



# BNGX 10T304 Z4

## 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 MM geometry with rounded cutting edges and facet



## GRADE Z4

- suitable for machining of steel and cast-iron
- PVD coated fine grained WC-Co carbide within ISO-grade ranges P01-P10 and K01-K10

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>			K10			H10
<b>Sfm ft/min</b>			607 - 1411			115 - 295
<b>Fz Inch/Z</b>			0.0039 - 0.0394			0.0039 - 0.0394
<b>ap Inch</b>			0.008 - 0.039			0.008 - 0.039

### LEGEND

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

### FORMULA

<b>S (RPM)</b> = Sfm * 12 / π / D = rev per minute
<b>F (IPR, inch per revolution)</b> = S * Fn = feed per minute
<b>F (IPM, inch per minute)</b> = S * Fz * n.flutes = feed per minute
<b>Sfm</b> = S * D * π / 12