

Product Brochure For L030

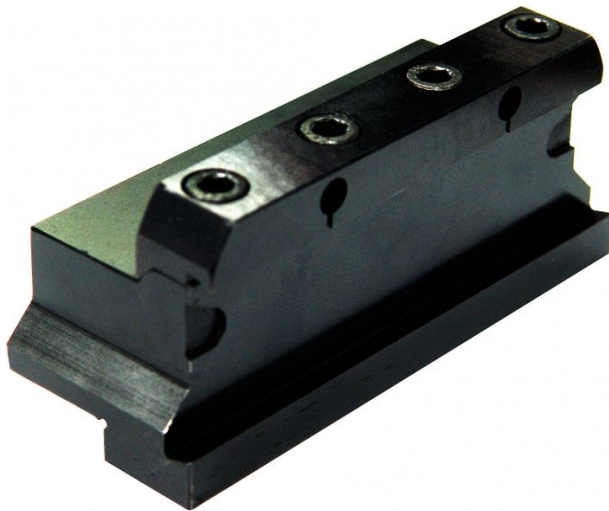
Parting Block - Suits 32mm Blade

25mm Tool Height

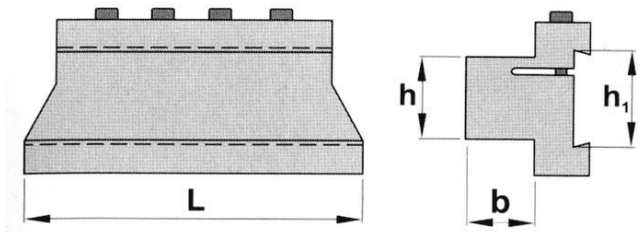
On Sale

Ex GST
\$100.00
\$84.55

Inc GST
\$110.00
\$93.00



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.

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

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

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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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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L431

Boring Bar Set - Carbide Insert



L430

Boring Bar Set - Carbide Insert

