

## Solid carbide HPC end mill

4 flutes, ULTRA-coated

**ORION®**



### Application

HPC end mill with uneven twist and uneven pitch for universal rough machining and smoothing.

### Version

- Solid carbide ultra-fine grain
- Straight shank as per DIN 6535 HA and HB
- ULTRA-coated
- With clearance
- Uneven twist angle 35°/38°
- With edge protection chamfer
- Edge-rounded flutes
- Centre cutting
- Uneven flute pitch

### Advantage

- Extremely smooth running
- Reduced oscillation
- Higher feed rates and cutting depths possible
- Ideal for static and dynamic trochoidal milling
- Defined edge rounding for outstanding service life

Application	Steel (N/mm <sup>2</sup> )			Stainless steel		Alu		Brass		Bronze		Plas-tics	Graphite G(C)FK	GG(G) GJMW	Titan-alloy	Nickel-alloy	Super-alloy	Hard mat.	
	<700	<1000	<1300	marten.	austen.	short	long	short	long	short	long							<55 HRC	<65 HRC
	230	190	150	120				350		240	280			160		70	70		

<b>Art. No.</b>	<b>16851 220</b>
<b>Cutting material</b>	VHM
<b>Surface</b>	ULTRA
<b>Type</b>	N
<b>Number of cutting edges</b>	4 PCS
<b>Twist angle</b>	35°, 38°
<b>Tool holding device</b>	HB parallel shank
<b>Overall length</b>	Short
<b>Cutting edge diameter</b>	20 mm
<b>Cutting edge length</b>	26 mm
<b>Clearance length</b>	42 mm
<b>Length</b>	92 mm
<b>Edge protection chamfer length</b>	0.2 mm
<b>Clearance diameter</b>	19.5 mm
<b>Shaft diameter</b>	20 mm
<b>fz steel 1000</b>	0.14 mm
<b>Overall stainless steel suitability</b>	1
<b>fitness not iron total</b>	2
<b>fitness Titan/Nickel/Super total</b>	1

### EAN-Code

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