

## High Performance Centres for Turning and Grinding

## Adapter sleeve Type KE

With internal taper 1:7.5  
 Made from alloy case-hardening steel, hardened, with draw-off thread, internally and externally precision-ground

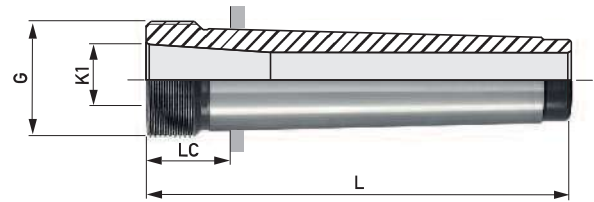
### Runout

Max. 0.003 mm

### Application

For re-grinding interchangeable inserts.  
 Combined with the inserts (pages 15/21/33/37) use as a dead centre in the headstock and tailstock for special applications.

► Draw-off nut to DIN 807: see page 59



Morse taper	Type KE ID.No.	Draw-off nut	K1	G	LC	L	Insert size (page 15)
2	2952A	M252	11	M 22x1.5	16	80	482..
3	2953A	M253	15	M 27x1.5	21	102	484..
4	2954A	M254	22	M 36x1.5	25.5	128	487..
5	2955A	M255	28	M 48x1.5	30.5	160	485..

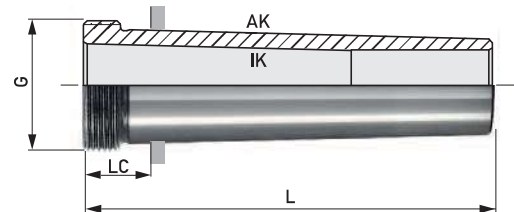
## Reduction sleeve Type SPHA

of alloy case-hardening steel, hardened, with draw-off thread, internally and externally precision-ground

### Runout

Max. 0.003 mm

► Draw-off nut to DIN 807: see page 59



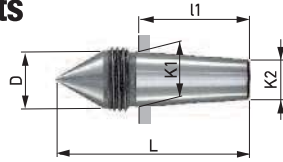
Taper size		Type SPHA				
external	internal	ID.No.	Draw-off nut ID.No.	LC	G	L
AK	IK					
MK 3	MK 2	6032A	M253	17.5	M 27x1.5	91.5
MK 4	MK 2	6042A	M254	16.5	M 36x1.5	110
	MK 3	6043A	M254	16.5	M 36x1.5	110
MK 5	MK 2	6052A	M255	16.5	M 48x1.5	132
	MK 3	6053A	M255	16.5	M 48x1.5	132
	MK 4	6054A	M255	16.5	M 48x1.5	132
MK 6	MK 4	6064A	M256	21.5	M 68x1.5	166
	MK 5	6065A	M256	21.5	M 68x1.5	166
Metr. 80 1:20	MK 5	6805A	M80*	20	M 80x2	192
	MK 6	6806A	M80*	20	M 80x2	192
Taper 80 1:10	MK 6	6806.1A	M80*	20	M 80x2	192

\*Similar to DIN 1804

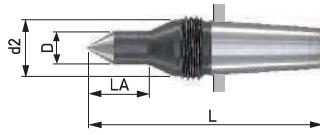
## Interchangeable inserts

taper 1:7.5, in gauge accuracy

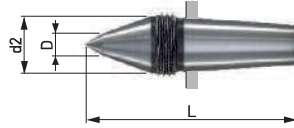
**Form AO**, 60°  
draw-off thread



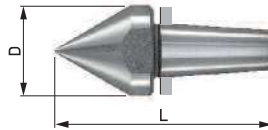
**Form ASL**, 60°  
slim, extended  
draw-off thread



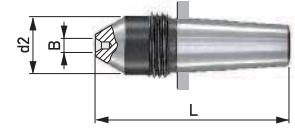
**Form AKOP**, 60°/40°  
extended  
draw-off thread



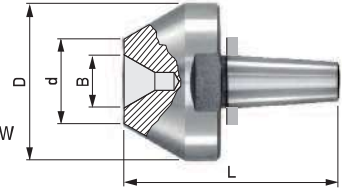
**Form A**, 60°  
for hollow parts  
spanner flat



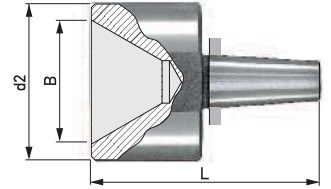
**Form B**, centre 60°  
for centreless workpieces,  
draw-off thread



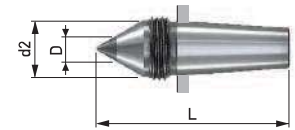
**Form C**, centre 60°  
for centreless workpieces,  
external angle 60° for hollow  
parts, spanner flat



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



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



Basic centre Types: SE, SEG, ASE KE (page 66)	Interchangeable inserts	radial load max. daN	inserts dimensions						thread SW	taper dimensions taper 1:7.5		
			D	d2	B	d	L	LA		K1	K2	l1
5482 5482G 5483 5483G 2952A	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				
	482AOHM	60	7	11.7		45		M 14x1.5				
	5484 5484G 5486 5486G 5484A 5486A 2953A	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				
5487 5487G 5487A 2954A		487AO	300	21.6			74		M 24x1.5	22	16.4	42
	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				
5485 5485G 5485A 2955A	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.

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