

Softcut® 90° shoulder mill MTC, with bore, Ø D / number of teeth Z: 50/6 mm



Order data

Order number	215575 50/6
GTIN	4045197409362
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 face milling to large depths, also slotting. General use in all steels including stainless 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.

Overall length L_{tot} : 40 mm

Mounting bore Ø: 22 mm

Circular interpolation milling \varnothing D_{min}: 87 mm Circular interpolation milling \varnothing D_{max}: 99.1 mm

Circular interpolation milling a_p: 1.8 mm

Ramping angle α_{max} : 0.9 degrees

Technical description

Overall length L_{tot} 40 mm Pack of insert screws 219826 (8IP; 2.2 Nm) Mounting bore \emptyset 22 mm Number of cutting edges Z 6 Ramping angle α_{max} 0.9 degrees Circular interpolation milling a_p 1.8 mm Ramping length L for α_{max} 572.9 mm Circular interpolation milling \emptyset D_{min} 87 mm Circular interpolation milling \emptyset D_{max} 99.1 mm Series Softcut* Shank type with bore 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	Cutting edge Ø D _c	50 mm
Pack of insert screws 219826 (8IP; 2.2 Nm) Mounting bore Ø 22 mm Number of cutting edges Z Ramping angle α _{max} 0.9 degrees Circular interpolation milling a _p Ramping length L for α _{max} 572.9 mm Circular interpolation milling Ø D _{min} 87 mm Circular interpolation milling Ø D _{max} 99.1 mm Series Softcut* Shank type with bore Setting angle κ 90 degrees Milling application Milling application Milling application Milling application Milling application Spacing of the cutters Through-coolant yes Machining strategy MTC Tool exchange	suitable indexable insert	AP 1335
Mounting bore Ø 22 mm Number of cutting edges Z 6 Ramping angle αmax 0.9 degrees Circular interpolation milling ap 1.8 mm Ramping length L for αmax 572.9 mm Circular interpolation milling Ø Dmin 87 mm Circular interpolation milling Ø Dmax 99.1 mm Series Softcut® Shank type with bore 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	Overall length L _{tot}	40 mm
Number of cutting edges Z Ramping angle α_{max} O.9 degrees Circular interpolation milling a_p 1.8 mm Ramping length L for α_{max} 572.9 mm Circular interpolation milling \varnothing D _{min} Circular interpolation milling \varnothing D _{max} 99.1 mm Series Softcut* Shank type with bore Setting angle κ 90 degrees Milling application End milling Milling application Circular milling Milling application Ramping Spacing of the cutters Inough-coolant yes Machining strategy MTC Tool exchange	Pack of insert screws	219826 (8IP; 2.2 Nm)
Ramping angle α_{max} Circular interpolation milling a_p 1.8 mm Ramping length L for α_{max} 572.9 mm Circular interpolation milling \varnothing D _{min} 87 mm Circular interpolation milling \varnothing D _{max} 99.1 mm Series Softcut® Shank type with bore Setting angle κ 90 degrees Milling application End milling Milling application Ramping Spacing of the cutters Machining strategy MTC Tool exchange	Mounting bore Ø	22 mm
Circular interpolation milling a_p 1.8 mm Ramping length L for α_{max} 572.9 mm Circular interpolation milling \varnothing D _{min} 87 mm Circular interpolation milling \varnothing D _{max} 99.1 mm Series Softcut® Shank type with bore 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	Number of cutting edges Z	6
Ramping length L for α _{max} Circular interpolation milling Ø D _{min} Circular interpolation milling Ø D _{max} Series Softcut® Shank type Setting angle κ 90 degrees Milling application Milling application Ramping Spacing of the cutters Machining strategy MTC Tool exchange S72.9 mm 572.9 mm 572.9 mm 572.9 mm 572.9 mm 677.9 mm 877 mm 99.1 mm Softcut® Sof	Ramping angle α_{max}	0.9 degrees
Circular interpolation milling \varnothing D _{min} 87 mmCircular interpolation milling \varnothing D _{max} 99.1 mmSeriesSoftcut®Shank typewith boreSetting angle κ 90 degreesMilling applicationEnd millingMilling applicationCircular millingMilling applicationRampingSpacing of the cuttersunequal spacingThrough-coolantyesMachining strategyMTCTool exchangePowerCard	Circular interpolation milling a _p	1.8 mm
Circular interpolation milling Ø D _{max} 99.1 mm Series Softcut® Shank type with bore 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	Ramping length L for α_{max}	572.9 mm
Series Softcut® Shank type with bore 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	Circular interpolation milling Ø D _{min}	87 mm
Shank type with bore 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	Circular interpolation milling Ø D _{max}	99.1 mm
Setting angle k Milling application Milling application Milling application Circular milling Ramping Spacing of the cutters Through-coolant Machining strategy Tool exchange 90 degrees 90 degrees 90 degrees 40 milling Lind milling Ramping Vircular milling Ramping Unequal spacing yes MTC PowerCard	Series	Softcut [®]
Milling application Milling application Milling application Milling application Spacing of the cutters Through-coolant Machining strategy Tool exchange End milling Circular milling Ramping unequal spacing yes MTC PowerCard	Shank type	with bore
Milling application Milling application Ramping Spacing of the cutters Through-coolant Machining strategy Tool exchange Circular milling Ramping unequal spacing yes MTC PowerCard	Setting angle κ	90 degrees
Milling application Ramping Spacing of the cutters unequal spacing Through-coolant yes Machining strategy MTC Tool exchange PowerCard	Milling application	End milling
Spacing of the cutters Through-coolant Machining strategy Tool exchange unequal spacing yes MTC PowerCard	Milling application	Circular milling
Through-coolant yes Machining strategy MTC Tool exchange PowerCard	Milling application	Ramping
Machining strategy MTC Tool exchange PowerCard	Spacing of the cutters	unequal spacing
Tool exchange PowerCard	Through-coolant	yes
J	Machining strategy	MTC
Type of product Indexable insert cutter	Tool exchange	PowerCard
	Type of product	Indexable insert cutter

Accessories

PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 8IP

674252 8IP

Data sheet



Set of insert screws 10-piece	219826
Torque screwdriver, fixed setting set torque 2,2 Nm	211750 2,2