

# GOLD•MAX<sup>4</sup> FFIN™



**Cutters:**  
• EF6J Series

**Insert:**  
• DFH324

**Grades:**  
• IN2030  
• IN2505  
• IN2515  
• IN2530  
• IN4015  
• IN4030

**Application:**  
• Finishing



## FINISH MILL

Ingersoll is pleased to announce the arrival of our newest Super-finishing face mill, **GOLD•MAX<sup>4</sup> 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•MAX<sup>4</sup> FFIN™** easily handles depths of cut up to .040".

- Cutter diameters from Ø2.00" 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.

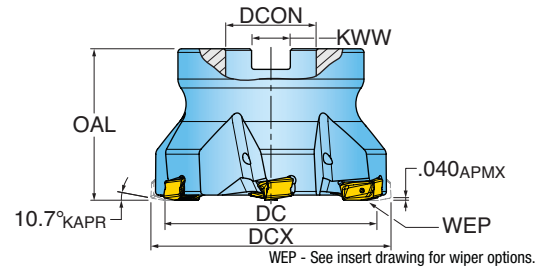
**PRODUCT  
ANNOUNCEMENT  
• UPDATE •  
2019**

## SERIES EF6J

### FINISH MILL



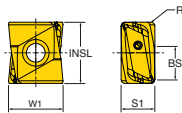
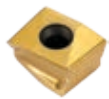
Facing



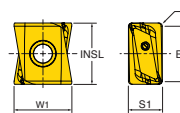
Cutter Number	DCX Cutting Dia. Max.	Effective Inserts	DCON Bore Dia.	DC Eff. Dia.	APMX Max DOC	Bolt Circle	KWW Keyway	OAL Height	Coolant Thru	Insert Series
EF6J-02R01	2.000	4	.750	1.243	0.040	-	0.312	1.750	Yes	DFH324L
EF6J-03R01	3.000	5	1.000	2.243	0.040	-	0.380	1.750	Yes	DFH324L
EF6J-04R01	4.000	6	1.500	3.234	0.040	-	0.630	2.500	Yes	DFH324L
EF6J-05R01	5.000	7	1.500	4.237	0.040	-	0.630	2.500	Yes	DFH324L
EF6J-06R01	6.000	9	1.500	5.234	0.040	-	0.630	2.500	Yes	DFH324L
EF6J-08R01	8.000	9	2.500	7.235	0.040	4.000	1.010	2.500	Yes	DFH324L

## INSERTS

### DFH324L001



### DFH324L205



Insert Number	Application	RE Corner Radius	INSL Length	S1 Thickness	W1 Width	BS Wiper	Grade	IN2030	IN2505	IN2515	IN2530	IN4015	IN4030
DFH324L001	Finishing	4 X .030" R	.571	.315	.507	.300		X	X		X	X	X
DFH324L205	Finishing	4 X .030" R	.571	.315	.538	.500			X	X	X	X	X

## HARDWARE



Screw



Driver



Retention Bolt



Coolant Plate



Coolant Plate Screw

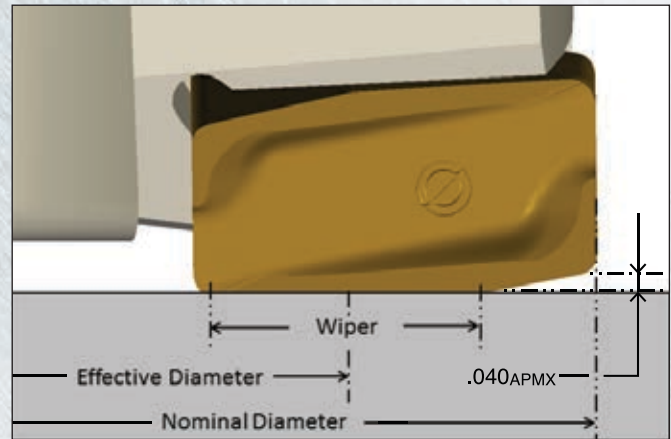
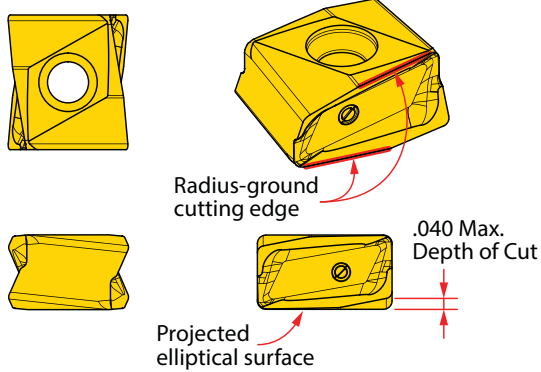
EF6J-03R01	SM40-143-H0	DS-T15T	SD-08-46	-	-
EF6J-04R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-05R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-06R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-08R01	SM40-143-H0	DS-T15T	SD-10-70	CZ-0187	SE03-66

## OPERATING GUIDELINES

Material	Brinnell 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	.005 - .020	3		1	2	Yes	
Titanium	6AL-4V, Ti-10-2-3, Ti-5553	-	75 - 200	.010 - .030	3		2	1	Yes	

## TECHNICAL INFORMATION

DFH324L001



DFH324L205

