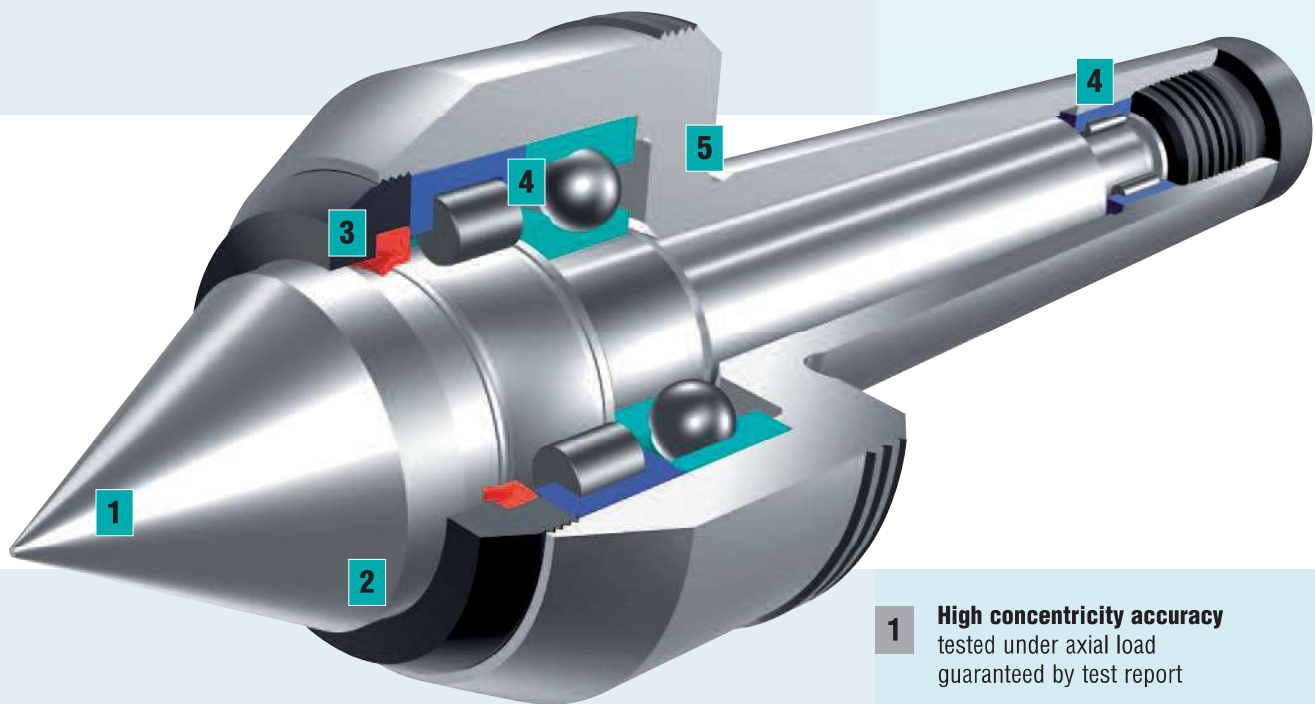


High Performance Centres for Turning and Grinding



LK Series – with superior stiffness

This high performance live centre was developed for use with advanced turning and grinding technology. With a short design, the bearings and pitch of the bearings distance are matched so that this high performance centre withstands vibrations in all machining situations. The bearings are designed for higher r.p.m.

Result

- ▶ Excellent surface quality
- ▶ Longer tool life
- ▶ Improved machine tool efficiency

Two types for MT4 and MT5

- ▶ Slim design for light machining
- ▶ With reinforced bearings for normal to heavy machining

- 1 High concentricity accuracy**
tested under axial load
guaranteed by test report
- 2 through-hardened alloy tool steel centrepoint**
- 3 Seal ring**
protects the bearings from dirt and coolant
- 4 Precision bearings**
bearings seats of housing and centre spindle are precision ground and matched to the bearings. Maintenance-free permanent lubrication
- 5 Housing**
of high tensile alloy tool steel. Housing head and shank are case-hardened for protection against damage

Produced according to BRUCKNER WORKS STANDARD (page 8)

Types LKS, LKSG

Centrepoint 60°

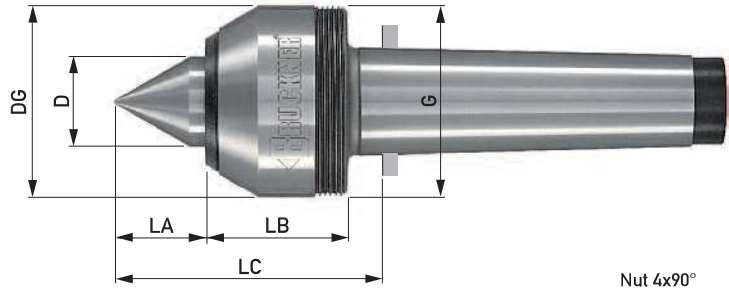
Runout

Type LKS max. 0.005 mm
 Type LKSG max. 0.003 mm

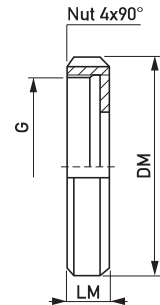
with test report

Application

High performance turning, hard turning, fine turning, cylindrical grinding. Optimum workpiece surface finish due to the short stable anti-vibration design.



Draw-off nut			
ID.No.	G	LM	DM
M55L	M55x1.5	10	68
M68L (MK4)	M68x1.5	15	80
M68L-5 (MK5)	M68x1.5	15	80
M92L	M92x1.5	18	110
M127L	M127x1.5	18	145

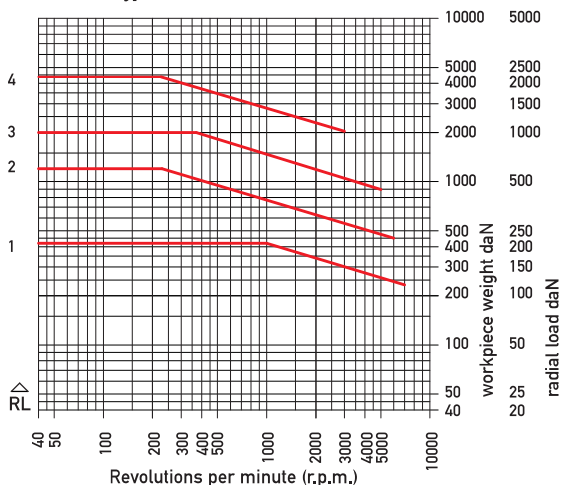


Type LKS	ID.No.	750S 055003A	750S 055004A	750S 068004A	750S 068005A	750S 092005A	750S 127006A
Type LKSG	ID.No.	751S 055003A	751S 055004A	751S 068004A	751S 068005A	751S 092005A	751S 127006A
Morse taper		3	4	4	5	5	6
D		26	26	36	36	51	71
DG		55	55	68	68	92	127
LA		26	26	35	35	47	65
LB		41	41	51,5	51,5	60	80
LC		71	72	92	92	113	152
G		M55x1.5	M55x1.5	M68x1.5	M68x1.5	M92x1.5	M127x1.5
Workpiece weight max. daN*		420	420	1200	1200	2000	4400
r.p.m. max.*		7000	7000	6000	6000	5000	3000
radial/axial load graph		RL1/AL1	RL1/AL1	RL2/AL2	RL2/AL2	RL3/AL3	RL4/AL4
Draw-off nut		M55L	M55L	M68L	M68L-5	M92L	M127L

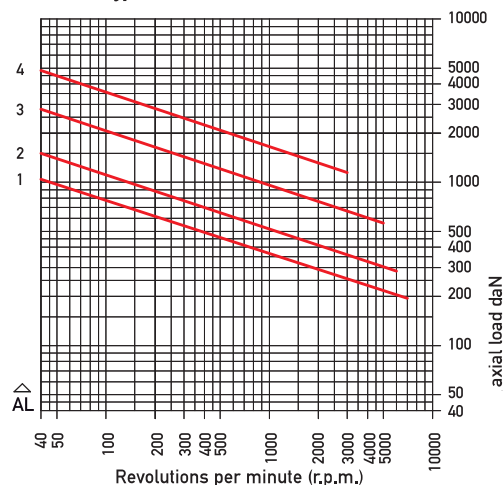
*observe the load graphs

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

Radial – Types LKS/LKSG



Axial – Types LKS/LKSG



Types LKV, LKVG

Centrepoint 60°/40° extended

Runout

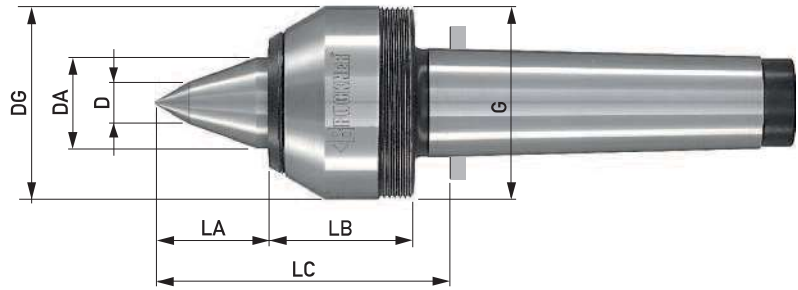
Type LKV max. 0.005 mm

Type LKVG max. 0.003 mm

with test report

Application

High performance turning, hard turning, fine turning, cylindrical grinding. The working space is enlarged due to the extended, slim centrepoint.

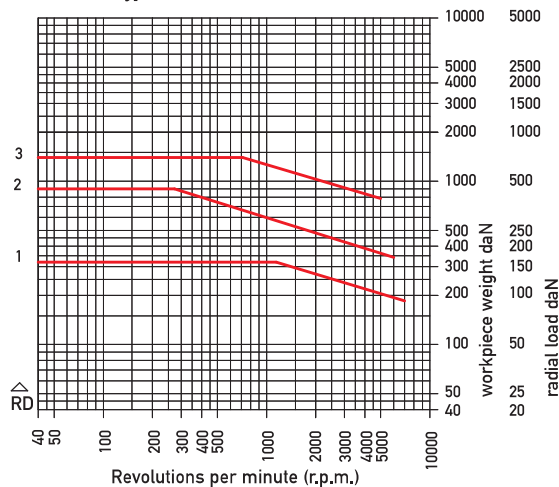


Type LKV	ID.No.	750V 055003A	750V 055004A	750V 068004A	750V 068005A	750V 092005A
Type LKVG	ID.No.	751V 055003A	751V 055004A	751V 068004A	751V 068005A	751V 092005A
Morse taper		3	4	4	5	5
DA		26	26	36	36	51
D		12	12	14	14	17
DG		55	55	68	68	92
LA		33	33	45,5	45,5	64
LB		41	41	51,5	51,5	60
LC		78	79	102	103	130
G		M55x1.5	M55x1.5	M68x1.5	M68x1.5	M92x1.5
Workpiece weight max. daN*		320	320	900	900	1400
r.p.m. max.*		7000	7000	6000	6000	5000
radial/axial load graph		RD1/AD1	RD1/AD1	RD2/AD2	RD2/AD2	RD3/AD3
Draw-off nut (page 23)		M55L	M55L	M68L	M68L-5	M92L

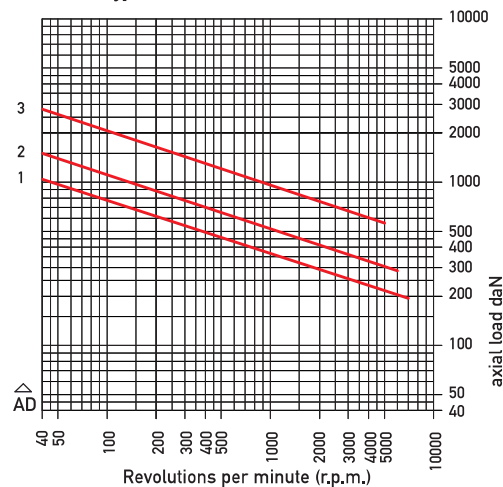
*observe the load graphs

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

Radial – Types LKV/LKVG



Axial – Types LKV/LKVG



Types LKH, LKHG

Centrepoint 60° with carbide insert

Runout

Type LKH max. 0.005 mm

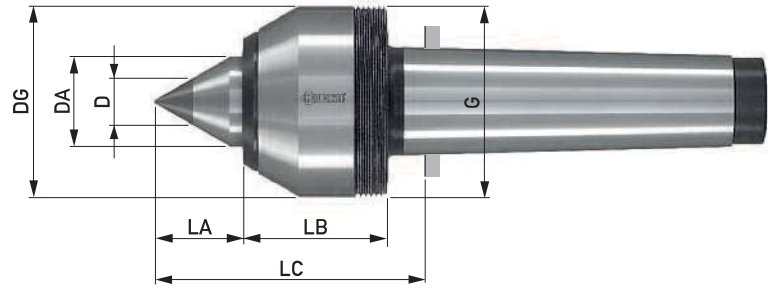
Type LKHG max. 0.003 mm

with test report

Application

High performance turning, hard turning, fine turning, cylindrical grinding.

For operations in which additional stress is put on the centrepoint (e. g. large batches, workpiece change when spindle is running, hard workpieces, extremely small workpiece centres).

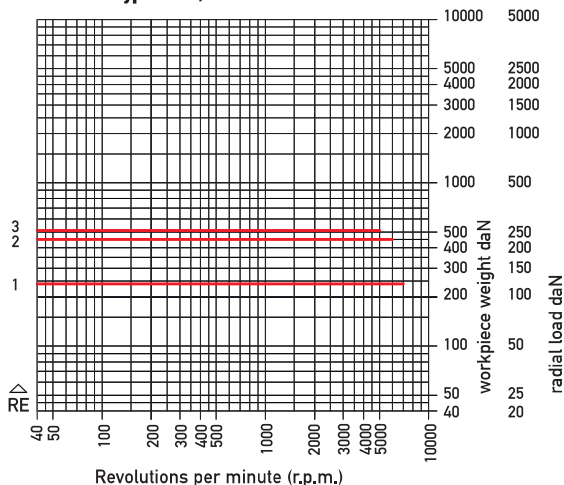


Type LKH	ID.No.	750H 055003A	750H 055004A	750H 068004A	750H 068005A	750H 092005A
Type LKHG	ID.No.	751H 055003A	751H 055004A	751H 068004A	751H 068005A	751H 092005A
Morse taper		3	4	4	5	5
DA		26	26	36	36	51
D		14	14	18	18	18
DG		55	55	68	68	92
LA		26	26	35	35	47
LB		41	41	51,5	51,5	60
LC		71	72	92	92	113
G		M55x1.5	M55x1.5	M68x1.5	M68x1.5	M92x1.5
Workpiece weight max. daN*		240	240	450	450	500
r.p.m. max.*		7000	7000	6000	6000	5000
radial/axial load graph		RE1/AE1	RE1/AE1	RE2/AE2	RE2/AE2	RE3/AE3
Draw-off nut		M55L	M55L	M68L	M68L-5	M92L

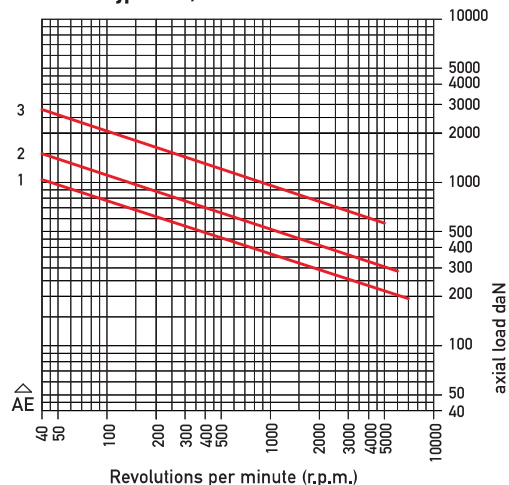
*observe the load graphs

Radial and axial loads for a bearing life of 2.000 operating hours (calculation example on page 11)

Radial – Types LKH/LKHG



Axial – Types LKH/LKHG



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



ABS50



Captor4



large centrepoint



carbide spherical centre

live collet chuck



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