

**NEW**



Member IMC Group

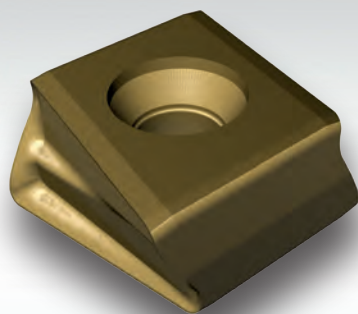
**Ingersoll**  
Cutting Tools

**EVOTECOMAX™**

## Extended Flute End Mill 2EJ4J

- left-hand spiralled -

- high process reliability
- positive rear contact surface
- smooth cutting conditions
- optimum chip removal





## Product Overview

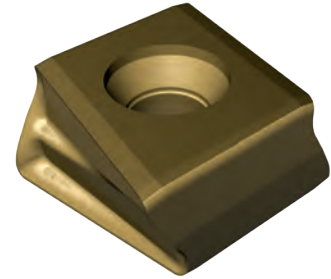
With its tangential design, the extended flute shell end mills of series 2EJ4J presented here, with fully effective l.h. spiral, offers an economic and reliable solution for shoulder milling at the maximum possible stock removal rate and cutting force in spindle direction.

### Indexable Insert:

Thanks to its positive dovetail rake face, the newly developed 4-edged **EvoTecMax** insert DGM324R3... provides high process reliability and avoids extreme tensile loads on the screw head.

The relief angle-reducing chamfer has been reduced by 6° to achieve a radially more positive mounting position and thus a smoother cut. At the same time, the relief angle-reducing chamfer provides a stable cutting edge with a high resistance to chipping.

The minor cutting edge is designed as a so-called wiper, which enables extremely good surface qualities to be achieved, even at higher feed rates.



## Application Features

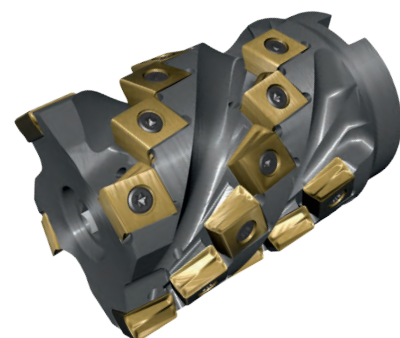
The main areas of use for this new tool series are shoulder milling in the light to medium stock removal range on 90°-shoulders with low lateral engagement.

The additional insert row compared to the series 2EJ3J provides the ideal tooth impact frequency for low lateral stock allowance, while still enabling high feed rates and stock removal rates at cutting conditions with low vibrations.

All tools are equipped with internal coolant supply and ensure, due to the l.h. spiral arrangement of the inserts and fine pitch, optimal milling at low **ae** and traction-sensitive spindle bearings.

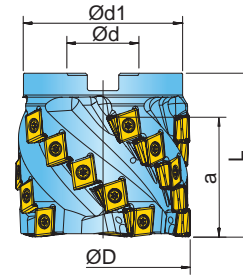
## Benefits

- 4-edged, axially-radially positive tangential insert
- Exact 90° shoulders
- Secondary edge with wiper geometry
- Diameter range 63 - 125 mm
- High stock removal rate
- High process reliability
- Internal coolant supply
- Chipping resistant cutting edge
- State-of-the-art grades



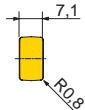
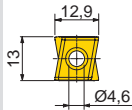
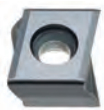
**EVOTECOMAX™ EXTENDED FLUTE END MILL 2EJ4J...F**

ADAPTION ACC. TO DIN 8030

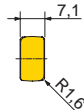
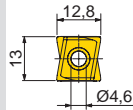


Designation	D	d	d1	L	$\kappa$	a	Z	Z <sub>eff</sub>		
2EJ4J063033F2R00	63	27	55	60	90	33	12	4	✓	0,94
2EJ4J063063F2R00	63	27	55	90	90	63	24	4	✓	1,40
2EJ4J080054F3R00	80	32	73	75	90	54	25	5	✓	2,00
2EJ4J080075F3R00	80	32	73	100	90	75	35	5	✓	2,72
2EJ4J100085F4R00	100	40	92	120	90	85	48	6	✓	5,70
2EJ4J125085F4R00	125	40	114	120	90	85	56	7	✓	9,18

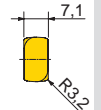
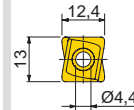
**DGM324R300**



**DGM324R301**



**DGM324R302**



Designation	fz(min/max)	Design	Grade					
				IN2505	IN4015	IN4030	IN4035	IN4040
DGM324R300	0,10/0,25	positive geometry R0,8						
DGM324R301	0,10/0,25	positive geometry R1,6						
DGM324R302	0,10/0,25	positive geometry R3,2						

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



SM40-143-H0 (4,5Nm) DS-T15S

① = Insert screw ② = Screw driver

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