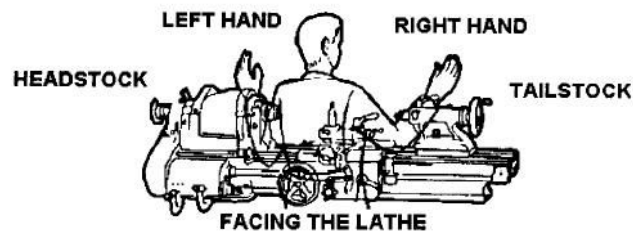
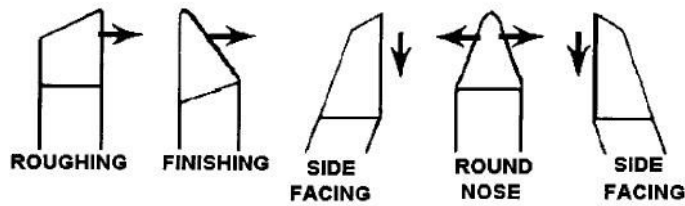


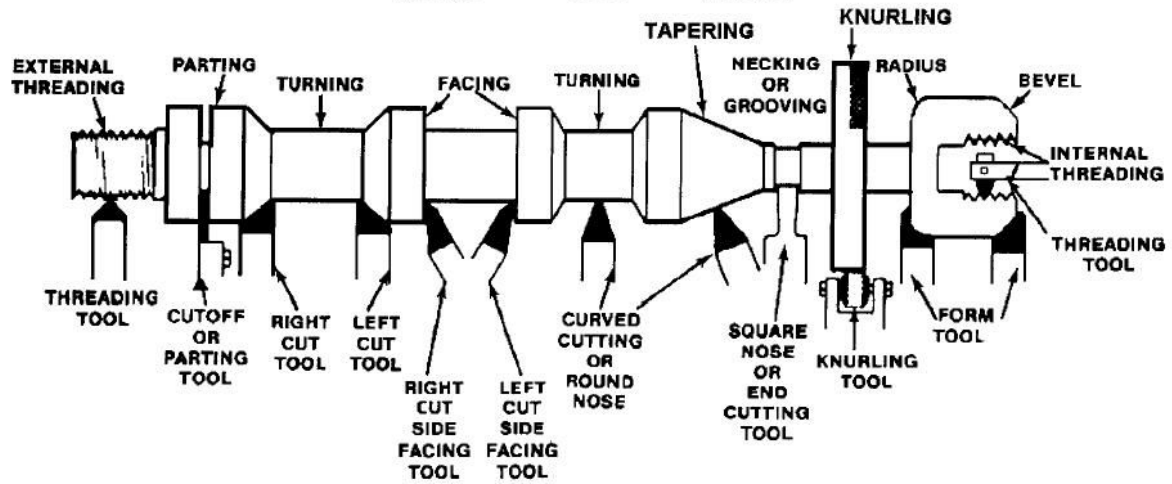
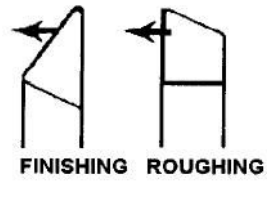
THIS WILL HELP YOU TO IDENTIFY A RIGHT-CUT
AND A LEFT-CUT TOOL.

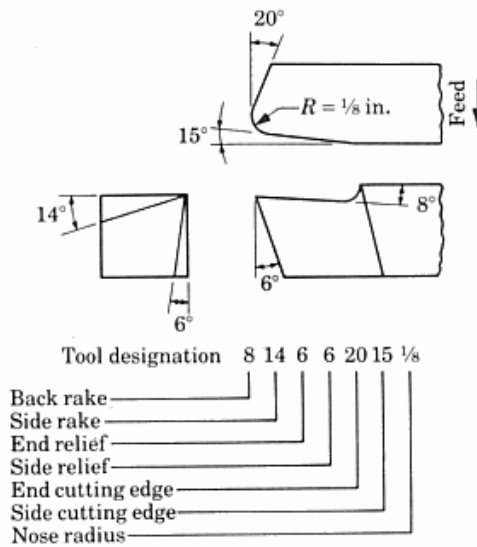


LEFT CUT



RIGHT CUT

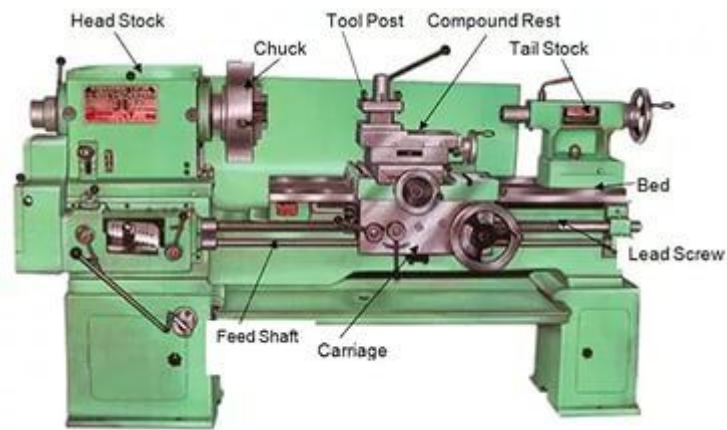




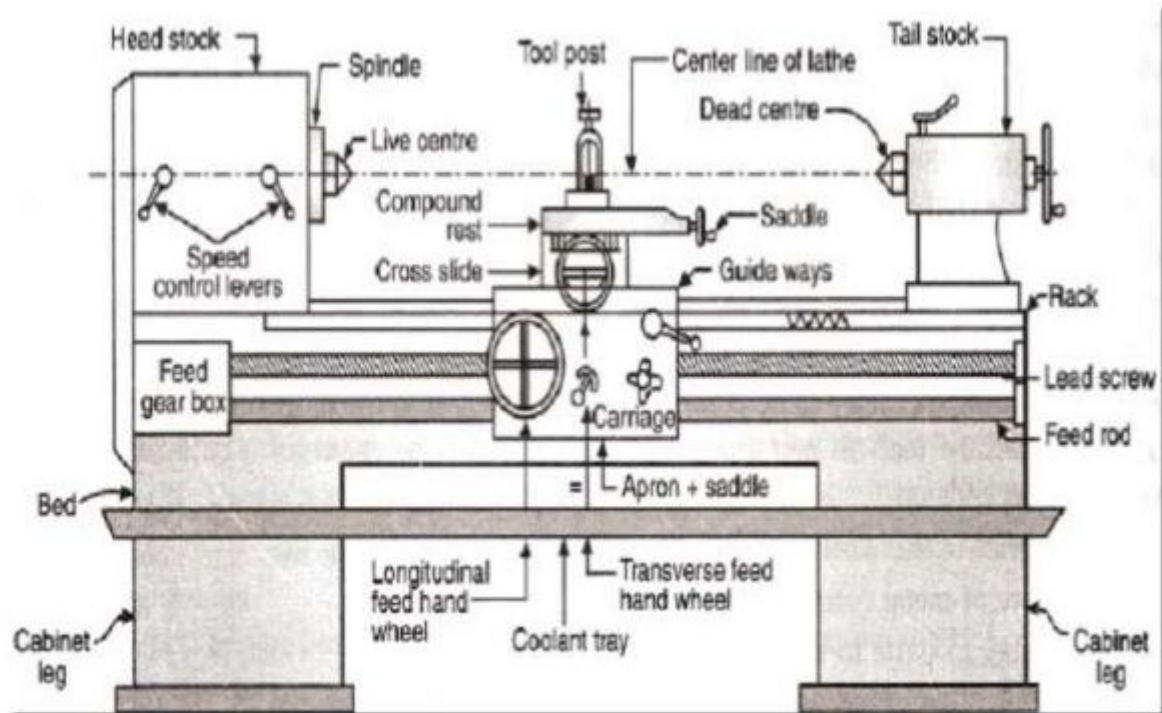
Designation and symbols for a right-hand cutting tool.

GENERAL RECOMMENDATIONS FOR TURNING TOOLS

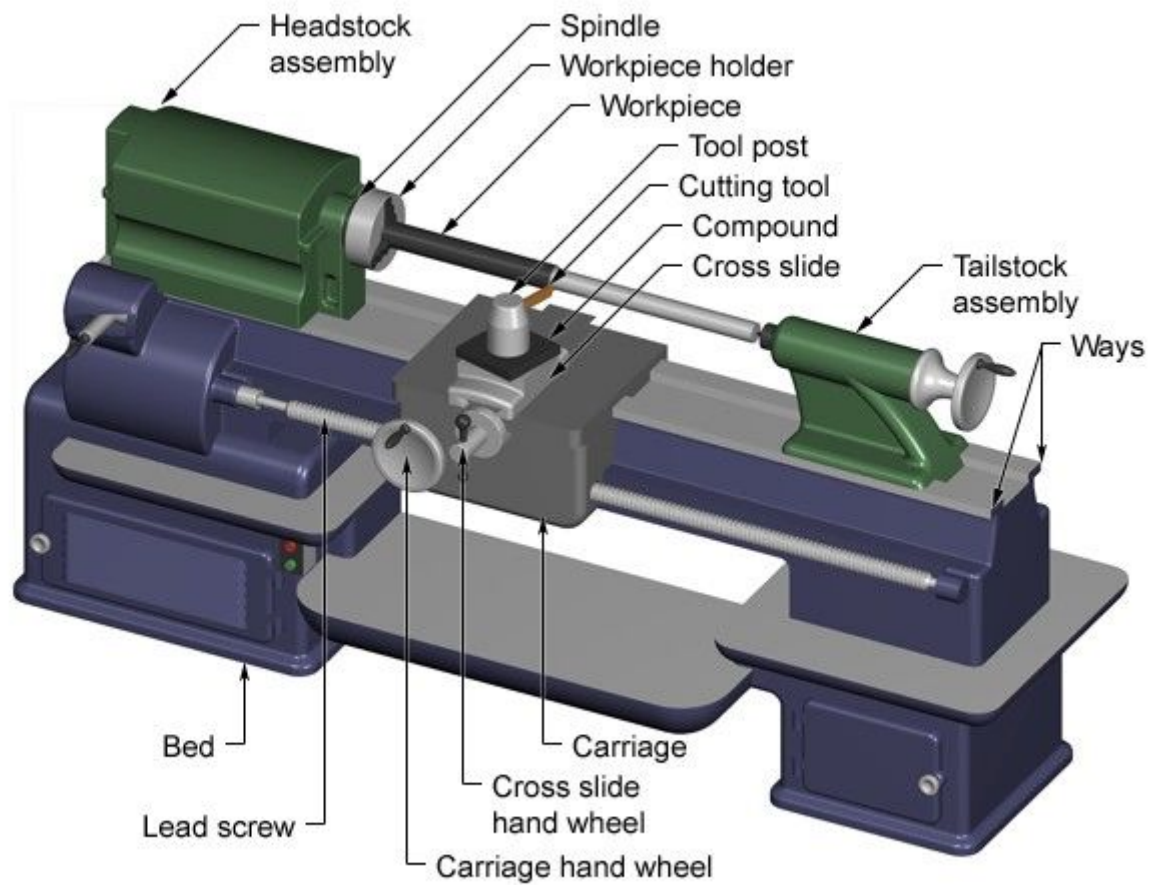
MATERIAL	HIGH-SPEED STEEL					CARBIDE (INSERTS)				
	BACK RAKE	SIDE RAKE	END RELIEF	SIDE RELIEF	SIDE AND END CUTTING EDGE	BACK RAKE	SIDE RAKE	END RELIEF	SIDE RELIEF	SIDE AND END CUTTING EDGE
Aluminum and magnesium alloys	20	15	12	10	5	0	5	5	5	15
Copper alloys	5	10	8	8	5	0	5	5	5	15
Steels	10	12	5	5	15	-5	-5	5	5	15
Stainless steels	5	8-10	5	5	15	-5-0	-5-5	5	5	15
High-temperature alloys	0	10	5	5	15	5	0	5	5	45
Refractory alloys	0	20	5	5	5	0	0	5	5	15
Titanium alloys	0	5	5	5	15	-5	-5	5	5	5
Cast irons	5	10	5	5	15	-5	-5	5	5	15
Thermoplastics	0	0	20-30	15-20	10	0	0	20-30	15-20	10
Thermosets	0	0	20-30	15-20	10	0	15	5	5	15



PRINCIPLE PARTS OF LATHE



SINGLE POINT CUTTING TOOL SHAPES



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