



Revolving lathe centre with pressure indicator and extended point, Morse taper: 5



Order data

Order number	321770 5
GTIN	4019208018737
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: 95 mm

Reach B: 177.5 mm
largest centre point \varnothing 60° A: 15 mm
largest centre point \varnothing 30° A: 40 mm
maximum radial run-out: 0.01 mm
Centre point length C: 66 mm

Technical description

maximum radial run-out	0.01 mm
maximum axial clamping force	1500 daN
Morse taper	MK5
largest centre point \varnothing 30° A	40 mm
for workpiece weight	1100 kg
largest centre point \varnothing 60° A	15 mm
Centre point length C	66 mm
Body \varnothing D	95 mm
Reach B	177.5 mm
Type of product	Centring drill