



Revolving lathe centre with pressure indicator and extended point, Morse taper: 4



Order data

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| Order number | 321770 4 |
| GTIN | 4019208018720 |
| Item class | 35R |

Description

Version:

- **The adjusting pressure (clamping force) is directly readable on the manometer sight glass in daN.**
- **The live centre, which is supported by a disc-spring pack, has a long spring travel.**
- **Short sturdy design with active longitudinal axis. Live centre through hardened and finish ground.**
- **Maximum accuracy due to precision roller bearings.**
- **With special seal against dirt and coolant ingress, maintenance-free due to lifetime lubrication.**

With extended centre, point angle 60° / 30°.

Description:

Lathe centres are mainly used on lathes to support long and slim workpieces, since with these workpieces there would otherwise be a risk of the workpiece bending or moving around as a result of the forces generated.

The lathe centre is secured with a Morse taper. The workpiece is clamped in the chuck and a counterbore is added using a centre drill. After re-clamping, the lathe centre is then inserted.

Application:

Whenever **the clamping force has to be kept within certain limits**, either to prevent deformation of the component or to ensure secure clamping with sufficient pressure.

- **As a tailstock centre in conjunction with hydro-mechanical face drivers No. 327451 – 327541 because the drive teeth have to dig into the component.**
- **For components that expand significantly due to high machining heat.**
- **For clamping long slender components to prevent lateral displacement.**
- **For clamping heavy components where a controlled clamping force is required.**

Body Ø D: 72 mm

Reach B: 137.5 mm
largest centre point \varnothing 60° A: 14 mm
largest centre point \varnothing 30° A: 32 mm
maximum radial run-out: 0.01 mm
Centre point length C: 52.5 mm

Technical description

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|--|----------------|
| maximum axial clamping force | 900 daN |
| largest centre point \varnothing 30° A | 32 mm |
| Body \varnothing D | 72 mm |
| Morse taper | MT4 |
| Centre point length C | 52.5 mm |
| largest centre point \varnothing 60° A | 14 mm |
| Reach B | 137.5 mm |
| for workpiece weight | 550 kg |
| maximum radial run-out | 0.01 mm |
| Type of product | Centring drill |