

MWLNL-2525-M08 - Left Hand Turning Tool Holder

25mm Tool Height
 Insert tip not included

Ex GST **Inc GST**
\$110.00 **\$121.00**



ORDER CODE:	L042
Size (mm):	25
Hand Type:	Left
Style:	MWLNL
A (mm):	25
B (mm):	25
C (mm):	150
E (mm):	~
F (mm):	32



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

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	
	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

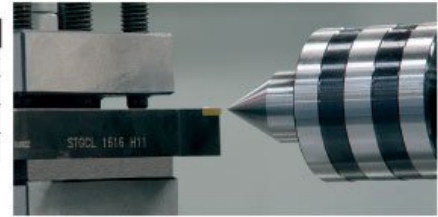
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

- 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

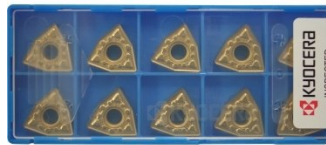
Recommended Accessories

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



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



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

