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sales@machineryhouse.co.nz
www.machineryhouse.co.nz

Product Brochure For L016

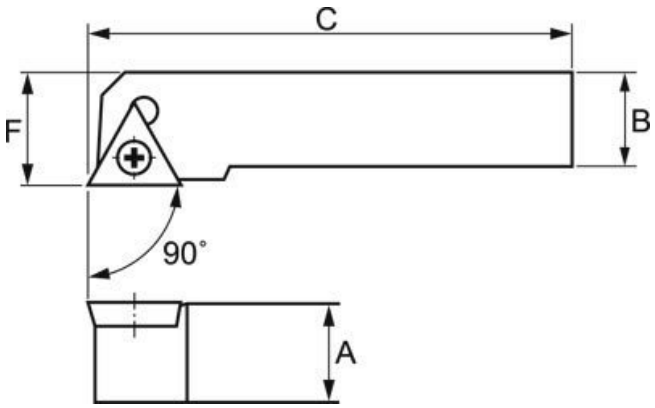
# Left Hand Turning Tool Holder - STGCL-1212-H11

12mm Tool Height
Insert tip not included

| Ex GST | Inc GST |
|---|---|
| $74.00 | $85.10 |



| | |
|---|---|
| ORDER CODE: | L016 |
| Part Number - Style: | STGC |
| Tool Height Size (mm): | 12 |
| Clamping Method of Insert: | ~ |
| Category: | ~ |
| Connection style: | ~ |
| Back End Size: | ~ |
| Application: | ~ |
| Hand Type: | Left |
| Holder Style: | ~ |
| Clearance Angle: | ~ |
| Insert Type: | TCMT11 |
| A (H) (mm): | 12 |
| B (mm): | 12 |
| C (LF) (mm): | 100 |
| LH (mm): | ~ |
| F (WF) (mm): | 16 |
| E (mm): | ~ |




Made in Taiwan

## Description

Quality Tipped Tool Holders ISO Standard to suit Tungsten Carbide Indexable Insert Tips.

NOTE: Inserts not included with tool holders

Use insert TCMT 110204 (L062)

## Features

- Positive rake turning tool holder with 90º approach angle
- Suitable for low powered machines
- Left hand tool holder suitable for facing operations

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## SETTING THE SPINDLE SPEED

To calculate the correct speed the following metric formula can be used

$$RPM = \frac{1000 \times \text{Surface speed in Metres per Minute}}{3.14 \times \text{Diameter in millimetres}}$$

| Approximate surface speeds for carbide tools | Metres per minute | |
|---|---|---|
| **Material** | **Roughing** | **Finishing** |
| Mild Steel | 50 | 80 |
| Cast Iron | 40 | 60 |
| Aluminium | 80 | 100 |
| Stainless Steel | 40 | 50 |

**Example 1.**
**20mm Mild Steel bar to be rough machined**

$$RPM = \frac{1000 \times 50}{3.14 \times 20mm} = \frac{50000}{62.8} = 796rpm$$

**Example 2.**
**20mm Mild Steel bar to be finished machined**

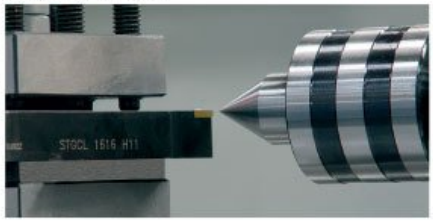
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- Set the spindle speed to the closest speed to the RPM calculated
- If in doubt then set a speed slower than the calculated speed

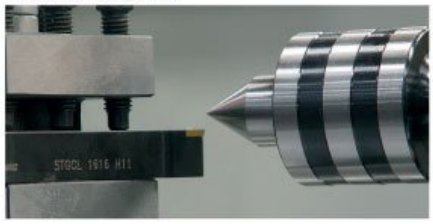
## SETTING THE TOOL ON CENTRE

For the tool to cut correctly it needs to be set on centre. This can be best achieved by placing a centre in the tailstock and packing the tool until the tool is on centre.

Correct centre height



Incorrect centre height



## Recommended Accessories

L062
KYOCERA Carbide Inserts - Turning



L525
Screw to Suit Turning Tool Holder



L526
Key to Suit Tool Holder



L450
Lathe Turning Tool Kit - 3 piece Insert Type



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# Product Brochure For L016

L451
Lathe Turning Tool Kit - 3 piece Insert Type



L452
Lathe Turning Tool Kit - 3 piece Insert Type



L453
Lathe Turning Tool Kit - 3 piece Insert Type



L072
HSS Turning Tool Set - 4 piece



L0085
Carbide Turning Tool Set - 11 piece



L0055
Lathe Turning Tool Kit - 5 piece Insert Type



L0099
Lathe Turning Tool Kit - 7 piece Insert Type



L0077
Lathe Turning Tool Kit - 7 piece Insert Type



L456
Lathe Threading Tool Kit - Insert Type



L457
Lathe Threading Tool Kit - Insert Type



L458
Lathe Threading Tool Kit - Insert Type



L459
Lathe Threading Tool Kit - Insert Type



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# Product Brochure For L016

## L464
Professional Lathe Parting Tool Kit - Insert Type




## L465
Professional Lathe Parting Tool Kit - Insert Type




## L466
Professional Lathe Parting Tool Kit - Insert Type




## L467
Professional Lathe Parting Tool Kit - Insert Type




## L006A
Boring Bar Set - HSS



## L431
Boring Bar Set - Carbide Insert



## L430
Boring Bar Set - Carbide Insert

