

Product Brochure For L464

Professional Lathe Parting Tool Kit - Insert Type

12mm Tool Height

Ex GST
\$180.00

Inc GST
\$198.00



ORDER CODE:	L464
Type:	Professional
Tool Centre Height (mm):	12
Blade Size (mm):	26 x 2
Insert Width (mm):	2
Nett Weight (kg):	1.0



Description

Professional kit for the toolroom and workshop application
 Kit consists of a block, blade & Kennametal inserts.

Features

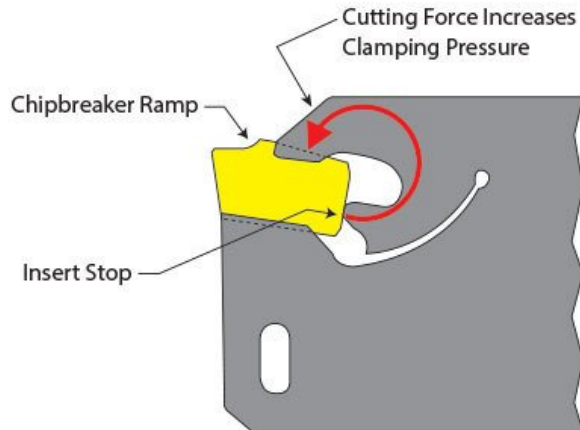
- Blades have top and bottom V-prism design enabling greater clamping force preventing insert movement, even when cutting at high feed rates

Includes

- 1 x 12mm Parting block suits 26mm blade height
- 1 x 26 x 2mm Parting blade
- 2 x 2.2mm Parting inserts
- 1 x Key insert remover
- 1 x Hex key

Insert Stop Design

- Clamping pressure is increased when cutting forces increase providing secure holding power.
- The fixed insert stop provides solid seating with every index and provides up to 30% longer life.



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.

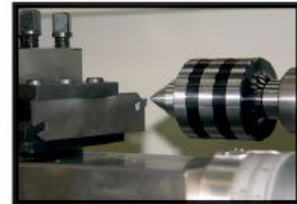
$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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

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Specific Features



Front View

Front Rear View

Rear View

Bottom View



Tip Close Up

Recommended Accessories

L027
 Parting Block - Suits 26mm
 Blade

L468
 Parting Blade

L0512
 KENAMETAL Carbide Inserts -
 Parting

L465
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 Kit - Insert Type



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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



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



Product Brochure For L464

L457

Lathe Threading Tool Kit - Insert Type



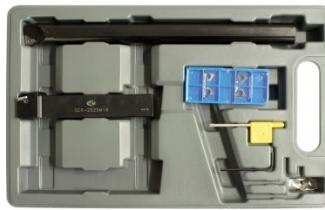
L458

Lathe Threading Tool Kit - Insert Type



L459

Lathe Threading Tool Kit - Insert Type



L006A

Boring Bar Set - HSS



L431

Boring Bar Set - Carbide Insert



L430

Boring Bar Set - Carbide Insert

