

Product Brochure For L015

STGCR-1212-H11 - Right Hand Turning Tool Holder

12mm Tool Height
 Insert tip not included

Ex GST
\$70.00

Inc GST
\$77.00



| | |
|-------------|-------|
| ORDER CODE: | L015 |
| Size (mm): | 12 |
| Hand Type: | Right |
| Style: | STGCR |
| A (mm): | 12 |
| B (mm): | 12 |
| C (mm): | 100 |
| E (mm): | ~ |
| F (mm): | 16 |



Description

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

NOTE: Inserts not included with tool holders

Use insert TCMT 110204 (L062)

Features

- Positive rake turning tool holder with 95° approach angle
- Suitable for low powered machines
- Right hand tool holder suitable for turning towards the chuck

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 | |
|-----------------|--|-----------|
| | 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

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

Example 2.

20mm Mild Steel bar to be finished machined

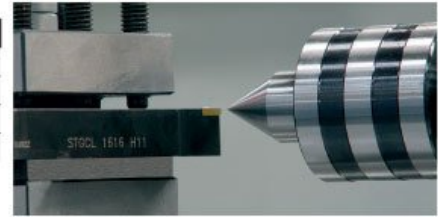
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

- 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



Front View

Product Brochure For L015

Recommended Accessories

L062
 KYOCERA Carbide Inserts -
 Turning



L525
 Screw to Suit Turning Tool
 Holder



L526
 Key to Suit Tool Holder



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



Product Brochure For L015

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



L467
 Professional Lathe Parting Tool Kit - Insert Type



Product Brochure For L015

L006A
Boring Bar Set - HSS



L431
Boring Bar Set - Carbide Insert



L430
Boring Bar Set - Carbide Insert

