

Product Brochure For L451

## Lathe Turning Tool Kit - 3 piece Insert Type

16mm Tool Height

**On Sale**

Ex GST	Inc GST
<del>\$280.00</del>	<del>\$308.00</del>
<b>\$244.55</b>	<b>\$269.00</b>



ORDER CODE:	L451
Type:	Turning Tool Kit
Tool Type:	Carbide Inserts
Shank Size - Tool Height (mm):	16
Pieces in Set (No.):	3
Replacement Tip Code:	L062
Nett Weight (kg):	1.2



### 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.

16mm Tool Height

### Includes

- 1 x 16mm Right hand turning tool STGCR1616H11
- 1 x 16mm Left hand turning tool STGCL1616H11
- 1 x 16mm Right hand boring bar S16QSTFCR11
- 10 x inserts to suit all tools(TCMT110204)

### Optional Accessories

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

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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

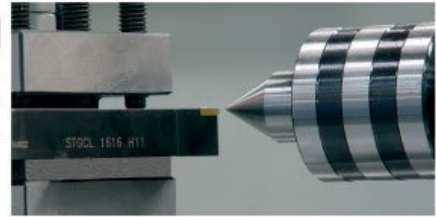
$$RPM = \frac{1000 \times 80}{3.14 \times 20mm} = \frac{80000}{62.8} = 1273rpm$$

- 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

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**Recommended Accessories**

**L062**  
 KYOCERA Carbide Inserts -  
 Turning



**L525**  
 Screw to Suit Turning Tool  
 Holder



**L526**  
 Key to Suit Tool Holder



**L017**  
 Right Hand Turning Tool Holder



**L018**  
 Left Hand Turning Tool Holder



**L022**  
 Right Hand Boring Bar



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



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



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**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



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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

