

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.

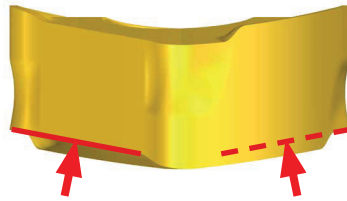
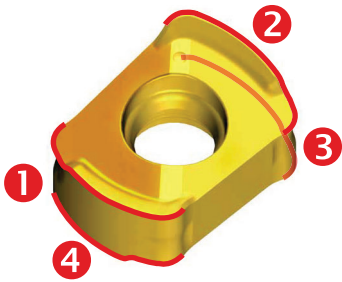
WIN-4-FEED Family

Insert	Cutter		
 <p data-bbox="240 1458 341 1487">BLMV 06</p>	 <p data-bbox="571 1429 687 1487">TEBLV-06 (Ø16-Ø40)</p>	 <p data-bbox="903 1429 1035 1487">TEBLV-M-06 (Ø16-Ø40)</p>	 <p data-bbox="1246 1429 1378 1487">TFMBLV-06 (Ø32-Ø63)</p>

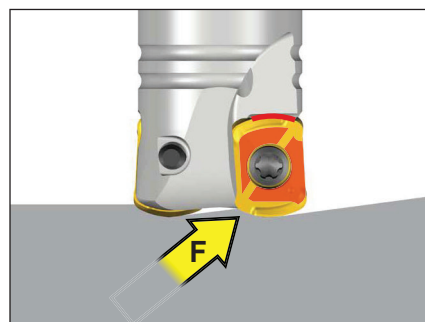
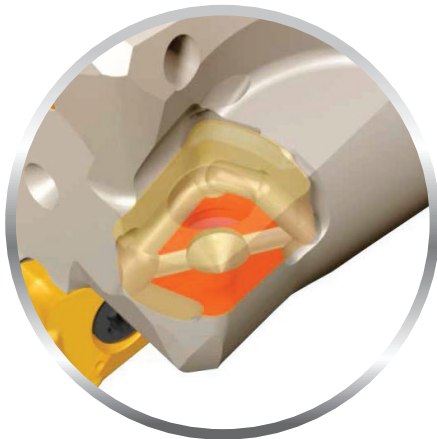


Features

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

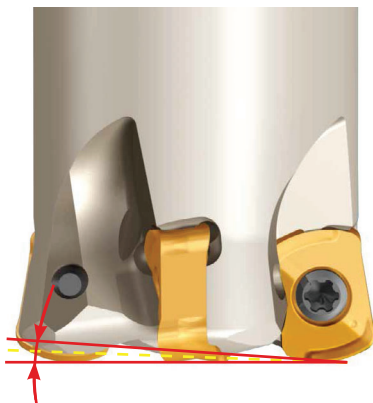


- Improved tool life even in ramping and step-down machining operations



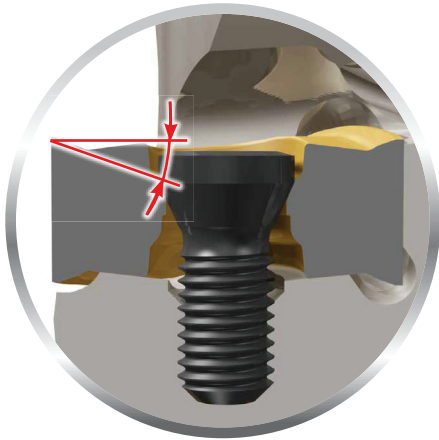
Ramping

- Insert design includes a higher ramping angle for improved productivity



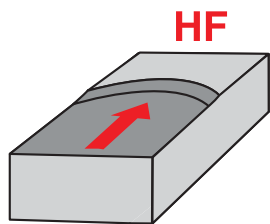
Cutter Diameter	Straight ramp down max. ramping angle	
	Competitor high feed insert	new BLMV
Ø16	2.0°	5.1°
Ø17	2.0°	4.5°
Ø20	1.5°	2.5°
Ø21	1.5°	2.3°
Ø25	1.3°	2.5°
Ø26	1.2°	2.2°
Ø32	0.9°	1.4°
Ø40	0.7°	1.2°
Ø50	0.6°	1.1°
Ø52	0.6°	0.7°
Ø63	0.5°	0.6°

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

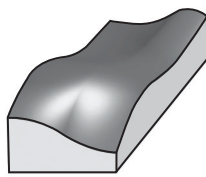


- Variable applications:

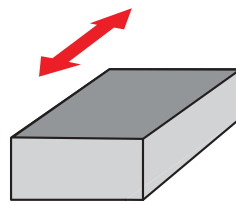
- Plunging, step down machining and BLMP machining applications



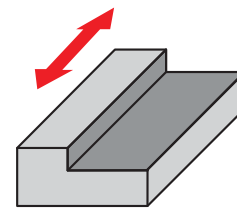
High feed milling



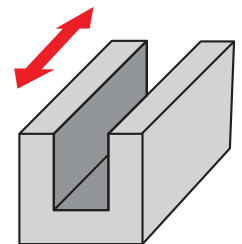
Profiling



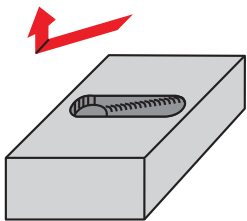
Facing



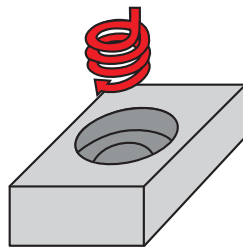
Shouldering



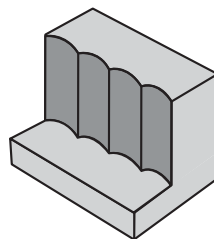
Slotting



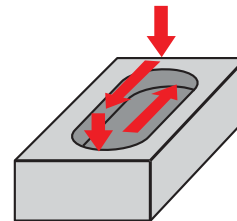
Straight ramping



Helical ramping



Plunging

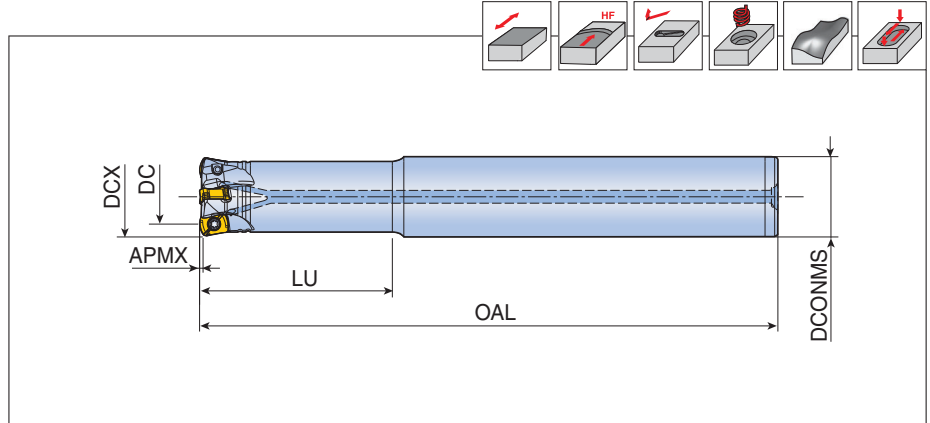


Step down

TEBLV-06



High feed 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-L100 new	2	17	10.1	16	100	30	0.7	●	
217-16-06-L150 new	2	17	10.1	16	150	40	0.7	●	
217-16-06-L200	2	17	10.1	16	200	20	0.7	●	
218-16-06-L150 new	2	18	11.2	16	150	25	0.7	●	
220-20-06-L200 new	2	20	12	20	200	80	1.0	●	
320-19-06-L180 new	3	20	12	19	180	80	1.0	●	
320-20-06-L130	3	20	12	20	130	50	1.0	●	
320-20-06-L160	3	20	12	20	160	80	1.0	●	
420-20-06-L130 new	4	20	12	20	130	50	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	●	
321-20-06-L250 new	3	21	13	20	250	20	1.0	●	
325-25-06-L220 new	3	25	17	25	220	50	1.0	●	
425-24-06-L180 new	4	25	17	24	180	60	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	●	
425-25-06-L250 new	4	25	17	25	250	40	1.0	●	
525-25-06-L140 new	5	25	17	25	140	60	1.0	●	
326-25-06-L200 new	3	26	18	25	200	30	1.0	●	

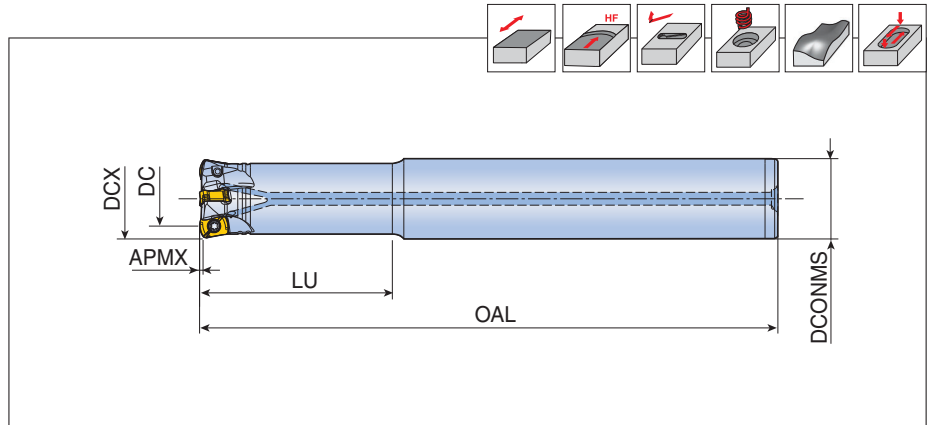
Spare parts

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

TEBLV-06



High feed end mills



Designation	Flutes	Dimension (mm)						Coolant hole	Insert
		DCX	DC	DCONMS	OAL	LU	APMX		
TEBLV 326-25-06-L250 new	3	26	18	25	250	30	1.0	●	BLMV 0603...
426-25-06-L150 new	4	26	18	25	150	30	1.0	●	
426-25-06-L200	4	26	18	25	200	30	1.0	●	
426-25-06-L250 new	4	26	18	25	250	30	1.0	●	
530-32-06-L150 new	5	30	22	32	150	70	1.0	●	
530-32-06-L200 new	5	30	22	32	200	120	1.0	●	
432-32-06-L150 new	4	32	24	32	150	70	1.0	●	
532-32-06-L150	5	32	24	32	150	70	1.0	●	
532-32-06-L200 new	5	32	24	32	200	120	1.0	●	
433-32-06-L220 new	4	33	25	32	220	40	1.0	●	
433-32-06-L300 new	4	33	25	32	300	50	1.0	●	
533-32-06-L150 new	5	33	25	32	150	30	1.0	●	
533-32-06-L200 new	5	33	25	32	200	40	1.0	●	
533-32-06-L250 new	5	33	25	32	250	40	1.0	●	
435-32-06-L200 new	4	35	27	32	200	50	1.0	●	
435-32-06-L300 new	4	35	27	32	300	50	1.0	●	
535-32-06-L200 new	5	35	27	32	200	50	1.0	●	
535-32-06-L300 new	5	35	27	32	300	50	1.0	●	
540-32-06-L220 new	5	40	32	32	220	40	1.0	●	
640-32-06-L150	6	40	32	32	150	40	1.0	●	
640-32-06-L220 new	6	40	32	32	220	40	1.0	●	
640-32-06-L250 new	6	40	32	32	250	40	1.0	●	

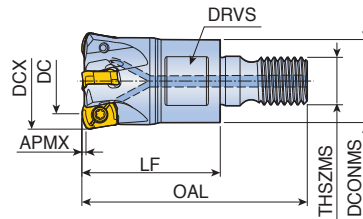
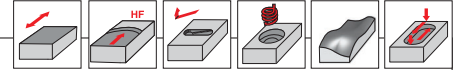
Spare parts

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



TEBLV-M-06

High feed modular heads



Designation	Z	Dimension (mm)								Coolant hole	Insert
		DCX	DC	DCONMS	LF	OAL	THSZMS	DRVS	APMX		
TEBLV 216-M08-06	2	16	9.1	13	25	42.5	M08	10	0.7	●	BLMV 0603...
217-M08-06 <small>new</small>	2	17	10.1	13	25	42.5	M08	10	0.7	●	
218-M08-06 <small>new</small>	2	18	11.2	13	25	42.5	M08	10	0.7	●	
220-M10-06 <small>new</small>	2	20	12	18	30	50	M10	15	1.0	●	
320-M10-06	3	20	12	18	30	50	M10	15	1.0	●	
321-M10-06 <small>new</small>	3	21	13	18	30	50	M10	15	1.0	●	
322-M10-06 <small>new</small>	3	22	14	18	30	50	M10	15	1.0	●	
325-M12-06 <small>new</small>	3	25	17	21	35	57	M12	17	1.0	●	
425-M12-06	4	25	17	21	35	57	M12	17	1.0	●	
326-M12-06 <small>new</small>	3	26	18	21	35	57	M12	17	1.0	●	
426-M12-06 <small>new</small>	4	26	18	21	35	57	M12	17	1.0	●	
530-M16-06 <small>new</small>	5	30	22	29	40	65	M16	25	1.0	●	
432-M16-06 <small>new</small>	4	32	24	29	40	65	M16	25	1.0	●	
532-M16-06	5	32	24	29	40	65	M16	25	1.0	●	
433-M16-06 <small>new</small>	4	33	25	29	40	65	M16	25	1.0	●	
533-M16-06 <small>new</small>	5	33	25	29	40	65	M16	25	1.0	●	
435-M16-06 <small>new</small>	4	35	27	29	43	68	M16	25	1.0	●	
535-M16-06	5	35	27	29	43	68	M16	25	1.0	●	
640-M16-06	6	40	32	29	43	68	M16	25	1.0	●	
542-M16-06 <small>new</small>	5	42	34	29	43	68	M16	25	1.0	●	
642-M16-06 <small>new</small>	6	42	34	29	43	68	M16	25	1.0	●	

► Matched with T-FLEXTEC holder

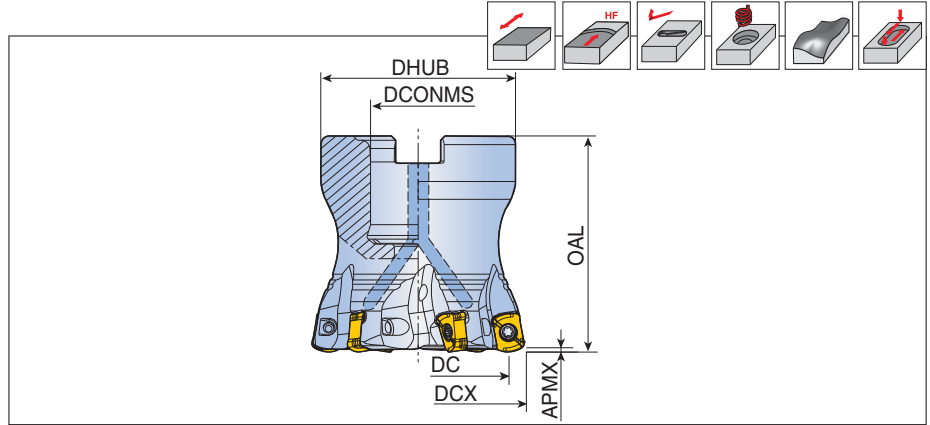
Spare parts

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

TFMBLV-06



High feed face mills



Designation	⌀	Dimension (mm)						Coolant hole	Arbor type	Kg	Mounting bolt	Insert
		DCX	DC	DCONMS	DHUB	OAL	APMX					
TFMBLV 432-16R-06 new	4	32	24	16	30	40	1.0	●	A	0.1	SH M8x25	BLMV 0603...
532-16R-06	5	32	24	16	30	40	1.0	●	A	0.1	SH M8x26	
640-16R-06	6	40	32	16	38	40	1.0	●	A	0.2	SH M8x25	
640-22R-06 new	6	40	32	22	38	40	1.0	●	A	0.2	SH M10x30	
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	
850-22R-06 new	8	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	
852-22R-06 new	8	52	44	22	45	40	1.0	●	A	0.4	SH M10x30	
763-22R-06 new	7	63	55	22	48	50	1.0	●	A	0.6	SH M10x30	
863-22R-06	8	63	55	22	48	50	1.0	●	A	0.6	SH M10x30	
963-22R-06 new	9	63	55	22	48	50	1.0	●	A	0.6	SH M10x30	
966-27R-06 new	9	66	58	27	58	50	1.0	●	A	0.7	SH M12x30	

► Mounting bolt with coolant through hole is available on request (ordering example: SH M10x1.5x30-C)

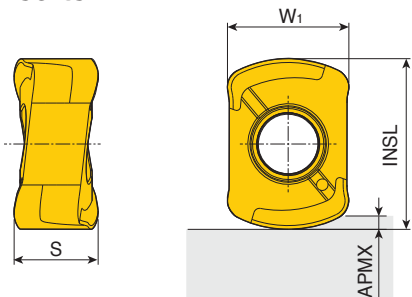
Spare parts

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

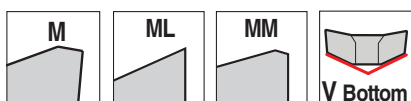
BLMV 06






High feed inserts



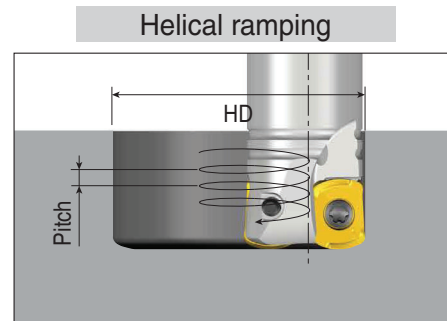
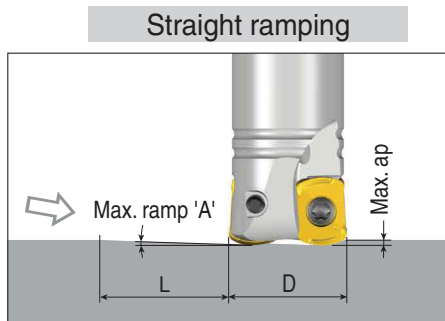
Size	Dimension (mm)				
	INSL	W1	S	APMX	
06	9	6.4	4.43	1.0	



Insert	Designation	Recommended machining conditions		Coated							Uncoated		
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525B	TT7080	TT3535	TT3520	TT2510	K10
	BLMV 0603R-M	0.1-1.0	2.50-0.35	●		●		●				●	
	BLMV 0603R-ML new	0.1-1.0	0.80-0.12	●		●				●	●		
	BLMV 0603R-MM new	0.1-1.0	2.00-0.25	●		●				●	●	●	

●: Standard items

Ramping Data

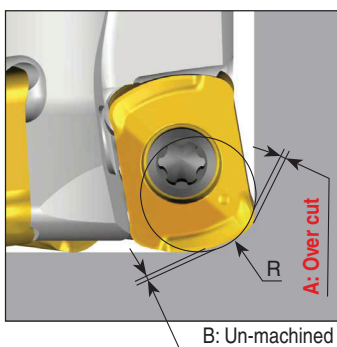


BLMV 06

(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	8	27	32	0.7
Ø17	4.5	0.7	9	29	34	0.7
Ø18	4.4	0.7	10	31	36	0.7
Ø20	2.5	1.0	23	34	40	1.0
Ø21	2.3	1.0	25	35	42	1.0
Ø22	2.7	1.0	22	39	44	1.0
Ø25	2.5	1.0	23	43	50	1.0
Ø26	2.2	1.0	26	45	52	1.0
Ø30	1.6	1.0	35	55	60	1.0
Ø32	1.4	1.0	40	57	64	1.0
Ø33	1.3	1.0	43	59	66	1.0
Ø35	1.2	1.0	46	63	70	1.0
Ø40	1.0	1.0	55	73	80	1.0
Ø42	1.0	1.0	58	79	84	1.0
Ø50	0.8	1.0	72	93	100	1.0
Ø52	0.8	1.0	77	97	104	1.0
Ø63	0.6	1.0	96	119	126	1.0
Ø66	0.6	1.0	96	127	132	1.0

Programming technical data



	R Program	A Over cut	B Un-machined
BLMV 06 (Ø16, Ø17, Ø18)	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'