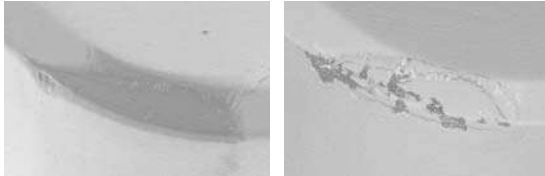


## CUTTING PERFORMANCE

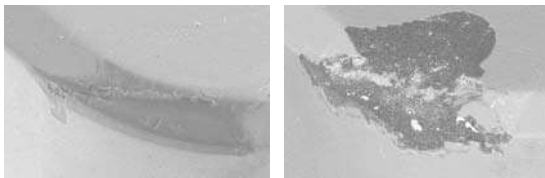
Machining length; 2300 ft



**BXA20**

Conventional grade

Machining length; 4600 ft

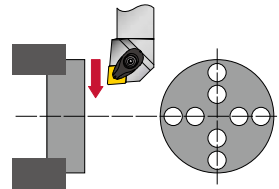


**BXA20**

Conventional grade

**H** Insert : 2QP-CNGA432  
 Workpiece material : Low carbon alloy (60HRC)  
 Cutting speed :  $V_c = 330$  sfm  
 Feed :  $f = 0.004$  ipr  
 Depth of cut :  $a_p = 0.008$  inch  
 Machining : Face turning  
 (interrupted cutting)

Without peeling-off, tool life is extended even in heavy interrupted machining.



## STANDARD CUTTING CONDITIONS

ISO	Grade	Workpiece condition	Cutting speed $V_c$ (sfm)	Depth of cut $a_p$ (inch)	Feed $f$ (ipr)
<b>H</b>	BXA20	Continuous	430 (200 - 590)	0.012 (0.002 - 0.020)	0.004 (0.002 - 0.012)
	BXA20	Interrupted	430 (200 - 590)	0.008 (0.002 - 0.012)	0.004 (0.002 - 0.008)

## GRADE

Application	Grade Application code	Microstructure	Hardness (Hv)	T.R.S (Gpa)
<b>H</b>	BXA20 H10-H20		3500 - 3700	1.35 - 1.50