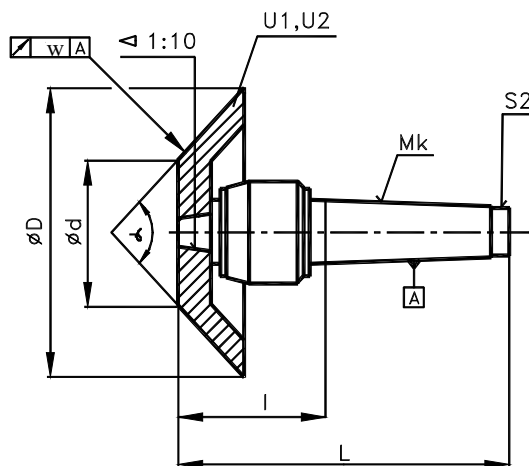


**LIVE CENTERS**
**24 3319 M**

for clamping hollow workpiece with apex angle 60°, 90°



Live centres are determined for the lathe-turning for quick and simple clamping hollow workpieces with big diameter which cannot be clamped by common live center. End of revolving part is cone 1:10 for setting clamping inserts with apex angle 60°(U1) or 90°(U2). Insert is fixed to the turning part by the clamping force (tailstock). The disassembly of the insert is carried – out by knocking in front of live center's shaft (to hold in hand is the best). The live centres delivered are lubricated with lithium – type lubricating grease of Mogul LV2-WR Grade. 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.

Commonly we supply live center with one set of exchangeable clamping inserts according to Mk size.

Specially we supply live center with inserts according to customer request with max. Diameter D based on the table below.

Specially we supply undisassemble live center – clamping inserts cannot be disassembled.

Single inserts are supplied also as spare parts (only for standard and disassemble design).

Mk	$\alpha$	$\varnothing d$	$\varnothing D$	L	l	n	Q	m	Mv	w
3	60	35	80	162	81	5 000	400	2.1	0.63	0.025
	90	32							0.61	
4	60	44	115	194	92	4 000	1 300	4.4	1.56	
	90	47							1.40	
5	60	46	135	240	116	3 500	2 000	8.0	2.76	
	90	45							2.13	
6	60	64	170	316	136	2 500	4 000	23.5	5.15	
	90	70							3.85	
	90	96							230	

Dimensions in mm.

Legend:

Mk ... MORSE taper

n ... max. speed [r.p.m.]

Q ... max. weight of workpiece [kg] at 50 r.p.m. and life Lh = 500 operationg hours

m ... weight of the product

Mv ... weigh of insert [kg]

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