i-Xmill END MILLS

XMR110A SERIES
XMR120C SERIES
XMR260T SERIES

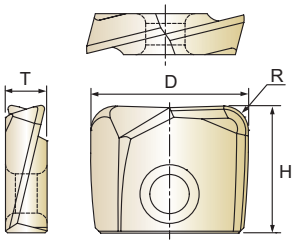
i-Xmill CORNER RADIUS INSERT

i-Xmill WECHSELPLATTE mit GERADER STIRN UND ECKRADIUS
i-Xmill - Plaquette pour usage général et inox
INSERTI IN MD, TORICI

- The optimized geometry of the tool achieves better reliability and less vibration and cutting load.
- Interchangeable with i-Xmill ball holder, but precise cutting is possible with i-Xmill corner radius holder due to higher stability and strength of tool.
- The varied and wide cutting range makes it possible to machine from roughing through to finishing.
- Special coating makes high hardness with high thermal stability against oxidation.

- Die optimale Werkzeuggeometrie für große Betriebssicherheit und geringe Vibration und Schneidendruck.
- Einsetzbar wie i-Xmill Rundplattenhalter, aber eine größere Schnittgenauigkeit ist mit dem Vierkantplattenhalter möglich, wegen der größeren Steifigkeit und Stärke des Werkzeugs.
- Die große Einsatzbreite des Werkzeugs macht den Einsatz sowohl zum Schruppen als auch zum Schlichten möglich.
- Eine spezielle Beschichtung verleiht der Schneide große Härte und Hitzebeständigkeit.





cutting conditions : p.C62

Recommended ToolHolder
Plain Shank
◎ POWER MILLING CHUCK
○ ER COLLET CHUCK

Unit : mm

EDP No. AlTiN	EDP No. XC-Coating	EDP No. Z-Coating	Corner Radius	Mill Diameter	Height	Thickness
General Purpose & Stainless Steels	Pre-Hardened Steels	High Hardened Steels	R	D	H	T
XMR110A080 03	XMR120C080 03	XMR260T080 03	R0.3	8.0	8.0	2.4
XMR110A080 05	XMR120C080 05	XMR260T080 05	R0.5	8.0	8.0	2.4
XMR110A080 10	XMR120C080 10	XMR260T080 10	R1.0	8.0	8.0	2.4
XMR110A080 20	XMR120C080 20	XMR260T080 20	R2.0	8.0	8.0	2.4
XMR110A100 03	XMR120C100 03	XMR260T100 03	R0.3	10.0	9.5	2.7
XMR110A100 05	XMR120C100 05	XMR260T100 05	R0.5	10.0	9.5	2.7
XMR110A100 10	XMR120C100 10	XMR260T100 10	R1.0	10.0	9.5	2.7
XMR110A100 15	XMR120C100 15	XMR260T100 15	R1.5	10.0	9.5	2.7
XMR110A100 20	XMR120C100 20	XMR260T100 20	R2.0	10.0	9.5	2.7
XMR110A100 30	XMR120C100 30	XMR260T100 30	R3.0	10.0	9.5	2.7
XMR110A110 03	XMR120C110 03	XMR260T110 03	R0.3	11.0	9.5	2.7
XMR110A110 05	XMR120C110 05	XMR260T110 05	R0.5	11.0	9.5	2.7
XMR110A110 10	XMR120C110 10	XMR260T110 10	R1.0	11.0	9.5	2.7
XMR110A110 15	XMR120C110 15	XMR260T110 15	R1.5	11.0	9.5	2.7
XMR110A110 20	XMR120C110 20	XMR260T110 20	R2.0	11.0	9.5	2.7
XMR110A110 30	XMR120C110 30	XMR260T110 30	R3.0	11.0	9.5	2.7

▶ The corner radius tolerance is ±0.015mm and the set-up accuracy is ±0.02mm.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
XMR110A	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎						
XMR120C									◎	○	◎				◎	◎	◎	◎	◎	◎
XMR260T																				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
XMR110A																					
XMR120C																		○			
XMR260T																		◎	◎	○	◎

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YG-1 CO., LTD.

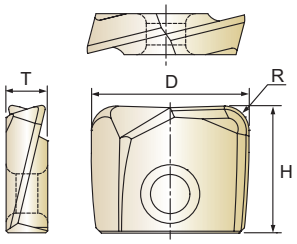
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cutting conditions : p.C62

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

EDP No.			Corner Radius	Mill Diameter	Height	Thickness
AlTiN	XC-Coating	Z-Coating				
General Purpose & Stainless Steels	Pre-Hardened Steels	High Hardened Steels	R	D	H	T
XMR110A120 03	XMR120C120 03	XMR260T120 03	R0.3	12.0	11.0	3.2
XMR110A120 05	XMR120C120 05	XMR260T120 05	R0.5	12.0	11.0	3.2
XMR110A120 10	XMR120C120 10	XMR260T120 10	R1.0	12.0	11.0	3.2
XMR110A120 15	XMR120C120 15	XMR260T120 15	R1.5	12.0	11.0	3.2
XMR110A120 20	XMR120C120 20	XMR260T120 20	R2.0	12.0	11.0	3.2
XMR110A120 30	XMR120C120 30	XMR260T120 30	R3.0	12.0	11.0	3.2
XMR110A130 03	XMR120C130 03	XMR260T130 03	R0.3	13.0	11.2	3.2
XMR110A130 05	XMR120C130 05	XMR260T130 05	R0.5	13.0	11.2	3.2
XMR110A130 10	XMR120C130 10	XMR260T130 10	R1.0	13.0	11.2	3.2
XMR110A130 15	XMR120C130 15	XMR260T130 15	R1.5	13.0	11.2	3.2
XMR110A130 20	XMR120C130 20	XMR260T130 20	R2.0	13.0	11.2	3.2
XMR110A130 30	XMR120C130 30	XMR260T130 30	R3.0	13.0	11.2	3.2
XMR110A160 03	XMR120C160 03	XMR260T160 03	R0.3	16.0	13.0	4.2
XMR110A160 05	XMR120C160 05	XMR260T160 05	R0.5	16.0	13.0	4.2
XMR110A160 10	XMR120C160 10	XMR260T160 10	R1.0	16.0	13.0	4.2
XMR110A160 15	XMR120C160 15	XMR260T160 15	R1.5	16.0	13.0	4.2
XMR110A160 20	XMR120C160 20	XMR260T160 20	R2.0	16.0	13.0	4.2
XMR110A160 30	XMR120C160 30	XMR260T160 30	R3.0	16.0	13.0	4.2

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▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
XMR110A	◎	◎	◎	◎	◎	◎	◎	◎		○		◎	◎	◎						
XMR120C									◎	◎	◎				◎	◎	◎	◎	◎	◎
XMR260T																				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
XMR110A																					
XMR120C																		○			
XMR260T																		◎	◎	○	◎

i-Xmill END MILLS

XMR110A SERIES
XMR120C SERIES
XMR260T SERIES

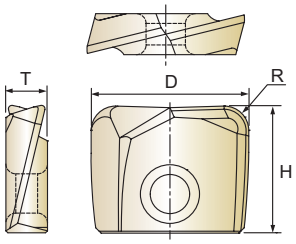
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cutting conditions : p.C62

Recommended ToolHolder
Plain Shank
◎ POWER MILLING CHUCK
○ ER COLLET CHUCK

Unit : mm

EDP No. AlTiN	EDP No. XC-Coating	EDP No. Z-Coating	Corner Radius	Mill Diameter	Height	Thickness
General Purpose & Stainless Steels	Pre-Hardened Steels	High Hardened Steels	R	D	H	T
XMR110A170 03	XMR120C170 03	XMR260T170 03	R0.3	17.0	13.0	4.2
XMR110A170 05	XMR120C170 05	XMR260T170 05	R0.5	17.0	13.0	4.2
XMR110A170 10	XMR120C170 10	XMR260T170 10	R1.0	17.0	13.0	4.2
XMR110A170 15	XMR120C170 15	XMR260T170 15	R1.5	17.0	13.0	4.2
XMR110A170 20	XMR120C170 20	XMR260T170 20	R2.0	17.0	13.0	4.2
XMR110A170 30	XMR120C170 30	XMR260T170 30	R3.0	17.0	13.0	4.2
XMR110A200 03	XMR120C200 03	XMR260T200 03	R0.3	20.0	16.0	5.2
XMR110A200 05	XMR120C200 05	XMR260T200 05	R0.5	20.0	16.0	5.2
XMR110A200 10	XMR120C200 10	XMR260T200 10	R1.0	20.0	16.0	5.2
XMR110A200 15	XMR120C200 15	XMR260T200 15	R1.5	20.0	16.0	5.2
XMR110A200 20	XMR120C200 20	XMR260T200 20	R2.0	20.0	16.0	5.2
XMR110A200 30	XMR120C200 30	XMR260T200 30	R3.0	20.0	16.0	5.2
XMR110A210 03	XMR120C210 03	XMR260T210 03	R0.3	21.0	16.0	5.2
XMR110A210 05	XMR120C210 05	XMR260T210 05	R0.5	21.0	16.0	5.2
XMR110A210 10	XMR120C210 10	XMR260T210 10	R1.0	21.0	16.0	5.2
XMR110A210 15	XMR120C210 15	XMR260T210 15	R1.5	21.0	16.0	5.2
XMR110A210 20	XMR120C210 20	XMR260T210 20	R2.0	21.0	16.0	5.2
XMR110A210 30	XMR120C210 30	XMR260T210 30	R3.0	21.0	16.0	5.2

▶ The corner radius tolerance is ±0.015mm and the set-up accuracy is ±0.02mm.

▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
XMR110A	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎						
XMR120C									◎	○	◎				◎	◎	◎	◎	◎	◎
XMR260T																				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
XMR110A																					
XMR120C																		○			
XMR260T																		◎	◎	○	◎

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YG-1 CO., LTD.

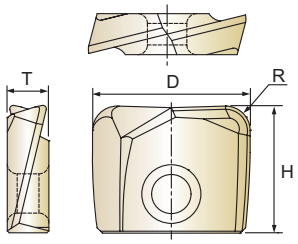
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cutting conditions : p.C62

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

EDP No.			Corner Radius	Mill Diameter	Height	Thickness
AlTiN	XC-Coating	Z-Coating				
General Purpose & Stainless Steels	Pre-Hardened Steels	High Hardened Steels	R	D	H	T
XMR110A250 03	XMR120C250 03	XMR260T250 03	R0.3	25.0	19.5	6.2
XMR110A250 05	XMR120C250 05	XMR260T250 05	R0.5	25.0	19.5	6.2
XMR110A250 10	XMR120C250 10	XMR260T250 10	R1.0	25.0	19.5	6.2
XMR110A250 15	XMR120C250 15	XMR260T250 15	R1.5	25.0	19.5	6.2
XMR110A250 20	XMR120C250 20	XMR260T250 20	R2.0	25.0	19.5	6.2
XMR110A250 30	XMR120C250 30	XMR260T250 30	R3.0	25.0	19.5	6.2
XMR110A260 03	XMR120C260 03	XMR260T260 03	R0.3	26.0	19.5	6.2
XMR110A260 05	XMR120C260 05	XMR260T260 05	R0.5	26.0	19.5	6.2
XMR110A260 10	XMR120C260 10	XMR260T260 10	R1.0	26.0	19.5	6.2
XMR110A260 15	XMR120C260 15	XMR260T260 15	R1.5	26.0	19.5	6.2
XMR110A260 20	XMR120C260 20	XMR260T260 20	R2.0	26.0	19.5	6.2
XMR110A260 30	XMR120C260 30	XMR260T260 30	R3.0	26.0	19.5	6.2
XMR110A300 03	XMR120C300 03	XMR260T300 03	R0.3	30.0	23.5	7.2
XMR110A300 05	XMR120C300 05	XMR260T300 05	R0.5	30.0	23.5	7.2
XMR110A300 10	XMR120C300 10	XMR260T300 10	R1.0	30.0	23.5	7.2
XMR110A300 15	XMR120C300 15	XMR260T300 15	R1.5	30.0	23.5	7.2
XMR110A300 20	XMR120C300 20	XMR260T300 20	R2.0	30.0	23.5	7.2
XMR110A300 30	XMR120C300 30	XMR260T300 30	R3.0	30.0	23.5	7.2

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▶ NEXT PAGE

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
XMR110A	◎	◎	◎	◎	◎	◎	◎	◎		○		◎	◎	◎						
XMR120C									◎	◎	◎				◎	◎	◎	◎	◎	◎
XMR260T																				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
XMR110A																					
XMR120C																		○			
XMR260T																		◎	◎	○	◎

i-Xmill END MILLS

XMR110A SERIES
XMR120C SERIES
XMR260T SERIES

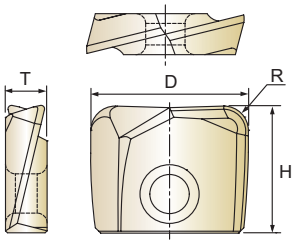
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cutting conditions : p.C62

Recommended ToolHolder
Plain Shank
◎ POWER MILLING CHUCK
○ ER COLLET CHUCK

Unit : mm

EDP No. AlTiN	EDP No. XC-Coating	EDP No. Z-Coating	Corner Radius	Mill Diameter	Height	Thickness
General Purpose & Stainless Steels	Pre-Hardened Steels	High Hardened Steels	R	D	H	T
XMR110A320 03	XMR120C320 03	XMR260T320 03	R0.3	32.0	23.5	7.2
XMR110A320 05	XMR120C320 05	XMR260T320 05	R0.5	32.0	23.5	7.2
XMR110A320 10	XMR120C320 10	XMR260T320 10	R1.0	32.0	23.5	7.2
XMR110A320 15	XMR120C320 15	XMR260T320 15	R1.5	32.0	23.5	7.2
XMR110A320 20	XMR120C320 20	XMR260T320 20	R2.0	32.0	23.5	7.2
XMR110A320 30	XMR120C320 30	XMR260T320 30	R3.0	32.0	23.5	7.2
XMR110A330 03	XMR120C330 03	XMR260T330 03	R0.3	33.0	23.5	7.2
XMR110A330 05	XMR120C330 05	XMR260T330 05	R0.5	33.0	23.5	7.2
XMR110A330 10	XMR120C330 10	XMR260T330 10	R1.0	33.0	23.5	7.2
XMR110A330 15	XMR120C330 15	XMR260T330 15	R1.5	33.0	23.5	7.2
XMR110A330 20	XMR120C330 20	XMR260T330 20	R2.0	33.0	23.5	7.2
XMR110A330 30	XMR120C330 30	XMR260T330 30	R3.0	33.0	23.5	7.2

- The corner radius tolerance is ±0.015mm and the set-up accuracy is ±0.02mm.

◎ : Excellent ○ : Good

ISO	P											M			K					
Material Description	Non-alloy steel					Low alloy steel				High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron	
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
HRc		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230
XMR110A	◎	◎	◎	◎	◎	◎	◎	◎				◎	◎	◎						
XMR120C									◎	○	◎				◎	◎	◎	◎	◎	◎
XMR260T																				

ISO	N										S							H			
Material Description	Aluminum-wrought alloy		Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials		Heat Resistant Super Alloys					Titanium Alloys		Hardened steel		Chilled Cast Iron	Hardened Cast Iron
VDI 3323	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41
HRc											15	30	25	38	34			55	60	42	55
HB	60	100	75	90	130	110	90	100			200	280	250	350	320	400 Rm	1050 Rm	550	630	400	550
XMR110A																					
XMR120C																		○			
XMR260T																		◎	◎	○	◎