

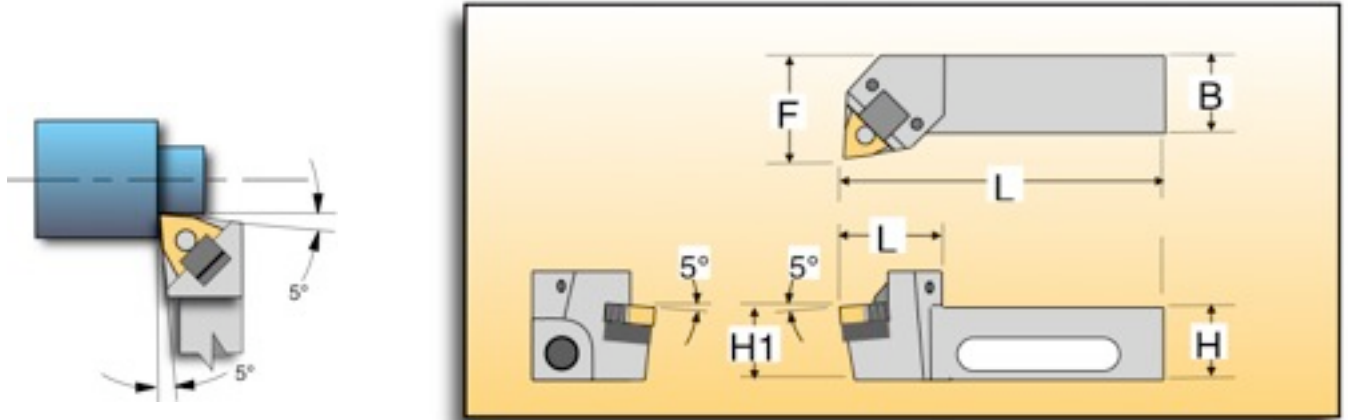


Lathe Tool Holders

U.S. Patent 7153069 other US & foreign patents pending

GWLNR/L - WNMG, 80° Trigon

This tool is designed for both turning and facing operations. The insert is firmly held from both sides by fingers that wedge against solid internal toolholder surfaces, giving superior rigidity and repeatability. The center hole is not used for clamping or positioning.



Metric Sizes											Dimensions in Millimeters		
Catalog Number		Gage Insert	H	B	H1	L	F	L1	Shim	Options			
Right Hand	Left Hand		Shank Height ±.10	Shank Width ±.15	Insert Height ±.08	Overall Length ±.08	Tip Offset ±.08	Head Length ±.15		Coolant Head	Parts List		
GWLNR-2025K-08	■ GWLNL-2025K-08	■ WNMG 08 04 08	20.00	25.00	20.00	125.00	32.00	32.00	IWSN-433	CHM-1008	PLM-1008		
GWLNR-2525M-08	■ GWLNL-2525M-08	■ WNMG 08 04 08	25.00	25.00	25.00	150.00	32.00	32.00	IWSN-433	CHM-1008	PLM-1008		
GWLNR-3225P-08	■ GWLNL-3225P-08	■ WNMG 08 04 08	32.00	25.00	32.00	170.00	32.00	32.00	IWSN-433	CHM-1008	PLM-1008		

Normally Stocked Special Order

Inch Sizes											Dimensions in Inches		
Catalog Number		Gage Insert	H	B	H1	L	F	L1	Shim	Options			
Right Hand	Left Hand		Shank Height ±.004	Shank Width ±.006	Insert Height ±.003	Overall Length ±.003	Tip Offset ±.003	Head Length ±.006		Coolant Head	Parts List		
GWLNR-124B	■ GWLNL-124B	■ WNMG-432	0.750	0.750	0.750	4.50	1.250	1.250	IWSN-433	CHE-1008	PLE-1008		
GWLNR-164C	■ GWLNL-164C	■ WNMG-432	1.000	1.000	1.000	5.00	1.250	1.250	IWSN-433	CHE-1008	PLE-1008		
GWLNR-164D	<input type="checkbox"/> GWLNL-164D	<input type="checkbox"/> WNMG-432	1.000	1.000	1.000	6.00	1.250	1.250	IWSN-433	CHE-1008	PLE-1008		
GWLNR-204D	■ GWLNL-204D	■ WNMG-432	1.250	1.250	1.250	6.00	1.500	1.250	IWSN-433	CHE-1008	PLE-1008		
GWLNR-244D	<input type="checkbox"/> GWLNL-244D	<input type="checkbox"/> WNMG-432	1.500	1.500	1.500	6.00	1.750	1.250	IWSN-433	CHE-1008	PLE-1008		

Normally Stocked Special Order

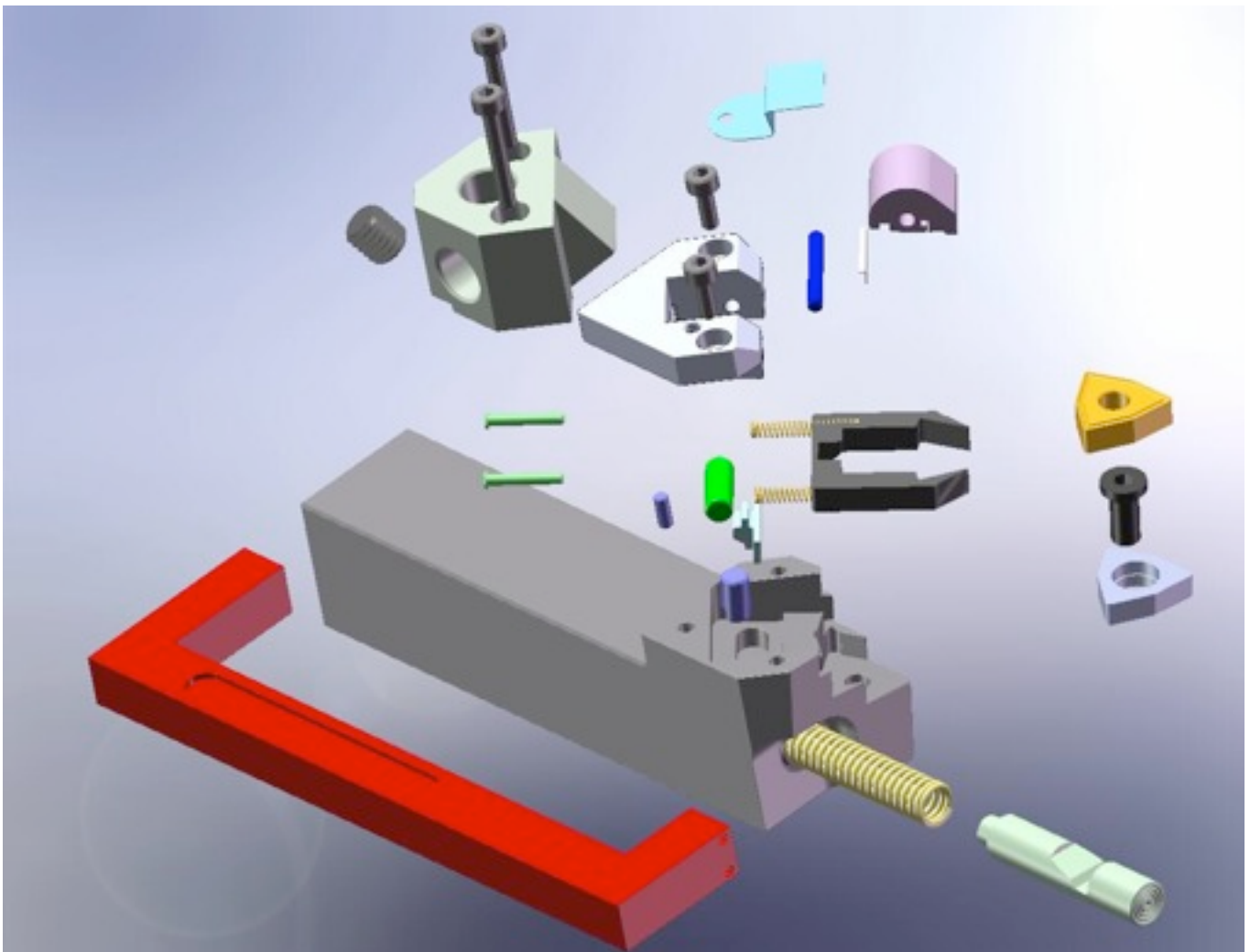
Revised 7/06/08



Disassembly & Assembly Instructions

U.S. Patent 7153069 other US & foreign patents pending
Specifications are subject to change without notice

GWLNR/L Tool Holder Disassembly *Follow Steps 1 through 6.*



GWLNR/L Insert Repeatability

This test shows the insert repeatability of the Click Change tool holder. The test is performed using a standard gauge insert in a metrology environment. The insert is manually removed and manually replaced for each reading using the same insert tip. Each measurement is recorded in the table below for each of the three axes. A standard production Click Change tool holder is used for the test, and similar results may be expected using any production tool. Measurements are taken with a Mititoyo Digimatic Indicator model ID-F, and recorded to a resolution of .00005". There is a gauge R&R error of +/- .00005 in the measurement data.

Repeatability Test Results (inches)

	Height	Width	Length
Avg. Value	1.00384	1.25130	4.50244
Std. Deviation	0.00003	0.00007	0.00008
Maximum Val	1.00390	1.25140	4.50250
Minimum Val	1.00380	1.25120	4.50230
Total Variation	0.00010	0.00020	0.00020

Measurement Data (inches)

No.	Height	Width	Length
1	1.00385	1.25135	4.50235
2	1.00380	1.25140	4.50230
3	1.00380	1.25135	4.50245
4	1.00385	1.25130	4.50250
5	1.00385	1.25140	4.50235
6	1.00380	1.25123	4.50245
7	1.00390	1.25125	4.50250
8	1.00380	1.25125	4.50250
9	1.00385	1.25123	4.50250
10	1.00385	1.25120	4.50250

Insert Repeatability <.0002" <.004 mm.

GWLNR/L Machining Test Cuts

These examples show some actual test cutting conditions for the Click Change Tool Holder. They are not intended to show the limits of the tool. The important measurements here are the depth of cut, the feed rate, and the material being cut. These three parameters determine the cutting forces that the tool holder will see. Increasing the cutting speed, will require more horsepower, but has little or no effect on the forces seen by the insert or the tool holder. In general, it is the machine rigidity, the insert composition and coating, and the coolant type and delivery method that limit the metal removal rate. The tool holder is not usually the "Weak Link".

	Test 1		Test 2		Test 3	
Material	347 Stainless		Inconel 625		1018	
Feed Rate	.020 in.	0.51 mm	.020 in.	0.51 mm	.035 in.	.89 mm
Depth of Cut	.150 in.	3.8 mm	.150 in.	3.8 mm	.150 in.	3.8 mm
Diameter	1.0 in.	25.4 mm	1.25 in.	31.75 mm	1.5 in.	38.1 mm
Speed	450 SF/M	135 M/M	225 SF/M	67.5 M/M	1200 SF/M	366 M/M
RPM	1720	1720	685	685	3000	3000

GWLNR/L WNMG - 80° Trigon

All prices are in US Dollars

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Coolant Head

GWLNR/L Metric - 80° Trigon			
Catalog Number			
Right Hand	Left Hand	List Price	Weight (Lbs.)
GWLNR-2025K-08	GWLNL-2025K-08	\$328.13	0.92
GWLNR-2525M-08	GWLNL-2525M-08	\$335.63	1.85
GWLNR-3225P-08	GWLNL-3225P-08	\$350.63	2.3(est)

Metric Parts		
Accessories & Parts (Applies to all sizes)		
Description	Part Number	Price
Coolant Head	CHM-1008	\$124.00
Shim Kit	SK-WNMG-4M	\$23.50

GWLNR/L Inch - 80° Trigon			
Catalog Number			
Right Hand	Left Hand	List Price	Weight (Lbs.)
GWLNR-124B	GWLNL-124B	\$328.70	0.84
GWLNR-164C	GWLNL-164C	\$335.63	1.51
GWLNR-164D	GWLNL-164D	\$335.63	1.79
GWLNR-204D	GWLNL-204D	\$350.63	2.68
GWLNR-244D	GWLNL-244D	\$374.63	

Inch Parts		
Accessories & Parts (Applies to all sizes)		
Description	Part Number	Price
Coolant Head	CHE-1008	\$124.00
Shim Kit	SK-WNMG-4M	\$23.50



Parts List & Prices

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GWLNR/L Individual Parts Price List

Part Number	Qty/ Tool	Description	Price Each																
AT-1008	0	Assembly Tool	\$34.50																
AX-1002	1	Axle	\$5.50																
BD-1008-xxx	1	Body (specify size)	\$165.70																
CF-1008	1	Clamp Foot	\$16.20																
CL-1008	1	Clamp	\$24.30																
CP-1008	1	Cover Pin	\$4.25																
CR-1008	1	Cam Rod	\$25.60																
CS-1002	2	Clamp Spring	\$14.75																
CS-1008	2	Clamp Spring	\$13.75																
CV-1008	1	Cover	\$35.25																
DS-1002	1	Drive Spring	\$13.80																
FS-1008	1	Front Shield	\$9.10																
IF-1008	1	Insert Fork	\$55.20																
LB-1001	1	Adhesive Label	\$4.50																
LR-1008	1	Lock Roller	\$9.80																
PS-1008	1	Piston	\$7.30																
RS-1008	1	Rear Shield	\$18.60																
SHCS-M3x8	3	Socket Head Cap Screw (M3 x 8)	\$4.00																
SHSS-M3x4	2	Socket Head Set Screw (M3 x 4)	\$4.00																
SP-1008	2	Spring Pin	\$6.50																
SR-1008	1	Shim Retainer	\$15.50																
VS-1008	1	V-Seal	\$12.00																
IWSN-432	1	Carbide Shim	\$8.50																
Coolant Head Parts																			
CH-1008	1	Coolant Head																	