-S.0-Z4	5/32	3/16	5/16	2	4	AITIN	-	■	
N09703	STS430.2-0.156-F3-S.0-Z4	5/32	3/16	15/32	2	4	AITIN	-	■	
N09704	STS430.2-0.188-D1-S.0-Z4	3/16	3/16	3/16	2	4	AITIN	-	■	
N09705	STS430.2-0.188-D2-S.0-Z4	3/16	3/16	3/8	2	4	AITIN	-	■	
N09706	STS430.2-0.188-D3-S.0-Z4	3/16	3/16	9/16	2	4	AITIN	-	■	
N09707	STS430.2-0.219-F1-S.0-Z4	7/32	1/4	7/32	2	4	AITIN	-	■	
N09708	STS430.2-0.219-F2-S.0-Z4	7/32	1/4	7/16	2 1/2	4	AITIN	-	■	
N09709	STS430.2-0.219-F3-S.0-Z4	7/32	1/4	21/32	2 1/2	4	AITIN	-	■	
N09712	STS430.2-0.250-D1-S.0-Z4	1/4	1/4	1/4	2	4	AITIN	-	■	
N09713	STS430.2-0.250-D2-S.0-Z4	1/4	1/4	1/2	2 1/2	4	AITIN	-	■	
N09714	STS430.2-0.250-D3-S.0-Z4	1/4	1/4	3/4	2 1/2	4	AITIN	-	■	
N09715	STS430.2-0.281-F1-S.0-Z4	9/32	5/16	9/32	2	4	AITIN	-	■	
N09716	STS430.2-0.281-F2-S.0-Z4	9/32	5/16	9/16	2 1/2	4	AITIN	-	■	
N09717	STS430.2-0.281-F3-S.0-Z4	9/32	5/16	27/32	2 1/2	4	AITIN	-	■	
N09718	STS430.2-0.313-D1-S.0-Z4	5/16	5/16	5/16	2	4	AITIN	-	■	
N09719	STS430.2-0.313-D2-S.0-Z4	5/16	5/16	5/8	2 1/2	4	AITIN	-	■	
N09722	STS430.2-0.313-D3-S.0-Z4	5/16	5/16	15/16	2 1/2	4	AITIN	-	■	
N09723	STS430.2-0.375-D1-S.0-Z4	3/8	3/8	3/8	2	4	AITIN	-	■	
N09724	STS430.2-0.375-D1-S.3-Z4	3/8	3/8	3/8	2	4	AITIN	-	■	■
N09725	STS430.2-0.375-D2-S.0-Z4	3/8	3/8	3/4	2 1/2	4	AITIN	-	■	
N09726	STS430.2-0.375-D2-S.3-Z4	3/8	3/8	3/4	2 1/2	4	AITIN	-	■	■
N09727	STS430.2-0.375-D3-S.0-Z4	3/8	3/8	1 1/8	3	4	AITIN	-	■	
N09728	STS430.2-0.375-D3-S.3-Z4	3/8	3/8	1 1/8	3	4	AITIN	-	■	■
N09729	STS430.2-0.438-D1-S.0-Z4	7/16	7/16	7/16	2 3/4	4	AITIN	-	■	
N09732	STS430.2-0.438-D1-S.3-Z4	7/16	7/16	7/16	2 3/4	4	AITIN	-	■	□
N09733	STS430.2-0.438-D2-S.0-Z4	7/16	7/16	7/8	2 3/4	4	AITIN	-	■	
N09734	STS430.2-0.438-D2-S.3-Z4	7/16	7/16	7/8	2 3/4	4	AITIN	-	■	□
N09735	STS430.2-0.438-D3-S.0-Z4	7/16	7/16	1 5/16	4	4	AITIN	-	■	
N09736	STS430.2-0.438-D3-S.3-Z4	7/16	7/16	1 5/16	4	4	AITIN	-	■	□
N09737	STS430.2-0.500-D1-S.0-Z4	1/2	1/2	1/2	2 1/2	4	AITIN	-	■	
N09738	STS430.2-0.500-D1-S.3-Z4	1/2	1/2	1/2	2 1/2	4	AITIN	-	■	■
N09739	STS430.2-0.500-D2-S.0-Z4	1/2	1/2	1	3	4	AITIN	-	■	
N09742	STS430.2-0.500-D2-S.3-Z4	1/2	1/2	1	3	4	AITIN	-	■	■
N09743	STS430.2-0.500-D3-S.0-Z4	1/2	1/2	1 1/4	3	4	AITIN	-	■	
N09744	STS430.2-0.500-D3-S.3-Z4	1/2	1/2	1 1/4	3	4	AITIN	-	■	■
N09745	STS430.2-0.500-D4-S.0-Z4	1/2	1/2	1 1/2	4	4	AITIN	-	■	
N09746	STS430.2-0.500-D4-S.3-Z4	1/2	1/2	1 1/2	4	4	AITIN	-	■	■
N09747	STS430.2-0.625-D1-S.0-Z4	5/8	5/8	5/8	3	4	AITIN	-	■	
N09748	STS430.2-0.625-D1-S.3-Z4	5/8	5/8	5/8	3	4	AITIN	-	■	■
N09749	STS430.2-0.625-D2-S.0-Z4	5/8	5/8	1 1/4	3 1/2	4	AITIN	-	■	
N09752	STS430.2-0.625-D2-S.3-Z4	5/8	5/8	1 1/4	3 1/2	4	AITIN	-	■	■
N09753	STS430.2-0.625-D3-S.0-Z4	5/8	5/8	1 7/8	4	4	AITIN	-	■	
N09754	STS430.2-0.625-D3-S.3-Z4	5/8	5/8	1 7/8	4	4	AITIN	-	■	□
N09755	STS430.2-0.750-D1-S.0-Z4	3/4	3/4	3/4	3	4	AITIN	-	■	
N09756	STS430.2-0.750-D1-S.3-Z4	3/4	3/4	3/4	3	4	AITIN	-	■	■
N09757	STS430.2-0.750-D2-S.0-Z4	3/4	3/4	1 1/2	4	4	AITIN	-	■	
N09758	STS430.2-0.750-D2-S.3-Z4	3/4	3/4	1 1/2	4	4	AITIN	-	■	■
N09759	STS430.2-0.750-D3-S.0-Z4	3/4	3/4	2 1/4	5	4	AITIN	-	■	
N09762	STS430.2-0.750-D3-S.3-Z4	3/4	3/4	2 1/4	5	4	AITIN	-	■	■
N09763	STS430.2-0.875-D1-S.0-Z4	7/8	7/8	7/8	4	4	AITIN	-	■	
N09764	STS430.2-0.875-D1-S.3-Z4	7/8	7/8	7/8	4	4	AITIN	-	■	□
N09765	STS430.2-0.875-D2-S.0-Z4	7/8	7/8	1 3/4	4	4	AITIN	-	■	
N09766	STS430.2-0.875-D2-S.3-Z4	7/8	7/8	1 3/4	4	4	AITIN	-	■	□
N09767	STS430.2-0.875-D3-S.0-Z4	7/8	7/8	2 5/8	5	4	AITIN	-	■	
N09768	STS430.2-0.875-D3-S.3-Z4	7/8	7/8	2 5/8	5	4	AITIN	-	■	□
N09769	STS430.2-1.000-D1-S.0-Z4	1	1	1	4	4	AITIN	-	■	
N09772	STS430.2-1.000-D1-S.3-Z4	1	1	1	4	4	AITIN	-	■	□
N09773	STS430.2-1.000-D2-S.0-Z4	1	1	2	5	4	AITIN	-	■	
N09774	STS430.2-1.000-D2-S.3-Z4	1	1	2	5	4	AITIN	-	■	■
N09775	STS430.2-1.000-D3-S.0-Z4	1	1	3	6	4	AITIN	-	■	
N09776	STS430.2-1.000-D3-S.3-Z4	1	1	3	6	4	AITIN	-	■	□

□ Quick Response Item. Delivery within 7 days.

# SOLID END MILLING - STABILIZER™ 2.0

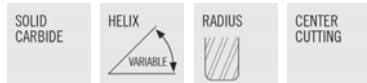


## NEW NIAGARA CUTTER STABILIZER 2.0 - STS430.2 (CON'T)



EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	FLUTES	COATING	RADIUS	CYLINDRICAL
<b>Metric</b>									
N09538	STS430M.2-030-F2-S.0-Z4	3	6	6	58	4	AlTiN	-	■
N09539	STS430M.2-030-F3-S.0-Z4	3	6	9	58	4	AlTiN	-	■
N09542	STS430M.2-040-F2-S.0-Z4	4	6	8	58	4	AlTiN	-	■
N09543	STS430M.2-040-F3-S.0-Z4	4	6	12	58	4	AlTiN	-	■
N09544	STS430M.2-050-F2-S.0-Z4	5	6	10	58	4	AlTiN	-	■
N09545	STS430M.2-050-F3-S.0-Z4	5	6	15	58	4	AlTiN	-	■
N09546	STS430M.2-060-D2-S.0-Z4	6	6	12	58	4	AlTiN	-	■
N09547	STS430M.2-060-D3-S.0-Z4	6	6	18	58	4	AlTiN	-	■
N09548	STS430M.2-080-D2-S.0-Z4	8	8	16	64	4	AlTiN	-	■
N09549	STS430M.2-080-D3-S.0-Z4	8	8	24	64	4	AlTiN	-	■
N09552	STS430M.2-100-D2-S.0-Z4	10	10	20	73	4	AlTiN	-	■
N09553	STS430M.2-100-D3-S.0-Z4	10	10	30	73	4	AlTiN	-	■
N09554	STS430M.2-120-D2-S.0-Z4	12	12	24	84	4	AlTiN	-	■
N09555	STS430M.2-120-D3-S.0-Z4	12	12	36	84	4	AlTiN	-	■
N09556	STS430M.2-160-D2-S.0-Z4	16	16	32	93	4	AlTiN	-	■
N09557	STS430M.2-160-D3-S.0-Z4	16	16	48	93	4	AlTiN	-	■
N09558	STS430M.2-200-D2-S.0-Z4	20	20	40	105	4	AlTiN	-	■
N09559	STS430M.2-200-D3-S.0-Z4	20	20	60	125	4	AlTiN	-	■
N09562	STS430M.2-250-D2-S.0-Z4	25	25	50	115	4	AlTiN	-	■
N09563	STS430M.2-250-D3-S.0-Z4	25	25	75	147	4	AlTiN	-	■

## NEW NIAGARA CUTTER STABILIZER 2.0 - STR430.2



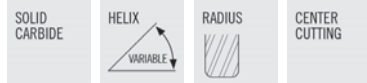
EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
<b>Inch</b>										
N09777	STR430.2-0.125-D1-R010.0-Z4	1/8	1/8	1/8	1 1/2	4	AlTiN	0.010	■	
N09778	STR430.2-0.125-D2-R010.0-Z4	1/8	1/8	1/4	1 1/2	4	AlTiN	0.010	■	
N09779	STR430.2-0.125-D3-R010.0-Z4	1/8	1/8	3/8	1 1/2	4	AlTiN	0.010	■	
N09782	STR430.2-0.156-F1-R010.0-Z4	5/32	3/16	5/32	2	4	AlTiN	0.010	■	
N09783	STR430.2-0.156-F2-R010.0-Z4	5/32	3/16	5/16	2	4	AlTiN	0.010	■	
N09784	STR430.2-0.156-F3-R010.0-Z4	5/32	3/16	15/32	2	4	AlTiN	0.010	■	
N09785	STR430.2-0.188-D1-R010.0-Z4	3/16	3/16	3/16	2	4	AlTiN	0.010	■	
N09786	STR430.2-0.188-D2-R010.0-Z4	3/16	3/16	3/8	2	4	AlTiN	0.010	■	
N09787	STR430.2-0.188-D3-R010.0-Z4	3/16	3/16	9/16	2	4	AlTiN	0.010	■	
N09788	STR430.2-0.219-F1-R020.0-Z4	7/32	1/4	7/32	2	4	AlTiN	0.020	■	
N09789	STR430.2-0.219-F2-R020.0-Z4	7/32	1/4	7/16	2 1/2	4	AlTiN	0.020	■	
N09792	STR430.2-0.219-F3-R020.0-Z4	7/32	1/4	21/32	2 1/2	4	AlTiN	0.020	■	
N09793	STR430.2-0.250-D1-R020.0-Z4	1/4	1/4	1/4	2	4	AlTiN	0.020	■	
N09794	STR430.2-0.250-D2-R020.0-Z4	1/4	1/4	1/2	2 1/2	4	AlTiN	0.020	■	
N09795	STR430.2-0.250-D3-R020.0-Z4	1/4	1/4	3/4	2 1/2	4	AlTiN	0.020	■	
N09796	STR430.2-0.281-F1-R020.0-Z4	9/32	5/16	9/32	2	4	AlTiN	0.020	■	
N09797	STR430.2-0.281-F2-R020.0-Z4	9/32	5/16	9/16	2 1/2	4	AlTiN	0.020	■	
N09798	STR430.2-0.281-F3-R020.0-Z4	9/32	5/16	27/32	2 1/2	4	AlTiN	0.020	■	
N09799	STR430.2-0.313-D1-R020.0-Z4	5/16	5/16	5/16	2	4	AlTiN	0.020	■	
N09802	STR430.2-0.313-D2-R020.0-Z4	5/16	5/16	5/8	2 1/2	4	AlTiN	0.020	■	
N09803	STR430.2-0.313-D3-R020.0-Z4	5/16	5/16	15/16	2 1/2	4	AlTiN	0.020	■	
N09804	STR430.2-0.375-D1-R020.0-Z4	3/8	3/8	3/8	2	4	AlTiN	0.020	■	
N09805	STR430.2-0.375-D1-R020.3-Z4	3/8	3/8	3/8	2	4	AlTiN	0.020	■	■
N09806	STR430.2-0.375-D2-R020.0-Z4	3/8	3/8	3/4	2 1/2	4	AlTiN	0.020	■	
N09807	STR430.2-0.375-D2-R020.3-Z4	3/8	3/8	3/4	2 1/2	4	AlTiN	0.020	■	■
N09808	STR430.2-0.375-D3-R020.0-Z4	3/8	3/8	1 1/8	3	4	AlTiN	0.020	■	
N09809	STR430.2-0.375-D3-R020.3-Z4	3/8	3/8	1 1/8	3	4	AlTiN	0.020	■	■
N09812	STR430.2-0.438-F1-R020.0-Z4	7/16	7/16	7/16	2 3/4	4	AlTiN	0.020	■	
N09813	STR430.2-0.438-F1-R020.3-Z4	7/16	7/16	7/16	2 3/4	4	AlTiN	0.020	■	□
N09814	STR430.2-0.438-F2-R020.0-Z4	7/16	7/16	7/8	2 3/4	4	AlTiN	0.020	■	
N09815	STR430.2-0.438-F2-R020.3-Z4	7/16	7/16	7/8	2 3/4	4	AlTiN	0.020	■	□
N09816	STR430.2-0.438-F3-R020.0-Z4	7/16	7/16	1 5/16	4	4	AlTiN	0.020	■	
N09817	STR430.2-0.438-F3-R020.3-Z4	7/16	7/16	1 5/16	4	4	AlTiN	0.020	■	□
N09818	STR430.2-0.500-D1-R030.0-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.030	■	
N09819	STR430.2-0.500-D1-R030.3-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.030	■	■
N09844	STR430.2-0.500-D2-R030.0-Z4	1/2	1/2	1	3	4	AlTiN	0.030	■	
N09845	STR430.2-0.500-D2-R030.3-Z4	1/2	1/2	1	3	4	AlTiN	0.030	■	■
N09846	STR430.2-0.500-D3-R030.0-Z4	1/2	1/2	1 1/4	3	4	AlTiN	0.030	■	
N09847	STR430.2-0.500-D3-R030.3-Z4	1/2	1/2	1 1/4	3	4	AlTiN	0.030	■	■

□ Quick Response Item. Delivery within 7 days.

# SOLID END MILLING - STABILIZER™ 2.0

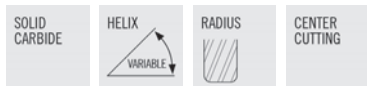


## NEW NIAGARA CUTTER STABILIZER 2.0 - STR430.2 (CON'T)



EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	NECK DIA	REACH LENGTH	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
<b>Inch</b>												
N09848	STR430.2-0.500-D4-R030.0-Z4	1/2	1/2	1 1/2	4	-	-	4	AlTiN	0.030	■	
N09849	STR430.2-0.500-D4-R030.3-Z4	1/2	1/2	1 1/2	4	-	-	4	AlTiN	0.030		■
N09852	STR430.2-0.625-D1-R030.0-Z4	5/8	5/8	5/8	3	-	-	4	AlTiN	0.030	■	
N09853	STR430.2-0.625-D1-R030.3-Z4	5/8	5/8	5/8	3	-	-	4	AlTiN	0.030		□
N09854	STR430.2-0.625-D2-R030.0-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AlTiN	0.030	■	
N09855	STR430.2-0.625-D2-R030.3-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AlTiN	0.030		■
N09856	STR430.2-0.625-D3-R030.0-Z4	5/8	5/8	1 7/8	4	-	-	4	AlTiN	0.030	■	
N09857	STR430.2-0.625-D3-R030.3-Z4	5/8	5/8	1 7/8	4	-	-	4	AlTiN	0.030		□
N09858	STR430.2-0.750-D1-R030.0-Z4	3/4	3/4	3/4	3	-	-	4	AlTiN	0.030	■	
N09859	STR430.2-0.750-D1-R030.3-Z4	3/4	3/4	3/4	3	-	-	4	AlTiN	0.030		■
N09862	STR430.2-0.750-D2-R030.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AlTiN	0.030	■	
N09863	STR430.2-0.750-D2-R030.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AlTiN	0.030		■
N09864	STR430.2-0.750-D3-R030.0-Z4	3/4	3/4	2 1/4	5	-	-	4	AlTiN	0.030	■	
N09865	STR430.2-0.750-D3-R030.3-Z4	3/4	3/4	2 1/4	5	-	-	4	AlTiN	0.030		■
N09866	STR430.2-0.875-D1-R030.0-Z4	7/8	7/8	7/8	4	-	-	4	AlTiN	0.030	■	
N09867	STR430.2-0.875-D1-R030.3-Z4	7/8	7/8	7/8	4	-	-	4	AlTiN	0.030		□
N09868	STR430.2-0.875-D2-R030.0-Z4	7/8	7/8	1 3/4	4	-	-	4	AlTiN	0.030	■	
N09869	STR430.2-0.875-D2-R030.3-Z4	7/8	7/8	1 3/4	4	-	-	4	AlTiN	0.030		□
N09872	STR430.2-0.875-D3-R030.0-Z4	7/8	7/8	2 5/8	5	-	-	4	AlTiN	0.030	■	
N09873	STR430.2-0.875-D3-R030.3-Z4	7/8	7/8	2 5/8	5	-	-	4	AlTiN	0.030		□
N09874	STR430.2-1.000-D1-R030.0-Z4	1	1	1	4	-	-	4	AlTiN	0.030	■	
N09875	STR430.2-1.000-D1-R030.3-Z4	1	1	1	4	-	-	4	AlTiN	0.030		□
N09876	STR430.2-1.000-D2-R030.0-Z4	1	1	2	5	-	-	4	AlTiN	0.030	■	
N09877	STR430.2-1.000-D2-R030.3-Z4	1	1	2	5	-	-	4	AlTiN	0.030		■
N09878	STR430.2-1.000-D3-R030.0-Z4	1	1	3	6	-	-	4	AlTiN	0.030	■	
N09879	STR430.2-1.000-D3-R030.3-Z4	1	1	3	6	-	-	4	AlTiN	0.030		□
<b>Metric</b>												
N09564	STR430M.2-030-F2-R250.0-Z4	3	6	6	58	-	-	4	AlTiN	0.250	■	
N09565	STR430M.2-030-F3-R250.0-Z4	3	6	9	58	-	-	4	AlTiN	0.250	■	
N09566	STR430M.2-040-F2-R250.0-Z4	4	6	8	58	-	-	4	AlTiN	0.250	■	
N09567	STR430M.2-040-F3-R250.0-Z4	4	6	12	58	-	-	4	AlTiN	0.250	■	
N09568	STR430M.2-050-F2-R250.0-Z4	5	6	10	58	-	-	4	AlTiN	0.250	■	
N09569	STR430M.2-050-F3-R250.0-Z4	5	6	15	58	-	-	4	AlTiN	0.250	■	
N09582	STR430M.2-060-D2-R500.0-Z4	6	6	12	58	-	-	4	AlTiN	0.500	■	
N09583	STR430M.2-060-D3-R500.0-Z4	6	6	18	58	-	-	4	AlTiN	0.500	■	
N09584	STR430M.2-080-D2-R500.0-Z4	8	8	16	64	-	-	4	AlTiN	0.500	■	
N09585	STR430M.2-080-D3-R500.0-Z4	8	8	24	64	-	-	4	AlTiN	0.500	■	
N09586	STR430M.2-100-D2-R500.0-Z4	10	10	20	73	-	-	4	AlTiN	0.500	■	
N09587	STR430M.2-100-D3-R500.0-Z4	10	10	30	73	-	-	4	AlTiN	0.500	■	
N09588	STR430M.2-120-D2-R750.0-Z4	12	12	24	84	-	-	4	AlTiN	0.750	■	
N09589	STR430M.2-120-D3-R750.0-Z4	12	12	36	84	-	-	4	AlTiN	0.750	■	
N09602	STR430M.2-160-D2-R750.0-Z4	16	16	32	93	-	-	4	AlTiN	0.750	■	
N09603	STR430M.2-160-D3-R750.0-Z4	16	16	48	93	-	-	4	AlTiN	0.750	■	
N09604	STR430M.2-200-D2-R750.0-Z4	20	20	40	105	-	-	4	AlTiN	0.750	■	
N09605	STR430M.2-200-D3-R750.0-Z4	20	20	60	125	-	-	4	AlTiN	0.750	■	
N09606	STR430M.2-250-D2-R750.0-Z4	25	25	50	115	-	-	4	AlTiN	0.750	■	
N09607	STR430M.2-250-D3-R750.0-Z4	25	25	75	147	-	-	4	AlTiN	0.750	■	

## NEW NIAGARA CUTTER STABILIZER 2.0 - STRN430.2 (NECKED)



<b>STRN430.2 (NECKED)</b>												
<b>Inch</b>												
N09447	STRN430.2-0.250-E2-R020.0-Z4	1/4	1/4	1/2	2 1/2	0.240	0.750	4	AlTiN	0.020	■	
N09448	STRN430.2-0.313-E2-R020.0-Z4	5/16	5/16	5/8	3	0.300	0.938	4	AlTiN	0.020	■	
N09449	STRN430.2-0.375-E2-R020.0-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AlTiN	0.020	■	
N09456	STRN430.2-0.375-E2-R020.3-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AlTiN	0.020		□
N09457	STRN430.2-0.438-E2-R020.0-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AlTiN	0.020	■	
N09462	STRN430.2-0.438-E2-R020.3-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AlTiN	0.020		□
N09463	STRN430.2-0.500-E2-R030.0-Z4	1/2	1/2	1	3	0.480	1.500	4	AlTiN	0.030	■	
N09464	STRN430.2-0.500-E2-R030.3-Z4	1/2	1/2	1	3	0.480	1.500	4	AlTiN	0.030		■
N09465	STRN430.2-0.625-E2-R030.0-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	0.030	■	
N09466	STRN430.2-0.625-E2-R030.3-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	0.030		□
N09467	STRN430.2-0.750-E2-R030.0-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	0.030	■	
N09468	STRN430.2-0.750-E2-R030.3-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	0.030		■
N09469	STRN430.2-1.000-E2-R030.0-Z4	1	1	2	5	0.960	3.000	4	AlTiN	0.030	■	
N09472	STRN430.2-1.000-E2-R030.3-Z4	1	1	2	5	0.960	3.000	4	AlTiN	0.030		□

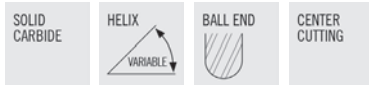
□ Quick Response Item. Delivery within 7 days.



# SOLID END MILLING - STABILIZER™ 2.0

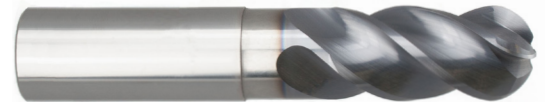


## NEW NIAGARA CUTTER STABILIZER 2.0 - STB430.2



EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	NECK DIA	REACH LENGTH	FLUTES	COATING	CYLINDRICAL	WELDON
<b>Inch</b>											
N09369	STB430.2-0.125-D2-B.0-Z4	1/8	1/8	1/4	1 1/2	-	-	4	AITIN	■	
N09373	STB430.2-0.188-D2-B.0-Z4	3/16	3/16	3/8	2	-	-	4	AITIN	■	
N09383	STB430.2-0.250-D2-B.0-Z4	1/4	1/4	1/2	2 1/2	-	-	4	AITIN	■	
N09386	STB430.2-0.313-D2-B.0-Z4	5/16	5/16	5/8	2 1/2	-	-	4	AITIN	■	
N09387	STB430.2-0.375-D2-B.0-Z4	3/8	3/8	3/4	2 1/2	-	-	4	AITIN	■	
N09389	STB430.2-0.375-D2-B.3-Z4	3/8	3/8	3/4	2 1/2	-	-	4	AITIN	■	■
N09393	STB430.2-0.438-D2-B.0-Z4	7/16	7/16	7/8	2 3/4	-	-	4	AITIN	■	
N09396	STB430.2-0.438-D2-B.3-Z4	7/16	7/16	7/8	2 3/4	-	-	4	AITIN	■	□
N09397	STB430.2-0.500-D2-B.0-Z4	1/2	1/2	1	3	-	-	4	AITIN	■	
N09398	STB430.2-0.500-D2-B.3-Z4	1/2	1/2	1	3	-	-	4	AITIN	■	■
N09399	STB430.2-0.625-D2-B.0-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AITIN	■	
N09402	STB430.2-0.625-D2-B.3-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AITIN	■	□
N09403	STB430.2-0.750-D2-B.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	■	
N09404	STB430.2-0.750-D2-B.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	■	■
N09405	STB430.2-1.000-D2-B.0-Z4	1	1	2	5	-	-	4	AITIN	■	
N09406	STB430.2-1.000-D2-B.3-Z4	1	1	2	5	-	-	4	AITIN	■	□
<b>Metric</b>											
N09608	STB430M.2-030-F2-B.0-Z4	3	6	6	58	-	-	4	AITIN	■	
N09609	STB430M.2-030-F3-B.0-Z4	3	6	9	58	-	-	4	AITIN	■	
N09612	STB430M.2-040-F2-B.0-Z4	4	6	8	58	-	-	4	AITIN	■	
N09613	STB430M.2-040-F3-B.0-Z4	4	6	12	58	-	-	4	AITIN	■	
N09614	STB430M.2-050-F2-B.0-Z4	5	6	10	58	-	-	4	AITIN	■	
N09615	STB430M.2-050-F3-B.0-Z4	5	6	15	58	-	-	4	AITIN	■	
N09616	STB430M.2-060-D2-B.0-Z4	6	6	12	58	-	-	4	AITIN	■	
N09617	STB430M.2-060-D3-B.0-Z4	6	6	18	58	-	-	4	AITIN	■	
N09618	STB430M.2-080-D2-B.0-Z4	8	8	16	64	-	-	4	AITIN	■	
N09622	STB430M.2-080-D3-B.0-Z4	8	8	24	64	-	-	4	AITIN	■	
N09623	STB430M.2-100-D2-B.0-Z4	10	10	20	73	-	-	4	AITIN	■	
N09624	STB430M.2-100-D3-B.0-Z4	10	10	30	73	-	-	4	AITIN	■	
N09626	STB430M.2-120-D2-B.0-Z4	12	12	24	84	-	-	4	AITIN	■	
N09627	STB430M.2-120-D3-B.0-Z4	12	12	36	84	-	-	4	AITIN	■	
N09628	STB430M.2-160-D2-B.0-Z4	16	16	32	93	-	-	4	AITIN	■	
N09631	STB430M.2-160-D3-B.0-Z4	16	16	48	93	-	-	4	AITIN	■	
N09632	STB430M.2-200-D2-B.0-Z4	20	20	40	105	-	-	4	AITIN	■	
N09633	STB430M.2-200-D3-B.0-Z4	20	20	60	125	-	-	4	AITIN	■	
N09634	STB430M.2-250-D2-B.0-Z4	25	25	50	115	-	-	4	AITIN	■	
N09635	STB430M.2-250-D3-B.0-Z4	25	25	75	147	-	-	4	AITIN	■	

## NEW NIAGARA CUTTER STABILIZER 2.0 - STBN430.2 (NECKED)



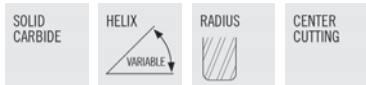
<b>STBN430.2 (NECKED)</b>											
<b>Inch</b>											
N09473	STBN430.2-0.250-E2-B.0-Z4	1/4	1/4	1/2	2 1/2	0.240	0.750	4	AITIN	■	
N09474	STBN430.2-0.313-E2-B.0-Z4	5/16	5/16	5/8	3	0.300	0.938	4	AITIN	■	
N09475	STBN430.2-0.375-E2-B.0-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AITIN	■	
N09476	STBN430.2-0.375-E2-B.3-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AITIN	■	□
N09477	STBN430.2-0.438-E2-B.0-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AITIN	■	
N09478	STBN430.2-0.438-E2-B.3-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AITIN	■	□
N09479	STBN430.2-0.500-E2-B.0-Z4	1/2	1/2	1	3	0.480	1.500	4	AITIN	■	
N09493	STBN430.2-0.500-E2-B.3-Z4	1/2	1/2	1	3	0.480	1.500	4	AITIN	■	■
N09494	STBN430.2-0.625-E2-B.0-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AITIN	■	
N09495	STBN430.2-0.625-E2-B.3-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AITIN	■	□
N09496	STBN430.2-0.750-E2-B.0-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AITIN	■	
N09497	STBN430.2-0.750-E2-B.3-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AITIN	■	□
N09499	STBN430.2-1.000-E2-B.0-Z4	1	1	2	5	0.960	3.000	4	AITIN	■	
N09502	STBN430.2-1.000-E2-B.3-Z4	1	1	2	5	0.960	3.000	4	AITIN	■	□

□ Quick Response Item. Delivery within 7 days.

# SOLID END MILLING - STABILIZER™ 2.0



## NEW NIAGARA CUTTER STABILIZER 2.0 - STR440.2



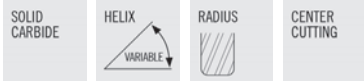
EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON	
	Inch										
N09882	STR440.2-0.125-D1-R010.0-Z4	1/8	1/8	1/8	1 1/2	4	AlTiN	0.010	■		
N09883	STR440.2-0.125-D2-R010.0-Z4	1/8	1/8	1/4	1 1/2	4	AlTiN	0.010	■		
N09884	STR440.2-0.125-D3-R010.0-Z4	1/8	1/8	3/8	1 1/2	4	AlTiN	0.010	■		
N09885	STR440.2-0.156-D1-R010.0-Z4	5/32	3/16	5/32	2	4	AlTiN	0.010	■		
N09886	STR440.2-0.156-F2-R010.0-Z4	5/32	3/16	5/16	2	4	AlTiN	0.010	■		
N09887	STR440.2-0.156-F3-R010.0-Z4	5/32	3/16	15/32	2	4	AlTiN	0.010	■		
N09888	STR440.2-0.188-D1-R010.0-Z4	3/16	3/16	3/16	2	4	AlTiN	0.010	■		
N09889	STR440.2-0.188-D2-R010.0-Z4	3/16	3/16	3/8	2	4	AlTiN	0.010	■		
N09892	STR440.2-0.188-D3-R010.0-Z4	3/16	3/16	9/16	2	4	AlTiN	0.010	■		
N09893	STR440.2-0.219-F1-R020.0-Z4	7/32	1/4	7/32	2	4	AlTiN	0.020	■		
N09894	STR440.2-0.219-F2-R020.0-Z4	7/32	1/4	7/16	2 1/2	4	AlTiN	0.020	■		
N09895	STR440.2-0.219-F3-R020.0-Z4	7/32	1/4	21/32	2 1/2	4	AlTiN	0.020	■		
N09896	STR440.2-0.250-D1-R020.0-Z4	1/4	1/4	1/4	2	4	AlTiN	0.020	■		
N09897	STR440.2-0.250-D2-R020.0-Z4	1/4	1/4	1/2	2 1/2	4	AlTiN	0.020	■		
N09898	STR440.2-0.250-D3-R020.0-Z4	1/4	1/4	3/4	2 1/2	4	AlTiN	0.020	■		
N09899	STR440.2-0.281-F1-R020.0-Z4	9/32	5/16	9/32	2	4	AlTiN	0.020	■		
N09902	STR440.2-0.281-F3-R020.0-Z4	9/32	5/16	9/16	2 1/2	4	AlTiN	0.020	■		
N09903	STR440.2-0.281-F4-R020.0-Z4	9/32	5/16	27/32	2 1/2	4	AlTiN	0.020	■		
N09904	STR440.2-0.313-D1-R020.0-Z4	5/16	5/16	5/16	2	4	AlTiN	0.020	■		
N09905	STR440.2-0.313-D2-R020.0-Z4	5/16	5/16	5/8	2 1/2	4	AlTiN	0.020	■		
N09906	STR440.2-0.313-D3-R020.0-Z4	5/16	5/16	15/16	2 1/2	4	AlTiN	0.020	■		
N09907	STR440.2-0.375-D1-R020.0-Z4	3/8	3/8	3/8	2	4	AlTiN	0.020	■		
N09908	STR440.2-0.375-D1-R020.3-Z4	3/8	3/8	3/8	2	4	AlTiN	0.020		■	
N09909	STR440.2-0.375-D2-R020.0-Z4	3/8	3/8	3/4	2 1/2	4	AlTiN	0.020	■		
N09912	STR440.2-0.375-D2-R020.3-Z4	3/8	3/8	3/4	2 1/2	4	AlTiN	0.020		■	
N09913	STR440.2-0.375-D3-R020.0-Z4	3/8	3/8	1 1/8	3	4	AlTiN	0.020	■		
N09914	STR440.2-0.375-D3-R020.3-Z4	3/8	3/8	1 1/8	3	4	AlTiN	0.020		■	
N09915	STR440.2-0.438-D1-R020.0-Z4	7/16	7/16	7/16	2 3/4	4	AlTiN	0.020	■		
N09916	STR440.2-0.438-D1-R020.3-Z4	7/16	7/16	7/16	2 3/4	4	AlTiN	0.020		□	
N09917	STR440.2-0.438-D2-R020.0-Z4	7/16	7/16	7/8	2 3/4	4	AlTiN	0.020	■		
N09919	STR440.2-0.438-D2-R020.3-Z4	7/16	7/16	7/8	2 3/4	4	AlTiN	0.020		□	
N09934	STR440.2-0.438-D3-R020.0-Z4	7/16	7/16	1 5/16	4	4	AlTiN	0.020	■		
N09935	STR440.2-0.438-D3-R020.3-Z4	7/16	7/16	1 5/16	4	4	AlTiN	0.020		■	
N09939	STR440.2-0.500-D1-R030.0-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.030	■		
N09942	STR440.2-0.500-D1-R030.3-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.030		■	
N09943	STR440.2-0.500-D1-R060.0-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.060	■		
N09944	STR440.2-0.500-D1-R060.3-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.060		■	
N09945	STR440.2-0.500-D1-R120.0-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.120	■		
N09946	STR440.2-0.500-D1-R120.3-Z4	1/2	1/2	1/2	2 1/2	4	AlTiN	0.120		■	
N09947	STR440.2-0.500-D2-R030.0-Z4	1/2	1/2	1	3	4	AlTiN	0.030	■		
N09948	STR440.2-0.500-D2-R030.3-Z4	1/2	1/2	1	3	4	AlTiN	0.030		■	
N09949	STR440.2-0.500-D3-R030.0-Z4	1/2	1/2	1 1/4	3	4	AlTiN	0.030	■		
N09952	STR440.2-0.500-D3-R030.3-Z4	1/2	1/2	1 1/4	3	4	AlTiN	0.030		■	
N09953	STR440.2-0.500-D2-R060.0-Z4	1/2	1/2	1	3	4	AlTiN	0.060	■		
N09954	STR440.2-0.500-D2-R060.3-Z4	1/2	1/2	1	3	4	AlTiN	0.060		■	
N09955	STR440.2-0.500-D2-R120.0-Z4	1/2	1/2	1	3	4	AlTiN	0.120	■		
N09956	STR440.2-0.500-D2-R120.3-Z4	1/2	1/2	1	3	4	AlTiN	0.120		■	
N09957	STR440.2-0.500-D4-R030.0-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.030	■		
N09958	STR440.2-0.500-D4-R030.3-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.030		■	
N09959	STR440.2-0.500-D3-R060.0-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.060	■		
N09962	STR440.2-0.500-D3-R060.3-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.060		■	
N09963	STR440.2-0.500-D3-R120.0-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.120	■		
N09964	STR440.2-0.500-D3-R120.3-Z4	1/2	1/2	1 1/2	4	4	AlTiN	0.120		■	
N09965	STR440.2-0.625-D1-R030.0-Z4	5/8	5/8	5/8	3	4	AlTiN	0.030	■		
N09966	STR440.2-0.625-D1-R030.3-Z4	5/8	5/8	5/8	3	4	AlTiN	0.030		□	
N09967	STR440.2-0.625-D1-R060.0-Z4	5/8	5/8	5/8	3	4	AlTiN	0.060	■		
N09968	STR440.2-0.625-D1-R060.3-Z4	5/8	5/8	5/8	3	4	AlTiN	0.060		□	
N09969	STR440.2-0.625-D1-R120.0-Z4	5/8	5/8	5/8	3	4	AlTiN	0.120	■		
N09972	STR440.2-0.625-D1-R120.3-Z4	5/8	5/8	5/8	3	4	AlTiN	0.120		□	
N09973	STR440.2-0.625-D2-R030.0-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.030	■		
N09974	STR440.2-0.625-D2-R030.3-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.030		■	
N09975	STR440.2-0.625-D2-R060.0-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.060	■		
N09976	STR440.2-0.625-D2-R060.3-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.060		□	
N09977	STR440.2-0.625-D2-R120.0-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.120	■		
N09978	STR440.2-0.625-D2-R120.3-Z4	5/8	5/8	1 1/4	3 1/2	4	AlTiN	0.120		□	
N09979	STR440.2-0.625-D3-R030.0-Z4	5/8	5/8	1 7/8	4	4	AlTiN	0.030	■		
N09982	STR440.2-0.625-D3-R030.3-Z4	5/8	5/8	1 7/8	4	4	AlTiN	0.030		□	
N09983	STR440.2-0.625-D3-R060.0-Z4	5/8	5/8	1 7/8	4	4	AlTiN	0.060	■		

□ Quick Response Item. Delivery within 7 days.

# SOLID END MILLING - STABILIZER™ 2.0



## NEW NIAGARA CUTTER STABILIZER 2.0 - STR440.2 (CON'T) & STRN440.2 (NECKED)



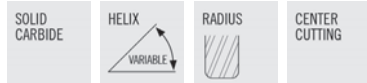
EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	NECK DIA	REACH LENGTH	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
<b>Inch</b>												
N09984	STR440.2-0.625-D3-R060.3-Z4	5/8	5/8	1 7/8	4	-	-	4	AITIN	0.060		□
N00328	STR440.2-0.625-D3-R120.0-Z4	5/8	5/8	1 7/8	4	-	-	4	AITIN	0.120	■	
N00329	STR440.2-0.625-D3-R120.3-Z4	5/8	5/8	1 7/8	4	-	-	4	AITIN	0.120		□
N00332	STR440.2-0.750-D1-R030.0-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.030	■	
N00333	STR440.2-0.750-D1-R030.3-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.030		■
N00334	STR440.2-0.750-D1-R060.0-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.060	■	
N00335	STR440.2-0.750-D1-R060.3-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.060		□
N00336	STR440.2-0.750-D1-R120.0-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.120	■	
N00337	STR440.2-0.750-D1-R120.3-Z4	3/4	3/4	3/4	3	-	-	4	AITIN	0.120		□
N00338	STR440.2-0.750-D2-R030.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.030	■	
N00339	STR440.2-0.750-D2-R030.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.030		■
N00342	STR440.2-0.750-D2-R060.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.060	■	
N00343	STR440.2-0.750-D2-R060.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.060		□
N00344	STR440.2-0.750-D2-R120.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.120	■	
N00345	STR440.2-0.750-D2-R120.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AITIN	0.120		□
N00346	STR440.2-0.750-D3-R030.0-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.030	■	
N00347	STR440.2-0.750-D3-R030.3-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.030		□
N00348	STR440.2-0.750-D3-R060.0-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.060	■	
N00349	STR440.2-0.750-D3-R060.3-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.060		□
N00352	STR440.2-0.750-D3-R120.0-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.120	■	
N00353	STR440.2-0.750-D3-R120.3-Z4	3/4	3/4	2 1/4	5	-	-	4	AITIN	0.120		□
N00354	STR440.2-1.000-D1-R030.0-Z4	1	1	1	4	-	-	4	AITIN	0.030	■	
N00355	STR440.2-1.000-D1-R030.3-Z4	1	1	1	4	-	-	4	AITIN	0.030		□
N09327	STR440.2-1.000-D1-R060.0-Z4	1	1	1	4	-	-	4	AITIN	0.060	■	
N09329	STR440.2-1.000-D1-R060.3-Z4	1	1	1	4	-	-	4	AITIN	0.060		□
N09333	STR440.2-1.000-D1-R120.0-Z4	1	1	1	4	-	-	4	AITIN	0.120	■	
N09336	STR440.2-1.000-D1-R120.3-Z4	1	1	1	4	-	-	4	AITIN	0.120		□
N09337	STR440.2-1.000-D2-R030.0-Z4	1	1	2	5	-	-	4	AITIN	0.030	■	
N09339	STR440.2-1.000-D2-R030.3-Z4	1	1	2	5	-	-	4	AITIN	0.030		■
N09343	STR440.2-1.000-D2-R060.0-Z4	1	1	2	5	-	-	4	AITIN	0.060	■	
N09346	STR440.2-1.000-D2-R060.3-Z4	1	1	2	5	-	-	4	AITIN	0.060		□
N09347	STR440.2-1.000-D2-R120.0-Z4	1	1	2	5	-	-	4	AITIN	0.120	■	
N09349	STR440.2-1.000-D2-R120.3-Z4	1	1	2	5	-	-	4	AITIN	0.120		□
N09356	STR440.2-1.000-D3-R030.0-Z4	1	1	3	6	-	-	4	AITIN	0.030	■	
N09357	STR440.2-1.000-D3-R030.3-Z4	1	1	3	6	-	-	4	AITIN	0.030		□
N09359	STR440.2-1.000-D3-R060.0-Z4	1	1	3	6	-	-	4	AITIN	0.060	■	
N09363	STR440.2-1.000-D3-R060.3-Z4	1	1	3	6	-	-	4	AITIN	0.060		□
N09366	STR440.2-1.000-D3-R120.0-Z4	1	1	3	6	-	-	4	AITIN	0.120	■	
N09367	STR440.2-1.000-D3-R120.3-Z4	1	1	3	6	-	-	4	AITIN	0.120		□
<b>Metric</b>												
N09636	STR440M.2-030-F2-R250.0-Z4	3	6	6	58	-	-	4	AITIN	0.250	■	
N09637	STR440M.2-030-F3-R250.0-Z4	3	6	9	58	-	-	4	AITIN	0.250	■	
N09645	STR440M.2-040-F2-R250.0-Z4	4	6	8	58	-	-	4	AITIN	0.250	■	
N09646	STR440M.2-040-F3-R250.0-Z4	4	6	12	58	-	-	4	AITIN	0.250	■	
N09647	STR440M.2-050-F2-R250.0-Z4	5	6	10	58	-	-	4	AITIN	0.250	■	
N09648	STR440M.2-050-F3-R250.0-Z4	5	6	15	58	-	-	4	AITIN	0.250	■	
N09649	STR440M.2-060-D2-R500.0-Z4	6	6	12	58	-	-	4	AITIN	0.500	■	
N09650	STR440M.2-060-D3-R500.0-Z4	6	6	18	58	-	-	4	AITIN	0.500	■	
N09651	STR440M.2-080-D2-R500.0-Z4	8	8	16	64	-	-	4	AITIN	0.500	■	
N09652	STR440M.2-080-D3-R500.0-Z4	8	8	24	64	-	-	4	AITIN	0.500	■	
N09653	STR440M.2-100-D2-R500.0-Z4	10	10	20	73	-	-	4	AITIN	0.500	■	
N09654	STR440M.2-100-D3-R500.0-Z4	10	10	30	73	-	-	4	AITIN	0.500	■	
N09655	STR440M.2-120-D2-R750.0-Z4	12	12	24	84	-	-	4	AITIN	0.750	■	
N09665	STR440M.2-120-D3-R750.0-Z4	12	12	36	84	-	-	4	AITIN	0.750	■	
N09667	STR440M.2-160-D2-R750.0-Z4	16	16	32	93	-	-	4	AITIN	0.750	■	
N09668	STR440M.2-160-D3-R750.0-Z4	16	16	48	93	-	-	4	AITIN	0.750	■	
N09670	STR440M.2-200-D2-R750.0-Z4	20	20	40	105	-	-	4	AITIN	0.750	■	
N09671	STR440M.2-200-D3-R750.0-Z4	20	20	60	125	-	-	4	AITIN	0.750	■	
N09672	STR440M.2-250-D2-R750.0-Z4	25	25	50	115	-	-	4	AITIN	0.750	■	
N09673	STR440M.2-250-D3-R750.0-Z4	25	25	75	147	-	-	4	AITIN	0.750	■	
<b>STRN440.2 (NECKED)</b>												
<b>Inch</b>												
N09503	STRN440.2-0.250-E2-R020.0-Z4	1/4	1/4	1/2	2 1/2	0.240	0.750	4	AITIN	0.020	■	
N09504	STRN440.2-0.313-E2-R020.0-Z4	5/16	5/16	5/8	3	0.300	0.938	4	AITIN	0.020	■	
N09505	STRN440.2-0.375-E2-R020.0-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AITIN	0.020	■	
N09506	STRN440.2-0.375-E2-R020.3-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AITIN	0.020		□
N09507	STRN440.2-0.438-E2-R020.0-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AITIN	0.020	■	
N09508	STRN440.2-0.438-E2-R020.3-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AITIN	0.020		□
N09509	STRN440.2-0.500-E2-R030.0-Z4	1/2	1/2	1	3	0.480	1.500	4	AITIN	0.030	■	
N09512	STRN440.2-0.500-E2-R030.3-Z4	1/2	1/2	1	3	0.480	1.500	4	AITIN	0.030		■

□ Quick Response Item. Delivery within 7 days.



# SOLID END MILLING - STABILIZER™ 2.0

## NEW NIAGARA CUTTER STABILIZER 2.0 - STRN440.2 (NECKED, CON'T)



EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	NECK DIA	REACH LENGTH	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
<b>Inch</b>												
N09513	STRN440.2-0.625-E2-R030.0-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	0.030	■	
N09515	STRN440.2-0.625-E2-R030.3-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	0.030		□
N09516	STRN440.2-0.750-E2-R030.0-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	0.030	■	
N09517	STRN440.2-0.750-E2-R030.3-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	0.030		■
N09518	STRN440.2-1.000-E2-R030.0-Z4	1	1	2	5	0.960	3.000	4	AlTiN	0.030	■	
N09519	STRN440.2-1.000-E2-R030.3-Z4	1	1	2	5	0.960	3.000	4	AlTiN	0.030		□

## NEW NIAGARA CUTTER STABILIZER 2.0 - STB440.2 & STBN440.2 (NECKED)



EDP	DESCRIPTION	FLUTE DIA	SHANK DIA	LENGTH OF CUT	OAL	NECK DIA	REACH LENGTH	FLUTES	COATING	RADIUS	CYLINDRICAL	WELDON
<b>Inch</b>												
N09407	STB440.2-0.125-D2-B.0-Z4	1/8	1/8	1/4	1 1/2	-	-	4	AlTiN	-	■	
N09408	STB440.2-0.188-D2-B.0-Z4	3/16	3/16	3/8	2	-	-	4	AlTiN	-	■	
N09409	STB440.2-0.250-D2-B.0-Z4	1/4	1/4	1/2	2 1/2	-	-	4	AlTiN	-	■	
N09422	STB440.2-0.313-D2-B.0-Z4	5/16	5/16	5/8	2 1/2	-	-	4	AlTiN	-	■	
N09423	STB440.2-0.375-D2-B.0-Z4	3/8	3/8	3/4	2 1/2	-	-	4	AlTiN	-	■	
N09426	STB440.2-0.375-D2-B.3-Z4	3/8	3/8	3/4	2 1/2	-	-	4	AlTiN	-		■
N09427	STB440.2-0.438-D2-B.0-Z4	7/16	7/16	7/8	2 3/4	-	-	4	AlTiN	-	■	
N09428	STB440.2-0.438-D2-B.3-Z4	7/16	7/16	7/8	2 3/4	-	-	4	AlTiN	-		□
N09429	STB440.2-0.500-D2-B.0-Z4	1/2	1/2	1	3	-	-	4	AlTiN	-	■	
N09432	STB440.2-0.500-D2-B.3-Z4	1/2	1/2	1	3	-	-	4	AlTiN	-		■
N09433	STB440.2-0.625-D2-B.0-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AlTiN	-	■	
N09442	STB440.2-0.625-D2-B.3-Z4	5/8	5/8	1 1/4	3 1/2	-	-	4	AlTiN	-		□
N09443	STB440.2-0.750-D2-B.0-Z4	3/4	3/4	1 1/2	4	-	-	4	AlTiN	-	■	
N09444	STB440.2-0.750-D2-B.3-Z4	3/4	3/4	1 1/2	4	-	-	4	AlTiN	-		■
N09445	STB440.2-1.000-D2-B.0-Z4	1	1	2	5	-	-	4	AlTiN	-	■	
N09446	STB440.2-1.000-D2-B.3-Z4	1	1	2	5	-	-	4	AlTiN	-		□
<b>Metric</b>												
N09674	STB440M.2-030-F2-B.0-Z4	3	6	6	58	-	-	4	AlTiN	-	■	
N09675	STB440M.2-030-F3-B.0-Z4	3	6	9	58	-	-	4	AlTiN	-	■	
N09676	STB440M.2-040-F2-B.0-Z4	4	6	8	58	-	-	4	AlTiN	-	■	
N09677	STB440M.2-040-F3-B.0-Z4	4	6	12	58	-	-	4	AlTiN	-	■	
N09679	STB440M.2-050-F2-B.0-Z4	5	6	10	58	-	-	4	AlTiN	-	■	
N09680	STB440M.2-050-F3-B.0-Z4	5	6	15	58	-	-	4	AlTiN	-	■	
N09682	STB440M.2-060-D2-B.0-Z4	6	6	12	58	-	-	4	AlTiN	-	■	
N09683	STB440M.2-060-D3-B.0-Z4	6	6	18	58	-	-	4	AlTiN	-	■	
N09684	STB440M.2-080-D2-B.0-Z4	8	8	16	64	-	-	4	AlTiN	-	■	
N09685	STB440M.2-080-D3-B.0-Z4	8	8	24	64	-	-	4	AlTiN	-	■	
N09686	STB440M.2-100-D2-B.0-Z4	10	10	20	73	-	-	4	AlTiN	-	■	
N09687	STB440M.2-100-D3-B.0-Z4	10	10	30	73	-	-	4	AlTiN	-	■	
N09688	STB440M.2-120-D2-B.0-Z4	12	12	24	84	-	-	4	AlTiN	-	■	
N09689	STB440M.2-120-D3-B.0-Z4	12	12	36	84	-	-	4	AlTiN	-	■	
N09690	STB440M.2-160-D2-B.0-Z4	16	16	32	93	-	-	4	AlTiN	-	■	
N09691	STB440M.2-160-D3-B.0-Z4	16	16	48	93	-	-	4	AlTiN	-	■	
N09692	STB440M.2-200-D2-B.0-Z4	20	20	40	105	-	-	4	AlTiN	-	■	
N09693	STB440M.2-200-D3-B.0-Z4	20	20	60	125	-	-	4	AlTiN	-	■	
N09694	STB440M.2-250-D2-B.0-Z4	25	25	50	115	-	-	4	AlTiN	-	■	
N09695	STB440M.2-250-D3-B.0-Z4	25	25	75	147	-	-	4	AlTiN	-	■	
<b>STBN440.2 (NECKED)</b>												
<b>Inch</b>												
N09522	STBN440.2-0.250-E2-B.0-Z4	1/4	1/4	1/2	2 1/2	0.240	0.750	4	AlTiN	-	■	
N09523	STBN440.2-0.313-E2-B.0-Z4	5/16	5/16	5/8	3	0.300	0.938	4	AlTiN	-	■	
N09524	STBN440.2-0.375-E2-B.0-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AlTiN	-	■	
N09525	STBN440.2-0.375-E2-B.3-Z4	3/8	3/8	3/4	3	0.360	1.125	4	AlTiN	-		□
N09526	STBN440.2-0.438-E2-B.0-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AlTiN	-	■	
N09527	STBN440.2-0.438-E2-B.3-Z4	7/16	7/16	7/8	4	0.420	1.313	4	AlTiN	-		□
N09528	STBN440.2-0.500-E2-B.0-Z4	1/2	1/2	1	3	0.480	1.500	4	AlTiN	-	■	
N09529	STBN440.2-0.500-E2-B.3-Z4	1/2	1/2	1	3	0.480	1.500	4	AlTiN	-		■
N09532	STBN440.2-0.625-E2-B.0-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	-	■	
N09533	STBN440.2-0.625-E2-B.3-Z4	5/8	5/8	1 1/4	3 1/2	0.600	1.875	4	AlTiN	-		□
N09534	STBN440.2-0.750-E2-B.0-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	-	■	
N09535	STBN440.2-0.750-E2-B.3-Z4	3/4	3/4	1 1/2	4	0.720	2.250	4	AlTiN	-		■
N09536	STBN440.2-1.000-E2-B.0-Z4	1	1	2	5	0.960	3.000	4	AlTiN	-	■	
N09537	STBN440.2-1.000-E2-B.3-Z4	1	1	2	5	0.960	3.000	4	AlTiN	-		□

□ Quick Response Item. Delivery within 7 days.

## STS430.2, STR430.2, STB430.2 - SLOTTING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)	n [min-1]	SLOTTING													
						Zn = 4													
						1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1
P	E 1 - 2	1.00	1.00	425	n [min-1]	12988	10390	8659	7422	6494	5772	5195	4329	3711	3247	2598	2165	1855	1624
					fz [in]	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.0020	0.0024	0.0028	0.0032	0.0039	0.0047	0.0055	0.0063
					vf [in/min]	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9
	E 3 - 4	1.00	1.00	400	n [min-1]	12224	9779	8149	6985	6112	5433	4890	4075	3493	3056	2445	2037	1746	1528
					fz [in]	0.0007	0.0009	0.0011	0.0012	0.0014	0.0016	0.0018	0.0021	0.0025	0.0029	0.0036	0.0043	0.0050	0.0057
					vf [in/min]	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8	34.8
E 5 - 6	1.00	1.00	350	n [min-1]	10696	8557	7131	6112	5348	4754	4278	3565	3056	2674	2139	1783	1528	1337	
				fz [in]	0.0006	0.0008	0.0009	0.0011	0.0013	0.0014	0.0016	0.0019	0.0022	0.0025	0.0031	0.0038	0.0044	0.0050	
				vf [in/min]	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7
K	E 12 - 13	1.00	1.00	350	n [min-1]	10696	8557	7131	6112	5348	4754	4278	3565	3056	2674	2139	1783	1528	1337
					fz [in]	0.0007	0.0009	0.0010	0.0012	0.0014	0.0015	0.0017	0.0021	0.0024	0.0028	0.0034	0.0041	0.0048	0.0055
					vf [in/min]	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4	29.4
	E 14 - 15	1.00	1.00	325	n [min-1]	9932	7946	6621	5675	4966	4414	3973	3311	2838	2483	1986	1655	1419	1242
					fz [in]	0.0006	0.0007	0.0008	0.0010	0.0011	0.0013	0.0014	0.0017	0.0020	0.0023	0.0028	0.0034	0.0039	0.0045
					vf [in/min]	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3
E 18	1.00	1.00	500	n [min-1]	15280	12224	10187	8731	7640	6791	6112	5093	4366	3820	3056	2547	2183	1910	
				fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0011	0.0013	0.0015	0.0018	0.0020	0.0025	0.0030	0.0035	0.0040	
				vf [in/min]	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6	30.6

## STS430.2, STR430.2, STB430.2 - SIDE MILLING/ROUGHING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)	n [min-1]	SIDE MILLING ROUGHING													
						Zn = 4													
						1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1
P	E 1 - 2	1.50	0.25	425	n [min-1]	12988	10390	8659	7422	6494	5772	5195	4329	3711	3247	2598	2165	1855	1624
					fz [in]	0.0009	0.0011	0.0013	0.0015	0.0018	0.0020	0.0022	0.0026	0.0031	0.0035	0.0044	0.0053	0.0061	0.0070
					vf [in/min]	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5	45.5
	E 3 - 4	1.50	0.25	400	n [min-1]	12224	9779	8149	6985	6112	5433	4890	4075	3493	3056	2445	2037	1746	1528
					fz [in]	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.0020	0.0024	0.0028	0.0032	0.0040	0.0048	0.0056	0.0064
					vf [in/min]	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1	39.1
E 5 - 6	1.00	0.25	350	n [min-1]	10696	8557	7131	6112	5348	4754	4278	3565	3056	2674	2139	1783	1528	1337	
				fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0053	0.0060	
				vf [in/min]	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1
K	E 12 - 13	1.50	0.25	350	n [min-1]	10696	8557	7131	6112	5348	4754	4278	3565	3056	2674	2139	1783	1528	1337
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0053	0.0060
					vf [in/min]	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1	32.1
	E 14 - 15	1.00	0.25	325	n [min-1]	9932	7946	6621	5675	4966	4414	3973	3311	2838	2483	1986	1655	1419	1242
					fz [in]	0.0006	0.0008	0.0009	0.0011	0.0013	0.0014	0.0016	0.0019	0.0022	0.0025	0.0031	0.0038	0.0044	0.0050
					vf [in/min]	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8	24.8
E 18	1.50	0.25	500	n [min-1]	15280	12224	10187	8731	7640	6791	6112	5093	4366	3820	3056	2547	2183	1910	
				fz [in]	0.0006	0.0007	0.0008	0.0010	0.0011	0.0012	0.0014	0.0017	0.0019	0.0022	0.0028	0.0033	0.0039	0.0044	
				vf [in/min]	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6	33.6

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

v<sub>c</sub> (sf/min) = Surface feet/min

a<sub>p</sub>/D<sub>c</sub> = % of diameter

a<sub>e</sub>/D<sub>c</sub> = % of diameter

All cutting data are start values

All cutting data is in inch values

## STS430.2, STR430.2, STB430.2 - SLOTTING - METRIC

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)	SLOTTING											
					Zn = 4											
					3	4	5	6	8	10	12	14	16	20	25	
P	E 1 - 2	1.00	1.00	425	n [min-1]	13790	10350	8280	6900	5170	4140	3450	2960	2590	2070	1660
					fz [in]	0.0007	0.0010	0.0012	0.0015	0.0020	0.0025	0.0030	0.0035	0.0040	0.0050	0.0062
					vf [in/min]	41.0	41.1	41.1	41.1	41.0	41.1	41.1	41.1	41.1	41.1	41.1
	E 3 - 4	1.00	1.00	400	n [min-1]	12940	9710	7770	6470	4850	3880	3240	2770	2430	1940	1550
					fz [in]	0.0007	0.0009	0.0011	0.0013	0.0018	0.0022	0.0027	0.0031	0.0036	0.0045	0.0056
					vf [in/min]	34.8	34.9	34.9	34.8	34.8	34.8	34.9	34.8	34.9	34.8	34.9
	E 5 - 6	1.00	1.00	350	n [min-1]	11350	8510	6810	5680	4260	3410	2840	2430	2130	1700	1360
					fz [in]	0.0006	0.0008	0.0010	0.0012	0.0016	0.0020	0.0024	0.0028	0.0031	0.0039	0.0049
					vf [in/min]	26.8	26.8	26.8	26.8	26.8	26.9	26.8	26.8	26.8	26.8	26.8
K	E 12 - 13	1.00	1.00	350	n [min-1]	11350	8510	6810	5680	4260	3410	2840	2430	2130	1700	1360
					fz [in]	0.0006	0.0009	0.0011	0.0013	0.0017	0.0022	0.0026	0.0030	0.0035	0.0043	0.0054
					vf [in/min]	29.5	29.5	29.5	29.5	29.5	29.5	29.5	29.5	29.5	29.5	29.4
	E 14 - 15	1.00	1.00	325	n [min-1]	10500	7880	6300	5250	3940	3150	2630	2250	1970	1580	1260
					fz [in]	0.0005	0.0007	0.0009	0.0011	0.0014	0.0018	0.0021	0.0025	0.0028	0.0035	0.0044
					vf [in/min]	22.3	22.3	22.3	22.3	22.3	22.3	22.4	22.3	22.3	22.4	22.3
E	18	1.00	1.00	500	n [min-1]	16130	12100	9680	8060	6050	4840	4030	3460	3020	2420	1940
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0013	0.0016	0.0019	0.0022	0.0025	0.0031	0.0039
					vf [in/min]	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.4	30.5

## STS430.2, STR430.2, STB430.2 - SIDE MILLING/ROUGHING - METRIC

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)	SIDE MILLING ROUGHING											
					Zn = 4											
					3	4	5	6	8	10	12	14	16	20	25	
P	E 1 - 2	1.50	0.25	425	n [min-1]	13790	10350	8280	6900	5170	4140	3450	2960	2590	2070	1660
					fz [in]	0.0008	0.0011	0.0014	0.0017	0.0022	0.0028	0.0033	0.0039	0.0044	0.0055	0.0069
					vf [in/min]	45.6	45.6	45.6	45.6	45.6	45.6	45.6	45.7	45.7	45.7	45.6
	E 3 - 4	1.50	0.25	400	n [min-1]	12940	9710	7770	6470	4850	3880	3240	2770	2430	1940	1550
					fz [in]	0.0008	0.0010	0.0013	0.0015	0.0020	0.0025	0.0030	0.0035	0.0040	0.0050	0.0063
					vf [in/min]	39.1	39.1	39.2	39.1	39.1	39.1	39.2	39.1	39.2	39.1	39.2
	E 5 - 6	1.00	0.25	350	n [min-1]	11350	8510	6810	5680	4260	3410	2840	2430	2130	1700	1360
					fz [in]	0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059
					vf [in/min]	32.2	32.2	32.2	32.2	32.2	32.2	32.2	32.1	32.2	32.1	32.2
K	E 12 - 13	1.50	0.25	350	n [min-1]	11350	8510	6810	5680	4260	3410	2840	2430	2130	1700	1360
					fz [in]	0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059
					vf [in/min]	32.2	32.2	32.2	32.2	32.2	32.2	32.2	32.1	32.2	32.1	32.2
	E 14 - 15	1.00	0.25	325	n [min-1]	10500	7880	6300	5250	3940	3150	2630	2250	1970	1580	1260
					fz [in]	0.0006	0.0008	0.0010	0.0012	0.0016	0.0020	0.0024	0.0028	0.0031	0.0039	0.0049
					vf [in/min]	24.8	24.8	24.8	24.8	24.8	24.8	24.9	24.8	24.8	24.9	24.8
E	18	1.50	0.25	500	n [min-1]	16130	12100	9680	8060	6050	4840	4030	3460	3020	2420	1940
					fz [in]	0.0005	0.0007	0.0009	0.0010	0.0014	0.0017	0.0021	0.0024	0.0028	0.0035	0.0043
					vf [in/min]	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.6	33.5	33.5

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

v<sub>c</sub> (sf/min) = Surface feet/min

a<sub>p</sub>/D<sub>c</sub> = % of diameter

a<sub>e</sub>/D<sub>c</sub> = % of diameter

All cutting data are start values

All cutting data is in inch values

## STRN430.2, STBN430.2 - SLOTTING - INCH

ISO GROUP	SMG	$a_p \times D_c$	$a_e \times D_c$	$v_c$ (sf / min)	SLOTTING								
					Zn = 4								
					1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P	E 1 - 2	0.50	1.00	425	n [min-1]	6494	5195	4329	3711	3247	2598	2165	1624
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0019	0.0023	0.0030
	E 3 - 4	0.50	1.00	400	n [min-1]	6112	4890	4075	3493	3056	2445	2037	1528
					fz [in]	0.0006	0.0008	0.0009	0.0011	0.0013	0.0016	0.0019	0.0025
	E 5 - 6	0.50	1.00	350	n [min-1]	5348	4278	3565	3056	2674	2139	1783	1337
					fz [in]	0.0006	0.0007	0.0009	0.0010	0.0012	0.0014	0.0017	0.0023
K	E 12 - 13	0.50	1.00	350	n [min-1]	5348	4278	3565	3056	2674	2139	1783	1337
					fz [in]	0.0010	0.0013	0.0015	0.0018	0.0020	0.0025	0.0030	0.0040
E	18	0.50	1.00	400	n [min-1]	7640	6112	5093	4366	3820	3056	2547	1910
					fz [in]	0.0006	0.0008	0.0009	0.0011	0.0013	0.0016	0.0019	0.0025

## STRN430.2, STBN430.2 - SIDE MILLING ROUGHING - INCH

ISO GROUP	SMG	$a_p \times D_c$	$a_e \times D_c$	$v_c$ (sf / min)	SIDE MILLING ROUGHING								
					Zn = 4								
					1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P	E 1 - 2	1.00	0.25	425	n [min-1]	6494	5195	4329	3711	3247	2598	2165	1624
					fz [in]	0.0009	0.0011	0.0013	0.0015	0.0018	0.0022	0.0026	0.0035
	E 3 - 4	1.00	0.25	400	n [min-1]	6112	4890	4075	3493	3056	2445	2037	1528
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0019	0.0023	0.0030
	E 5 - 6	1.00	0.25	350	n [min-1]	5348	4278	3565	3056	2674	2139	1783	1337
					fz [in]	0.0007	0.0009	0.0011	0.0012	0.0014	0.0018	0.0021	0.0028
K	E 12 - 13	1.00	0.25	350	n [min-1]	5348	4278	3565	3056	2674	2139	1783	1337
					fz [in]	0.0011	0.0014	0.0017	0.0020	0.0023	0.0028	0.0034	0.0045
E	18	1.00	0.25	400	n [min-1]	7640	6112	5093	4366	3820	3056	2547	1910
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0019	0.0023	0.0030

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

$v_c$  (sf/min) = Surface feet/min

$a_p/D_c$  = % of diameter

$a_e/D_c$  = % of diameter

All cutting data are start values

All cutting data is in inch values

## STR440.2 - STB440.2 - SLOTTING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)		SLOTTING												
						Zn = 4												
						1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	1
M	E 8 - 9	1.00	1.00	370	n [min-1]	11307	9046	7538	6461	5654	5025	4523	3769	3231	2827	2261	1885	1413
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0060
					vf [in/min]	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9
	E 10 - 11	1.00	1.00	300	n [min-1]	9168	7334	6112	5239	4584	4075	3667	3056	2619	2292	1834	1528	1146
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0060
					vf [in/min]	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5
S	E 19	1.00	1.00	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0010	0.0012	0.0014	0.0016	0.0020	0.0024	0.0032
					vf [in/min]	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4
	E 20	1.00	1.00	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0010	0.0012	0.0014	0.0016	0.0020	0.0024	0.0032
					vf [in/min]	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4
	E 21	1.00	1.00	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0010	0.0012	0.0014	0.0016	0.0020	0.0024	0.0032
					vf [in/min]	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4	4.4
	E 22	1.00	1.00	185	n [min-1]	5654	4523	3769	3231	2827	2513	2261	1885	1615	1413	1131	942	707
					fz [in]	0.0006	0.0008	0.0009	0.0011	0.0013	0.0014	0.0016	0.0019	0.0022	0.0025	0.0031	0.0038	0.0050
					vf [in/min]	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1	14.1

## STR440.2 - STB440.2 - SIDE MILLING/ROUGHING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)		SIDE MILLING ROUGHING												
						Zn = 4												
						1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	1
H	E 7	1.00	0.15	150	n [min-1]	4584	3667	3056	2619	2292	2037	1834	1528	1310	1146	917	764	573
					fz [in]	0.0003	0.0004	0.0004	0.0005	0.0006	0.0006	0.0007	0.0009	0.0010	0.0012	0.0014	0.0017	0.0023
M	E 8 - 9	1.00	0.25	370	n [min-1]	11307	9046	7538	6461	5654	5025	4523	3769	3231	2827	2261	1885	1413
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0060
					vf [in/min]	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9	33.9
	E 10 - 11	1.00	0.25	300	n [min-1]	9168	7334	6112	5239	4584	4075	3667	3056	2619	2292	1834	1528	1146
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0060
					vf [in/min]	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5	27.5
S	E 19	1.00	0.15	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0011	0.0013	0.0015	0.0018	0.0020	0.0025	0.0030	0.0040
					vf [in/min]	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5
	E 20	1.00	0.15	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0011	0.0013	0.0015	0.0018	0.0020	0.0025	0.0030	0.0040
					vf [in/min]	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5
	E 21	1.00	0.15	90	n [min-1]	2750	2200	1834	1572	1375	1222	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0011	0.0013	0.0015	0.0018	0.0020	0.0025	0.0030	0.0040
					vf [in/min]	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5	5.5
	E 22	1.00	0.25	185	n [min-1]	5654	4523	3769	3231	2827	2513	2261	1885	1615	1413	1131	942	707
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0023	0.0026	0.0030	0.0038	0.0045	0.0060
					vf [in/min]	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

v<sub>c</sub> (sf/min) = Surface feet/min

a<sub>p</sub>/D<sub>c</sub> = % of diameter

a<sub>e</sub>/D<sub>c</sub> = % of diameter

All cutting data are start values

All cutting data is in inch values



## STR440.2 - STB440.2 - SLOTTING - METRIC

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>g</sub> x D <sub>c</sub>	SLOTTING												
				v <sub>c</sub> (sf / min)	n [min-1]	Zn = 4										
						3	4	5	6	8	10	12	14	16	20	25
M	E 8 - 9	1.00	1.00	370	n [min-1]	11990	8990	7190	5990	4500	3600	3000	2570	2250	1800	1440
				fz [in]	0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059	
	270 - 470	vf [in/min]	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0
	E 10 - 11	1.00	1.00	300	n [min-1]	9660	7240	5790	4830	3620	2900	2410	2070	1810	1450	1160
fz [in]				0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059		
S	E 19	1.00	1.00	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0004	0.0005	0.0006	0.0008	0.0010	0.0013	0.0015	0.0018	0.0020	0.0025	0.0031	
	70 - 110	vf [in/min]	4.3	4.3	4.3	4.3	4.3	4.3	4.3	4.4	4.3	4.4	4.3	4.3		
	E 20	1.00	1.00	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0004	0.0005	0.0006	0.0008	0.0010	0.0013	0.0015	0.0018	0.0020	0.0025	0.0031	
	70 - 110	vf [in/min]	4.3	4.3	4.3	4.3	4.3	4.3	4.3	4.4	4.3	4.4	4.3	4.3		
	E 21	1.00	1.00	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0004	0.0005	0.0006	0.0008	0.0010	0.0013	0.0015	0.0018	0.0020	0.0025	0.0031	
	70 - 110	vf [in/min]	4.3	4.3	4.3	4.3	4.3	4.3	4.3	4.4	4.3	4.4	4.3	4.3		
	E 22	1.00	1.00	185	n [min-1]	5940	4460	3570	2970	2230	1780	1490	1270	1110	890	710
				fz [in]	0.0006	0.0008	0.0010	0.0012	0.0016	0.0020	0.0024	0.0028	0.0031	0.0039	0.0049	
	165 - 205	vf [in/min]	14.0	14.0	14.1	14.0	14.0	14.0	14.0	14.1	14.0	14.0	14.0	14.0	14.0	

## STR440.2 - STB440.2 - SIDE MILLING/ROUGHING - METRIC

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>g</sub> x D <sub>c</sub>	SIDE MILLING ROUGHING												
				v <sub>c</sub> (sf / min)	n [min-1]	Zn = 4										
						3	4	5	6	8	10	12	14	16	20	25
H	E 7	1.00	0.15	150	n [min-1]	4880	3660	2930	2440	1830	1460	1220	1050	920	730	590
				fz [in]	0.0003	0.0004	0.0005	0.0005	0.0007	0.0009	0.0011	0.0013	0.0014	0.0018	0.0023	
M	E 8 - 9	1.00	0.25	370	n [min-1]	11990	8990	7190	5990	4500	3600	3000	2570	2250	1800	1440
				fz [in]	0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059	
	270 - 470	vf [in/min]	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	34.0	
	E 10 - 11	1.00	0.25	300	n [min-1]	9660	7240	5790	4830	3620	2900	2410	2070	1810	1450	1160
fz [in]				0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059		
S	E 19	1.00	0.15	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0005	0.0006	0.0008	0.0009	0.0013	0.0016	0.0019	0.0022	0.0025	0.0031	0.0039	
	70 - 110	vf [in/min]	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4		
	E 20	1.00	0.15	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0005	0.0006	0.0008	0.0009	0.0013	0.0016	0.0019	0.0022	0.0025	0.0031	0.0039	
	70 - 110	vf [in/min]	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4		
	E 21	1.00	0.15	90	n [min-1]	2860	2150	1720	1430	1070	860	720	610	540	430	340
				fz [in]	0.0005	0.0006	0.0008	0.0009	0.0013	0.0016	0.0019	0.0022	0.0025	0.0031	0.0039	
	70 - 110	vf [in/min]	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4	5.4		
	E 22	1.00	0.25	185	n [min-1]	5940	4460	3570	2970	2230	1780	1490	1270	1110	890	710
				fz [in]	0.0007	0.0009	0.0012	0.0014	0.0019	0.0024	0.0028	0.0033	0.0038	0.0047	0.0059	
	165 - 205	vf [in/min]	16.8	16.9	16.9	16.8	16.9	16.8	16.9	16.8	16.9	16.8	16.8	16.8	16.8	

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

v<sub>c</sub> (sf/min) = Surface feet/min

a<sub>p</sub>/D<sub>c</sub> = % of diameter

a<sub>g</sub>/D<sub>c</sub> = % of diameter

All cutting data are start values

All cutting data is in inch values

## STRN440.2 - STBN440.2 - SLOTTING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)		Zn = 4							
						1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
						n [min-1]	fz [in]	vf [in/min]	n [min-1]	fz [in]	vf [in/min]	n [min-1]	fz [in]
M	E 8 - 9	0.50	1.00	370	n [min-1]	5654	4523	3769	3231	2827	2261	1885	1413
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0019	0.0023	0.0030
					vf [in/min]	17.0	17.0	17.0	17.0	17.0	17.0	17.0	17.0
	E 10 - 11	0.50	1.00	300	n [min-1]	4584	3667	3056	2619	2292	1834	1528	1146
					fz [in]	0.0008	0.0009	0.0011	0.0013	0.0015	0.0019	0.0023	0.0030
					vf [in/min]	13.8	13.8	13.8	13.8	13.8	13.8	13.8	13.8
S	E 19	0.50	1.00	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0011	0.0015
	E 20	0.50	1.00	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0011	0.0015
	E 21	0.50	1.00	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0004	0.0005	0.0006	0.0007	0.0008	0.0009	0.0011	0.0015
	E 22	0.50	1.00	185	n [min-1]	2827	2261	1885	1615	1413	1131	942	707
					fz [in]	0.0006	0.0008	0.0009	0.0011	0.0012	0.0015	0.0018	0.0024
					vf [in/min]	6.8	6.8	6.8	6.8	6.8	6.8	6.8	6.8
					165 - 205	vf [in/min]	6.8	6.8	6.8	6.8	6.8	6.8	6.8

## STRN440.2 - STBN440.2 - SIDE MILLING/ROUGHING - INCH

ISO GROUP	SMG	a <sub>p</sub> x D <sub>c</sub>	a <sub>e</sub> x D <sub>c</sub>	v <sub>c</sub> (sf / min)		Zn = 4							
						1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
						n [min-1]	fz [in]	vf [in/min]	n [min-1]	fz [in]	vf [in/min]	n [min-1]	fz [in]
H	E 7	1.00	0.15	150	n [min-1]	2292	1834	1528	1310	1146	917	764	573
					fz [in]	0.0003	0.0004	0.0005	0.0006	0.0006	0.0008	0.0010	0.0013
					vf [in/min]	2.93	2.9	2.9	2.9	2.9	2.9	2.9	2.9
M	E 8 - 9	1.00	0.25	370	n [min-1]	5654	4523	3769	3231	2827	2261	1885	1413
					fz [in]	0.0008	0.0010	0.0012	0.0014	0.0016	0.0020	0.0024	0.0032
					vf [in/min]	18.1	18.1	18.1	18.1	18.1	18.1	18.1	18.1
	E 10 - 11	1.00	0.25	300	n [min-1]	4584	3667	3056	2619	2292	1834	1528	1146
					fz [in]	0.0008	0.0010	0.0012	0.0014	0.0016	0.0020	0.0024	0.0032
					vf [in/min]	14.7	14.7	14.7	14.7	14.7	14.7	14.7	14.7
S	E 19	1.00	0.15	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0013	0.0015	0.0020
	E 20	1.00	0.15	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0013	0.0015	0.0020
	E 21	1.00	0.15	90	n [min-1]	1375	1100	917	786	688	550	458	344
					fz [in]	0.0005	0.0006	0.0008	0.0009	0.0010	0.0013	0.0015	0.0020
	E 22	1.00	0.25	185	n [min-1]	2827	2261	1885	1615	1413	1131	942	707
					fz [in]	0.0007	0.0008	0.0010	0.0011	0.0013	0.0016	0.0020	0.0026
					vf [in/min]	7.3	7.3	7.3	7.3	7.3	7.3	7.3	7.3
					165 - 205	vf [in/min]	7.3	7.3	7.3	7.3	7.3	7.3	7.3

SMG = Seco Material Group

n [min-1] = RPM

fz [in] = Feed/tooth

vf [in/min] = Feed rate

v<sub>c</sub> (sf/min) = Surface feet/min

a<sub>p</sub>/D<sub>c</sub> = % of diameter

a<sub>e</sub>/D<sub>c</sub> = % of diameter

All cutting data are start values

All cutting data is in inch values

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