

The **EVOLution** Continues!!

NEW! **EVOO TEC™**

Ingersoll introduces...
a new Evo-Tec for
applications when...
"Size Does Matter"



DGM314
.420" DOC



DGM324
.540" DOC



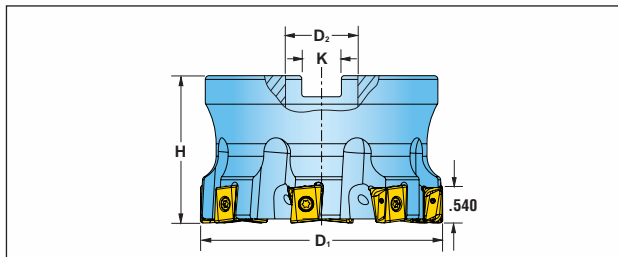
*Same dynamic combination of
insert strength and pocket stability
integrated into a larger, more
aggressive cutting tool solution!*

Features & Benefits

- DOC capability up to .540"
- Coolant/Air through the tool in $\text{Ø}3.00''$ & $\text{Ø}4.00''$
- Replaceable pocket protection in $\text{Ø}5.00''$, $\text{Ø}6.00''$, & $\text{Ø}8.00''$
- Inserts available in .031", .062", .093", & .125" corner radii.
- Multi-purpose insert in carbide grades for all material types.
- 4-edged insert offers an economical advantage over 2-edged competition.
- High shear geometry provides smooth cuts at super-aggressive feed rates.

EVOOTEC™ FACE MILL SERIES SJ_J

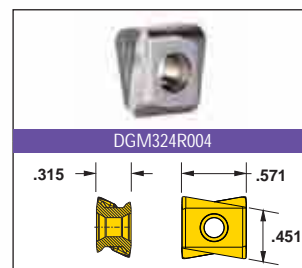
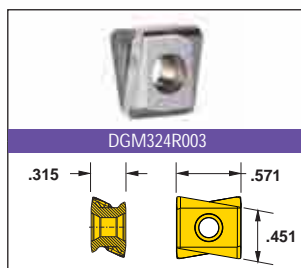
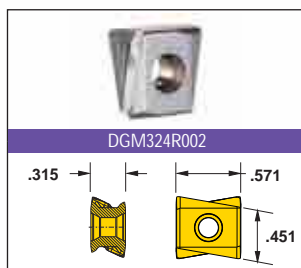
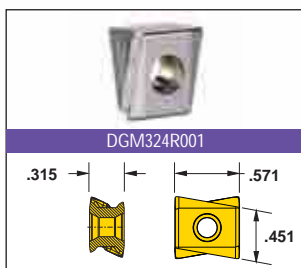
Diameters 3.000"-8.000"
Cutting Edge Length .540"
Insert Corner .031", .062", .093", .125"R



D ₁ Effective Diameter	Part Number	Total Inserts	Effective Inserts	EQ UNEQ	H Height	D ₂ Bore Diameter	Max DOC	Retention Bolt	K Keyway	Coolant Thru
3.000	SJ5J-03R01	7	7	UE	2.375	1.000	0.540	SD-08-47	0.375	Yes
3.000	SJ6J-03R01	5	5	UE	2.375	1.000	0.540	SD-08-47	0.375	Yes
4.000	SJ5J-04R01	8	8	UE	2.375	1.500	0.540	SD-12-82	0.625	Yes
4.000	SJ6J-04R01	6	6	UE	2.375	1.500	0.540	SD-12-82	0.625	Yes
5.000	SJ2J-05R01	7	7	UE	2.375	1.500	0.540	-	0.625	No
6.000	SJ2J-06R01	8	8	UE	2.375	1.500	0.540	-	0.625	No
8.000	SJ2J-08R01	10	10	UE	2.375	2.500	0.540	-	1.000	No

EVOOTEC™ INSERTS

INSERTS



Insert Number	Application	Corner	Grades				
			IN	2005	2015	2030	2040
DGM324R001	Multi-Purpose	4 x .031R	■	■	■	■	■
DGM324R002	Multi-Purpose	4 x .062R	■	■	■	■	■
DGM324R003	Multi-Purpose	4 x .093R	■				
DGM324R004	Multi-Purpose	4 x .125R	■	■	■	■	■

EVOOTEC™ HARDWARE

HARDWARE

Insert & Anvil Screw			Wrench	Anvil
Part No.	Description	Torque	Part No.	Part No.
SM40-140-00	M4.0 x .7 x .551	30-35 in. lbs.	DS-T15T	PAR0646



EVOOTEC™ TECHNICAL INFORMATION

Series SJ_J		Brinell Hardness	SFM	Feed per Insert	Grades						Coolant
Material					IN05S	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							No
	High Carbon F-6180	250-400	300-500								
	Alloyed Steel 4140, 4340	150-300	300-600		1		3	2			
	Tool Steel A-6, D-1, D-2	Up to 300									
Stainless Steel	300 Series, 304, 316	-	300-600	.005-.012							May not be required at high speeds
	400 Series 15-5 PH	-	350-700		2		1				
	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

