

Product Brochure For L046

## Right Hand Turning Tool Holder - WTJNR-2020-K16

20mm Tool Height

Insert tip not included

**On Sale**

|                 |                 |
|-----------------|-----------------|
| <b>Ex GST</b>   | <b>Inc GST</b>  |
| <b>\$116.00</b> | <b>\$133.40</b> |
| <b>\$93.04</b>  | <b>\$107.00</b> |



|                            |        |
|----------------------------|--------|
| ORDER CODE:                | L046   |
| Part Number - Style:       | WTJN   |
| Tool Height Size (mm):     | 20     |
| Clamping Method of Insert: | ~      |
| Category:                  | ~      |
| Connection style:          | ~      |
| Back End Size:             | ~      |
| Application:               | ~      |
| Hand Type:                 | Right  |
| Holder Style:              | ~      |
| Clearance Angle:           | ~      |
| Insert Type:               | TNMG16 |
| A (H) (mm):                | 20     |
| B (mm):                    | 20     |
| C (LF) (mm):               | 125    |
| LH (mm):                   | ~      |
| F (WF) (mm):               | 20     |
| E (mm):                    | 32     |



### Description

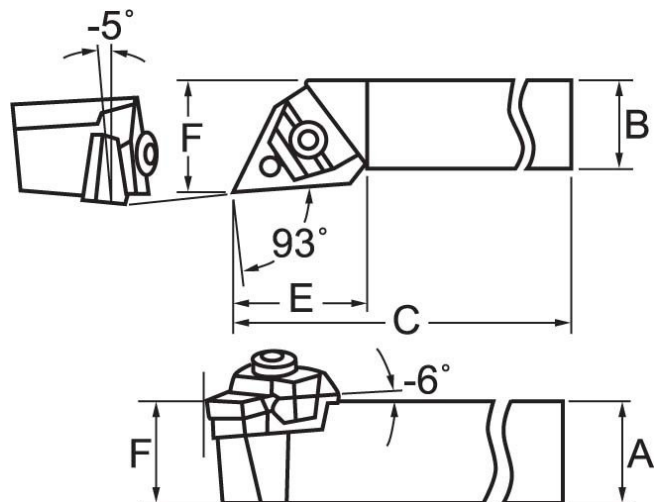
Quality Tipped Tool Holders ISO Standard to suit Tungsten Carbide Indexable Insert Tips.

NOTE: Inserts not included with tool holders

Use insert TNMG 160408 (L064)

### Features

- Negative rake turning tool holder with 93° approach angle
- Suitable for rapid metal removal
- Right hand tool holder suitable for turning towards the chuck



Product Brochure For L046

**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 |           |
|-----------------|--|-----------|
|                 | 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

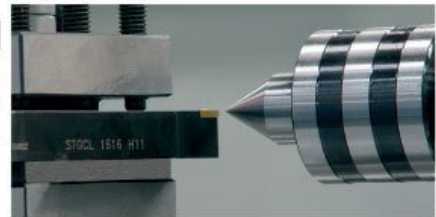
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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



**Recommended Accessories**

L0644  
KYOCERA Carbide Inserts -  
Turning

L064  
KYOCERA Carbide Inserts -  
Turning

L0648  
KYOCERA Carbide Inserts -  
Turning

L527  
Seat to Suit Turning Tool  
Holders



Product Brochure For L046

**L528**  
Screw Pin to Suit Turning Tool Holders



**L529**  
Clamp to Suit Turning Tool Holders



**L530**  
Clamp Screw to Suit Turning Tool Holders



**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



Product Brochure For L046

**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

