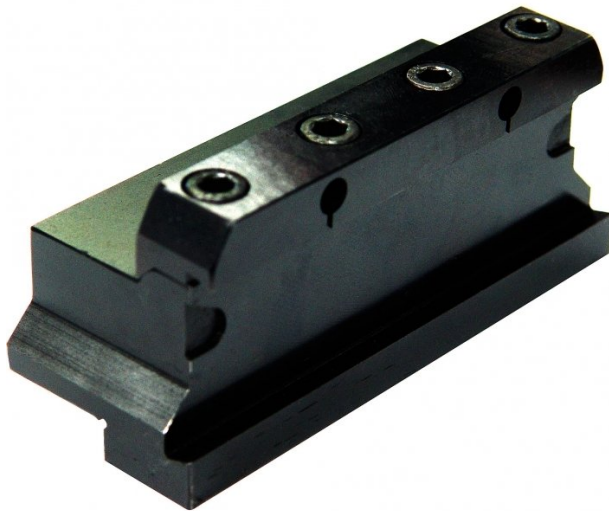


Product Brochure For L029B

Parting Block - Suits 32mm Blade

20mm Tool Height



**On Sale**

Ex GST

~~\$90.00~~

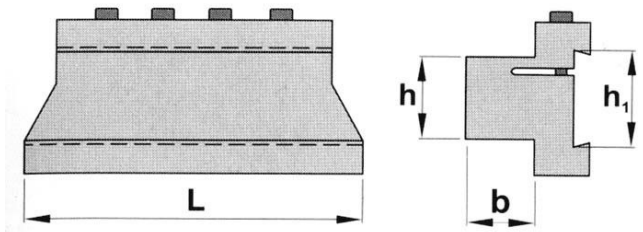
**\$76.36**

Inc GST

~~\$99.00~~

**\$84.00**

ORDER CODE:	L029B
Blade Size (h1) (mm):	32 x 3
h (mm):	20
b (mm):	20
L (mm):	87
Nett Weight (kg):	0.8



**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.

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

**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

Product Brochure For L029B

Specific Features



Shown Setup with Optional Blade and Tip

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



Product Brochure For L029B

**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



Product Brochure For L029B

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L431

Boring Bar Set - Carbide Insert



L430

Boring Bar Set - Carbide Insert

