

Copy mill 7° positive, with bore, Ø D / number of teeth Z: 52/5 mm



Order data

Order number	212150 52/5
GTIN	4045197750426
Item class	210

Description

Version:

Milling body with irregular pitch for smooth cutting.

- · High axial run-out accuracy and concentricity
- · Stepless repositioning as the cutting edge wears.

Vibration reduction and soft cutter edge entry due to 7° positive setting of the indexable inserts.

Attention:

Retaining screws and retaining washers should **not** be used for inserts with positive geometry.

Note:

Use GARANT torque screwdriver TQ No. 211750 size 3.8 with bit No. 674252 size 15IP.

 $a_{p \, max} = 4.0 \, mm.$

Tool exchange: PowerCard

Through-coolant: yes

Number of cutting edges Z: 5

Ø D₃: 40 mm

Overall length L_{tot}: 50 mm Mounting bore Ø: 22 mm

Circular interpolation milling \varnothing D_{min}: 92 mm Circular interpolation milling \varnothing D_{max}: 102 mm

Technical description

Mounting bore \varnothing 22 mm Overall length L_{tot} 50 mm Pack of insert screws 219805 (15IP; 3.8 Nm) Set of retaining screws 219807 (15IP; 3.8 Nm) \varnothing D ₃ 40 mm Number of cutting edges Z 5 Through-coolant yes Circular interpolation milling \varnothing D _{min} 92 mm Circular interpolation milling \varnothing D _{max} 102 mm Ramping length L for α_{max} 36.95 mm Ramping angle α_{max} 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Circular milling Milling application Circular milling Spacing of the cutters unequal spacing	Cutting edge Ø D _c	52 mm
Overall length L _{tot} 50 mm Pack of insert screws 219805 (15IP; 3.8 Nm) Set of retaining screws 219807 (15IP; 3.8 Nm) Ø D₃ 40 mm Number of cutting edges Z 5 Through-coolant yes Circular interpolation milling Ø Dmin 92 mm Circular interpolation milling Ø Dmax 102 mm Ramping length L for αmax 36.95 mm Ramping angle αmax 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	suitable indexable insert	RD12T3
Pack of insert screws 219805 (15IP; 3.8 Nm) Set of retaining screws 219807 (15IP; 3.8 Nm) Ø D₃ 40 mm Number of cutting edges Z 5 Through-coolant yes Circular interpolation milling Ø Dmin 92 mm Circular interpolation milling Ø Dmax 102 mm Ramping length L for αmax 36.95 mm Ramping angle αmax 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Mounting bore Ø	22 mm
Set of retaining screws $219807 (15IP; 3.8 \text{ Nm})$ $\varnothing D_3$ 40 mm Number of cutting edges Z 5 Through-coolantyesCircular interpolation milling $\varnothing D_{min}$ 92 mm Circular interpolation milling $\varnothing D_{max}$ 102 mm Ramping length L for α_{max} 36.95 mm Ramping angle α_{max} 1.3 degrees Shank typewith boreMilling head suitable for insert shaperoundMilling applicationRampingMilling applicationCircular millingSpacing of the cuttersunequal spacing	Overall length L _{tot}	50 mm
	Pack of insert screws	219805 (15IP; 3.8 Nm)
Number of cutting edges Z 5 Through-coolant yes Circular interpolation milling \emptyset D _{min} 92 mm Circular interpolation milling \emptyset D _{max} 102 mm Ramping length L for α_{max} 36.95 mm Ramping angle α_{max} 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Set of retaining screws	219807 (15IP; 3.8 Nm)
Through-coolant yes Circular interpolation milling \varnothing D _{min} Circular interpolation milling \varnothing D _{max} Ramping length L for α_{max} Ramping angle α_{max} Shank type Milling head suitable for insert shape Milling application Milling application Spacing of the cutters yes 92 mm 102 mm 102 mm 1.3 degrees with bore with bore round Circular milling Unequal spacing	\emptyset D ₃	40 mm
Circular interpolation milling \varnothing D _{min} Circular interpolation milling \varnothing D _{max} Ramping length L for α_{max} Ramping angle α_{max} Shank type Milling head suitable for insert shape Milling application Milling application Spacing of the cutters Page mm 102 mm 36.95 mm 1.3 degrees with bore round Ramping Circular milling	Number of cutting edges Z	5
Circular interpolation milling \varnothing D _{max} Ramping length L for α_{max} Ramping angle α_{max} Shank type Milling head suitable for insert shape Milling application Milling application Spacing of the cutters 102 mm 103.95 mm 1.3 degrees with bore round Ramping Circular milling	Through-coolant	yes
Ramping length L for α_{max} 36.95 mm Ramping angle α_{max} 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Circular interpolation milling \emptyset D_{min}	92 mm
Ramping angle α _{max} 1.3 degrees Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Circular interpolation milling \emptyset D_{max}	102 mm
Shank type with bore Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Ramping length L for α_{max}	36.95 mm
Milling head suitable for insert shape round Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Ramping angle α_{max}	1.3 degrees
Milling application Ramping Milling application Circular milling Spacing of the cutters unequal spacing	Shank type	with bore
Milling application Circular milling Spacing of the cutters unequal spacing	Milling head suitable for insert shape	round
Spacing of the cutters unequal spacing	Milling application	Ramping
	Milling application	Circular milling
Tool exchange PowerCard	Spacing of the cutters	unequal spacing
	Tool exchange	PowerCard

Accessories

PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 15IP	674252 15IP
Set of insert screws 10-piece	219805
Torque screwdriver, fixed setting set torque 3,8 Nm	211750 3,8
Set of insert screws 10-piece	219807