

Product Brochure For L027

Parting Block - Suits 26mm Blade

12mm Tool Height

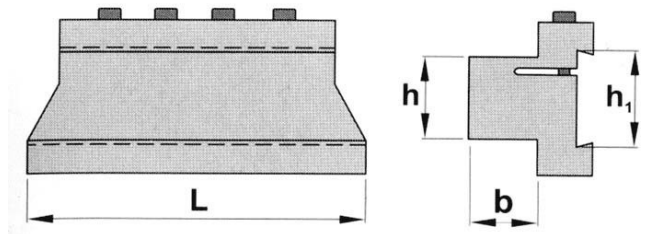


**On Sale**

Ex GST  
~~\$92.00~~  
**\$73.91**

Inc GST  
~~\$105.80~~  
**\$85.00**

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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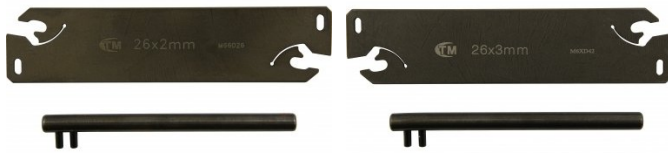
**Recommended Accessories**

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



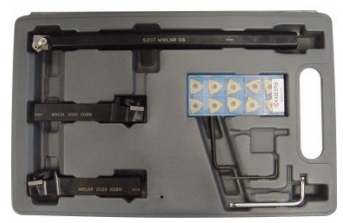
**L450**  
Lathe Turning Tool Kit - 3 piece Insert Type



**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

