

## Product Brochure For L453

# Lathe Turning Tool Kit - 3 piece Insert Type

25mm Tool Height

**On Sale**

Ex GST	Inc GST
<del>\$488.00</del>	<del>\$561.20</del>
<b>\$389.57</b>	<b>\$448.00</b>



ORDER CODE:	L453
Type:	Turning Tool Kit
Tool Type:	Carbide Inserts
Shank Size - Tool Height (mm):	25
Pieces in Set (No.):	3
Replacement Tip Code:	L053
Nett Weight (kg):	3.4



## 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.

25mm Tool Height

## Includes

- 1 x Right hand turning tool MWLNR2525 M08W
- 1 x Left hand turning tool MWLNL2525 M08W
- 1 x Right hand boring bar S25TMWLNRM08
- 10 x inserts to suit all tools (WNMG080404)

## Optional Accessories

- Replacement Packet (10) Inserts use (L053)
- 25mm R/H Tool MWLNR 2525 M08W (L041)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)
- SCREW (L516)
- 25mm L/H Tool MWLNL 2525 M08W (L042)
- SHIM (L513)
- SHIM PIN (L514)
- CLAMP (L515)
- 25mm Boring Bar S25T MWLNR 08 (L416)
- CLAMP SCREW (L536)
- CLAMP (L535)
- SHIM PIN (L503)

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**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

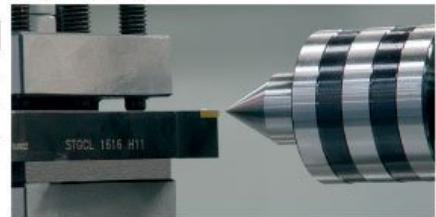
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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



**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

ML400  
Cutter Part - Key



L041  
Right Hand Turning Tool Holder

L042  
Left Hand Turning Tool Holder

L513  
Seat to Suit Turning Tool  
Holders

L514  
Pin to Suit Turning Tool Holders



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**L515**  
Clamp to Suit Turning Tool Holders



**L516**  
Clamp Screw to Suit Turning Tool Holders



**L416**  
Right Hand Boring Bar



**L535**  
Clamp to Suit Turning Tool Holders



**L503**  
Seat Pin to Suit Turning Tool Holders



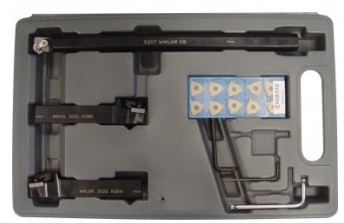
**L450**  
Lathe Turning Tool Kit - 3 piece Insert Type



**L451**  
Lathe Turning Tool Kit - 3 piece Insert Type



**L452**  
Lathe Turning Tool Kit - 3 piece Insert Type



**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



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**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



**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

