



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



## GRADE Z2

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

|                   | STEEL           | STAINLESS | CAST IRON | NON FERROUS | S.ALLOYS | HEAT TREATED |
|-------------------|-----------------|-----------|-----------|-------------|----------|--------------|
| <b>GROUP</b>      | P25             |           |           |             |          |              |
| <b>Sfm ft/min</b> | 722 - 1427      |           |           |             |          |              |
| <b>Fz Inch/Z</b>  | 0.0079 - 0.0327 |           |           |             |          |              |
| <b>ap Inch</b>    | 0.012 - 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   |