

Product Brochure For L040

## Left Hand Turning Tool Holder - MWLNL-2020-K08

20mm Tool Height

Insert tip not included

Ex GST  
\$98.00

Inc GST  
\$112.70



ORDER CODE:	L040
Part Number - Style:	MWLN
Tool Height Size (mm):	20
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Left
Holder Style:	~
Clearance Angle:	~
Insert Type:	WNMG08
A (H) (mm):	20
B (mm):	20
C (LF) (mm):	125
LH (mm):	~
F (WF) (mm):	25
E (mm):	~



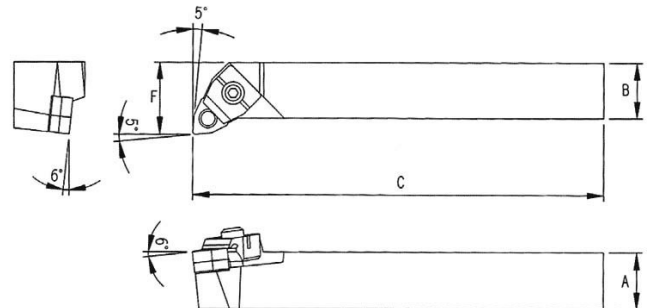
### Description

NOTE: Inserts not included with tool holders

Use insert WNMG 080408 (L053)

### Features

- Negative rake turning tool holder suitable for turning and facing
- Suitable for rapid metal removal



## Product Brochure For L040

### SETTING THE SPINDLE SPEED

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

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

Material	Approximate surface speeds for carbide tools	
	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

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

#### Example 2.

20mm Mild Steel bar to be finished machined

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

- 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



## Specific Features



Side View



Top View

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**Recommended Accessories**

L053  
KYOCERA Carbide Inserts -  
Turning

L0534  
KYOCERA Carbide Inserts -  
Turning

L0538  
KYOCERA Carbide Inserts -  
Turning

L513  
Seat to Suit Turning Tool  
Holders



L514  
Pin to Suit Turning Tool  
Holders

L515  
Clamp to Suit Turning Tool  
Holders

L516  
Clamp Screw to Suit Turning  
Tool Holders

L450  
Lathe Turning Tool Kit - 3 piece  
Insert Type

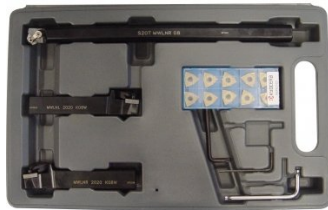


Product Brochure For L040

**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



Product Brochure For L040

**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

