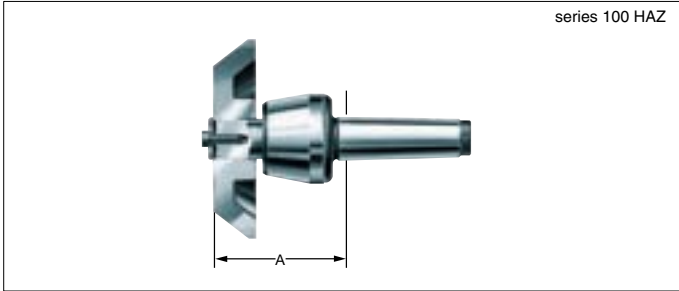
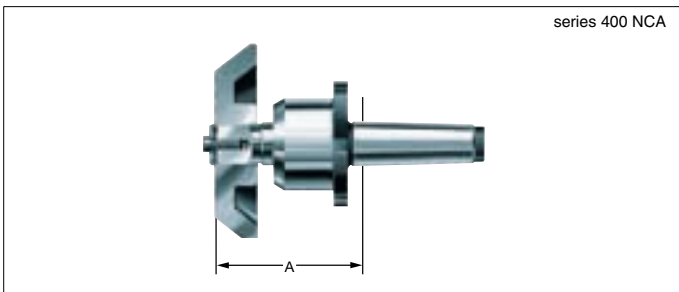


Type 608-00 Revolving tailstock center



Size	108	110	114			
MT	4	5	6			
Id.-No. ¹⁾	304562	304563	304564			
Workpiece weight max. kg	800	1600	3000			
A	103	128	159			
ca. kg	2,2	4,8	12			

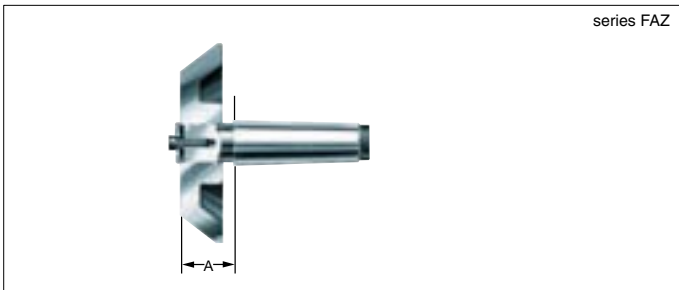
Type 640-90 Revolving tailstock center with draw-off nut, for high charge



Size	494	495	496			
MT	4	5	6			
Id.-No. ¹⁾	304583	304584	304585			
Workpiece weight max. kg	1000	2000	3500			
A	118	140	168			
ca. kg	3,2	6,5	13,5			

Type 698-00 Fixed shafts

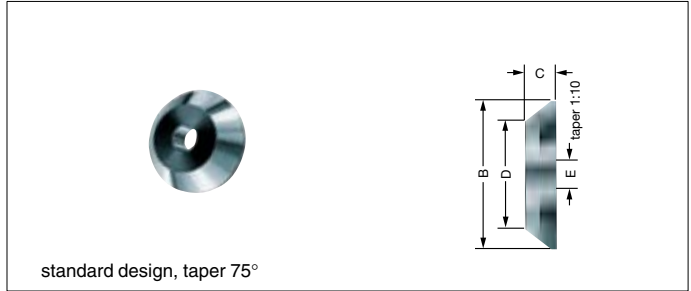
Tool group 07



Size	–	–	–			
MT	4	5	6			
Id.-No. ¹⁾	304580	304581	304582			
workpiece weight	2000	4800	12000			
A	45	60	70			
ca. kg	0,8	2,0	5,5			

¹⁾ including fixing screw and washer, without insert

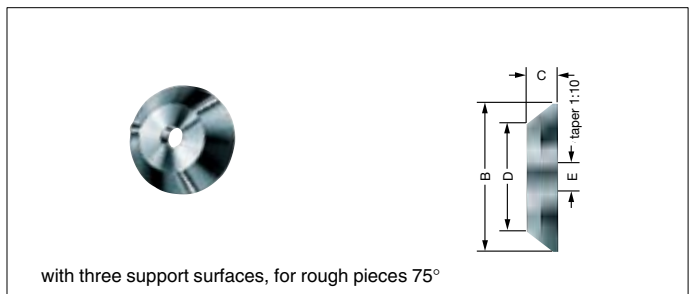
Suitable insert attachments for centering tapers **AZ**



size of insert	for MT	Id.-No.		B	C	D	E	ca. kg
1	4	304565²⁾		60	68	5	32	0,9
2	4	304566		100	45	45	32	1,5
3	4	304567		150	45	95	32	4,1
4	4	304568		200	45	145	32	6,0
5	4	304569		250	45	195	32	8,5
1	5	304570		100	43	45	40	1,5
2	5	304571		150	43	95	40	4,4
3	5	304572		200	43	145	40	6,1
4	5	304573		250	43	195	40	8,1
5	5	304574		300	43	245	40	11,6
1	6	304575		150	54	95	50	3,0
2	6	304576		200	54	145	50	8,1
3	6	304577		250	54	195	50	11,1
4	6	304578		300	54	245	50	14,0
5	6	304579		350	54	295	50	18,8

²⁾ without fixing by screw and washer

Suitable insert attachments for centering tapers **AZR**

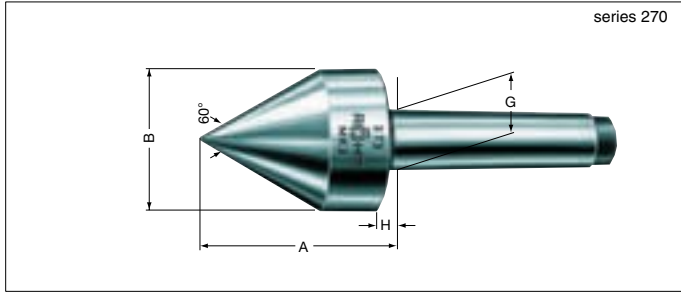


size of insert	for MT	Id.-No.		B	C	D	E	ca. kg
2	4	304736		100	45	45	32	1,5
3	4	304737		150	45	95	32	4,1
4	4	304738		200	45	145	32	6,0
5	4	304739		250	45	195	32	8,5
1	5	304740		100	43	45	40	1,5
2	5	304741		150	43	95	40	4,4
3	5	304742		200	43	145	40	6,1
4	5	304743		250	43	195	40	8,1
5	5	304744		300	43	245	40	11,6
1	6	304745		150	54	95	50	3,0
2	6	304746		200	54	145	50	8,1
3	6	304747		250	54	195	50	11,1
4	6	304748		300	54	245	50	14,0
5	6	304749		350	54	295	50	18,8

Tool group 06

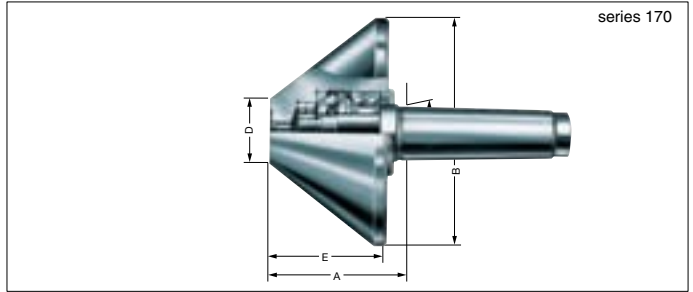
ROHM Revolving Centering Tapers

Type 627 Revolving centering taper, pointed. As centering taper for tubular workpieces and as a revolving tailstock center to machine normal workpieces



Size	272	273	274	275	276
MT	2	3	4	5	6
Id.-No.	010613	010635	010638	010642	306396
Workpiece weight max. kg	200	400	800	1600	2500
Concentr. error max.	0,01	0,008	0,008	0,008	0,008
A	61	79	100	115,5	153
B	42	56	64	78	105
G	17,780	23,825	31,267	44,399	63,348
ca. kg	0,4	1,1	1,6	3,6	

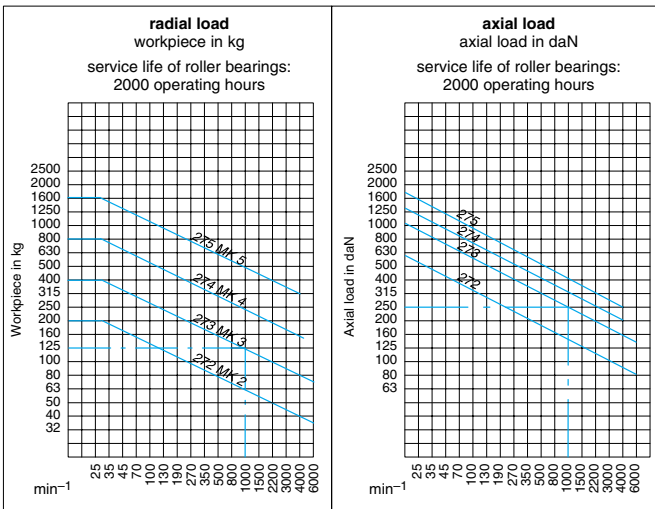
Type 617/618 Revolving tailstock center



Size	MT	Id.-No.	workpiece weight max. kg	concentr. error max.	A	B	D	E	ca. kg
Type 617-60°									
171	1	301615	100	0,008	64	50	20	52	0,9
171a	2	301616	200	0,008	65	50	20	52	1,2
172	2	301556	300	0,008	77	80	30	64	2
172a	3	301557	400	0,008	77	80	30	64	2,2
172b	4	301558	400	0,008	78,5	80	30	64	2,3
173	3	221605	600	0,008	96,5	120	30	83	4,2
173a	4	044023	800	0,008	98	120	30	83	4,5
173b	5	090483	800	0,008	99	120	30	83	5,3
Type 618-75°									
172	2	301559	300	0,008	80	80	20	67	2,0
172a	3	301560	400	0,008	80	80	20	67	2,0
172b	4	301561	400	0,008	81,5	80	20	67	2,4
173	3	062211	600	0,008	85,5	120	30	72	4,2
173a	4	062224	800	0,008	87	120	30	72	4,3
173b	5	062232	800	0,008	88	120	30	72	5,1
174	4	062299	1200	0,01	107	170	50	90	9,7
174a	5	063614	1600	0,01	106	170	50	90	10,6
174b	6	063633	1600	0,01	107,5	170	50	90	13,3
175	5	063662	2000	0,01	146,5	250	75	130	34
175a	6	063656	2000	0,01	148	250	75	130	37
176	6	063680	4000	0,015	184	350	120	168	82

Load Diagrams

Example Type 627: admissible load of revolving tailstock center 273 at 1000 min⁻¹ radially = 125 kg workpiece, axially = 240 daN



example Type 617 and 618: admissible load of revolving tailstock center 176 at 800 min⁻¹ radially = 2500 kg workpiece, axially = 2800 daN

