

GOLD•MAX⁴ FFIN™

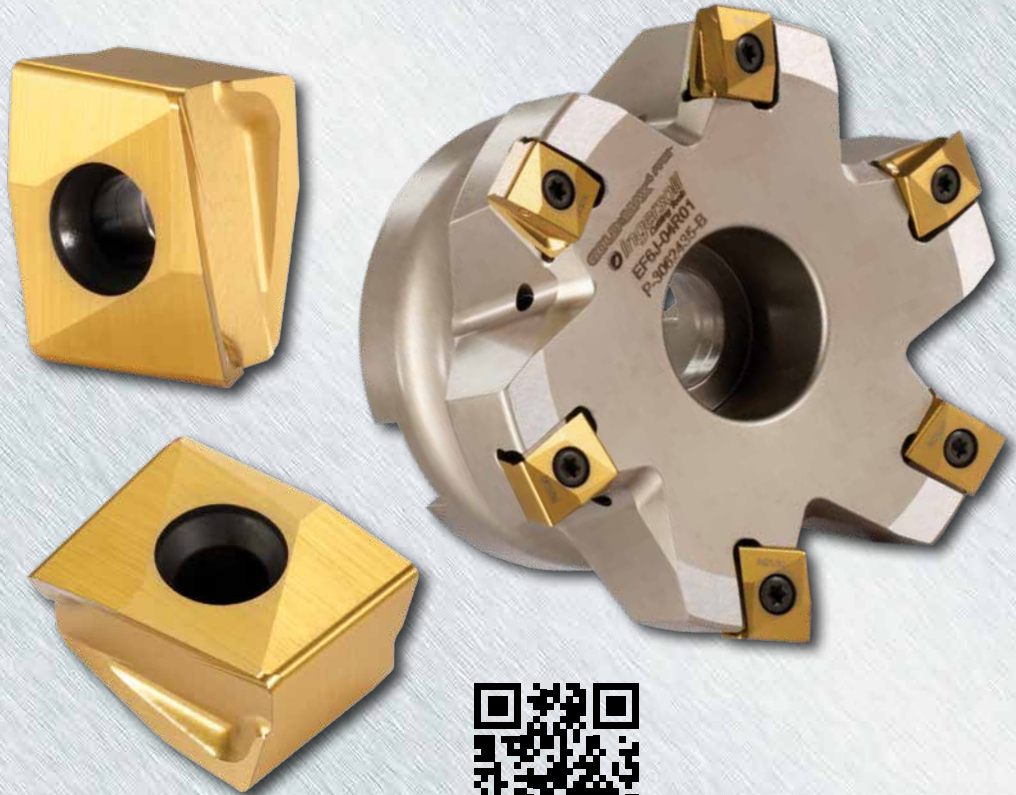


Cutters:
• EF6J Series

Insert:
• DFH324

Grades:
• IN2030
• IN2505
• IN2530
• IN4015
• IN4030

Application:
• Finishing



FINISH MILL

Ingersoll is pleased to announce the arrival of our newest Super-finishing face mill, **GOLD•MAX⁴ FFIN™**

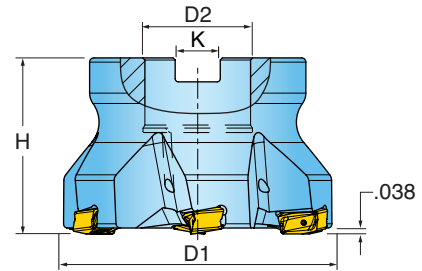
The generous .300" wide crowned wiper provides high quality finishes with superior flatness, eliminating the need for finish grinding operations. While most MicroMill finishing inserts are designed for depths of cut less than .010", the **GOLD•MAX⁴ FFIN™** easily handles depths of cut up to .038".

- Cutter diameters from Ø3.00" thru Ø8.00"
- High precision cutter bodies with tangentially mounted inserts offering (4) insert indexes.
- Micro Finishing possible at 4X's the typical axial depth of cut.
- Large elliptical radius aligns itself to the surface.
- Multiple carbide grades for all material types.

**PRODUCT
ANNOUNCEMENT
• UPDATE •
2019**

SERIES EF6J

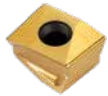
FINISH MILL



Cutter Number	D1 Nom. Diameter	# Effective Inserts	D2 Bore Diameter	D3 Effective Diameter	Max DOC	Bolt Circle	K Keyway	H Height	Coolant Thru	Insert Series
EF6J-03R01	3.000	5	1.000	2.243	0.038	-	0.380	1.750	Yes	DFH324L001
EF6J-04R01	4.000	6	1.500	3.234	0.038	-	0.630	2.500	Yes	DFH324L001
EF6J-05R01	5.000	7	1.500	4.237	0.038	-	0.630	2.500	Yes	DFH324L001
EF6J-06R01	6.000	9	1.500	5.234	0.038	-	0.630	2.500	Yes	DFH324L001
EF6J-08R01	8.000	9	2.500	7.235	0.038	4.000	1.010	2.500	Yes	DFH324L001

INSERTS

DFH324



Insert Number	Corner Configuration	Application	Grade					
				IN2030	IN2505	IN2530	IN4015	IN4030
DFH324L001	4 X .030" R	Finishing		X	X	X	X	X

HARDWARE



Screw



Driver



Retention Bolt



Coolant Plate



Coolant Plate Screw

EF6J-03R01	SM40-143-H0	DS-T15T	SD-08-46	-	-			
EF6J-04R01	SM40-143-H0	DS-T15T	SD-12-82	-	-			
EF6J-05R01	SM40-143-H0	DS-T15T	SD-12-82	-	-			
EF6J-06R01	SM40-143-H0	DS-T15T	SD-12-82	-	-			
EF6J-08R01	SM40-143-H0	DS-T15T	SD-10-70	CZ-0187	SE03-66			

OPERATING GUIDELINES

Material		Brinell Hardness	SFM	Feed per Insert	IN2030	IN2505	IN2530	IN4015	IN4030	Coolant
Cast Iron	Gray	150 - 250	400 - 750	.020 - .030		2		1	3	No
	Nodular		300 - 650							
Steel	Low Carbon 1018, 8620	100 - 250	400 - 850	.010 - .030	3	4	1	5	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	.010 - .030	3		1		2	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	.0005 - .020	3		1		2	Yes
Titanium	6AL-4V, TI-10-2-3, TI-5553	-	75 - 200	.010 - .030	3		2		1	Yes

TECHNICAL INFORMATION

