

Product Brochure For L041

## Right Hand Turning Tool Holder - MWLNR-2525-M08

25mm Tool Height

Insert tip not included

Ex GST  
\$85.00

Inc GST  
\$93.50



ORDER CODE:	L041
Part Number - Style:	MWLN
Tool Height Size (mm):	25
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Right
Holder Style:	~
Clearance Angle:	~
Insert Type:	WNMG08
A (H) (mm):	25
B (mm):	25
C (LF) (mm):	150
LH (mm):	~
F (WF) (mm):	32
E (mm):	~



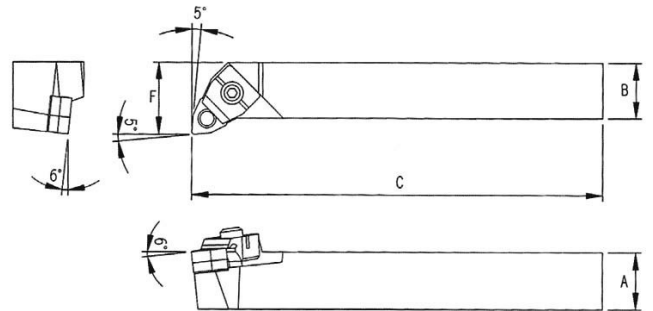
### Description

NOTE: Inserts not included with tool holders

Use insert WNMG 080408 (L053)

### Features

- Negative rake turning tool holder suitable for turning and facing
- Suitable for rapid metal removal



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**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**

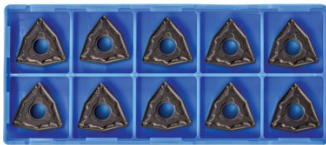


Side View

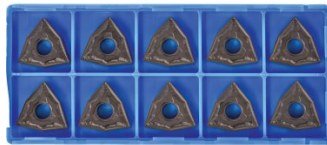
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**Recommended Accessories**

**L053**  
 KYOCERA Carbide Inserts -  
 Turning



**L0534**  
 KYOCERA Carbide Inserts -  
 Turning



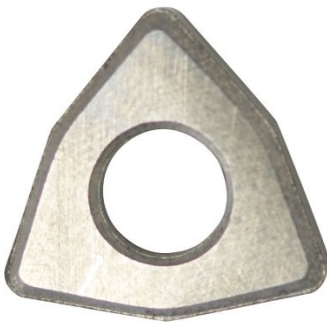
**L0538**  
 KYOCERA Carbide Inserts -  
 Turning



**L0539**  
 KENAMETAL Carbide Inserts -  
 Turning



**L513**  
 Seat to Suit Turning Tool  
 Holders



**L514**  
 Pin to Suit Turning Tool Holders



**L515**  
 Clamp to Suit Turning Tool  
 Holders



**L516**  
 Clamp Screw to Suit Turning  
 Tool Holders



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**ML400**  
 Cutter Part - Key



**L453**  
 Lathe Turning Tool Kit - 3 piece  
 Insert Type



**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



**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

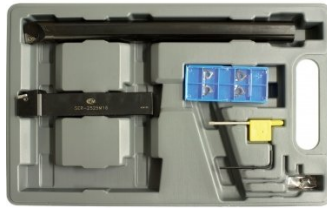


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**L458**  
 Lathe Threading Tool Kit - Insert Type



**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



**L006A**  
 Boring Bar Set - HSS



**L431**  
 Boring Bar Set - Carbide Insert



**L430**  
 Boring Bar Set - Carbide Insert

