



Carbide dead centres according to works standard

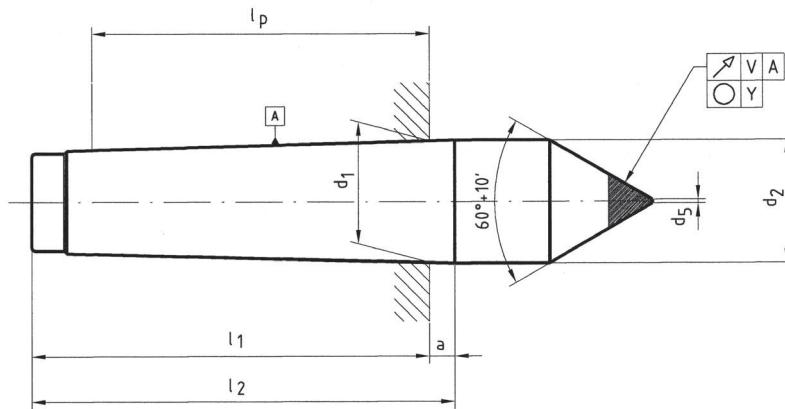
Extension of our product range for STUDER* grinding machines



*Registered brand of the FRITZ STUDER AG, CH-Thun

Carbide dead centres

Technical features



Excerpt from DIN 806, DIN 228 and BRUCKNER works standard (dimensions in mm)

| MT | DIN | | | | | | | DIN | Bruckner works standard | | |
|----|----------------|----------------|----------------|----------------|----------------|-----|----------------|------|-------------------------|-------|-------------------|
| | d ₁ | d ₂ | d ₅ | l ₁ | l ₂ | a | l _p | V | V | Z | Y* _{max} |
| 2 | 17.780 | 18.0 | 0.8 | 64.0 | 69.0 | 5.0 | 54 | 0.01 | 0.003 | 0.003 | 0.0008 |
| 3 | 23.825 | 24.1 | 0.8 | 81.0 | 86.0 | 5.0 | 69 | 0.01 | 0.004 | 0.004 | 0.0008 |
| 4 | 31.267 | 31.6 | 1.0 | 102.5 | 109 | 6.5 | 87 | 0.01 | 0.004 | 0.005 | 0.0008 |

*For centres with centrebore Y = 0.001 mm



Roundness of the carbide Y
Out-of-roundness ≤ 0.0008 mm (0.8 μm)



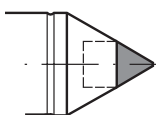
Concentricity V
Very narrow eccentricity V of the 60° point to the taper shank according to table.



Taper shank tolerance Z
Maximum Morse taper error, taper increasing towards the large diameter along the tested length l_p (deviation of taper is ≤ AT4 according to DIN 228).

HRC

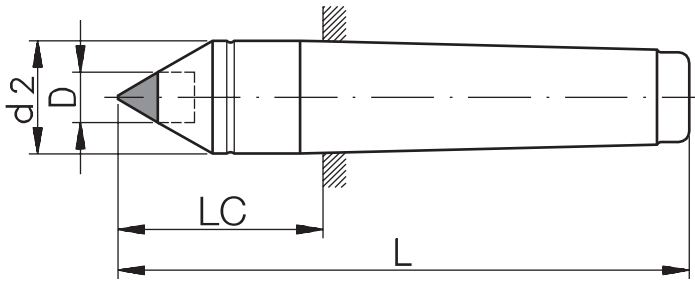
Hardened Morse taper
The taper shank is case-hardened for protection from damage.



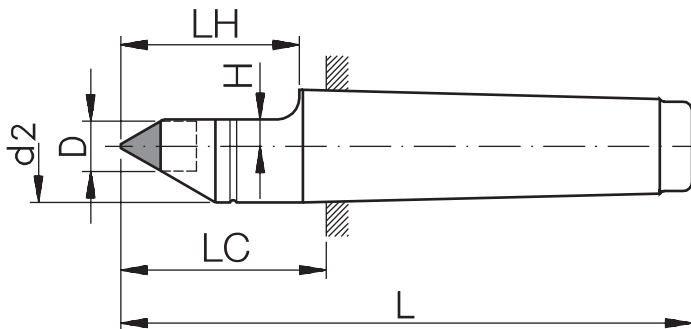
Regrinding line

Regrinding line
The useful end of the carbide is shown by the regrinding line for dead centres with carbide insert resp. by the braze line for centres with carbide ring.

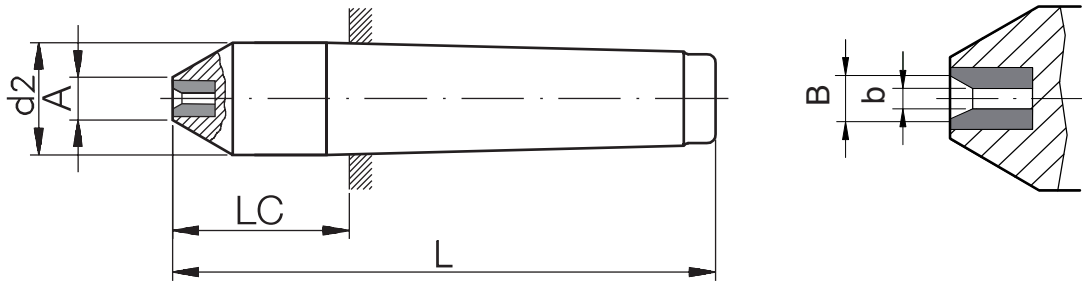
Regrinding/Repair service (also for tools from other manufacturers)
We judge the centre's condition. You will get a survey report on the repair tasks.


Form L, full centre 60°, out-of-roundness \square 0.8 μ m

| MT | ID.No. | equal to STUDER* No. | D mm | d2 mm | LC mm | L mm |
|----|-------------|-------------------------|---------|----------|----------|---------|
| 2 | 2802.15-94 | 0166.025 | 15 | 20 | 30 | 94 |
| 2 | 2802.15-110 | 0138.004 | 15 | 20 | 46.5 | 110.5 |
| 3 | 2803.15-117 | - | 15 | 26 | 36.5 | 117 |
| 3 | 2803.15-125 | - | 15 | 26 | 45 | 125.5 |
| 3 | 2803.20-117 | 0709.017 | 20 | 26 | 36.5 | 117 |
| 3 | 2803.20-125 | 0710.020 | 20 | 26 | 45 | 125.5 |
| 4 | 2804.25-160 | 2810.030 | 25 | 35 | 57.5 | 160 |

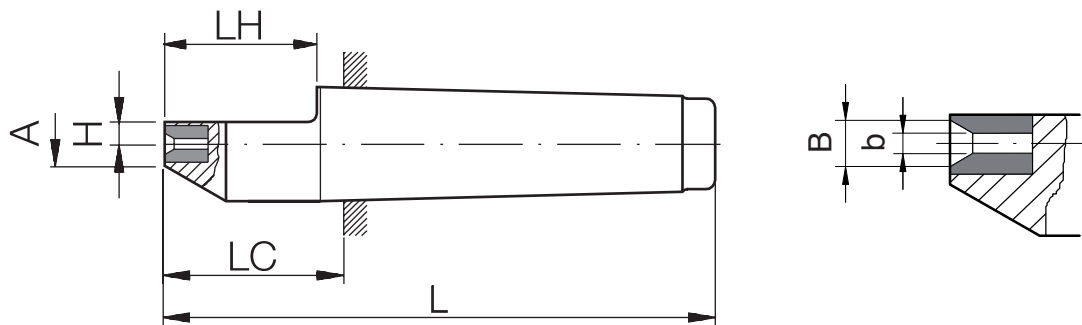

Form HS, extra flat height 60°, out-of-roundness \square 0.8 μ m

| MT | ID.No. | equal to STUDER* No. | D mm | d2 mm | H mm | LH mm | LC mm | L mm |
|----|-----------------|-------------------------|---------|----------|---------|----------|----------|---------|
| 2 | 2812.15H2,5-97 | 0810.052 | 15 | 20 | 2.5 | 28 | 33 | 97 |
| 2 | 2812.15H2,5-110 | 0138.005 | 15 | 20 | 2.5 | 38.5 | 46.5 | 110.5 |
| 3 | 2813.11H1-150 | - | 11 | 24.1 | 1 | 63 | 69.5 | 150 |
| 3 | 2813.11H2-150 | - | 11 | 24.1 | 2 | 63 | 69.5 | 150 |
| 3 | 2813.11H3-150 | - | 11 | 24.1 | 3 | 63 | 69.5 | 150 |
| 3 | 2813.20H4-125 | 0710.021 | 20 | 26 | 4 | 36.5 | 45 | 125.5 |
| 3 | 2813.20H2-150 | 0710.045 | 20 | 26 | 2 | 55 | 69.5 | 150 |



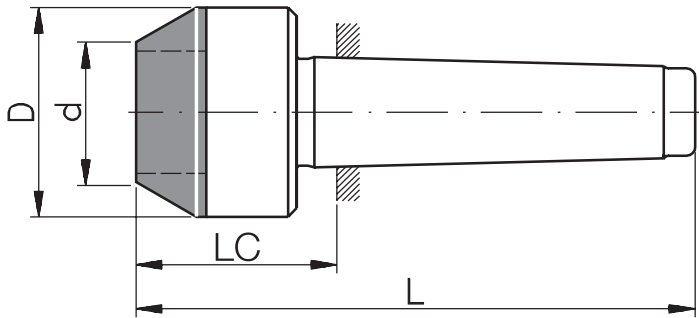
Form B, female centre with ground centrebore in the carbide, 60°, out-of-roundness \square 1.0 μ m

| MT | ID.No. | equal to STUDER* No. | B mm | b mm | A mm | d2 mm | LC mm | L mm |
|----|----------------|-------------------------|---------|---------|---------|----------|----------|---------|
| 2 | 2822.2,5x1-96 | - | 2.5 | 1 | 6 | 18 | 32 | 96 |
| 3 | 2823.2,5x1-120 | - | 2.5 | 1 | 6 | 24.1 | 39 | 120 |
| 3 | 2823.4x2-120 | - | 4 | 2 | 9 | 24.1 | 39 | 120 |



Form HB, with flat, female centre with ground centrebore in the carbide, 60°, out-of-roundness \square 1.0 μ m

| MT | ID.No. | equal to STUDER* No. | B mm | b mm | A mm | d2 mm | H mm | LH mm | LC mm | L mm |
|----|------------------|-------------------------|---------|---------|---------|----------|---------|----------|----------|---------|
| 2 | 2832.2,5x1H2-96 | - | 2.5 | 1 | 6 | 18 | 2 | 26 | 32 | 96 |
| 2 | 2832.4x2H2,5-96 | - | 4 | 2 | 9 | 18 | 2.5 | 26 | 32 | 96 |
| 3 | 2833.2,5x1H2-120 | - | 2.5 | 1 | 6 | 24.1 | 2 | 32 | 39 | 120 |
| 3 | 2833.4x2H2,5-120 | - | 4 | 2 | 9 | 24.1 | 2.5 | 32 | 39 | 120 |



Form R, carbide ring 60°, out-of-roundness \square 0.8 μ m

| MT | ID.No. | equal to STUDER* No. | D mm | d mm | LC mm | L mm |
|----|--------------|-------------------------|---------|---------|----------|---------|
| 2 | 2802.28x13,5 | 0166.026 | 28 | 13.5 | 30 | 94 |
| 2 | 2802.38x23 | 0166.029 | 38 | 23 | 32 | 96 |
| 3 | 2803.28x13,5 | 0709.058 | 28 | 13.5 | 30.5 | 111 |
| 3 | 2803.38x23 | 0709.059 | 38 | 23 | 32.5 | 113 |

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