

NEW PRODUCT

BASIC LINE+

▶ 4 flute CAM-EXPERT end mill 36°-38°



The SCT 4 flute "CAM-EXPERT" variable helix geometry and unique face geometry allow CAD/CAM users to drill, slot, ramp down and perform peripheral milling with 1 single tool.

No. BLC4Lxxx38VND

Milling cutter dia.	5,7 - 19,5 mm
	6,0 - 20,0 mm
Shank type	DIN 6535 HA
	DIN 6535 HB
Coating	AlTiN
Number of flutes	4
Helix angle	36°-38°

HIGH QUALITY COATING

The AlTiN coating isolates the solid carbide from the generated heat and allows long tool life as well as high cutting conditions.

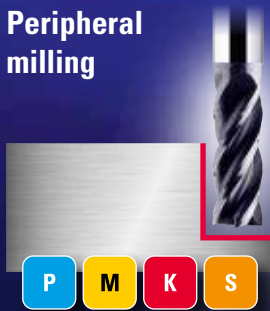
VARIABLE HELIX GEOMETRY

The 36°-38° helix angle provides excellent stability for chatter free machining and leaves outstanding surface finish for both slot and peripheral milling.

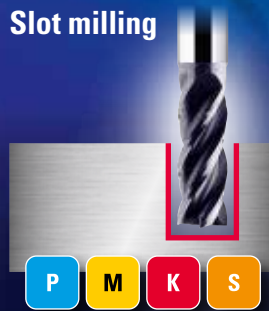
UNIQUE END FACE GEOMETRY

The SCT end face geometry makes the tool suitable for drilling applications up to 2xD and provides excellent conditions for ramping down to 45°.

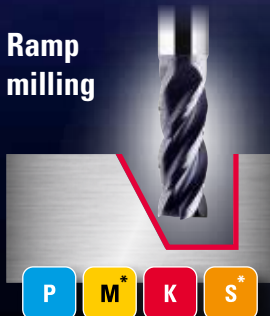
Peripheral milling



Slot milling



Ramp milling



Drilling



* Ramping MAX 5°-10°



Improving Quality Through Innovation

Product of Holland

4 flute end mill 36°-38°; DIN6527L; long length; AlTiN coated

Specifications



DIN 6535 HA	DIN 6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	z	Price / pc.
BLC4L05738VND	BLW4L05738VND	5,7	6	13	19	5,4	57	-	4	€ 30,85
BLC4L06038VND	BLW4L06038VND	6,0	6	13	19	5,7	57	-	4	€ 30,85
BLC4L07738VND	BLW4L07738VND	7,7	8	19	25	7,3	63	-	4	€ 39,15
BLC4L08038VND	BLW4L08038VND	8,0	8	19	25	7,6	63	-	4	€ 39,15
BLC4L09738VND	BLW4L09738VND	9,7	10	22	30	9,2	72	-	4	€ 58,60
BLC4L10038VND	BLW4L10038VND	10,0	10	22	30	9,5	72	-	4	€ 58,60
BLC4L11738VND	BLW4L11738VND	11,7	12	26	36	11,2	83	-	4	€ 76,80
BLC4L12038VND	BLW4L12038VND	12,0	12	26	36	11,5	83	-	4	€ 76,80
BLC4L13738VND	BLW4L13738VND	13,7	14	26	36	13,2	83	-	4	€ 98,85
BLC4L14038VND	BLW4L14038VND	14,0	14	26	36	13,5	83	-	4	€ 98,85
BLC4L15638VND	BLW4L15638VND	15,6	16	32	42	15,1	92	-	4	€ 124,95
BLC4L16038VND	BLW4L16038VND	16,0	16	32	42	15,5	92	-	4	€ 124,95
BLC4L19538VND	BLW4L19538VND	19,5	20	38	52	19,0	104	-	4	€ 189,95
BLC4L20038VND	BLW4L20038VND	20,0	20	38	52	19,5	104	-	4	€ 189,95

Other dimensions on request

Dimensions in mm



Workpiece material groups and cutting speed

	Material	Tensile strength Rm [N/mm²]	Hardness [HB/HRC]	Cutting speed Vc [m/min]			fz [beim Ae = 0,3xD / Ap = 1,5xD]						
				min	opt	max	5,7-6	7,7-8	9,7-10	11,7-12	15,7-16	19,7-20	
Peripheral milling	P	Plain carbon steel	< 600	< 230	180	210	240	0,045	0,060	0,070	0,085	0,115	0,140
		Alloy Steel	< 1200	< 350	150	175	200	0,040	0,055	0,065	0,080	0,100	0,120
		High alloy steel and tool steel	< 1400	< 380	100	120	140	0,035	0,050	0,060	0,075	0,085	0,100
	M	Aust. and Ferr. Stainless steel	< 680	< 220	80	110	140	0,030	0,040	0,055	0,070	0,075	0,085
		Mart. Stainless steel	< 820	< 240	60	90	120	0,030	0,040	0,050	0,055	0,070	0,080
	K	Grey cast iron	-	< 280	120	150	180	0,030	0,045	0,060	0,075	0,090	0,110
		Ductile cast iron	-	< 320	90	110	130	0,030	0,045	0,060	0,075	0,090	0,110
	S	High temperature alloys Fe, Ni and Co based	< 3300	< 350	40	50	60	0,030	0,040	0,055	0,070	0,075	0,085
		Titanium alloys; Alpha and Beta	< 2100	< 400	60	70	80	0,030	0,040	0,050	0,055	0,070	0,080
	Slot milling	P	Plain carbon steel	< 600	< 230	180	210	240	0,035	0,050	0,060	0,070	0,095
Alloy Steel			< 1200	< 350	150	175	200	0,030	0,045	0,055	0,060	0,085	0,100
High alloy steel and tool steel			< 1400	< 380	100	120	140	0,025	0,040	0,050	0,050	0,075	0,090
M		Aust. and Ferr. Stainless steel	< 680	< 220	80	110	140	0,020	0,030	0,045	0,060	0,065	0,075
		Mart. Stainless steel	< 820	< 240	60	90	120	0,020	0,030	0,040	0,045	0,060	0,070
K		Grey cast iron	-	< 280	120	150	180	0,025	0,035	0,050	0,060	0,080	0,100
		Ductile cast iron	-	< 320	90	110	130	0,025	0,035	0,050	0,060	0,080	0,100
S		High temperature alloys Fe, Ni and Co based	< 3300	< 350	40	50	60	0,020	0,030	0,045	0,060	0,065	0,075
		Titanium alloys; Alpha and Beta	< 2100	< 400	60	70	80	0,020	0,030	0,040	0,045	0,060	0,070
Ramp milling		P	Plain carbon steel	< 600	< 230	180	210	240	0,025	0,0375	0,04500	0,050	0,070
	Alloy Steel		< 1200	< 350	150	175	200	0,025	0,0350	0,04000	0,045	0,065	0,075
	High alloy steel and tool steel		< 1400	< 380	100	120	140	0,020	0,0300	0,03500	0,040	0,055	0,070
	M	Aust. and Ferr. Stainless steel	< 680	< 220	80	110	140	0,015	0,0225	0,03375	0,045	0,050	0,055
		Mart. Stainless steel	< 820	< 240	60	90	120	0,015	0,0200	0,03000	0,035	0,045	0,050
	K	Grey cast iron	-	< 280	120	150	180	0,018	0,0250	0,03750	0,045	0,060	0,075
		Ductile cast iron	-	< 320	90	110	130	0,018	0,0250	0,03750	0,045	0,060	0,075
	S	High temperature alloys Fe, Ni and Co based	< 3300	< 350	40	50	60	0,015	0,0200	0,03500	0,045	0,050	0,055
		Titanium alloys; Alpha and Beta	< 2100	< 400	60	70	80	0,015	0,0200	0,03000	0,035	0,045	0,050
	Drilling	P	Plain carbon steel	< 600	< 230	180	210	240	0,0175	0,0250	0,0300	0,035	0,0475
Alloy Steel			< 1200	< 350	150	175	200	0,0150	0,0225	0,0275	0,030	0,0425	0,050
High alloy steel and tool steel			< 1400	< 380	100	120	140	0,0125	0,0200	0,0250	0,025	0,0375	0,045
M		Aust. and Ferr. Stainless steel*	< 680	< 220	-	-	-	-	-	-	-	-	-
		Mart. Stainless steel*	< 820	< 240	-	-	-	-	-	-	-	-	-
K		Grey cast iron	-	< 280	120	150	180	0,0125	0,0175	0,0250	0,030	0,040	0,050
		Ductile cast iron	-	< 320	90	110	130	0,0125	0,0175	0,0250	0,030	0,040	0,050
S		High temperature alloys Fe, Ni and Co based*	< 3300	< 350	-	-	-	-	-	-	-	-	-
		Titanium alloys; Alpha and Beta*	< 2100	< 400	-	-	-	-	-	-	-	-	-

*Drilling in material groups M1+M2 and S1+S2 is not recommended