

Types NCE 34, NCE 44

For high r.p.m.
Centre spindle with internal taper 1:7.5
for interchangeable inserts
 with draw-off thread

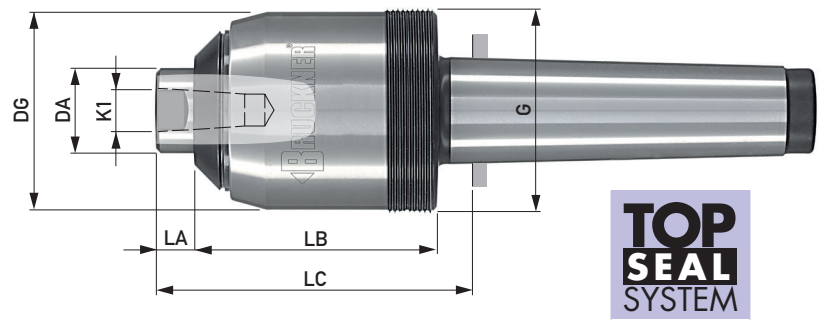
Runout

max. 0.005 mm, with test report

Application

Variable clamping possibilities for CNC turning through interchangeable inserts. In the case of a collision or insert wear, type NCE offers the advantage that, simply by changing the insert, the high performance centre is immediately ready for use again.

Multiple use is made possible by eight different insert styles.



Type NCE	ID.No	34.045-2	34.045-3	44.058-3	34.058-4	44.076-4	34.076-5	44.095-5	34.095-6
Draw-off nut	ID.No.	M45A	M45A	M60	M60	M80	M80	M100	M100
Morse taper		2	3	3	4	4	5	5	6
DA		20	20	25	25	35	35	45	45
DG		45	45	58	58	76	76	95	95
K1		11	11	15	15	22	22	28	28
LA		9	9	11	11	13	13	14	14
LB		57	57	70	70	81	81	103	103
LC		72	73	88	88	101	101	124	124
G		M45x2	M45x2	M60x1.5	M60x1.5	M80x2	M80x2	M100x2	M100x2
SW (spanner flat)		16	16	22	22	30	30	41	41
r.p.m. max.		8000	8000	7000	7000	6000	6000	5000	5000
Suitable insert		482..	482..	484..	484..	487..	487..	485..	485..
Load	The load of type NCE is limited by the interchangeable inserts								

The thread structure of the ID.Nos. 34.045-2 and 34.045-3 is similar to that of version A, fitting the special nut for version A



BRUCKNER TOP-SEAL-SYSTEM

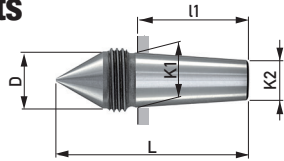
- The coolant does not impact the seal, but flows with reduced energy into the first labyrinth channel.
- There the largest part of the coolant is drained through the first drain aperture.
- The small residue is wiped off the seal into the second labyrinth channel and flows through the second drain aperture.



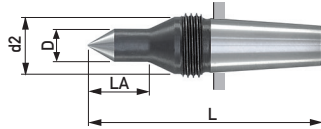
Interchangeable inserts

taper 1:7.5, in gauge accuracy

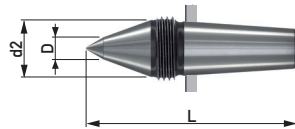
Form A0, 60°
with draw-off nut



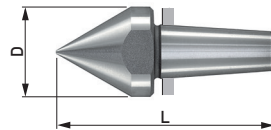
Form ASL, 60°
slim, extended
with draw-off nut



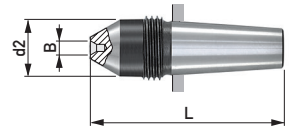
Form AKOP, 60°/40°
extended
with draw-off nut



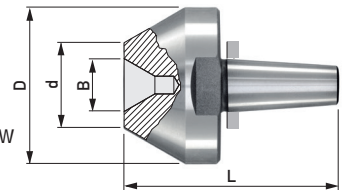
Form A, 60°
for hollow parts
spanner flat (SW)



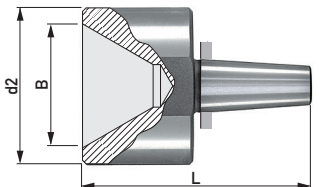
Form B, centre 60°
for centreless workpieces,
with draw-off nut



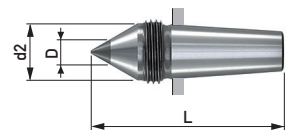
Form C, centre 60°
for centreless workpieces,
external angle 60° for hollow
parts, spanner flat (SW)



Form D, centre 60°
for centreless workpieces,
spanner flat (SW)



Form AOHM, 60°
with carbide insert
with draw-off nut



Basic centre Type: NCE	Interchangeable inserts	Workpiece weight max. daN	Insert dimensions						Thread SW	Taper dimensions taper 1:7.5		
ID.No.	ID.No.		D	d2	B	d	L	LA		K1	K2	I1
34.045-2 34.045-3	482A0	90	11.7				45		M14x1.5	11	8	23
	482ASL	30	6	11.7			55	15	M14x1.5			
	482AKOP	90	5	11.7			50		M14x1.5			
	482A	90	17				45		SW14			
	482B	90		11.7	4x2		45		M14x1.5			
	482C	90	28		8x3	12	45		SW24			
	482D	90		28	20x6		45		SW24			
	482AOHM	60	7	11.7			45		M14x1.5			
44.058-3 34.058-4	484A0	160	15.7				53		M18x1.5	15	11	30
	484ASL	100	9	15.7			65	17	M18x1.5			
	484AKOP	160	6	15.7			58		M18x1.5			
	484A	160	25				60		SW22			
	484B	110		15.7	4x2		53		M18x1.5			
	484C	160	44		15x5	24	60		SW41			
	484D	160		44	35x12		64		SW41			
	484AOHM	60	7	15.7			53		M18x1.5			
44.076-4 34.076-5	487A0	300	21.6				74		M24x1.5	22	16.4	42
	487ASL	100	9	21.6			86	17	M24x1.5			
	487AKOP	300	8	21.6			80		M24x1.5			
	487A	300	32				82		SW27			
	487B	240		21.6	5x2.5		74		M24x1.5			
	487C	300	55		20x6	30	82		SW50			
	487D	300		55	45x15		85		SW50			
	487AOHM	200	11	21.6			74		M24x1.5			
44.095-5 34.095-6	485A0	500	27.7				93		M30x1.5	28	21	52.5
	485ASL	180	13	27.7			110	27	M30x1.5			
	485AKOP	500	8	27.7			105		M30x1.5			
	485A	500	45				105		SW41			
	485B	500		27.7	7x3		93		M30x1.5			
	485C	500	65		25x6	35	105		SW55			
	485D	500		65	55x20		105		SW55			
	485AOHM	500	18	27.7			93		M30x1.5			

ID.No.	Content
P 10	100 g

Installation paste

Makes insert change easier.
Apply thinly and evenly to the insert taper.