

Garant

Softcut® 90° shoulder mill MTC long, Plain shank, Ø D / number of teeth Z: 20/4L mm



Order data

Order number	215609 20/4L
GTIN	4045197409867
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. Suitable inserts APMT 0602..**

Application:

For shoulder milling to large depths, also slotting. General use in all steels including stainless and acid-resistant steels.

Spare part:

Pack of insert screws No. 219827 (6IP; 0.45 Nm).

Note:

GARANT torque screwdriver TQ No. **211750 size 0.45**, use bit No. **674252 size 6IP**.

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

Overhang L_1 : 25 mm

Overall length L_{tot} : 200 mm

Shank $\varnothing D_s$ h6: 18 mm

Circular interpolation milling $\varnothing D_{min}$: 32.3 mm

Circular interpolation milling $\varnothing D_{max}$: 39.3 mm

Circular interpolation milling a_p : 0.9 mm

Technical description

Overall length L_{tot}	200 mm
Pack of insert screws	219827 (6IP; 0.45 Nm)
Shank $\varnothing D_s$ h6	18 mm

Overhang L_1	25 mm
suitable indexable insert	AP.. 0602..
Cutting edge $\varnothing D_c$	20 mm
Number of cutting edges Z	4
Ramping length L for α_{max}	171.4 mm
Circular interpolation milling $\varnothing D_{max}$	39.3 mm
Circular interpolation milling $\varnothing D_{min}$	32.3 mm
Circular interpolation milling a_p	0.9 mm
Ramping angle α_{max}	1.3 degrees
Shank type	Plain shank
Setting angle κ	90 degrees
Milling application	End milling
Milling application	Ramping
Milling application	Circular milling
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	219827
PrecisionBit for Torx Plus®, shank E 6.3 Torx Plus® profile 6IP	674252 6IP
Torque screwdriver, fixed setting set torque 0,45 Nm	211750 0,45