Auckland: (09) 2717 234
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Product Brochure For L030

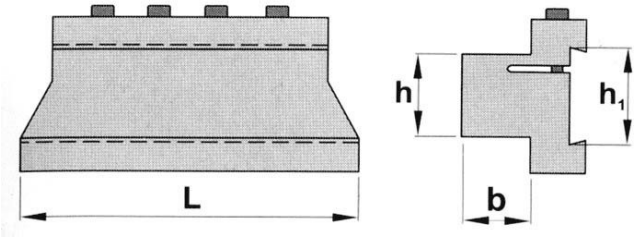
Parting Block - Suits 32mm Blade

25mm Tool Height

Ex GST	Inc GST
$122.00	$140.30

ORDER CODE:	L030
Blade Size (h1) (mm):	32 x 3
h (mm):	25
b (mm):	20
L (mm):	100
Nett Weight (kg):	1.0





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.

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

Example 2.
20mm Aluminium bar to be parted off.

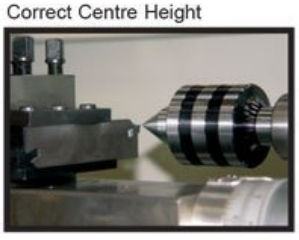
$$RPM = \frac{1000 \times 100}{3.14 \times 20mm} = \frac{100000}{62.8} = 1592rpm$$

- 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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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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Product Brochure For L030

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



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Product Brochure For L030

L431
Boring Bar Set - Carbide Insert



L430
Boring Bar Set - Carbide Insert

