

STABILIZER™ HT STR440
SOLID CARBIDE END MILLS



Niagara Cutter

STR440: SOLID CARBIDE, 4 FLUTE WITH RADIUS



STR440

- US Patent # 6,991,409
- Eccentric Primary Relief
- Asymmetrical Flute Geometry
- Weldon Flat Standard on Shank Sizes 3/8" and Larger



Stainless Steel, High Temperature Alloys

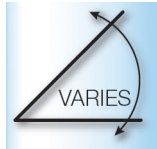
Nickel Based Alloys, Titanium and Titanium Alloys

Price Code E

Flute Dia	Shank Dia	Length of Cut	Overall Length	Radius	No. of Flutes	AlCrN EDP #	AlTiN EDP #
1/8	1/8	1/8	1-1/2	0.010	4	68444	57453
1/8	1/8	3/8	1-1/2	0.010	4	68445	57454
5/32	3/16	3/16	2	0.010	4	68446	57455
5/32	3/16	7/16	2	0.010	4	68447	57456
3/16	3/16	3/16	2	0.010	4	68448	57457
3/16	3/16	7/16	2	0.010	4	68449	57458
7/32	1/4	1/4	2	0.020	4	68450	57459
1/4	1/4	1/4	2	0.020	4	68452	57461
1/4	1/4	1/2	2-1/2	0.020	4	68453	57462
9/32	5/16	5/8	2-1/2	0.020	4	68454	57463
5/16	5/16	5/16	2	0.020	4	68455	57464
5/16	5/16	13/16	2-1/2	0.020	4	68456	57465
3/8	3/8	3/8	2	0.020	4	68458	57467
3/8	3/8	7/8	2-1/2	0.020	4	68459	57468
7/16	7/16	1	2-3/4	0.020	4	68462	57471
1/2	1/2	1/2	2-1/2	0.030	4	68464	57473
1/2	1/2	1	3	0.030	4	68465	57474
1/2	1/2	1-1/4	3	0.030	4	68466	57475
5/8	5/8	5/8	3	0.030	4	68468	57477
5/8	5/8	1-1/4	3-1/2	0.030	4	68469	57478
3/4	3/4	3/4	3	0.030	4	68471	57480
3/4	3/4	1-1/2	4	0.030	4	68472	57481
1	1	1	4	0.030	4	68476	57485
1	1	1-1/2	4	0.030	4	68477	57486
1	1	2	5	0.030	4	68478	57487

SOLID CARBIDE

**AlCrN
AlTiN
COATED**



4 Flutes



Center Cutting

Material	SFPM	STABILIZER Recommended Starting Point Speed and Feeds for Slotting														
		1/4" Diameter			3/8" Diameter			1/2" Diameter			3/4" Diameter			1" Diameter		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Inconel																
625	135	2063	0.0006	5.0	1375	0.0009	5.0	1031	0.0012	5.0	688	0.0015	4.1	516	0.0018	3.7
718	90	1375	0.0005	2.8	917	0.0008	2.8	688	0.0010	2.8	458	0.0013	2.3	344	0.0015	2.1
Other Nickel Based																
Waspalloy / Hastelloy	90	1375	0.0005	2.8	917	0.0008	2.8	688	0.0010	2.8	458	0.0013	2.3	344	0.0015	2.1
A-286	110	1681	0.0005	3.4	1121	0.0008	3.4	840	0.0010	3.4	560	0.0013	2.8	420	0.0015	2.5
Titanium																
6AL-4V / Comm. Pure	275	4202	0.0008	12.6	2801	0.0011	12.6	2101	0.0015	12.6	1401	0.0019	10.5	1051	0.0023	9.5
Stainless Steel																
303, 304 & 316	400	6112	0.0009	20.8	4075	0.0013	20.8	3056	0.0017	20.8	2037	0.0021	17.3	1528	0.0026	15.6
15/5, 17/4 & 416	350	5348	0.0009	18.2	3565	0.0013	18.2	2674	0.0017	18.2	1783	0.0021	15.2	1337	0.0026	13.6
Kovar / Invar	225	3438	0.0009	11.7	2292	0.0013	11.7	1719	0.0017	11.7	1146	0.0021	9.7	860	0.0026	8.8

Speeds and Feeds are based upon: ADOC = 1 x Diameter, RDOC = 1 x Diameter

For Profiling with 25% of the tool diameter increase speed by 25% and feed by 15%

STR440: SOLID CARBIDE, 4 FLUTE WITH AEROSPACE RADIUS



NEW STR440

- Cylindrical Shank
- US Patent # 6,991,409
- Eccentric Primary Relief
- Asymmetrical Flute Geometry



Profiling, Roughing, Slotting

Stainless Steels, High Temperature Alloys

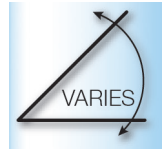
Nickel Based Alloys, Titanium and Titanium Alloys

Price Code E

Flute Dia	Shank Dia	Length of Cut	Overall Length	Corner Radius	No. of Flutes	AlTiN EDP #
3/16	3/16	7/16	2	0.030	4	57011
1/4	1/4	1/2	2-1/2	0.015	4	57012
1/4	1/4	1/2	2-1/2	0.030	4	57013
1/4	1/4	1/2	2-1/2	0.060	4	57014
3/8	3/8	7/8	2-1/2	0.020	4	57015
3/8	3/8	7/8	2-1/2	0.030	4	57016
3/8	3/8	7/8	2-1/2	0.060	4	57017
3/8	3/8	7/8	2-1/2	0.090	4	57018
1/2	1/2	1-1/4	3	0.015	4	57019
1/2	1/2	1-1/4	3	0.030	4	57020
1/2	1/2	1-1/4	3	0.060	4	57021
1/2	1/2	1-1/4	3	0.090	4	57022
1/2	1/2	1-1/4	3	0.120	4	57023
5/8	5/8	1-1/4	3-1/2	0.030	4	57024
5/8	5/8	1-1/4	3-1/2	0.060	4	57025
5/8	5/8	1-1/4	3-1/2	0.090	4	57026
5/8	5/8	1-1/4	3-1/2	0.120	4	57027
5/8	5/8	1-1/4	3-1/2	0.190	4	57028
3/4	3/4	1-1/2	4	0.030	4	57029
3/4	3/4	1-1/2	4	0.060	4	57030
3/4	3/4	1-1/2	4	0.090	4	57031
3/4	3/4	1-1/2	4	0.120	4	57032
3/4	3/4	1-1/2	4	0.190	4	57033
1	1	2	5	0.030	4	57034
1	1	2	5	0.060	4	57035
1	1	2	5	0.090	4	57036
1	1	2	5	0.120	4	57037
1	1	2	5	0.190	4	57038
1	1	2	5	0.250	4	57039

SOLID CARBIDE

AlTiN COATED



4 Flutes



Center Cutting

STABILIZER Recommended Starting Point Speed and Feeds for Profiling																
Material	SFPM	1/4" Diameter			3/8" Diameter			1/2" Diameter			3/4" Diameter			1" Diameter		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Inconel																
625	155	2372	0.0008	7.1	1581	0.0011	7.1	1186	0.0015	7.1	791	0.0019	5.9	593	0.0023	5.3
718	104	1581	0.0006	4.0	1054	0.0009	4.0	791	0.0013	4.0	527	0.0016	3.3	395	0.0019	3.0
Other Nickel Based																
Waspalloy / Hastelloy	104	1581	0.0006	4.0	1054	0.0009	4.0	791	0.0013	4.0	527	0.0016	3.3	395	0.0019	3.0
A-286	127	1933	0.0006	4.8	1289	0.0009	4.8	966	0.0013	4.8	644	0.0016	4.0	483	0.0019	3.6
Titanium																
6AL-4V / Comm. Pure	316	4832	0.0009	18.1	3222	0.0014	18.1	2416	0.0019	18.1	1611	0.0023	15.1	1208	0.0028	13.6
Stainless Steel																
303, 304 & 316	460	7029	0.0011	29.9	4686	0.0016	29.9	3514	0.0021	29.9	2343	0.0027	24.9	1757	0.0032	22.4
15/5, 17/4 & 416	403	6150	0.0011	26.1	4100	0.0016	26.1	3075	0.0021	26.1	2050	0.0027	21.8	1538	0.0032	19.6
Kovar / Invar	259	3954	0.0011	16.8	2636	0.0016	16.8	1977	0.0021	16.8	1318	0.0027	14.0	988	0.0032	12.6

Speeds and Feeds are based upon: ADOC = 1 x Diameter, RDOC = 0.25 x Diameter



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For customer service, call:
1-248-528-5220

For technical assistance, call:
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SECO TOOLS, LLC
North American Headquarters
2805 Bellingham Drive
Troy, MI 48083
248-528-5200

SECOTOOLS.COM/US
customerservice.us@secotools.com

NIAGARA CUTTER, LLC
North American Production Unit
150 South Fifth Street
Reynoldsville, PA 15851-0279
814-653-8211

NIAGARACUTTER.COM

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