

High Performance Centres for Turning and Grinding

Material

High quality tool steel,
through-hardened

Runout

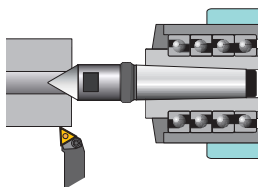
See table on page 54

Taper shank

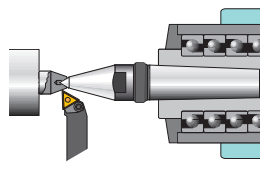
Manufactured in gauge accuracy to
DIN 228 \leq AT4. This means a precise
seating of the centre in the tailstock sleeve
(see table on page 54)

**The quick solution – systematically**

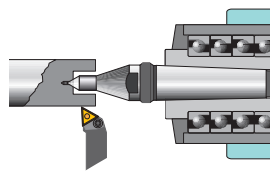
The use of BRUCKNER centres for revolving tailstock sleeves enables a flexible reaction to changing workpiece forms and turning operations.



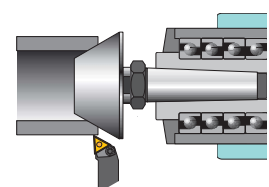
Form 255
for small and large centrebores



Form 256
for limited work space



Form 257
for threading and for centrebores
deep inside a workpiece



Form 258
for large centrebores

Morse taper, metr. 80 1:20, taper 80 1:10

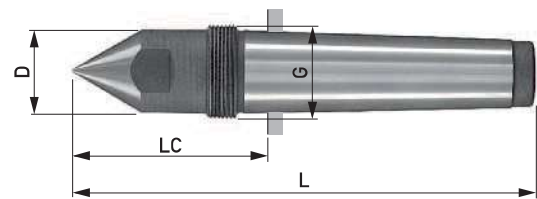
Form 255 – 256 – 257 – 258

Interchangeable dead centres, through-hardened for revolving tailstock sleeves

Form	Taper size	ID.No.	D	G	SW	LC	L	Draw-off nut
255	MK 2	2552	18	M 22x1.5	16	48	112	M252
		2553	24.1	M 27x1.5	22	57	138	M253
	MK 3	2553-150	24.1	M 27x1.5	22	69	150	M253
		2553-170	24.1	M 27x1.5	22	89	170	M253
	MK 4	2554	31.6	M 36x1.5	27	72.5	175	M254
		2554-190	31.6	M 36x1.5	27	87.5	190	M254
		2554-230	31.6	M 36x1.5	27	127.5	230	M254
	MK 5	2555	44.7	M 48x1.5	41	87.5	217	M255
		2555-250	44.7	M 48x1.5	41	120.5	250	M255
	MK 6	2556	63.8	M 68x1.5	55	108	290	M256
Metr. 80 1:20	2557.20	80	M 85x2	-	134	330	M257	
Taper 80 1:10	2557.10	80	M 85x2	-	130	330	M257	

Form 255

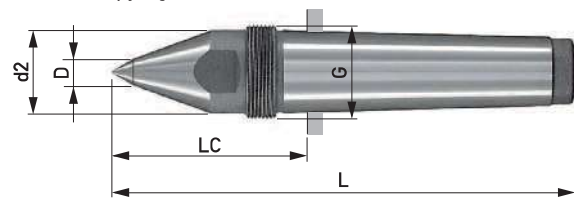
similar to DIN 807 and extended



Form	Taper size	ID.No.	D	d2	G	SW	LC	L	Draw-off nut
256	MK 2	2562	6	18	M 22x1.5	16	48	112	M252
	MK 3	2563	8	24.1	M 27x1.5	22	57	138	M253
	MK 4	2564	10	31.6	M 36x1.5	27	72.5	175	M254
	MK 5	2565	12	44.7	M 48x1.5	41	87.5	217	M255
	MK 6	2566	15	63.8	M 68x1.5	55	136	318	M256

Form 256

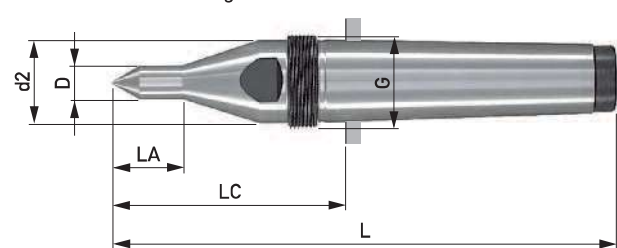
copying centre 60°/40°



Form	Taper size	ID.No.	D	d2	G	SW	LA	LC	L	Draw-off nut
257	MK 2	2572.06-120	6	18	M 22x1.5	16	15	56	120	M252
		2572.09-120	9	18	M 22x1.5	16	17	56	120	M252
		2572.11-120	11	18	M 22x1.5	16	21	56	120	M252
	MK 3	2573.09-150	9	24.1	M 27x1.5	19	17	69	150	M253
		2573.13-150	13	24.1	M 27x1.5	19	25	69	150	M253
	MK 4	2574.09-190	9	31.6	M 36x1.5	27	17	87.5	190	M254
		2574.13-190	13	31.6	M 36x1.5	27	27	87.5	190	M254
		2574.19-190	19	31.6	M 36x1.5	27	53	87.5	190	M254

Form 257

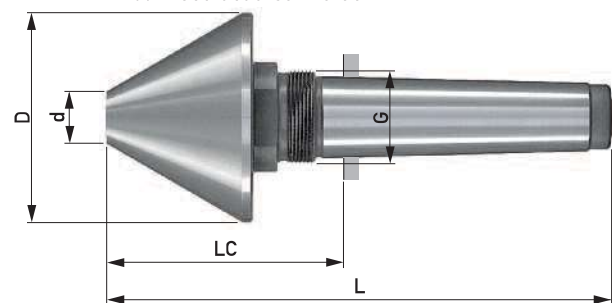
slim design 60°/30°



Form	Taper size	ID.No.	D	d	G	SW	LC	L	Draw-off nut
258	MK 2	2582.40	40	1	M 22x1.5	36	64	128	M252
		2582.80x20	80	20	M 22x1.5	36	88	152	M252
	MK 3	2583.40	40	1	M 27x1.5	36	65	146	M253
		2583.80x20	80	20	M 27x1.5	36	89	170	M253
	MK 4	2584.80x20	80	20	M 36x1.5	36	89.5	192	M254
		2584.125x65	125	65	M 36x1.5	36	89.5	192	M254
		2585.80x20	80	20	M 48x1.5	50	100.5	230	M255
	MK 5	2585.100x50	100	50	M 48x1.5	50	90.5	220	M255
		2585.125x65	125	65	M 48x1.5	50	100.5	230	M255

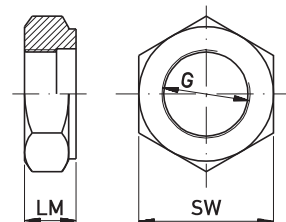
Form 258

bullnose dead centre 60°



Draw-off nut to DIN 807

ID.No.	G	LM	SW
M252	M 22x1.5	15.5	32
M253	M 27x1.5	17.5	41
M254	M 36x1.5	21	55
M255	M 48x1.5	23	75
M256	M 68x1.5	25.5	100
M257	M 85x2.0	40	130



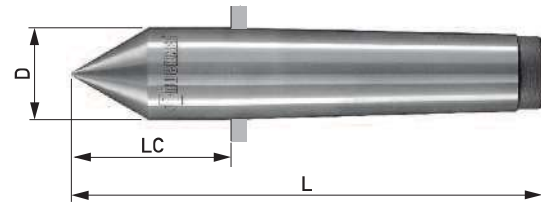
Morse taper, metr. 80 1:20, taper 80 1:10

Form 250

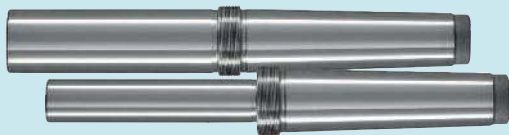
Dead centres – to DIN 806 – through-hardened

Form	Taper size	ID.No.	D	LC	L
250	MK 0	2500	9.2	20.0	70
	MK 1	2501	12.2	26.5	80
	MK 2	2502	18.0	36.0	100
	MK 3	2503	24.1	44.0	125
	MK 4	2504	31.6	57.5	160
	MK 5	2505	44.7	70.5	200
	MK 6	2506	63.8	88.0	270
	Metr. 80 1:20	2507.20	80.4	124.0	320
	Taper 80 1:10	2507.10	80.8	120.0	320

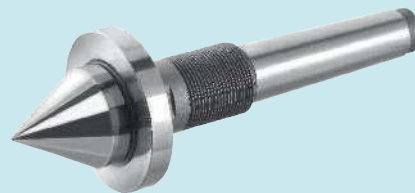
Form 250
to DIN 806, full centre 60°



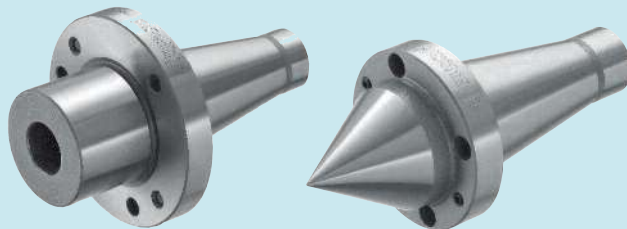
Tool Steel Dead Centres – Special Designs



setting mandrels



centre with measuring bands



SK 45 with face contact
cylindrical mounting for caps 60° centre



extension sleeve MK 5 to MK 5



double diameter 60° dead centre
with draw-off thread



bullnose dead centre with SK 30 mounting taper

Steep tapers SK 30, SK 40

Form 220 – 230

Interchangeable dead centres, through-hardened, runout max. 0.004 mm, for revolving tailstock sleeves

Taper form	Steep taper	Group	ID.No.	D	d	d2	LC	LA	L	
220 is suitable for Index	SK 30	A	2230.10 A-130	10		32.5	61.6		130	
			2230.10 A-150	10		32.5	81.6		150	
			2230.09 B-120	9		32.5	51.6	17	120	
		B	2230.13 B-125	13		32.5	56.6	27	125	
			2230.19 B-135	19		32.5	66.6	57	135	
			2230.25 B-145	25		32.5	76.6	67	145	
			2230.36 C-116	36			47.6		116	
		C	2230.36 C-130	36			61.6		130	
			D	2230.80x20 D	80	20		71.6		140
		2230.125x65 D		125	65		71.6		140	
SK 40	C	2240.48 C-152	48			59		152		
230 is suitable for MAG (Boehringer)	SK 30	A	2330.10 A-130	10		32.2	61.6		130	
			2330.10 A-150	10		32.2	81.6		150	
			2330.10 A-170	10		32.2	101.6		170	
		B	2330.09 B-120	9		32.2	51.6	17	120	
			2330.09 B-150	9		32.2	81.6	17	150	
			2330.13 B-125	13		32.2	56.6	27	125	
			2330.13 B-170	13		32.2	101.6	27	170	
		B	2330.19 B-135	19		32.2	66.6	50	135	
			2330.19 B-170	19		32.2	101.6	50	170	
			2330.25 B-145	25		32.2	76.6	63	145	
			2330.32 C-116	32.2			47.6		116	
		C	2330.32 C-130	32.2			61.6		130	
			2330.32 C-150	32.2			81.6		150	
			2330.32 C-170	32.2			101.6		170	
			2330.45 C-130	45			61.6		130	
		D	2330.80x20 D	80	20		71.6		140	
			2330.125x65 D	125	65		71.6		140	
		SK 40	C	2340.44 C-152	44.9			58.6		152
				2340.44 C-172	44.9			78.6		172
				2340.44 C-200	44.9			106.6		200

Form 220
is suitable for Index

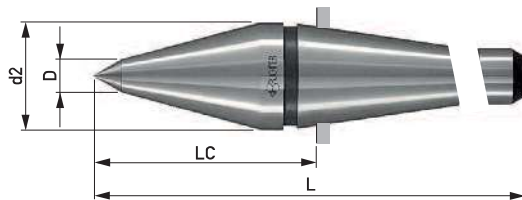


Form 230
is suitable for MAG (Boehringer)

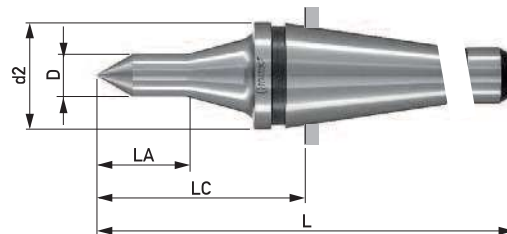


We make special forms, larger steep tapers or carbide-tipped designs to your requirements.

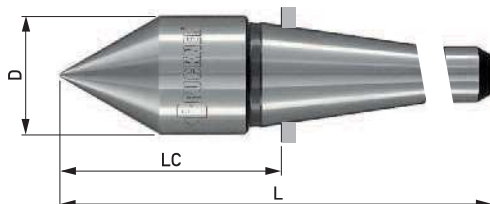
Group A – Copying centre 60°/30°



Group B – Slim centre 60°



Group C – Full centre 60°



Group D – Bullnose dead centre 60°



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