

L030 - Parting Block - Suits 32mm Blade

25mm Tool Height

Ex GST
\$120.00

Inc GST
\$132.00



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

Recommended Accessories

L4693
 Parting Blade



L0513
 KENAMETAL 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 L030

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 L030

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www.machineryhouse.com.au

L431

Boring Bar Set - Carbide Insert

L430

Boring Bar Set - Carbide Insert

