

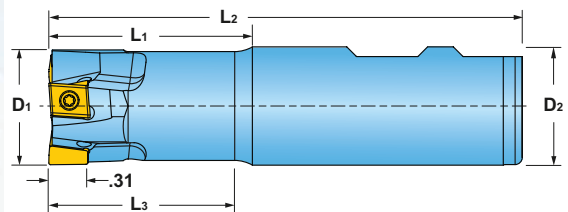
## Ingersoll is proud to announce the latest addition to the Evo-Tec family...

- Diameters from Ø.75" thru Ø3.00"
- Multiple densities and extension lengths with coolant through
- Chip Surfer style, TopOn style, Weldon style, and Shell Mill style
- Large rest pad provides stable seating in DOC to .310"
- 4 indexable insert available in .015", .031", & .062" corner rad



### **EVO•TEC<sup>MINI</sup>** SERIES 1SJ1Y

EVO-TEC END MILL

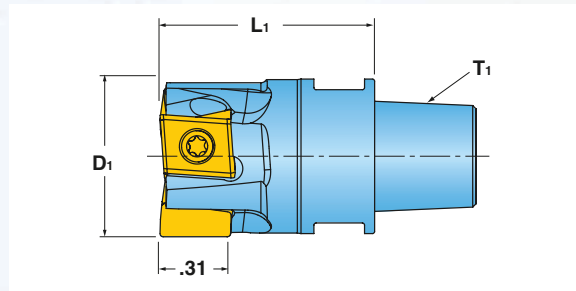


Cutter Number	D1 Eff. Dia.	Number of Inserts	Number of Effective Inserts	L1 Extension Length	L2 Overall Length	L3 Projection Length	Max DOC	D2 Shank Size/Style	Coolant Thru
1SJ1Y-0701284R01	0.750	2	2	1.25	3.25	1.06	0.31	.750" Weldon	Yes
1SJ1Y-0701280R02	0.750	3	3	1.25	3.50	0.95	0.31	1.000" Weldon	Yes
1SJ1Y-0701280R01	0.750	2	2	1.25	3.50	0.95	0.31	1.000" Weldon	Yes
1SJ1Y-0702280R01	0.750	2	2	2.25	4.50	1.95	0.31	1.000" Weldon	Yes
1SJ1Y-0703280R01	0.750	2	2	3.25	5.50	2.95	0.31	1.000" Weldon	Yes
1SJ1Y-1001784R01	1.000	3	3	1.75	3.75	1.75	0.31	.750" Weldon	Yes
1SJ1Y-1001780R01	1.000	3	3	1.75	4.00	1.56	0.31	1.000" Weldon	Yes
1SJ1Y-1001780R02	1.000	4	4	1.75	4.00	1.56	0.31	1.000" Weldon	Yes
1SJ1Y-1003280R01	1.000	3	3	3.25	5.50	3.06	0.31	1.000" Weldon	Yes
1SJ1Y-1201784R01	1.250	3	3	1.75	3.75	1.75	0.31	.750" Weldon	Yes
1SJ1Y-1201781R02	1.250	5	5	1.75	4.00	1.56	0.31	1.250" Weldon	Yes
1SJ1Y-1201781R01	1.250	3	3	1.75	4.00	1.56	0.31	1.250" Weldon	Yes
1SJ1Y-1203281R01	1.250	4	4	3.25	5.50	3.06	0.31	1.250" Weldon	Yes
1SJ1Y-1501781R02	1.500	6	6	1.75	4.00	1.75	0.31	1.250" Weldon	Yes
1SJ1Y-1501781R01	1.500	4	4	1.75	4.00	1.75	0.31	1.250" Weldon	Yes
1SJ1Y-1502281R01	1.500	5	5	2.25	4.50	2.25	0.31	1.250" Weldon	Yes



**SERIES 1SJ1Y (CHIP SURFER STYLE)**

EVO-TEC END MILL

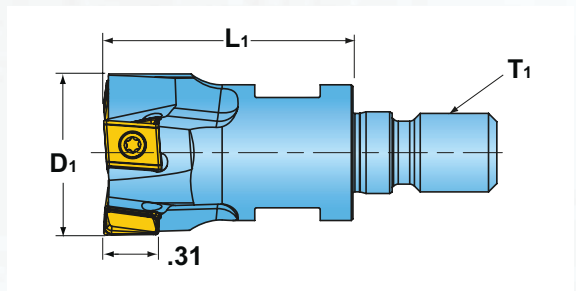


Cutter Number	D1 Nominal Diameter	Adaption	L1 Extension Length	Number of Inserts	Wrench Size
1SJ1Y-07010TSR01	0.750	T12	1.00	3	NA
1SJ1Y-10012TUR01	1.000	T15	1.25	4	NA



**SERIES 1SJ1Y (TOP-ON STYLE)**

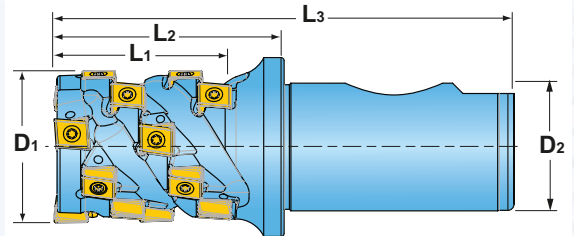
EVO-TEC END MILL



Cutter Number	D1 Nominal Diameter	T1 Adaption	L1 Extension Length	Number of Inserts	Wrench Size
1SJ1Y-07015X6R01	0.750	10mm	1.50	2	15mm
1SJ1Y-07015X6R02	0.750	10mm	1.50	3	15mm
1SJ1Y-10015X7R02	1.000	12mm	1.50	4	17mm
1SJ1Y-10015X7R01	1.000	12mm	1.50	3	18mm
1SJ1Y-12017X8R01	1.250	16mm	1.75	3	22mm
1SJ1Y-12017X8R02	1.250	16mm	1.75	5	22mm
1SJ1Y-15017X8R01	1.500	16mm	1.75	4	22mm
1SJ1Y-15017X8R02	1.500	16mm	1.75	6	22mm

**EVO•TEC<sup>MINI</sup>™ SERIES 2SJ3Y**

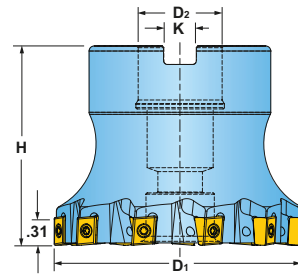
EVO-TEC EXTENDED FLUTE END MILL



Cutter Number	D1 Nom. Dia.	L1 Length of Cut	L2 Extension Length	L3 Overall Length	D2 Shank Size/Style	Number of Effective Flutes	Number of Flutes Total	Number of Inserts
2SJ3Y-1001780R01	1.000	1.14	1.75	4.00	1.000" Weldon w/Flange	2	2	8
2SJ3Y-1201781R01	1.250	1.14	1.75	4.00	1.250" Weldon w/Flange	3	3	12
2SJ3Y-1502281R01	1.500	1.68	2.25	4.50	1.250" Weldon w/Flange	3	3	18

**EVO•TEC<sup>MINI</sup>™ SERIES SJ\_Y**

EVO-TEC FACE MILL

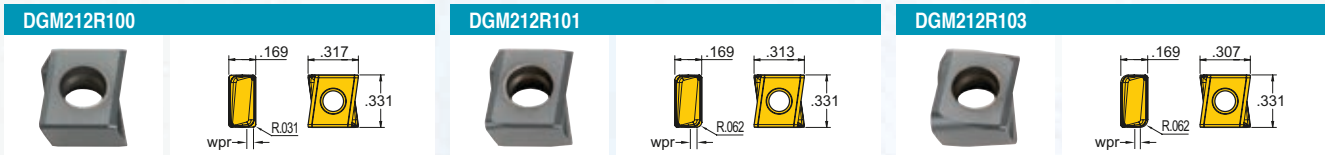


Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Dia.	Retention Bolt	K Keyway
SJ5Y-01R01	1.500	6	1.570	0.500	SD-04-46	0.250
SJ6Y-01R01	1.500	4	1.570	0.500	SD-04-46	0.250
SJ5Y-02R01	2.000	7	1.570	0.750	SD-06-46	0.312
SJ6Y-02R01	2.000	5	1.570	0.750	SD-06-46	0.312
SJ5Y-02R02	2.500	9	1.570	0.750	SD-06-46	0.312
SJ6Y-02R02	2.500	6	1.570	0.750	SD-06-46	0.312
SJ5Y-03R01	3.000	11	2.375	1.000	SD-08-43	0.375
SJ6Y-03R01	3.000	7	2.375	1.000	SD-08-43	0.375



INSERTS FOR END MILLS AND FACE MILLS

INSERTS



Part Number	Applications	Grade	IN2005	IN2015	IN2030					
DGM212R100	Multi-Purpose - 0.015" R									
DGM212R101	Multi-Purpose - 0.031" R									
DGM212R103	Multi-Purpose - 0.062" R									



HARDWARE FOR END MILLS AND FACE MILLS



.750	SM30-074-21	DS-T08W
1.000 - 3.000	SM30-082-21	DS-T08W



OPERATING GUIDELINES

Series 1SJ1Y, SJ_Y, 2SJ3Y				IN2005	IN2015	IN2030	Coolant
Material	Brinnell Hardness	SFM	Feed per Insert				
Cast Iron	Gray	150 - 250	500 - 1200	.003 - .010	2	1	No
	Nodular		400 - 800				
Steel	Low Carbon 1018, 8620	100 - 250	400 - 850	.003 - .008	1	2	No
	High Carbon F-6180	250 - 400	350 - 650				
	Alloyed Steel 4140	150 - 300	300 - 600				
	Tool Steel A-6, D-1, D-2	Up to 300					
Stainless Steel	300 Series, 304, 316	-	300 - 600	.003 - .006		1	May not be required at high speeds
	400 Series 15-5 PH	-	350 - 700				Yes
	13-8 PH	-	200 - 400				
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-150	.003 - .004		1	Yes
Titanium	6AL-4V	-	75 - 200	.003 - .004		1	Yes