

Garant**Softcut® shoulder mill with thread, for indexable inserts AO..****Order data**

Order number	215409 32/4
GTIN	4069515038751
Item class	210

Description**Version:**

High precision square shoulder mill with irregular pitch for very smooth cutting, very high precision and cutting power. **With special geometry for reduced cutting forces for MTC applications** under **unstable conditions** or for spindles with low drive power.

Application:

For shoulder milling in large depths, also slotting. General use in all steel materials as well as stainless and acid-resistant steels.

Note:

Use GARANT torque screwdriver TQ No. **211750 size 1.5** with bit No. **674252 size 8IP**.

Technical description

Ø D ₂	28.5 mm
Series	Softcut®
Mounting thread M	M16
Circular interpolation milling Ø D _{min}	52.8 mm
Ø D ₃	20.8 mm
Cutting edge Ø D _c	32 mm
Number of cutting edges Z	4
Set of insert screws	219799 10 (8IP; 1.5 Nm)

Data sheet

Ramping angle $\alpha_{\max}$	2.7 degrees
$\varnothing D_1$ h6	17 mm
Overall length L_{tot}	40 mm
Circular interpolation milling a_p	4 mm
Ramping length L for $\alpha_{\max}$	6.4 mm
Circular interpolation milling $\varnothing D_{\max}$	61.3 mm
suitable indexable insert	AO.T1104
Shank type	with thread
Setting angle κ	90 degrees
Milling application	End milling
Milling application	Circular milling
Milling application	Ramping
Milling application	Plunging
Spacing of the cutters	unequal spacing
Through-coolant	yes
Machining strategy	MTC
Tool exchange	PowerCard
Type of product	Indexable end mill

Suitable products

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