

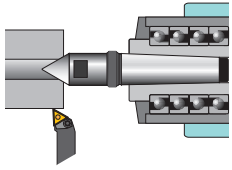
Tool Steel Dead Centres with Draw-Off Thread



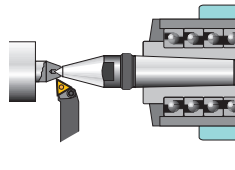
Morse taper, metr. 80 1:20, taper 80 1:10

Form 255 – 256 – 257 – 258

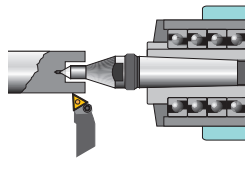
Interchangeable dead centres, through-hardened for revolving tailstock sleeves. **Special designs available on request.**



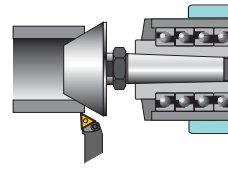
Form 255
for small and large
centrebores



Form 256
for limited work space



Form 257
for threading and for centre-
bores deep inside a workpiece



Form 258
for large centrebores

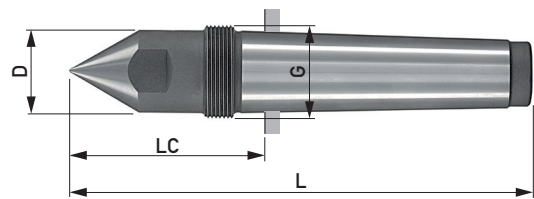
Material
High quality tool steel,
through-hardened

Runout
MT 2 0.003 mm, MT 3-MT 6 0.004 mm
Metr. 80/Taper 80 0.005 mm

Taper shank
Manufactured in gauge accuracy to DIN
228 ≤ AT4. This means a precise seating
of the centre in the tailstock sleeve.

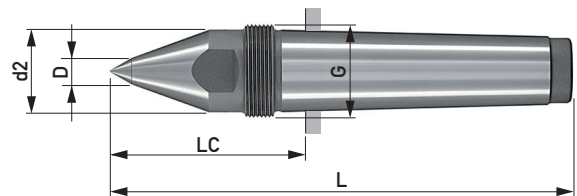
Form	Taper size	ID.No.	D	G	SW	LC	L	Draw-off nut
255	MT 2	2552	18	M22x1.5	16	48	112	M252
		2553	24.1	M27x1.5	22	57	138	M253
	MT 3	2553-150	24.1	M27x1.5	22	69	150	M253
		2553-170	24.1	M27x1.5	22	89	170	M253
		2554	31.6	M36x1.5	27	72.5	175	M254
	MT 4	2554-190	31.6	M36x1.5	27	87.5	190	M254
		2554-230	31.6	M36x1.5	27	127.5	230	M254
		2555	44.7	M48x1.5	41	87.5	217	M255
	MT 5	2555-250	44.7	M48x1.5	41	120.5	250	M255
		2556	63.8	M68x1.5	55	108	290	M256
Metr. 80 1:20	2557.20	80	M85x2	-	134	330	M257	
Taper 80 1:10	2557.10	80	M85x2	-	130	330	M257	

Form 255
similar to DIN 807 and extended, 60°



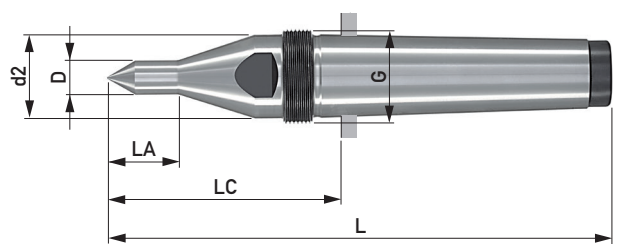
Form	Taper size	ID.No.	D	d2	G	SW	LC	L	Draw-off nut
256	MT 2	2562	6	18	M22x1.5	16	48	112	M252
	MT 3	2563	8	24.1	M27x1.5	22	57	138	M253
	MT 4	2564	10	31.6	M36x1.5	27	72.5	175	M254
	MT 5	2565	12	44.7	M48x1.5	41	87.5	217	M255
	MT 6	2566	15	63.8	M68x1.5	55	136	318	M256

Form 256
copying centre 60°/40°



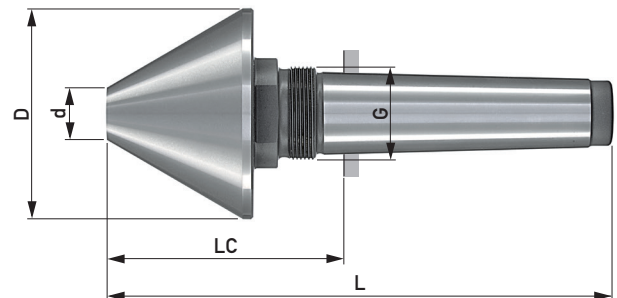
Form	Taper size	ID.No.	D	d2	G	SW	LA	LC	L	Draw-off nut
257	MT 2	2572.06-120	6	18	M22x1.5	16	15	56	120	M252
		2572.09-120	9	18	M22x1.5	16	17	56	120	M252
		2572.11-120	11	18	M22x1.5	16	21	56	120	M252
	MT 3	2573.09-150	9	24.1	M27x1.5	19	17	69	150	M253
		2573.13-150	13	24.1	M27x1.5	19	25	69	150	M253
		2574.09-190	9	31.6	M36x1.5	27	17	87.5	190	M254
	MT 4	2574.13-190	13	31.6	M36x1.5	27	27	87.5	190	M254
		2574.19-190	19	31.6	M36x1.5	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	MT 2	2582.40	40	1	M22x1.5	36	64	128	M252
		2582.80x20	80	20	M22x1.5	36	88	152	M252
	MT 3	2583.40	40	1	M27x1.5	36	65	146	M253
		2583.80x20	80	20	M27x1.5	36	89	170	M253
	MT 4	2584.80x20	80	20	M36x1.5	36	89.5	192	M254
		2584.125x65	125	65	M36x1.5	36	89.5	192	M254
		2585.80x20	80	20	M48x1.5	50	100.5	230	M255
	MT 5	2585.100x50	100	50	M48x1.5	50	90.5	220	M255
		2585.125x65	125	65	M48x1.5	50	100.5	230	M255

Form 258
bullnose dead centre 60°



Draw-off nut to DIN 807

ID.No.	G	LM	SW
M252	M22x1.5	15.5	32
M253	M27x1.5	17.5	41
M254	M36x1.5	21	55
M255	M48x1.5	23	75
M256	M68x1.5	25.5	100
M257	M85x2.0	40	130

