

## Garant

**Softcut® 90° shoulder mill MTC long, Plain shank, Ø D / number of teeth Z:  
25/7S mm**



### Order data

Order number	215609 25/7S
GTIN	4045197708120
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  $L_1$ : 30 mm

Overall length  $L_{tot}$ : 180 mm

Shank  $\varnothing D_s$  h6: 16 mm

Circular interpolation milling  $\varnothing D_{min}$ : 42.3 mm

Circular interpolation milling  $\varnothing D_{max}$ : 49.3 mm

Circular interpolation milling  $a_p$ : 0.9 mm

### Technical description

Cutting edge $\varnothing D_c$	25 mm
Overall length $L_{tot}$	180 mm
Overhang $L_1$	30 mm

Shank $\varnothing D_s$ h6	16 mm
Pack of insert screws	219827 (6IP; 0.45 Nm)
suitable indexable insert	AP.. 0602..
Number of cutting edges Z	7
Ramping length L for $\alpha_{max}$	237.7 mm
Circular interpolation milling $\varnothing D_{max}$	49.3 mm
Circular interpolation milling $\varnothing D_{min}$	42.3 mm
Circular interpolation milling $a_p$	0.9 mm
Ramping angle $\alpha_{max}$	1 degrees
Shank type	Plain shank
Setting angle $\kappa$	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

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