

Adapter sleeve Type KE

With internal taper 1:7.5
for interchangeable inserts.
Made from alloy case-hardening steel,
hardened, with draw-off thread,
internally and externally precision-ground

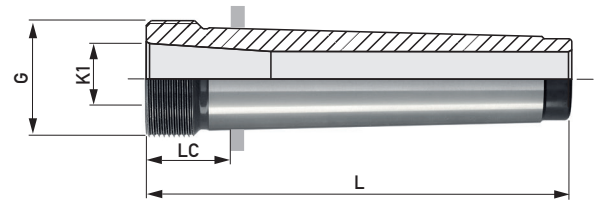
Runout
max. 0.003 mm

Application

For regrinding interchangeable inserts.
Combined with the inserts
use as a dead centre in the headstock
and tailstock for special applications.



► Draw-off nut to DIN 807,



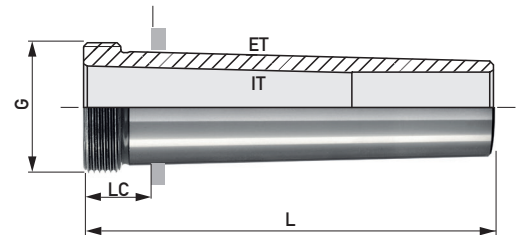
| Morse taper | Type KE ID.No. | Draw-off nut | K1 | G | LC | L | Insert size |
|-------------|----------------|--------------|----|---------|------|-----|-------------|
| 2 | 2952A | M252 | 11 | M22x1.5 | 16 | 80 | 482.. |
| 3 | 2953A | M253 | 15 | M27x1.5 | 21 | 102 | 484.. |
| 4 | 2954A | M254 | 22 | M36x1.5 | 25.5 | 128 | 487.. |
| 5 | 2955A | M255 | 28 | M48x1.5 | 30.5 | 160 | 485.. |

Reduction sleeve Type SPHA

of alloy case-hardening steel, hardened,
with draw-off thread, internally and externally
precision-ground

Runout
Max. 0.003 mm

► Draw-off nut to DIN 807,



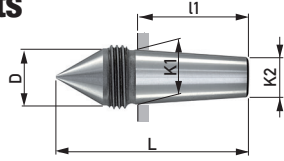
| Taper size | | Type SPHA | | | | |
|------------------|----------|-----------|---------------------|------|---------|------|
| external | internal | ID.No. | Draw-off nut ID.No. | LC | G | L |
| ET | IT | | | | | |
| MT 3 | MT 2 | 6032A | M253 | 17.5 | M27x1.5 | 91.5 |
| MT 4 | MT 2 | 6042A | M254 | 16.5 | M36x1.5 | 110 |
| | MT 3 | 6043A | M254 | 16.5 | M36x1.5 | 110 |
| MT 5 | MT 2 | 6052A | M255 | 16.5 | M48x1.5 | 132 |
| | MT 3 | 6053A | M255 | 16.5 | M48x1.5 | 132 |
| | MT 4 | 6054A | M255 | 16.5 | M48x1.5 | 132 |
| MT 6 | MT 4 | 6064A | M256 | 21.5 | M68x1.5 | 166 |
| | MT 5 | 6065A | M256 | 21.5 | M68x1.5 | 166 |
| Metr. 80 1:20 | MT 5 | 6805A | M80* | 20 | M80x2 | 192 |
| | MT 6 | 6806A | M80* | 20 | M80x2 | 192 |
| Taper 80 1:10 | MT 6 | 6806.1A | M80* | 20 | M80x2 | 192 |

*Similar to DIN 1804

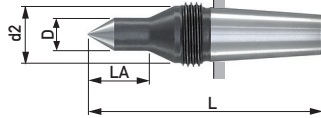
Interchangeable inserts

taper 1:7.5, in gauge accuracy

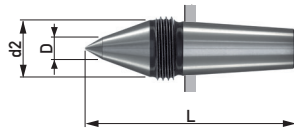
Form A0, 60°
with draw-off nut



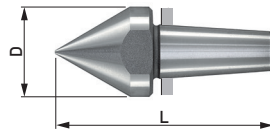
Form ASL, 60°
slim, extended
with draw-off nut



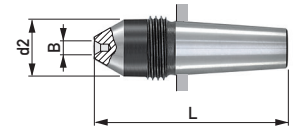
Form AKOP, 60°/40°
extended
with draw-off nut



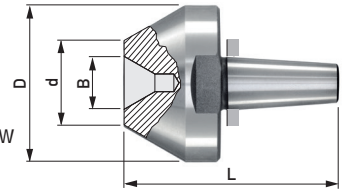
Form A, 60°
for hollow parts
spanner flat (SW)



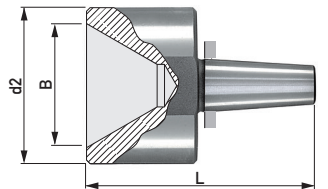
Form B, centre 60°
for centreless workpieces,
with draw-off nut



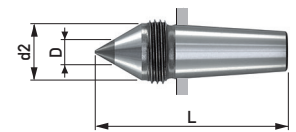
Form C, centre 60°
for centreless workpieces,
external angle 60° for hollow
parts, spanner flat (SW)



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



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



| Basic centre Types: SE, SEG, ASE KE (page 78) | Interchangeable inserts | Workpiece weight max. daN | Insert dimensions | | | | | | Thread SW | Taper dimensions taper 1:7.5 | | |
|---|----------------------------|---------------------------------|-------------------|------|-------|----|-----|----|--------------|---------------------------------|------|------|
| | | | D | d2 | B | d | L | LA | | K1 | K2 | I1 |
| 5482 5482G 5483 5483G 2952A | 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 | | | |
| 5484 5484G 5486 5486G 5484A 5486A 2953A | 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 | | | |
| 5487 5487G 5487A 2954A | 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 | | | |
| 5485 5485G 5485A 2955A | 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.