

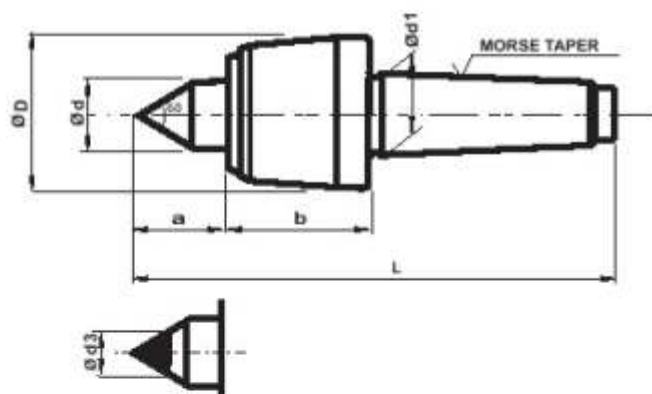
CNC TURNING APPLICATIONS

RPM UPTO 6000

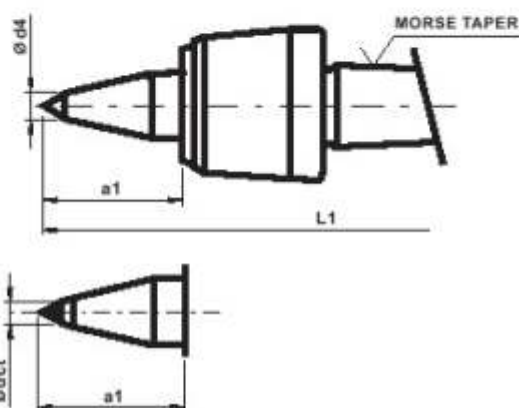
Life Revolving centre have a highly developed design with all the conventional shapes of centres points . The housing is drop forged ,high grade material, thus guaranteeing a uniform structure having a maximum stability and load capacity. The centres are made of high quality tool steel scientifically hardened and can be reground several times. The especially rugged tripple precision roller bearing ensures maximum accuracy and a long operation time. Best quality grease lubrication is maintenance free for permanent top performances. A special sealing arrangement protects from coolant and dirt.

STANDARD CENTRES

(PLAIN / CARBIDE)



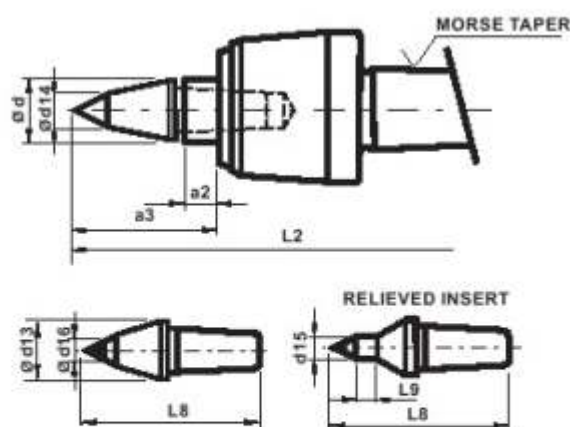
ORDER.NO.	3011	3012	3013	3014	3015
MT.	1	2	3	4	5
a	20	24	30	40	42
b	38	45	53	56	64
d	12	18	23	28	34
d1	12.065	17.78	23.825	31.267	44.399
d3	-	8	11	14	18
D	40	44	61	70	88
L	112	138	169	205	242
R/O	STD	0.01	OPT.	0.005	



EXTENDED CENTRES

(PLAIN / CARBIDE)

ORDER.NO.	3022	3023	3024	3026
a1	32	42	47	58
d4	6	10	10	13
dct	6	8	8	11
L1	146	181	217	258

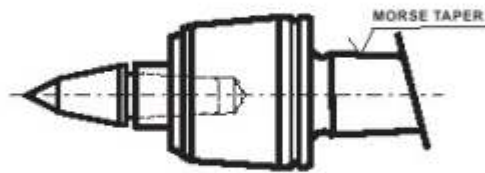


QUICK CHANGE CENTRES

WITH PLAIN, CARBIDE or RELIEVED INSERTS

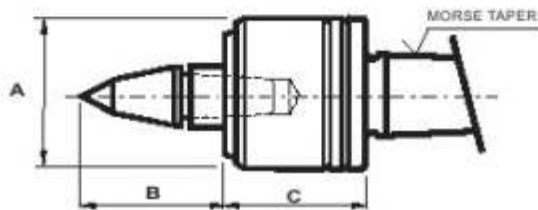
ORDER.NO.	3033	3034	3035
a2	10	7	10
a3	39	49	54
d	23	28	34
d13	18	24	26
d14	10	12	12
d15	10	10	10
d16	6	10	10
L8	60	75	80
L2	156	217	259
L9	10	10	10

Ordering ex :- Mention 'P' for Plain and 'C.T' for carbide centres along with Ord.No. ex. 3022 CT.



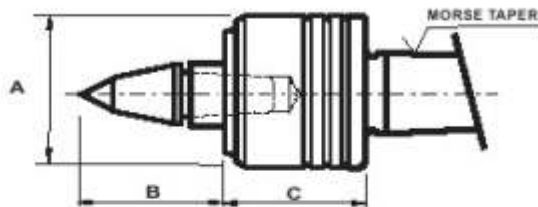
WORK DRIVE CENTRE (DRIVES WORKPIECE WITH TAILSTOCK PRESSURE)

ORDER. NO.	3043	3044	3045
MT.	3	4	5



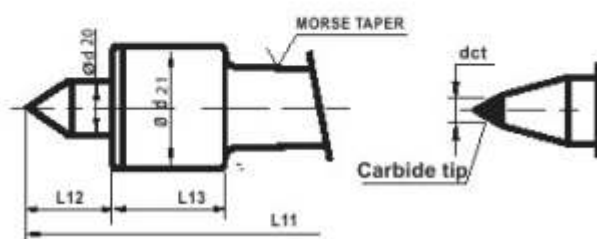
HIGH PERFORMANCE CENTRES (FOUR BEARINGS)

ORDER. NO.	4023	4024	4025	4026
MT.	3	4	5	6
A	60	64	68	145
B	39	49	54	68
C	62	64	64	110



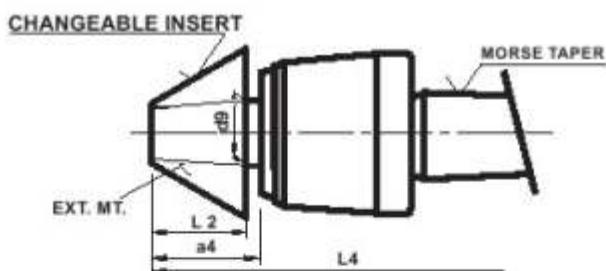
SUPER PERFORMANCE CENTRES (FOUR BEARINGS)

ORDER. NO.	4033	4034	4035	4036
MT.	3	4	5	6
A	60	60	85	110
B	39	49	54	68
C	62	62	72	85



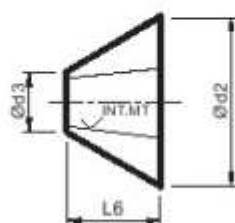
MINI CENTRES (SMALL BODY DIA)

ORDER. NO.	MT	d20	d21	dcl	L13	L12	L11
3063	3	15	36	7	34	25	149
3064	4	20	42	8	44	26	180
3065	5	28	68	10	56	54	246



CENTRES WITH EXTERNAL TAPER

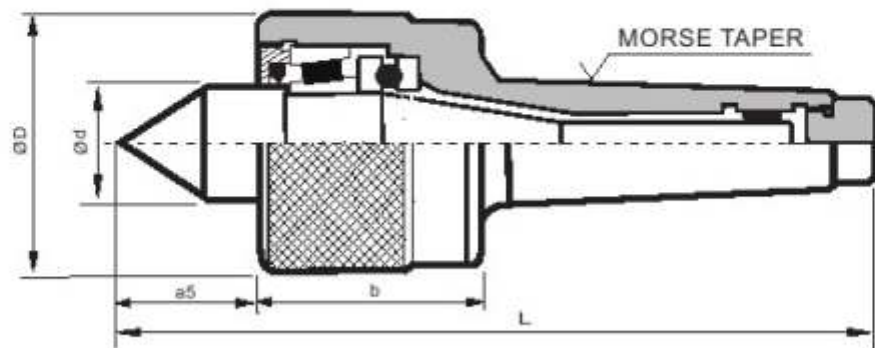
ORDER. NO.	3072	3073	3074	3075
MT.	2	3	4	5
a4	29	36	36	45
l2	25	32	32	40
d9	17.78	23.825	23.825	31.267
L4	143	175	201	245
External MT.	2	3	3	4



PIPE INSERTS (EXT. TAPER CENTRES)

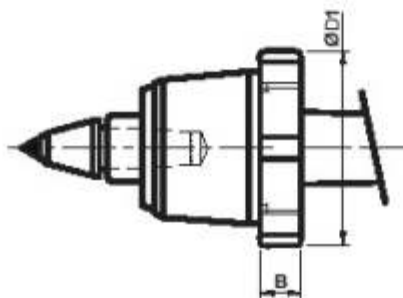
ORDER.NO.	3172	3173	3174	3175
INT. MT	2	3	3	4
d2	50	65	75	95
d3	23	30	40	50
L6	25	32	32	40

HEAVY LOAD CENTRES



HEAVY LOAD, MEDIUM RPM, CENTRES

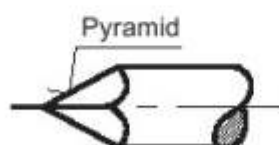
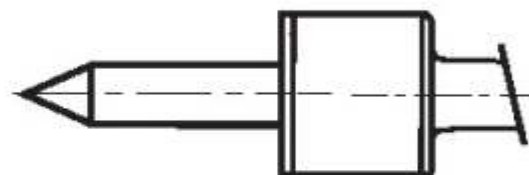
ORDER.NO	3083	3084	3085	3186	3286	3386	3287	3387
MT	3	4	5	6	6	6	7	7
a5	28	36	40	56	100	85	100	85
b	50	55	60	90	135	135	130	135
d	24	28	34	56	85	85	85	85
D	62	69	78	108	150	180	150	180
L	165	200	235	335	420	410	490	480
RATED LOAD AT 100 rpm - kg	3	4	5	6	6	6	7	
AXIAL	850	1200	1900	2100	8000	12000	11000	
RADIAL	600	850	1600	1500	5000	8000	5000	



CENTRES WITH EXTRACTOR NUT

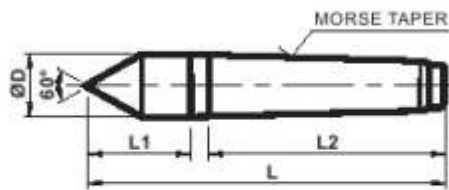
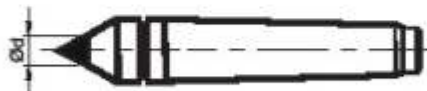
MT.	-	3	4	5
B	-	18	18	18
ØD1	-	75	85	100

Mention 'EX .NUT' along with ordering No. ex. 3022 EX.NUT.



INDUCTION HARDENING REVOLVING CENTRES

Stainless Steel components to avoid corrosion
Pyramid Shaped centre for extra driving force
Carbide or Plain centre options are available

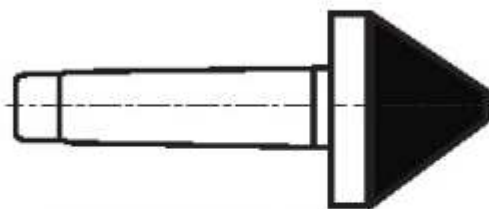
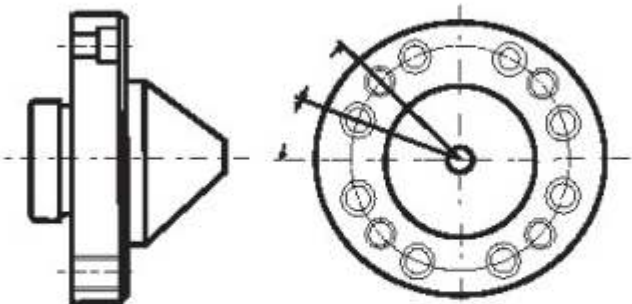

 PLAIN
(DC)

 CARBIDE TIP
(DCC)

 CARBIDE TIP
HALF (DCCH)

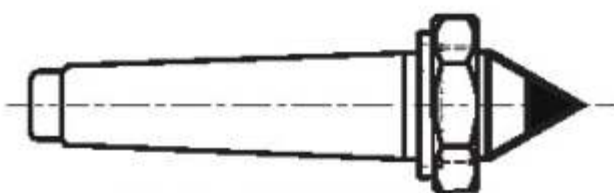
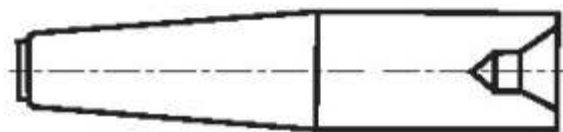
MT.NO.	MT-1	MT-2	MT-3	MT-4	MT-5	MT-6
ORDER.NO.	11	12	13	14	15	16
ØD	12.2	18	24.1	31.6	44.7	63.8
L1	23	31	39	51	64	80
L2	53.5	64	81	102.5	129.5	182
L	80	100	125	160	200	270
Ød	6	8	11	14	18	18
h	1.5	2	3	5	7	10
L3	22	30	38	50	63	79

METRIC TAPER shanks 60,80,100, and 120 are also available
Mention categories DC, DCC or DCCH along with
Ordering No. Ex. DCCH 11

SPECIAL DEAD CENTRES


 LARGE CARBIDE DEAD CENTRES
UP TO DIA 100 MM TIP


FLANGE TYPE CENTRES ex Hobbing M/C


 THREADED DEAD CENTRES
WITH NUT


FEMALE DEAD CENTRES


 CENTRES FOR OIL or COOLANT
THROUGH APPLICATION


QUICK CHANGE PT. DEAD CENTRES

TURRET SLEEVES

(CYLINDRICAL SHANK)

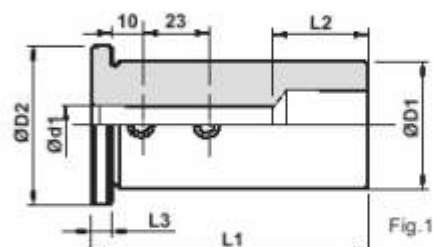


Fig. 1

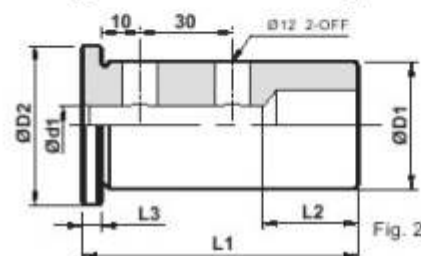


Fig. 2

ORDER.NO.		D1	D2	d1	L1	L2	L3	Figure
CYL40-	8,10,12	40	47	8,10,12	85	45	5	1
	16,20,25,32			16,20,25,32	90	20		2
CYL32-	8,10,12	32	39	8,10,12	85	45	5	1
	16,20,25			16,20,25	90	20		2
CYL25-	8,10,12	25	35	8,10,12	60	15	5	1
	16,20			16,20		10		2

TURRET MORSE TAPER SLEEVES

(TAPER SHANK)

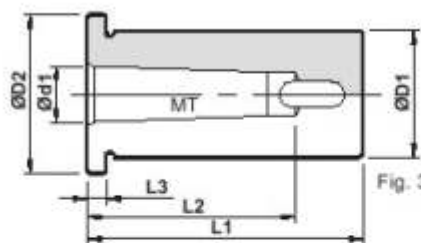
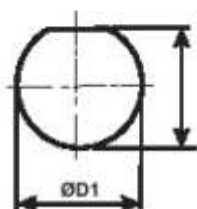


Fig. 3

ORDER.NO.	D1	d1	L1	L2	L3	Figure
T.SMT1- 40,32,25	40,32,25	12.065	85	56	5	3
T.SMT2- 40,32,25	40,32,25	17.780	95	67		
T.SMT3- 40,32	40,32	23.825	110	84		



APPLICABLE TO FIG. 1, 3 & 4

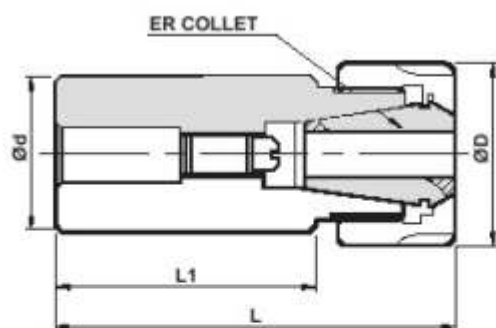
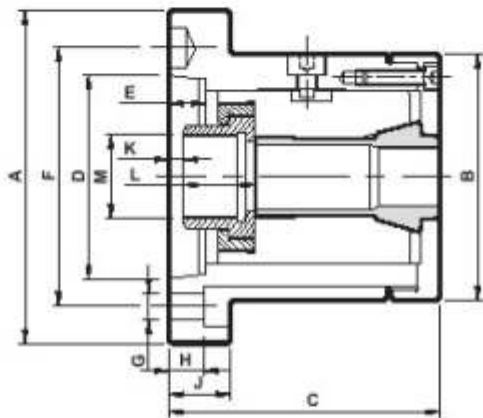
TURRET COLLET CHUCKS


Fig. 4

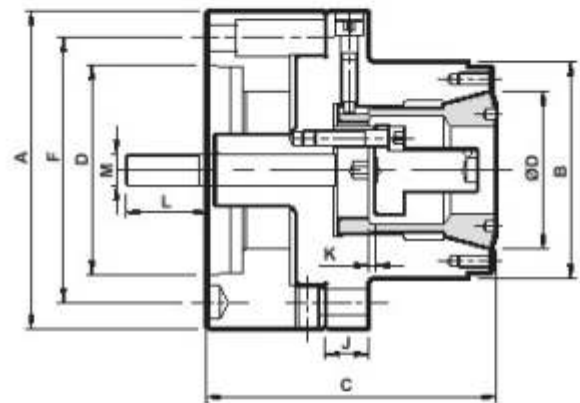
ORDER.NO.	ER COLLET	CLAMPING RANGE	d	D	L1	L
CYL20-ER16/130	ER16	2-10	20	32	80	130
CYL25-ER20/130	ER20	2-13	25	35		
CYL25-ER32/130	ER32	3-20	25	50		
CYL32-ER32/130	ER32	3-20	32	50		

MODEL - A



PUSH TYPE COLLET CHUCKS

MODEL - B



PULL TYPE COLLET CHUCKS

MODEL	A				B	
ORDER.NO.	AA ₂ 5-25	AA ₂ 5-42	AA ₂ 6-42	AA ₂ 8-60	BA ₂ 5-D	BA ₂ 6-D
A	135	135	170	220	160	160
B	100	100	110	130	110	110
C	110	126	126	146	141	141
D	82.563	82.563	106.375	139.719	82.563	106.375
E	13	13	17.5	20	13	13
F	104.78	104.78	133.4	171.4	104.78	133.4
G	3x11	3x11	3x14	3x17	6x11	3x14
H	12	12	14	14	-	-
J	25	25	27	30	25	25
K (MAX)	1	1	6	5	3	3
K (MIN)	6	6	2	1	-	-
L	29	29	30	35	41	41
M	M33x1.5	M39x1.5	M50x1.5	M60x1.5	M16x2	M16x2

DESIGNATION:- Example- AA₂5-25 or BA₂5-D

A or B → represents model of collet chuck .

A₂5 → represents spindle nose size.

COLLETS:-

25 → represents standard push collet size A25 for Model 'A'.

D → represents maximum dia of customized collet suitable to work piece for 'B'.

Note:- → special machinable work piece stopper fitted for true resting in Model 'B'.