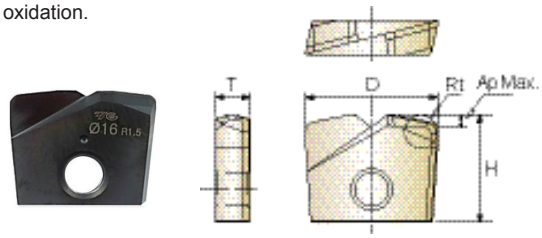
i-Xmill CORNER RADIUS INSERT

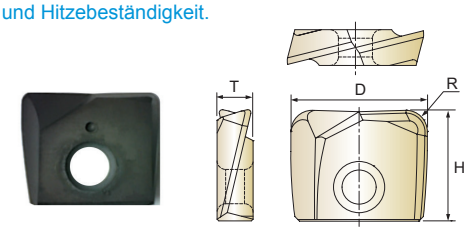
i-Xmill WECHSELPLATTE mit GERADER STIRN UND ECKRADIUS
i-Xmill Plaquette Torique AVEC RAYON de coupe frontale
INSERTI IN MD, TORICI & TORICI HIGH FEED

- 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

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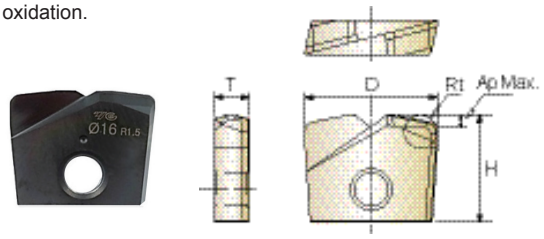
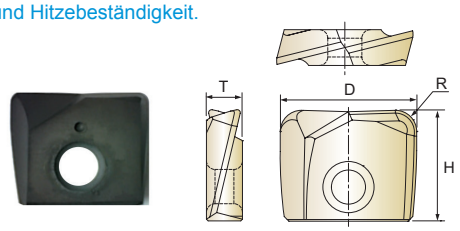


High Feed



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	-

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▶ NEXT PAGE

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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	○	○	○	○					◎												

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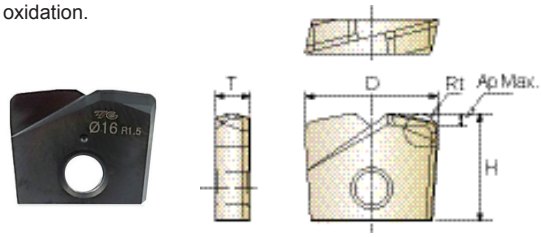
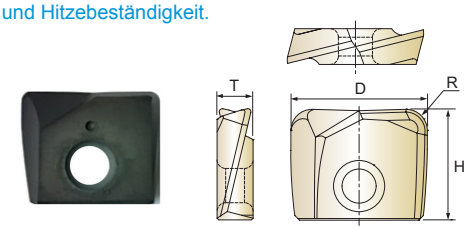


High Feed



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	-

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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
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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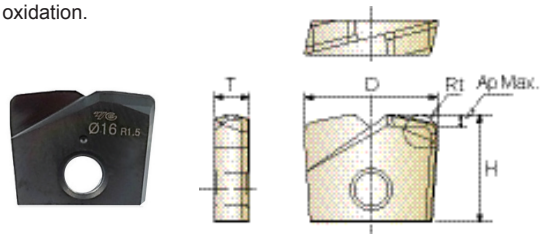

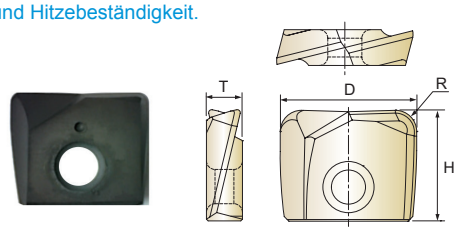

High Feed

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

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▶ NEXT PAGE

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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	○	○	○	○					◎												

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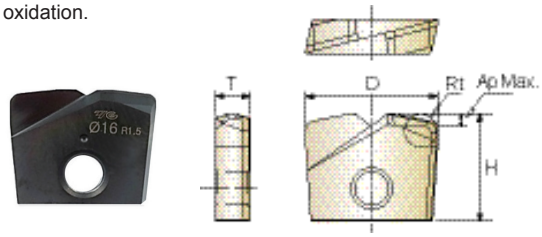
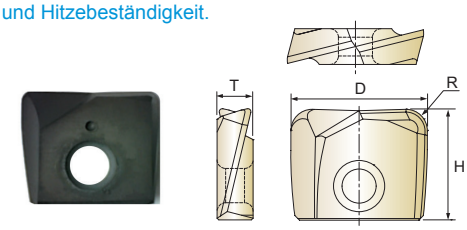


High Feed



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.
-	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	○	○	○	○					◎												