

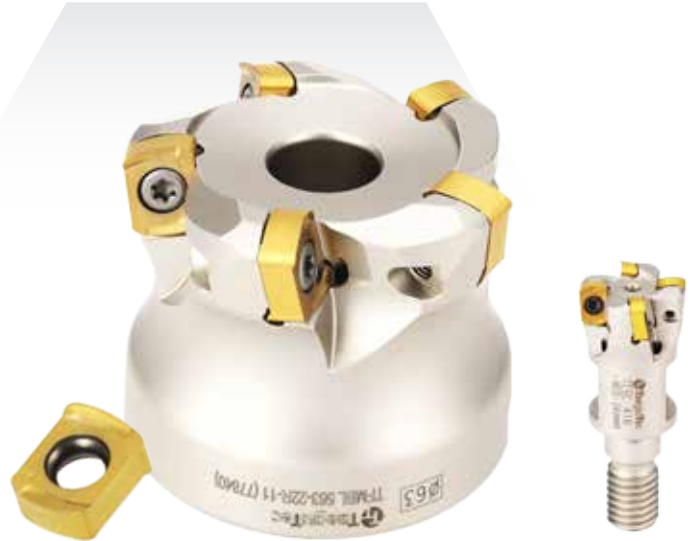
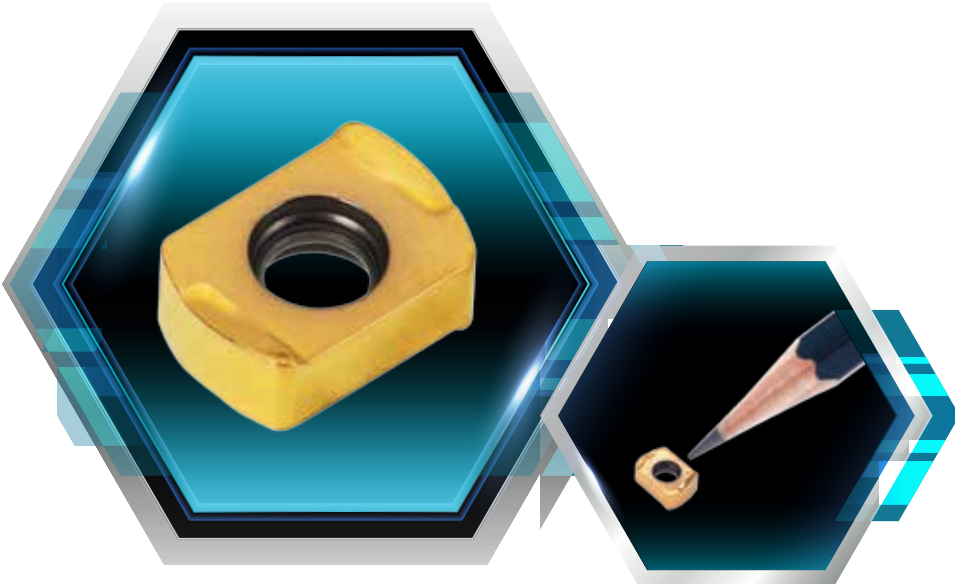
NPN

New Product News



CHASE4FEED HIGH FEED MILL

Versatile High Feed Mill with
Strong 4 Cutting Edge Insert



KEY POINT

TaeguTec has released an expansion to the CHASE-4-FEED family - BLMP 04, 11 inserts and cutters.

To meet market demand, smaller double-sided four corner designed **BLMP 04** inserts have been launched for small and high feed machining applications.

The smaller size inserts mean more inserts can be mounted to the same diameter cutters, which will greatly improve productivity over the existing BLMP 06 type under similar conditions. Available in Ø8(1z) and Ø10(2z) sizes, these are an alternative to solid end mills for roughing operations.

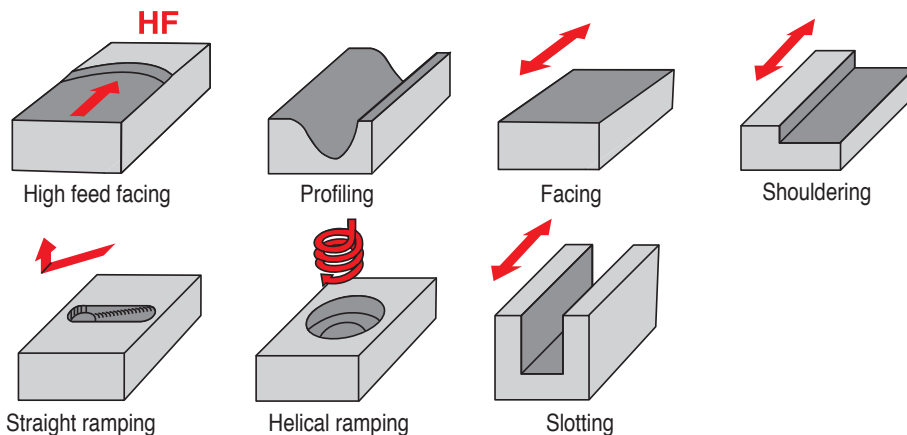
While both the **BLMP 11** and BLMP 13 cover a similar machining range, the BLMP 11 inserts give an advantage as they make it a finer pitch same diameter cutter for better productivity. The cutters come in all types: face mill, end mill and modular types.

- * As part of the new campaign, the design for the new **CHASE-4-FEED** line highlights TaeguTec's new direction.
- * The new **CHASE-4-FEED** logo will be applied to the BLMP 06, 09 inserts and cutters as well.

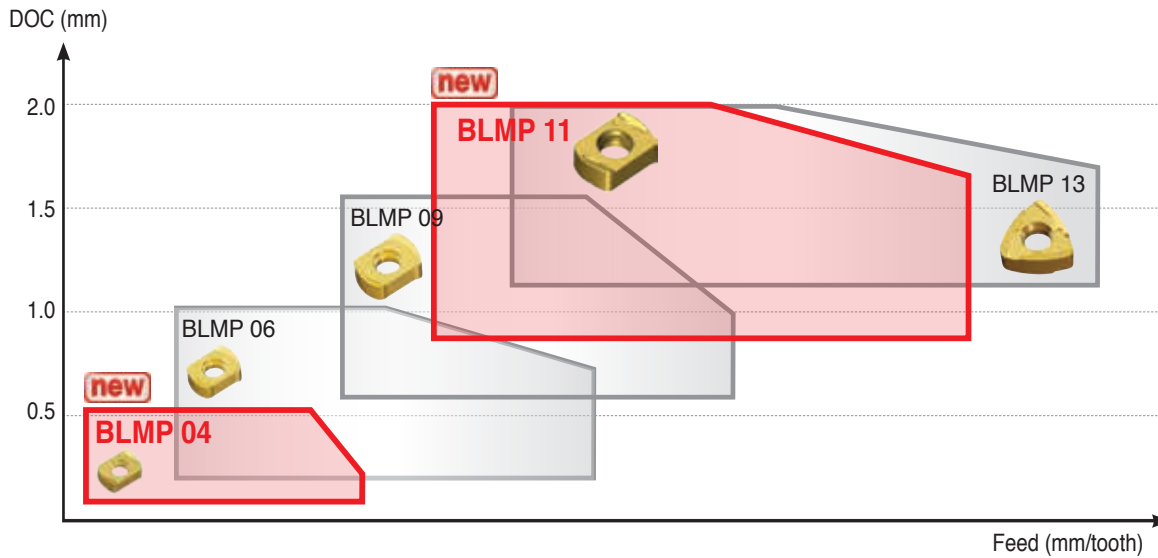
For further technical questions, please contact TaeguTec's product manager.

Features





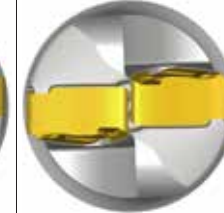
- Double-sided four corners insert
- Smaller insert size means more inserts can be fitted into similar size cutters (improved productivity)
- Smooth cutting and excellent insert rigidity
- Applies to a variety of applications



BLMP application range



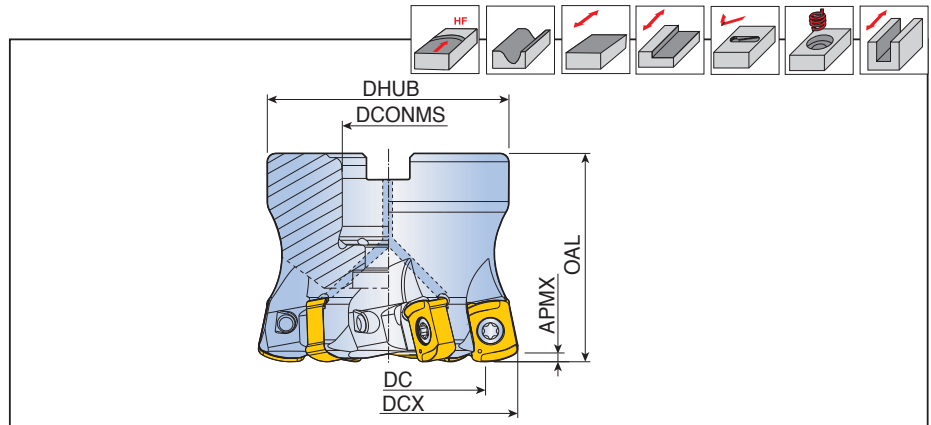
Maximum number of teeth by diameter

Diameter \ Insert	BLMP 04	BLMP 06	BLMP 09	BLMP 11	BLMP 13
	Ø10	2	-	-	-
Ø12	3	-	-	-	-
Ø16	4	2	-	-	-
Ø20	5	3	-	-	-
Ø25	7	4	2	-	-
Ø30	-	5	3	2	-
Ø32	8	5	4	3	2
					



TFMBL-11

High feed face mills



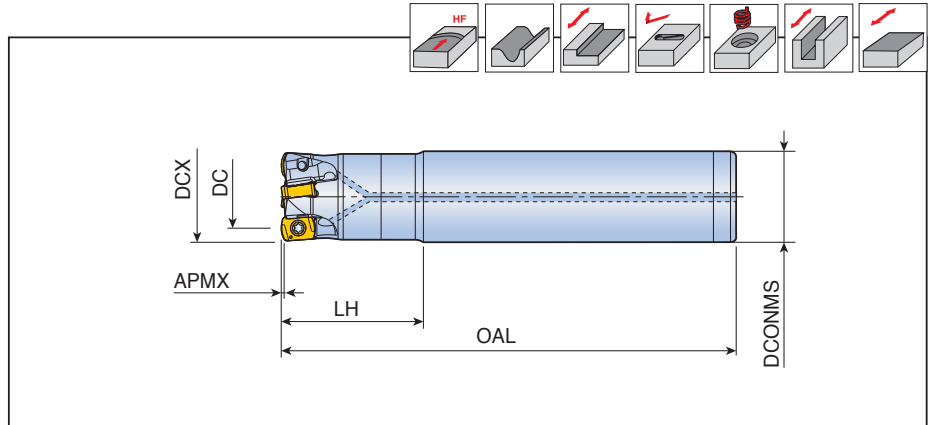
Designation	Z	Dimension (mm)						Coolant	Arbor type	Kg	Mounting bolt	Insert
		DCX	DC	DCONMS	DHUB	OAL	APMX					
TFMBL 440-16R-11	4	40	24.4	16	30	40	2.0	●	E	0.2	KTB 32B	BLMP 1105...
450-22R-11	4	50	34.4	22	45	40	2.0	●	A	0.3	LH M10x25	
550-22R-11	5	50	34.4	22	45	40	2.0	●	A	0.3	LH M10x25	
552-22R-11	5	52	36.4	22	45	40	2.0	●	A	0.3	LH M10x25	
563-22R-11	5	63	48.4	22	58	50	2.0	●	A	0.7	SH M10x30	
663-22R-11	6	63	48.4	22	58	50	2.0	●	A	0.7	SH M10x30	
666-22R-11	6	66	50.3	22	58	50	2.0	●	A	0.8	SH M10x30	
680-27R-11	6	80	64.3	27	70	60	2.0	●	A	1.4	SH M12x30	
780-27R-11	7	80	64.3	27	70	60	2.0	●	A	1.4	SH M12x30	
6100-32R-11	6	100	84.3	32	85	60	2.0	●	A	2.2	SH M16x35	
7100-32R-11	7	100	84.3	32	85	60	2.0	●	A	2.2	SH M16x35	
8125-32R-11	8	125	109.3	32	85	60	2.0	●	A	2.5	SH M20x40	
10125-40R-11	10	125	109.3	40	85	60	2.0	●	A	2.7	SH M20x40	
10160-40R-11	10	160	144.3	40	110	60	2.0	x	C	3.9	-	
12200-60R-11	12	200	184.3	60	130	60	2.0	x	C	5.8	-	

Spare parts

Designation	Screw	Wrench	Wrench handle		
TFMBL-11	TS 50A121/HG	TBLD T20-W6	SW6-T		

TEBL-04

High feed end mills

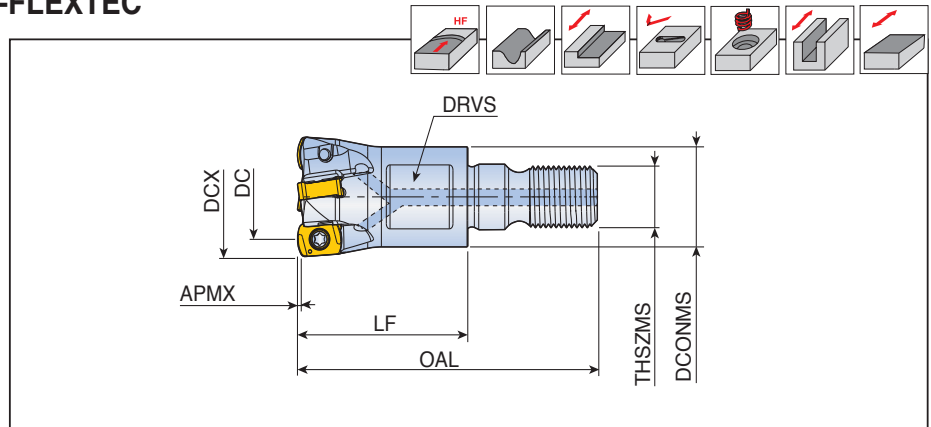


Designation	Inserts	Dimension (mm)						Coolant	Insert
		DCX	DC	DCONMS	OAL	LH	APMX		
TEBL 108-08-04-L80	1	8	3.8	8	80	20	0.5	●	BLMP 0402...
210-10-04-L100	2	10	5.6	10	100	20	0.5	●	
211-10-04-L100	2	11	6.6	10	100	20	0.5	●	
312-12-04-L110	3	12	7.6	12	110	20	0.5	●	
313-12-04-L110	3	13	8.6	12	110	20	0.5	●	
416-16-04-L150	4	16	11.6	16	150	25	0.5	●	
417-16-04-L200	4	17	12.6	16	200	25	0.5	●	
520-20-04-L200	5	20	15.5	20	200	25	0.5	●	
521-20-04-L200	5	21	16.5	20	200	25	0.5	●	

TEBL-M-04



High feed modular heads for T-FLEXTEC



Designation		Dimension (mm)								Coolant	Insert
		DCX	DC	DCONMS	LF	OAL	THSZMS	APMX	DRVS		
TEBL 210-M06-04	2	10	5.6	9.7	17	31.5	M06	0.5	8	●	BLMP 0402...
211-M06-04	2	11	6.6	9.7	17	31.5	M06	0.5	8	●	
312-M06-04	3	12	7.6	11	17	31.5	M06	0.5	8	●	
313-M06-04	3	13	8.6	11	17	31.5	M06	0.5	8	●	
416-M08-04	4	16	11.6	13	23	40.5	M08	0.5	10	●	
417-M08-04	4	17	12.6	13	23	40.5	M08	0.5	10	●	
520-M10-04	5	20	15.5	18	23	43	M10	0.5	15	●	
725-M12-04	7	25	20.6	21	27	49	M12	0.5	17	●	
832-M16-04	8	32	27.5	29	27	52	M16	0.5	25	●	

• Matched with T-FLEXTEC holder

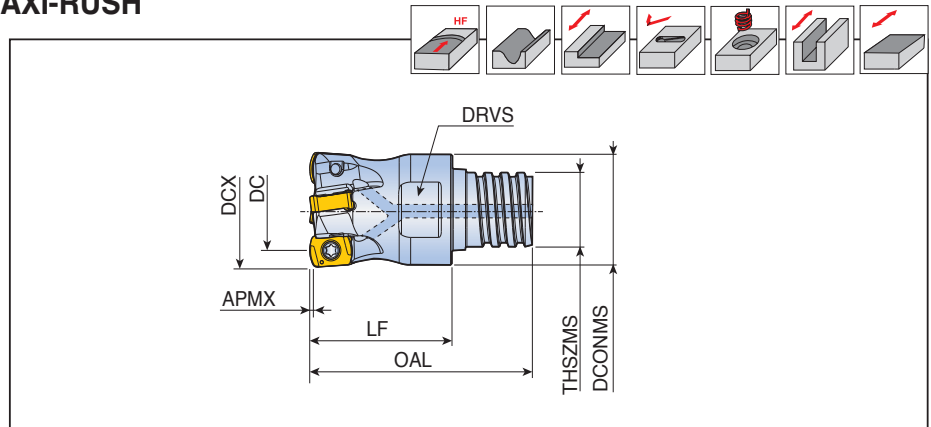
Spare parts

Designation	Screw	Wrench			
TEBL-04	TS 18041/HG	TD 6P			



TEBL-S-04

High feed modular heads for MAXI-RUSH



Designation	Z	Dimension (mm)								Coolant	Insert
		DCX	DC	DCONMS	LF	OAL	THSZMS	APMX	DRVS		
TEBL 210-S06-04	2	10	5.6	9.6	15	21.3	S06	0.5	8	●	BLMP 0402...
312-S08-04	3	12	7.6	11.5	16	23.5	S08	0.5	10	●	
416-S10-04	4	16	11.6	15.2	20	31.3	S10	0.5	13	●	

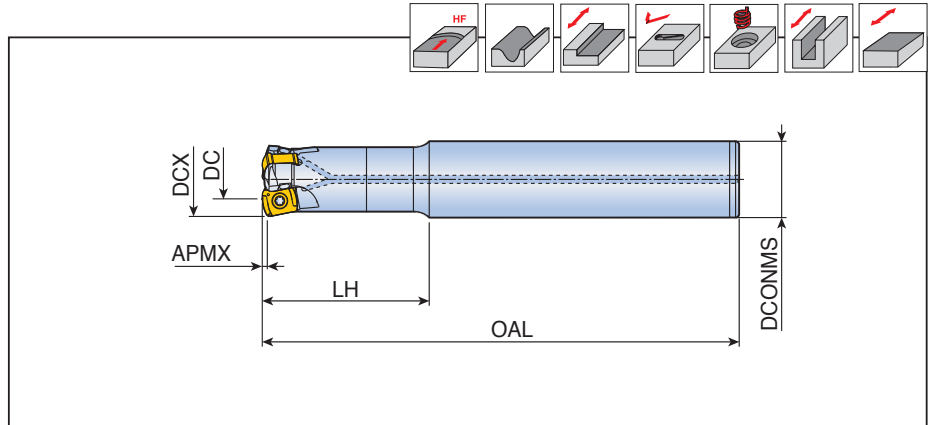
• Matched with MAXI-RUSH holder

Spare parts

Designation	Screw	Wrench			
TEBL-04	TS 18041/HG	TD 6P			

TEBL-11

High feed end mills

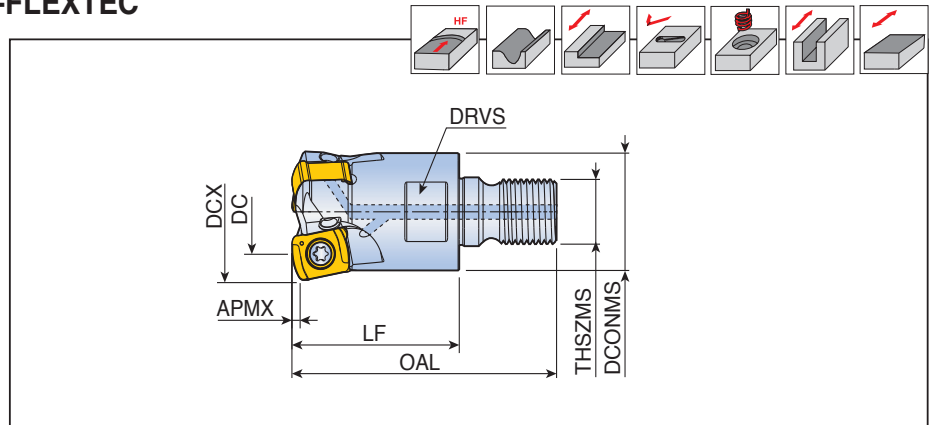


Designation	Flutes	Dimension (mm)						Coolant	Insert
		DCX	DC	DCONMS	OAL	LH	APMX		
TEBL 230-32-11-L150	2	30	14.7	32	150	70	2.0	●	BLMP 1105...
232-32-11-L150	2	32	16.6	32	150	70	2.0	●	
232-32-11-L200	2	32	16.6	32	200	70	2.0	●	
332-32-11-L200	3	32	16.6	32	200	70	2.0	●	
233-32-11-L200	2	33	17.6	32	200	40	2.0	●	
233-32-11-L250	2	33	17.6	32	250	50	2.0	●	
333-32-11-L250	3	33	17.6	32	250	50	2.0	●	
335-32-11-L200	3	35	19.5	32	200	40	2.0	●	
340-32-11-L150	3	40	24.4	32	150	40	2.0	●	
340-32-11-L200	3	40	24.4	32	200	40	2.0	●	

TEBL-M-11



High feed modular heads for T-FLEXTEC



Designation		Dimension (mm)								Coolant	Insert
		DCX	DC	DCONMS	LF	OAL	THSZMS	APMX	DRVS		
TEBL 230-M16-11	2	30	14.7	29	43	68	M16	2.0	25	●	BLMP 1105...
232-M16-11	2	32	16.6	29	43	68	M16	2.0	25	●	
233-M16-11	2	33	17.6	29	43	68	M16	2.0	25	●	
335-M16-11	3	35	19.5	29	43	68	M16	2.0	25	●	
340-M16-11	3	40	24.4	29	43	68	M16	2.0	25	●	
342-M16-11	3	42	26.4	29	43	68	M16	2.0	25	●	

• Matched with T-FLEXTEC holder

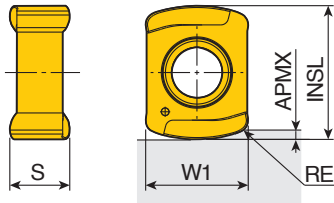
Spare parts

Designation	Screw 	Wrench 	Wrench handle 		
TEBL-11	TS 50A121I/HG	TBLD T20-W6	THND 6W		

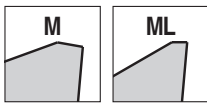
BLMP



High feed inserts



Size	Dimension (mm)				
	INSL	W1	S	APMX	RE
04	6.0	4.2	2.5	0.5	0.5
11	14.6	11.2	6.5	2.0	1.3

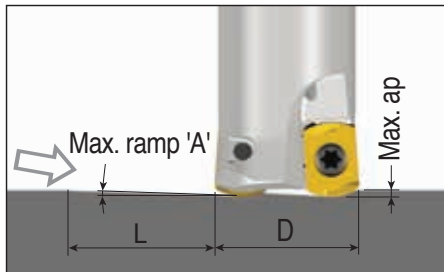


Insert	Designation	Recommended machining conditions		Coated							Uncoated			
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525	TT7080	TT7515	TT6080	TT2510	K10	
	BLMP 0402R-M	0.1-0.5	1.50-0.20	●		●						●		
	1105R-M	0.3-2.0	4.00-0.30	●		●		●				●		
	BLMP 0402R-ML	0.1-0.5	0.60-0.10	●		●								
	1105R-ML	0.3-2.0	4.00-0.30	●		●								

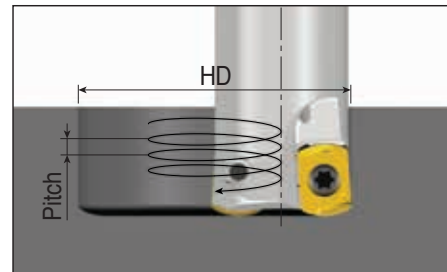
●: Standard items

Ramping Data

Straight ramping



Helical ramping

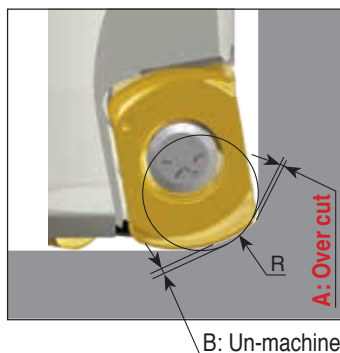


BLMP 04

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø8	0.4	0.5	72	12.6	16	0.1
Ø10	0.6		44	16.6	20	0.2
				22	0.3	
Ø11	0.7		38	20.6	24	0.4
				26	0.5	
Ø12	1.0		29	28.6	32	0.5
				34	0.5	
Ø13	1.1		25	30.6	34	0.5
				40	0.5	
Ø16	1.0		29	36.6	40	0.5
				42	0.5	
Ø17	1.1		26	38.6	42	0.5
				50	0.5	
Ø20	1.0		27	46.6	50	0.5
		60.6		64	0.5	
Ø21	0.7	38	60.6	64	0.5	
			64	0.5		
Ø25	0.7	38	60.6	64	0.5	
			64	0.5		
Ø32	0.6	48	60.6	64	0.5	
			64	0.5		

Programming technical data

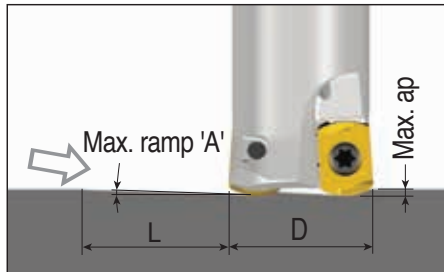


	R Program	A Over cut	B Un-machined
BLMP 04	0.8	0.00	0.28
	0.9	0.00	0.25
	1.0	0.08	0.22

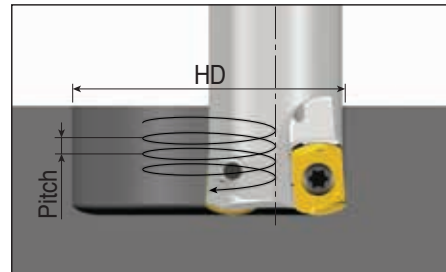
: Recommended program 'R'

Ramping Data

Straight ramping



Helical ramping

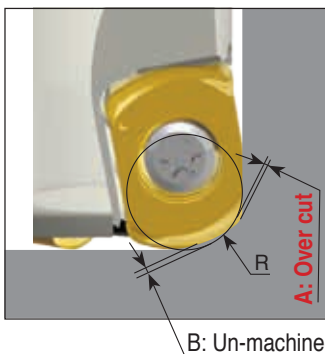


BLMP 11

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø30	0.50	2.0	229	41	60	0.3
Ø32	0.50		229	45	64	0.3
Ø33	0.45		255	47	66	0.3
Ø35	0.50		229	51	70	0.4
Ø40	0.55		208	61	80	0.5
Ø42	0.50		229	65	84	0.5
Ø50	0.50		229	81	100	0.7
Ø52	0.45		255	85	104	0.7
Ø63	0.45		255	107	126	0.9
Ø66	0.40		287	113	132	0.9
Ø80	0.35		328	141	160	1.0
Ø100	0.30		382	181	200	1.1
Ø125	0.25		459	231	250	1.2
Ø160	0.20		573	301	320	1.3
Ø200	0.15		764	381	400	1.3

Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 11	2.4	0.00	1.09
	3.0	0.00	0.90
	3.2	0.18	0.85

 : Recommended program 'R'

KIT COLLECTIONS

These kit products are available in the format listed below.



Cat. No.	Designation	Bill of materials	Qty.
6334778	KISFT-TEBL-210-10-04-L100	TEBL 210-10-04-L100	1
		BLMP 0402R-M TT9080	4
6334779	KISFT-TEBL 312-12-04-L110	TEBL 312-12-04-L110	1
		BLMP 0402R-M TT9080	6
6334780	KISFT-TEBL 416-16-04-L150	TEBL 416-16-04-L150	1
		BLMP 0402R-M TT9080	8
6334781	KISFT-TEBL 520-20-04-L200	TEBL 520-20-04-L200	1
		BLMP 0402R-M TT9080	10



Cat. No.	Designation	Bill of materials	Qty.
6337844	KISFS-TEBL-210-10-04-L100	TEBL 210-10-04-L100	1
		BLMP 0402R-M TT9080	50
6337845	KISFS-TEBL 312-12-04-L110	TEBL 312-12-04-L110	1
		BLMP 0402R-M TT9080	50
6337846	KISFS-TEBL 416-16-04-L150	TEBL 416-16-04-L150	1
		BLMP 0402R-M TT9080	50
6337847	KISFS-TEBL 520-20-04-L200	TEBL 520-20-04-L200	1
		BLMP 0402R-M TT9080	50



Cat. No.	Designation	Bill of materials	Qty.
6338424	KISFF-A-BLMP 04-M TT9080	BLMP 0402R-M TT9080	100
6338425	KISFF-B-BLMP 04-M TT9080		300
6338426	KISFF-C-BLMP 04-M TT9080		500