◀BRUCKNER®
Precision and reliability first

High Performance Centres
for Turning and Grinding

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Conventional turning

( ) = catalogue pages

Operation requirements	Recommended series/types			
Workpiece accuracy ≥ 0.004 mm	S Series (9-15)	Bokö Series (26/27)		
Workpiece accuracy ≤ 0.003 mm	S Series 3µm (9-15)	LK Series 3µm (22-25)		
High workpiece surface finish	LK Series (22-25)			
Hard workpieces (hard turning)				
High live centre rigidity				
Elimination of or minimum vibrations during operation				
Heavy coolant flow	NC Series (18-21)			
High r.p.m. (> 5.000 1/min.)	NC Series (18-21)	LK Series (22-25)		
Long shafts	LR Series (28-33)	LD Series (34-37)		
Thermal expansion of workpiece due to machining				
Large workpiece centres/bores	ZA Series (48-53)	Type LDA (35)		
Variable clamping possibilities for different workpieces	Types SE/SEG (14/15)	Type NCE (20/21)	Type LRE (32/33)	Type LDE (36/37)
High rate of wear on the 60° centre point angle				
Wear reduction on the 60° angle by carbide tipping	Types SH/SHG (12)	Types SV/SVG (13)	Types LKH/LKHG (25)	
Tailstock without hydraulic force adjustment	LR Series (28-33)			
Controlling the axial force				
Face driver application with mechanical tailstock				
Face driver application with hydraulic tailstock	S Series (9-15)	LD Series (34-37)	NC Series (18-21)	
Tailstock sleeve design prevents convenient removal of live centre	A Series (16/17)	NC Series (18-21)	LK Series (22-25)	

CNC turning

Operation requirements	Recommended series/types			
Workpiece accuracy ≥ 0.004 mm	S Series (9-15)	NC Series (18-21)	Bokö Series (26/27)	
Workpiece accuracy ≤ 0.003 mm	S Series 3µm (9-15)	LK Series 3µm (22-25)		
High workpiece surface finish	LK Series (22-25)			
Hard workpieces (hard turning)				
Elimination of or minimum vibrations during operation				
Heavy coolant flow	NC Series (18-21)			
High r.p.m. (> 5.000 1/min.)	NC Series (18-21)	LK Series (22-25)		
Long shafts	LR Series (28-33)	LD Series (34-37)		
Thermal expansion of workpiece due to machining				
Large workpiece centres/bores	ZA Series (48-53)	Type LDA (35)		
Variable clamping possibilities for different workpieces	Types SE/SEG (14/15)	Type NCE (20/21)	Type LRE (32/33)	Type LDE (36/37)
High rate of wear on the 60° centre point angle				
Wear reduction on the 60° angle by carbide tipping	Types SH/SHG (12)	Types SV/SVG (13)	Types LKH/LKHG (25)	
Tailstock without hydraulic force adjustment	LR Series (28-33)			
Controlling the axial force				
Face driver application with mechanical tailstock				
Face driver application with hydraulic tailstock	S Series (9-15)	LD Series (34-37)	NC Series (18-21)	
Compensation for varying centre depths and length tolerances of the workpiece at fixed preset tailstock and turret positions	LR Series (28-33)	T-Line (38-41)		
Centre in second counter spindle				
Tailstock sleeve design prevents convenient removal of live centre	A Series (16/17)	NC Series (18-21)	LK Series (22-25)	

Cylindrical grinding

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Operation requirements	Recommended series/types	
Workpiece accuracy	S Series 3µm with additional sealing (9-15)	LK Series 3µm (22-25)
High workpiece surface finish	LK Series 3µm (22-25)	
Elimination of or minimum vibrations during operation		
Heavy coolant flow	S Series 3µm, with additional sealing (9-15)	
Long shafts	S Series 3µm with additional sealing (9-15)	LK Series 3µm (22-25)
Large workpiece centres/bores	ZA Series 3µm (48-53)	
Variable clamping possibilities for different workpieces	Type SEG with additional sealing (14/15)	
Wear reduction on the 60° angle by carbide tipping	Type SHG with additional sealing (12)	Type SVG with additional sealing (13)
Tailstock sleeve design prevents convenient removal of live centre	A Series 3µm with additional sealing (16/17)	LK Series 3µm (22-25)

Heavy-duty machining

Operation requirements	Recommended series/types	
Without tailstock sleeve support, without expansion compensation	Types M/MG, Type AM/AMG (44)	
Without tailstock sleeve support, with expansion compensation and pressure indication	Types MZ/AMZ (46/47)	
With tailstock sleeve support, without expansion compensation	Types MR/MRG (45)	
With tailstock sleeve support, with expansion compensation and pressure indication	Type MZR (46/47)	
High workpiece surface finish	Types MR/MRG (45)	Type MZR (46/47)
Thermal expansion of workpiece due to machining	Types MZ/AMZ (46/47)	
Large workpiece centres/bores	ZA Series (48-53)	
Tailstock sleeve design prevents convenient removal of live centre	Types AM/AMG (44)	Type AMZ (46/47)
Interrupted cut/out of balance workpiece	Types MR/MRG (45)	Type MZR (46/47)

Measuring/testing

Operation requirements	Recommended series/types		
Workpiece accuracy ≤ 0.003 mm and more	S Series 3µm (9-15)	LD Series 3µm (34-37)	
Long shafts	S Series 3µm (9-15)	LK Series 3µm (22-25)	
Large workpiece centres/bores	ZA Series 3µm (48-53)		
Variable clamping possibilites for different workpieces	Type SEG (14/15)		
Wear reduction on the 60° angle by carbide tipping	Type SHG (12)	Type SVG (13)	Type LKHG (25)
Tailstock sleeve design prevents convenient removal of live centre	A Series 3µm (16/17)	LK Series 3µm (22-25)	

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