

Garant**Softcut® shoulder mill with Weldon shank, for indexable inserts AP..****Order data**

Order number	215560 25/4
GTIN	4045197408952
Item class	210

Description**Version:**

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

Application:

For shoulder 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**.

Technical description

Shank Ø D _s h6	25 mm
Overall length L _{tot}	105 mm
Set of insert screws	219826 (8IP; 2.2 Nm)
suitable indexable insert	AP.. 1335..
Cutting edge Ø D _c	25 mm
Overhang L ₁	49 mm

Number of cutting edges Z	4
Ramping length L for $\alpha_{\max}$	19.5 mm
Circular interpolation milling $\varnothing D_{\max}$	48 mm
Circular interpolation milling $\varnothing D_{\min}$	47 mm
Circular interpolation milling a_p	1.9 mm
Ramping angle $\alpha_{\max}$	0.88 degrees
Series	Softcut®
$\varnothing D_3$	22 mm
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	End / face mill

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/215560-25/4>