

## Product Brochure For L401

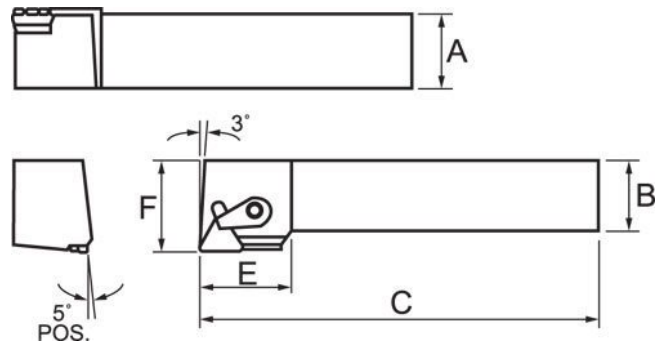
### Left Hand Turning Tool Holder - CTGPL-1212-F11

12mm Tool Height

Insert tip not included



ORDER CODE:	L401
Part Number - Style:	CTGP
Tool Height Size (mm):	12
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Left
Holder Style:	~
Clearance Angle:	~
Insert Type:	TPMR11
A (H) (mm):	12
B (mm):	12
C (LF) (mm):	80
LH (mm):	~
F (WF) (mm):	16
E (mm):	20



#### Description

Quality Tipped Tool Holders ISO Standard to suit Tungsten Carbide Indexable Insert Tips.

NOTE: Inserts not included with tool holders

Use insert TPMP 110304 (L061)

#### Features

- Positive rake turning tool holder with 90° approach angle
- Suitable for heavy duty cutting
- Left hand tool holder suitable for facing operations

Product Brochure For L401

**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

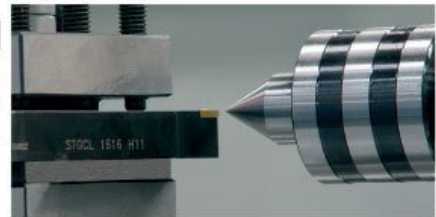
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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



**Recommended Accessories**

**L061**  
KYOCERA Carbide Inserts - Turning

**L533**  
Clamp to Suit Turning Tool Holders

**L534**  
Clamp Screw to Suit Tool Holders

**L450**  
Lathe Turning Tool Kit - 3 piece Insert Type



Product Brochure For L401

**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



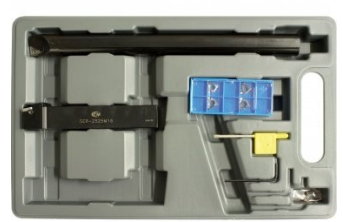
**L457**  
Lathe Threading Tool Kit - Insert  
Type



**L458**  
Lathe Threading Tool Kit - Insert  
Type



**L459**  
Lathe Threading Tool Kit - Insert  
Type



Product Brochure For L401

**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

