

Product Brochure For L029B

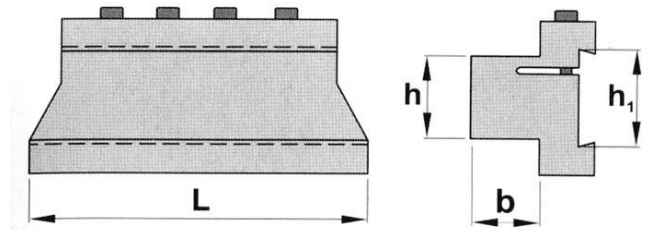
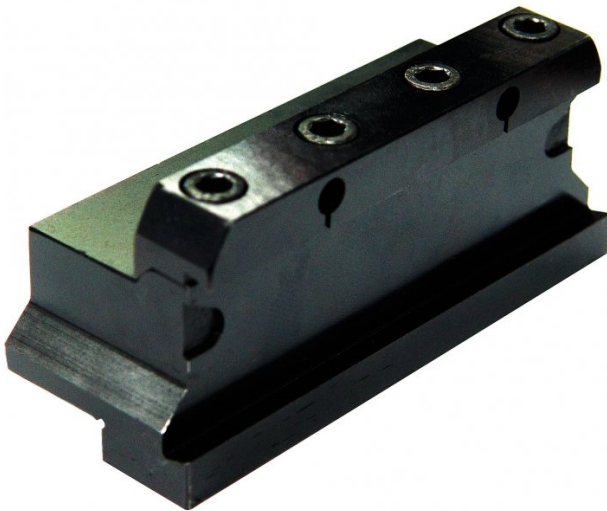
Parting Block - Suits 32mm Blade

20mm Tool Height

Ex GST
 \$90.00

Inc GST
 \$99.00

ORDER CODE:	L029B
Blade Size (h1) (mm):	32 x 3
h (mm):	20
b (mm):	20
L (mm):	87
Nett Weight (kg):	0.8



Description

NOTE: Blades and Inserts not included:

Optional Accessories

- Blade - 32 x 3mm (L4693) & Inserts (L0513)

TECHNICAL INFORMATION

SETTING THE SPINDLE SPEED

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

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

Example 1.

20mm Mild Steel bar to be parted off.

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

Example 2.

20mm Aluminium bar to be parted off.

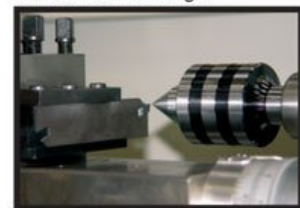
$$RPM = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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

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Specific Features



Shown Setup with Optional Blade and Tip

Recommended Accessories

L4693
Parting Blade



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



L072
HSS Turning Tool Set - 4 piece



L0085
Carbide Turning Tool Set - 11 piece



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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



L459

Lathe Threading Tool Kit - Insert
 Type



L006A

Boring Bar Set - HSS



Product Brochure For L029B

L431

Boring Bar Set - Carbide Insert



L430

Boring Bar Set - Carbide Insert

