

Product Brochure For L0430

Right Hand Turning Tool Holder - MWLNR-3232-P08W

32mm Tool Height
 Inserts not included



Description

Use insert/s
 WNMG 080404 PMG CA115P (L0534)
 Primarily used for 'FINISHING'

WNMG 080408 PMG CA125P (L053)
 Primarily used for 'GENERAL PURPOSE'

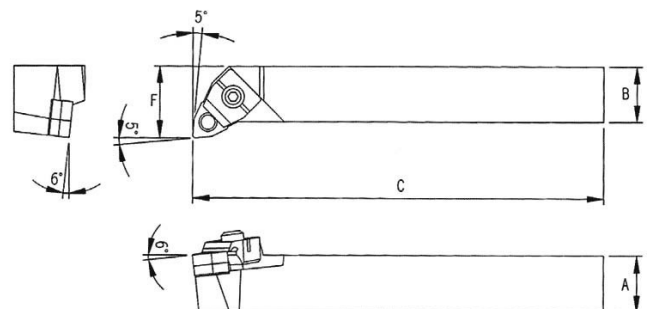
WNMG 080408 MS CA6525 (L0538)
 Primarily used for 'STAINLESS STEEL'

WNGP 080408K KC5410 (L0539)
 Primarily used for 'ALUMINIUM'

Features

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

ORDER CODE:	L0430
Part Number - Style:	MWLNR
Tool Height Size (mm):	32
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Right
Holder Style:	~
Clearance Angle:	~
Insert Type:	WNMG08
A (H) (mm):	32
B (mm):	32
C (LF) (mm):	170
LH (mm):	~
F (WF) (mm):	32
E (mm):	~



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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

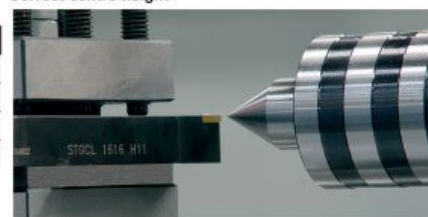
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

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

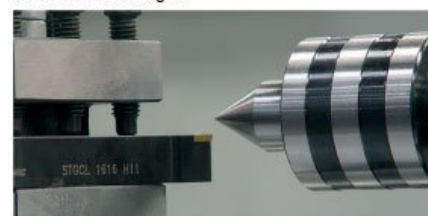
SETTING THE TOOL ON CENTRE

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

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



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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



Product Brochure For L0430

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

