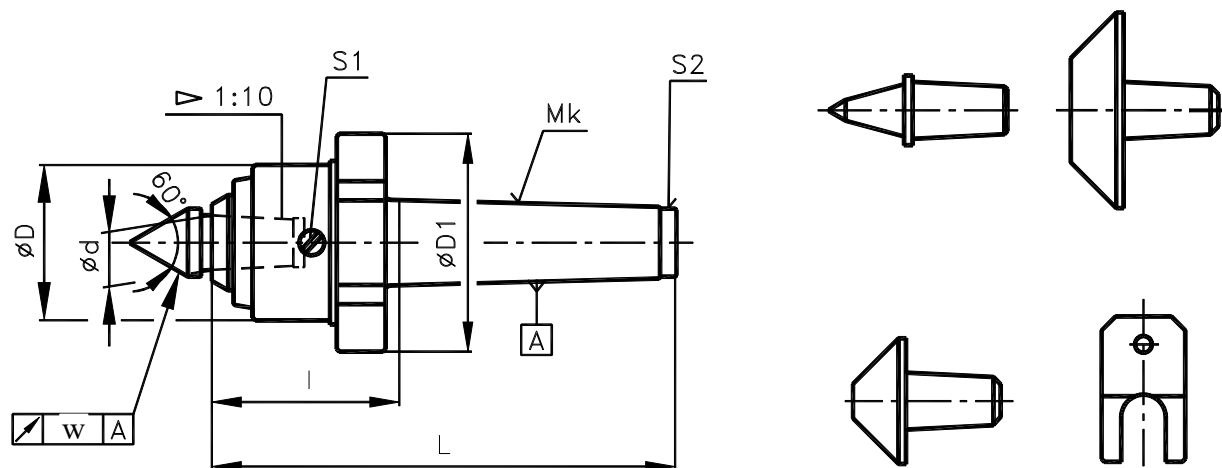


LIVE CENTERS FOR NC MACHINES

24 3314

with interchangeable inserts and forcing-off nut



Live centres are determined for the clamping of workpiece on NC and CNC lathes. Clamping part allows easy access of the tool to the workpiece, it is useful by the machining shaped piece. Design of live center allows to adjust the clearance in radial bearing in front of part of live center. Live centres have Morse cone according to ČSN 2204208 (DIN 228, ISO296) without the clamping thread.

The exchangeable inserts allow universal use in various piece production. It is possible to clamp workpiece in 60° centre, the tube by inside diameter etc according to using exchangeable insert. Turning part is ended by the cone hollow to which it is possible to put in various clamping inserts. Inserts must be pushed in the hollow by the clamping force (tailstock). The clamping insert is taken out by the ejector fork. Live center is provided with the forcing-off nut for the easy removing of the live center from the machine spindle except of using of the exchangeable inserts. Protection of bearing from the ingress of coolant, dirt or swarf is provided by the built-in ring gasket which also prevent loss of lubricant. Due to this fact the working live is prolonged.

The live center is lubricated by lithium lubricant grease Mogul LV2-WR. It is recommended to lubricate live centers if they are used in extreme conditions at intervals 300 working hours in the quantity lubricant max. 1g through the hole in head case (blinded by S1 screw) and in the quantity of max. 0.5g through the hole at the end of the cone shank (blinded by S2 screw). The disassembly of live center is not recommended.

Mk	Ø D	Ø D1	Ø d	L	l	n	Q	m	w
3	52	75	15	143	63	5 000	400	1.65	0.01
4	55	80	20	171	69	4 000	1 300	3.05	
5	69.5	95	25	213	84	3 500	2 000	6.10	

Dimensions in mm

Legend:

Mk ... MORSE cone

n ... max. speed [1/min]

Q ... max. weight of workpiece [kg]

m ... weight [kg]

w ... max. radial run-out [mm]