

L027 - Parting Block - Suits 26mm Blade

12mm Tool Height

Ex GST
\$85.00

Inc GST
\$93.50



ORDER CODE:	L027
Blade Size (h1) (mm):	26 x 2 or 26 x 3
h (mm):	12
b (mm):	16
L (mm):	87
Nett Weight (kg):	0.7



Description

NOTE: Blades and Inserts not included:

Optional Accessories

- Blade - 26 x 2mm (L468) & Inserts (L0512)
- Blade - 26 x 3mm (L469) & 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

Specific Features



Shown Setup with Optional Blade and Tip

Product Brochure For L027

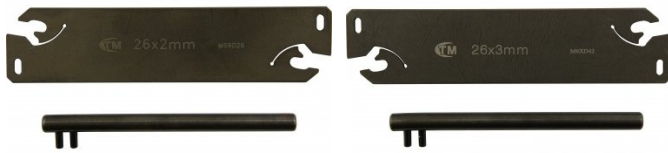
Recommended Accessories

L468
 Parting Blade

L469
 Parting Blade

L0512
 KENNAMETAL Carbide Inserts -
 Parting

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



Product Brochure For L027

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



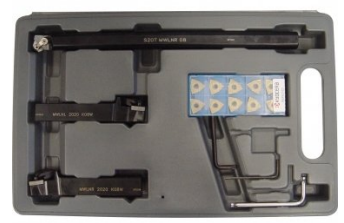
L450
Lathe Turning Tool Kit - 3 piece
Insert Type



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



L457
Lathe Threading Tool Kit - Insert
Type



L458
Lathe Threading Tool Kit - Insert
Type



Product Brochure For L027

L459

Lathe Threading Tool Kit - Insert
Type

L006A

Boring Bar Set - HSS

L431

Boring Bar Set - Carbide Insert

L430

Boring Bar Set - Carbide Insert

