

## Product Brochure For L012

### Right Hand Turning Tool Holder - SCLCR-1010-H06

10mm Tool Height

Insert tip not included

Ex GST  
\$54.00

Inc GST  
\$59.40



|                            |        |
|----------------------------|--------|
| ORDER CODE:                | L012   |
| Part Number - Style:       | SCLC   |
| Tool Height Size (mm):     | 10     |
| Clamping Method of Insert: | ~      |
| Category:                  | ~      |
| Connection style:          | ~      |
| Back End Size:             | ~      |
| Application:               | ~      |
| Hand Type:                 | Right  |
| Holder Style:              | ~      |
| Clearance Angle:           | ~      |
| Insert Type:               | CCMT06 |
| A (H) (mm):                | 10     |
| B (mm):                    | 10     |
| C (LF) (mm):               | 100    |
| LH (mm):                   | ~      |
| F (WF) (mm):               | 12     |
| E (mm):                    | ~      |



#### Description

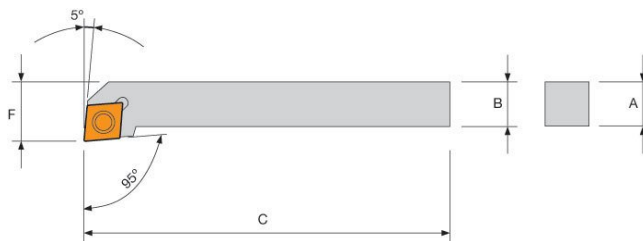
Quality Tipped Tool Holders ISO Standard to suit Tungsten Carbide Indexable Insert Tips.

NOTE: Inserts not included with tool holders

Use insert CCMT 60204 (L060)

#### 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



## Product Brochure For L012

### 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

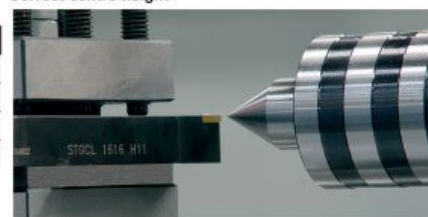
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

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

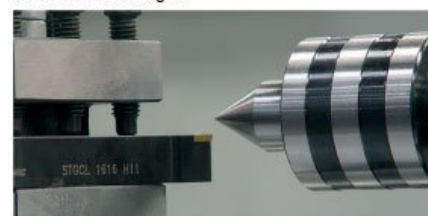
### SETTING THE TOOL ON CENTRE

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



Front View

## Product Brochure For L012

### Recommended Accessories

#### L060

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 L012

**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 L012

### L006A

Boring Bar Set - HSS



### L431

Boring Bar Set - Carbide Insert



### L430

Boring Bar Set - Carbide Insert

