



BNGX 10T308 Z6P

APPLICATION

- Double-sided milling insert BNGX 10T3, 82° parallelogram and highfeed design for a maximum depth of cut of .0394"
- with .0315" corner radius, an indexing accuracy according to ISOtolerance class-G and M geometry with rounded cutting edges and facet



GRADE Z6P

- suitable for machining of steel
- PVD coated fine grained WC-Co carbide within ISO-grade ranges P25-P50

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35		K35			
Sfm ft/min	541 - 1050		509 - 984			
Fz Inch/Z	.008 - .055		.008 - .059			
ap Inch	.012 - .039		.012 - .039			

LEGEND

Sfm (Vc)	Surface Feet per Minute
Fn (ipr)	Feed per revolution
Fz (ipt)	Feed per tooth
ap	Depth of cut

FORMULA

S (RPM) = $Sfm * 12 / \pi / D$ = rev per minute
F (IPR, inch per revolution) = $S * Fn$ = feed per minute
F (IPM, inch per minute) = $S * Fz * n.flutes$ = feed per minute
Sfm = $S * D * \pi / 12$

MILLING CARBIDE INSERT