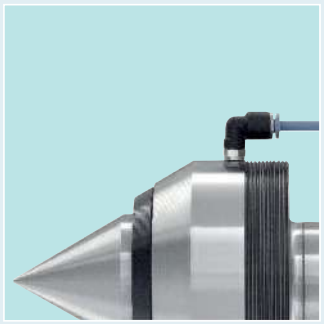
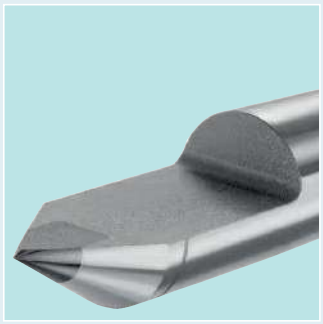
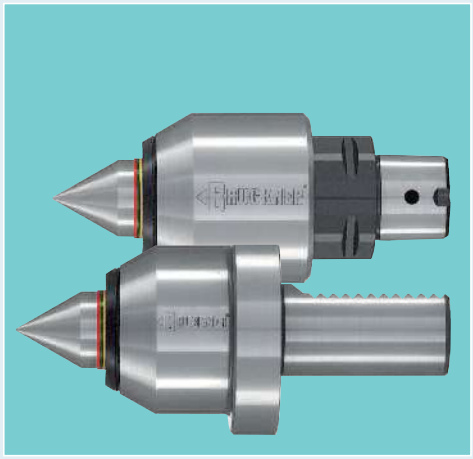
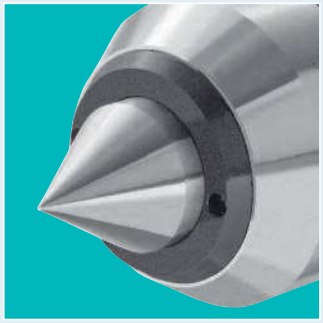
BRUCKNER®
Precision and reliability first

High Performance Centres

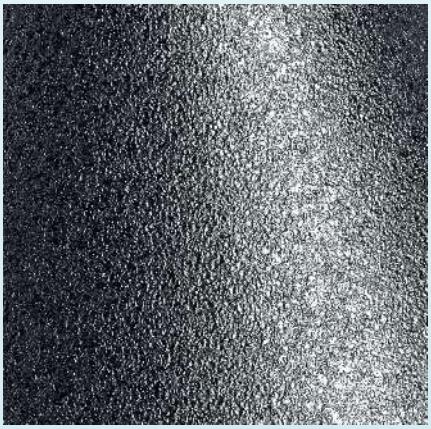
for Turning and Grinding

CARBIDOR® features
Permanent connection with the carrier material, impact resistant

High hardness 74 – 78 HRC
Surface roughness:
CARBIDOR®-F Rz 15 µm
CARBIDOR®-M Rz 17 µm
CARBIDOR®-G Rz 19 µm
Coating thickness: approx. 25 µm

In case of wear re-coating is possible.

CARBIDOR® coated tool steel dead centres for gear cutting, fine turning, finishing, measuring/inspection



CARBIDOR® surface structure

CARBIDOR®

is tungsten carbide based coating especially developed to drive workpieces. The coating can be applied to all hard tool steels and particularly features wear resistance, high coefficient of friction and low coating thickness.

CARBIDOR® is applied to enhance friction between workpiece and clamping tool. In this case almost all shapes can be coated. To drive by a workpiece centre, the centre must be ≥ 4 x 2 mm. The axial pressure should be as high as possible.

CARBIDOR® coating is applicable to

- BRUCKNER standard tool steel dead centres (pages 63 – 65)
- tool steel dead centres in special design
- all soft, hardened components of tool steel and stainless steel, jaws, spheres, collets etc.

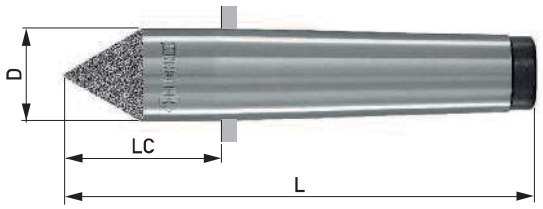
Please pay attention to our safety tips for process reliability of driving coatings.
www.karlbruckner.de/prs

Tool Steel Dead Centres
with CARBIDOR®-M Coating
Form 250CA – 255CA – 257CA – 258CA

coated surface

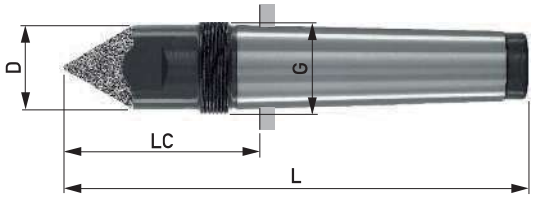
Form	MK	ID.No.	D	LC	L
250CA	2	2502CA	18.0	36.0	100
	3	2503CA	24.1	44.0	125
	4	2504CA	31.6	57.5	160

Form 250CA
full centre 60°, without draw-off thread



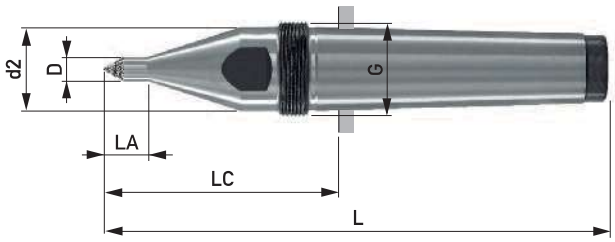
Form	MK	ID.No.	D	G	SW	LC	L	Draw-off nut
255CA	2	2552CA	18.0	M22x1.5	16	48	112	M252
	3	2553CA	24.1	M27x1.5	22	57	138	M253
	4	2554CA	31.6	M36x1.5	27	72.5	175	M254

Form 255CA
full centre 60°, with draw-off thread



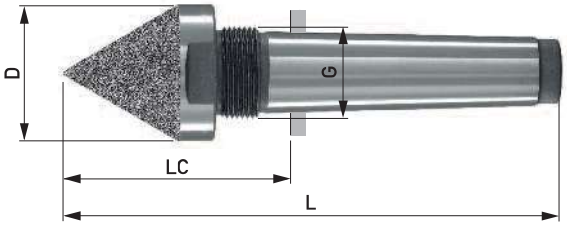
Form	MK	ID.No.	D	d2	G	SW	LA	LC	L	Draw-off nut
257CA	2	2572.06-120CA	6	18	M22x1.5	16	15	56	120	M252
	2	2572.09-120CA	9	18	M22x1.5	16	17	56	120	M252
	2	2572.11-120CA	11	18	M22x1.5	16	21	56	120	M252
	3	2573.09-150CA	9	24.1	M27x1.5	19	17	69	150	M253
	3	2573.13-150CA	13	24.1	M27x1.5	19	25	69	150	M253
	4	2574.09-190CA	9	31.6	M36x1.5	27	17	87.5	190	M254
	4	2574.13-190CA	13	31.6	M36x1.5	27	27	87.5	190	M254
	4	2574.19-190CA	19	31.6	M36x1.5	27	53	87.5	190	M254

Form 257CA
slim centre 60°/30°, with draw-off thread

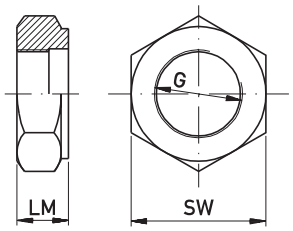


Form	MK	ID.No.	D	G	SW	LC	L	Draw-off nut
258CA	2	2582.40CA	40	M22x1.5	36	64	128	M252
	3	2583.40CA	40	M27x1.5	36	65	146	M253

Form 258CA
bullnose dead centre 60°, with draw-off thread



Draw-off nut to DIN 807			
ID.No.	G	LM	SW
M252	M 22x1.5	15,5	32
M253	M 27x1.5	17,5	41
M254	M 36x1.5	21	55



Please pay attention to our safety tips for process reliability of driving coatings: www.karlbruckner.de/prs

BRUCKNER®
Precision and reliability first

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with hydraulic compensation

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