

## Double-sided **negative** inserts

Expanded lineup for BXA10 and more corner radius variations.

### BXA10

Shape	Corner R				
	0.2	0.4	0.8	1.2	Wiper
<b>C</b>	-	●	●	●	●
<b>D</b>	●	●	●	●	-
<b>S</b>	-	●	●	●	-
<b>T</b>	-	●	●	●	-
<b>V</b>	●	●	●	●	-
<b>W</b>	-	●	●	●	●

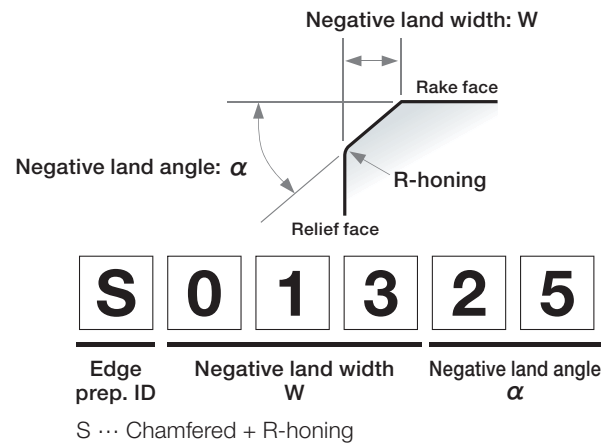
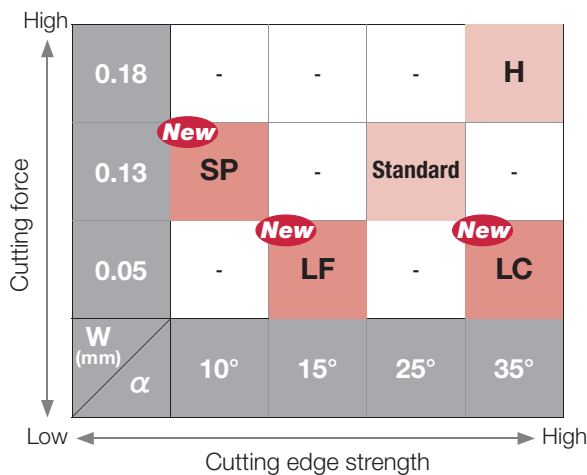
### BXA20

Shape	Corner R				
	0.2	0.4	0.8	1.2	Wiper
<b>C</b>	-	●	●	●	●
<b>D</b>	●	●	●	●	-
<b>S</b>	-	●	●	●	-
<b>T</b>	-	●	●	●	-
<b>V</b>	●	●	●	●	-
<b>W</b>	-	●	●	●	●

● : New product

## Edge preparations

For expanded application range.



**New MiniForce-Turn CBN inserts** are available with SP (S01310) style edge preparation, which is designed to form a high rake angle identical to standard ISO positive insert when positioned on the toolholder for smooth cutting.

New ISO negative inserts are offered with LF (S00515) and LC (S00535) styles for wider application coverage.

## STANDARD CUTTING CONDITIONS

ISO	Grade	Shape	Workpiece condition	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
<b>H</b>	<b>BXA10</b>	ISO Negative type	Continuous	100 - 230	0.05 - 0.8	0.03 - 0.3
			Light interrupted	100 - 230	0.05 - 0.8	0.03 - 0.2
		<b>MINIFURN</b>	Continuous	100 - 230	0.05 - 0.5	0.03 - 0.3
			Light interrupted	100 - 230	0.05 - 0.5	0.03 - 0.2
	<b>BXA20</b>	ISO Negative type	Continuous	60 - 180	0.05 - 0.8	0.03 - 0.3
			Interrupted	60 - 180	0.05 - 0.8	0.03 - 0.2
		<b>MINIFURN</b>	Continuous	60 - 180	0.05 - 0.5	0.03 - 0.3
			Interrupted	60 - 180	0.05 - 0.5	0.03 - 0.2