



TBB Cutting Tool

M4 Series

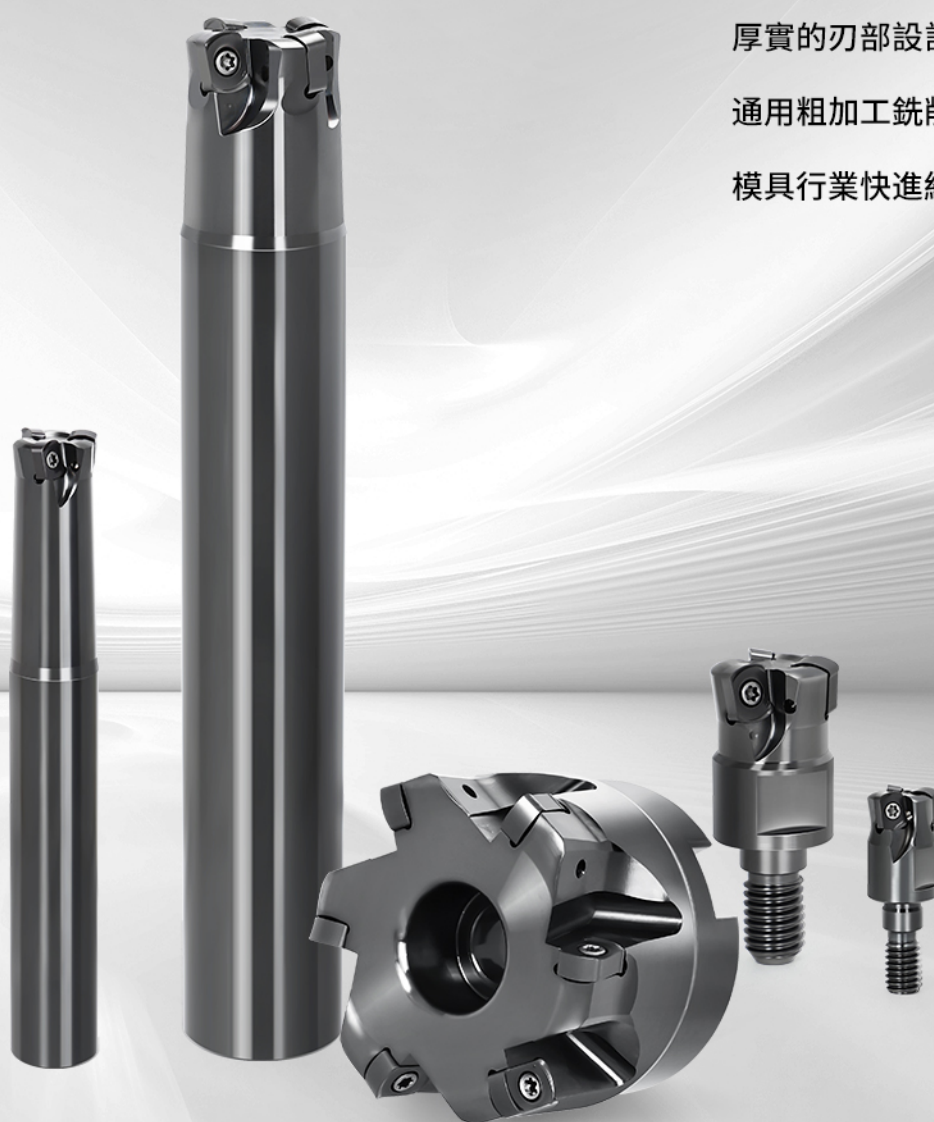
快進給銑削系列 MILLING TOOLS SERIES

BLMP04 / BLMP06 (BLMP)

厚實的刃部設計增強抗崩性

通用粗加工銑削加工首選

模具行業快進給解決方案



團隊切削 行家首選

TEAMCUTTING EXPERT PREFERRED

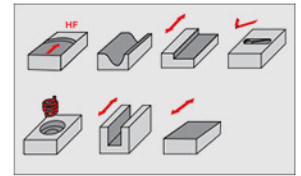
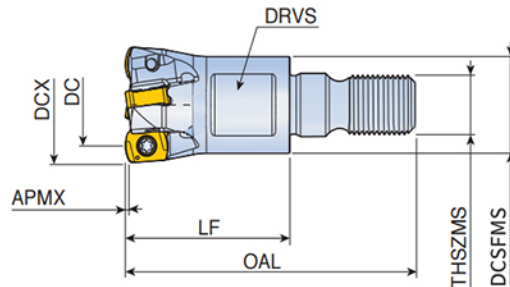
TMHBL04 (BLMP)

4刃雙面刀片快進給鎖牙銑刀頭

High Feed Modular Heads

BLMP04系列

BLMP04 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							THSZMS 螺紋規格	INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LF	DRVS		
TMHBL04-108-M04	1	0.5	8	3.6	7.8	28	17	7	M6xP1.0	BLMP04...
TMHBL04-109-M04	1	0.5	9	4.6	7.8	28	17	7	M6xP1.0	BLMP04...
TMHBL04-210-M05	2	0.5	10	5.6	9	28	17	7	M6xP1.0	BLMP04...
TMHBL04-211-M05	2	0.5	11	6.6	9	28	17	7	M6xP1.0	BLMP04...
TMHBL04-312-M06	3	0.5	12	7.6	11	32	17	9	M6xP1.0	BLMP04...
TMHBL04-313-M06	3	0.5	13	8.6	11	32	17	9	M6xP1.0	BLMP04...
TMHBL04-314-M06	3	0.5	14	9.6	13	32	17	10	M6xP1.0	BLMP04...
TMHBL04-315-M06	3	0.5	15	10.6	13	32	17	10	M6xP1.0	BLMP04...
TMHBL04-314-M08	3	0.5	14	9.6	13	34.5	17	10	M8xP1.25	BLMP04... *
TMHBL04-315-M08	3	0.5	15	10.6	13	34.5	17	10	M8xP1.25	BLMP04... *
TMHBL04-416-M08	4	0.5	16	11.6	15	43	25	12	M8xP1.25	BLMP04...
TMHBL04-417-M08	4	0.5	17	12.6	15	43	25	12	M8xP1.25	BLMP04...

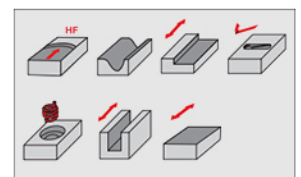
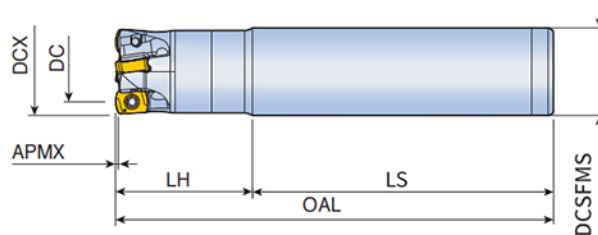
TEHBL04 (BLMP)

4刃雙面刀片快進給銑刀桿

High Feed End Mills

BLMP04系列

BLMP04 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LH	LS	
TEHBL04-107-10-80	1	0.5	7	2.8	10	80	17.5	62.5	BLMP04...
TEHBL04-108-10-80	1	0.5	8	3.8	10	80	20	60	BLMP04...
TEHBL04-109-10-80	1	0.5	9	4.8	10	80	22.5	57.5	BLMP04...
TEHBL04-210-10-80	2	0.5	10	5.7	10	80	25	55	BLMP04...
TEHBL04-211-10-80	2	0.5	11	6.6	10	80	20	60	BLMP04...
TEHBL04-312-12-80	3	0.5	12	7.6	12	80	30	50	BLMP04...
TEHBL04-313-12-80	3	0.5	13	8.6	12	80	20	60	BLMP04...
TEHBL04-314-14-100	3	0.5	14	9.6	14	100	35	65	BLMP04...
TEHBL04-315-14-100	3	0.5	15	10.6	14	100	20	80	BLMP04...
TEHBL04-416-16-120	4	0.5	16	11.6	16	120	40	80	BLMP04...
TEHBL04-417-16-120	4	0.5	17	12.6	16	120	20	100	BLMP04...

刀片相關資訊請參照第M4-03頁

切削參數請參照第M4-04頁

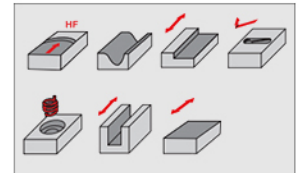
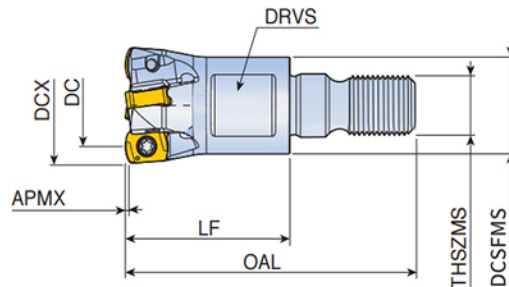
TMHBL06 (BLMP)

4刃雙面刀片快進給鎖牙銑刀頭

High Feed Modular Heads

BLMP06系列

BLMP06 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							THSZMS 螺紋規格	INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LF	DRVS		
TMHBL06-216-M08	2	1	16	9.4	15	43	25.5	12	M8xP1.25	BLMP06...
TMHBL06-217-M08	2	1	17	10.1	15	43	25.5	12	M8xP1.25	BLMP06...
TMHBL06-218-M08	2	1	18	11.1	15	43	25.5	12	M8xP1.25	BLMP06...
TMHBL06-320-M10	3	1	20	12.4	19	49	29	15	M10xP1.5	BLMP06...
TMHBL06-321-M10	3	1	21	13.4	19	49	29	15	M10xP1.5	BLMP06...
TMHBL06-425-M12	4	1	25	17.3	24	57	35	19	M12xP1.75	BLMP06...
TMHBL06-426-M12	4	1	26	18.3	24	57	35	19	M12xP1.75	BLMP06...
TMHBL06-430-M16	4	1	30	22.3	29	63	38	24	M16xP2.0	BLMP06...
TMHBL06-532-M16	5	1	32	24.3	31	63	38	24	M16xP2.0	BLMP06...
TMHBL06-533-M16	5	1	33	25.3	31	63	38	24	M16xP2.0	BLMP06...

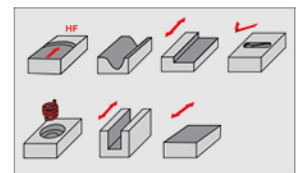
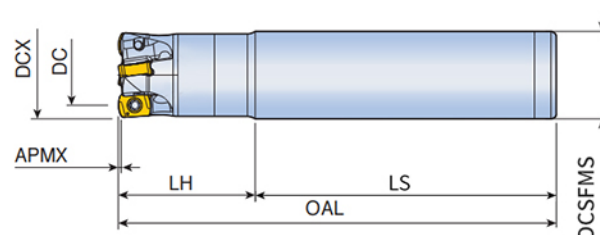
TEHBL06 (BLMP)

4刃雙面刀片快進給銑刀桿

High Feed End Mills

BLMP06系列

BLMP06 Series



Designation 型號	CIC 齒數	Dimension (mm)/尺寸							INSERT 刀片
		APMX	DCX	DC	DCSFMS	OAL	LH	LS	
TEHBL06-216-16-120	2	1	16	9.4	16	120	25	95	BLMP06...
TEHBL06-217-16-160	2	1	17	10.1	16	160	15	145	BLMP06...
TEHBL06-320-20-120	3	1	30	12.4	20	120	25	95	BLMP06...
TEHBL06-320-20-160	3	1	20	12.4	20	160	25	135	BLMP06...
TEHBL06-321-20-160	3	1	21	13.4	20	160	20	140	BLMP06...
TEHBL06-321-20-200	3	1	21	13.4	20	200	20	180	BLMP06...
TEHBL06-425-25-160	4	1	25	17.3	25	160	30	130	BLMP06...
TEHBL06-425-25-200	4	1	25	17.3	25	200	30	170	BLMP06...
TEHBL06-426-25-160	4	1	26	18.3	25	160	20	140	BLMP06...
TEHBL06-426-25-200	4	1	26	18.3	25	200	20	180	BLMP06...
TEHBL06-430-28-160	4	1	30	22.3	28	160	30	130	BLMP06...
TEHBL06-532-32-160	5	1	32	24.3	32	160	35	125	BLMP06...
TEHBL06-532-32-200	5	1	32	24.3	32	200	35	165	BLMP06...
TEHBL06-533-32-160	5	1	33	25.3	32	160	25	135	BLMP06...
TEHBL06-533-32-200	5	1	33	25.3	32	200	25	175	BLMP06...

刀片相關資訊請參照第M4-03頁

切削參數請參照第M4-04頁

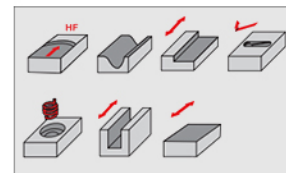
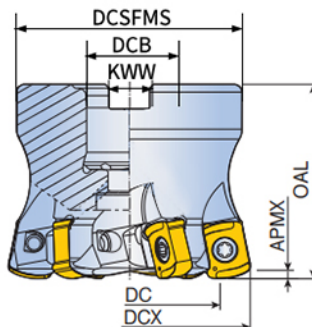
TFHBL06 (BLMP)

4刃雙面刀片快進給銑刀盤

High Feed Face Mills

BLMP06系列

BLMP06 Series



Designation 型號	CICT 齒數	Dimension (mm)/尺寸							INSERT 刀片
		APMX	DCX	DC	DCB	OAL	KWW	DCSFMS	
TFHBL06-535-16	5	1	35	27.3	16	40	8.4	32	BLMP06...
TFHBL06-540-16	5	1	40	32.2	16	40	8.4	32	BLMP06...
TFHBL06-650-22	6	1	50	42.2	22	40	10.4	45	BLMP06...
TFHBL06-863-22	8	1	63	55.5	22	40	10.4	48	BLMP06...
TFHBL06-1080-27	10	1	80	72.5	27	50	12.4	60	BLMP06...

BLMP0402 (BLMP)

4刃雙面快進給銑刀片

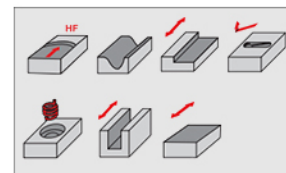
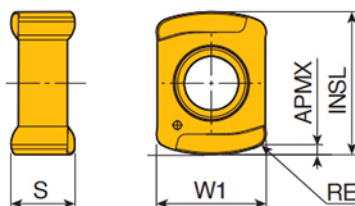
High Feed Inserts

BLMP04系列

BLMP04 Series



P 銅
M 不鏽鋼
S 鈦、鎳



Designation 型號	Dimension (mm)/尺寸						Grade 材質	Use 用途
	IC/大小	S/厚度	RE/圓角	APMX/最大切深	Screw/螺絲	Wrench/扳手		
BLMP0402R-M	6	2.5	0.5	0.5	TSA-18040-1	TWA-T6	TC3320	P
							TC5520	M S

BLMP0603 (BLMP)

4刃雙面快進給銑刀片

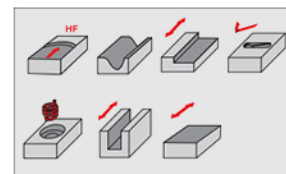
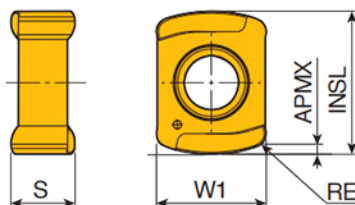
High Feed Inserts

BLMP06系列

BLMP06 Series



P 銅
M 不鏽鋼
S 鈦、鎳



Designation 型號	Dimension (mm)/尺寸						Grade 材質	Use 用途
	IC/大小	S/厚度	RE/圓角	APMX/最大切深	Screw/螺絲	Wrench/扳手		
BLMP0603R-M	9	3.73	0.9	1	TSA-25070-1	TWA-T8	TC3320	P
							TC5520	M S

R-M槽型多用於模具、機械加工領域

刀盤相關資訊請參照第M4-03頁

鎖牙銑刀頭、銑刀桿相關資訊請參照第M4-01, M4-02頁

BLMP0402/BLMP0603 (BLMP)

4刃雙面快進給銑刀片

High Feed Mill Inserts

BLMP04/BLMP06系列

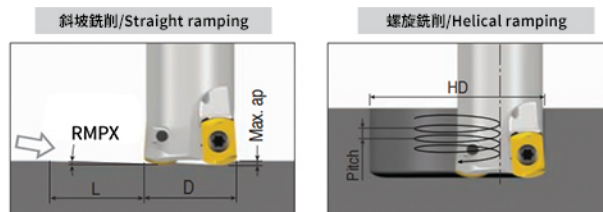
BLMP04/BLMP06 Series

切削參數 / Cutting Conditions

ISO	Material/工件材料	Hardness/硬度	Vc (m/min)/切削速度	fz (mm/t)/每齒進給量
P	碳鋼 S45C, S55C ... C45, C55 ...	-300HB	100-300	0.5-3.0
	合金鋼 SCM440, SCr415 ... 42CrMo4 ...	-300HB	120-250	0.4-2.5
	預硬化鋼 NAK80, PX5 ...	30-40HRC	80-160	0.3-2.0
M	不銹鋼 SUS304, SUS316 ... X5CrNi18-9 X5CrNiMo17-12-2 ...	-200HB	100-170	0.3-2.0
K	灰鑄鐵 FC250, FC300 ... 250, 300 ...	150-250HB	100-300	0.5-2.0
	球墨鑄鐵 FCD400 ... 400-15, 600-3 ...	150-250HB	80-200	0.5-2.0
S	鈦合金 Ti-6Al-4V ...	-40HRC	30-80	0.3-1.2
	耐熱合金 Inconel, Hastelloy...	-40HRC	20-60	0.3-1.0
H	淬火鋼	SKD61 ... X40CrMoV5-1 ...	80-150	0.3-1.2
		SKD11 ... X153CrMoV12...	50-70	0.2-1.0

刀具應用注意事項

當使用CAM軟件編程時，該刀具應設置成圓角刀具，通常BLMP04的圓角最大設定值為R=0.9以內，BLMP0603在刀具直徑20mm以內的最大設定為R=1.5以內，刀具直徑大於20mm的最大設定值為R=2.0。
如果圓角設置過大會出現過切的情況。



● BLMP0402 (BLMP)

型號	DCX	斜坡銑削/Straight ramping			螺旋銑削/Helical ramping		
		APMX	RMPX	Min. length (L)	Min. dia.	Max. dia.	Max. pitch/rev.
		最大切深	最大斜坡銑角度	最短距離	最小加工孔徑	最大加工孔徑	最大軸向切深
TEHBL04-108-10-80	8	0.5	0.4°	72	12.6	16	0.1
TEHBL04-210-10-80	10	0.5	0.6°	44	16.6	20	0.2
TEHBL04-211-10-80	11	0.5	0.7°	38	18.6	22	0.2
TEHBL04-312-12-80	12	0.5	1.0°	29	20.6	24	0.4
TEHBL04-313-12-80	13	0.5	1.1°	25	22.6	26	0.5
TEHBL04-314-14-100	14	0.5	1.1°	29	24.6	28	0.5
TEHBL04-315-14-100	15	0.5	1.1°	29	26.6	30	0.5
TEHBL04-416-16-120	16	0.5	1.0°	29	28.6	32	0.5
TEHBL04-417-16-120	17	0.5	1.1°	25	30.6	34	0.5

● BLMP0603 (BLMP)

型號	DCX	斜坡銑削/Straight ramping			螺旋銑削/Helical ramping		
		APMX	RMPX	Min. length (L)	Min. dia.	Max. dia.	Max. pitch/rev.
		最大切深	最大斜坡銑角度	最短距離	最小加工孔徑	最大加工孔徑	最大軸向切深
TEHBL06-216-16-120	16	1.0	2.0°	13	23	32	0.7
TEHBL06-217-16-160	17	1.0	2.0°	15	25	34	0.7
TEHBL06-320-20-120	20	1.0	1.5°	38	31	40	0.8-1.0
TEHBL06-321-20-160	21	1.0	1.5°	38	33	42	0.8-1.0
TEHBL06-425-25-160	25	1.0	1.3°	41	41	50	1.0
TEHBL06-426-25-200	26	1.0	1.2°	44	43	52	1.0
TEHBL06-532-32-160	32	1.0	0.9°	57	55	64	1.0
TFHBL06-540-16	40	1.0	0.7°	64	71	80	1.0
TFHBL06-650-22	50	1.0	0.5°	96	91	100	1.0
TFHBL06-863-22	63	1.0	0.5°	115	117	126	1.0
TFHBL06-1080-27	80	1.0	0.4°	135	151	160	1.0