

## STGCL-1212-H11 - Left Hand Turning Tool Holder

12mm Tool Height  
 Insert tip not included

**Ex GST**  
**\$70.00**

**Inc GST**  
**\$77.00**



ORDER CODE:	L016
Size (mm):	12
Hand Type:	Left
Style:	STGCL
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 90° approach angle
- Suitable for low powered machines
- Left hand tool holder suitable for facing operations

### 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



### 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



Product Brochure For L016

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 L016

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

