



Cutters:
• EF6J Series

Insert:
• DFH324L001
• DFH324L205

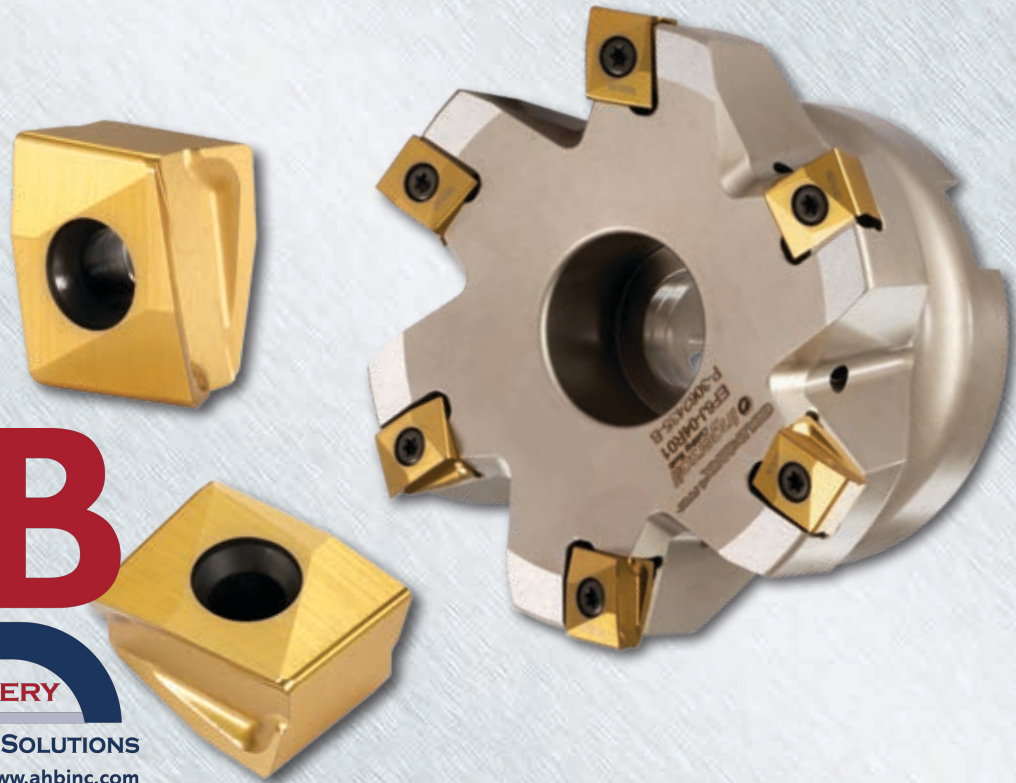
Grades:
• IN2505
• IN2515
• IN2530
• IN4015
• IN4030

Application:
• Finishing

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HIGH-FEED FINISHING FACEMILL

Ingersoll's unique and popular **GOLD^oMAX⁴ FFIN™** finishing facemill now includes a new insert, DFH324L205, for finishing up to a shoulder. This additional insert achieves the same high-quality surface textures and at the same high feedrates. By limiting the depth-of-cut to a maximum of .008" the insert can also be applied for finish face milling of any flat surfaces and at the same operating parameters recommended for the DFH324L001 insert.

Features and Benefits:

- Cutter diameters from Ø2.00" thru Ø8.00"
- Two insert types with four keen cutting edges
- High precision fixed pocket cutters with high precision inserts for attractive, uniform and low Ra finishes (as low as 4 Ra is possible and 8-24 Ra is common).
- Both inserts offer a long elliptical wiper geometry to eliminate mismatch lines.
- All DFH inserts include our newest hone, "Y" hone, and nano-laminate coating technology
- The "FFin" is ideally suited to materials like irons, carbon steels, low alloy steels and titanium.

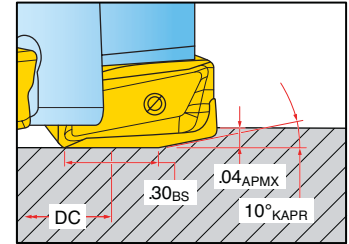
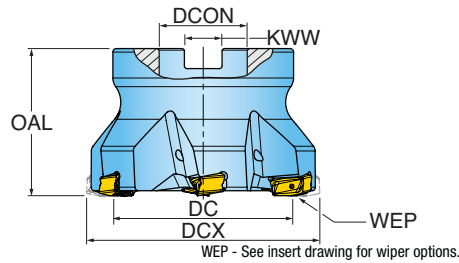
**PRODUCT
ANNOUNCEMENT**
● UPDATE ●
2020

SERIES EF6J

FINISH MILL



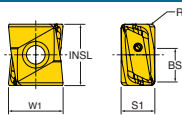
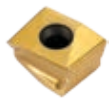
Facing



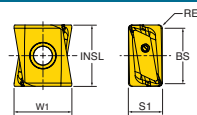
Cutter Number	DCX Cutting Dia. Max.	Effective Inserts	DCON Bore Dia.	DC Eff. Dia.	APMX Max DOC	Bolt Circle	KWW Keyway	OAL Height	Coolant Thru	Insert Series
NEW EF6J-02R01	2.000	4	.750	1.243	0.040	-	0.312	1.750	Yes	DFH324L
EF6J-03R01	3.000	5	1.000	2.243	0.040	-	0.380	1.750	Yes	DFH324L
EF6J-04R01	4.000	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	IN2505	IN2515	IN2530	IN4015	IN4030
DFH324L001	Finishing	4 X .030" R	.571	.315	.507	.300		X		X	X	X
NEW 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

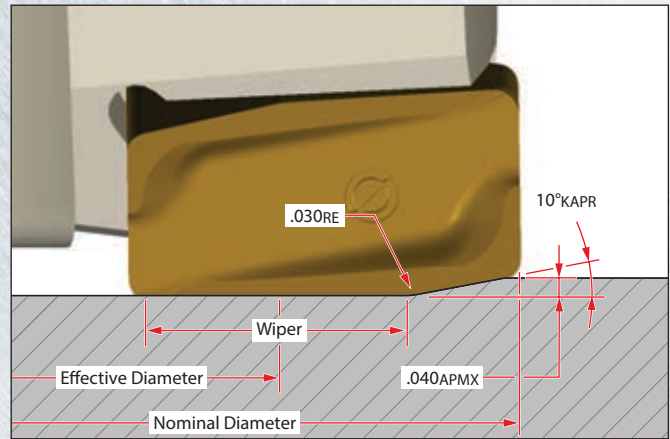
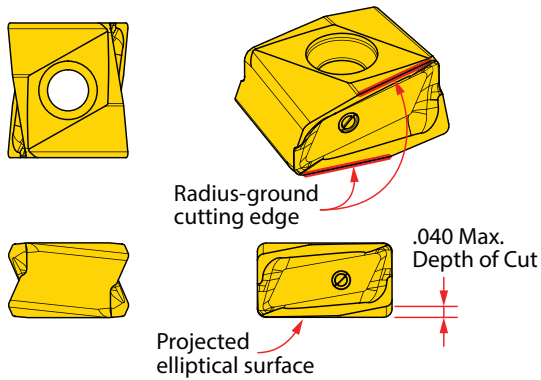
EF6J-03R01	SM40-143-H0	DS-T15T	SD-08-46	-	-
EF6J-04R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-05R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-06R01	SM40-143-H0	DS-T15T	SD-12-82	-	-
EF6J-08R01	SM40-143-H0	DS-T15T	SD-10-70	CZ-0187	SE03-66

OPERATING GUIDELINES

Material	Brinell Hardness	SFM	Feed per Insert	IN2505	IN2515	IN2530	IN4015	IN4030	Coolant	
Cast Iron	Gray	150 - 250	400 - 750	.020 - .030	3	2	4	1	5	No
	Nodular		300 - 650							
Steel	Low Carbon 1018, 8620	100 - 250	400 - 850	.010 - .030	3	5	1	4	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			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			1		2	Yes
Titanium	6AL-4V, Ti-10-2-3, Ti-5553	-	75 - 200	.010 - .030			2		1	Yes

TECHNICAL INFORMATION

DFH324L001



NEW

DFH324L205

