

## Garant

### Softcut® 90° shoulder mill MTC long, Plain shank, Ø D / number of teeth Z: 25/2 mm



## Order data

Order number	215157 25/2
GTIN	4045197349231
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**.

Without internal cooling.

### 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  $L_1$ : 45 mm

Overall length  $L_{tot}$ : 200 mm

Shank  $\varnothing D_s$  h6: 25 mm

Circular interpolation milling  $\varnothing D_{min}$ : 31.3 mm

Circular interpolation milling  $\varnothing D_{max}$ : 47 mm

Circular interpolation milling  $a_p$ : 1 mm

## Technical description

suitable indexable insert	AP.. 1805..
Overhang $L_1$	45 mm

Shank $\varnothing D_s$ h6	25 mm
Overall length $L_{tot}$	200 mm
Pack of insert screws	219824 (15IP; 3.8 Nm)
Cutting edge $\varnothing D_c$	25 mm
Number of cutting edges Z	2
Ramping length L for $\alpha_{max}$	139.2 mm
Circular interpolation milling $\varnothing D_{max}$	47 mm
Circular interpolation milling $\varnothing D_{min}$	31.3 mm
Circular interpolation milling $a_p$	1 mm
Ramping angle $\alpha_{max}$	3.7 degrees
Shank type	Plain shank
Setting angle $\kappa$	90 degrees
Milling application	Corner milling
Milling application	Circular milling
Milling application	Ramping
Spacing of the cutters	unequal spacing
Through-coolant	no
Machining strategy	MTC
Tool exchange	PowerCard
Type of product	Indexable insert cutter

## Accessories

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