

## Product Brochure For L469

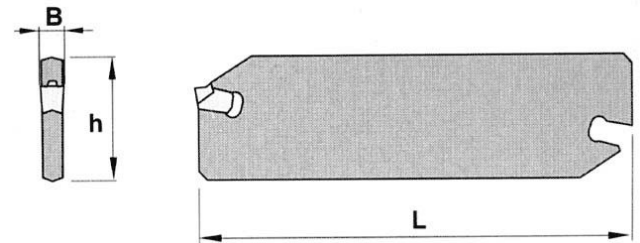
### Parting Blade

26 x 3mm

**On Sale**

Ex GST	Inc GST
<b>\$110.00</b>	<b>\$126.50</b>
<b>\$87.83</b>	<b>\$101.00</b>

ORDER CODE:	L469
H:	26mm
B:	3mm
L:	110mm
Nett Weight (kg):	0.7



#### Description

To suit Kennametal inserts

Uses insert L0513

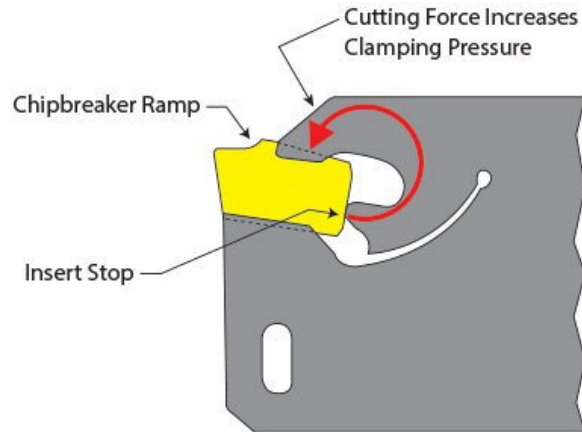
#### Features

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

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### 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.

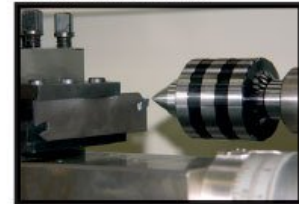
$$\text{RPM} = \frac{1000 \times 100}{3.14 \times 20\text{mm}} = \frac{100000}{62.8} = 1592\text{rpm}$$

- 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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**Recommended Accessories**

L0513

KENNAMETAL Carbide Inserts - Parting



L027

Parting Block - Suits 26mm Blade



L028

Parting Block - Suits 26mm Blade



L029

Parting Block - Suits 26mm Blade



L466

Professional Lathe Parting Tool Kit - Insert Type

