

Product Brochure For L041

Right Hand Turning Tool Holder - MWLNR-2525-M08

25mm Tool Height

Insert tip not included

Ex GST
\$104.00

Inc GST
\$119.60



ORDER CODE:	L041
Part Number - Style:	MWLN
Tool Height Size (mm):	25
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Right
Holder Style:	~
Clearance Angle:	~
Insert Type:	WNMG08
A (H) (mm):	25
B (mm):	25
C (LF) (mm):	150
LH (mm):	~
F (WF) (mm):	32
E (mm):	~



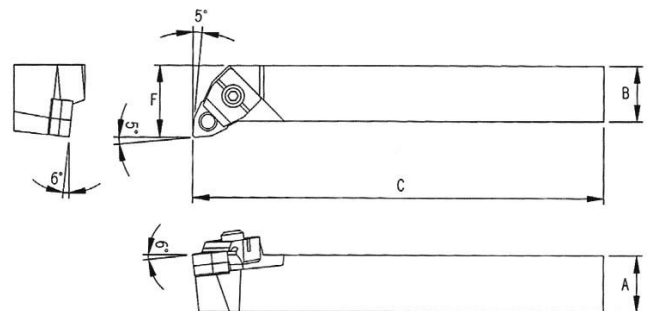
Description

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



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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	
	Metres per minute	
	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

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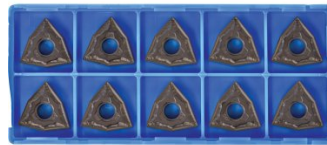
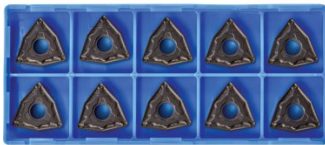
Recommended Accessories

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

ML400
Cutter Part - Key



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L453

Lathe Turning Tool Kit - 3 piece
Insert Type



L450

Lathe Turning Tool Kit - 3 piece
Insert Type



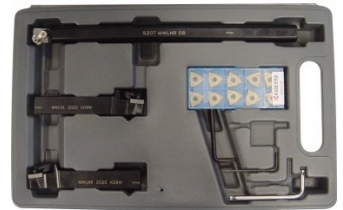
L451

Lathe Turning Tool Kit - 3 piece
Insert Type



L452

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



Product Brochure For L041

L459
Lathe Threading Tool Kit - Insert Type



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

