

High Performance Centres for Turning and Grinding

Type LDS

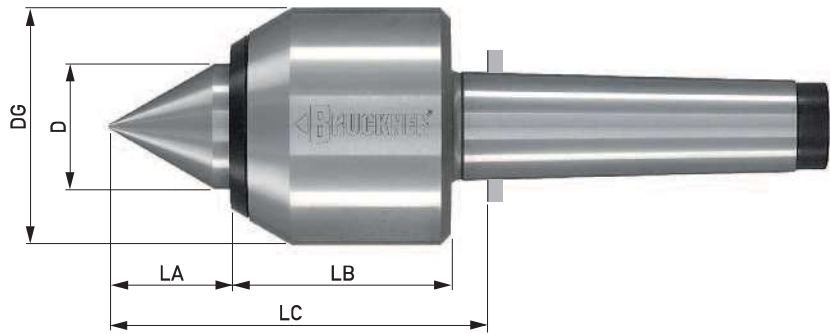
Centrepoint 60°
Spring loaded for expansion
compensation,
without pressure indication

Runout

Max. 0.005 mm, with test report
 Max. 0.003 mm high-precision design
 on request

Application

Turning, CNC turning, precision design
 for cylindrical grinding and measuring



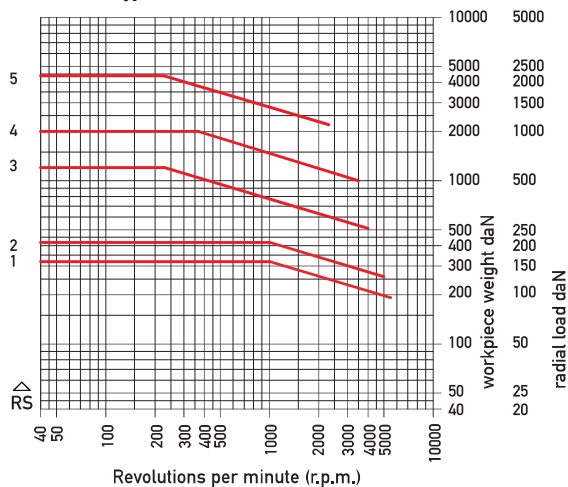
Type LDS	ID.No.	710S 045002	710S 055003	710S 068004	710S 092005	710S 127006
Morse taper		2	3	4	5	6
D		19	26	36	51	71
DG		45	55	68	92	127
LA		24	26	35	47	65
LB		45	51	63	82	109
LC		72	82	103	135	181
Workpiece weight max. daN*		320	420	1200	2000	4400
Spring travel		0.85	0.95	1.4	1.8	2.8
r.p.m. max.*		5500	5000	4000	3500	2300
radial/axial load graph		RS1/AS1	RS2/AS2	RS3/AS3	RS4/AS4	RS5/AS5

Available with draw-off thread and draw-off nut (design A page 28)

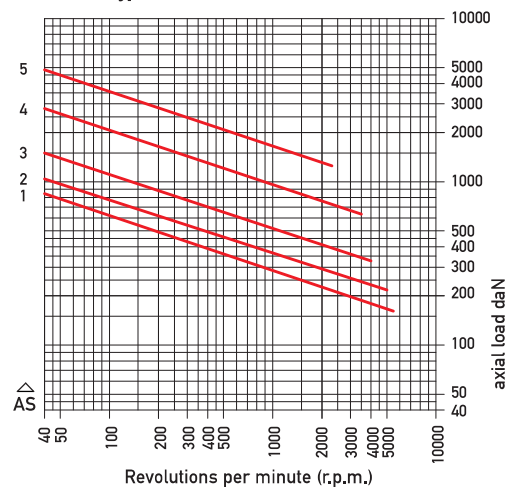
*observe the load graphs

Radial and axial loads for a bearing life of 2,000 operating hours (see calculation example on page 11)

Radial – Type LDS



Axial – Type LDS



Type LDA

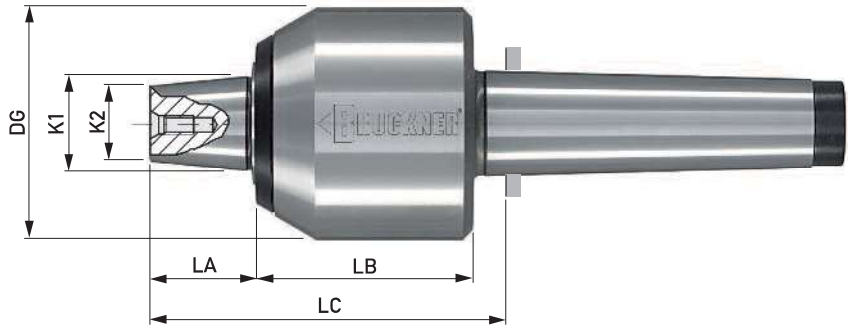
Centrepoint with 1:5 external taper for interchangeable tapered caps. Spring loaded for expansion compensation, without pressure indication

Runout

max. 0.005 mm, with test report

Application

Workpieces with large bores. Retaining and extraction screws are included with these centres.



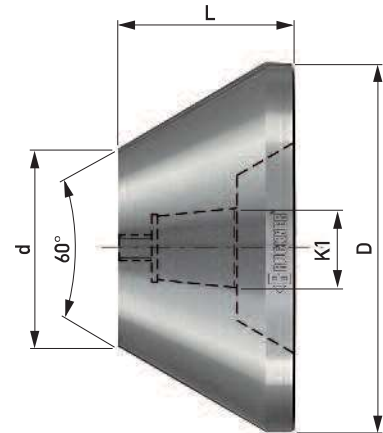
Type LDA	ID.No.	710A 045002	710A 055003	710A 068004	710A 092005	710A 127006
Morse taper		2	3	4	5	6
K1		18	23	28	38	48
K2		14.3	18.4	22.3	30.4	37.6
DG		45	55	68	92	127
LA		22	26	31	42	58
LB		45	51	63	82	109
LC		70	82	99	129	173
Workpiece weight max. daN*		280	320	900	1400	3600
Spring travel		0.85	0.95	1.4	1.8	2.8
r.p.m. max.*		5500	5000	4000	3500	2300
radial/axial load graph		RA1/AA1	RA2/AA2	RA3/AA3	RA4/AA4	RA5/AA5

Available with draw-off thread and draw-off nut (design A, page 28)

*observe the load graphs

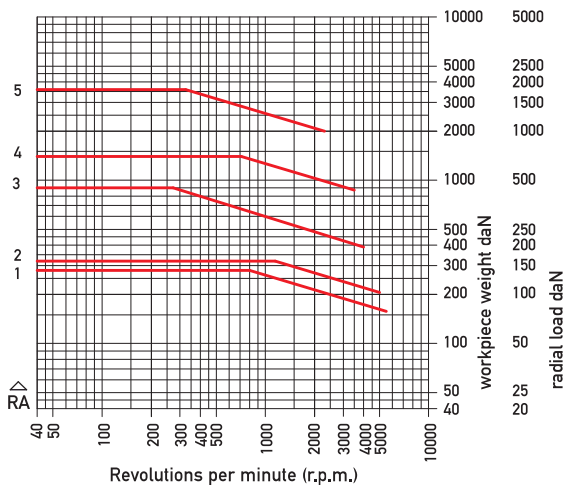
Basic body Type LDA ID.No.	Form KA internal taper 1:5 through hardened alloy tool steel				
	ID.No.	D	d	K1	L
710A 045002	7KA2.056	56	15	18	44
710A 055003	7KA3.068	68	18	23	51
	7KA3.110	110	60	23	53
710A 068004	7KA4.080	80	20	28	60
	7KA4.130	130	70	28	62
710A 092005	7KA5.110	110	30	38	80
	7KA5.175	175	95	38	80
710A 127006	7KA6.150	150	45	48	101
	7KA6.225	225	120	48	101

Special dimensions on request

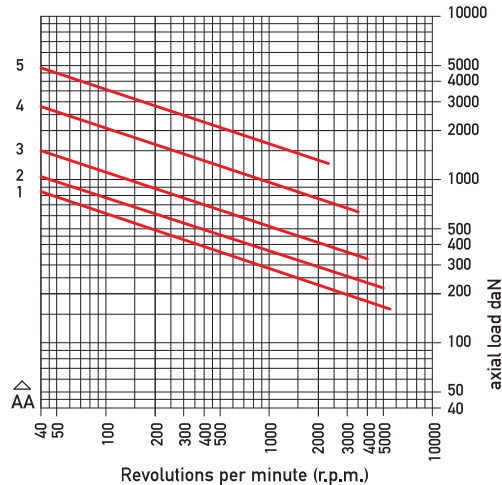


Radial and axial loads for a bearing life of 2,000 working hours (see calculation example page 11)

Radial – Type LDA



Axial – Type LDA



Type LDE

Centrepoint with 1:7.5 internal taper for interchangeable inserts. Spring loaded for expansion compensation, without pressure indication

Runout

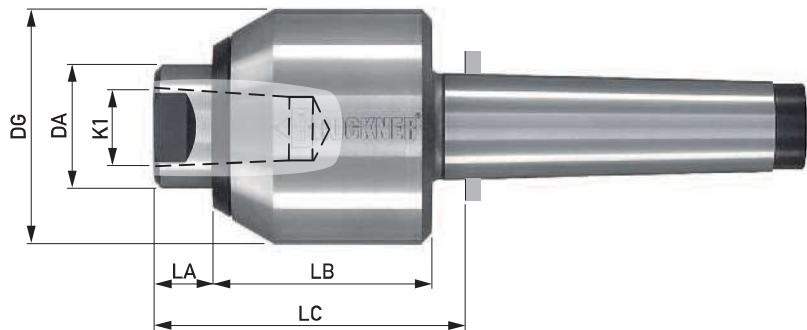
Max. 0.005 mm, with test report
Max. 0.003 mm high-precision design on request

Application

Turning, CNC turning

Advantages

As the centrepoint wears only the insert has to be changed and once again the high performance centre is ready for use. Flexibility in application is made possible by a choice of eight different insert styles (page 37). Depending on the style the insert can be removed by its draw-off thread and draw-off nut or with spanners applied to the spanner flats.



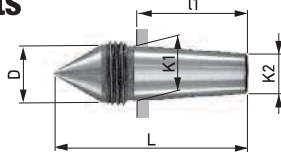
Type LDE	ID.No.	710E 045002	710E 055003	710E 068004	710E 092005
Morse taper		2	3	4	5
DA		19	26	36	51
K1		11	15	22	28
DG		45	55	68	92
LA		9	14	18	20
LB		45	51	63	82
LC		57	70	86	107
Spring travel		0.85	0.95	1.4	1.8
r.p.m. max.		5500	5000	4000	3500
Corresponding inserts		482..	484..	487..	485..
Load	The radial load of type LDE is restricted by the interchangeable inserts (page 37)				

Available with draw-off thread and draw-off nut (design A, page 28)

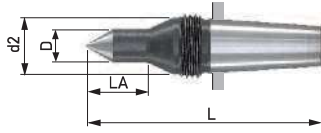
Interchangeable inserts

taper 1:7.5, in gauge accuracy

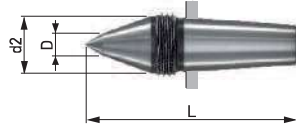
Form AO, 60°
draw-off thread



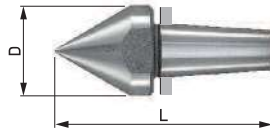
Form ASL, 60°
slim, extended
draw-off thread



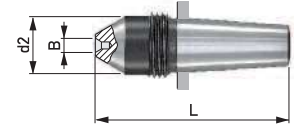
Form AKOP, 60°/40°
extended
draw-off thread



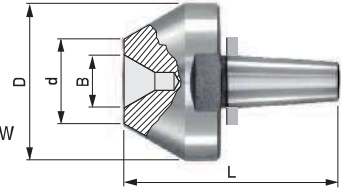
Form A, 60°
for hollow parts
spanner flat



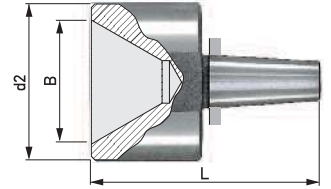
Form B, centre 60°
for centreless workpieces,
draw-off thread



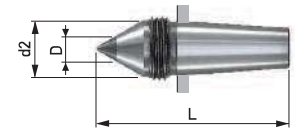
Form C, centre 60°
for centreless workpieces,
external angle 60° for hollow
parts, spanner flat



Form D, centre 60°
for centreless workpieces,
spanner flat



Form AOHM, 60°
with carbide insert
draw-off thread



Basic Centre Types: LDE, TRE	Inserts	Radial load max. daN	Insert dimensions						Thread SW	Taper dimensions		
			taper 1:7.5							K1	K2	l1
ID.No.	ID.No.		D	d2	B	d	L	LA				
710E 045002	482AO	90	11.7				45		M 14x1.5	11	8	23
	482ASL	30	6	11.7			55	15	M 14x1.5			
	482AKOP	90	5	11.7			50		M 14x1.5			
	482A	90	17				45		SW14			
	482B	90	11.7		4x2		45		M 14x1.5			
	482C	90	28		8x3	12	45		SW24			
	482D	90	28		20x6		45		SW24			
710E 055003 700E 055VDI30 700E 055C04 700E 055Zyl25,4 700E 055Zyl25 700E 055Zyl32	482AOHM	60	7	11.7			45		M 14x1.5	15	11	30
	484AO	160	15.7				53		M 18x1.5			
	484ASL	100	9	15.7			65	17	M 18x1.5			
	484AKOP	160	6	15.7			58		M 18x1.5			
	484A	160	25				60		SW22			
	484B	110	15.7		4x2		53		M 18x1.5			
	484C	160	44		15x5	24	60		SW41			
	484D	160	44		35x12		64		SW41			
	484AOHM	60	7	15.7			53		M 18x1.5			
	710E 068004 700E 068VDI40 700E 068C05 700E 068C06 700E 068Zyl32 700E 068Zyl40	487AO	300	21.6				74				
487ASL		100	9	21.6			86	17	M 24x1.5			
487AKOP		300	8	21.6			80		M 24x1.5			
487A		300	32				82		SW27			
487B		240	21.6		5x2,5		74		M 24x1.5			
487C		300	55		20x6	30	82		SW50			
487D		300	55		45x15		85		SW50			
487AOHM	200	11	21.6			74		M 24x1.5				
710E 092005	485AO	500	27.7				93		M 30x1.5	28	21	52.5
	485ASL	180	13	27.7			110	27	M 30x1.5			
	485AKOP	500	8	27.7			105		M 30x1.5			
	485A	500	45				105		SW41			
	485B	500	27.7		7x3		93		M 30x1.5			
	485C	500	65		25x6	35	105		SW55			
	485D	500	65		55x20		105		SW55			
485AOHM	500	18	27.7			93		M 30x1.5				

ID.No.	content
P 10	100 g

Installation paste

Makes insert change easier.
Apply thinly and evenly to the insert taper.

for hard turning



for vertical turning machines



with internal taper 1:7.5 for interchangeable inserts



with spring and coloured pressure indication



High Performance Bullnose Live Centres Special Designs

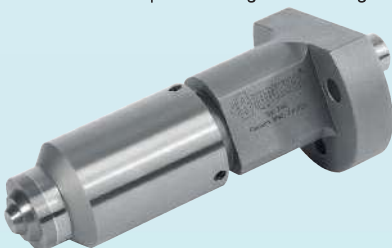
for mounting chucks



pointed design



with carbide cap and flange mounting



with carbide triple contact pads





from small to large



HSK40



with sealing air connection



Capto4

ABS50



large centrepoint



carbide spherical centre



live collet chuck



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