

Product Brochure For L4693

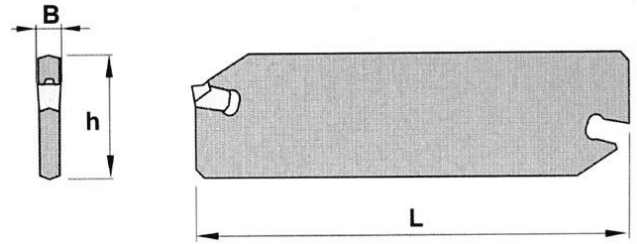
Parting Blade

32 x 3mm

Ex GST
\$122.00

Inc GST
\$140.30

| | |
|-------------------|-------|
| ORDER CODE: | L4693 |
| H: | 32mm |
| B: | 3mm |
| L: | 150mm |
| Nett Weight (kg): | 0.7 |



Description

To suit Kennametal inserts

Uses insert L0513

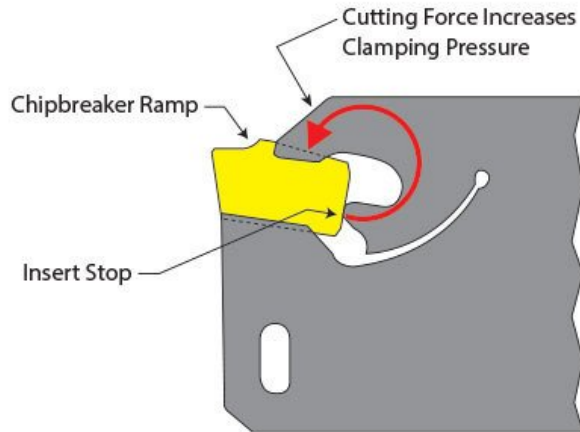
Features

- 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.

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

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.

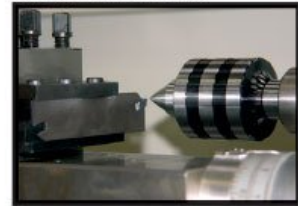
$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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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Recommended Accessories

L0513

KENNAMETAL Carbide Inserts -
Parting



L029B

Parting Block - Suits 32mm
Blade



L030

Parting Block - Suits 32mm
Blade



L467

Professional Lathe Parting Tool
Kit - Insert Type

