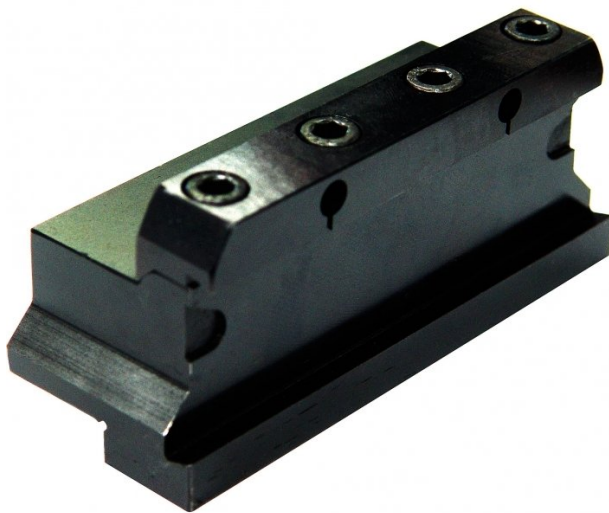


## Product Brochure For L029B

### Parting Block - Suits 32mm Blade

20mm Tool Height

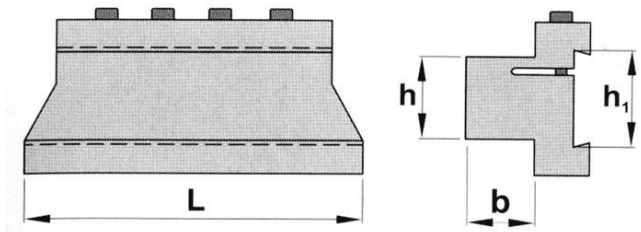


**On Sale**

Ex GST  
**\$110.00**  
**\$87.83**

Inc GST  
**\$126.50**  
**\$101.00**

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.

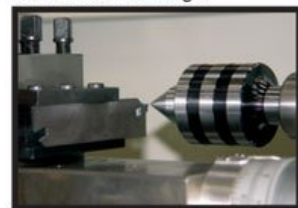
$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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



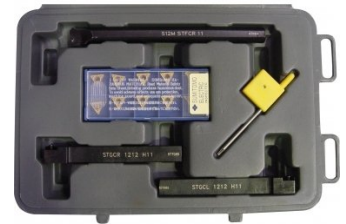
L0077

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



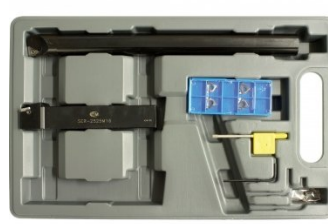
L458

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

