

Product Brochure For L042

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

25mm Tool Height

Insert tip not included

**On Sale**

Ex GST

**\$104.00**

**\$82.61**

Inc GST

**\$119.60**

**\$95.00**



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):	~



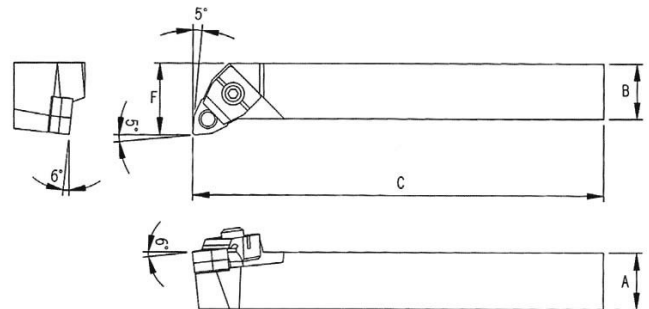
### Description

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	
	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

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

#### 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

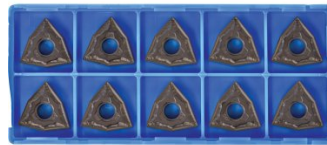
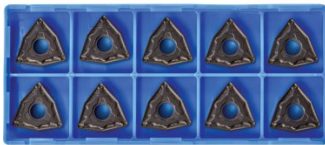
**Recommended Accessories**

L053  
KYOCERA Carbide Inserts -  
Turning

L0534  
KYOCERA Carbide Inserts -  
Turning

L0538  
KYOCERA Carbide Inserts -  
Turning

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

ML400  
Cutter Part - Key



Product Brochure For L042

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



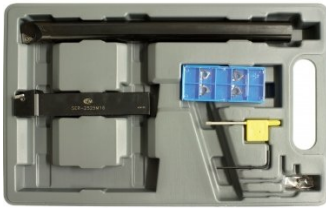
L458

Lathe Threading Tool Kit - Insert  
Type



Product Brochure For L042

**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

