



# BNGX.M 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 MM geometry with rounded cutting edges and facet



## GRADE Z7P

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

	STEEL	STAINLESS	CAST IRON	NON FERROUS	S.ALLOYS	HEAT TREATED
<b>GROUP</b>	P30	M30			S30	
<b>Sfm ft/min</b>	607 - 1115	361 - 656			115 - 328	
<b>Fz Inch/Z</b>	.008 - .043	.009 - .040			.009 - .030	
<b>ap Inch</b>	.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

$S \text{ (RPM)} = Sfm * 12 / \pi / D = \text{rev per minute}$
$F \text{ (IPR, inch per revolution)} = S * Fn = \text{feed per minute}$
$F \text{ (IPM, inch per minute)} = S * Fz * n.\text{flutes} = \text{feed per minute}$
$Sfm = S * D * \pi / 12$

**MILLING CARBIDE INSERT**