

GOLD MAX⁴



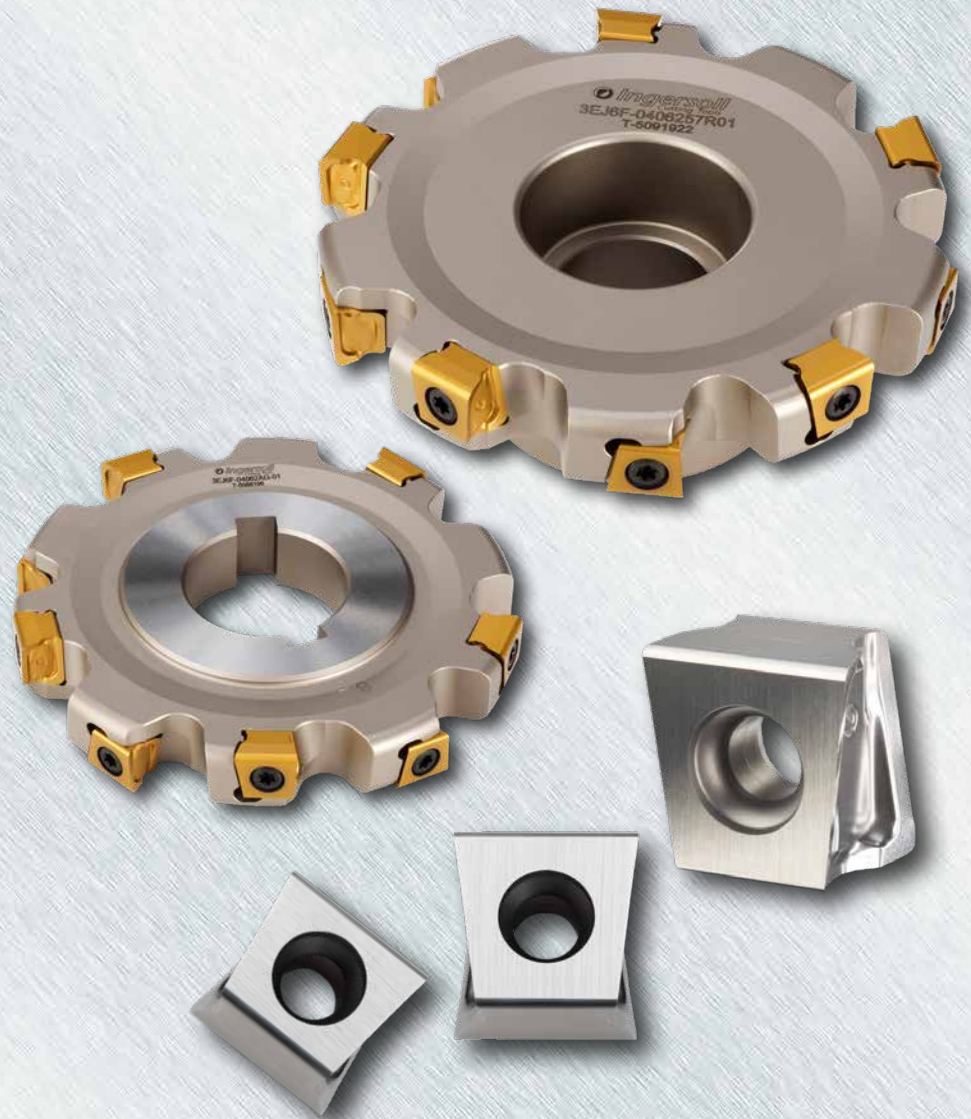
Diameters:
4.00" - 10.00"

Widths:
.625", .750", 1.000"

Mounting:
Axial and Radial Drive

Corner Radii:
.031, .062, .093, .125"

Grades:
IN05S
IN2530
IN4005
IN4015
IN4030



**PRODUCT
ANNOUNCEMENT
UPDATE
2018**

Tangential Technology Perfectly Applied

Features & Benefits

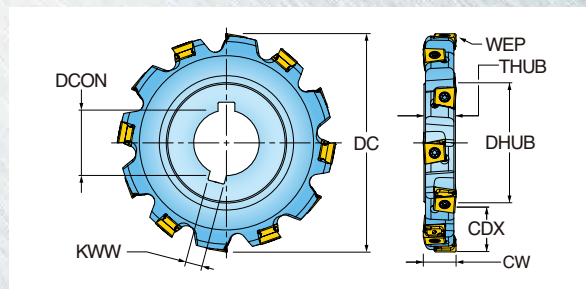
- New upsharp and polished inserts combined with IN05S grade maximizes tool life and productivity in aluminum applications
- Neutral hand inserts provide 2 right hand and 2 left hand cutting edges fitting all pockets
- Optimized insert grade selection
- Precise width adjustment with tailor-made specials

SERIES 3EJ6

HEAVY DUTY AXIAL DRIVE SLOTTED



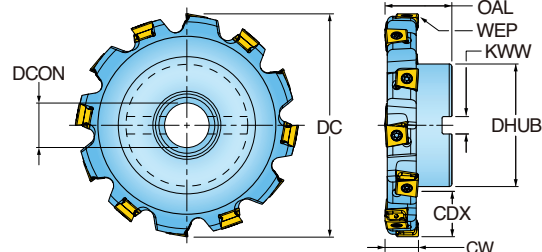
Slotting



Part Number	DC Cutting Dia.	CW Cutting Width	CDX Cutting Depth Max.	ZEP Effective Teeth	ZNP Insert Count	DHUB Hub Dia.	THUB Hub Thickness	DCON Bore Dia.	KWW Keyway	Insert Series
3EJ6F-04062AG-01	4.000	0.625	0.87	5	10	2.25	0.595	1.250	0.312	DGM315
3EJ6J-04075AG-01	4.000	0.750	0.87	5	10	2.25	0.720	1.250	0.312	DGM325
3EJ6F-05062AH-01	5.000	0.625	1.12	6	12	2.75	0.595	1.500	0.375	DGM315
3EJ6J-05075AH-01	5.000	0.750	1.12	6	12	2.75	0.720	1.500	0.375	DGM325
3EJ6M-05100AH-01	5.000	1.000	1.12	5	10	2.75	0.970	1.500	0.375	DGM426
3EJ6F-06062AH-01	6.000	0.625	1.25	7	14	3.50	0.595	1.500	0.375	DGM315
3EJ6J-06075AH-01	6.000	0.750	1.25	7	14	3.50	0.720	1.500	0.375	DGM325
3EJ6M-06100AH-01	6.000	1.000	1.25	6	12	3.50	0.970	1.500	0.375	DGM426
3EJ6F-08062AK-01	8.000	0.625	2.25	8	16	3.50	0.595	2.000	0.500	DGM315
3EJ6J-08075AK-01	8.000	0.750	2.25	8	16	3.50	0.720	2.000	0.500	DGM325
3EJ6M-08100AK-01	8.000	1.000	2.25	7	14	3.50	0.970	2.000	0.500	DGM426
3EJ6F-10062AK-01	10.000	0.625	3.25	9	18	3.50	0.595	2.000	0.500	DGM315
3EJ6M-10100AK-01	10.000	1.000	3.25	8	16	3.50	0.970	2.000	0.500	DGM426

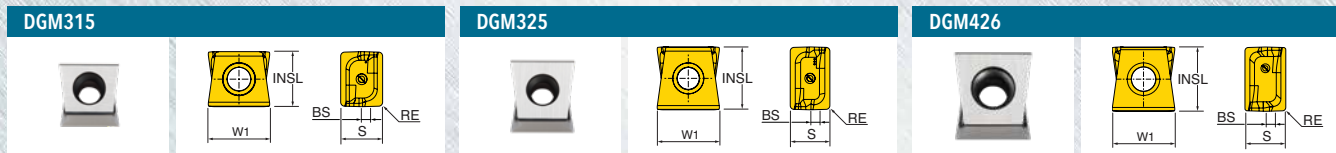
SERIES 3EJ6

HEAVY DUTY RADIAL DRIVE SLOTTED



Part Number	DC Cutting Dia.	CW Cutting Width	CDX Cutting Depth Max.	ZEFP Effective Teeth	ZNP Insert Count	DHUB Hub Dia.	THUB Hub Thickness	DCON Bore Dia.	KWW Keyway	Insert Series
3EJ6F-0406257R01	4.000	0.625	0.97	1.50	5	10	2.00	1.000	0.375	DGM315
3EJ6J-0407557R01	4.000	0.750	0.97	1.50	5	10	2.00	1.000	0.375	DGM325
3EJ6M-0410057R01	4.000	1.000	0.97	1.50	4	8	2.00	1.000	0.375	DGM426
3EJ6F-0506257R01	5.000	0.625	1.10	1.50	6	12	2.75	1.000	0.375	DGM315
3EJ6J-0507557R01	5.000	0.750	1.10	1.50	6	12	2.75	1.000	0.375	DGM325
3EJ6M-0510057R01	5.000	1.000	1.10	1.50	5	10	2.75	1.000	0.375	DGM426
3EJ6F-0606258R01	6.000	0.625	1.60	2.00	7	14	2.75	1.500	0.625	DGM315
3EJ6J-0607558R01	6.000	0.750	1.60	2.00	7	14	2.75	1.500	0.625	DGM325
3EJ6M-0610058R01	6.000	1.000	1.06	2.00	6	12	3.81	1.500	0.625	DGM426
3EJ6F-0806258R01	8.000	0.625	2.06	2.00	8	16	3.81	1.500	0.625	DGM315
3EJ6J-0807558R01	8.000	0.750	2.06	2.00	8	16	3.81	1.500	0.625	DGM325
3EJ6M-0810058R01	8.000	1.000	2.06	2.00	7	14	3.81	1.500	0.625	DGM426
3EJ6F-1006261R01	10.000	0.625	2.53	2.00	9	18	4.87	2.500	1.000	DGM315
3EJ6J-1007561R01	10.000	0.750	2.53	2.00	9	18	4.87	2.500	1.000	DGM325
3EJ6M-1010061R01	10.000	1.000	2.53	2.00	8	16	4.87	2.500	1.000	DGM426

INSERTS & HARDWARE



Part Number	RE/BCH Corner Radius/ Chamfer	BS Wiper Length	INSL Insert Length	W1 Insert Width	S Thickness (To Cutting Edge)	Grade				
						IN055	IN2530	IN4005	IN4015	IN4030
DGM315-001	0.031 R	0.109	0.413	0.461	0.315		•	•	•	•
DGM315-001-P	0.031 R	0.109	0.413	0.461	0.315	•				
DGM315-002	0.062 R	0.076	0.413	0.454	0.315		•	•	•	•
DGM315-002-P	0.062 R	0.076	0.413	0.454	0.315	•				
DGM315-003	0.093 R	0.044	0.413	0.448	0.315		•	•	•	•
DGM315-003-P	0.093 R	0.044	0.413	0.448	0.315	•				
DGM315-004	0.125 R	0.012	0.413	0.441	0.315		•	•		•
DGM315-004-P	0.125 R	0.012	0.413	0.441	0.315	•				
DGM325-001	0.031 R	0.109	0.500	0.494	0.315		•	•	•	•
DGM325-001-P	0.031 R	0.109	0.500	0.494	0.315	•				
DGM325-002	0.062 R	0.076	0.500	0.488	0.315		•	•	•	•
DGM325-002-P	0.062 R	0.076	0.500	0.488	0.315	•				
DGM325-003	0.093 R	0.044	0.500	0.481	0.315		•	•	•	•
DGM325-003-P	0.093 R	0.044	0.500	0.481	0.315	•				
DGM325-004	0.125 R	0.012	0.500	0.475	0.315		•	•	•	•
DGM325-004-P	0.125 R	0.012	0.500	0.475	0.315	•				
DGM426-001	0.031 R	0.108	0.591	0.574	0.375		•	•	•	•
DGM426-001-P	0.031 R	0.108	0.591	0.574	0.375	•				
DGM426-002	0.062 R	0.076	0.591	0.568	0.375		•	•	•	•
DGM426-002-P	0.062 R	0.076	0.591	0.568	0.375	•				
DGM426-003	0.093 R	0.043	0.591	0.561	0.375		•	•	•	•
DGM426-003-P	0.093 R	0.043	0.591	0.561	0.375	•				
DGM426-004	0.125 R	0.011	0.591	0.555	0.375		•	•	•	•
DGM426-004-P	0.125 R	0.011	0.591	0.555	0.375	•				



Screw



Driver

DGM315	SM40-143-H0	DS-T15T
DGM325	SM40-143-H0	DS-T15T
DGM426	SM50-160-10	DS-T20T

OPERATING GUIDELINES

GoldMax4 - Series 3EJ6_					IN055	IN2530	IN4005	IN4015	IN4030	Coolant
	Material	Brinell Hardness	SFM	Feed per Insert						
Non-Ferrous	Aluminum, Brass	-	750+	.006-.016	1		2			Yes
Cast Iron	Gray	150-250	600-850	.005-.015			2	1		No
	Nodular		400-650							
Steel	Low Carbon 1018, 8620	100-250	450-700	.005-.014						No
	High Carbon F-6180	250-400	300-600	.004-.012		2	1			
	Alloyed Steel 4140, 4340	150-300								
	Tool Steel A2, O1, D2, P20	Up to 300	250-400		1			2		
Stainless Steel	300 Series, 304, 316	-	300-500	.004-.012						Yes
	400 Series, 15-5 PH	-	350-600			2			1	
	13-8 PH	-	200-400							
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	60-125	.004-.008		2			1	Yes
Titanium	6-4, 10-2-3, 5-5-5-3	-	75-150	.004-.008		2			1	Yes

PRE-ENGINEERED TAILOR MADE SPECIALS

Max WOC Change	DGM315	DGM325	DGM426
Δ WOC	.125"	.200"	.200"

