



Niagara Cutter

5 Flute Stabilizer™ End

Mill for High Performance

Milling Applications

- U.S. Patent # 6,991,409
- Unique individual variable flute geometry to eliminate chatter
- Increased feedrates by a minimum of 20% as compared to 4 flute end mills
- Effective in Steels, Stainless Steels, & High Temp Alloys
- AlCrN coated for highest hot hardness and abrasive wear resistance
- Corner radius options and Weldon flat available through Niagara Cutter *JIF* program for **JUST IN TIME** delivery



Price Code E					STS540 Square Corner		STS540 Square Corner	
Flute Dia	Shank Dia	LOC	OAL	# F	Uncoated		AlCrN	
					EDP	List	EDP	List
1/4	1/4	3/4	2 1/2	5	68618	\$24.45	68625	\$27.38
5/16	5/16	3/4	2 1/2	5	68619	\$30.63	68626	\$34.30
3/8	3/8	7/8	2 1/2	5	68620	\$38.00	68627	\$42.56
1/2	1/2	1 1/4	3	5	68621	\$63.99	68628	\$71.67
5/8	5/8	1 1/4	3 1/2	5	68622	\$123.26	68629	\$138.05
3/4	3/4	1 1/2	4	5	68623	\$159.60	68630	\$178.75
1	1	1 3/4	4	5	68624	\$253.99	68631	\$284.47

Price Code E					STR540 (with corner radius)					
Flute Dia	Shank Dia	LOC	OAL	# F	0.015"		0.030"		0.045"	
					AlCrN EDP	List	AlCrN EDP	List	AlCrN EDP	List
1/4	1/4	3/4	2 1/2	5	68632	\$28.62	68639	\$28.62	68646	\$28.62
5/16	5/16	3/4	2 1/2	5	68633	\$35.91	68640	\$35.91	68647	\$35.91
3/8	3/8	7/8	2 1/2	5	68634	\$44.53	68641	\$44.53	68648	\$44.53
1/2	1/2	1 1/4	3	5	68635	\$74.64	68642	\$74.64	68649	\$74.64
5/8	5/8	1 1/4	3 1/2	5	68636	\$144.33	68643	\$144.33	68650	\$144.33
3/4	3/4	1 1/2	4	5	68637	\$186.89	68644	\$186.89	68651	\$186.89
1	1	1 3/4	4	5	68638	\$297.31	68645	\$297.31	68652	\$297.31

Price Code E					STR540 (with corner radius)					
Flute Dia	Shank Dia	LOC	OAL	# F	0.060"		0.090"		0.125"	
					AlCrN EDP	List	AlCrN EDP	List	AlCrN EDP	List
1/2	1/2	1 1/4	3	5	68653	\$74.64	68657	\$74.64	68661	\$74.64
5/8	5/8	1 1/4	3 1/2	5	68654	\$144.33	68658	\$144.33	68662	\$144.33
3/4	3/4	1 1/2	4	5	68655	\$186.89	68659	\$186.89	68663	\$186.89
1	1	1 3/4	4	5	68656	\$297.31	68660	\$297.31	68664	\$297.31



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STR540 Recommended Starting Point Speed and Feeds (Profiling)

Material	SFM	Diameter = 1/4			Diameter = 3/8			Diameter = 1/2			Diameter = 3/4			Diameter = 1		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Inconel																
625	140	2139	0.0009	9.6	1426	0.0014	9.6	1070	0.0018	9.6	713	0.0023	8.0	535	0.0027	7.2
718	100	1528	0.0008	5.7	1019	0.0011	5.7	764	0.0015	5.7	509	0.0019	4.8	382	0.0023	4.3
Other Nickel Based																
Waspalloy	105	1604	0.0008	6.0	1070	0.0011	6.0	802	0.0015	6.0	535	0.0019	5.0	401	0.0023	4.5
Hastelloy	105	1604	0.0008	6.0	1070	0.0011	6.0	802	0.0015	6.0	535	0.0019	5.0	401	0.0023	4.5
A-286	125	1910	0.0008	7.2	1273	0.0011	7.2	955	0.0015	7.2	637	0.0019	6.0	478	0.0023	5.4
Titanium																
6AL-4V / Comm. Pure	300	4584	0.0011	25.8	3056	0.0017	25.8	2292	0.0023	25.8	1528	0.0028	21.5	1146	0.0034	19.3
Stainless Steel																
303	425	6494	0.0013	41.4	4329	0.0019	41.4	3247	0.0026	41.4	2165	0.0032	34.5	1624	0.0038	31.0
304	425	6494	0.0013	41.4	4329	0.0019	41.4	3247	0.0026	41.4	2165	0.0032	34.5	1624	0.0038	31.0
316	425	6494	0.0013	41.4	4329	0.0019	41.4	3247	0.0026	41.4	2165	0.0032	34.5	1624	0.0038	31.0
15/5	400	6112	0.0013	39.0	4075	0.0019	39.0	3056	0.0026	39.0	2037	0.0032	32.5	1528	0.0038	29.2
17/4	400	6112	0.0013	39.0	4075	0.0019	39.0	3056	0.0026	39.0	2037	0.0032	32.5	1528	0.0038	29.2
416	400	6112	0.0013	39.0	4075	0.0019	39.0	3056	0.0026	39.0	2037	0.0032	32.5	1528	0.0038	29.2
Kovar / Invar	275	4202	0.0013	26.8	2801	0.0019	26.8	2101	0.0026	26.8	1401	0.0032	22.3	1051	0.0038	20.1

Speeds and Feeds are based upon: ADOC = 1 x Diameter, RDOC = 0.15 x Diameter

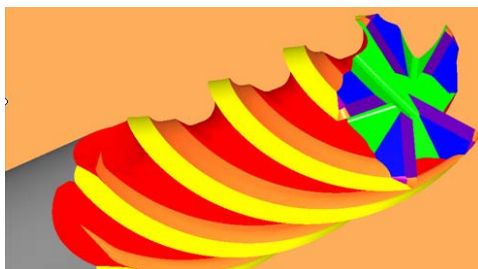
Speeds and Feeds are based upon material hardness < 32 Rc

STR540 Recommended Starting Point Speed and Feeds (Profiling)

Material	SFM	Diameter = 1/4			Diameter = 3/8			Diameter = 1/2			Diameter = 3/4			Diameter = 1		
		RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM	RPM	CPT	IPM
Material Steels																
1018/1020	625	9550	0.0019	89.5	6367	0.0028	89.5	4775	0.0038	89.5	3183	0.0047	74.6	2388	0.0056	67.1
1045	600	9168	0.0015	68.8	6112	0.0023	68.8	4584	0.0030	68.8	3056	0.0038	57.3	2292	0.0045	51.6
4140	550	8404	0.0015	63.0	5603	0.0023	63.0	4202	0.0030	63.0	2801	0.0038	52.5	2101	0.0045	47.3
4340	500	7640	0.0015	57.3	5093	0.0023	57.3	3820	0.0030	57.3	2547	0.0038	47.8	1910	0.0045	43.0
Cast Iron																
Ductile	500	7640	0.0019	71.6	5093	0.0028	71.6	3820	0.0038	71.6	2547	0.0047	59.7	1910	0.0056	53.7
Gray	625	9550	0.0019	89.5	6367	0.0028	89.5	4775	0.0038	89.5	3183	0.0047	74.6	2388	0.0056	67.1
Tool Steel																
A2	475	7258	0.0015	54.4	4839	0.0023	54.4	3629	0.0030	54.4	2419	0.0038	45.4	1815	0.0045	40.8
D2	425	6494	0.0015	48.7	4329	0.0023	48.7	3247	0.0030	48.7	2165	0.0038	40.6	1624	0.0045	36.5
H13	500	7640	0.0015	57.3	5093	0.0023	57.3	3820	0.0030	57.3	2547	0.0038	47.8	1910	0.0045	43.0
P20	500	7640	0.0019	71.6	5093	0.0028	71.6	3820	0.0038	71.6	2547	0.0047	59.7	1910	0.0056	53.7
S7	500	7640	0.0015	57.3	5093	0.0023	57.3	3820	0.0030	57.3	2547	0.0038	47.8	1910	0.0045	43.0

Speeds and Feeds are based upon: ADOC = 1 x Diameter, RDOC = 0.15 x Diameter

Speeds and Feeds are based upon material hardness < 32 Rc



Niagara Cutter

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