Sydney: (02) 9890 9111
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L452 - Lathe Turning Tool Kit - 3 piece Insert Type

20mm Tool Height

Ex GST	Inc GST
$400.00	$440.00

ORDER CODE:	L452
Type:	Turning Tool Kit
Tool Type:	Carbide Inserts
Shank Size - Tool Height (mm):	20
Pieces in Set (No.):	3
Replacement Tip Code:	L053
Nett Weight (kg):	3.0

Made in Taiwan

Description

Compact turning kit with right hand and left hand turning tools and a boring bar. The kit is designed so that all the tools use the same inserts. The inserts used in this kit are ISO standard and can be substituted with any of the major brands of inserts.

20mm Tool Height

Includes

- 1 x Right hand turning tool MWLNR08
- 1 x Left hand turning tool MWLNL08
- 1 x Right hand boring bar MWLNR08
- 10 x inserts to suit all tools (WNMG080404)

Optional Accessories

- Replacement Packet (10) Inserts use (L053)

- 20mm R/H Tool MWLNR 2020 K08W (L039)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)

- 20mm L/H Tool MWLNL 2020 K08W (L040)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)

- 20mm Boring Bar S20T MWLNR 08 (L415)
- CLAMP SCREW (L534)
- SHIM PIN (L503)
- CLAMP (L504)

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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

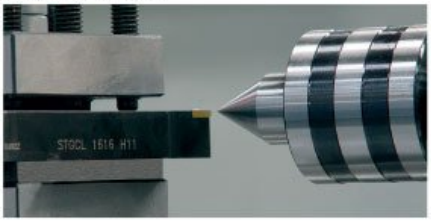
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

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

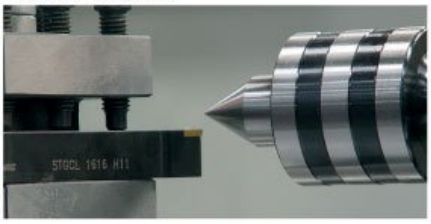
SETTING THE TOOL ON CENTRE

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

Set

Plastic Case

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Recommended Accessories

L053
KYOCERA Carbide Inserts - Turning

L0534
KYOCERA Carbide Inserts - Turning

L0538
KYOCERA Carbide Inserts - Turning

L039
Right Hand Turning Tool Holder

L040
Left Hand Turning Tool Holder

L513
Seat to Suit Turning Tool Holders

L514
Pin to Suit Turning Tool Holders

L515
Clamp to Suit Turning Tool Holders

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Product Brochure For L452

L415
Right Hand Boring Bar

L534
Clamp Screw to Suit Tool Holders

L503
Seat Pin to Suit Turning Tool Holders

L504
Clamp to Suit Turning Tool Holders

L450
Lathe Turning Tool Kit - 3 piece Insert Type

L451
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

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Product Brochure For L452

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