



WINSFEED

MAXSFEED

ULTRA SMALL CGM101 / CGX101
INSERTS AND END MILLS

HIGH PRODUCTIVITY 90° SHOULDER MILL WITH STRONG TANGENTIAL INSERT

- Strong tangential type 4-corner insert •*
- Exact 90 degree shouldering •*
- Optimized geometry for smooth machining and improved stability •*
- Capable of straight and helical ramping machining •*
- Enhanced cutting stability •*



Product Overview

MaxSFeed series with new CGM101 and CGX101 inserts and end mills!

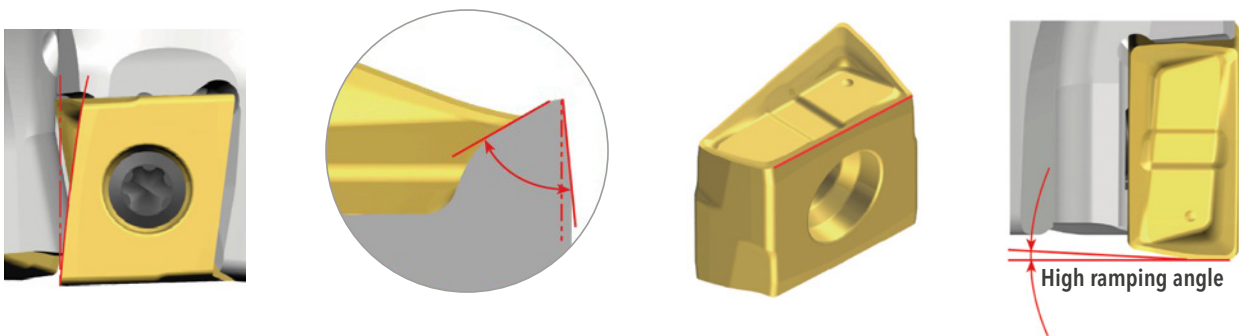
Ingersoll has introduced a **5 mm** small tangential insert for end mills and screw-in type mills of the new **MaxSFeed** product line.

Along with the smaller size end mills, two new inserts have been added; a **CGX101** pressed to size and a **CGM101** precision type.

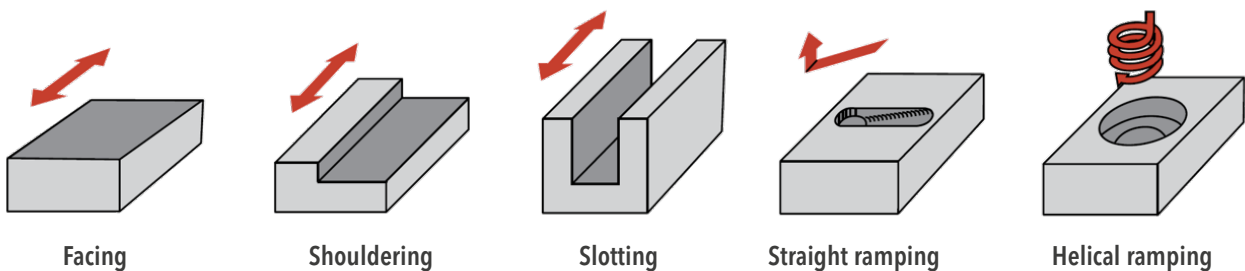
Both inserts along with the end mills and screw-in type mills are available in a **10 to 32 mm** diameter range.

Technical Features & Advantages of Inserts

- Strong double-sided 4 corners tangential insert with helical cutting edges for smooth machining
- Enhanced cutting stability due to the reinforced cutting edge
- Minimum mismatch during step machining due to unique tangential insert design
- Capable of straight and helical ramping machining
- Exact 90 degree shouldering
- Optimized geometry for smooth machining and improved stability

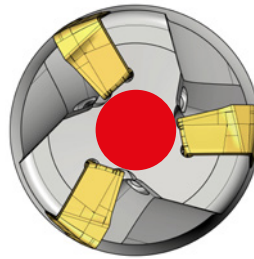


Wide Range of Application

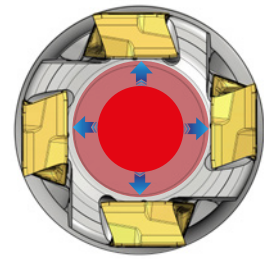


Technical Features & Advantages of Cutters

- Suitable for roughing due to big core design for strong cutter body compared to radial type cutter:



Radial type



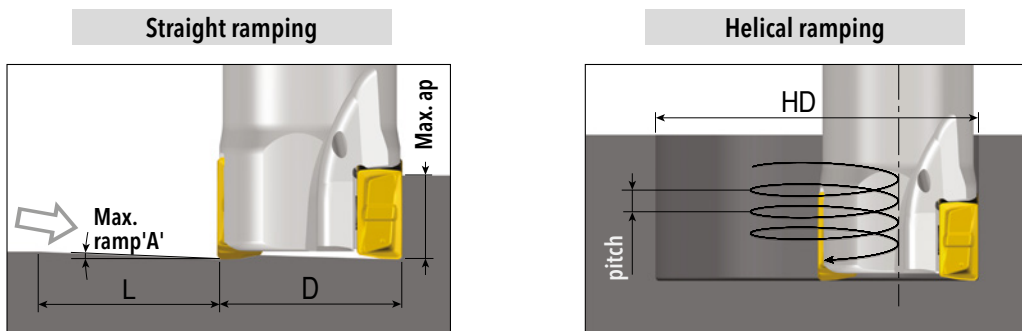
Tangential type
MAXSFEED

- Wide product line-up compared to competitors:

MaxSFeed cutters lineup by diameters:

	Ø10	Ø12	Ø16	Ø20	Ø25	Ø32
NEW CGM(X)101	2z	3z	3z / 4z	4z / 5z	6z	8z

Ramping Data



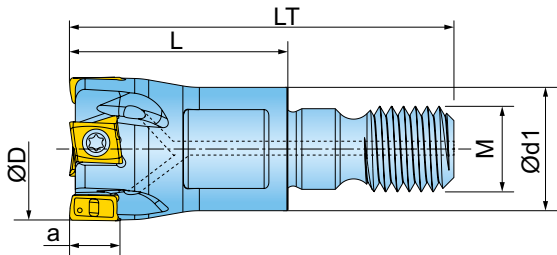
CGM(X)101

(in mm)

Cutter dia. (D)	Straight ramp down			Helical ramp down		
	max. ramp (A°)	max. ap	min. length (L)	min. diameter (HD)	max. diameter (HD)	max. pitch/rev.
Ø10	1,8	4,6	142	16,8	20	0,6 0,9
Ø12	1,5	4,6	176	20,8	24	0,6 0,8
Ø16	1,0	4,6	251	28,8	32	0,6 0,8
Ø20	0,8	4,6	330	36,8	40	0,6 0,7
Ø25	0,6	4,6	439	46,8	50	0,6 0,7
Ø32	0,4	4,6	586	60,8	64	0,6 0,7

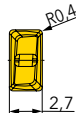
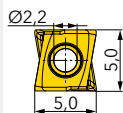
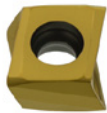
MAXSPEED END MILL 1EJ5A...X

WITH SCREW-IN TYPE ADAPTION

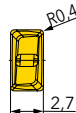
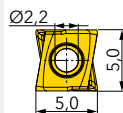
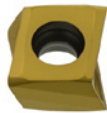


Designation	D	d1	LT	L	a	M	Z			
1EJ5A010017X4R00	10	9,7	31,5	17	4,6	M06	2	1,8	✓	0,085
1EJ5A012017X4R00	12	11	31,5	17	4,6	M06	3	1,5	✓	0,065
1EJ5A016023X5R00	16	13	40,5	23	4,6	M08	4	1,0	✓	0,100
1EJ5A020023X6R00	20	18	43,0	23	4,6	M10	5	0,8	✓	0,105
1EJ5A025027X7R00	25	21	49,0	27	4,6	M12	6	0,6	✓	0,140
1EJ5A032027X8R00	32	29	52,0	27	4,6	M16	8	0,4	✓	0,215

CGX101R001-M



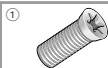
CGM101R001-ML



Designation	fz(min/max)	Design	Grade	IN2505	IN2530					
CGX101R001-M	0,04/0,08	positive geometry R0,4, pressed								
CGM101R001-ML	0,04/0,08	positive geometry R0,4, ground								

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS

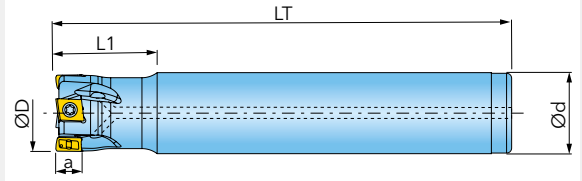


SM18-041-00 (0,5Nm) TXPLUS06x90-B

① = Insert screw ② = Torx bit

MAXSPEED END MILL 1EJ5A...T

ADAPTION ACC. TO DIN 1835 A



Designation	D	d	LT	L	a	Z			
1EJ5A010015T1R00	10	10	80	15	4,6	2	1,8	✓	0,097
1EJ5A012015T2R00	12	12	80	15	4,6	2	1,5	✓	0,115
1EJ5A012015T2R01	12	12	80	15	4,6	3	1,5	✓	0,135

CGX101R001-M			CGM101R001-ML								
Designation	fz(min/max)	Design	Grade	IN2505	IN2530						
CGX101R001-M	0,04/0,08	positive geometry R0,4, pressed									
CGM101R001-ML	0,04/0,08	positive geometry R0,4, ground									

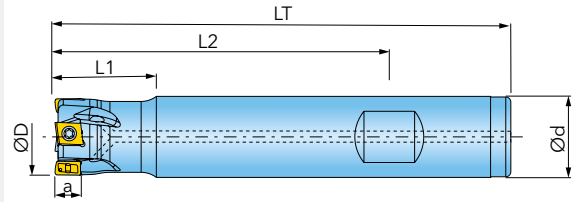
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SPARE PARTS		
	SM18-041-00 (0,5Nm)	TXPLUS06x90-B

① = Insert screw ② = Torx bit

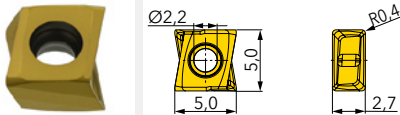
MAXSPEED END MILL 1EJ5A...W

ADAPTION ACC. TO DIN 1835 B

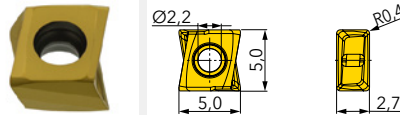


Designation	D	d	LT	L	a	Z			
1EJ5A016020W3R00	16	16	90	20	4,6	3	1,0	✓	0,195
1EJ5A016020W3R01	16	16	90	20	4,6	4	1,0	✓	0,195
1EJ5A020025W4R00	20	20	100	25	4,6	4	0,8	✓	0,285
1EJ5A020025W4R01	20	20	100	25	4,6	5	0,8	✓	0,270
1EJ5A025030W5R00	25	25	110	30	4,6	6	0,6	✓	0,420
1EJ5A032020W5R00	32	25	110	20	4,6	8	0,4	✓	0,485

CGX101R001-M



CGM101R001-ML



Designation	fz(min/max)	Design	Grade	IN2505	IN2530						
CGX101R001-M	0,04/0,08	positive geometry R0,4, pressed									
CGM101R001-ML	0,04/0,08	positive geometry R0,4, ground									

● = P ● = M ● = K ● = N ● = S ○ = H

SPARE PARTS



SM18-041-00 (0,5Nm) TXPLUS06x90-B

① = Insert screw ② = Torx bit

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