

Product Brochure For L401

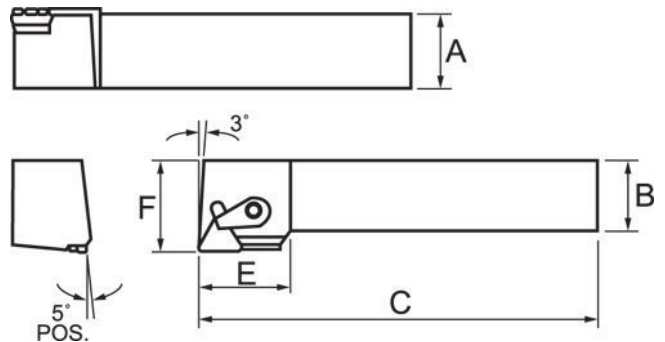
Left Hand Turning Tool Holder - CTGPL-1212-F11

12mm Tool Height

Insert tip not included



ORDER CODE:	L401
Part Number - Style:	CTGP
Tool Height Size (mm):	12
Clamping Method of Insert:	~
Category:	~
Connection style:	~
Back End Size:	~
Application:	~
Hand Type:	Left
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 TPMR 110304 (L061)

Features

- Positive rake turning tool holder with 90° approach angle
- Suitable for heavy duty cutting
- Left hand tool holder suitable for facing operations

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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

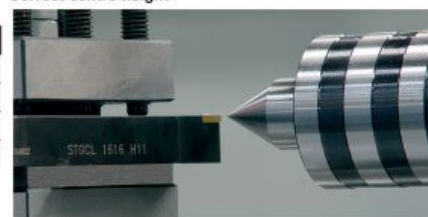
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

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

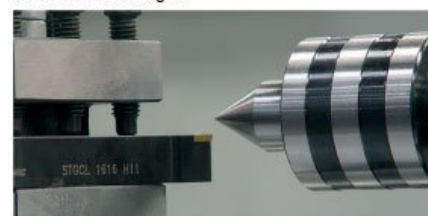
SETTING THE TOOL ON CENTRE

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



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



Product Brochure For L401

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



L458

Lathe Threading Tool Kit - Insert
 Type



L459

Lathe Threading Tool Kit - Insert
 Type



Product Brochure For L401

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

