

Product Brochure For L466

## Professional Lathe Parting Tool Kit - Insert Type

20mm Tool Height

**On Sale**

Ex GST

~~\$180.00~~

**\$153.64**

Inc GST

~~\$198.00~~

**\$169.00**



ORDER CODE:	L466
Type:	Professional
Tool Centre Height (mm):	20
Blade Size (mm):	26 x 3
Insert Width (mm):	3
Nett Weight (kg):	1.0



### Description

Professional kit for the toolroom and workshop application  
 Kit consists of a block, blade & Kennametal inserts.

### Features

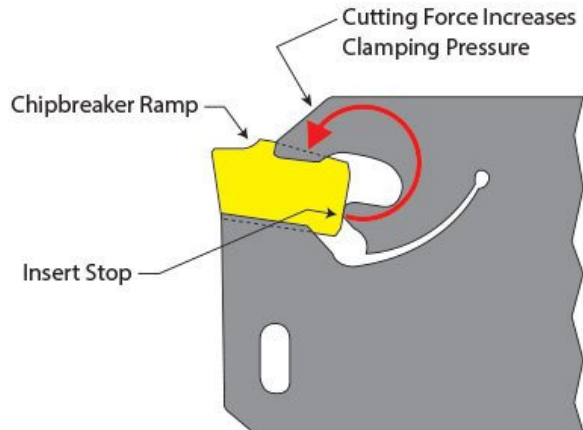
- Blades have top and bottom V-prism design enabling greater clamping force preventing insert movement, even when cutting at high feed rates

### Includes

- 1 x 20mm Parting block suits 26mm blade height
- 1 x 26 x 3mm Parting blade
- 2 x 3mm Parting inserts
- 1 x Key insert remover
- 1 x Hex key

### 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.

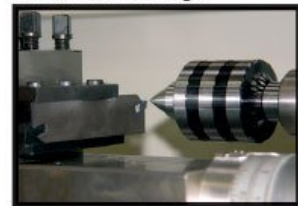
$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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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**Specific Features**



Front View

Front Rear View

Rear View

Bottom View



Tip Close Up

**Recommended Accessories**

**L029**  
 Parting Block - Suits 26mm  
 Blade

**L469**  
 Parting Blade

**L0513**  
 KENNAMETAL Carbide Inserts -  
 Parting

**L464**  
 Professional Lathe Parting Tool  
 Kit - Insert Type



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**L465**  
 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



**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



Product Brochure For L466

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



L430

Boring Bar Set - Carbide Insert

