

NPA

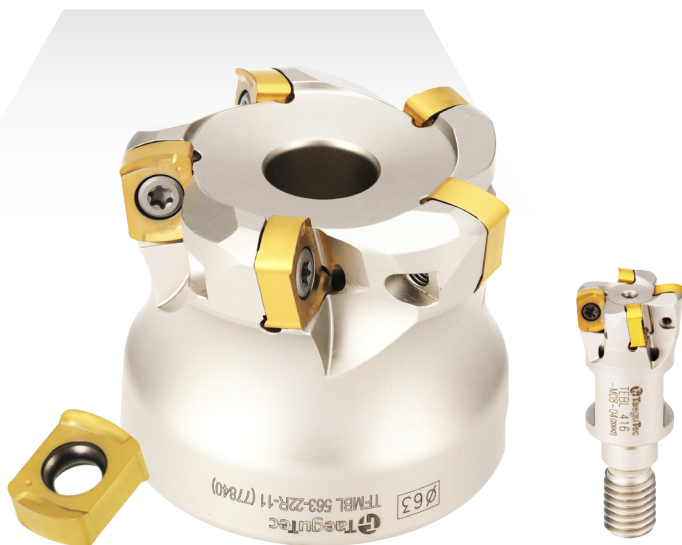
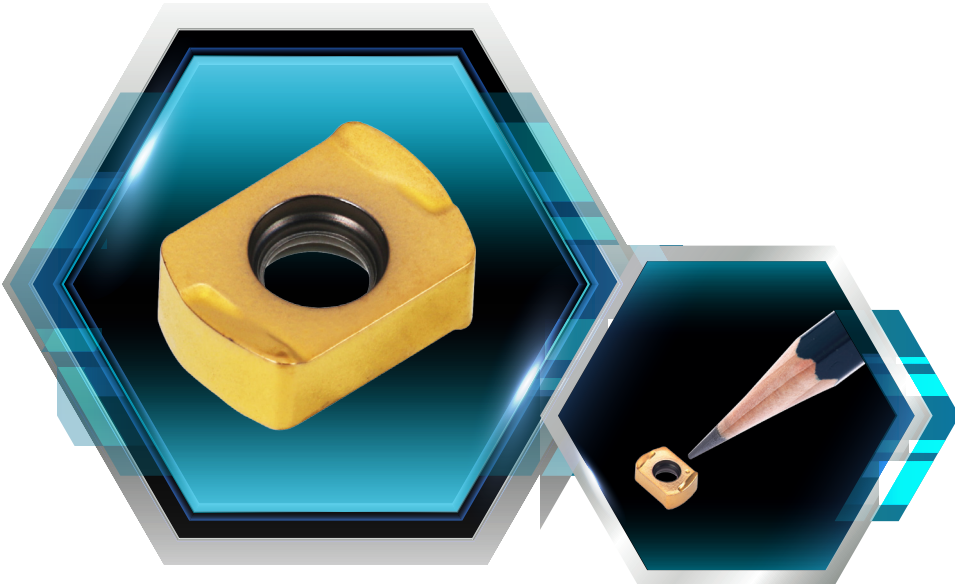
New Product Announcement No. 2019-27



CHASE4FEED

HIGH FEED MILL

Versatile High Feed Mill with
Strong 4 Cutting Edge Insert



KEY POINT

TaeguTec has released an expansion to the CHASE-4-FEED family - BLMP 04, 11 inserts and cutters.

To meet market demand, smaller double-sided four corner designed **BLMP 04** inserts have been launched for small and high feed machining applications.

The smaller size inserts mean more inserts can be mounted to the same diameter cutters, which will greatly improve productivity over the existing BLMP 06 type under similar conditions. Available in Ø8(1z) and Ø10(2z) sizes, these are an alternative to solid end mills for roughing operations.

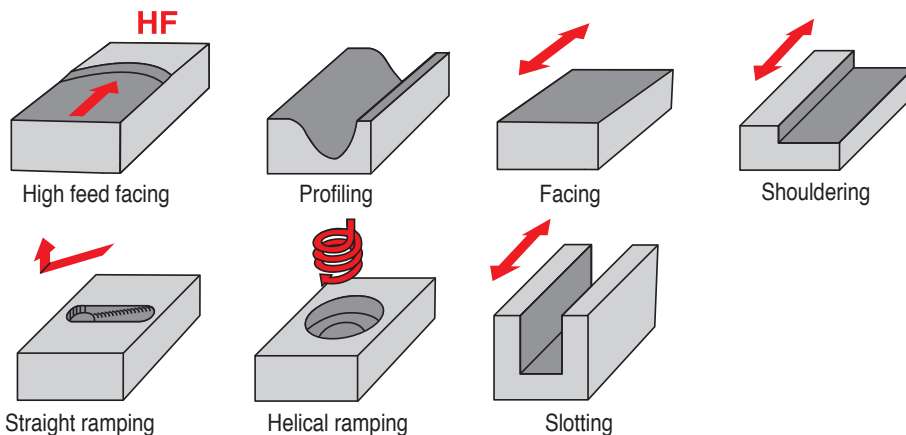
While both the **BLMP 11** and BLMP 13 cover a similar machining range, the BLMP 11 inserts give an advantage as they make it a finer pitch same diameter cutter for better productivity. The cutters come in all types: face mill, end mill and modular types.

- * As part of the new campaign, the design for the new **CHASE-4-FEED** line highlights TaeguTec's new direction.
- * The new **CHASE-4-FEED** logo will be applied to the BLMP 06, 09 inserts and cutters as well.

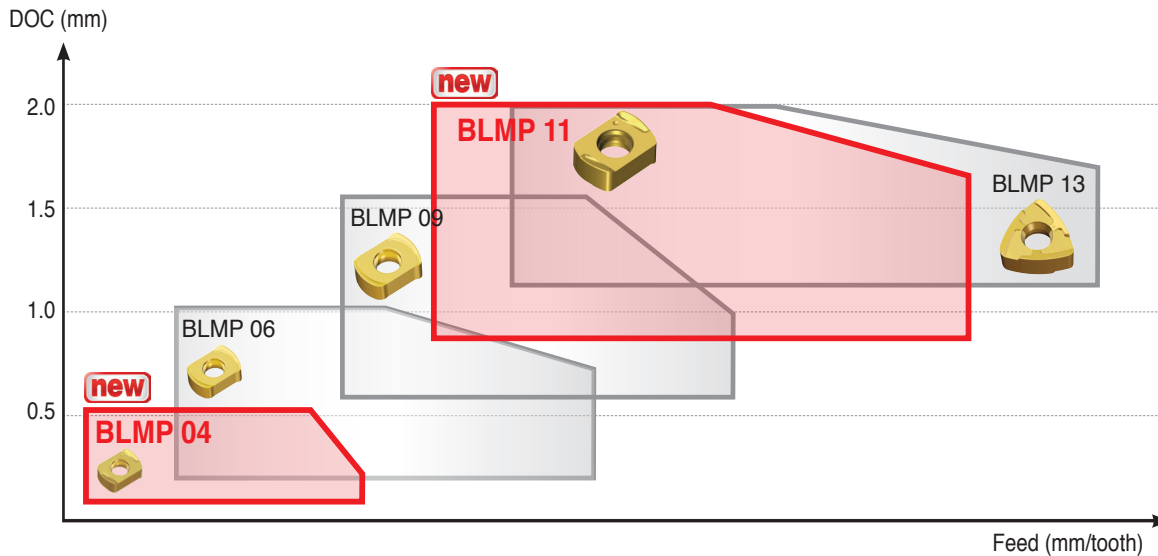
For further technical questions, please contact TaeguTec's product manager.

Features

- Double-sided four corners insert
- Smaller insert size means more inserts can be fitted into similar size cutters (improved productivity)
- Smooth cutting and excellent insert rigidity
- Applies to a variety of applications



BLMP application range



Maximum number of teeth by diameter

| Insert | BLMP 04 | BLMP 06 | BLMP 09 | BLMP 11 | BLMP 13 |
|----------|---------|---------|---------|---------|---------|
| Diameter | | | | | |
| Ø10 | 2 | - | - | - | - |
| Ø12 | 3 | - | - | - | - |
| Ø16 | 4 | 2 | - | - | - |
| Ø20 | 5 | 3 | - | - | - |
| Ø25 | 7 | 4 | 2 | - | - |
| Ø30 | - | 5 | 3 | 2 | - |
| Ø32 | 8 | 5 | 4 | 3 | 2 |
| | | | | | |

Availability

In stock

Price

Available in the GAL system

Sincerely,
TaeguTec

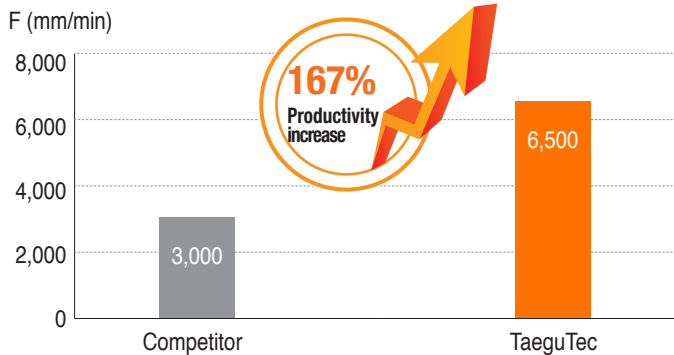
Cho Yeo-myeong
Rotating General PM

Sincerely,
TaeguTec

Lee Jae-wook
Milling Product Manager

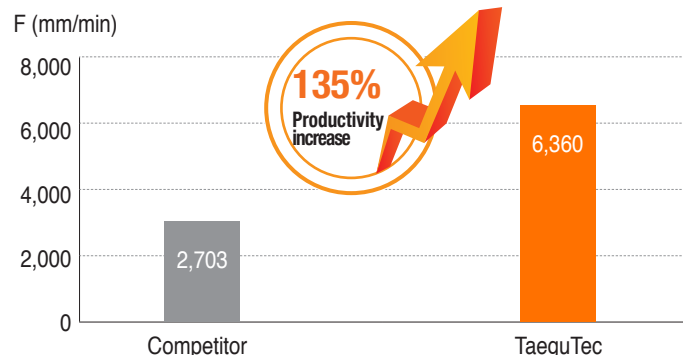
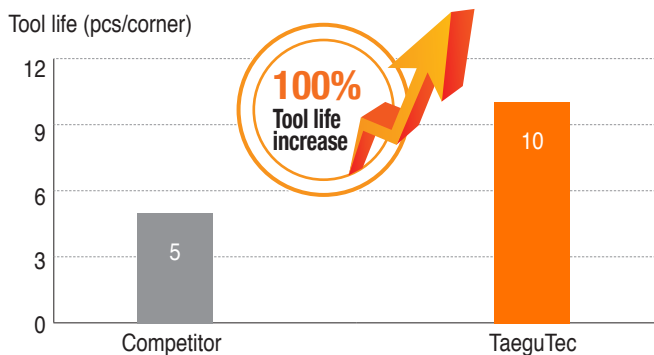
Case study 1

| | | Competitor | TaeguTec |
|---------------|--------------|--------------------|------------------------------|
| Material | | DIN 1.2344, H13 | |
| Cutter | | Ø13, 2z | TEBL 313-12-04-L90 (Ø13, 3z) |
| Insert | | RDMW 05 PVD coated | BLMP 0402R-M TT9080 |
| Cutting Speed | V (m/min) | 135 | 163 |
| | f (mm/tooth) | 0.45 | 0.54 |
| Feed | F (mm/min) | 3,000 | 6,500 |
| | ap (mm) | 0.3 | 0.3 |
| Coolant | | Air | Air |



Case study 2

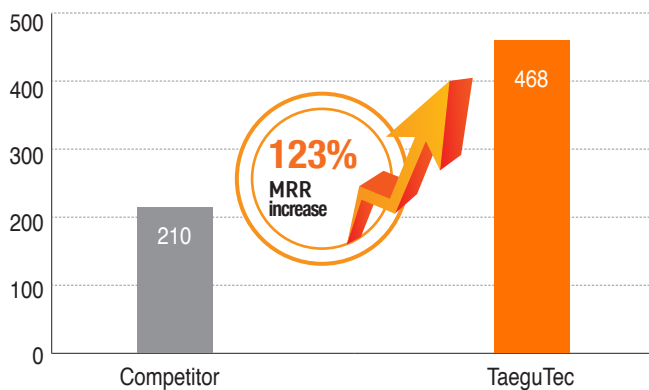
| | | Competitor | TaeguTec |
|------------------------|--------------|------------------|--------------------------|
| Material | | Mold steel | |
| Cutter | | Ø10, 2z | TEBL 210-10-04 (Ø10, 2z) |
| Insert | | AX 06 PVD coated | BLMP 0402R-M TT9080 |
| Cutting Speed | V (m/min) | 170 | 200 |
| | f (mm/tooth) | 0.25 | 0.5 |
| Feed | F (mm/min) | 2,703 | 6,360 |
| | ap (mm) | 0.3 | 0.3 |
| Coolant | | Dry | Dry |
| Tool life (pcs/corner) | | 5 | 10 |



Case study 3

| | | Competitor | TaeguTec |
|----------------------------|--------------|------------|----------------------------|
| Material | | AISI 1045 | |
| Cutter | | Ø80, 7z | TFMBL 780-27R-11 (Ø80, 7z) |
| Insert | | RXXX 12 | BLMP 1105R-M TT9080 |
| Cutting Speed | V (m/min) | 150 | 200 |
| Feed | f (mm/tooth) | 0.3 | 1.0 |
| | F (mm/min) | 1,254 | 5,573 |
| Depth of cut | ap (mm) | 3 | 1.5 |
| Width of cut | ae (mm) | 55 | 55 |
| MRR (cm ³ /min) | | 210 | 468 |

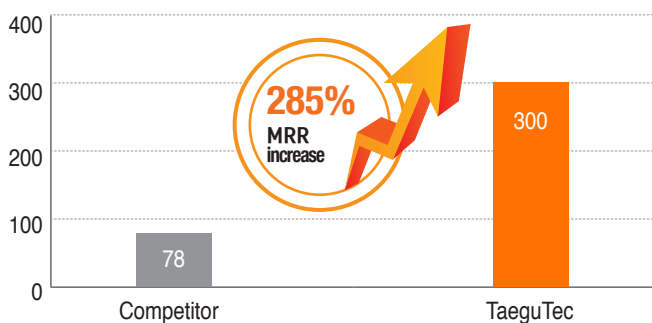
MRR (cm³/min)



Case study 4

| | | Competitor | TaeguTec |
|----------------------------|--------------|-----------------------------|----------------------------|
| Material | | Martensitic stainless steel | |
| Cutter | | Ø50, 4z | TFMBL 550-22R-11 (Ø50, 5z) |
| Insert | | RXXX 12 | BLMP 1105R-M TT8080 |
| Cutting Speed | V (m/min) | 220 | 180 |
| Feed | f (mm/tooth) | 0.2 | 1.0 |
| | F (mm/min) | 1,121 | 5,732 |
| Depth of cut | ap (mm) | 2 | 1.5 |
| Width of cut | ae (mm) | 34 | 34 |
| MRR (cm ³ /min) | | 78 | 300 |

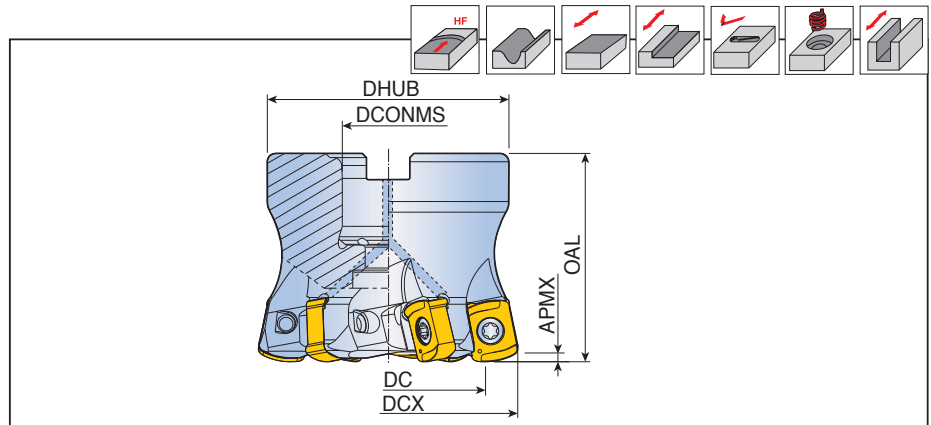
MRR (cm³/min)





TFMBL-11

High feed face mills



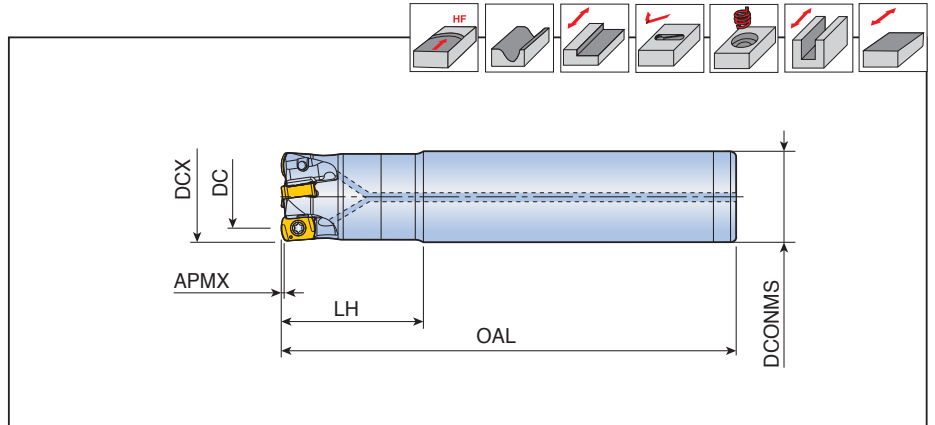
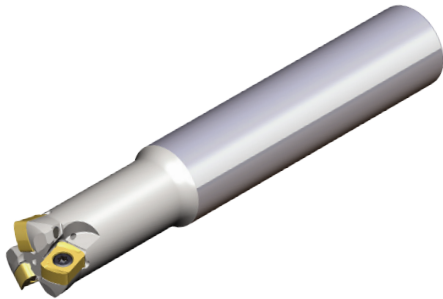
| Designation | | Dimension (mm) | | | | | | Coolant | Arbor type | Kg | Mounting bolt | Insert |
|-------------------------|----|----------------|-------|--------|------|-----|------|---------|------------|-----|---------------|-----------------|
| | | DCX | DC | DCONMS | DHUB | OAL | APMX | | | | | |
| TFMBL 440-16R-11 | 4 | 40 | 24.4 | 16 | 30 | 40 | 2.0 | ● | E | 0.2 | KTB 32B | BLMP 1105... |
| 450-22R-11 | 4 | 50 | 34.4 | 22 | 45 | 40 | 2.0 | ● | A | 0.3 | LH M10x25 | |
| 550-22R-11 | 5 | 50 | 34.4 | 22 | 45 | 40 | 2.0 | ● | A | 0.3 | LH M10x25 | |
| 552-22R-11 | 5 | 52 | 36.4 | 22 | 45 | 40 | 2.0 | ● | A | 0.3 | LH M10x25 | |
| 563-22R-11 | 5 | 63 | 48.4 | 22 | 58 | 50 | 2.0 | ● | A | 0.7 | SH M10x30 | |
| 663-22R-11 | 6 | 63 | 48.4 | 22 | 58 | 50 | 2.0 | ● | A | 0.7 | SH M10x30 | |
| 666-22R-11 | 6 | 66 | 50.3 | 22 | 58 | 50 | 2.0 | ● | A | 0.8 | SH M10x30 | |
| 680-27R-11 | 6 | 80 | 64.3 | 27 | 70 | 60 | 2.0 | ● | A | 1.4 | SH M12x30 | |
| 780-27R-11 | 7 | 80 | 64.3 | 27 | 70 | 60 | 2.0 | ● | A | 1.4 | SH M12x30 | |
| 6100-32R-11 | 6 | 100 | 84.3 | 32 | 85 | 60 | 2.0 | ● | A | 2.2 | SH M16x35 | |
| 7100-32R-11 | 7 | 100 | 84.3 | 32 | 85 | 60 | 2.0 | ● | A | 2.2 | SH M16x35 | |
| 8125-32R-11 | 8 | 125 | 109.3 | 32 | 85 | 60 | 2.0 | ● | A | 2.5 | SH M20x40 | |
| 10125-40R-11 | 10 | 125 | 109.3 | 40 | 85 | 60 | 2.0 | ● | A | 2.7 | SH M20x40 | |
| 10160-40R-11 | 10 | 160 | 144.3 | 40 | 110 | 60 | 2.0 | x | C | 3.9 | - | |
| 12200-60R-11 | 12 | 200 | 184.3 | 60 | 130 | 60 | 2.0 | x | C | 5.8 | - | |
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Spare parts

| Designation | Screw | Wrench | Wrench handle | | |
|-----------------|--------------|-------------|---------------|--|--|
| TFMBL-11 | TS 50A121/HG | TBLD T20-W6 | SW6-T | | |
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TEBL-04

High feed end mills

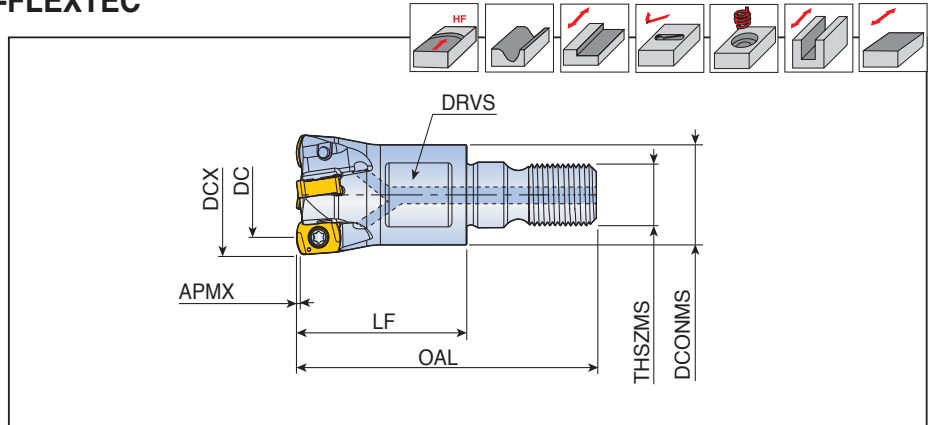
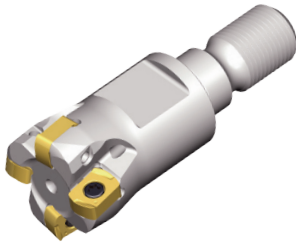


| Designation | ✂ | Dimension (mm) | | | | | | Coolant | Insert |
|---------------------------|---|----------------|------|--------|-----|----|------|---------|--------------|
| | | DCX | DC | DCONMS | OAL | LH | APMX | | |
| TEBL 108-08-04-L80 | 1 | 8 | 3.8 | 8 | 80 | 20 | 0.5 | ● | BLMP 0402... |
| 210-10-04-L100 | 2 | 10 | 5.6 | 10 | 100 | 20 | 0.5 | ● | |
| 211-10-04-L100 | 2 | 11 | 6.6 | 10 | 100 | 20 | 0.5 | ● | |
| 312-12-04-L110 | 3 | 12 | 7.6 | 12 | 110 | 20 | 0.5 | ● | |
| 313-12-04-L110 | 3 | 13 | 8.6 | 12 | 110 | 20 | 0.5 | ● | |
| 416-16-04-L150 | 4 | 16 | 11.6 | 16 | 150 | 25 | 0.5 | ● | |
| 417-16-04-L200 | 4 | 17 | 12.6 | 16 | 200 | 25 | 0.5 | ● | |
| 520-20-04-L200 | 5 | 20 | 15.5 | 20 | 200 | 25 | 0.5 | ● | |
| 521-20-04-L200 | 5 | 21 | 16.5 | 20 | 200 | 25 | 0.5 | ● | |
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TEBL-M-04



High feed modular heads for T-FLEXTEC



| Designation | | Dimension (mm) | | | | | | | | Coolant | Insert |
|------------------------|---|----------------|------|--------|----|------|--------|------|------|---------|--------------|
| | | DCX | DC | DCONMS | LF | OAL | THSZMS | APMX | DRVS | | |
| TEBL 210-M06-04 | 2 | 10 | 5.6 | 9.7 | 17 | 31.5 | M06 | 0.5 | 8 | ● | BLMP 0402... |
| 211-M06-04 | 2 | 11 | 6.6 | 9.7 | 17 | 31.5 | M06 | 0.5 | 8 | ● | |
| 312-M06-04 | 3 | 12 | 7.6 | 11 | 17 | 31.5 | M06 | 0.5 | 8 | ● | |
| 313-M06-04 | 3 | 13 | 8.6 | 11 | 17 | 31.5 | M06 | 0.5 | 8 | ● | |
| 416-M08-04 | 4 | 16 | 11.6 | 13 | 23 | 40.5 | M08 | 0.5 | 10 | ● | |
| 417-M08-04 | 4 | 17 | 12.6 | 13 | 23 | 40.5 | M08 | 0.5 | 10 | ● | |
| 520-M10-04 | 5 | 20 | 15.5 | 18 | 23 | 43 | M10 | 0.5 | 15 | ● | |
| 725-M12-04 | 7 | 25 | 20.6 | 21 | 27 | 49 | M12 | 0.5 | 17 | ● | |
| 832-M16-04 | 8 | 32 | 27.5 | 29 | 27 | 52 | M16 | 0.5 | 25 | ● | |
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• Matched with T-FLEXTEC holder

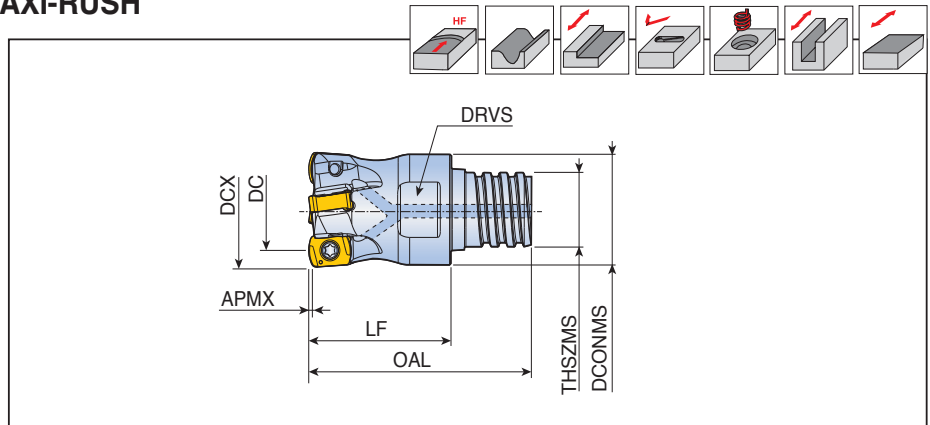
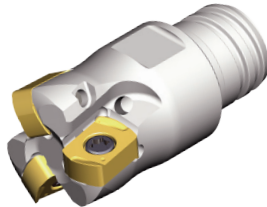
Spare parts

| Designation | Screw | Wrench | | | |
|----------------|-------------|--------|--|--|--|
| | | | | | |
| TEBL-04 | TS 18041/HG | TD 6P | | | |
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TEBL-S-04



High feed modular heads for MAXI-RUSH



| Designation | Z | Dimension (mm) | | | | | | | | Coolant | Insert |
|------------------------|---|----------------|------|--------|----|------|--------|------|------|---------|--------------|
| | | DCX | DC | DCONMS | LF | OAL | THSZMS | APMX | DRVS | | |
| TEBL 210-S06-04 | 2 | 10 | 5.6 | 9.6 | 15 | 21.3 | S06 | 0.5 | 8 | ● | BLMP 0402... |
| 312-S08-04 | 3 | 12 | 7.6 | 11.5 | 16 | 23.5 | S08 | 0.5 | 10 | ● | |
| 416-S10-04 | 4 | 16 | 11.6 | 15.2 | 20 | 31.3 | S10 | 0.5 | 13 | ● | |
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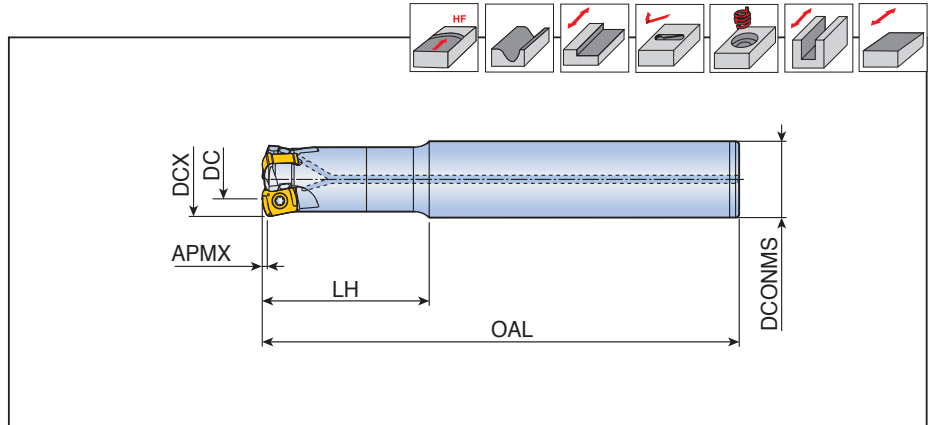
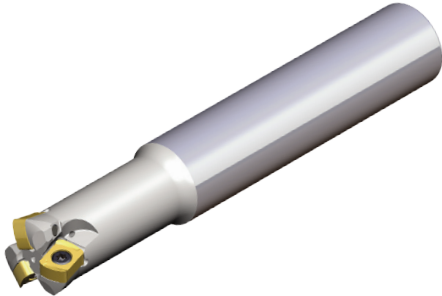
• Matched with MAXI-RUSH holder

Spare parts

| Designation | Screw | Wrench | | | |
|----------------|-------------|--------|--|--|--|
| | | | | | |
| TEBL-04 | TS 18041/HG | TD 6P | | | |
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TEBL-11

High feed end mills

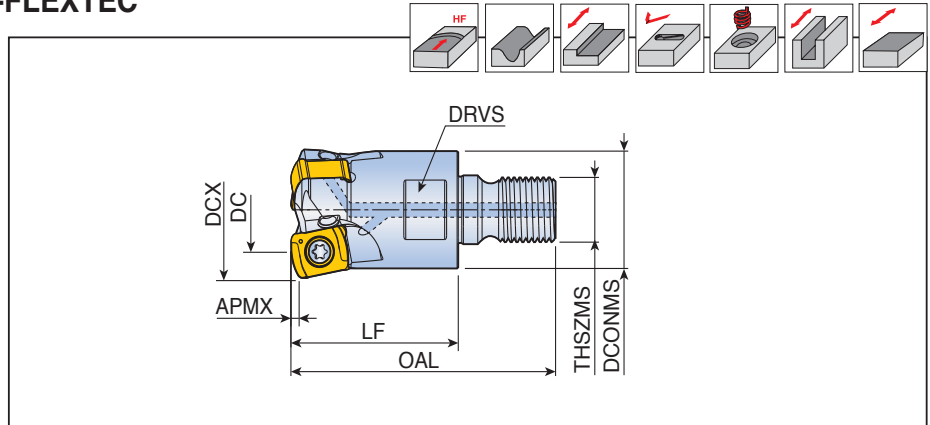
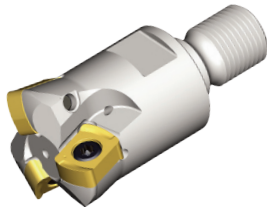


| Designation | Flutes | Dimension (mm) | | | | | | Coolant | Insert |
|----------------------------|--------|----------------|------|--------|-----|----|------|---------|--------------|
| | | DCX | DC | DCONMS | OAL | LH | APMX | | |
| TEBL 230-32-11-L150 | 2 | 30 | 14.7 | 32 | 150 | 70 | 2.0 | ● | BLMP 1105... |
| 232-32-11-L150 | 2 | 32 | 16.6 | 32 | 150 | 70 | 2.0 | ● | |
| 232-32-11-L200 | 2 | 32 | 16.6 | 32 | 200 | 70 | 2.0 | ● | |
| 332-32-11-L200 | 3 | 32 | 16.6 | 32 | 200 | 70 | 2.0 | ● | |
| 233-32-11-L200 | 2 | 33 | 17.6 | 32 | 200 | 40 | 2.0 | ● | |
| 233-32-11-L250 | 2 | 33 | 17.6 | 32 | 250 | 50 | 2.0 | ● | |
| 333-32-11-L250 | 3 | 33 | 17.6 | 32 | 250 | 50 | 2.0 | ● | |
| 335-32-11-L200 | 3 | 35 | 19.5 | 32 | 200 | 40 | 2.0 | ● | |
| 340-32-11-L150 | 3 | 40 | 24.4 | 32 | 150 | 40 | 2.0 | ● | |
| 340-32-11-L200 | 3 | 40 | 24.4 | 32 | 200 | 40 | 2.0 | ● | |
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TEBL-M-11



High feed modular heads for T-FLEXTEC



| Designation | | Dimension (mm) | | | | | | | | Coolant | Insert |
|------------------------|---|----------------|------|--------|----|-----|--------|------|------|---------|--------------|
| | | DCX | DC | DCONMS | LF | OAL | THSZMS | APMX | DRVS | | |
| TEBL 230-M16-11 | 2 | 30 | 14.7 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | BLMP 1105... |
| 232-M16-11 | 2 | 32 | 16.6 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | |
| 233-M16-11 | 2 | 33 | 17.6 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | |
| 335-M16-11 | 3 | 35 | 19.5 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | |
| 340-M16-11 | 3 | 40 | 24.4 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | |
| 342-M16-11 | 3 | 42 | 26.4 | 29 | 43 | 68 | M16 | 2.0 | 25 | ● | |
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• Matched with T-FLEXTEC holder

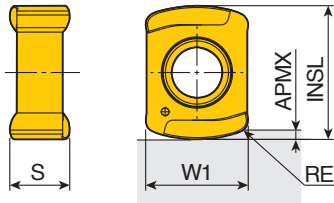
Spare parts

| Designation | Screw | Wrench | Wrench handle | | |
|----------------|---------------|-------------|---------------|--|--|
| TEBL-11 | TS 50A121I/HG | TBLD T20-W6 | THND 6W | | |
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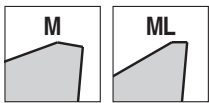
BLMP



High feed inserts



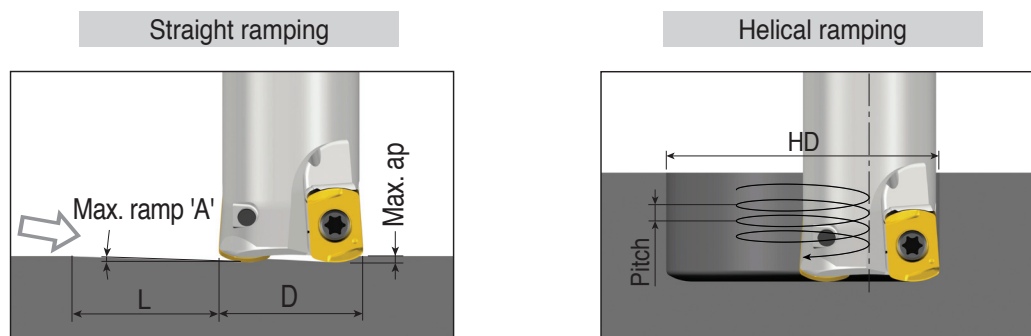
| Size | Dimension (mm) | | | | |
|-----------|----------------|------|-----|------|-----|
| | INSL | W1 | S | APMX | RE |
| 04 | 6.0 | 4.2 | 2.5 | 0.5 | 0.5 |
| 11 | 14.6 | 11.2 | 6.5 | 2.0 | 1.3 |
| | | | | | |
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| Insert | Designation | Recommended machining conditions | | Coated | | | | | | | Uncoated | | | |
|--------|----------------------|----------------------------------|-----------------|--------|--------|--------|--------|--------|--------|--------|----------|--------|-----|--|
| | | ap (mm) | Feed (mm/tooth) | TT9080 | TT9030 | TT8080 | TT8020 | TT8525 | TT7080 | TT7515 | TT6080 | TT2510 | K10 | |
| | | | | | | | | | | | | | | |
| | BLMP 0402R-M | 0.1-0.5 | 1.50-0.20 | ● | | ● | | | | | | ● | | |
| | 1105R-M | 0.3-2.0 | 4.00-0.30 | ● | | ● | | ● | | | | ● | | |
| | BLMP 0402R-ML | 0.1-0.5 | 0.60-0.10 | ● | | ● | | | | | | | | |
| | 1105R-ML | 0.3-2.0 | 4.00-0.30 | ● | | ● | | | | | | | | |

●: Standard items

Ramping Data

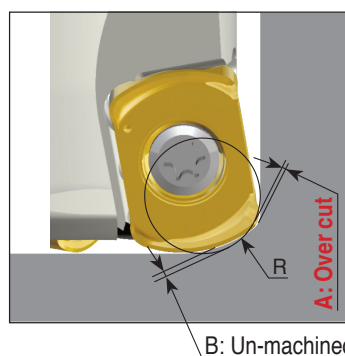


BLMP 04

(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. |
| Ø8 | 0.4 | 0.5 | 72 | 12.6 | 16 | 0.1 |
| Ø10 | 0.6 | | 44 | 16.6 | 20 | 0.2 |
| Ø11 | 0.7 | | 38 | 18.6 | 22 | 0.2 |
| Ø12 | 1.0 | | 29 | 20.6 | 24 | 0.4 |
| Ø13 | 1.1 | | 25 | 22.6 | 26 | 0.5 |
| Ø16 | 1.0 | | 29 | 28.6 | 32 | 0.5 |
| Ø17 | 1.1 | | 26 | 30.6 | 34 | 0.5 |
| Ø20 | 1.0 | | 27 | 36.6 | 40 | 0.5 |
| Ø21 | 0.7 | | 38 | 38.6 | 42 | 0.5 |
| Ø25 | 0.7 | | 38 | 46.6 | 50 | 0.5 |
| Ø32 | 0.6 | | 48 | 60.6 | 64 | 0.5 |

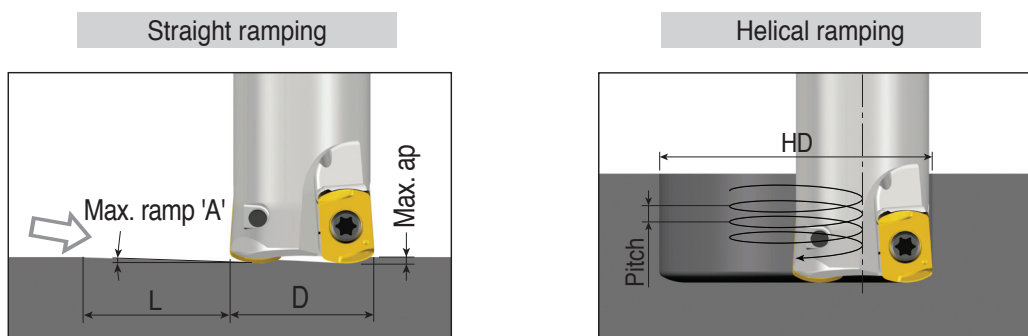
Programming technical data



| | R Program | A Over cut | B Un-machined |
|---------|-----------|------------|---------------|
| BLMP 04 | 0.8 | 0.00 | 0.28 |
| | 0.9 | 0.00 | 0.25 |
| | 1.0 | 0.08 | 0.22 |

: Recommended program 'R'

Ramping Data

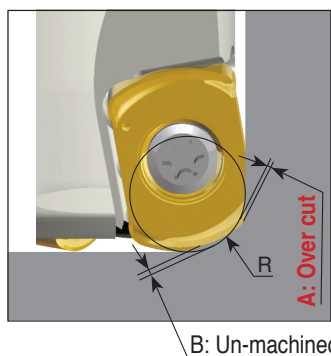


BLMP 11

(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. |
| Ø30 | 0.50 | 2.0 | 229 | 41 | 60 | 0.3 |
| Ø32 | 0.50 | | 229 | 45 | 64 | 0.3 |
| Ø33 | 0.45 | | 255 | 47 | 66 | 0.3 |
| Ø35 | 0.50 | | 229 | 51 | 70 | 0.4 |
| Ø40 | 0.55 | | 208 | 61 | 80 | 0.5 |
| Ø42 | 0.50 | | 229 | 65 | 84 | 0.5 |
| Ø50 | 0.50 | | 229 | 81 | 100 | 0.7 |
| Ø52 | 0.45 | | 255 | 85 | 104 | 0.7 |
| Ø63 | 0.45 | | 255 | 107 | 126 | 0.9 |
| Ø66 | 0.40 | | 287 | 113 | 132 | 0.9 |
| Ø80 | 0.35 | | 328 | 141 | 160 | 1.0 |
| Ø100 | 0.30 | | 382 | 181 | 200 | 1.1 |
| Ø125 | 0.25 | | 459 | 231 | 250 | 1.2 |
| Ø160 | 0.20 | | 573 | 301 | 320 | 1.3 |
| Ø200 | 0.15 | | 764 | 381 | 400 | 1.3 |

Programming technical data



| | R Program | A Over cut | B Un-machined |
|---------|-----------|------------|---------------|
| BLMP 11 | 2.4 | 0.00 | 1.09 |
| | 3.0 | 0.00 | 0.90 |
| | 3.2 | 0.18 | 0.85 |

Yellow background: Recommended program 'R'

KIT COLLECTIONS

These kit products are available in the format listed below.



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|----------------------------------|---------------------|------|
| 6334778 | KISFT-TEBL-210-10-04-L100 | TEBL 210-10-04-L100 | 1 |
| | | BLMP 0402R-M TT9080 | 4 |
| 6334779 | KISFT-TEBL 312-12-04-L110 | TEBL 312-12-04-L110 | 1 |
| | | BLMP 0402R-M TT9080 | 6 |
| 6334780 | KISFT-TEBL 416-16-04-L150 | TEBL 416-16-04-L150 | 1 |
| | | BLMP 0402R-M TT9080 | 8 |
| 6334781 | KISFT-TEBL 520-20-04-L200 | TEBL 520-20-04-L200 | 1 |
| | | BLMP 0402R-M TT9080 | 10 |



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|----------------------------------|---------------------|------|
| 6337844 | KISFS-TEBL-210-10-04-L100 | TEBL 210-10-04-L100 | 1 |
| | | BLMP 0402R-M TT9080 | 50 |
| 6337845 | KISFS-TEBL 312-12-04-L110 | TEBL 312-12-04-L110 | 1 |
| | | BLMP 0402R-M TT9080 | 50 |
| 6337846 | KISFS-TEBL 416-16-04-L150 | TEBL 416-16-04-L150 | 1 |
| | | BLMP 0402R-M TT9080 | 50 |
| 6337847 | KISFS-TEBL 520-20-04-L200 | TEBL 520-20-04-L200 | 1 |
| | | BLMP 0402R-M TT9080 | 50 |



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|---------------------------------|---------------------|------|
| 6338424 | KISFF-A-BLMP 04-M TT9080 | BLMP 0402R-M TT9080 | 100 |
| 6338425 | KISFF-B-BLMP 04-M TT9080 | | 300 |
| 6338426 | KISFF-C-BLMP 04-M TT9080 | | 500 |