

# 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.

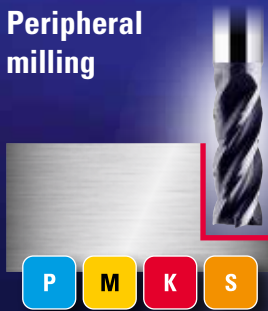
#### VARIABLE HELIX GEOMETRY

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

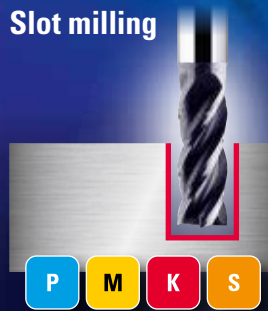
#### UNIQUE END FACE GEOMETRY

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

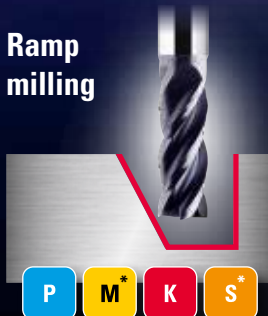
#### Peripheral milling



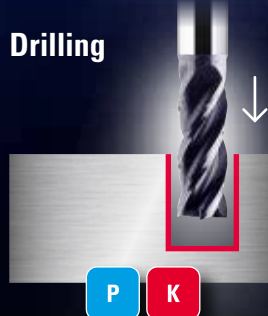
#### Slot milling



#### Ramp milling



#### Drilling



\* Ramping MAX 5°-10°

**Faitools srl**  
via Di Vittorio 2  
VILLANOVA

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