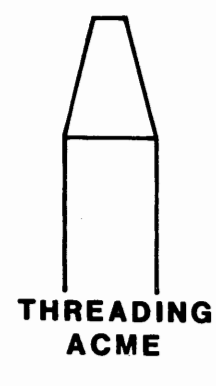
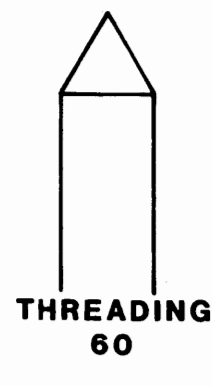
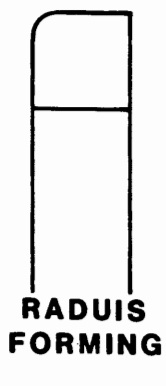
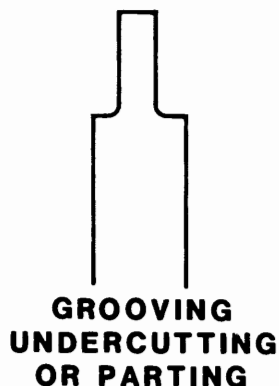
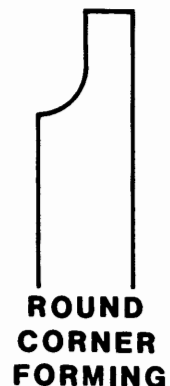
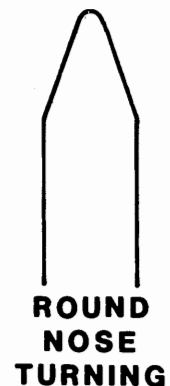
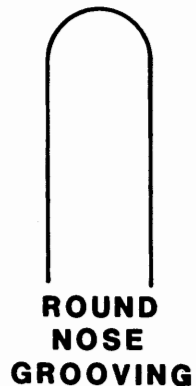
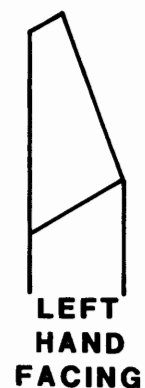
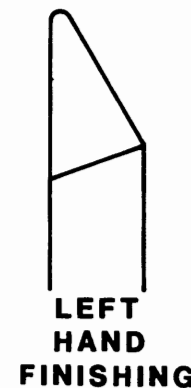
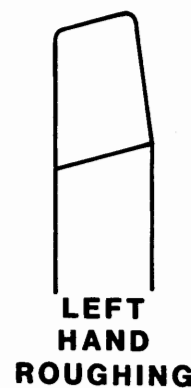
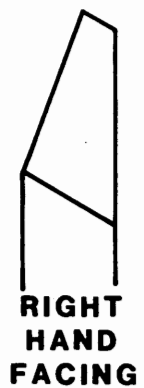
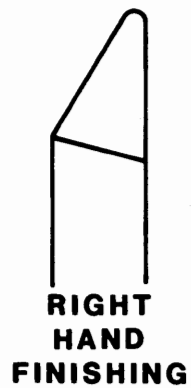
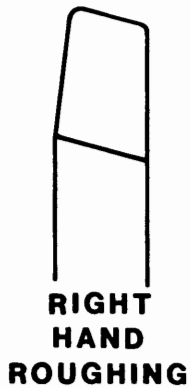
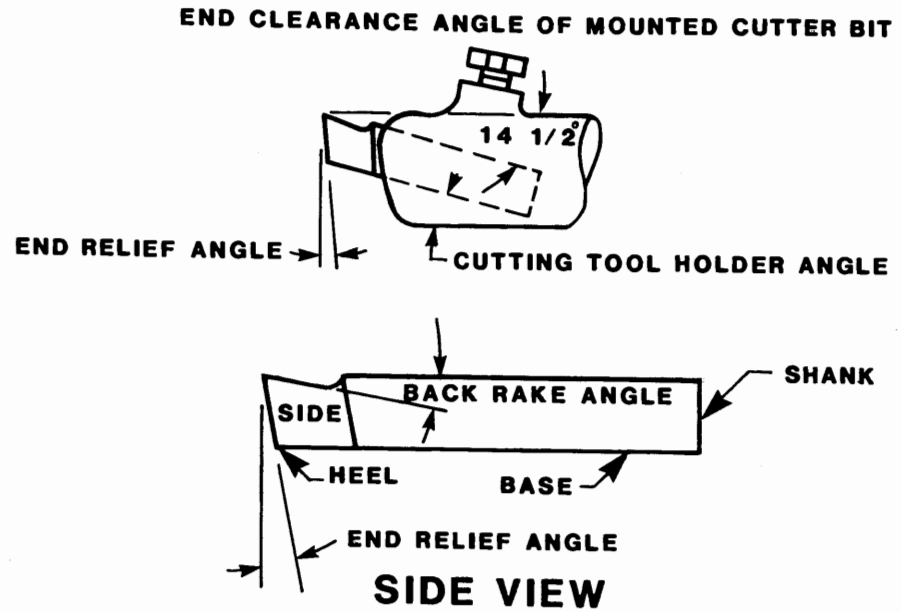
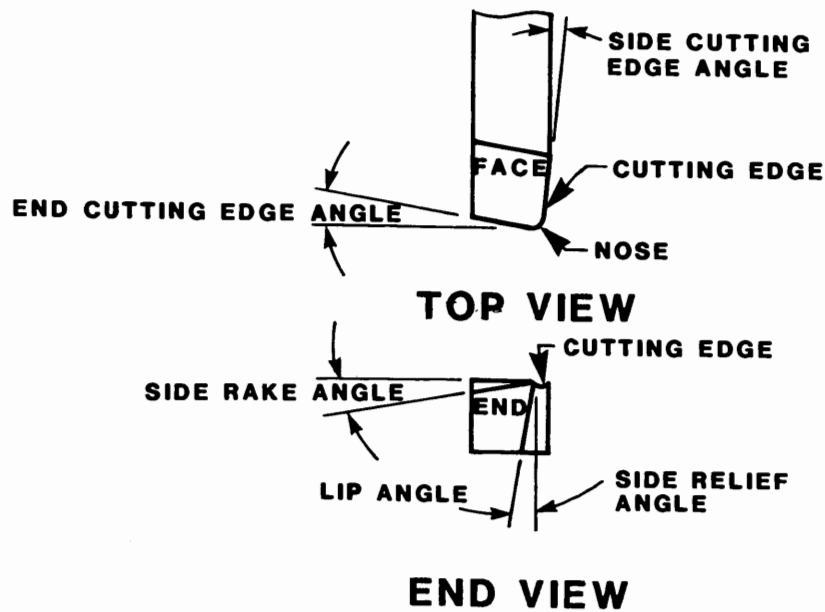


LATHE TOOLS

STANDARD SHAPES



SINGLE POINT LATHE TOOL ANGLES



MATERIAL	SIDE RELIEF	END RELIEF	BACK RAKE	SIDE RAKE
LOW CARBON STEEL	10 to 12	8	8 to 16	12 to 14
MEDIUM CARBON STEEL	10 to 12	8	12 to 16	12 to 22
HIGH CARBON STEEL	10	8	8	12
HIGH SPEED STEELS	10	8	8	12
ALLOY TOOL STEELS	10	8	8	12
CARBON TOOL STEELS	10	8	8	12
ALLOY STEELS	10	8	8 to 12	12 to 15
STAINLESS STEEL	10	8	8 to 10	14 to 20
ALUMINUM	12	8	35	15
BRASS	10	8	0	1 to 5
BRONZE	10	8	0	0 to -4
COPPER	14	12	16	20
GREY CAST IRON	10	8	5	12
NICKEL	15	13	8	12
MONEL	15	13	8	14
WOOD	20	20	30	30

(WHEN GRINDING TOOLS TO BE USED IN STANDARD ANGLED TOOL HOLDERS, REMEMBER THE $14 \frac{1}{2}$ DEGREE BUILT-IN ANGLE AND GRIND ACCORDINGLY)