

Product Brochure For L0507

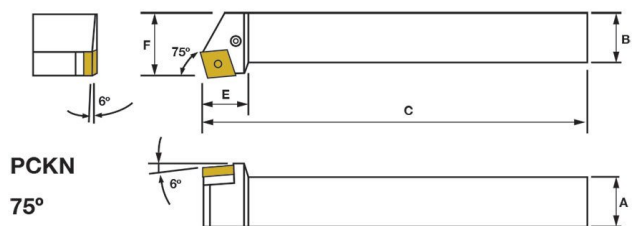
Right Hand Turning Tool Holder - PCKNR-2525-K12

25mm Tool Height

Insert tip not included



| | |
|----------------------------|--------|
| ORDER CODE: | L0507 |
| Part Number - Style: | PCKN |
| 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: | CNMG12 |
| A (H) (mm): | 25 |
| B (mm): | 25 |
| C (LF) (mm): | 150 |
| LH (mm): | ~ |
| F (WF) (mm): | 32 |
| E (mm): | 26 |



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 75° approach angle and suitable for rapid metal removal
- Works in partnership with the 95° 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

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

| 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

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

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

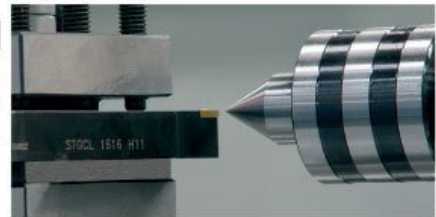
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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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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



Product Brochure For L0507

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



Product Brochure For L0507

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

