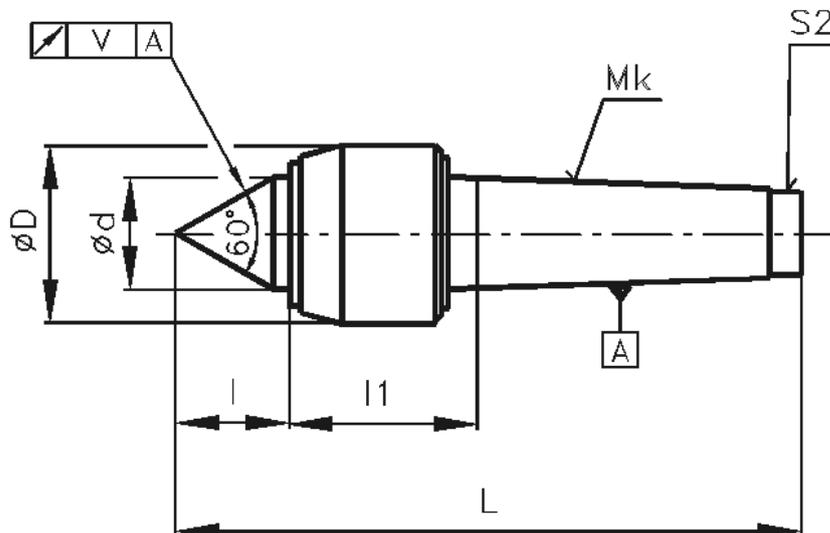


LIVE CENTRES

24 3324

With 60° Point Angle



The centres are intended for the clamping of workpieces on lathes. The version with the run – out tolerance of max. 0.0035 mm are, usually, employed in work on even grinding machines and, above all, in the grinding of heavy workpieces. The design features a small diameter of the center head which allows for an easy access of the tool to workpiece. On centres with MORSE 2 – 6 taper the adjustability of the clearance in the front radial bearing is very advantageous. The MK 1 centre is of a different design and is intended for the clamping of very light workpieces. For the mentioned reason, the admissible load of the concerned centre is not specified. The live centre is provided with the shank with Morse taper according to ČSN 2204208 (DIN 228, ISO296) without the clamping thread. The live centres applied by LV2-3 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
1	34	17	114	21.5	38.5	6 000	-	0.25	0.005
2	36	22	125	25.5	35		340	0.34	
3	47	30	162	32	49	5 000	400	0.8	
4	55	35	194	37.5	53	4 000	1 300	1.37	
5	70	45	240	47	63	3 500	2 000	3.03	
6	90	60	318	62	75.5	2 500	4 000	7.18	

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 Lh = working hours [kg]

G ... weight of product [kg]

V ... max. roundness deviation