

Product Brochure For L452

## Lathe Turning Tool Kit - 3 piece Insert Type

20mm Tool Height

**On Sale**

<b>Ex GST</b>	<b>Inc GST</b>
<del>\$370.00</del>	<del>\$407.00</del>
<b>\$317.27</b>	<b>\$349.00</b>



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

$$RPM = \frac{1000 \times \text{Surface speed in Metres per Minute}}{3.14 \times \text{Diameter in millimetres}}$$

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

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

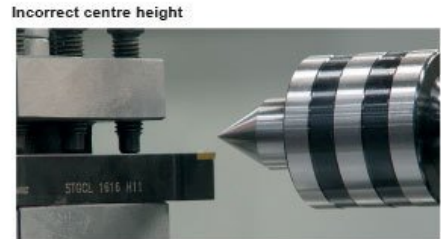
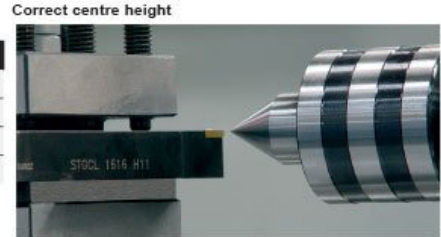
**Example 2.**  
 20mm Mild Steel bar to be finished machined

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

- 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.



**Specific Features**



Set

Plastic Case

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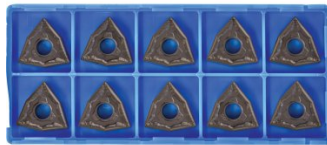
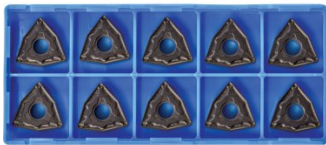
**Recommended Accessories**

**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



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**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

