

Product Brochure For L027

Parting Block - Suits 26mm Blade

12mm Tool Height



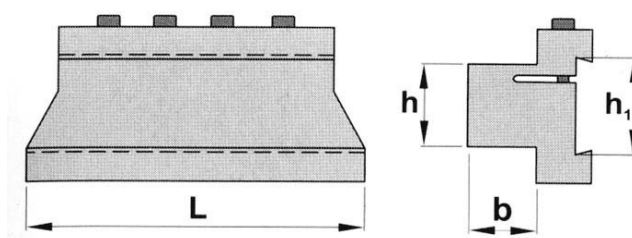
Ex GST

\$75.00

Inc GST

\$82.50

ORDER CODE:	L027
Blade Size (h1) (mm):	26 x 2 or 26 x 3
h (mm):	12
b (mm):	16
L (mm):	87
Nett Weight (kg):	0.7



Description

NOTE: Blades and Inserts not included:

Optional Accessories

- Blade - 26 x 2mm (L468) & Inserts (L0512)
- Blade - 26 x 3mm (L469) & Inserts (L0513)

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TECHNICAL INFORMATION

SETTING THE SPINDLE SPEED

To calculate the correct speed the following formula can be used.

$$\text{RPM} = \frac{1000 \times \text{Surface speed in Metres per Minute (M/min)}}{3.14 \times \text{Work Piece Diameter (mm)}}$$

Example 1.

20mm Mild Steel bar to be parted off.

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

Example 2.

20mm Aluminium bar to be parted off.

$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- Set the spindle speed to the closest RPM speed 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 adjusting the tool height to line up with centre point.

Correct Centre Height



Approximate surface speeds for carbide tools

Material	Parting Off
Mild Steel	80 M/min
Cast Iron	70 M/min
Aluminium	100 M/min
Stainless Steel	60 M/min

Specific Features



Shown Setup with Optional Blade and Tip

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Recommended Accessories

L468

Parting Blade



L469

Parting Blade

L0512

KENNAMETAL Carbide Inserts - Parting



L0513

KENNAMETAL Carbide Inserts - Parting



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



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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



L450

Lathe Turning Tool Kit - 3 piece Insert Type



L451

Lathe Turning Tool Kit - 3 piece Insert Type



L452

Lathe Turning Tool Kit - 3 piece Insert Type



L453

Lathe Turning Tool Kit - 3 piece Insert Type



L456

Lathe Threading Tool Kit - Insert Type



L457

Lathe Threading Tool Kit - Insert Type



L458

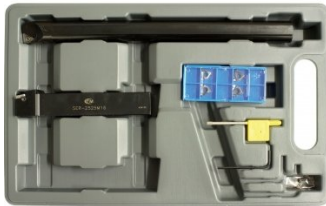
Lathe Threading Tool Kit - Insert Type



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L459

Lathe Threading Tool Kit - Insert
 Type



L006A

Boring Bar Set - HSS



L431

Boring Bar Set - Carbide Insert



L430

Boring Bar Set - Carbide Insert

