

NEW PRODUCT NEWS

CHASE² FEED



BLMP 1306 Size Insert for Maximum 2 mm Depth High Feed Milling Applications Now Available



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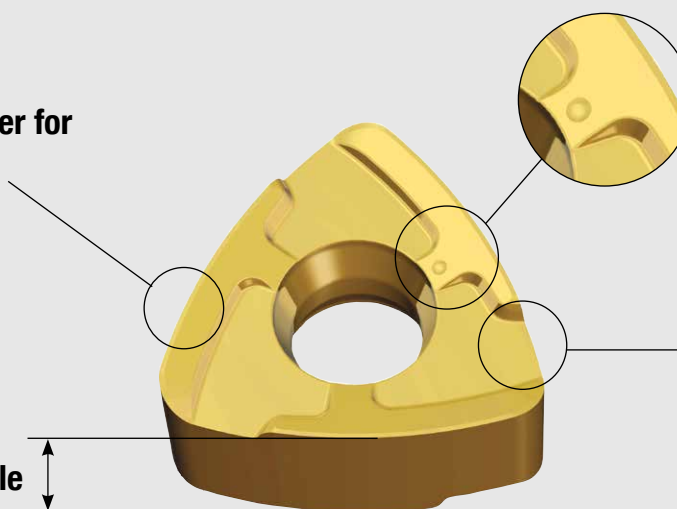
FEATURES

High rake chip former for smooth machining

Unique reinforced design for anti-breakage

Thicker insert (7mm) enables stable machining

Unique pocket seat design for stable machining



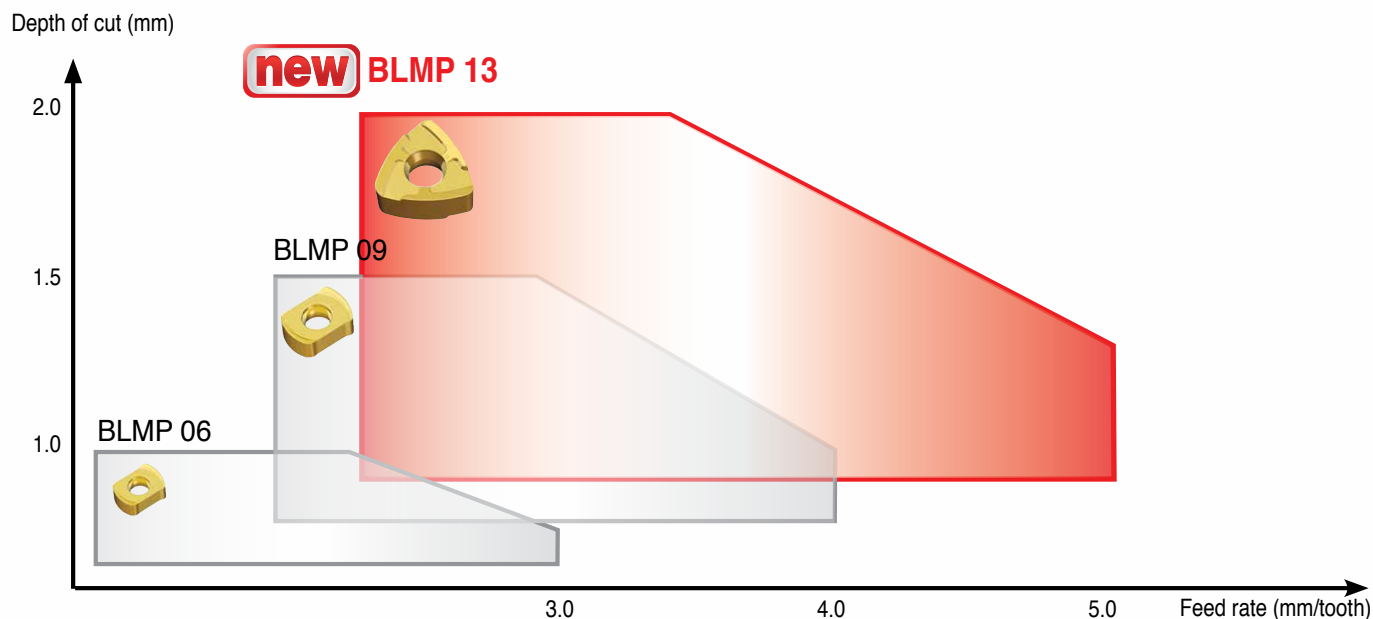
TaeguTec has introduced a new BLMP to the CHASE2FEED line — the BLMP 13 size inserts and cutters for up to 2 mm depth milling in high feed conditions.

Specifically designed for heavy, die and mold, power generation and general industries milling applications, the insert's unique characteristics make it an excellent addition to the line.

With a reinforced unique design for better anti-breakage capability and high rake angle, the new addition to the CHASE2FEED Line demonstrates a reduced cutting load over the existing BLMP 12 as well as providing excellent chip evacuation.

Its 7 mm thickness and unique pocket seat enables stable machining in high feed conditions. Further, the BLMP 13 is a double sided insert with six cutting edges for practical issues such as economy.

CHASE2FEED high feed application guide



BLMP 13

Insert

Size	Dimension (mm)			
	d	t	ap	r
13	12.3	7	2	22

Insert	Designation	Recommended machining conditions		CVD coated			PVD coated					
		Fz (mm/tooth)	ap (mm)	TT6800	TT7800	TT9540	TT2510	TT3540	TT6080	TT8020	TT8080	TT9080
	BLMP 1306R-M	0.40-4.50	0.5-2.0	●	●	○	●	○	●	●	●	●
	1306R-MM	0.40-4.50	0.5-2.0			○		○		●	●	●
	1306R-MR	0.40-4.50	0.5-2.0	●		○	●	○	●			●

• MM/MR will be launched by the end of July 2014

●: Standard item ○: Semi standard item

TFMBL...-R-13

Face mill

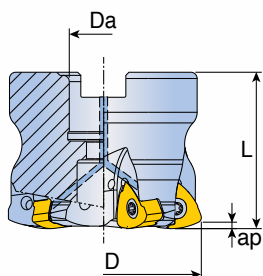
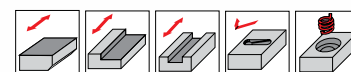


Fig.1

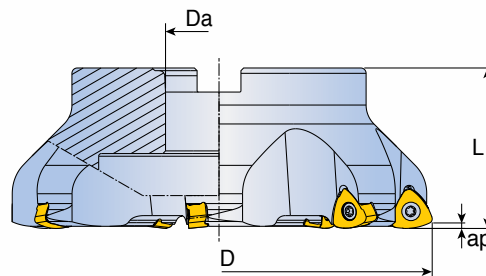


Fig.2

Designation		Dimension (mm)					Insert
		D	Da	L	ap	Fig.	
TFMBL 340-16R-13	3	40	16	50	2	1	BLMP 1306R-M/MM/MR
350-22R-13	3	50	22	40	2	1	
450-22R-13	4	50	22	40	2	1	
452-22R-13	4	52	22	40	2	1	
463-22R-13	4	63	22	50	2	1	
563-22R-13	5	63	22	50	2	1	
580-27R-13	5	80	27	60	2	1	
580-32R-13	5	80	32	60	2	1	
680-27R-13	6	80	32	60	2	1	
5100-32R-13	5	100	32	60	2	1	
6100-32R-13	6	100	32	60	2	1	
7100-32R-13	7	100	32	60	2	1	
6125-32R-13	6	125	32	60	2	1	
7125-40R-13	7	125	40	60	2	1	
7160-40R-13	7	160	40	60	2	2	
8160-40R-13	8	160	40	60	2	2	
9160-40R-13	9	160	40	60	2	2	
8200-60R-13	8	200	60	60	2	2	
9200-60R-13	9	200	60	60	2	2	
11200-60R-13	11	200	60	60	2	2	
9250-60R-13	9	250	60	60	2	2	
10250-60R-13	10	250	60	60	2	2	
12250-60R-13	12	250	60	60	2	2	

• ~D125: Coolant through type

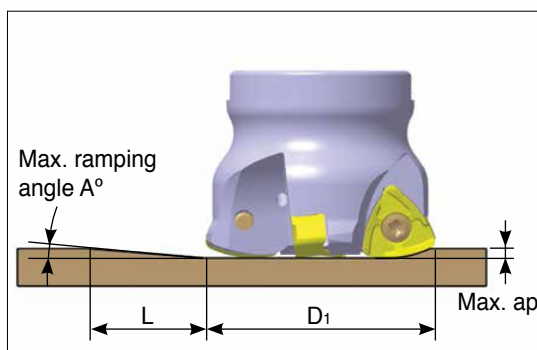
Spare parts

Designation	Screw	Wrench			
TFMBL...-R-13	TS50B106I/HG	T-T20			

Programming technical data

1. Recommended ramping angle

- Straight ramping



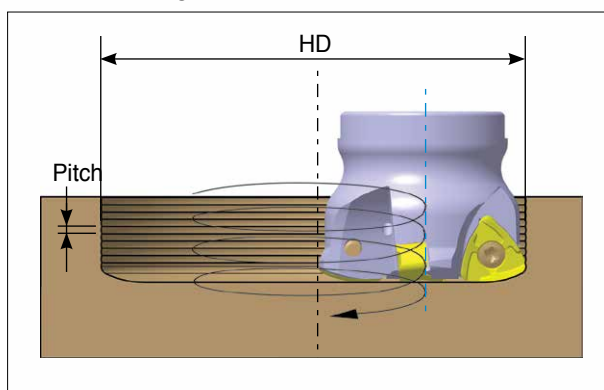
End mill

Diameter(D ₁)	32	33	35	40	42
Max. Angle(A°)	0.8	1.1	1.1	1.3	1.1

Face mill

Diameter(D ₁)	40	50	52	63	80	100	125	160	200	250
Max. Angle(A°)	1.3	0.8	0.8	0.6	0.45	0.4	0.3	0.2	0.15	0.1

- Helical ramping

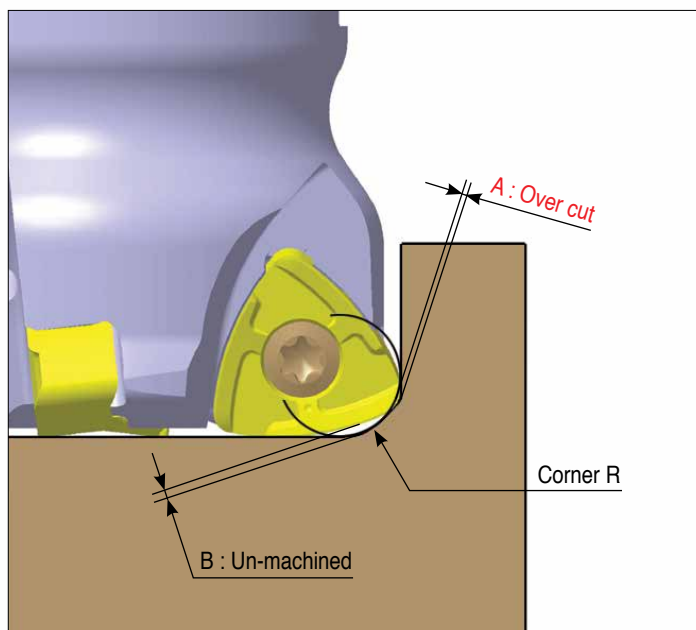


BLMP 13

Cutter Dia. (D ₁)	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.(HD)	Max. Dia.(HD)	Max. Pitch/Rev.
32	0.8	2	143	50	64	0.7
				66		0.9
40	1.3	2	88	86	80	1.5
				100		1.8
50	0.8	2	143	112	126	1.2
				146		1.4
63	0.6	2	191	186	160	1.2
				200		1.3
80	0.45	2	255	236	250	1.1
				306		1.3
100	0.4	2	287	386	400	1.2
				486		1.4
125	0.3	2	382	500	500	1.3
				573		1.0
160	0.2	2	573	764	764	1.1
				764		1.1
200	0.15	2	764	1146	1146	1.0
				1146		0.8
250	0.1	2	1146	1146	1146	0.9
				1146		0.9

2. Programming Tip

When performing CNC programming operations, specify tools with “Corner R” value for the BLMP 13 insert. This will achieve un-machined material thickness of approximately “B” mm along the corner.

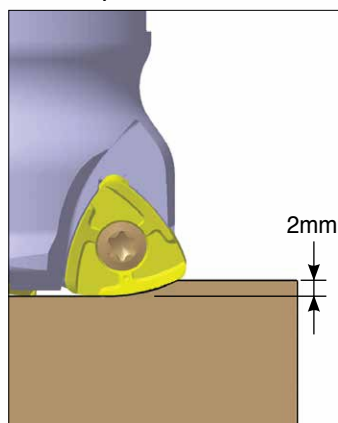


When applying the CNC program with “Corner R,” the over cut area is indicated as “A” mm. For other program “Corner R” data, please refer to the diagram below.

	Corner R Program	A Over cut	B Un-machined material thickness
BLMP 13	3.0	0	1.31
	3.5	0	1.17
	4.0	0.04	1.03
	4.5	0.15	0.89
	5.0	0.3	0.76

: Recommended program 'Corner R'

Max. depth of cut



Recommended cutting conditions

BLMP 13

Material	Hardness (HB)	D.O.C (mm)	Cutting speed (m/min)	Best grades	Feed (mm/tooth)
Carbon Steel	85-225	0.3-2.0	130-300	TT9080	0.5 - 4.5
Alloy Steel	275-375	0.3-1.6	120-250	TT9080	0.4 - 4.0
Alloy Steel	375-480	0.3-1.6	60-140	TT9080	0.3 - 3.5
Pre-Hardened Steel	250-470	0.3-1.6	50-200	TT9080	0.3 - 2.8
Hardened Steel	480-	0.3-1.6	50-110	TT2510	0.3 - 2.3
Stainless 300 Series	-	0.3-1.6	80-170	TT8080	0.3 - 2.3
Stainless 400 Series	-	0.3-1.6	100-210	TT8080	0.4 - 2.8
High Temp. Alloy	-	0.3-1.2	30-100	TT8080	0.3 - 2.3
Inconel	-	0.3-1.2	20-60	TT8080	0.3 - 2.3
Titanium Alloy	-	0.3-1.2	30-80	TT8080	0.3 - 2.3
Gray Cast Iron	190-220	0.3-2.0	150-400	TT6080	0.5 - 4.0
Nodular Cast Iron	140-200	0.3-2.0	100-250	TT6080	0.5 - 3.0