



BNGX 10T308 Z7P



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 Z7P

- suitable for machining of steel and cast-iron
- PVD coated fine grained WC-Co carbide within ISO-grade ranges P20-P40 and K20-K40

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30		K30			H30
Sfm ft/min	574 - 1115		541 - 1050			115 - 213
Fz Inch/Z	.008 - .055		.008 - .059			.002 - .027
ap Inch	.012 - .039		.012 - .039			.012 - .028

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