

Garant

Softcut® 90° shoulder millmilling cutter MTC, Weldon shank, Ø D / number of teeth Z: 25/4 mm



Order data

Order number	215560 25/4
GTIN	4045197408952
Item class	210

Description

Version:

High precision indexable face mill with irregular pitch for very smooth cutting, very high precision, and very high metal removal rate. **New generation** of high performance indexable face mills **with special geometry for reduced cutting forces for MTC applications** under **unstable conditions** or **for spindles with low drive power**.

Application:

For end milling to large depths, also into solid. General use in all steels including stainless steels and acid-proof steels.

Spare part:

Pack of insert screws No. 219826 (8IP; 2.2 Nm).

Note:

The insert pocket must be modified when using indexable inserts with a radius greater than 2 mm.

GARANT torque screwdriver TQ No. **211750 size 2.2**, use bit No. **674252 size 8IP**.

Overhang L_i : 49 mm

Overall length L_{tot} : 105 mm

Shank $\varnothing D_s$ h6: 25 mm

Circular interpolation milling $\varnothing D_{min}$: 37.1 mm

Circular interpolation milling $\varnothing D_{max}$: 49.1 mm

Circular interpolation milling a_p : 1.9 mm

Technical description

Shank $\varnothing D_s$ h6	25 mm
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Overall length L_{tot}	105 mm
Pack of insert screws	219826 (8IP; 2.2 Nm)
suitable indexable insert	AP.. 1335..
Cutting edge $\varnothing D_c$	25 mm
Overhang L_1	49 mm
Number of cutting edges Z	4
Ramping length L for α_{max}	117.7 mm
Circular interpolation milling $\varnothing D_{max}$	49.1 mm
Circular interpolation milling $\varnothing D_{min}$	37.1 mm
Circular interpolation milling a_p	1.9 mm
Ramping angle α_{max}	2.9 degrees
Shank type	Weldon shank
Setting angle κ	90 degrees
Milling application	End 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	219826
Torque screwdriver, fixed setting set torque 2,2 Nm	211750 2,2
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 8IP	674252 8IP