

Garant

Softcut® 90° indexable milling cutter MTC short, Weldon shank, Ø D / number of teeth Z: 40/4 mm



Order data

Order number	215155 40/4
GTIN	4045197349224
Item class	210

Description

Version:

High precision square shoulder milling cutter with irregular pitch for very smooth cutting, very high precision and cutting power. High performance indexable square shoulder milling cutter **with special geometry for reduced cutting forces for MTC applications** under **unstable conditions** or **for spindles with low drive power**.

Application:

For face milling to large depths, also slotting. General use in all steels including stainless steels. Especially for **MTC (Multi Task Cutting)** use on the new generation of turning/milling centres (**MTM**).

Note:

Use GARANT torque screwdriver TQ No. **211750 size 3.8** with bit No. **674252 size 15IP**. The insert pocket must be modified when using indexable inserts with a radius greater than 3.1 mm.

Overhang L_1 : 55 mm

Overall length L_{tot} : 115 mm

Shank $\varnothing D_s$ h6: 32 mm

Circular interpolation milling $\varnothing D_{min}$: 61.4 mm

Circular interpolation milling $\varnothing D_{max}$: 78.5 mm

Circular interpolation milling a_p : 1 mm

Technical description

Overall length L_{tot}	115 mm
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Overhang L_1	55 mm
Shank $\varnothing D_s$ h6	32 mm
suitable indexable insert	AP.. 1805..
Cutting edge $\varnothing D_c$	40 mm
Pack of insert screws	219808 (15IP; 3.8 Nm)
Number of cutting edges Z	4
Ramping length L for α_{max}	286.4 mm
Circular interpolation milling $\varnothing D_{max}$	78.5 mm
Circular interpolation milling $\varnothing D_{min}$	61.4 mm
Circular interpolation milling a_p	1 mm
Ramping angle α_{max}	1.8 degrees
Shank type	Weldon shank
Setting angle κ	90 degrees
Milling application	Corner milling
Milling application	Circular milling
Milling application	Ramping
Spacing of the cutters	unequal spacing
Through-coolant	yes
Machining strategy	MTC
Tool exchange	PowerCard
Type of product	Indexable insert cutter

Accessories

Set of insert screws 10-piece	219808
Set of insert screws 10-piece	219824
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 15IP	674252 15IP
Torque screwdriver, fixed setting set torque 3,8 Nm	211750 3,8

