



BNGX.M 10T308 Z5

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 Z5

- suitable for machining of steel and super alloy
- PVD coated WC-Co carbide within ISO-grade ranges M30-M40 and S20-S30 for machining of stainless-steel and superalloy with high feed cutters

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P30	M25			S30	
Sfm ft/min	443 - 837	262 - 492			82 - 246	
Fz Inch/Z	.008 - .043	.009 - .040			.008 - .030	
ap Inch	.012 - .039	.012 - .039			.012 - .031	

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 = $S * D * \pi / 12$

MILLING CARBIDE INSERT