

24110 - 24115

Dead Lathe Centres DIN 806

Type
Point angle 60°, fully hardened and ground.

24110
RÖHM
Type
Full centre.
Quality
Tool steel.

24113
RÖHM
Type
Full centre.
Quality
Carbide insert.

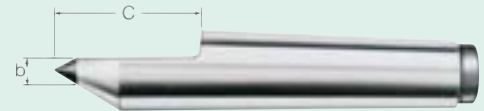
24115
Type
Half centre.
Quality
Carbide insert.



24110



24113



24115

MT	Overall length mm	no. 24115 b mm	no. 24115 c mm	24110	...	24113	...	24115	...
1	80	7	22	102				102	
2	100	7	30	103				103	
3	125	11	38	104		104		104	
4	160	14	50	105		105		105	
5	200	18	63	106		106		106	

24200

Live Lathe Centres



Type
Point angle 60°, ball-bearing mounted, fully hardened and ground. End of point made of high-quality tool steel, high true-running accuracy, smooth running.



24200

Size	MT	for workpieces up to max. kg	Lathe centre Ø mm	Housing Ø mm	24200	...
1	1	30	15	36	101	
2	2	50	20	45	102	
3	3	120	25	60	103	
4	4	220	32	70	104	

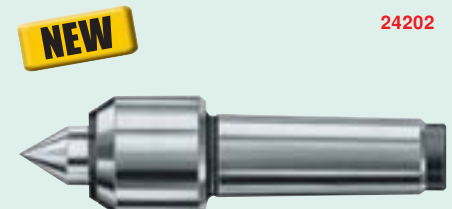
24202

Live Lathe Centres, lightweight, slim



Type
Point angle 60°, lightweight, with slim housing. Body and live centre hardened. Live centre full-hardened, can be reground several times. Precise roller bearings for high true-running accuracy. Maintenance-free thanks to life-time lubrication. Special seal to prevent ingress of dirt and coolant.

Application
Mainly for machining small and very small parts with small and large lathes.



24202

MT	length from spindle mm	Housing Ø mm	highest centre Ø mm	max. concentricity error mm	for workpiece weight kg	24202	...
2	62,0	32	15	0,005	200	101	
3	62,0	34	15	0,005	400	102	
4	75,5	42	20	0,005	800	103	
5	104,0	58	30	0,010	1600	104	

24204 - 24205

Live Lathe Centres



Type

Point angle 60°, multiple ball-bearing and needle roller bearing at end of point in shank. Housing and point drop-forged, hardened and ground. Stationary cap with special seal to keep out coolant and dirt.

Note:

Spare points available on request.

Note:

Size 101 - 104 with single-row radial bearings.

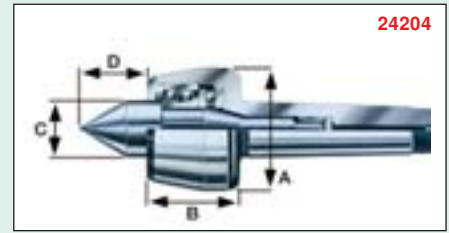
24205

Type

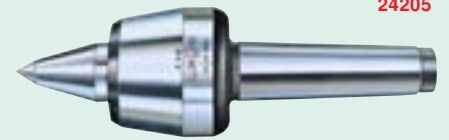
Lengthened point, permits unhindered engaging of the support.

Application

Particularly suited for tracer turning.



24204



24205

24204

Type

Standard point.

Size	MT	for workpieces up to max. kg	C mm	D mm	A mm	B mm	Concentricity deviation max. mm	Rotational speed max. rpm	24204	...	24205	...
101 H	1	100	15	17,0	36	37,5	0,005	7000			101	
102 H	2	200	20	24,0	45	34,0	0,005	7000			102	
104 H	3	400	22	27,5	50	36,5	0,005	6300			103	
106 H	3	500	25	31,0	60	42,0	0,005	5000			104	
108 H	4	800	32	41,0	70	53,0	0,005	3800			105	
110 H	5	2000	40	50,5	90	70,0	0,005	3000			106	
114 H	6	3500	50	57,5	105	81,5	0,010	2600			107	
102 HVL	2	140	10	34,0	45	34,0	0,005	7000				101
106 HVL	3	400	12	47,0	60	47,0	0,005	5000				102
108 HVL	4	500	14	53,0	70	53,0	0,005	3800				103
110 HVL	5	1200	16	65,0	90	65,0	0,005	3000				104

24206

Live Lathe Centres, Sets



Type

Body hardened, maintenance-free. Sets with 4 inserts (60° / 75° / 90° and 60° extended), 1 socket for hollow shapes, 1 ea. socket, large and small, for work pieces without centre, 1 ejector, in wooden box.



24206

Size	MT	24206	...
102 H	2		101
104 H	3		102
108 H	4		104
110 H	5		105

24207 - 24208

Live Lathe Centres



Type

Body hardened, maintenance-free. Without socket and ejector, true-running accuracy max. 0,01 mm.

Application

For exchangeable chuck collets, for all kinds of centring projects especially for single-part production.

Note:

Centres see cat.-no. 24209 - 24213.

24208

Ejector

Application

For removing points.



24207



24208

Size	MT	for workpieces up to max. kg	24207	...	24208	...
102 A	2	40		101		201
104 A	3	130		102		202
108 A	4	250		104		202
110 A	5	650		105		203

24209 - 24213

Exchangeable Points



24209

Extension point

Type

Type VL, point angle 60°.

Application

For live lathe centres cat.-no. 24207.

24210

Point

Type

60°.

Application

For live lathe centres cat.-no. 24207.

24213

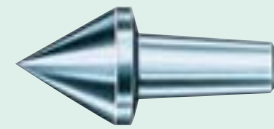
Point

Type

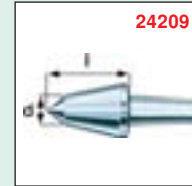
For hollow shapes 60°.

Application

For live lathe centres cat.-no. 24207.



24210



24209



24213

for Size	d mm	l mm	24209 ...
102A	6	25	101
104A	8	30	102
108A	12	43	104
110A	13	55	105

for size	Centres Ø mm	24210 ...
102A	16	101
104A	20	102
108A	28	104
110A	38	105

for Size	D mm	d mm	24213 ...
102A	25	10	101
104A	35	15	102
108A	55	30	104
110A	70	40	105

24231 - 24232

Live Lathe Centres 400 NC



Type

Point angle 60°, with shock absorption and high-precision bearings supported by laminated springs. Housing and point hardened and ground, maintenance-free.

Application

For abrupt loading (e.g. running the sleeve rapidly up to the workpiece) and high rotational speed applications at low axial load.

24231

Application

and high rotational speed.

24232

Type

With extractor nut.



24231



24232

Size cat.-no.	MT	for workpieces up to max. kg	Concentricity deviation max. mm	Rotational speed max. rpm	A mm	B mm	D mm	H mm	K mm	M mm	24231 ...	24232 ...
24231 / 24232												
424 / 484	4	1000	0,005	7000	122	70	16	6,5	44	100	101	101
425 / 485	5	2000	0,005	6000	150	95	20	6,5	59	125	102	102

24260

Live Lathe Centres



Type

Point angle 60°, point preloaded. Housing and point hardened and ground. Pressure display for an accurate reading of the axial clamping force in daN.

Application

Also suitable for normal chucking.

Note:

Especially suitable as counter centre with face drivers, cat.-no. 25230 - 25239, to maintain a constant axial clamping force between the centres (permanent reclamping). With extended point available on request.



24260

Size	MT	axial clamping force max. daN	D mm	E mm	B mm	F mm	Concentricity deviation max. mm	24260 ...
503	3	550	25	31,5	64	67	0,01	101
504	4	900	32	39,0	72	76	0,01	102
505	5	1500	40	49,0	95	103	0,01	103

24300

Live Lathe Centres

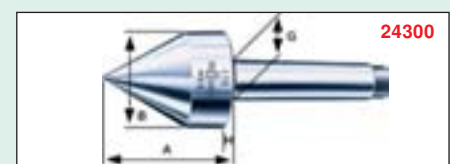


Type

Pointed taper, 60°, sturdy bearing, mounting shank and body, as well as taper hardened.

Application

Used as lathe centre for hollow shapes and as a centre point for machining normal workpieces.



24300

Size	MT	A mm	B mm	H mm	G mm	Workpiece weight max. kg	Concentricity deviation max. mm	24300 ...
272	2	61	42	7,0	17,780	200	0,01	101
273	3	79	56	7,0	23,825	400	0,008	102
274	4	100	64	8,5	31,267	800	0,008	103

• Live lathe centres • Face driver

24501 - 24502

Live Lathe Centres



Type

Sturdy bearing, high true-running accuracy, body and housing hardened and ground, maintenance-free.

Application

For accomodating very large axial and radial forces. For machining pipes and other hollow shapes.

24501

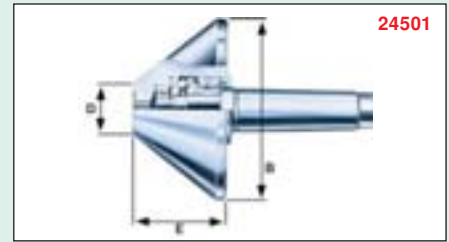
Type

Point angle 60°.

24502

Type

Point angle 75°.



Size	MT	D mm	B mm	E mm	for workpieces up to max. kg	Concentricity deviation max. mm	60°		75°	
							24501	...	24502	...
171A	2	20	50	52	200	0,008	102			
172	2	30	80	64	300	0,008	103			
172A	3	30	80	64	400	0,008	104			
172B	4	30	80	64	400	0,008	105			
172	2	20	80	67	300	0,008				101
172A	3	20	80	67	400	0,008				102
172B	4	20	80	67	400	0,008				103
173	3	30	120	72	600	0,008				104
173A	4	30	120	72	800	0,008				105
173B	5	30	120	72	800	0,008				106
174	4	50	170	90	1200	0,01				107
174A	5	50	170	90	1600	0,01				108

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Performance requires quality.

Short chucks by ATORN:

- high-strength materials
- perfect concentricity accuracy
- large clamping range
- high clamping force

This is but one example of ATORN's high-quality clamping tools.

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