

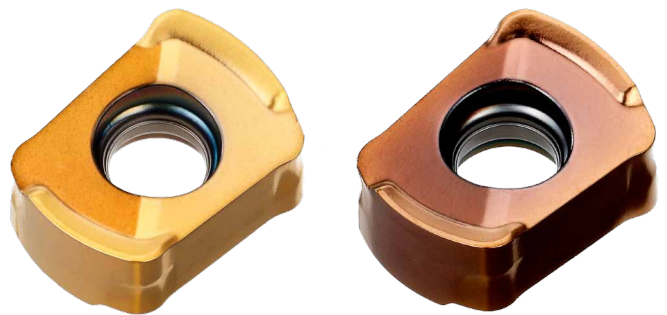
NPN

New Product News



WIN4FEED

**Next Generation High Feed Milling Line
with V-Bottom for Stronger Clamping**



KEY POINT

WIN-4-FEED's BLMV inserts and cutters are the next-generation high feed milling solution.





Building on the success of the CHASE-4-FEED series, TaeguTec has unveiled the powerful premium high feed milling solution WIN-4-FEED that includes BLMV inserts and dedicated cutters.

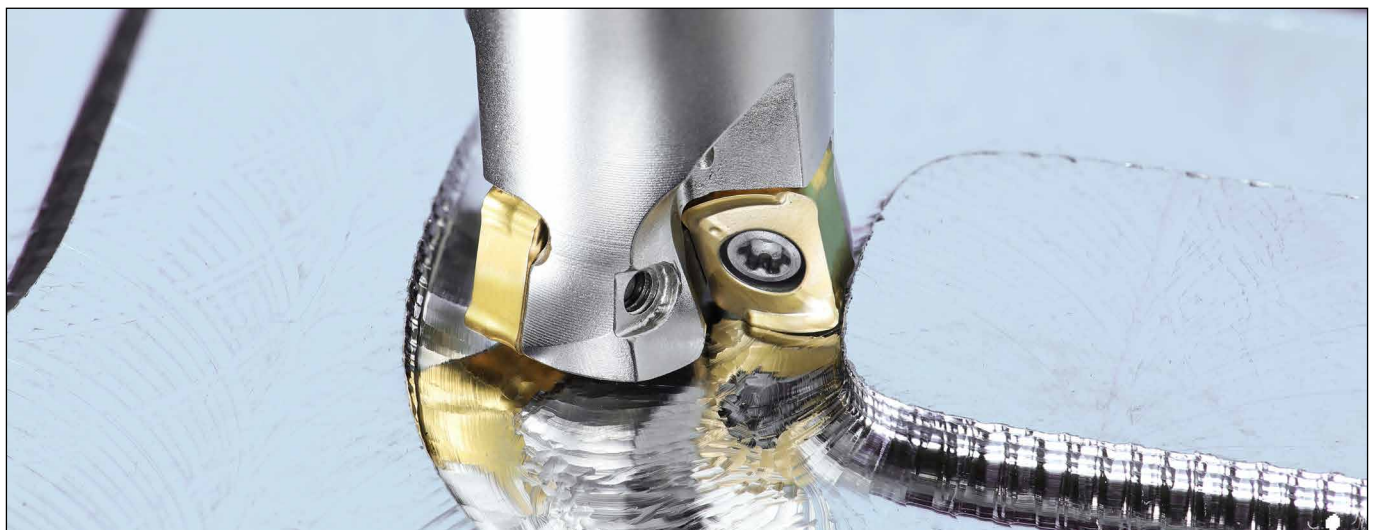
The BLMV line's V-shaped contact face, which prevents insert rotation during ramping and plunging operations, contributes to its steady machining performance and increased productivity. These features not only ensure a high ramping angle but also enable deeper step-down machining, boost productivity, and provide a range of machining entry operations.

The insert comes in an M type chip former and has a 6 mm I.C. size. Later, -MM and -ML chip formers will both be made available. There are two different types of cutters: Ø32-63 mm face cutters and Ø16 -40 mm end mills.

Please contact the product manager for more details.

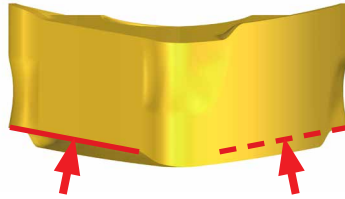
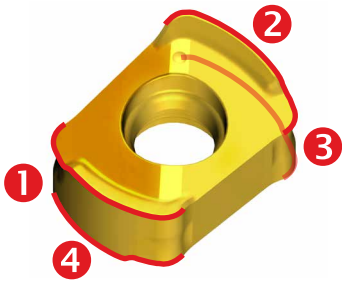
WIN-4-FEED Family

Insert	Cutter		
 <p data-bbox="240 1458 341 1485">BLMV 06</p>	 <p data-bbox="571 1429 687 1485">TEBLV-06 (Ø16-Ø40)</p>	 <p data-bbox="903 1429 1035 1485">TEBLV-M-06 (Ø16-Ø40)</p>	 <p data-bbox="1246 1429 1378 1485">TFMBLV-06 (Ø32-Ø63)</p>

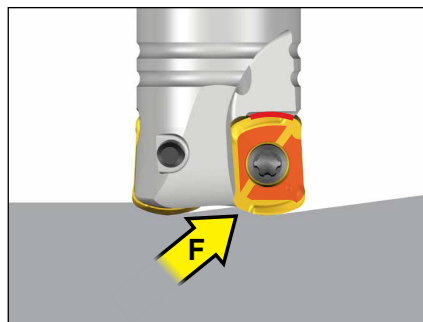


Features

- Double-sided 4-corner insert
- Stronger clamping due to the insert's top/bottom face V-shaped design



- Improved tool life even in ramping and step-down machining operations



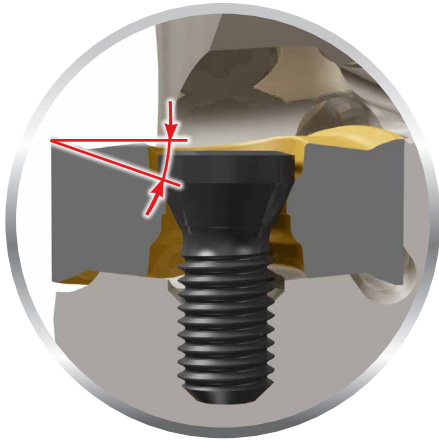
Ramping

- Insert design includes a higher ramping angle for improved productivity



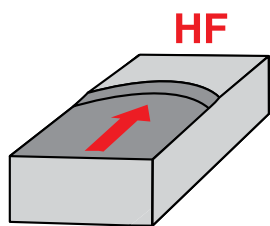
Cutter Diameter	Straight ramp down max. ramping angle	
	Competitor high feed insert	new BLMV
Ø16	2.0°	5.1°
Ø17	2.0°	4.5°
Ø20	1.5°	2.5°
Ø21	1.5°	2.3°
Ø25	1.3°	2.5°
Ø26	1.2°	2.2°
Ø32	0.9°	1.4°
Ø40	0.7°	1.2°
Ø50	0.6°	1.1°
Ø52	0.6°	0.7°
Ø63	0.5°	0.6°

- Excellent machining performance is made possible by the insert's higher rake angle

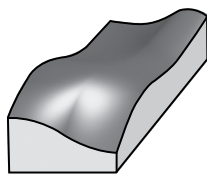


- Variable applications:

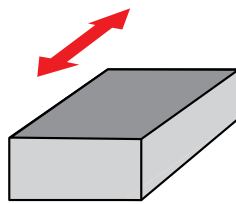
- Plunging, step down machining and BLMP machining applications



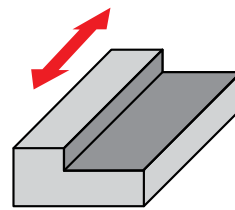
High feed milling



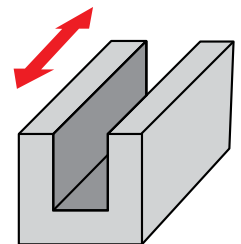
Profiling



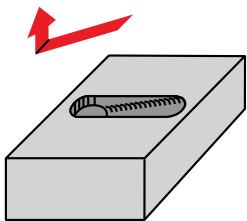
Facing



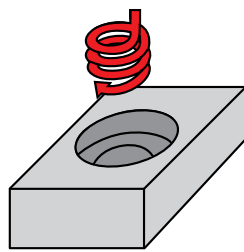
Shouldering



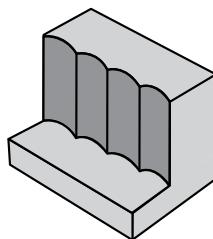
Slotting



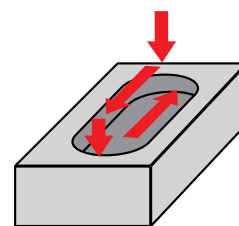
Straight ramping



Helical ramping



Plunging

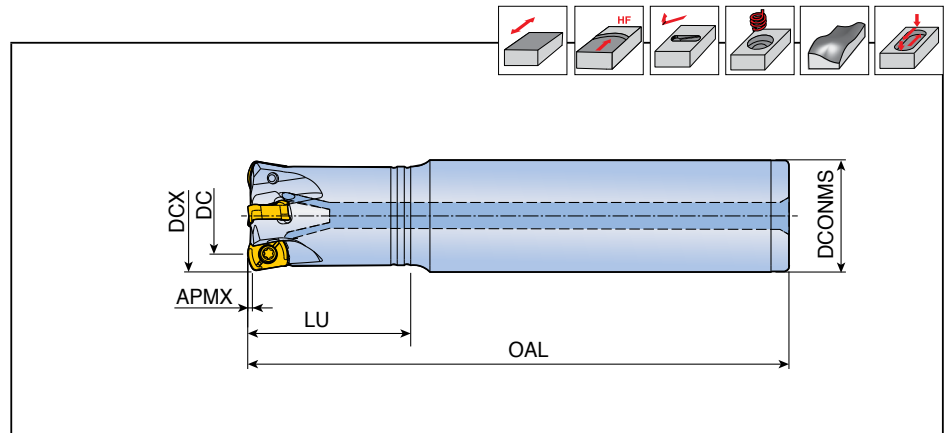


Step down

TEBLV-06



End mills

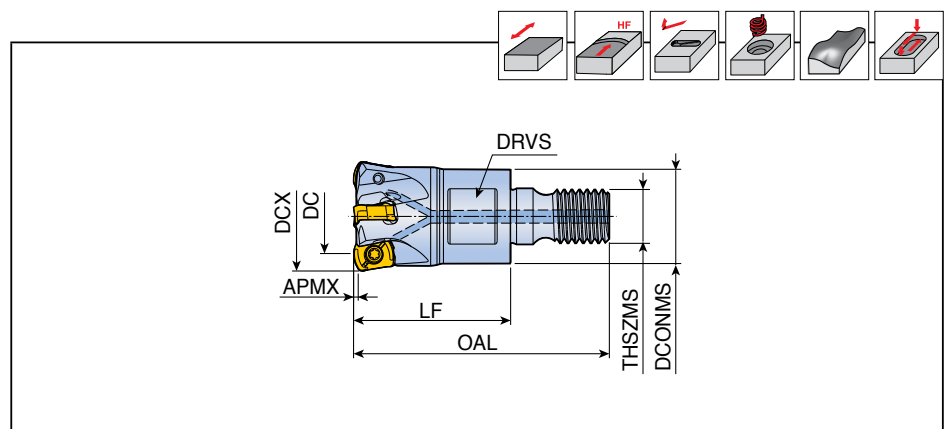


Designation	Flutes	Dimension (mm)						Coolant hole	Insert
		DCX	DC	DCONMS	OAL	LU	APMX		
TEBLV 216-15-06-L150	2	16	9.1	15	150	40	0.7	●	BLMV 0603...
216-16-06-L100	2	16	9.1	16	100	30	0.7	●	
216-16-06-L150	2	16	9.1	16	150	40	0.7	●	
217-16-06-L200	2	17	10.1	16	200	20	0.7	●	
320-20-06-L130	3	20	12	20	130	50	1.0	●	
320-20-06-L160	3	20	12	20	160	80	1.0	●	
321-20-06-L150	3	21	13	20	150	20	1.0	●	
321-20-06-L200	3	21	13	20	200	20	1.0	●	
425-25-06-L140	4	25	17	25	140	60	1.0	●	
425-25-06-L180	4	25	17	25	180	60	1.0	●	
426-25-06-L200	4	26	18	25	200	30	1.0	●	
532-32-06-L150	5	32	24	32	150	70	1.0	●	
640-32-06-L150	6	40	32	32	150	40	1.0	●	

TEBLV-M-06



Modular heads



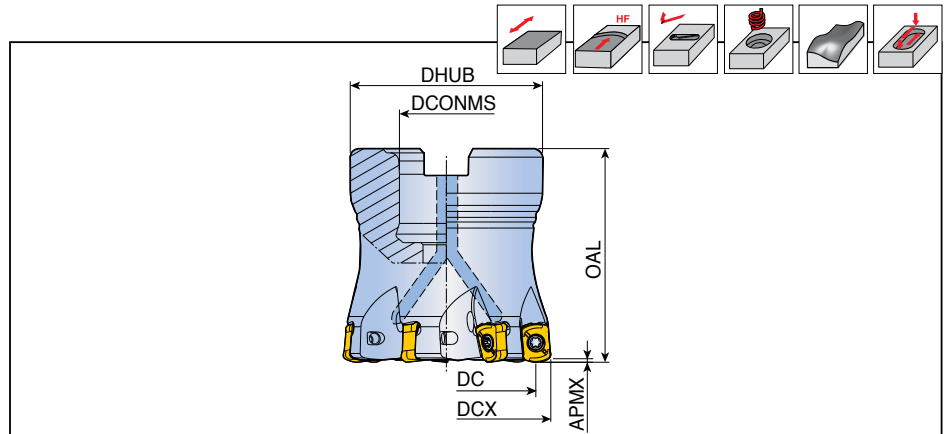
Designation	Flutes	Dimension (mm)								Coolant hole	Insert
		DCX	DC	DCONMS	LF	OAL	THSZMS	APMX	DRVS		
TEBLV 216-M08-06	2	16	9.1	13	25	42.5	M08	0.7	10	●	BLMV 0603...
320-M10-06	3	20	12	18	30	50	M10	1.0	15	●	
425-M12-06	4	25	17	21	35	57	M12	1.0	17	●	
532-M16-06	5	32	24	29	40	65	M16	1.0	25	●	
535-M16-06	5	35	27	29	43	68	M16	1.0	25	●	
640-M16-06	6	40	32	29	43	68	M16	1.0	25	●	

► Matched with T-FLEXTEC holder

TFMBLV-06



Face mills



Designation		Dimension (mm)							Coolant hole	Arbor type	Kg	Mounting bolt	Insert
		DCX	DC	DCONMS	DHUB	OAL	APMX						
TFMBLV 532-16R-06	5	32	24	16	30	40	1.0	●	A	0.1	SH M8x25	BLMV 0603...	
640-16R-06	6	40	32	16	38	40	1.0	●	A	0.2	SH M8x25		
650-22R-06	6	50	42	22	45	50	1.0	●	A	0.4	SH M10x30		
750-22R-06	7	50	42	22	45	50	1.0	●	A	0.4	SH M10x30		
752-22R-06	7	52	44	22	45	40	1.0	●	A	0.4	SH M10x30		
863-22R-06	8	63	55	22	48	50	1.0	●	A	0.6	SH M10x30		

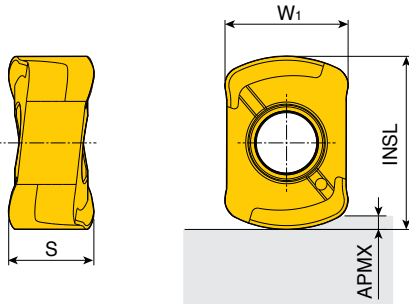
Spare parts

Designation	Screw	Wrench			
TEBLV/TFMBLV-06	TS 25064I/HG-P	TD 8P			

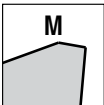
BLMV 06



Inserts



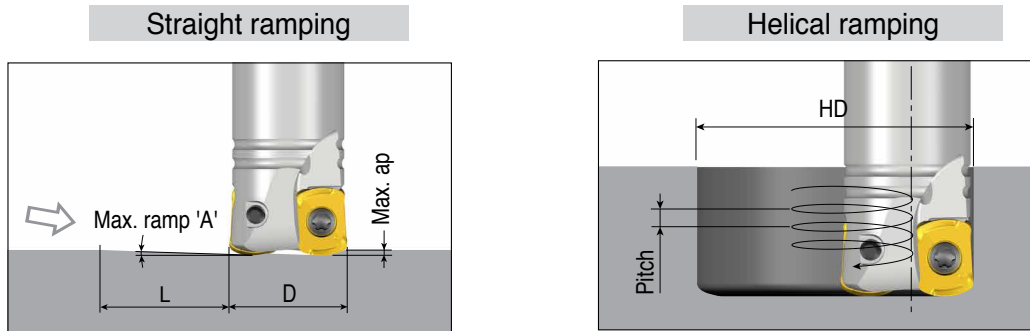
Size	Dimension (mm)				
	INSL	W1	S	APMX	
06	9	6.4	4.43	1.0	



Insert	Designation	Recommended machining conditions		Coated							Uncoated	
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525B	TT7080	TT2510	K10	
	BLMV 0603R-M	0.1-1.0	2.50-0.30	●		●		●		●		

●: Standard items

Ramping Data

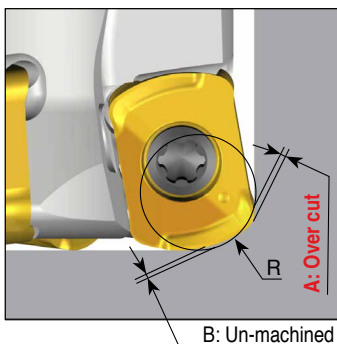


BLMV 06

(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.
Ø16	5.1	0.7	7.9	26	32	0.7
Ø17	4.5	0.7	8.9	28	34	0.7
Ø20	2.5	1.0	23.0	33	40	1.0
Ø21	2.3	1.0	25.0	35	42	1.0
Ø25	2.5	1.0	23.0	43	50	1.0
Ø26	2.2	1.0	26.1	45	52	1.0
Ø32	1.4	1.0	41.0	57	64	1.0
Ø40	1.2	1.0	47.8	73	80	1.0
Ø50	1.1	1.0	52.2	93	100	1.0
Ø52	0.7	1.0	81.9	97	104	1.0
Ø63	0.6	1.0	95.6	119	126	1.0

Programming technical data



	R Program	A Over cut	B Un-machined
BLMV 06 (Ø16, Ø17)	1.5	0	0.36
	2.0	0.09	0.22
	2.5	0.27	0.10
BLMV 06 (Ø20~)	1.5	0	0.58
	2.0	0	0.41
	2.5	0.12	0.26
	3.0	0.29	0.12

Yellow background: Recommended program 'R'