



BNGX 10T308 Z2



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 Z2

- suitable for machining of steel
- MT-CVD coated WC-Co carbide

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P25		K25			H10
Sfm ft/min	689 - 1427		640 - 1345			131 - 279
Fz Inch/Z	.008 - .055		.008 - .059			.002 - .028
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)	$Sfm * 12 / \pi / D = \text{rev per minute}$
F (IPR, inch per revolution)	$S * Fn = \text{feed per minute}$
F (IPM, inch per minute)	$S * Fz * n.\text{flutes} = \text{feed per minute}$
Sfm	$S * D * \pi / 12$