

Precision live centers for hollow workpieces clamping with a centering hole angle 60° or 90°

- ✓ Set of 60° and 90° inserts expanding the production portfolio of workpieces.
- ✓ Wide range of special design options according to customer specifications.
- ✓ Special seals prevent the ingress of process liquid and dust particles.



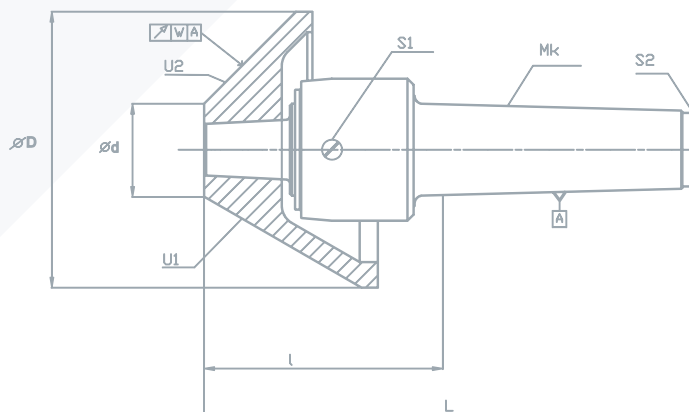
These live centers are designed for turning operations where is necessary the workpieces clamping with cavities of large diameters, which cannot be clamped with live centers of the conventional type.

ČSN 24 3319

The rotating part of the live center is ended with a special taper which enables to fit clamping insert with an angle 60° (U1) or 90° (U2) as needed. In the basic version, the live centers are supplied with one set of replaceable clamping inserts corresponding to the MT size.

In the standard version, the live centers are supplied with inserts as required with a maximum \varnothing of D according to the table. In a special design, non-disassemble live centers are also supplied - the clamping inserts cannot be removed. The special clamping inserts are also supplied as spare parts. The live centers are provided with a MORSE taper shank according to ČSN standard ISO 296.

The live centers are supplied with lithium-based grease Mogul LV2-WR. Disassembly of the live centers - except for authorized service - is not recommended.



Mk	MORSE taper shank
α	head angle ($^\circ$)
n	max. rotation speed (rpm)
Q	max. workpiece weight (kg)
m	product weight (kg)
m_v	insert weight (kg)
w	concentricity accuracy (mm)

Mk	α	$\varnothing d$	$\varnothing D$	L	l	n	Q	m	m_v	w	catalogue no.
3	60	35	80	162	81	5 000	400	2,1	0,63	0,02	21-71193
	90	32							0,61		
4	60	44	115	194	92	4 000	1300	4,4	1,56		21-71194
	90	47							1,4		
5	60	46	135	240	116	3 500	2 000	8,0	2,76		21-71195
	90	45							2,13		
6	60	64	170	316	136	2 500	4 000	23,5	5,15		21-71196
	90	70							3,85		
	90	96							6,73		