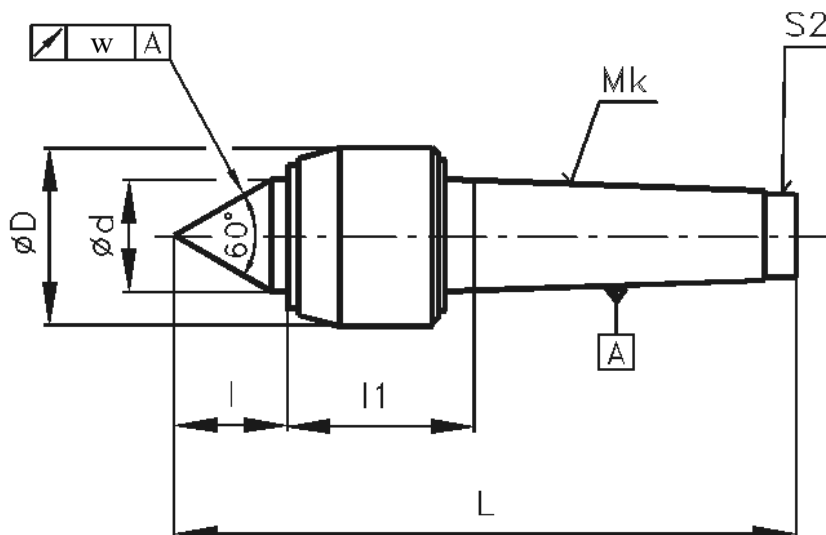


LIVE CENTRES
24 3324 M

with 60° apex angle



Live centers are determined for workpiece chucking in lathes or to work in grinding machines, especially by the grinding workpiece higher weight. The construction of live centers features with small diameter head of tip, allow easy access tool to the workpiece. Live centers with cone Mk 2 ÷ 6 is possible adjusting clearance in front of radial bearing. Live center Mk1 is dedicated for chucking lightweight workpiece. Live centers have shank with cone MORSE according to ČSN 22 0420 (DIN 228, ISO 296) without clamping thread.

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 d	L	l	l1	n	Q	m	w
1	34	17	114	19	41	6 000	-	0.25	0.007
2	36	20	125	17	41		340	0.34	
3	47	28	162	29	53	5 000	400	0.8	
4	55	35	194	35	56,5	4 000	1 300	1.37	
5	70	45	240	43	67	3 500	2 000	3.03	
6	90	60	318	59	79	2 500	4 000	7.18	

Dimensions in mm.

Legend:

Mk ... MORSE cone

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

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

m ... weight of product [kg]

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