

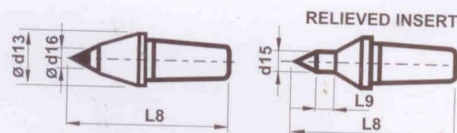
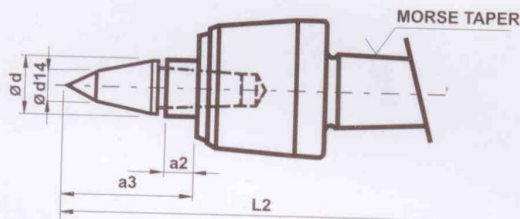
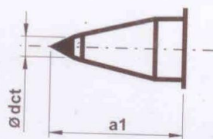
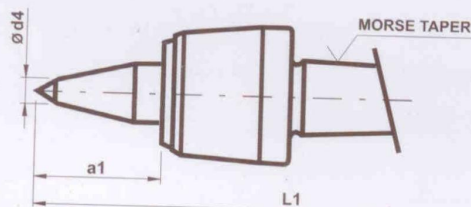
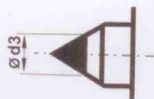
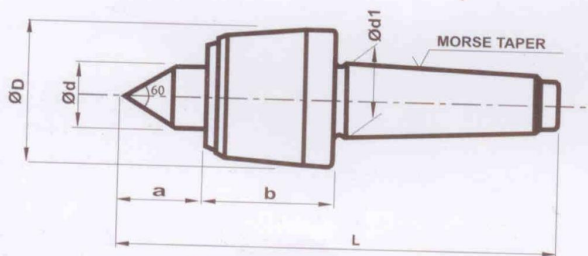
# REVOLVING CENTRES

## CNC TURNING APPLICATIONS RPM UPTO 6000

**Life** Revolving centres have a highly developed design with all the conventional shapes of centres points. The housing is drop forged, high grade material, thus guaranteeing a uniform structure having a maximum stability and load capacity. The centres are made of high quality tool steel scientifically hardened and can be reground several times. The especially rugged tripple precision roller bearing ensures maximum accuracy and a long operation time. Best quality grease lubrication is maintenance free for permanent top performances. A special sealing arrangement protects from coolant and dirt.

### STANDARD CENTRES

(PLAIN / CARBIDE)



ORDER.NO.	3011	3012	3013	3014	3015
MT.	1	2	3	4	5
a	20	24	30	40	42
b	38	45	53	56	64
d	12	18	23	28	34
d1	12.065	17.78	23.825	31.267	44.399
d3	-	8	11	14	18
D	40	44	61	70	88
L	115	138	169	205	242
R/O	0.005				

### EXTENDED CENTRES

(PLAIN / CARBIDE)

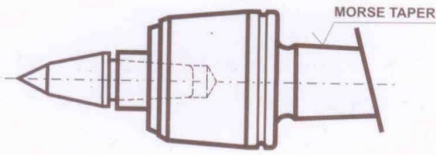
ORDER.NO.	3022	3023	3024	3025
a1	32	42	47	58
d4	6	10	10	13
dct	6	8	8	11
L1	146	181	212	258

### QUICK CHANGE CENTRES

WITH PLAIN, CARBIDE or RELIEVED INSERTS

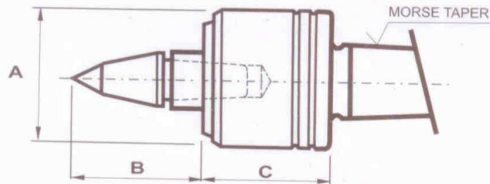
ORDER.NO.	3033	3034	3035
a2	10	7	10
a3	39	46	54
d	23	28	34
d13	18	24	26
d14	10	12	12
d15	10	10	10
d16	6	10	10
L8	52/60	75	80
L2	178	212	254
L9	10	10	10

Ordering ex :- Mention 'P' for Plain and 'C.T' for carbide centres along with Ord.No. ex. 3022 CT



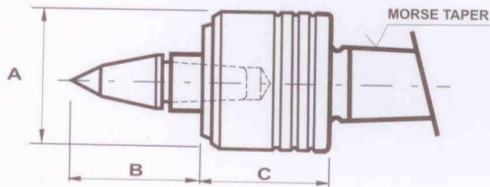
### WORK DRIVE CENTRE (DRIVES WORKPIECE WITH TAILSTOCK PRESSURE)

ORDER. NO.	3043	3044	3045
MT.	3	4	5



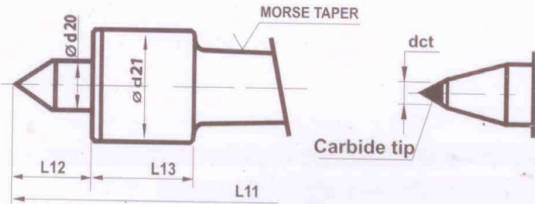
### HIGH PERFORMANCE CENTRES (FOUR BEARINGS) R/o 0.003mm

ORDER. NO.	4023	4024	4025	4026
MT.	3	4	5	6
A	60	64	68	145
B	39	49	54	68
C	62	64	64	110



### SUPER PERFORMANCE CENTRES (FOUR BEARINGS) 6000 rpm R/o 0.003mm

ORDER. NO.	4033	4034	4035	4036
MT.	3	4	5	6
A	60	60	85	110
B	39	49	54	68
C	62	62	72	85

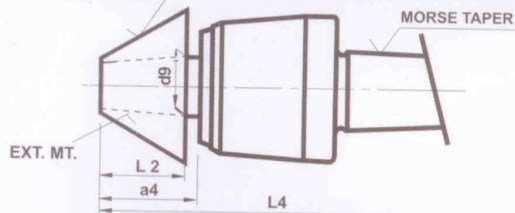


### MINI CENTRES

(SMALL BODY DIA) 6000 rpm

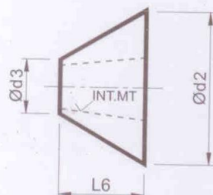
ORDER. NO.	MT	d20	d21	dct	L13	L12	L11
3063	3	15	36	7	37	25	148
3064	4	20	42	8	44	26	180
3065	5	28	68	10	56	54	246

### CHANGEABLE INSERT



### CENTRES WITH EXTERNAL TAPER

ORDER. NO.	3072	3073	3074	3075
MT.	2	3	4	5
a4	29	36	36	45
I2	25	32	32	40
d9	17.78	23.825	23.825	31.267
L4	143	175	201	245
External MT.	2	3	3	4



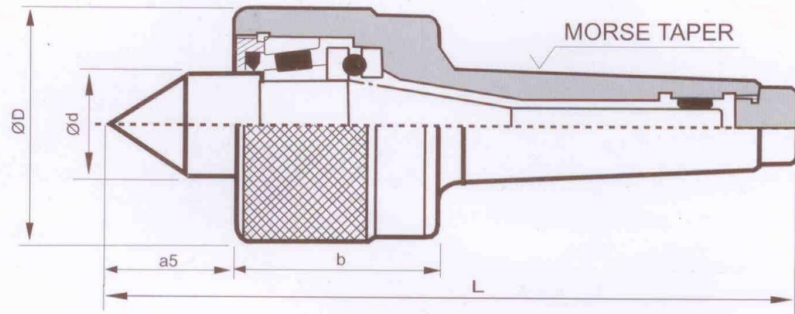
### PIPE INSERTS

(EXT. TAPER CENTRES)

ORDER. NO.	3172	3173	3174	3175
INT. MT	2	3	3	4
d2	50	65	75	95
d3	23	30	40	50
L6	25	32	32	40

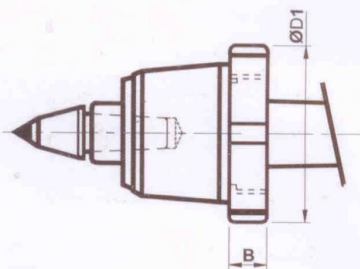


# HEAVY LOAD CENTRES



## HEAVY LOAD, MEDIUM RPM, CENTRES

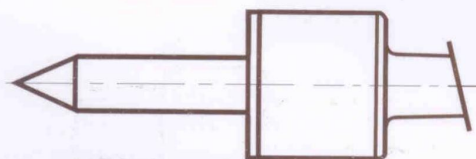
ORDER NO.	3083	3084	3085	3186	3286	3386	3287	3387
MT	3	4	5	6	6	6	7	7
a5	28	36	40	56	100	85	100	85
b	50	55	60	90	135	135	130	135
d	24	28	34	56	85	85	85	85
D	62	69	78	108	150	180	150	180
L	165	200	235	335	420	410	490	480
<b>RATED LOAD AT 100 rpm- kg</b>								
AXIAL	850	1200	1900	2100	10000	12000	10000	12000
RADIAL	600	850	1600	1500	5000	8000	5000	8000



## CENTRES WITH EXTRACTOR NUT

MT.	-	3	4	5
B	-	18	18	18
ØD1	-	75	85	100

Mention 'EX .NUT' along with ordering No. ex. 3022 EX.NUT.

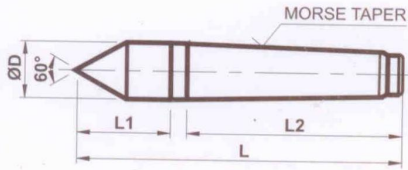


## INDUCTION HARDENING REVOLVING CENTRES

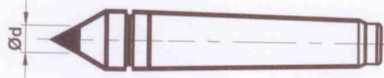


**Stainless Steel** components to avoid corrosion  
**Pyramid Shaped** centre for extra driving force  
**Carbide or Plain** centre options are available

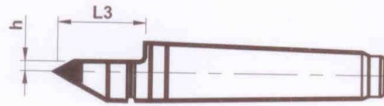
## DEAD CENTRES ( I.S:- 2289 )



PLAIN (DC)



CARBIDE TIP (DCC)

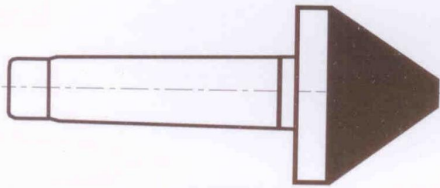


CARBIDE TIP HALF (DCCH)

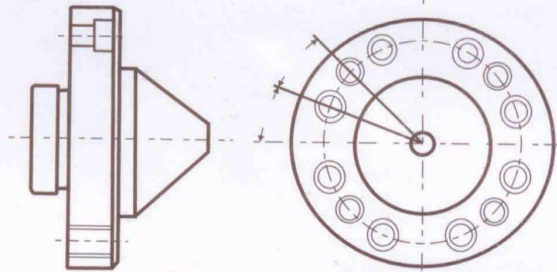
MT.NO.	MT-1	MT-2	MT-3	MT-4	MT-5	MT-6
ORDER.NO.	11	12	13	14	15	16
ØD	12.2	18	24.1	31.6	44.7	63.8
L1	23	31	39	51	64	80
L2	53.5	64	81	102.5	129.5	182
L	80	100	125	160	200	270
Ød	6	8	11	14	18	18
h	1.5	2	3	5	7	10
L3	22	30	38	50	63	79

**METRIC TAPER shanks 60,80,100, and 120** are also available  
Mention categories DC, DCC or DCCH along with  
Ordering No. Ex. DCCH 11

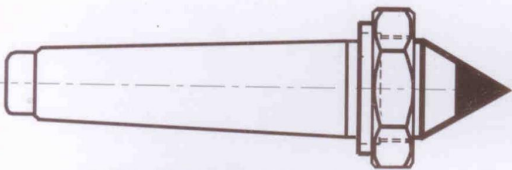
## SPECIAL CENTRES



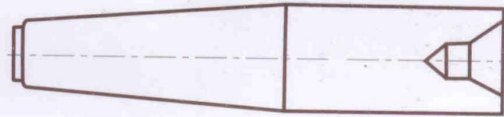
LARGE CARBIDE DEAD CENTRES  
UP TO DIA 100 MM TIP



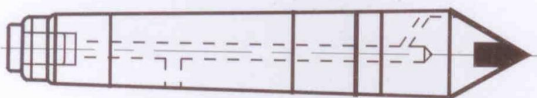
FLANGE TYPE CENTRES ex Hobbing M/C



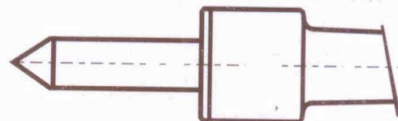
THREADED DEAD CENTRES  
WITH NUT



FEMALE DEAD CENTRES



CENTRES FOR OIL or COOLANT  
THROUGH APPLICATION



SPLINE ROLLING CENTRES



# TURRET SLEEVES

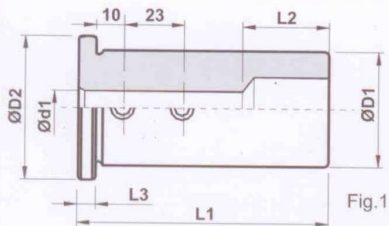


Fig. 1

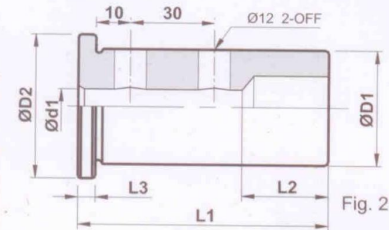


Fig. 2

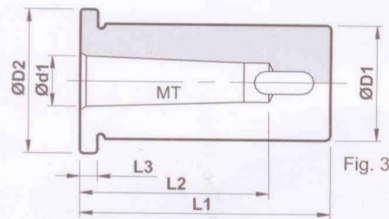
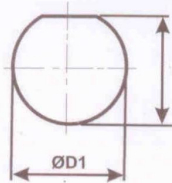


Fig. 3



APPLICABLE TO FIG. 1, 3 & 4

## TURRET SLEEVES

(CYLINDRICAL SHANK)

ORDER.NO.	D1	D2	d1	L1	L2	L3	Figure
CYL40-	8,10,12	40	47	8,10,12	85	45	5
	16,20,25,32			90	20		
CYL32-	8,10,12	32	39	8,10,12	85	45	5
	16,20,25			90	20		
CYL25-	8,10,12	25	35	8,10,12	60	15	5
	16,20			60	10		

## TURRET MORSE TAPER SLEEVES

(TAPER SHANK)

ORDER.NO.	D1	d1	L1	L2	L3	Figure
T.SMT1- 40,32,25	40,32,25	12.065	85	56	5	3
T.SMT2- 40,32,25	40,32,25	17.780	95	67		
T.SMT3- 40,32	40,32	23.825	110	84		

## TURRET COLLET CHUCKS

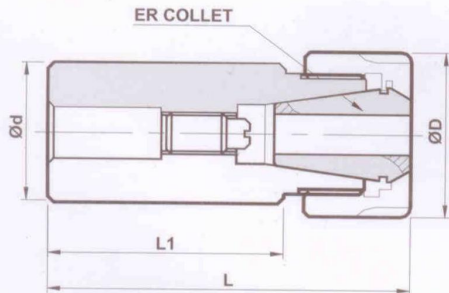
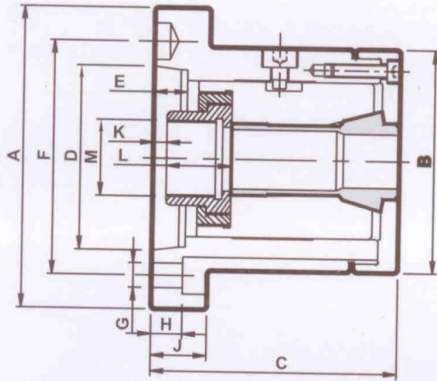


Fig. 4

ORDER.NO.	ER COLLET	CLAMPING RANGE	d	D	L1	L
CYL20-ER16/130	ER16	2-10	20	32	80	130
CYL25-ER20/130	ER20	2-13	25	35		
CYL25-ER32/130	ER32	3-20	25	50		
CYL32-ER32/130	ER32	3-20	32	50		

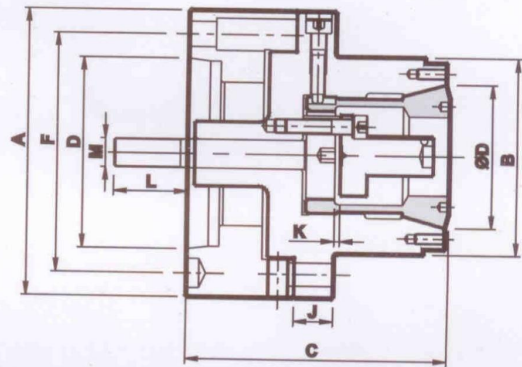
# POWER COLLET CHUCKS

**MODEL - A**



PUSH TYPE COLLET CHUCKS

**MODEL - B**



PULL TYPE COLLET CHUCKS

MODEL	A				B	
ORDER.NO.	AA <sub>2</sub> 5-25	AA <sub>2</sub> 5-42	AA <sub>2</sub> 6-42	AA <sub>2</sub> 8-60	BA <sub>2</sub> 5-D	BA <sub>2</sub> 6-D
A	135	135	170	220	160	160
B	100	100	110	130	110	110
C	110	126	126	146	141	141
D	82.563	82.563	106.375	139.719	82.563	106.375
E	13	13	17.5	20	13	13
F	104.78	104.78	133.4	171.4	104.78	133.4
G	3x11	3x11	3x14	3x17	6x11	3x14
H	12	12	14	14	-	-
J	25	25	27	30	25	25
K (MAX)	1	1	6	5	3	3
K (MIN)	6	6	2	1	-	-
L	29	29	30	35	41	41
M	M33x1.5	M39x1.5	M50x1.5	M60x1.5	M16x2	M16x2

**DESIGNATION:-** Example- AA<sub>2</sub>5-25 or BA<sub>2</sub>5-D

A or B → represents model of collet chuck .

A<sub>2</sub>5 → represents spindle nose size.

## COLLETS:-

25 → represents standard push collet size A25 for Model 'A'.

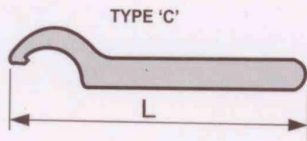
D → represents maximum dia of customized collet suitable to work piece for 'B'.

**Note:-**

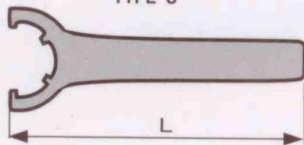
→ special machinable work piece stopper fitted for true resting in Model 'B'.



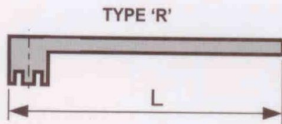
## ER COLLETS & SPANNERS



TYPE 'C'



TYPE 'S'



TYPE 'R'

### TYPE 'C' SPANNER FOR SLOTTED NUTS

SPANNER DESIGNATION	L	SUITABLE FOR NUT
CS 25	115	ER 25
CS 32	200	ER 32
CS 40	190	ER 40
CS 50	200	ER 50

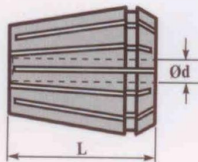
### USE 'D' SPANNER FOR HEXAGONAL NUTS

### TYPE 'STAR SPANNER' FOR SLOTTED NUTS

SPANNER DESIGNATION	L	SUITABLE FOR NUT
SS 25	210	ER 25
SS 32	252	ER 32
SS 40	295	ER 40
SS 50	350	ER 50

### TYPE 'R' SPANNER FOR MINI NUTS

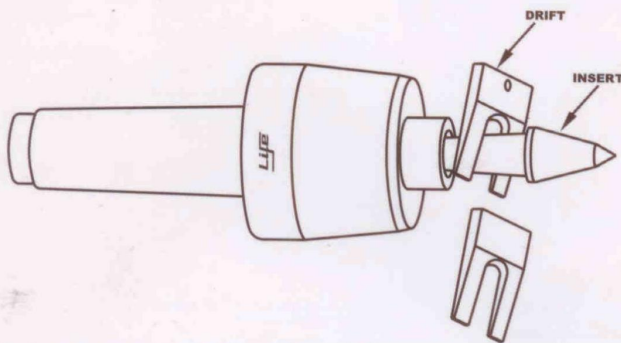
SPANNER DESIGNATION	L	SUITABLE FOR NUT
RS 11	105	ER 11M
RS 16	135	ER 16M
RS 20	135	ER 20M
RS 25	150	ER 25M



ER TYPE

ORDERING NO.	BORE RANGE (d)			PCS /SET	CLAMPING RANGE
	FROM	TO	IN STEP		
ER 8	1	5	0.5	9	0.5 ~ 5.0
ER 11	1	7	0.5	13	0.5 ~ 7.0
ER 16	1	10	1	10	0.5 ~ 10
ER 20	1.5	13	1	12	0.5 ~ 13
ER 25	1	16	1	16	0.5 ~ 16
ER 32	2	20	1	19	1.0 ~ 20
ER 40	4	26	1	23	3.0 ~ 26
ER 50	10	34	2	13	8 ~ 34

## QUICK CHANGING OF INSERTS



## OUR MISSION :

*Customer satisfaction  
through excellence  
in technology  
and services.*