

Product Brochure For L461

Lathe Parting Tool Kit - Insert Type

16mm Tool Height

ORDER CODE:	L461
Type:	Workshop
Tool Centre Height (mm):	16
Blade Size (mm):	26 x 2
Insert Width (mm):	2
Nett Weight (kg):	1.0



Description

Kit consists of a block, blade & inserts.

TECHNICAL INFORMATION

SETTING THE SPINDLE SPEED

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

$$\text{RPM} = \frac{1000 \times \text{Surface speed in Metres per Minute}}{3.14 \times \text{Diameter in millimetres}}$$

Example 1.

20mm Mild Steel bar to be rough machined

$$\text{RPM} = \frac{1000 \times 50}{3.14 \times 20\text{mm}} = \frac{50000}{62.8} = 796\text{rpm}$$

Example 2.

20mm Mild Steel bar to be finished machined

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

- Set the spindle speed to the closest speed to the RPM 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 packing the tool until the tool is on centre.

Correct centre height



Approximate surface speeds for carbide tools

Material	Metres per min	
	Roughing	Finishing
Mild Steel	50	80
Cast Iron	40	60
Aluminium	80	100
Stainless Steel	40	50

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Recommended Accessories

L028

Parting Block - Suits 26mm
Blade



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



L0055

Lathe Turning Tool Kit - 5 piece
Insert Type



Product Brochure For L461

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



L431

Boring Bar Set - Carbide Insert



Product Brochure For L461

L430

Boring Bar Set - Carbide Insert

