

Product Brochure For L400

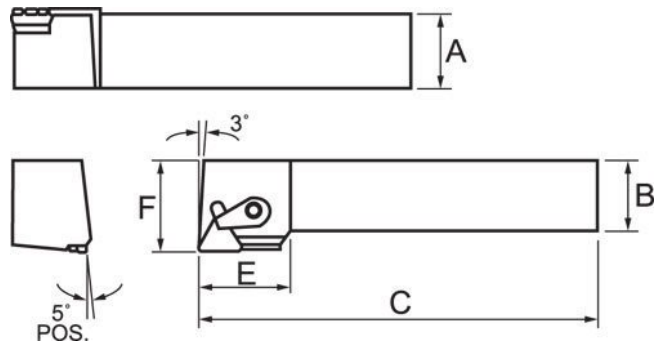
Right Hand Turning Tool Holder - CTGPR-1212-F11

12mm Tool Height

Insert tip not included



ORDER CODE:	L400
Part Number - Style:	CTGP
Tool Height Size (mm):	12
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Right
Holder Style:	~
Clearance Angle:	~
Insert Type:	TPMR11
A (H) (mm):	12
B (mm):	12
C (LF) (mm):	80
LH (mm):	~
F (WF) (mm):	16
E (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 TPMP 110304 (L061)

Features

- Positive rake turning tool holder with 90° approach angle
- Suitable for heavy duty cutting
- Right hand tool holder suitable for turning towards the chuck

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SETTING THE SPINDLE SPEED

To calculate the correct speed the following metric formula can be used

$$RPM = \frac{1000 \times \text{Surface speed in Metres per Minute}}{3.14 \times \text{Diameter in millimetres}}$$

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

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

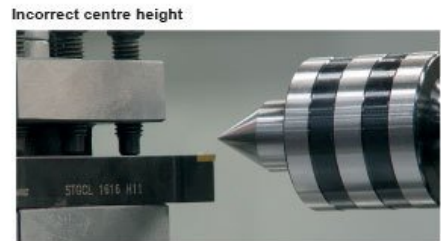
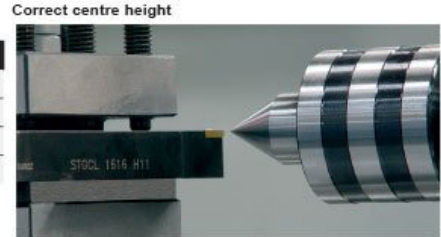
Example 2.
 20mm Mild Steel bar to be finished machined

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

- 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.



Specific Features



Full View



Side View



Locking Tool

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Recommended Accessories

L061
 KYOCERA Carbide Inserts -
 Turning



L533
 Clamp to Suit Turning Tool
 Holders



L534
 Clamp Screw to Suit 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



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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 L400

L006A
Boring Bar Set - HSS



L431
Boring Bar Set - Carbide Insert



L430
Boring Bar Set - Carbide Insert

