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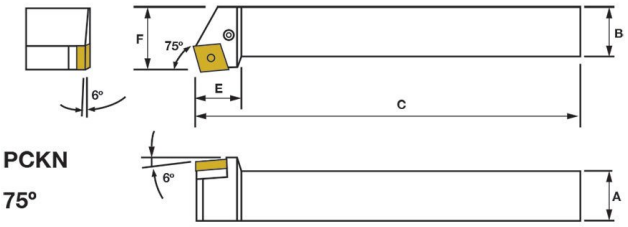
Product Brochure For L0506

Right Hand Turning Tool Holder - PCKNR-2020-K12

20mm Tool Height
Insert tip not included



ORDER CODE:	L0506
Part Number - Style:	PCKN
Tool Height Size (mm):	20
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Right
Holder Style:	~
Clearance Angle:	~
Insert Type:	CNMG12
A (H) (mm):	20
B (mm):	20
C (LF) (mm):	125
LH (mm):	~
F (WF) (mm):	25
E (mm):	26



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 CNMG 120408 (L0602)

Features

- Negative rake turning tool holder with 75º approach angle and suitable for rapid metal removal
- Works in partnership with the 95º approach tool holders. These tools allow the other four cutting edges of the insert to be utilised.
- Right hand tool holder suitable for turning towards the chuck

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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

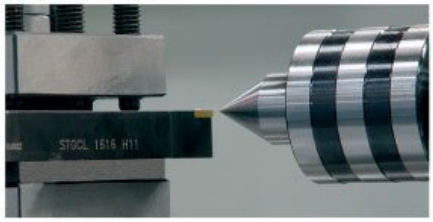
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

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

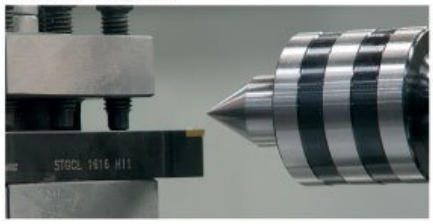
SETTING THE TOOL ON CENTRE

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



Tool Holder



Side View



Top View

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Product Brochure For L0506

Recommended Accessories

L0602
KYOCERA Carbide Inserts - Turning



L5211
Cam Shim to Suit Turning Tool Holders



L5212
Lever Clamp to Suit Turning Tool Holders



L5213
Clamp Screw to Suit Turning Tool Holders



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



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Product Brochure For L0506

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



L464
Professional Lathe Parting Tool Kit - Insert Type



L465
Professional Lathe Parting Tool Kit - Insert Type



L466
Professional Lathe Parting Tool Kit - Insert Type



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Product Brochure For L0506

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

