

infoTECH™



Performance Guarantee

Plus 1 End Mill FREE

ST4 / ST5 Stratus High Performance End Mills

- ⊗ Premium Micro-grain carbide substrate
- ⊗ Next generation AlCrN PVD coating
- ⊗ Differential flute spacing for smooth cutting performance
- ⊗ Variable Helix design to combat vibration & chatter
- ⊗ Designed to Slot at 1 x D
- ⊗ Eccentric Relief for improved edge strength
- ⊗ Tapered core for added stability
- ⊗ All STRATUS end mills are Post Processed after coating to achieve improved tool performance.



Purchase 4 pieces Stratus ST4 or ST5 End Mills and receive the 5th tool FREE. Use the FREE tool and if you are not satisfied with the performance return the remaining tools for a full refund.

Note! The FREE tool would be the least expensive of tools ordered. Guarantee only valid if the FREE tool does not meet performance level expected. Offer is valid for all end mills on pages 2 to 4 of this brochure

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STRATUS 4 Flute End Mills

- Premium Micro-grain carbide substrate
- Next generation AlCrN PVD coating
- Differential flute spacing for smooth cutting performance
- Variable Helix design to combat vibration & chatter
- Designed to Slot at 1 x D
- Eccentric Relief for improved edge strength
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4 Flute End Mills

(Variable Flute / Center Cutting)

Designation	Cutter Dia.	Shank Dia.	Length of Cut	OAL	Corner Radius	TL30 Coated
ST4RC-SQ0125	1/8	1/8	1/2	2	---	●
ST4RC-SQ0125-010	1/8	1/8	1/2	2	.010	●
ST4RC-SQ0187	3/16	3/16	5/8	2	---	●
ST4RC-SQ0187-015	3/16	3/16	5/8	2	.015	●
ST4EC-SQ0187	3/16	3/16	7/8	2.1/2	---	●
ST4SC-SQ0250	1/4	1/4	3/8	2	---	●
ST4SC-SQ0250-020	1/4	1/4	3/8	2	.020	●
ST4RC-SQ0250	1/4	1/4	3/4	2.1/2	---	●
ST4RC-SQ0250-020	1/4	1/4	3/4	2.1/2	.020	●
ST4RC-SQ0250-030	1/4	1/4	3/4	2.1/2	.030	●
ST4RC-SQ0250-060	1/4	1/4	3/4	2.1/2	.060	●
ST4LC-SQ0250	1/4	1/4	1.1/4	3	---	●
ST4LC-SQ0250-020	1/4	1/4	1.1/4	3	.020	●
ST4RC-SQ0312	5/16	5/16	13/16	2.1/2	---	●
ST4RC-SQ0312-020	5/16	5/16	13/16	2.1/2	.020	●
ST4SC-SQ0375	3/8	3/8	1/2	2	---	●
ST4SC-SQ0375-020	3/8	3/8	1/2	2	.020	●
ST4RC-SQ0375	3/8	3/8	7/8	2.1/2	---	●
ST4RC-SQ0375-020	3/8	3/8	7/8	2.1/2	.020	●
ST4RC-SQ0375-030	3/8	3/8	7/8	2.1/2	.030	●
ST4RC-SQ0375-060	3/8	3/8	7/8	2.1/2	.060	●
ST4RC-SQ0375-120	3/8	3/8	7/8	2.1/2	.120	●
ST4EC-SQ0375	3/8	3/8	1.1/8	3	---	●
ST4EC-SQ0375-020	3/8	3/8	1.1/8	3	.020	●

Designation	Cutter Dia.	Shank Dia.	Length of Cut	OAL	Corner Radius	TL30 Coated
ST4LC-SQ0375	3/8	3/8	1.1/2	3.1/2	---	●
ST4LC-SQ0375-030	3/8	3/8	1.1/2	3.1/2	.030	●
ST4RC-SQ0437	7/16	7/16	1	2.3/4	---	●
ST4RC-SQ0437-020	7/16	7/16	1	2.3/4	.020	●
ST4SC-SQ0500	1/2	1/2	5/8	2.1/2	---	●
ST4SC-SQ0500-015	1/2	1/2	5/8	2.1/2	.015	●
ST4SC-SQ0500-030	1/2	1/2	5/8	2.1/2	.030	●
ST4SC-SQ0500-060	1/2	1/2	5/8	2.1/2	.060	●
ST4RC-SQ0500	1/2	1/2	1	3	---	●
ST4RC-SQ0500-030	1/2	1/2	1	3	.030	●
ST4RC-SQ0500-060	1/2	1/2	1	3	.060	●
ST4EC-SQ0500	1/2	1/2	1.1/4	3	---	●
ST4EC-SQ0500-015	1/2	1/2	1.1/4	3	.015	●
ST4EC-SQ0500-020	1/2	1/2	1.1/4	3	.020	●
ST4EC-SQ0500-030	1/2	1/2	1.1/4	3	.030	●
ST4EC-SQ0500-060	1/2	1/2	1.1/4	3	.060	●
ST4EC-SQ0500-090	1/2	1/2	1.1/4	3	.090	●
ST4EC-SQ0500-120	1/2	1/2	1.1/4	3	.120	●
ST4MC-SQ0500	1/2	1/2	1.5/8	3.1/2	---	●
ST4LC-SQ0500	1/2	1/2	2	4	---	●
ST4LC-SQ0500-030	1/2	1/2	2	4	.030	●
ST4SC-SQ0625	5/8	5/8	3/4	3	---	●
ST4SC-SQ0625-030	5/8	5/8	3/4	3	.030	●
ST4SC-SQ0625-060	5/8	5/8	3/4	3	.060	●
ST4RC-SQ0625	5/8	5/8	1.1/4	3.1/2	---	●
ST4RC-SQ0625-030	5/8	5/8	1.1/4	3.1/2	.030	●
ST4RC-SQ0625-060	5/8	5/8	1.1/4	3.1/2	.060	●
ST4EC-SQ0625	5/8	5/8	1.5/8	3.1/2	---	●
ST4EC-SQ0625-030	5/8	5/8	1.5/8	3.1/2	.030	●
ST4SC-SQ0750	3/4	3/4	7/8	3	---	●
ST4SC-SQ0750-030	3/4	3/4	7/8	3	.030	●
ST4SC-SQ0750-060	3/4	3/4	7/8	3	.060	●
ST4RC-SQ0750	3/4	3/4	1.1/2	4	---	●
ST4RC-SQ0750-030	3/4	3/4	1.1/2	4	.030	●
ST4RC-SQ0750-060	3/4	3/4	1.1/2	4	.060	●
ST4RC-SQ0750-090	3/4	3/4	1.1/2	4	.090	●
ST4RC-SQ0750-120	3/4	3/4	1.1/2	4	.120	●
ST4EC-SQ0750	3/4	3/4	1.3/4	4	---	●
ST4EC-SQ0750-030	3/4	3/4	1.3/4	4	.030	●
ST4EC-SQ0750-060	3/4	3/4	1.3/4	4	.060	●
ST4EC-SQ0750-120	3/4	3/4	1.3/4	4	.120	●
ST4MC-SQ0750	3/4	3/4	2.3/8	5	---	●
ST4RC-SQ1000	1	1	1.1/2	4	---	●
ST4RC-SQ1000-030	1	1	1.1/2	4	.030	●
ST4RC-SQ1000-060	1	1	1.1/2	4	.060	●
ST4RC-SQ1000-120	1	1	1.1/2	4	.120	●

STRATUS 4 Flute Ball Nose End Mills

The STRATUS family of Premium end mills bring a new performance level to machining of todays difficult to machine materials. We have incorporated many of the advanced features necessary to achieve superior results.

- Premium Micro-grain carbide substrate
- Next generation AlCrN PVD coating
- 4 flute Differential spacing for smooth cutting performance
- Variable Helix design to combat vibration & chatter
- Eccentric Relief for improved edge strength
- Tapered core for added stability
- All STRATUS end mills are Post Processed after coating to achieve improved tool performance

STRATUS 4 Flute Cylindrical Shank Ball Nose End Mills



Designation	Cutter Dia.	Shank Dia.	Length of Cut	OAL	Corner Radius	TL30 Coated
ST4RC-BN0250	1/4	1/4	3/4	2.1/2	.120	●
ST4RC-BN0312	5/16	5/16	13/16	2.1/2	.156	●
ST4SC-BN0375	3/8	3/8	1/2	2	.188	●
ST4RC-BN0375	3/8	3/8	7/8	2.1/2	.188	●
ST4RC-BN0500	1/2	1/2	1	3	.250	●
ST4EC-BN0500	1/2	1/2	1.1/4	3	.250	●
ST4RC-BN0625	5/8	5/8	1.1/4	3.1/2	.313	●
ST4RC-BN0750	3/4	3/4	1.1/2	4	.375	●
ST4RC-BN1000	1	1	1.1/2	4	.500	●



STRATUS ST4 & ST5 Recommended Cutting Parameters

Work Material	Type of Cut	ap	ae	Cutting Speed (SFM)		Feed per flute (Inch)						
				Min	Max	3/16	1/4	3/8	1/2	5/8	3/4	1
Low Carbon Steels < 38 Rc 1018, 12L14, 8620	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	480	650	.0010 .0013	.0014 .0017	.0021 .0026	.0026 .0033	.0031 .0039	.0034 .0043	.0040 .0050
Medium & High Carbon Carbon Steels <35 Rc 1045, 1050, 1525, 1545	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	450	625	.0010 .0013	.0014 .0017	.0021 .0026	.0026 .0033	.0032 .0040	.0036 .0045	.0040 .0050
Alloy Steels & Tool Steels <35 Rc 4000 series, 5000 series P20, H13, A2, D2	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	400	525	.0008 .0010	.0011 .0014	.0018 .0022	.0022 .0028	.0026 .0033	.0030 .0038	.0035 .0044
Alloy Steels & Tool Steels <48 Rc 4000 series, 5000 series P20, H13, A2, D2	Slotting Peripheral	0.75 x D 1.5 x D	1 x D 0.5 x D	300	475	.0005 .0008	.0010 .0013	.0016 .0020	.0020 .0025	.0024 .0030	.0027 .0034	.0032 .0040
Martensitic & Ferritic Stainless Steels <35 Rc 13-8 PH, 15-5 PH, 17-4 PH, 400 & 500 series	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	200	325	.0007 .0009	.0010 .0012	.0014 .0017	.0018 .0022	.0021 .0026	.0024 .0030	.0028 .0035
Martensitic & Ferritic Stainless Steels <48 Rc 13-8 PH, 15-5 PH, 17-4 PH, 400 & 500 series	Slotting Peripheral	0.75 x D 1.5 x D	1 x D 0.5 x D	150	225	.0006 .0008	.0008 .0010	.0011 .0014	.0014 .0018	.0016 .0020	.0019 .0024	.0022 .0027
Austenitic Stainless Steels 200 Series, 304, 304L, 309	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	310	375	.0008 .0010	.0011 .0014	.0018 .0022	.0022 .0028	.0026 .0033	.0030 .0038	.0035 .0044
High Strength Stainless Steels 310, 316, 316L	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	200	260	.0007 .0009	.0010 .0012	.0014 .0018	.0018 .0022	.0021 .0026	.0024 .0030	.0028 .0035
Duplex Stainless Steels F55, 323, 2205	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	200	240	.0006 .0008	.0008 .0010	.0011 .0014	.0014 .0018	.0018 .0022	.0019 .0024	.0022 .0027
Gray Cast Iron GG15, GG25, GG30, GG40	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	390	500	.0010 .0013	.0014 .0017	.0021 .0026	.0026 .0033	.0030 .0038	.0035 .0044	.0040 .0050
Low to Medium Strength Ductile Cast Iron GGG40, GTS35	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	360	460	.0008 .0010	.0011 .0014	.0018 .0022	.0022 .0028	.0026 .0033	.0032 .0040	.0036 .0045
High Strength Ductile Iron GGG60, GTW55, GTS65	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	330	430	.0006 .0008	.0010 .0012	.0014 .0017	.0018 .0022	.0021 .0026	.0024 .0030	.0028 .0035
Titanium Alloys	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	150	200	.0006 .0008	.0009 .0011	.0013 .0016	.0016 .0020	.0019 .0024	.0022 .0027	.0026 .0032
High Temperature Alloys Inconel, Haynes, Stellite, Hastalloy	Slotting Peripheral	1 x D 1.5 x D	1 x D 0.5 x D	120	170	.0006 .0007	.0008 .0010	.0013 .0016	.0016 .0020	.0019 .0024	.0024 .0030	.0028 .0035

Notes: Use lower value cutting speed for higher hardness or stock removal
 Use higher value cutting speed for lower hardness and finishing operations
 Adjust values for smaller taper machines

STRATUS 5 Flute End Mills

The STRATUS family of Premium end mills bring a new performance level to machining of todays difficult to machine materials. We have incorporated many of the advanced features necessary to achieve superior results

- Premium Micro-grain carbide substrate
- Next generation AlCrN PVD coating
- 5 flute Differential spacing for smooth cutting performance
- Variable Helix design to combat vibration & chatter
- Designed to Slot at 1 x D
- Eccentric Relief for improved edge strength
- Tapered core for added stability
- All STRATUS end mills are Post Processed after coating to achieve improved tool performance



STRATUS 5 Flute High Performance Cylindrical Shank End Mills

Designation	Cutter Dia.	Shank Dia.	Length of Cut	OAL	Radius	TL30 Coated
ST5RC-SQ0187	3/16	3/16	5/8	2	---	●
ST5RC-SQ0187-015	3/16	3/16	5/8	2	.015	●
ST5EC-SQ0187	3/16	3/16	7/8	2.1/2	---	●
ST5RC-SQ0250	1/4	1/4	3/4	2.1/2	---	●
ST5RC-SQ0250-020	1/4	1/4	3/4	2.1/2	.020	●
ST5RC-SQ0250-030	1/4	1/4	3/4	2.1/2	.030	●
ST5RC-SQ0250-060	1/4	1/4	3/4	2.1/2	.060	●
ST5RC-SQ0312	5/16	5/16	13/16	2.1/2	---	●
ST5RC-SQ0312-020	5/16	5/16	13/16	2.1/2	.020	●
ST5RC-SQ0375	3/8	3/8	7/8	2.1/2	---	●
ST5RC-SQ0375-020	3/8	3/8	7/8	2.1/2	.020	●
ST5RC-SQ0375-030	3/8	3/8	7/8	2.1/2	.030	●
ST5RC-SQ0375-060	3/8	3/8	7/8	2.1/2	.060	●
ST5RC-SQ0375-120	3/8	3/8	7/8	2.1/2	.120	●
ST5EC-SQ0375	3/8	3/8	1.1/8	3	---	●
ST5EC-SQ0375-020	3/8	3/8	1.1/8	3	.020	●
ST5SC-SQ0500	1/2	1/2	5/8	2.1/2	---	●
ST5RC-SQ0500	1/2	1/2	1	3	---	●
ST5RC-SQ0500-020	1/2	1/2	1	3	.020	●
ST5RC-SQ0500-030	1/2	1/2	1	3	.030	●
ST5RC-SQ0500-060	1/2	1/2	1	3	.060	●
ST5EC-SQ0500	1/2	1/2	1.1/4	3	---	●
ST5EC-SQ0500-015	1/2	1/2	1.1/4	3	.015	●

Designation	Cutter Dia.	Shank Dia.	Length of Cut	OAL	Radius	TL30 Coated
ST5EC-SQ0500-020	1/2	1/2	1.1/4	3	.020	●
ST5EC-SQ0500-030	1/2	1/2	1.1/4	3	.030	●
ST5EC-SQ0500-060	1/2	1/2	1.1/4	3	.060	●
ST5EC-SQ0500-090	1/2	1/2	1.1/4	3	.090	●
ST5EC-SQ0500-120	1/2	1/2	1.1/4	3	.120	●
ST5RC-SQ0625	5/8	5/8	1.1/4	3.1/2	---	●
ST5RC-SQ0625-030	5/8	5/8	1.1/4	3.1/2	.030	●
ST5RC-SQ0625-060	5/8	5/8	1.1/4	3.1/2	.060	●
ST5EC-SQ0625	5/8	5/8	1.5/8	3.1/2	---	●
ST5EC-SQ0625-030	5/8	5/8	1.5/8	3.1/2	.030	●
ST5RC-SQ0750	3/4	3/4	1.1/2	4	---	●
ST5RC-SQ0750-030	3/4	3/4	1.1/2	4	.030	●
ST5RC-SQ0750-060	3/4	3/4	1.1/2	4	.060	●
ST5RC-SQ0750-090	3/4	3/4	1.1/2	4	.090	●
ST5RC-SQ0750-120	3/4	3/4	1.1/2	4	.120	●
ST5EC-SQ0750	3/4	3/4	1.3/4	4	---	●
ST5EC-SQ0750-030	3/4	3/4	1.3/4	4	.030	●
ST5EC-SQ0750-060	3/4	3/4	1.3/4	4	.060	●
ST5EC-SQ0750-120	3/4	3/4	1.3/4	4	.120	●
ST5RC-SQ1000	1	1	1.1/2	4	---	●
ST5RC-SQ1000-030	1	1	1.1/2	4	.030	●
ST5RC-SQ1000-060	1	1	1.1/2	4	.060	●
ST5RC-SQ1000-120	1	1	1.1/2	4	.120	●