

Garant

Softcut® 90° shoulder mill MTC long, Plain shank, Ø D / number of teeth Z: 32/3 mm



Order data

Order number	215157 32/3
GTIN	4045197349248
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 : 50 mm

Overall length L_{tot} : 250 mm

Shank $\varnothing D_s$ h6: 32 mm

Circular interpolation milling $\varnothing D_{min}$: 45.4 mm

Circular interpolation milling $\varnothing D_{max}$: 62.5 mm

Circular interpolation milling a_p : 1 mm

Technical description

suitable indexable insert	AP.. 1805..
Cutting edge $\varnothing D_c$	32 mm

Shank $\varnothing D_s$ h6	32 mm
Overall length L_{tot}	250 mm
Pack of insert screws	219824 (15IP; 3.8 Nm)
Overhang L_1	50 mm
Number of cutting edges Z	3
Ramping length L for α_{max}	198.2 mm
Circular interpolation milling $\varnothing D_{max}$	62.5 mm
Circular interpolation milling $\varnothing D_{min}$	45.4 mm
Circular interpolation milling a_p	1 mm
Ramping angle α_{max}	2.6 degrees
Shank type	Plain 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	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