

Product Brochure For L452

Lathe Turning Tool Kit - 3 piece Insert Type

20mm Tool Height

On Sale

Ex GST

Inc GST

\$370.00

\$407.00

\$326.36

\$359.00



ORDER CODE:	L452
Type:	Turning Tool Kit
Tool Type:	Carbide Inserts
Shank Size - Tool Height (mm):	20
Pieces in Set (No.):	3
Replacement Tip Code:	L053
Nett Weight (kg):	3.0



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.

20mm Tool Height

Includes

- 1 x Right hand turning tool MWLNR08
- 1 x Left hand turning tool MWLNL08
- 1 x Right hand boring bar MWLNR08
- 10 x inserts to suit all tools (WNMG080404)

Optional Accessories

- Replacement Packet (10) Inserts use (L053)
- 20mm R/H Tool MWLNR 2020 K08W (L039)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)
- 20mm L/H Tool MWLNL 2020 K08W (L040)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)
- 20mm Boring Bar S20T MWLNR 08 (L415)
- CLAMP SCREW (L534)
- SHIM PIN (L503)
- CLAMP (L504)

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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

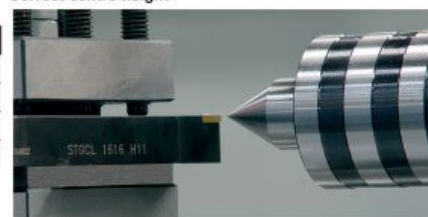
$$\text{RPM} = \frac{1000 \times 80}{3.14 \times 20\text{mm}} = \frac{80000}{62.8} = 1273\text{rpm}$$

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

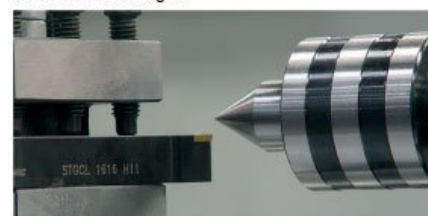
SETTING THE TOOL ON CENTRE

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



Set

Plastic Case

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Recommended Accessories

L053

KYOCERA Carbide Inserts -
Turning



L0534

KYOCERA Carbide Inserts -
Turning



L0538

KYOCERA Carbide Inserts -
Turning



L039

Right Hand Turning Tool Holder



L040

Left Hand Turning Tool Holder



L513

Seat to Suit Turning Tool
Holders



L514

Pin to Suit Turning Tool Holders



L515

Clamp to Suit Turning Tool
Holders



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L415

Right Hand Boring Bar



L534

Clamp Screw to Suit Tool Holders



L503

Seat Pin to Suit Turning Tool Holders



L504

Clamp to Suit Turning Tool Holders



L450

Lathe Turning Tool Kit - 3 piece Insert Type



L451

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



Product Brochure For L452

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



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

