



BNGX.M 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 MM geometry with rounded cutting edges and facet



GRADE Z6P

- suitable for machining of stainless-steel and superalloy
- TIN PVD coated fine grained WC-Co carbide for machining with high feed cutters

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
GROUP	P35	M30			S30	
Sfm ft/min	574 - 1050	344 - 623			115 - 312	
Fz Inch/Z	0.0079 - 0.0433	0.0087 - 0.039			0.009 - 0.030	
ap Inch	0.012 - 0.039	0.012 - 0.039			0.012 - 0.031	

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 / π / 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 * π / 12

MILLING CARBIDE INSERT