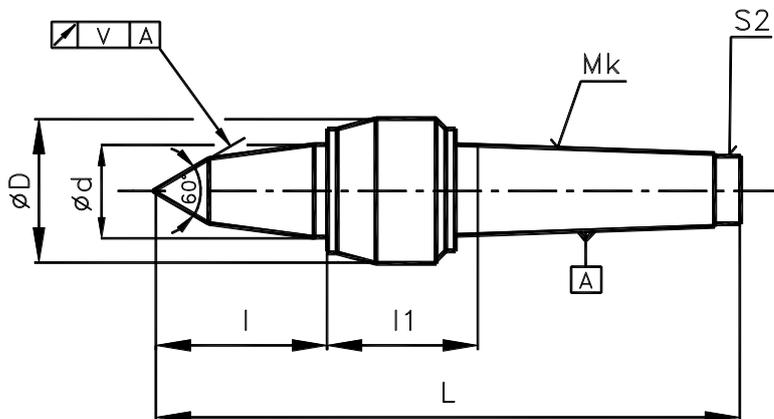


**LIVE CENTRES**

24 3328

Extended, with 60° Point Angle



The centres are intended for work on lathes. Their extended clamping section allows for the access of the tool to workpiece which can be used, to advantage, in the machining by tools with exchangeable cutting tips and in the work on copying lathes. The design of the centre allows for the adjusting of the radial clearance. The centre is provided with the MORSE taper shank ČSN 220420 (DIN 228, ISO296) without the clamping thread. In a special version, also centres of shape and projection of live part of centre at the option of the customer, are available. The live centres are lubricated by LV 2-3 lithium lubricating grease before the dispatching. Centres used in extreme conditions should be additionally lubricated in intervals of 300 working hours by max. 1g of grease through the hole at the taper shank end (blinded by S2 screw). The live centres should not be disassembled.

Mk	$\varnothing D$	$\varnothing d$	L	l	l <sub>1</sub>	U	Q	G	V
2	36	22	128.5	30	35	6 000	270	0.36	0.008
3	47	30	167	37	49	5 000	320	0.84	
4	55	35	207.5	51	53	4 000	1 000	1.45	
5	69.5	45	259	66	63	3 500	1 600	3.2	
6	89	60	341	85	75.5	2 500	3 200	7.75	

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<sub>h</sub> = 500 working hours [kg]

G ... weight of product [kg]

V ... max. roundness deviation