

## WTJNR-2020-K16 - Right Hand Turning Tool Holder

20mm Tool Height  
 Insert tip not included

**Ex GST**  
**\$110.00**

**Inc GST**  
**\$121.00**

ORDER CODE:	L046
Size (mm):	20
Hand Type:	Right
Style:	WTJNR
A (mm):	20
B (mm):	20
C (mm):	125
E (mm):	32
F (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 TNMG 160408 (L064)

### Features

- Negative rake turning tool holder with 93° approach angle
- Suitable for rapid metal removal
- Right hand tool holder suitable for turning towards the chuck

Product Brochure For L046

**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

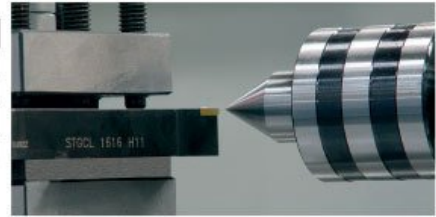
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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**

L0644  
 KYOCERA Carbide Inserts - Turning

L064  
 KYOCERA Carbide Inserts - Turning

L0648  
 KYOCERA Carbide Inserts - Turning

L527  
 Seat to Suit Turning Tool Holders



Product Brochure For L046

**L528**  
Screw Pin to Suit Turning Tool Holders



**L529**  
Clamp to Suit Turning Tool Holders



**L530**  
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



**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



Product Brochure For L046

**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



**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

