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Product Brochure For L042

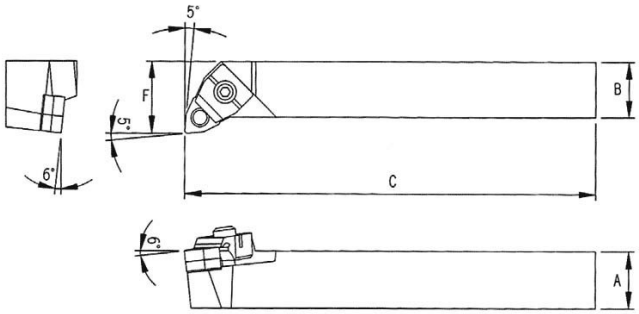
Left Hand Turning Tool Holder - MWLNL-2525-M08

25mm Tool Height
Inserts not included

Ex GST	Inc GST
$82.61	$95.00

ORDER CODE:	L042
Part Number - Style:	MWLN
Tool Height Size (mm):	25
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Left
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):	~





Made in Taiwan

Description

Use insert/s
WNMG 080404 PMG CA115P (L0534)
Primarily used for 'FINISHING'

WNMG 080408 PMG CA125P (L053)
Primarily used for 'GENERAL PURPOSE'

WNMG 080408 MS CA6525 (L0538)
Primarily used for 'STAINLESS STEEL'

WNGP 080408K KC5410 (L0539)
Primarily used for 'ALUMINIUM'

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

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

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

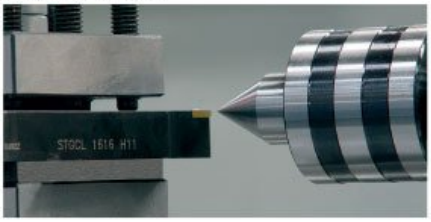
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

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

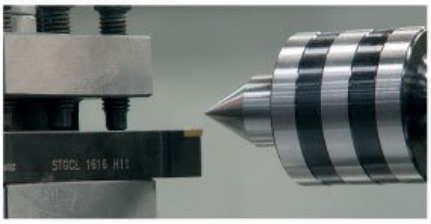
SETTING THE TOOL ON CENTRE

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



Specific Features



Side View

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Product Brochure For L042

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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Product Brochure For L042

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



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



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Product Brochure For L042

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

