

## **NEW!** **EVOOTEC™**

### The **EVOLution** of **TECHnology!!**



*Ingersoll announces...  
the next generation in the MaxLine family!!*

*Dynamic combination of strength and stability give the words 'Chip Control' a whole new meaning!!! Larger seating surface plus stronger edge equals longer tool life!*

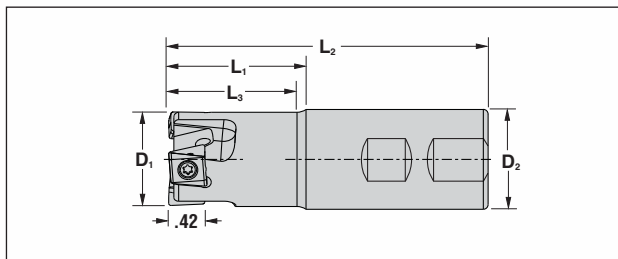


#### **Features & Benefits:**

- DOC capability up to .420".
- Coolant/Air through the tool is available.
- Cutter diameters range from  $\varnothing 1.250$ " thru  $\varnothing 4.00$ ".
- Choice between Medium and High Density cutters.
- Multi-purpose insert geometry for all material types.
- Inserts available in .031", .062", .093", & .125" corner radii.
- Primary land dramatically improves cutting edge strength.
- 4-edged insert offers an economical advantage over 2-edged competition.

• **EVO•TEC™** END MILL SERIES 1SJ1F

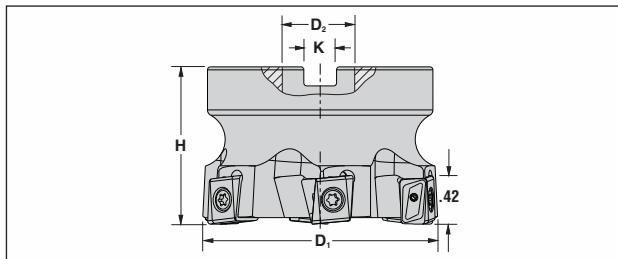
<b>Diameters</b> 1.250"-1.500"	<b>Cutting Edge Length</b> .42"	<b>Insert Corner</b> .031", .062", .093", .125"R
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D <sub>1</sub> Effective Diameter	Part Number	Total Inserts	Effective Inserts	EQ UNEQ	L <sub>1</sub> Extension Length	L <sub>2</sub> Overall Length	L <sub>3</sub> Projection Length	Max DOC	D <sub>2</sub> Shank Style/Size	Coolant Thru
1.250	1SJ1F-1201781R01	3	3	E	1.750	4.000	1.500	0.42	1.250	Yes
1.500	1SJ1F-1501781R01	4	4	E	1.750	4.000	1.750	0.42	1.250	Yes

• **EVO•TEC™** FACE MILL SERIES 1SJ1F

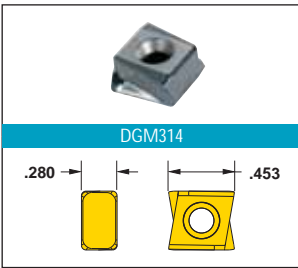
<b>Diameters</b> 2.000"-4.000"	<b>Cutting Edge Length</b> .42"	<b>Insert Corner</b> .031", .062", .093", .125"R
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D <sub>1</sub> Effective Diameter	Part Number	Total Inserts	Effective Inserts	EQ UNEQ	H Height	D <sub>2</sub> Bore Diameter	Max DOC	Retention Bolt	K Keyway	Coolant Thru
2.000	SJ6F-02R01	5	5	U	1.570	0.750	0.42	SD-06-46	0.32	Yes
2.500	SJ6F-02R02	6	6	U	1.570	0.750	0.42	SD-06-46	0.32	Yes
3.000	SJ6F-03R01	6	6	U	2.375	1.000	0.42	SD-08-47	0.38	Yes
3.000	SJ5F-03R01	8	8	U	2.375	1.000	0.42	SD-08-47	0.38	Yes
4.000	SJ6F-04R01	6	6	U	2.375	1.500	0.42	SD-12-89	0.63	Yes
4.000	SJ5F-04R01	9	9	U	2.375	1.500	0.42	SD-12-89	0.63	Yes

• **EVOOTEC™** INSERTS FOR END MILLS AND FACE MILLS

INSERTS



Insert Number	Application	Corner	Grades					
			IN	2005	2015	2030	2040	6515
DGM314R001	Multi-Purpose	4 x .031R	•	•	•	•	•	
DGM314R002	Multi-Purpose	4 x .062R	•	•	•	•	•	
DGM314R003	Multi-Purpose	4 x .093R	•					
DGM314R004	Multi-Purpose	4 x .125R	•	•	•	•	•	

• **EVOOTEC™** HARDWARE FOR END MILLS AND FACE MILLS

HARDWARE

Insert Screw			Wrench
Part No.	Description	Torque	Part No.
SM35-114-H0	M3.5 x .6 x .449	25-30 in. lbs.	DS-T15T

• **EVOOTEC™** TECHNICAL INFORMATION

Series 1SJ1F, SJ5F, SJ6F		Brinell Hardness	SFM	Feed per Insert	Grades						Coolant
Material					IN095S	IN2005	IN2015	IN2030	IN2040	IN6515	
Cast Iron	Gray	150-250	400-750	.005-.012		1	3	2	No		
	Nodular		300-650								
Steel	Low Carbon 1018, 8620	100-250	400-850	.005-.012	1	3	2		No		
	High Carbon F-6180	250-400	300-500								
	Alloyed Steel 4140, 4340	150-300	300-600								
	Tool Steel A-6, D-1, D-2	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300-600	.005-.012	2	1			May not be required at high speeds		
	400 Series 15-5 PH	-	350-700								
	13-8 PH	-	200-400								
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-150	.004-.008	2	1			Yes		
Titanium	6AL-4V, TI-10-2-3, TI-5553	-	75-200	.004-.008	1	2			Yes		