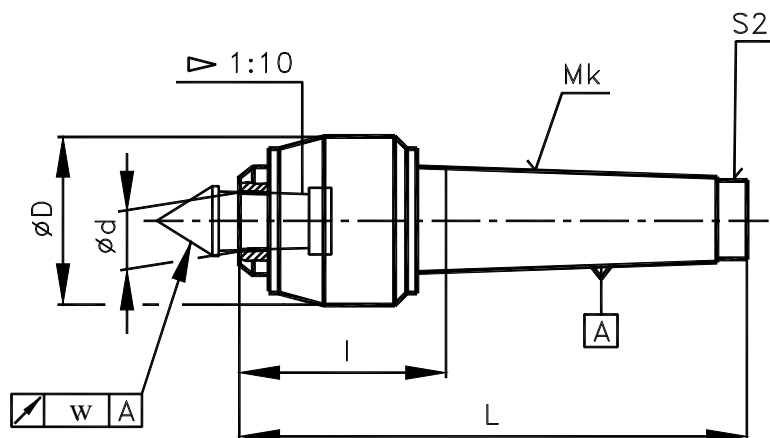


LIVE CENTERS
24 3326 M

with interchangeable inserts



The live centers with interchangeable inserts are for working on lathes. Their design allows universal use in the piece production. Clamping of workpiece depends on using interchangeable insert. End of revolving part is ended by cone hollow for clamping inserts „a-g“. Insert is fixed to the turning part by the clamping force (tailstock). The clamping insert is taken out by the ejector fork (h). Morse cone CSN 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. It is supplied with one set of interchangeable inserts (a-g) and ejector fork (h). Special supply is with set of interchangeable inserts according to customer wish. Spare parts are individual interchangeable inserts.

Mk	Ø D	Ø d	L	l	n	Q	m	w
2	36	10	110	45.5	6 000	340	0.75	0.012
3	47	15	145	62	5 000	400	1.52	
4	55	20	171	69	4 000	1 300	2.88	
5	70	25	213	84	3 500	2 000	5.75	
6	90	30	283,5	103	2 500	4 000	13.85	

Dimensions in mm.

Legend:

Mk ... MORSE taper

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

 Q ... max. weight of workpiece at 50 r.p.m. and service life L_h = 500 working hours [kg]

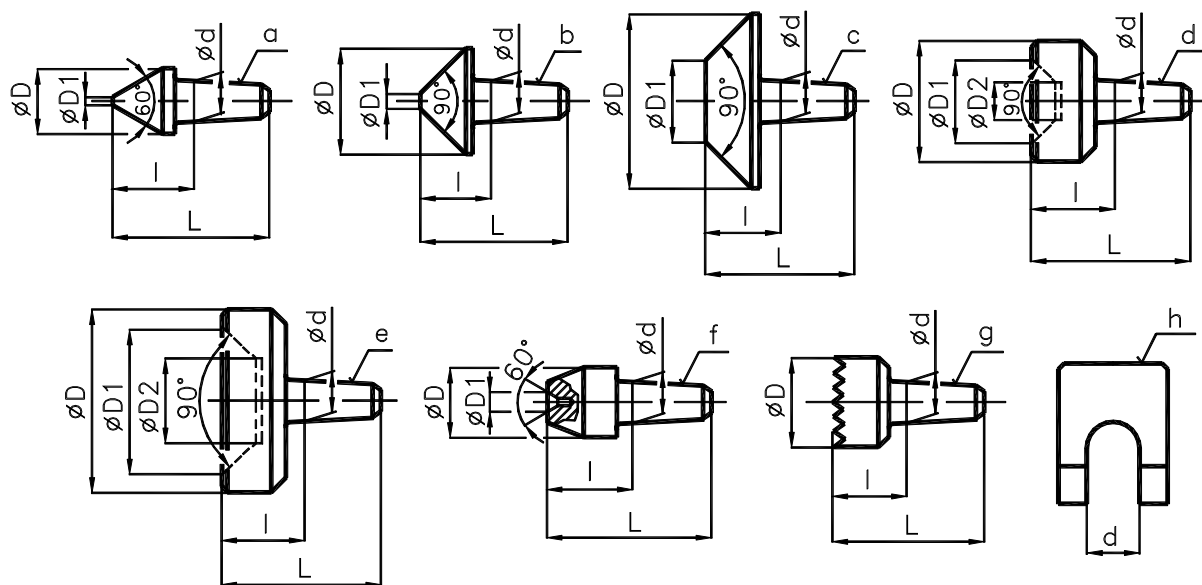
m ... weight [kg]

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

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Spare Parts



a)

Mk	Ø D	Ø D1	Ø d	L	l	i	m
2	15	0.5	10	40	21	1	0.02
3	20		15	51	26		0.05
4	25		20	60,5	30,5		0.11
5	32	1	25	74	37		0.20
6	36		30	90	44		0.34

b)

Mk	Ø D	Ø D1	Ø d	L	l	i	m
2	28	4	10	36	17	1	0.042
3	36	6	15	45	20		0.065
4	45	10	20	53	23		0.135
5	56	14	25	65	27		0.27
6	70	20	30	80	34		0.72

c)

Mk	Ø D	Ø D1	Ø d	L	l	i	m
2	44	20	10	36	17	1	0.067
3	63	33	15	45	20		0.22
4	70	35	20	53	23		0.43
5	80	38	25	65	27		0.47
6	100	50	30	80	34		1.55

LIVE CENTERS
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d)

Mk	∅ D	∅ D1	∅ D2	∅ d	L	l	i	m
2	28	19	5	10	36	17	1	0.061
3	36	28	12	15	45	20		0.13
4	45	37	17	20	53	23		0.23
5	56	44	20	25	65	27		0.42
6	70	58	24	30	80	34		0.92

e)

Mk	∅ D	∅ D1	∅ D2	∅ d	L	l	i	m
2	38	28	14	10	36	17	1	0.11
3	45	38	22	15	45	20		0.2
4	63	53	30	20	53	23		0.41
5	70	60	36	25	65	27		0.66
6	100	88	54	30	80	34		1.35

f)

Mk	∅ D	∅ D1	∅ d	L	l	i	m
2	15	2.5	10	36	17	1	0.03
3	20		15	45	20		0.06
4	25	5	20	53	23		0.123
5	32		25	65	27		0.23
6	36	8	30	80	34		0.38

g)

Mk	∅ D	∅ d	L	l	i	m
2	22	10	36	17	1	0.055
3	25	15	45	20		0.13
4	32	20	53	23		0.18
5	45	25	65	27		0.34
6	56	30	80	34		0.50

h)

Mk	d	i	m
2	11	1	0.018
3	16		0.02
4	22		0.03
5	27		0.06
6	32		0.16

Dimensions in mm.

Legend:

Mk ... MORSE taper

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

 Q ... max. weight of workpiece at 50r.p.m. and service life L_h = 500 working hours [kg]

m ... weight of product [kg]

w ... max. roundness deviation

i ... number of pieces in a cassette