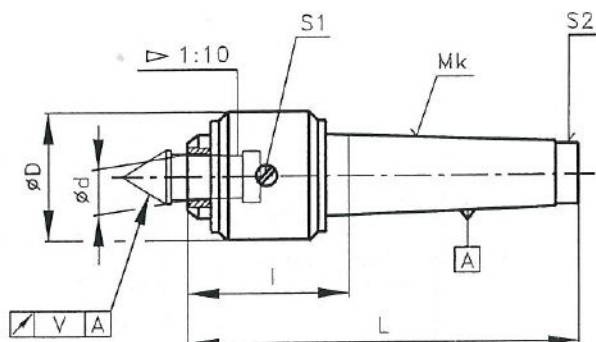


LIVE CENTRES

ČSN 24 3326

With Interchangeable Points



The centres with interchangeable points are intended for work on lathes. Their design allows for universal use in various on-off production programmes. According to the interchangeable points it is possible to clamp workpieces in 60° work centre, workpieces with 60° centre, parts without drilled pit by the surface, tubes by the inside diameter, etc. The live part of the centre is ended by the taper bore into which various points of (a-g) shapes can be put as required. The points must be pressed into the bore by the clamping force (tailstock). The points are taken out by means of the drift plug (h). The live centre is provided with the shank with MORSE taper according to ČSN 220420 (DIN 228, ISO 296) without a clamping thread.

The live centres lubricated by LV-2-3 lithium lubricating grease, are available. The additional lubricating of centres used in extreme condition in the interval of 300 working hours in the quantity of max. 1g through the hole in the bush head (blinded by S1 screw) and in the quantity of max. 0.5 g through the hole at the end of the taper shank (blinded by S2 screw) is recommended. It is not recommended to disassemble the live centres. In a standard version, each centre is available with 1 set of interchangeable points of (a-g) shapes and 1 drift plug (h). In a special version, the centres are available with the set of points at the option of the customer as well as centres with points shapes at to the option of the customer. The individual points are available as spare parts, too.

Mk	Ø D	Ø d	L	l	U	Q	G	V
2	36	10	110	45.5	6 000	340	0.75	0.01
3	47	15	145	61	5 000	400	1.52	
4	55	20	174	76	4 000	1 300	2.88	
5	70	25	227	103	3 500	2 000	5.75	
6	90	30	305	132.5	2 500	40 000	13.85	

Dimensions in mm.

Legend:

Mk ... MORSE taper

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

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

G ... weight of product [kg]

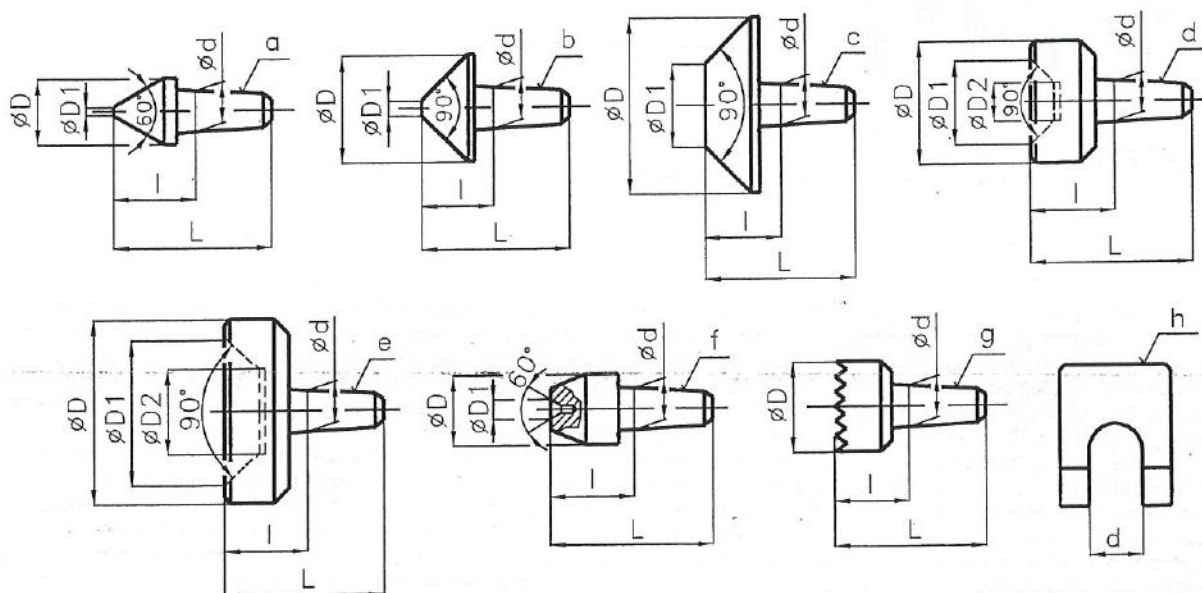
V ... max. roundness deviation

LIVE CENTRES

ČSN 24 3326

With Interchangeable Points

Spare Parts



a)

Mk	$\varnothing D$	$\varnothing D1$	$\varnothing d$	L	l	n	G
2	15	0.5	10	39	20	1	0.02
3	20		15	50	25		0.05
4	25		20	60	30		0.11
5	32	1	25	73	35		0.20
6	36		30	90	44		0.34

b)

Mk	$\varnothing D$	$\varnothing D1$	$\varnothing d$	L	l	n	G
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	18	30	80	34		0.72

c)

Mk	$\varnothing D$	$\varnothing D1$	$\varnothing d$	L	l	n	G
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 CENTRES

ČSN 24 3326

With Interchangeable Points

d)

Mk	∅ D	∅ D1	∅ D2	∅ d	L	l	n	G
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	n	G
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	n	G
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

g)

Mk	∅ D	∅ d	L	l	n	G
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	n	G
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

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

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

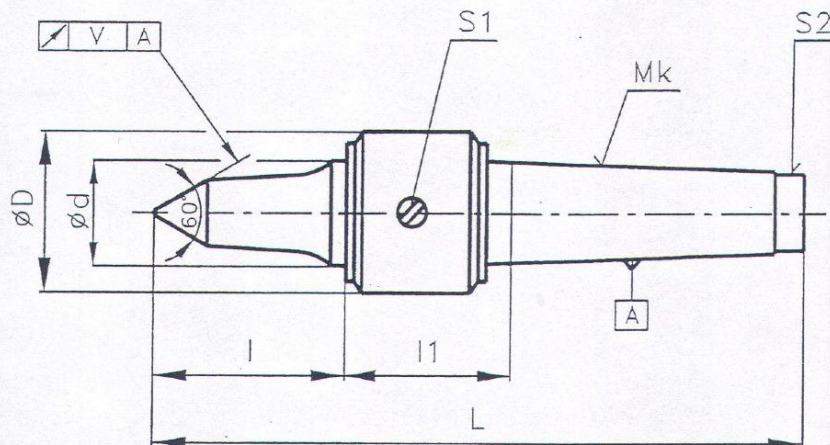
G ... weight of product [kg]

V ... max. roundness deviation

LIVE CENTRES

24 3327

For NC Lathes



The centres are intended for the clamping of workpieces on NC lathes. Their clamping part allows for an easy access of the tool to the workpiece, which is particularly advantageous during machining of form workpieces. The design allows for the adjustability of the clearance in the radial bearing. The live centre is provided with the shank with Morse taper according to CSN 2204208 (DIN 228, ISO296) without the clamping thread.

The live centres applied by LV 2-3 lithium lubricating grease, are available. It is recommended to lubricate, additionally, the centres used in extreme conditions in the interval of 300 working hours in the quantity of max. 1g through the hole in the bushing head (blinded by S1 screw) and in the quantity of max. 0.5 g through the hole at the end of the taper shank (blinded by S2 screw).

Mk	ø D	ø d	L	l	l1	U	Q	G	V
2	36	17	130	31	35	6 000	270	0.39	0.002
3	47	25	169.5	40	49	5 000	320	0.89	
4	55	30	206	50	53	4 000	1 000	1.4	
5	70	40	260	65	63	3 500	1 600	3.2	

Dimensions in mm.

Legend:

Mk ... MORSE taper

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

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

G ... weight of product [kg]

V ... max. roundness deviation

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