Auckland: (09) 2717 234
Christchurch: (03) 741 6241

sales@machineryhouse.co.nz
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Product Brochure For L469

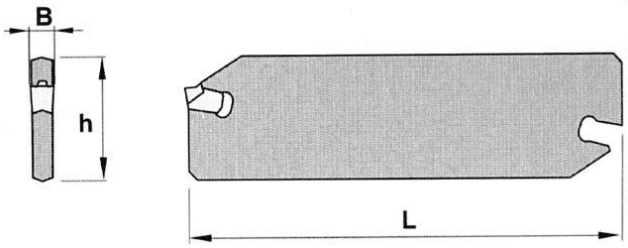
Parting Blade

26 x 3mm

Ex GST	Inc GST
$116.00	$133.40

ORDER CODE:	L469
ISO Catalog ID:	~
(H) Blade Height (mm):	26
(W) Insert Width (mm):	~
(H1) Cutting Height (mm):	~
(L1) Blade Length (mm):	110
(B) Blade Width (mm):	3





Made in Taiwan

Description

To suit Kennametal inserts

Uses insert L0513

Features

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

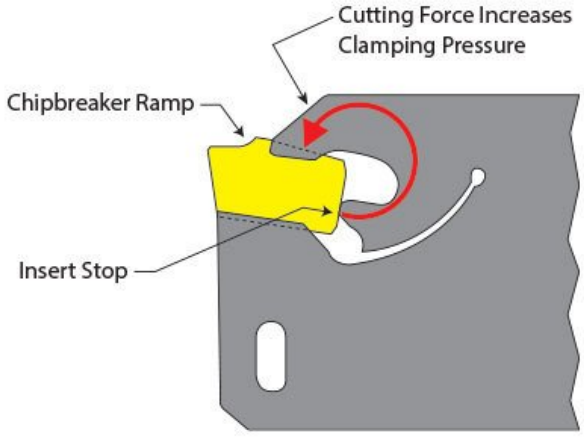
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Insert Stop Design

- 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.

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

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.

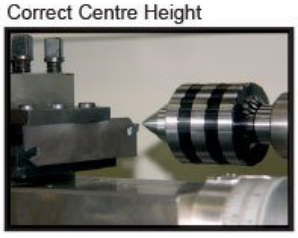
$$RPM = \frac{1000 \times 100}{3.14 \times 20mm} = \frac{100000}{62.8} = 1592rpm$$

- 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

L0513
KENNAMETAL Carbide Inserts - Parting



L0511
KENNAMETAL Grooving Insert EVO Generation



L027
Parting Block - Suits 26mm Blade



L028
Parting Block - Suits 26mm Blade



L029
Parting Block - Suits 26mm Blade



L466
Professional Lathe Parting Tool Kit - Insert Type

