

**Garant**
**Softcut® 90° shoulder mill MTC, with bore, Ø D / number of teeth Z: 80/6 mm**

**Order data**

Order number	215160 80/6
GTIN	4045197349330
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 corner 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.

Overall length  $L_{tot}$ : 50 mm

Mounting bore Ø: 27 mm

Circular interpolation milling Ø  $D_{min}$ : 141.5 mm

Circular interpolation milling Ø  $D_{max}$ : 158.5 mm

Circular interpolation milling  $a_p$ : 0.8 mm

Ramping angle  $\alpha_{max}$ : 0.6 degrees

## Technical description

Mounting bore $\varnothing$	27 mm
Pack of insert screws	219808 (15IP; 3.8 Nm)
suitable indexable insert	AP.. 1805..
Overall length $L_{tot}$	50 mm
Cutting edge $\varnothing D_c$	80 mm
Number of cutting edges Z	6
Ramping angle $\alpha_{max}$	0.6 degrees
Circular interpolation milling $a_p$	0.8 mm
Ramping length L for $\alpha_{max}$	859.4 mm
Circular interpolation milling $\varnothing D_{min}$	141.5 mm
Circular interpolation milling $\varnothing D_{max}$	158.5 mm
Series	Softcut®
Shank type	with bore
Setting angle $\kappa$	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

PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 15IP

674252 15IP

Set of insert screws 10-piece	219808
Torque screwdriver, fixed setting set torque 3,8 Nm	211750 3,8