

## Product Brochure For L042

### Left Hand Turning Tool Holder - MWLNL-2525-M08

25mm Tool Height

Insert tip not included

Ex GST  
\$85.00

Inc GST  
\$93.50



|                            |        |
|----------------------------|--------|
| ORDER CODE:                | L042   |
| Part Number - Style:       | MWLN   |
| Tool Height Size (mm):     | 25     |
| Clamping Method of Insert: | ~      |
| Category:                  | ~      |
| Connection style:          | ~      |
| Back End Size:             | ~      |
| Application:               | ~      |
| Hand Type:                 | Left   |
| 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):                    | ~      |



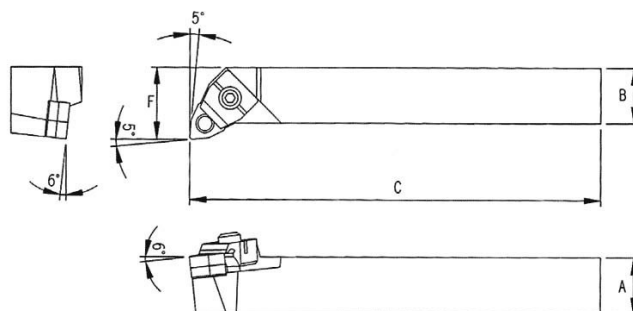
#### Description

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



## Product Brochure For L042

### 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

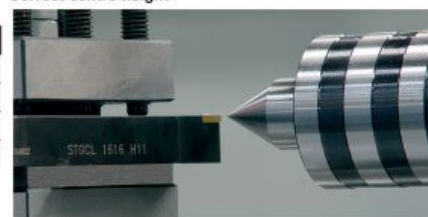
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

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

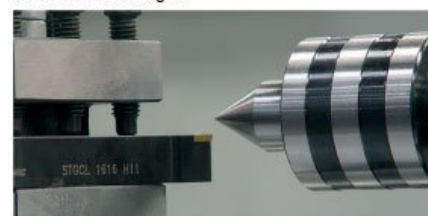
### SETTING THE TOOL ON CENTRE

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

## Product Brochure For L042

### Recommended Accessories

#### L053

KYOCERA Carbide Inserts -  
Turning



#### L0534

KYOCERA Carbide Inserts -  
Turning



#### L0538

KYOCERA Carbide Inserts -  
Turning



#### L0539

KENNAMETAL 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



## Product Brochure For L042

### ML400

Cutter Part - Key



### 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



### 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



## Product Brochure For L042

### 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

