

Revolving Centre



At a glance

- Centre inserts with internal centre and blanks for revolving centre
- Interchangeable centres made of carbide with different diameters matching all taper 2° centre holders
- Adjustable pressure for consistent operation
- Also available with hollow (female) centres
- Heavy-duty and durable Swiss quality products

ANGST Revolving Centre

The revolving centre is mounted in the turret. The shaft with inserted centre-point is spring loaded and rotates with the workpiece. The spring pressure can be adjusted to suit the prevailing conditions. The centre-points are carbide/stellite coated and interchangeable to suit different workpiece centre sizes.

Revolving Centre

$\varnothing d \times l$	No.	C	$\varnothing D$	E	F	H max.
Centres exchanged with extractor (Fig. 1)						
$\frac{3}{4}'' \times 28$	28-1001	25	33	29	16	5
20 x 28	28-1002	25	33	29	16	5
MK 3	28-1403	52	50	-	16	5
Centres exchanged with nut (Fig. 2)						
25 x 45	28-3007	25	35	-	16	6
1" x 45	28-3008	25	35	-	16	6
30 x 55	28-3009	25	35	-	16	6
MK4 4	28-3404	69	55	-	16	6

NOTE

To ensure free running, do not overtighten when clamping the centre in the turret.

Fig. 1

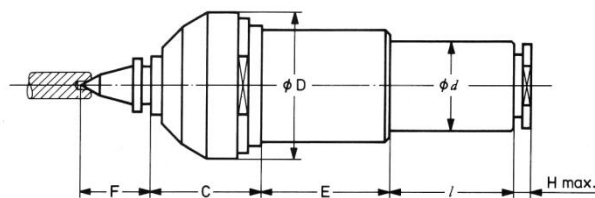
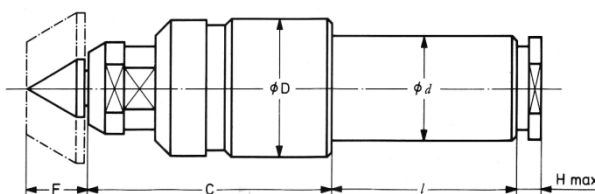


Fig. 2



Insertion centres with internal centre and blanks

Interchangeables insertion centres matching all taper 2° centre holders				
Centres 60°	A	B	C	Fig.
With HSS centre				
28-2031	12	4	15	3
28-2032	12	6	15	3
28-2033	12	-	15	4
28-2034	15	-	18	4
28-2041	16.5	9	11	5
28-2042	18.5	11	11	5
28-2043	20.5	13	11	5
28-2044	22.5	15	11	5
28-2045	24.5	17	11	5
28-2046	26.5	19	11	5
28-2047	28.5	21	11	5
28-2048	30.5	23	11	5
28-2049	35.5	26	12	5
28-2050	40	31	12	5
28-2051	45	36	12	5
28-2052	50	41	12	5
28-2053	55	46	12	5
28-2054	60	51	12	5
With HM centre				
28-2011	∅ 5	-	-	6
28-2014	∅ 23	∅ 36	-	7
28-2220	12	6	16	8
With inside centre 60°				
28-2215	0.5	15	19	9
28-2216	1	15	19	9
28-2217	2	15	19	9
28-2218	3	15	19	9
28-2015	4	15	19	9
28-2016	5	15	19	9
28-2017	10	15	19	9
28-2018	15	15	19	9
Blanks unhardened, raw material 100Cr6, taper ground				
28-2010	12	-	19	10
28-2009	30	-	22	10
Centre Extractor				
28-2020				11

Fig. 3

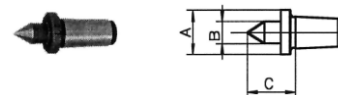


Fig. 4

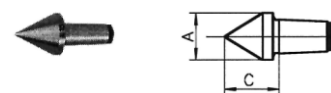


Fig. 5

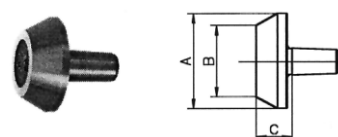


Fig. 6



Fig. 7

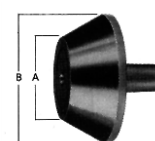


Fig. 8

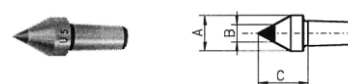


Fig. 9

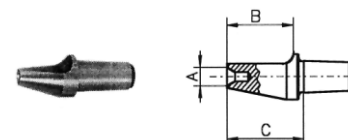


Fig. 10

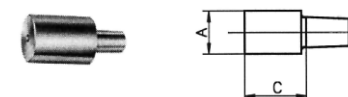


Fig. 11

