

24110 - 24115

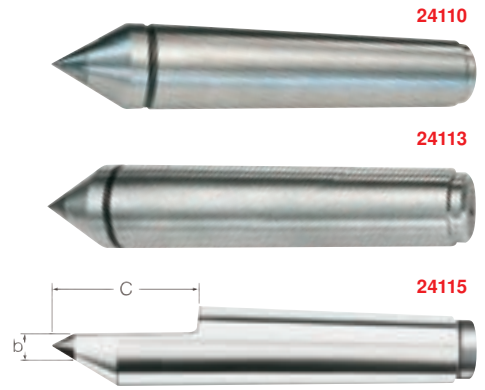
Dead Lathe Centres DIN 806

Type
Point angle 60°, fully hardened and ground.

24110
RÖHM
Type
Full centre.
Quality
Tool steel.

24113
RÖHM
Type
Full centre.
Quality
Carbide point.

24115
Type
Half centre.
Quality
Carbide point.



MT	Overall length mm	no. 24115 b mm	no. 24115 c mm	24110	...	24113	...	24115	...
1	80	7	22		102				102
2	100	7	30		103				103
3	125	11	38		104			104	104
4	160	14	50		105			105	105
5	200	18	63		106			106	106

24200

Live Lathe Centres



Type
Point angle 60°, mounted in ball bearings, fully hardened and ground. End of point made of high-quality tool steel, high true-running accuracy, smooth running.



Size	MT	Workpiece weight max. kg	Lathe centre Ø mm	Housing Ø mm	24200	...
1	1	30	15	36		101
2	2	50	20	45		102
3	3	120	25	60		103
4	4	220	32	70		104

24202

Live lathe centres, lightweight, slim



Type
Point angle 60°, lightweight, with slim housing. Body and live centre hardened. Live centre full-hardened, can be reground several times. Precise roller bearings for high true-running accuracy. Maintenance-free thanks to life-time lubrication. Special seal to prevent ingress of dirt and coolant.

Use
Mainly for machining small and very small parts with small and large lathes.



MT	length from spindle mm	Housing Ø mm	Largest punch Ø mm	Concentricity deviation max. mm	Workpiece weight max. kg	24202	...
2	62,0	32	15	0,005	200		101
3	62,0	34	15	0,005	400		102
4	75,5	42	20	0,005	800		103
5	104,0	58	30	0,010	1600		104

24203

Live Lathe Centres

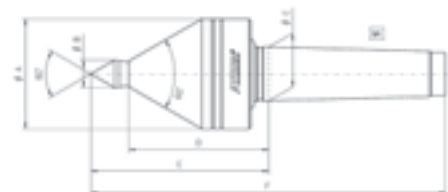


Type
- Point angle 60°.
- Extended live centre
- Concentricity deviation max. 0.005 mm
- Completely hardened and ground

- Bearing arrangement for high axial forces
- Shaft seal prevents ingress of dirt and coolant
Use
For universal use on manual lathes.



MT	A mm	B mm	C mm	D mm	E mm	F mm	rpm max.	Workpiece weight max. kg	24203	...
2	54	13	17,78	68,5	86,5	150,5	4200	170		201
3	54	13	23,83	68,5	86,5	167,5	4200	170		202
3	64	16	23,83	78,0	100,0	181,0	3800	330		203
4	64	16	31,27	78,0	100,0	202,5	3800	330		204
4	86	19	31,27	93,5	121,5	224,0	3200	550		205
5	86	19	44,40	93,5	121,5	251,0	3200	550		206



24204 - 24205

Live Lathe Centres



Type

- Point angle 60°.
- Multiple ball bearings and needle bearings for point angle in shaft]
- Body and point angle die-forged, hardened and ground
- Fixed protective cover with special seal to prevent ingress of dirt and coolant

Note:

Replacement point angles available on request.

24204

Type

- Normal point angle

Note:

Size 101 - 104 with single-row radial bearings.

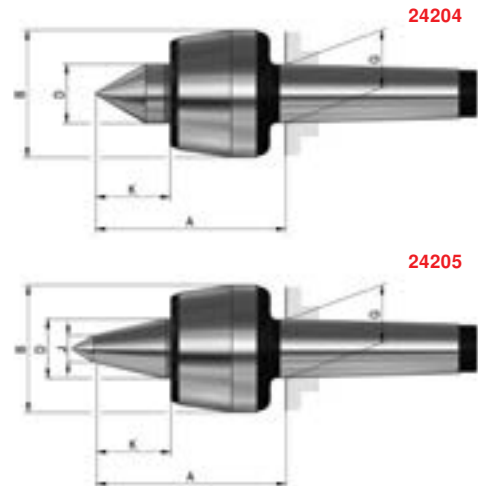
24205

Type

- Extended point angle, permitting unrestricted approach of support

Use

Particularly suited for tracer turning.



Size	MT	Workpiece weight max. kg	A mm	B mm	D mm	G mm	K mm	J mm	Concentricity deviation max. mm	Rotational speed max. rpm	24204	...	24205	...
101 H	1	100	60.5	34.5	15	12.065	17.0	-	0.005	7000		101		
102 H	2	200	65.0	43.0	20	17.780	24.0	-	0.005	7000		102		
104 H	3	400	70.5	48.5	22	23.825	27.5	-	0.005	6300		103		
106 H	3	500	79.5	58.5	25	23.825	31.0	-	0.005	5000		104		
108 H	4	800	102.5	68.5	32	31.267	41.0	-	0.005	3800		105		
110 H	5	2000	129.0	88.5	40	44.399	50.5	-	0.005	3000		106		
114 H	6	3500	152.0	102.5	50	63.348	57.5	-	0.008	2600		107		
102 HVL	2	140	75.0	43.0	20	17.780	34.0	10	0.005	7000				101
106 HVL	3	400	95.5	58.5	25	23.825	47.0	12	0.005	5000				102
108 HVL	4	500	114.5	68.5	32	31.267	53.0	14	0.005	3800				103
110 HVL	5	1200	143.5	88.5	40	44.399	65.0	16	0.005	3000				104

24206

Live Lathe Centres, Sets



Set contents

- 1 Body, hardened, zero-maintenance
- 4 Points (60° / 75° / 90° and 60° extended)
- 1 Point for cavity parts
- 1 Point small, for workpieces without a centre
- 1 Point large, for workpieces without a centre
- 1 Lifter
- 1 Wooden box

Size	MT	Workpiece weight max. kg	Concentricity deviation max. mm	24206	...
102 H	2	40	0.01		101
104 H	3	130	0.01		102
108 H	4	250	0.01		104
110 H	5	650	0.01		105



24207 - 24208

Live Lathe Centres



Type

- Body hardened, zero-maintenance
- Without point and lifter

Use

For exchangeable chuck collets, for all kinds of centring projects especially for single-part production.

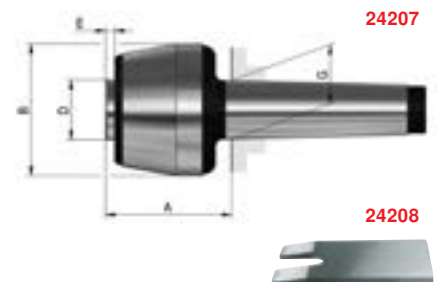
Note:

Centres see cat.-no. 24209 - 24213.

24208

Ejector

- Use For removing points.



Size	MT	Workpiece weight max. kg	A mm	B mm	D mm	E mm	G mm	Concentricity deviation max. mm	24207	...	24208	...
102 A	2	40	4.5	43.0	20	4.0	17.780	0.01		101		201
104 A	3	130	4.5	48.5	22	48	23.825	0.01		102		202
108 A	4	250	67	68.5	32	5.0	31.267	0.01		104		202
110 A	5	650	85	88.5	40	6.0	44.399	0.01		105		203



Clamping Technology

24209 - 24213

Exchangeable Points



24209

Extension point

Type

Type VL, point angle 60°.

Use

For live lathe centres cat.-no. 24207.

24210

Point

Type

60°.

Use

For live lathe centres cat.-no. 24207.

24213

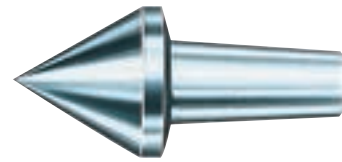
Point

Type

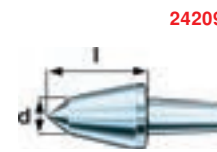
For hollow shapes 60°.

Use

For live lathe centres cat.-no. 24207.



24210



24209



24213

for Size	d mm	l mm	24209	...
102A	6	25		101
104A	8	30		102
108A	12	43		104
110A	13	55		105

for Size	Centres Ø mm	24210	...
102A	16		101
104A	20		102
108A	28		104
110A	38		105

for Size	D mm	d mm	24213	...
102A	25	10		101
104A	35	15		102
108A	55	30		104
110A	70	40		105

24231 - 24232

Live Lathe Centres 400 NC



Type

Point angle 60°, with shock absorption and high-precision bearings supported by laminated springs. Housing and point hardened and ground, maintenance-free.

Use

For damping impact loads, e.g. fast movement of spindle towards workpiece and for high speeds at low levels of axial load.

24231

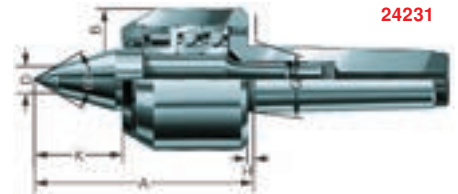
Use

For high loading at high speed.

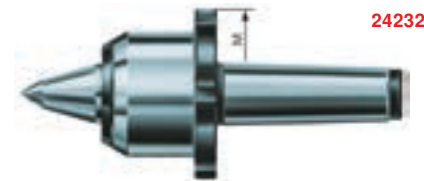
24232

Type

With extractor nut.



24231



24232

Size cat.-no.	MT	Workpiece weight max. kg	Concentricity deviation max. mm	Rotational speed max. 1/min	A mm	B mm	D mm	H mm	K mm	M mm	24231	...	24232	...
24231 / 24232														
424 / 484	4	1000	0.005	7000	122	70	16	6,5	44	100		101		101
425 / 485	5	2000	0.005	6000	150	95	20	6,5	59	125		102		102

24260

Live Lathe Centres



Type

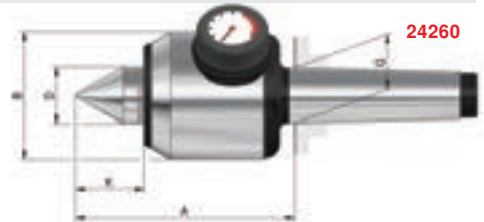
Point angle 60°, point preloaded. Housing and point hardened and ground. Pressure display for an accurate reading of the axial clamping force in daN.

Use

Also suitable for normal chucking.

Note:

Especially suitable as counter centre with face drivers, cat.-no. 25230 - 25239, to maintain a constant axial clamping force between the centres (permanent reclamping). With extended live centre available on request.



24260

Size	MT	axial clamping force max. daN	D mm	E mm	B mm	F mm	concentricity deviation max. mm	24260	...
503	3	550	25	31,5	64	67	0,01		101
504	4	900	32	39,0	72	76	0,01		102
505	5	1500	40	49,0	95	103	0,01		103

24300

Live Lathe Centres

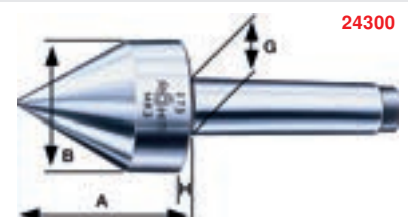


Type

Bevel tip tapering, 60°, robust mounting, locating shaft and body as well as bevel tip hardened.

Use

As centring taper for cavity parts and as centring tip for machining normal workpieces.



24300

Size	MT	A mm	B mm	H mm	G mm	Workpiece weight max. kg	Concentricity deviation max. mm	24300	...
272	2	61	42	7,0	17,780	200	0,01		101
273	3	79	56	7,0	23,825	400	0,008		102
274	4	100	64	8,5	31,267	800	0,008		103

24501 - 24502

Live Lathe Centres



Type

Robust mounting, high concentricity precision, body and housing hardened and ground, zero-maintenance.

Use

For accomodating very large axial and radial forces. For machining pipes and other hollow shapes.

24501

Type

Point angle 60°.

24502

Type

Point angle 75°.



Size	MT	A mm	B mm	D mm	E mm	G mm	Workpiece weight max. kg	Concentricity deviation max. mm	60°		75°	
									24501	...	24502	...
171A	2	65	50	20	52	17.78	200	0.008		102		
172	2	77	80	30	64	17.78	300	0.008		103		
172A	3	77	80	30	64	23.825	400	0.008		104		
172B	4	78.5	80	30	64	31.267	400	0.008		105		
172	2	80	80	20	67	17.78	300	0.008				101
172A	3	80	80	20	67	23.825	400	0.008				102
172B	4	81.5	80	20	67	31.267	400	0.008				103
173	3	85.5	120	30	72	23.825	600	0.008				104
173A	4	87	120	30	72	31.267	800	0.008				105
173B	5	88	120	30	72	44.399	800	0.008				106
174	4	107	170	50	90	31.267	1200	0,01				107
174A	5	106	170	50	90	44.399	1600	0.01				108

System Prefab Office SHB 50



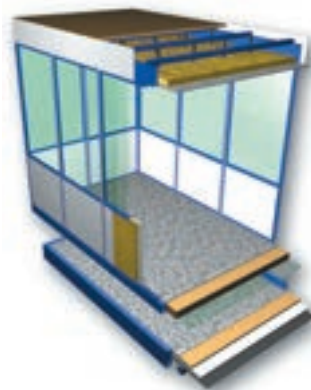
Use

Individual spatial concepts - turnkey solutions.

The Prefab Office SHB 50 is the optimal spatial solution - from the small foreman's office to the 2-storey large facility with many advantages:

- Fast and easy installation through monoblock elements
- Optimal protection against noise and dust
- Effective use of space
- Turnkey solution
- Easy extensibility
- Cost-effective transferability
- Room heights to 3000 mm

Design



Standard floor

Transport floor

Additional information on request



1-storey spatial solution



2-storey spatial solution



Spatial solution on a platform



Transportable spatial solution