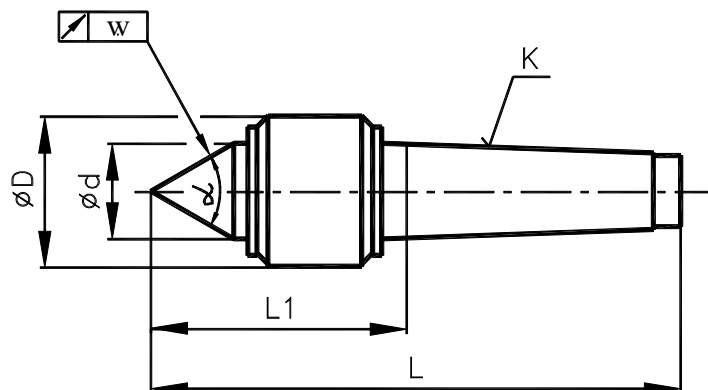


LIVE CENTERS

for heavy clamping with apex angle 60° and 90°

24 3325



Live centers are for clamping heavy workpiece in lathe. Rigid structure and placing revolving part is characterized long working life. Oil OL-J5 is inside bearing.

Live centers with accuracy EXTRA is used on grinding machine.

Live centers are for chucking heavy workpiece in lathe. Rigid structure and placing revolving part is characterized long working life.

The advantage is the possibility to adjust clearance in front radial bearing. Oil OL-J5 is inside the bearing.

Live centers with accuracy EXTRA is used on grinding machine. Live centers are supplied with apex angle 60° due to reduction machine deformation (tailstock, lathe bed, headstock) which accrue from axial clamping forces. It is profitable for machine which works in area allowable maximum.

The centers have conical shank MORSE 4-7 according to CSN 22 0420 or metric shank according to CSN 22 0410. Shanks correspond to DIN 228 and ISO 296 (without thread for clamping screw). The disassembly of live center is not recommended.

K	Ø D	Ø d	α	L1	L	P	w	Q	n	m
MORSE 4	80	40	60	105	207	N	0.04	1 500	3 200	4.1
						E	0.01			
			90	90	192	N	0.04			
						E	0.01			
MORSE 5	90	48	60	119	247	N	0.04	2 500	2 700	6.2
						E	0.01			
			90	109	237	N	0.04			
						E	0.01			
MORSE 6	125	55	60	163	340	N	0.04	5 000	1 900	12.4
						E	0.01			
			90	153	330	N	0.04			
						E	0.01			
MORSE 7	145	65	60	198	455	N	0.05	8 000	1 600	21.5
						E	0.01			
			90	188	445	N	0.05			
						E	0.01			

K	Ø D	Ø d	α	L1	L	P	V	Q	U	G
METR. 80	145	65	60	198	390	N	0.05	8 000	1 600	20.4
						E	0.01			
			90	188	380	N	0.05			
						E	0.01			
METR. 100	175	75	60	230	457	N	0.05	12 000	1 300	35.4
						E	0.01			
			90	220	447	N	0.05			
						E	0.01			
METR. 120	210	95	90	263	525	N	0.06	20 000	900	62.5
						E	0.01			

Dimensions in mm.

Legend:

K ... shank taper

P ... precision mark in product marking

E ... extra precise version

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

m ... weight [kg]

α ... apex angle [°]

N ... normal version

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

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

i ... number of pieces in set