

Product Brochure For L049

WTJNL-2525-M16 - Left Hand Turning Tool Holder

25mm Tool Height
 Insert tip not included

Ex GST
\$120.00

Inc GST
\$132.00

ORDER CODE:	L049
Size (mm):	25
Hand Type:	Left
Style:	WTJNL
A (mm):	25
B (mm):	25
C (mm):	150
E (mm):	32
F (mm):	25



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
- 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	
	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

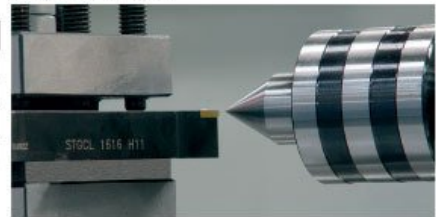
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

- 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



Top View

Recommended Accessories

L0644
 KYOCERA Carbide Inserts -
 Turning

L064
 KYOCERA Carbide Inserts -
 Turning

L0648
 KYOCERA Carbide Inserts -
 Turning

L527
 Seat to Suit Turning Tool
 Holders



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



Product Brochure For L049

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 L049

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

