

NEW

Member IMC Group
Ingersoll
Cutting Tools

EVOTECOMAX™

Semi-Finish / Finish Mill EF2J

with new EvoTecMax design

- positive insert seat (dovetail)
- axial and wiper-adjustable indexable insert
- high process reliability
- 90° finishing fully into the corner
- excellent surface quality due to the wiper-finishing geometry





Product Overview

The semi-finish / finish mills of series EF2J presented here are an upgrade to the already known SF2E **SMax** series. The newly developed **EvoTecMax** roughing insert makes high tooth feeds possible with improved reliability.

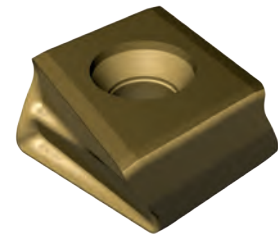
- The tool series covers the diameter range 100 - 315 mm.

Indexable Insert:

The peripheral insert type DGM324R300, used in this tool series, offers 4 r.h. rotating cutting edges in a reliable, tangential mounting position.

Exact 90° shoulders up to a depth of cut of 12 mm allow finishing to be done fully into the corner even on deeper workpiece shoulders.

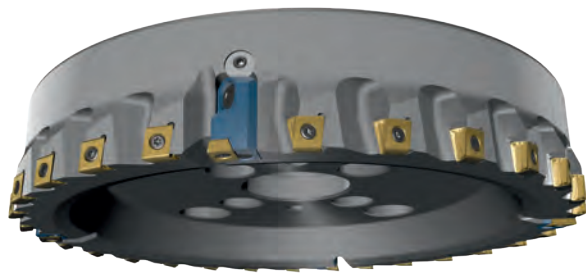
The positive dovetail rake face of the indexable insert minimizes the tensile load on the screw head and keeps the indexable insert securely in its pocket.



Application Features:

The main areas of use for this tool series are milling operations in short and long-chipping materials with a maximum stock removal allowance of 12 mm. The finishing inserts are on axially adjustable cartridges, which make it possible to adjust the run-out and the projection of the finishing edge with respect to the peripheral cutting edges. The indexable inserts YDA323L101 or YDA323L114 can be used as finishing inserts. As on all Ingersoll finish mills, the position of the wiper is adjustable.

A second cartridge is available for use solely as a roughing tool.



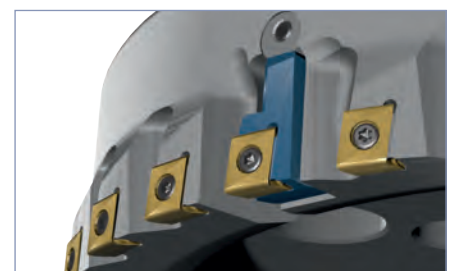
With cartridge 56B183R01
for inserts YDA323L101/L114



With cartridge 5EJ183R00
for insert DGM324R300

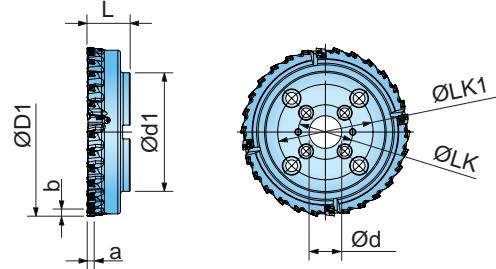
Benefits

- 4-edged, tangential insert
- Exact 90° shoulders
- ap max. 12 mm
- Secondary edge with wiper geometry
- Diameter range 100 - 315 mm
- Axial and wiper-adjustable insert
- High process-reliability thanks to the positive insert pocket



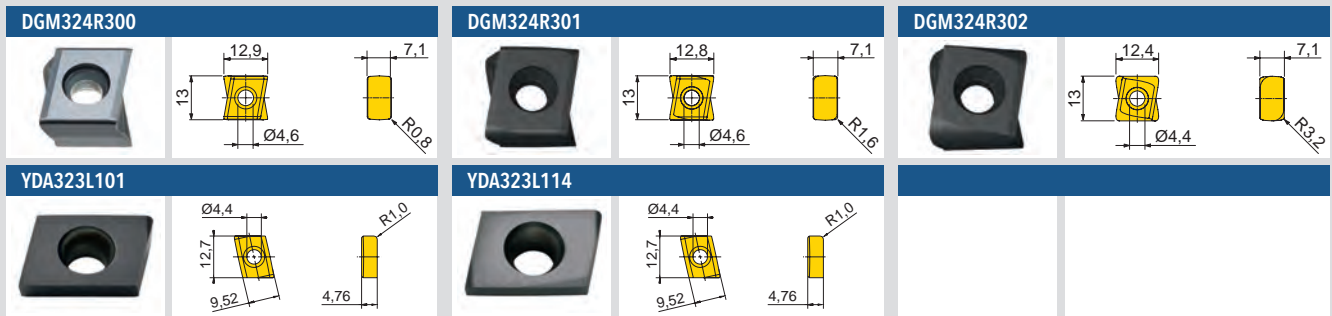
EVOTECOMAX™ SEMI-FINISH / FINISH MILL EF2J

ADAPTION ACC. TO DIN 8030



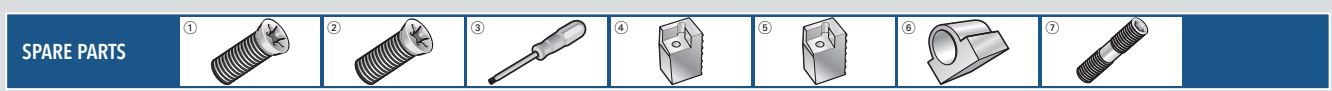
Designation	D	d	d1	LK	LK1	L	κ	a	Z	Z _{eff}	Z _s	kg
EF2J100R00	100	32	80	-	-	50	90	12	8/2	10	2	1,70
EF2J125R00	125	40	100	-	-	63	90	12	10/2	12	2	3,75
EF2J160R00	160	40	130	66,7	-	63	90	12	12/3	15	3	5,20
EF2J200R00	200	60	160	101,6	-	63	90	12	15/3	18	3	8,07
EF2J250R00	250	60	221	101,6	-	63	90	12	20/4	24	4	13,20
EF2J315R00	315	60	221	101,6	177,8	80	90	12	26/4	30	4	26,80

Cutter is supplied with cartridge 56B183R01.



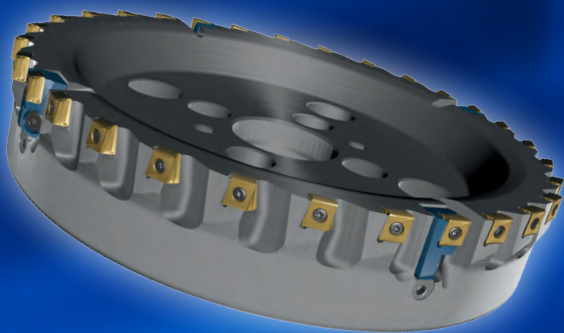
Designation	fz(min/max)	Design	Grade	IN10K	IN0560	IN2010	IN2040	IN2505	IN4015	IN4030	IN4035
DGM324R300	0,10/0,25	positive geometry R0,8						●	●	●	●
DGM324R301	0,10/0,25	positive geometry R1,6						●	●	●	●
DGM324R302	0,10/0,25	positive geometry R3,2						●	●	●	●
YDA323L101	1/5	wiper finishing edge R1,0		●	●	●	●				
YDA323L114	1/5	short wiper finishing edge R1,0		●	●	●	●				

● = P ● = M ● = K ● = N ● = S ○ = H



SM40-143-H0 (4,5Nm) SM40-110-00 (4,5Nm) DS-T15S 56B183R01 5EJ183R00 KR012-002 SB060-01
 ① = Insert screw ② = Insert screw ③ = Screw driver ④ = Cartridge for YDA323... ⑤ = Cartridge for DGM324R300 ⑥ = Circular wedge ⑦ = Differential screw

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