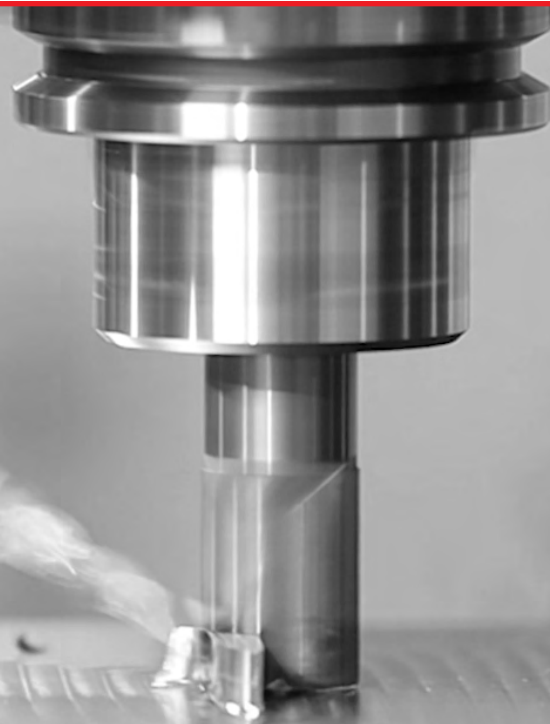


# ST Series

An off-the-shelf milling assembly that applies science for optimized output.



## How to find your assembly and dashboard

Select your machine make and model; material; diameter; length of cut and number of flutes. This will identify the assembly and dashboard code right for you.

- BRIDGEPORT Machines..... [Page 2](#)
- HAAS Machines ..... [Pages 3-4](#)
- OKUMA Machines..... [Page 5](#)

## Accupro® ST Dashboard Sample

Material #1  
Material #2  
Material #3  
Material #4

	#1	#2	#3	#4
Machine Name:	Haas 12,000 RPM	Haas 12,000 RPM	Haas 12,000 RPM	Haas 12,000 RPM
Machine Model:	VFVM	VFVM	VFVM	VFVM
Holder Name:	1/2 Stub Holder CAT40	1/2 Stub Holder CAT40	1/2 Stub Holder CAT40	1/2 Stub Holder CAT40
Holder Model:	18856615	18856615	18856615	18856615
Tool Name:	1/2 5FL Regular	1/2 5FL Regular	1/2 5FL Regular	1/2 5FL Regular
Tool Model:	90783952	90783952	90783952	90783952
Gage Length:	3.125 in	3.125 in	3.125 in	3.125 in
Material Name:	M	H	P	Ti
Material Group:	Stainless Steels	Hardened Steels	Steels	Titanium and Titanium Alloys
<b>Cutting Parameters</b>				
Spindle Speed: rpm	1000	1000	1000	1000
Depth of Cut (Ap): in	1.0000	1.0000	1.0000	1.0000
Width of Cut (Ae): in	0.1250	0.1250	0.1250	0.1250
Feed: IPM	30	30	30	30
Power (%)	9.59	14.10	7.53	8.10
MRR: in <sup>3</sup> /min	3.74	3.74	3.74	3.74
Chatter Status:	Stable	Stable	Stable	Stable
	English Units		Metric Units	

Complete the open cells to identify the optimal running parameters for your application.

Accupro® ST Series and Dashboard Technology help pinpoint the ideal running parameters for your specific milling process. This is achieved by leveraging machining dynamics data to identify each application's stable milling zone. This high performance milling assembly comes ready-to-use with a dual-contact, coolant thru, pre-balanced to 20,000 RPM, CAT-40 tool holder, retention knob and end mill.

## BRIDGEPORT

Models: GX1000; GX480; V1000; V710

**N** Aluminum and Non-Ferrous

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503371</a>	1/2"	5/8"	3	<a href="#">BRI-100-0500-3-1.htm</a>
<a href="#">12503470</a>	1/2"	1"	3	<a href="#">BRI-100-0500-3-2.htm</a>
<a href="#">12502589</a>	1/2"	1-1/4"	3	<a href="#">BRI-100-0500-3-3.htm</a>
<a href="#">12503793</a>	5/8"	3/4"	3	<a href="#">BRI-100-0625-3-1.htm</a>
<a href="#">12503686</a>	5/8"	1-1/4"	3	<a href="#">BRI-100-0625-3-2.htm</a>
<a href="#">12503280</a>	5/8"	1-1/2"	3	<a href="#">BRI-100-0625-3-3.htm</a>
<a href="#">12504064</a>	3/4"	1"	3	<a href="#">BRI-100-0750-3-1.htm</a>
<a href="#">12503645</a>	3/4"	1-1/2"	3	<a href="#">BRI-100-0750-3-2.htm</a>
<a href="#">12503504</a>	3/4"	2"	3	<a href="#">BRI-100-0750-3-3.htm</a>

**P** Steels; **H** Hardened Steels; **M** Stainless Steels; **Ti** Titanium

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12502878</a>	1/2"	5/8"	5	<a href="#">BRI-100-0500-5-1.htm</a>
<a href="#">12503777</a>	1/2"	1"	5	<a href="#">BRI-100-0500-5-2.htm</a>
<a href="#">12503124</a>	1/2"	1-1/4"	5	<a href="#">BRI-100-0500-5-3.htm</a>
<a href="#">12502654</a>	5/8"	3/4"	5	<a href="#">BRI-100-0625-5-1.htm</a>
<a href="#">12503447</a>	5/8"	1-1/4"	5	<a href="#">BRI-100-0625-5-2.htm</a>
<a href="#">12503587</a>	5/8"	1-1/2"	5	<a href="#">BRI-100-0625-5-3.htm</a>
<a href="#">12503603</a>	3/4"	1"	5	<a href="#">BRI-100-0750-5-1.htm</a>
<a href="#">12503140</a>	3/4"	1-1/2"	5	<a href="#">BRI-100-0750-5-2.htm</a>
<a href="#">12502860</a>	3/4"	2"	5	<a href="#">BRI-100-0750-5-3.htm</a>

**P** Steels; **H** Hardened Steels; **M** Stainless Steels; **K** Cast Iron

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503496</a>	1/2"	5/8"	4	<a href="#">BRI-100-0500-4-1.htm</a>
<a href="#">12503181</a>	1/2"	1"	4	<a href="#">BRI-100-0500-4-2.htm</a>
<a href="#">12503413</a>	1/2"	1-1/4"	4	<a href="#">BRI-100-0500-4-3.htm</a>
<a href="#">12502902</a>	5/8"	3/4"	4	<a href="#">BRI-100-0625-4-1.htm</a>
<a href="#">12502647</a>	5/8"	1-1/4"	4	<a href="#">BRI-100-0625-4-2.htm</a>
<a href="#">12503330</a>	5/8"	1-1/2"	4	<a href="#">BRI-100-0625-4-3.htm</a>
<a href="#">12502803</a>	3/4"	1"	4	<a href="#">BRI-100-0750-4-1.htm</a>
<a href="#">12503785</a>	3/4"	1-1/2"	4	<a href="#">BRI-100-0750-4-2.htm</a>
<a href="#">12502829</a>	3/4"	2"	4	<a href="#">BRI-100-0750-4-3.htm</a>

**H** Hardened Steels; **M** Stainless Steels; **Ti** Titanium; **S** Super Alloys

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12504080</a>	1/2"	5/8"	7	<a href="#">BRI-100-0500-7-1.htm</a>
<a href="#">12503405</a>	1/2"	1"	7	<a href="#">BRI-100-0500-7-2.htm</a>
<a href="#">12503462</a>	1/2"	1-1/4"	7	<a href="#">BRI-100-0500-7-3.htm</a>
<a href="#">12503207</a>	5/8"	3/4"	7	<a href="#">BRI-100-0625-7-1.htm</a>
<a href="#">12503058</a>	5/8"	1-1/4"	7	<a href="#">BRI-100-0625-7-2.htm</a>
<a href="#">12503702</a>	5/8"	1-1/2"	7	<a href="#">BRI-100-0625-7-3.htm</a>
<a href="#">12503009</a>	3/4"	1"	7	<a href="#">BRI-100-0750-7-1.htm</a>
<a href="#">12503231</a>	3/4"	1-1/2"	7	<a href="#">BRI-100-0750-7-2.htm</a>
<a href="#">12503173</a>	3/4"	2"	7	<a href="#">BRI-100-0750-7-3.htm</a>

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## HAAS

Models: VF1; VF2; VF3; VF4; VF5; VF6; UMC1000; UMC1250; UMC500; UMC750

N Aluminum and Non-Ferrous				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503371</a>	1/2"	5/8"	3	<a href="#">HAA-081-0500-3-1.htm</a>
<a href="#">12503470</a>	1/2"	1"	3	<a href="#">HAA-081-0500-3-2.htm</a>
<a href="#">12502589</a>	1/2"	1-1/4"	3	<a href="#">HAA-081-0500-3-3.htm</a>
<a href="#">12503793</a>	5/8"	3/4"	3	<a href="#">HAA-081-0625-3-1.htm</a>
<a href="#">12503686</a>	5/8"	1-1/4"	3	<a href="#">HAA-081-0625-3-2.htm</a>
<a href="#">12503280</a>	5/8"	1-1/2"	3	<a href="#">HAA-081-0625-3-3.htm</a>
<a href="#">12504064</a>	3/4"	1"	3	<a href="#">HAA-081-0750-3-1.htm</a>
<a href="#">12503645</a>	3/4"	1-1/2"	3	<a href="#">HAA-081-0750-3-2.htm</a>
<a href="#">12503504</a>	3/4"	2"	3	<a href="#">HAA-081-0750-3-3.htm</a>

P Steels; H Hardened Steels; M Stainless Steels; Ti Titanium				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12502878</a>	1/2"	5/8"	5	<a href="#">HAA-081-0500-5-1.htm</a>
<a href="#">12503777</a>	1/2"	1"	5	<a href="#">HAA-081-0500-5-2.htm</a>
<a href="#">12503124</a>	1/2"	1-1/4"	5	<a href="#">HAA-081-0500-5-3.htm</a>
<a href="#">12502654</a>	5/8"	3/4"	5	<a href="#">HAA-081-0625-5-1.htm</a>
<a href="#">12503447</a>	5/8"	1-1/4"	5	<a href="#">HAA-081-0625-5-2.htm</a>
<a href="#">12503587</a>	5/8"	1-1/2"	5	<a href="#">HAA-081-0625-5-3.htm</a>
<a href="#">12503603</a>	3/4"	1"	5	<a href="#">HAA-081-0750-5-1.htm</a>
<a href="#">12503140</a>	3/4"	1-1/2"	5	<a href="#">HAA-081-0750-5-2.htm</a>
<a href="#">12502860</a>	3/4"	2"	5	<a href="#">HAA-081-0750-5-3.htm</a>

P Steels; H Hardened Steels; M Stainless Steels; K Cast Iron				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503496</a>	1/2"	5/8"	4	<a href="#">HAA-081-0500-4-1.htm</a>
<a href="#">12503181</a>	1/2"	1"	4	<a href="#">HAA-081-0500-4-2.htm</a>
<a href="#">12503413</a>	1/2"	1-1/4"	4	<a href="#">HAA-081-0500-4-3.htm</a>
<a href="#">12502902</a>	5/8"	3/4"	4	<a href="#">HAA-081-0625-4-1.htm</a>
<a href="#">12502647</a>	5/8"	1-1/4"	4	<a href="#">HAA-081-0625-4-2.htm</a>
<a href="#">12503330</a>	5/8"	1-1/2"	4	<a href="#">HAA-081-0625-4-3.htm</a>
<a href="#">12502803</a>	3/4"	1"	4	<a href="#">HAA-081-0750-4-1.htm</a>
<a href="#">12503785</a>	3/4"	1-1/2"	4	<a href="#">HAA-081-0750-4-2.htm</a>
<a href="#">12502829</a>	3/4"	2"	4	<a href="#">HAA-081-0750-4-3.htm</a>

H Hardened Steels; M Stainless Steels; Ti Titanium; S Super Alloys				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12504080</a>	1/2"	5/8"	7	<a href="#">HAA-081-0500-7-1.htm</a>
<a href="#">12503405</a>	1/2"	1"	7	<a href="#">HAA-081-0500-7-2.htm</a>
<a href="#">12503462</a>	1/2"	1-1/4"	7	<a href="#">HAA-081-0500-7-3.htm</a>
<a href="#">12503207</a>	5/8"	3/4"	7	<a href="#">HAA-081-0625-7-1.htm</a>
<a href="#">12503058</a>	5/8"	1-1/4"	7	<a href="#">HAA-081-0625-7-2.htm</a>
<a href="#">12503702</a>	5/8"	1-1/2"	7	<a href="#">HAA-081-0625-7-3.htm</a>
<a href="#">12503009</a>	3/4"	1"	7	<a href="#">HAA-081-0750-7-1.htm</a>
<a href="#">12503231</a>	3/4"	1-1/2"	7	<a href="#">HAA-081-0750-7-2.htm</a>
<a href="#">12503173</a>	3/4"	2"	7	<a href="#">HAA-081-0750-7-3.htm</a>

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## HAAS

Models: VF1SS; VF2SS; VF3SS; VF4SS; VF5SS; VF6SS; VM1; VM2; VM3; VM6;  
 UMC1000SS; UMC1250SS; UMC500SS; UMC750SS

N Aluminum and Non-Ferrous				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503371</a>	1/2"	5/8"	3	<a href="#">HAA-120-0500-3-1.htm</a>
<a href="#">12503470</a>	1/2"	1"	3	<a href="#">HAA-120-0500-3-2.htm</a>
<a href="#">12502589</a>	1/2"	1-1/4"	3	<a href="#">HAA-120-0500-3-3.htm</a>
<a href="#">12503793</a>	5/8"	3/4"	3	<a href="#">HAA-120-0625-3-1.htm</a>
<a href="#">12503686</a>	5/8"	1-1/4"	3	<a href="#">HAA-120-0625-3-2.htm</a>
<a href="#">12503280</a>	5/8"	1-1/2"	3	<a href="#">HAA-120-0625-3-3.htm</a>
<a href="#">12504064</a>	3/4"	1"	3	<a href="#">HAA-120-0750-3-1.htm</a>
<a href="#">12503645</a>	3/4"	1-1/2"	3	<a href="#">HAA-120-0750-3-2.htm</a>
<a href="#">12503504</a>	3/4"	2"	3	<a href="#">HAA-120-0750-3-3.htm</a>

P Steels; H Hardened Steels; M Stainless Steels; Ti Titanium				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12502878</a>	1/2"	5/8"	5	<a href="#">HAA-120-0500-5-1.htm</a>
<a href="#">12503777</a>	1/2"	1"	5	<a href="#">HAA-120-0500-5-2.htm</a>
<a href="#">12503124</a>	1/2"	1-1/4"	5	<a href="#">HAA-120-0500-5-3.htm</a>
<a href="#">12502654</a>	5/8"	3/4"	5	<a href="#">HAA-120-0625-5-1.htm</a>
<a href="#">12503447</a>	5/8"	1-1/4"	5	<a href="#">HAA-120-0625-5-2.htm</a>
<a href="#">12503587</a>	5/8"	1-1/2"	5	<a href="#">HAA-120-0625-5-3.htm</a>
<a href="#">12503603</a>	3/4"	1"	5	<a href="#">HAA-120-0750-5-1.htm</a>
<a href="#">12503140</a>	3/4"	1-1/2"	5	<a href="#">HAA-120-0750-5-2.htm</a>
<a href="#">12502860</a>	3/4"	2"	5	<a href="#">HAA-120-0750-5-3.htm</a>

P Steels; H Hardened Steels; M Stainless Steels; K Cast Iron				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503496</a>	1/2"	5/8"	4	<a href="#">HAA-120-0500-4-1.htm</a>
<a href="#">12503181</a>	1/2"	1"	4	<a href="#">HAA-120-0500-4-2.htm</a>
<a href="#">12503413</a>	1/2"	1-1/4"	4	<a href="#">HAA-120-0500-4-3.htm</a>
<a href="#">12502902</a>	5/8"	3/4"	4	<a href="#">HAA-120-0625-4-1.htm</a>
<a href="#">12502647</a>	5/8"	1-1/4"	4	<a href="#">HAA-120-0625-4-2.htm</a>
<a href="#">12503330</a>	5/8"	1-1/2"	4	<a href="#">HAA-120-0625-4-3.htm</a>
<a href="#">12502803</a>	3/4"	1"	4	<a href="#">HAA-120-0750-4-1.htm</a>
<a href="#">12503785</a>	3/4"	1-1/2"	4	<a href="#">HAA-120-0750-4-2.htm</a>
<a href="#">12502829</a>	3/4"	2"	4	<a href="#">HAA-120-0750-4-3.htm</a>

H Hardened Steels; M Stainless Steels; Ti Titanium; S Super Alloys				
Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12504080</a>	1/2"	5/8"	7	<a href="#">HAA-120-0500-7-1.htm</a>
<a href="#">12503405</a>	1/2"	1"	7	<a href="#">HAA-120-0500-7-2.htm</a>
<a href="#">12503462</a>	1/2"	1-1/4"	7	<a href="#">HAA-120-0500-7-3.htm</a>
<a href="#">12503207</a>	5/8"	3/4"	7	<a href="#">HAA-120-0625-7-1.htm</a>
<a href="#">12503058</a>	5/8"	1-1/4"	7	<a href="#">HAA-120-0625-7-2.htm</a>
<a href="#">12503702</a>	5/8"	1-1/2"	7	<a href="#">HAA-120-0625-7-3.htm</a>
<a href="#">12503009</a>	3/4"	1"	7	<a href="#">HAA-120-0750-7-1.htm</a>
<a href="#">12503231</a>	3/4"	1-1/2"	7	<a href="#">HAA-120-0750-7-2.htm</a>
<a href="#">12503173</a>	3/4"	2"	7	<a href="#">HAA-120-0750-7-3.htm</a>

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## OKUMA

Models: M460-VE; M560-V; M660-V; MB46-V; MB56-V

**N** Aluminum and Non-Ferrous

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503363</a>	1/2"	5/8"	3	<a href="#">OKU-150-0500-3-1.htm</a>
<a href="#">12504122</a>	1/2"	1"	3	<a href="#">OKU-150-0500-3-2.htm</a>
<a href="#">12502936</a>	1/2"	1-1/4"	3	<a href="#">OKU-150-0500-3-3.htm</a>
<a href="#">12503074</a>	5/8"	3/4"	3	<a href="#">OKU-150-0625-3-1.htm</a>
<a href="#">12503694</a>	5/8"	1-1/4"	3	<a href="#">OKU-150-0625-3-2.htm</a>
<a href="#">12503272</a>	5/8"	1-1/2"	3	<a href="#">OKU-150-0625-3-3.htm</a>
<a href="#">12504056</a>	3/4"	1"	3	<a href="#">OKU-150-0750-3-1.htm</a>
<a href="#">12503611</a>	3/4"	1-1/2"	3	<a href="#">OKU-150-0750-3-2.htm</a>
<a href="#">12503512</a>	3/4"	2"	3	<a href="#">OKU-150-0750-3-3.htm</a>

**P** Steels; **H** Hardened Steels; **M** Stainless Steels; **Ti** Titanium

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12502886</a>	1/2"	5/8"	5	<a href="#">OKU-150-0500-5-1.htm</a>
<a href="#">12503710</a>	1/2"	1"	5	<a href="#">OKU-150-0500-5-2.htm</a>
<a href="#">12503090</a>	1/2"	1-1/4"	5	<a href="#">OKU-150-0500-5-3.htm</a>
<a href="#">12502704</a>	5/8"	3/4"	5	<a href="#">OKU-150-0625-5-1.htm</a>
<a href="#">12503314</a>	5/8"	1-1/4"	5	<a href="#">OKU-150-0625-5-2.htm</a>
<a href="#">12503579</a>	5/8"	1-1/2"	5	<a href="#">OKU-150-0625-5-3.htm</a>
<a href="#">12503629</a>	3/4"	1"	5	<a href="#">OKU-150-0750-5-1.htm</a>
<a href="#">12503108</a>	3/4"	1-1/2"	5	<a href="#">OKU-150-0750-5-2.htm</a>
<a href="#">12502845</a>	3/4"	2"	5	<a href="#">OKU-150-0750-5-3.htm</a>

**P** Steels; **H** Hardened Steels; **M** Stainless Steels; **K** Cast Iron

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12503488</a>	1/2"	5/8"	4	<a href="#">OKU-150-0500-4-1.htm</a>
<a href="#">12503199</a>	1/2"	1"	4	<a href="#">OKU-150-0500-4-2.htm</a>
<a href="#">12503355</a>	1/2"	1-1/4"	4	<a href="#">OKU-150-0500-4-3.htm</a>
<a href="#">12502910</a>	5/8"	3/4"	4	<a href="#">OKU-150-0625-4-1.htm</a>
<a href="#">12502605</a>	5/8"	1-1/4"	4	<a href="#">OKU-150-0625-4-2.htm</a>
<a href="#">12503439</a>	5/8"	1-1/2"	4	<a href="#">OKU-150-0625-4-3.htm</a>
<a href="#">12502779</a>	3/4"	1"	4	<a href="#">OKU-150-0750-4-1.htm</a>
<a href="#">12503041</a>	3/4"	1-1/2"	4	<a href="#">OKU-150-0750-4-2.htm</a>
<a href="#">12502811</a>	3/4"	2"	4	<a href="#">OKU-150-0750-4-3.htm</a>

**H** Hardened Steels; **M** Stainless Steels; **Ti** Titanium; **S** Super Alloys

Item #	Diameter	LOC	Flutes	Dashboard Link
<a href="#">12504114</a>	1/2"	5/8"	7	<a href="#">OKU-150-0500-7-1.htm</a>
<a href="#">12503397</a>	1/2"	1"	7	<a href="#">OKU-150-0500-7-2.htm</a>
<a href="#">12503306</a>	1/2"	1-1/4"	7	<a href="#">OKU-150-0500-7-3.htm</a>
<a href="#">12502670</a>	5/8"	3/4"	7	<a href="#">OKU-150-0625-7-1.htm</a>
<a href="#">12503769</a>	5/8"	1-1/4"	7	<a href="#">OKU-150-0625-7-2.htm</a>
<a href="#">12503728</a>	5/8"	1-1/2"	7	<a href="#">OKU-150-0625-7-3.htm</a>
<a href="#">12503033</a>	3/4"	1"	7	<a href="#">OKU-150-0750-7-1.htm</a>
<a href="#">12503256</a>	3/4"	1-1/2"	7	<a href="#">OKU-150-0750-7-2.htm</a>
<a href="#">12503132</a>	3/4"	2"	7	<a href="#">OKU-150-0750-7-3.htm</a>

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