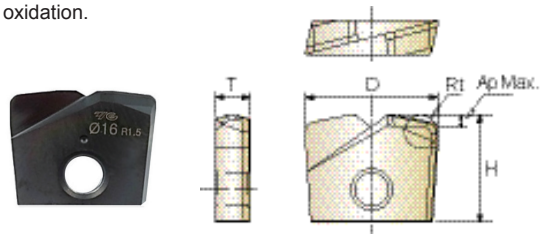
# i-Xmill CORNER RADIUS INSERT

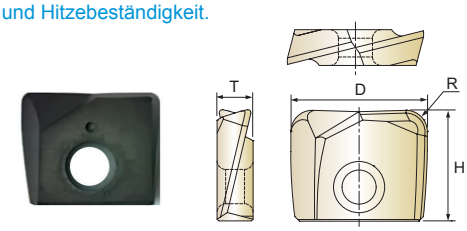
## i-Xmill WECHSELPLATTE mit GERADER STIRN UND ECKRADIUS
## i-Xmill Plaquette Torique AVEC RAYON de coupe frontale
## INSERTI IN MD, TORICI & TORICI HIGH FEED

- 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.




High Feed




cutting conditions : p.C63

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

| EDP No. | | Corner Radius | Mill Diameter | Height | Thickness | for High Feed |
|---|---|---|---|---|---|---|
| Y-Coating | Diamond | | | | | |
| General Purpose High Feed | Graphite | R(Rt) | D | H | T | Ap Max. |
| - | XMR110D080 03 | R0.3 | 8.0 | 8.0 | 2.4 | - |
| - | XMR110D080 05 | R0.5 | 8.0 | 8.0 | 2.4 | - |
| XMF110V080 08 | - | R0.8 | 8.0 | 8.0 | 2.4 | 0.4 |
| - | XMR110D080 10 | R1.0 | 8.0 | 8.0 | 2.4 | - |
| - | XMR110D080 20 | R2.0 | 8.0 | 8.0 | 2.4 | - |
| - | XMR110D100 03 | R0.3 | 10.0 | 9.5 | 2.7 | - |
| - | XMR110D100 05 | R0.5 | 10.0 | 9.5 | 2.7 | - |
| XMF110V100 10 | XMR110D100 10 | R1.0 | 10.0 | 9.5 | 2.7 | 0.5 |
| - | XMR110D100 15 | R1.5 | 10.0 | 9.5 | 2.7 | - |
| - | XMR110D100 20 | R2.0 | 10.0 | 9.5 | 2.7 | - |
| - | XMR110D100 30 | R3.0 | 10.0 | 9.5 | 2.7 | - |
| - | XMR110D110 03 | R0.3 | 11.0 | 9.5 | 2.7 | - |
| - | XMR110D110 05 | R0.5 | 11.0 | 9.5 | 2.7 | - |
| XMF110V110 10 | XMR110D110 10 | R1.0 | 11.0 | 9.5 | 2.7 | 0.5 |
| - | XMR110D110 15 | R1.5 | 11.0 | 9.5 | 2.7 | - |
| - | XMR110D110 20 | R2.0 | 11.0 | 9.5 | 2.7 | - |
| - | XMR110D110 30 | R3.0 | 11.0 | 9.5 | 2.7 | - |

- The corner radius tolerance is ±0.015mm(Rt tolerance is ±0.05mm) 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 |
| XMF110V | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | ◎ | | | | | | | | | | |
| XMR110D | | | | | | | | | | | | | | | | | | | | |

| 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 |
| XMF110V | | | | | | | | | | | | | | | | | | | | | |
| XMR110D | ○ | ○ | ○ | ○ | | | | | ◎ | | | | | | | | | | | | |

YG i-Xmill END MILLS

XMF110V SERIES
XMR110D SERIES

# i-Xmill CORNER RADIUS INSERT

## i-Xmill WECHSELPLATTE mit GERADER STIRN UND ECKRADIUS
## i-Xmill Plaquette Torique AVEC RAYON de coupe frontale
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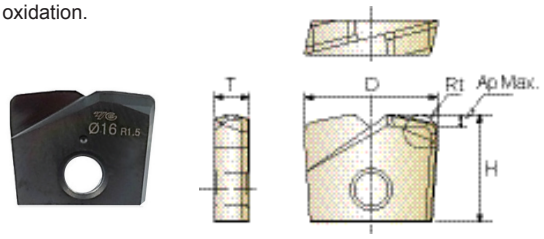
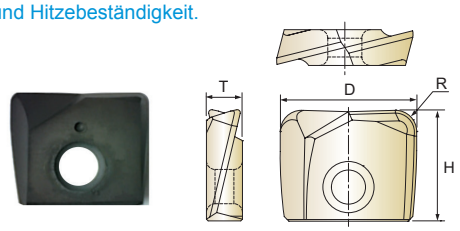



High Feed




cutting conditions : p.C63

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

| EDP No. | | Corner Radius | Mill Diameter | Height | Thickness | for High Feed |
|---|---|---|---|---|---|---|
| Y-Coating | Diamond | | | | | |
| General Purpose High Feed | Graphite | R(Rt) | D | H | T | Ap Max. |
| - | XMR110D120 03 | R0.3 | 12.0 | 11.0 | 2.7 | - |
| - | XMR110D120 05 | R0.5 | 12.0 | 11.0 | 2.7 | - |
| XMF110V120 10 | XMR110D120 10 | R1.0 | 12.0 | 11.0 | 2.7 | 0.6 |
| - | XMR110D120 15 | R1.5 | 12.0 | 11.0 | 2.7 | - |
| - | XMR110D120 20 | R2.0 | 12.0 | 11.0 | 2.7 | - |
| - | XMR110D120 30 | R3.0 | 12.0 | 11.0 | 2.7 | - |
| - | XMR110D130 03 | R0.3 | 13.0 | 11.2 | 2.7 | - |
| - | XMR110D130 05 | R0.5 | 13.0 | 11.2 | 2.7 | - |
| XMF110V130 10 | XMR110D130 10 | R1.0 | 13.0 | 11.2 | 2.7 | 0.6 |
| - | XMR110D130 15 | R1.5 | 13.0 | 11.2 | 2.7 | - |
| - | XMR110D130 20 | R2.0 | 13.0 | 11.2 | 2.7 | - |
| - | XMR110D130 30 | R3.0 | 13.0 | 11.2 | 2.7 | - |
| - | XMR110D160 03 | R0.3 | 16.0 | 13.0 | 4.2 | - |
| - | XMR110D160 05 | R0.5 | 16.0 | 13.0 | 4.2 | - |
| - | XMR110D160 10 | R1.0 | 16.0 | 13.0 | 4.2 | - |
| XMF110V160 15 | XMR110D160 15 | R1.5 | 16.0 | 13.0 | 4.2 | 0.8 |
| - | XMR110D160 20 | R2.0 | 16.0 | 13.0 | 4.2 | - |
| - | XMR110D160 30 | R3.0 | 16.0 | 13.0 | 4.2 | - |

- The corner radius tolerance is ±0.015mm(Rt tolerance is ±0.05mm) 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 |
| XMF110V | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | ◎ | | | | | | | | | | |
| XMR110D | | | | | | | | | | | | | | | | | | | | |

| 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 |
| XMF110V | | | | | | | | | | | | | | | | | | | | | |
| XMR110D | ○ | ○ | ○ | ○ | | | | | ◎ | | | | | | | | | | | | |

# i-Xmill CORNER RADIUS INSERT

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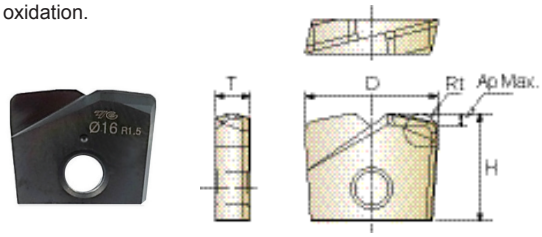
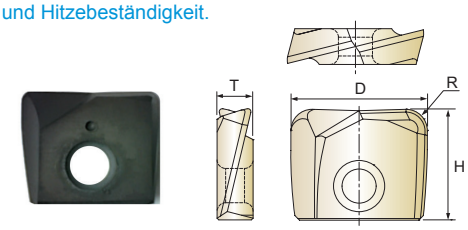



High Feed




cutting conditions : p.C63

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

| EDP No. | | Corner Radius | Mill Diameter | Height | Thickness | for High Feed |
|---|---|---|---|---|---|---|
| Y-Coating | Diamond | | | | | |
| General Purpose High Feed | Graphite | R(Rt) | D | H | T | Ap Max. |
| - | XMR110D170 03 | R0.3 | 17.0 | 13.0 | 4.2 | - |
| - | XMR110D170 05 | R0.5 | 17.0 | 13.0 | 4.2 | - |
| - | XMR110D170 10 | R1.0 | 17.0 | 13.0 | 4.2 | - |
| XMF110V170 15 | XMR110D170 15 | R1.5 | 17.0 | 13.0 | 4.2 | 0.8 |
| - | XMR110D170 20 | R2.0 | 17.0 | 13.0 | 4.2 | - |
| - | XMR110D170 30 | R3.0 | 17.0 | 13.0 | 4.2 | - |
| - | XMR110D200 03 | R0.3 | 20.0 | 16.0 | 5.2 | - |
| - | XMR110D200 05 | R0.5 | 20.0 | 16.0 | 5.2 | - |
| - | XMR110D200 10 | R1.0 | 20.0 | 16.0 | 5.2 | - |
| - | XMR110D200 15 | R1.5 | 20.0 | 16.0 | 5.2 | - |
| XMF110V200 20 | XMR110D200 20 | R2.0 | 20.0 | 16.0 | 5.2 | 1.0 |
| - | XMR110D200 30 | R3.0 | 20.0 | 16.0 | 5.2 | - |
| - | XMR110D210 03 | R0.3 | 21.0 | 16.0 | 5.2 | - |
| - | XMR110D210 05 | R0.5 | 21.0 | 16.0 | 5.2 | - |
| - | XMR110D210 10 | R1.0 | 21.0 | 16.0 | 5.2 | - |
| - | XMR110D210 15 | R1.5 | 21.0 | 16.0 | 5.2 | - |
| XMF110V210 20 | XMR110D210 20 | R2.0 | 21.0 | 16.0 | 5.2 | 1.0 |
| - | XMR110D210 30 | R3.0 | 21.0 | 16.0 | 5.2 | - |

▶ The corner radius tolerance is ±0.015mm(Rt tolerance is ±0.05mm) 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 |
| XMF110V | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | ◎ | | | | | | | | | | |
| XMR110D | | | | | | | | | | | | | | | | | | | | |

| 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 |
| XMF110V | | | | | | | | | | | | | | | | | | | | | |
| XMR110D | ○ | ○ | ○ | ○ | | | | | ◎ | | | | | | | | | | | | |

# i-Xmill END MILLS

**XMF110V** SERIES
**XMR110D** SERIES

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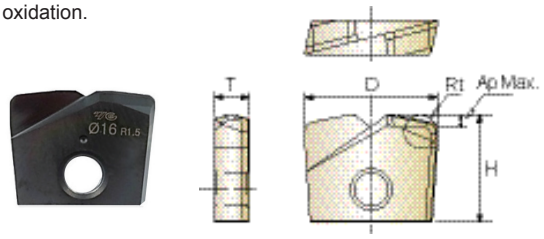
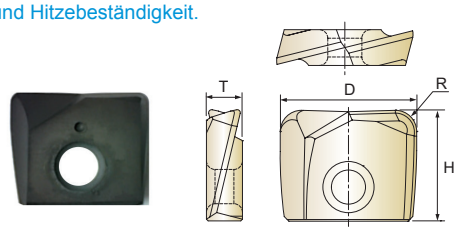



**High Feed**

cutting conditions : p.C63

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

| EDP No. | | Corner Radius | Mill Diameter | Height | Thickness | for High Feed |
|---|---|---|---|---|---|---|
| Y-Coating | Diamond | | | | | |
| General Purpose High Feed | Graphite | R(Rt) | D | H | T | Ap Max. |
| - | **XMR110D250 03** | R0.3 | **25.0** | 19.5 | 6.2 | - |
| - | **XMR110D250 05** | R0.5 | **25.0** | 19.5 | 6.2 | - |
| - | **XMR110D250 10** | R1.0 | **25.0** | 19.5 | 6.2 | - |
| - | **XMR110D250 15** | R1.5 | **25.0** | 19.5 | 6.2 | - |
| - | **XMR110D250 20** | R2.0 | **25.0** | 19.5 | 6.2 | - |
| **XMF110V250 25** | - | R2.5 | **25.0** | 19.5 | 6.2 | 1.25 |
| - | **XMR110D250 30** | R3.0 | **25.0** | 19.5 | 6.2 | - |
| - | **XMR110D260 03** | R0.3 | **26.0** | 19.5 | 6.2 | - |
| - | **XMR110D260 05** | R0.5 | **26.0** | 19.5 | 6.2 | - |
| - | **XMR110D260 10** | R1.0 | **26.0** | 19.5 | 6.2 | - |
| - | **XMR110D260 15** | R1.5 | **26.0** | 19.5 | 6.2 | - |
| - | **XMR110D260 20** | R2.0 | **26.0** | 19.5 | 6.2 | - |
| **XMF110V260 25** | - | R2.5 | **26.0** | 19.5 | 6.2 | 1.25 |
| - | **XMR110D260 30** | R3.0 | **26.0** | 19.5 | 6.2 | - |
| - | **XMR110D300 03** | R0.3 | **30.0** | 23.5 | 7.2 | - |
| - | **XMR110D300 05** | R0.5 | **30.0** | 23.5 | 7.2 | - |
| - | **XMR110D300 10** | R1.0 | **30.0** | 23.5 | 7.2 | - |
| - | **XMR110D300 15** | R1.5 | **30.0** | 23.5 | 7.2 | - |
| - | **XMR110D300 20** | R2.0 | **30.0** | 23.5 | 7.2 | - |
| **XMF110V300 30** | **XMR110D300 30** | R3.0 | **30.0** | 23.5 | 7.2 | 1.6 |

- The corner radius tolerance is ±0.015mm(Rt tolerance is ±0.05mm) 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 |
| XMF110V | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | ◎ | | | | | | | | | | |
| XMR110D | | | | | | | | | | | | | | | | | | | | |

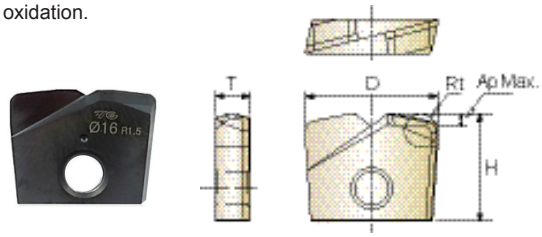
| ISO | N | | | | | | | | | | S | | | | | | | H | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Material Description | Aluminum-wrought alloy | | Aluminum-cast, alloyed | | | Copper and Copper Alloys (Bronze / Brass) | | | Non Metallic Materials | | 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 |
| XMF110V | | | | | | | | | | | | | | | | | | | | | |
| XMR110D | ○ | ○ | ○ | ○ | | | | | ◎ | | | | | | | | | | | | |

# i-Xmill CORNER RADIUS INSERT

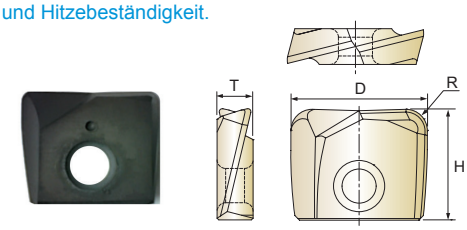
## i-Xmill WENDEPLATTE mit GERADER STIRN UND ECKRADIUS
## i-Xmill Plaquette Torique AVEC RAYON de coupe frontale
## INSERTI IN MD, TORICI & TORICI HIGH FEED

- 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.




High Feed




cutting conditions : p.C63

Recommended ToolHolder
Plain Shank
POWER MILLING CHUCK
ER COLLET CHUCK

Unit : mm

| EDP No. | | Corner Radius | Mill Diameter | Height | Thickness | for High Feed |
|---|---|---|---|---|---|---|
| Y-Coating | Diamond | | | | | |
| General Purpose High Feed | Graphite | R(Rt) | D | H | T | Ap Max. |
| - | XMR110D320 03 | R0.3 | 32.0 | 23.5 | 7.2 | - |
| - | XMR110D320 05 | R0.5 | 32.0 | 23.5 | 7.2 | - |
| - | XMR110D320 10 | R1.0 | 32.0 | 23.5 | 7.2 | - |
| - | XMR110D320 15 | R1.5 | 32.0 | 23.5 | 7.2 | - |
| - | XMR110D320 20 | R2.0 | 32.0 | 23.5 | 7.2 | - |
| - | XMR110D320 30 | R3.0 | 32.0 | 23.5 | 7.2 | - |
| XMF110V320 32 | XMR110D320 32 | R3.2 | 32.0 | 23.5 | 7.2 | 1.6 |
| - | XMR110D330 03 | R0.3 | 33.0 | 23.5 | 7.2 | - |
| - | XMR110D330 05 | R0.5 | 33.0 | 23.5 | 7.2 | - |
| - | XMR110D330 10 | R1.0 | 33.0 | 23.5 | 7.2 | - |
| - | XMR110D330 15 | R1.5 | 33.0 | 23.5 | 7.2 | - |
| - | XMR110D330 20 | R2.0 | 33.0 | 23.5 | 7.2 | - |
| - | XMR110D330 30 | R3.0 | 33.0 | 23.5 | 7.2 | - |
| XMF110V330 32 | XMR110D330 32 | R3.2 | 33.0 | 23.5 | 7.2 | 1.6 |

- The corner radius tolerance is ±0.015mm(Rt tolerance is ±0.05mm) 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 |
| XMF110V | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | ◎ | | | ◎ | | | | | | | | | | |
| XMR110D | | | | | | | | | | | | | | | | | | | | |

| 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 |
| XMF110V | | | | | | | | | | | | | | | | | | | | | |
| XMR110D | ○ | ○ | ○ | ○ | | | | | ◎ | | | | | | | | | | | | |