

Product Brochure For L450

Lathe Turning Tool Kit - 3 piece Insert Type

12mm Tool Height

Ex GST
\$270.00

Inc GST
\$297.00

ORDER CODE:	L450
Type:	Turning Tool Kit
Tool Type:	Carbide Inserts
Shank Size - Tool Height (mm):	12
Pieces in Set (No.):	3
Replacement Tip Code:	L062
Nett Weight (kg):	0.8



Description

Compact turning kit with right hand and left hand turning tools and a boring bar. The kit is designed so that all the tools use the same inserts. The inserts used in this kit are ISO standard and can be substituted with any of the major brands of inserts.

12mm Tool Height

Includes

- 1 x Right hand turning tool STGCR1212H11
- 1 x Left hand turning tool STGCL1212H11
- 1 x Right hand boring bar S12MSTFCR11
- 10 x inserts to suit all tools(TCMT110204)

Optional Accessories

- Replacement Inserts use (L062)
- Replacement Screw use (L525)
- Replacement Key T-7 use (L526)

Product Brochure For L450

SETTING THE SPINDLE SPEED

To calculate the correct speed the following metric formula can be used

$$RPM = \frac{1000 \times \text{Surface speed in Metres per Minute}}{3.14 \times \text{Diameter in millimetres}}$$

Material	Approximate surface speeds for carbide tools	
	Metres per minute	
	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

$$RPM = \frac{1000 \times 50}{3.14 \times 20mm} = \frac{50000}{62.8} = 796rpm$$

Example 2.
 20mm Mild Steel bar to be finished machined

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

- 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



Set

Product Brochure For L450

Recommended Accessories

L062
 KYOCERA Carbide Inserts -
 Turning



L525
 Screw to Suit Turning Tool
 Holder



L526
 Key to Suit Tool Holder



L015
 Right Hand Turning Tool Holder



L016
 Left Hand Turning Tool Holder



L021
 Right Hand Boring Bar



L451
 Lathe Turning Tool Kit - 3 piece
 Insert Type



L452
 Lathe Turning Tool Kit - 3 piece
 Insert Type



Product Brochure For L450

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



L464
 Professional Lathe Parting Tool
 Kit - Insert Type



L465
 Professional Lathe Parting Tool
 Kit - Insert Type



Product Brochure For L450

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

