

**SAME DAY SHIPPING\***  
800-USA-TURN



*Centers Designed to Last a Lifetime*



The Original US Manufacturer of Live, Dead Centers & Grinder Dogs  
Since 1908

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## CUSTOMER SERVICE

Ready Tool employs only knowledgeable customer service representatives to assist you in choosing the appropriate center to meet your work holding need.

## ENGINEERING

Ready Tool has an engineering staff on hand to answer all your technical questions without delay.

## NO MINIMUM ORDER

Ready Tool is committed to customer service and has no minimum order value or drop shipping fee.

## SPECIALS

Ready Tool welcomes the opportunity to supply specials to our valued customer. Just call, fax, or mail us a sketch and we will send you a prompt reply. Most specials are quoted on the same day of receipt. Expedite delivery service is available at a small charge.

## REBUILD & REPAIR POLICY

We offer prompt repair and rebuilding services on all our products. User to return product shipping prepaid. We reserve the right to scrap material held at our facility after a six month period, if unclaimed or unresponsive.

## \*SAME DAY SHIPPING

Call by 3:00 pm ET and we will ship any in stock item the same day. We have a 95% fulfillment rate.

## TECHNICAL INFORMATION

### General

The Ready Tool Co. uses the finest quality tool steel for all our products. Parts (contacting your workpiece) are through hardened to ensure long life and consistent hardness. Carbide tip solid centers have soft body and toughened back end. All standard centers have a  $60^{\circ} \pm 30' /_{\pm 0}$  included angle, females are  $60^{\circ}$ . All dimensions are in inches. Fractional dimensions are +/- .062. When ordering please specify Model No. and Taper. The Ready Tool Co. reserves the right to change or improve its products or designs without obligating itself to make such changes or improvements on previously sold products. All products may not be exactly as pictured in the catalog. Special items are considered non-returnable. The Ready Tool Co. disclaims all responsibility for its products used in operations exceeding RPMs and loads of those specified in the catalog. Information in this catalog supercedes all other catalogs. We reserve the right to substitute a product with one of like dimensions and better quality if lesser in not available.

### Load Ratings

Loads are based on the B-10 Life Factor of 3800 Hrs at 100 R.P.M. The maximum workpiece weight listed is based on the assumption that the workpiece will be supported between the headstock and footstock, and does not take into consideration the radial load applied by the cutting or grinding forces. Shank and bearing assemblies are matched to support maximum workpiece weights. Reducing a given shank size proportionately reduces the load carrying capacity. Increasing the shank size does not increase the load capacity. Guaranteed TIR (runout) is checked between centers, from shank to standard point, and is based on a load free center. Usage of a sleeve is not a recommended practice.

### Warranty

Ready Tool Centers and Dogs carry a 90 day guarantee against defects in workmanship and materials. Proper adjustment or replacement will be made upon return of the tool to Ready Tool, subject to our inspection. Warranty may be voided if tool has been modified, tampered with, damaged, repaired by customer, or outside repair facility. Regrinding of any centers will be held to a T.I.R. of +/- .0002 .

### Terms

The Ready Tool terms are Net 30, Prepay and Add Shipping and Handling, FOB West Hartford, CT., 06110. Centers returned for credit must be new and unused and will be subject to a 20% restocking fee. Specials are considered non-returnable.

## The Ready Tool Repair Guarantee

Our Standard Live Center will be totally reconditioned at 45% of the list cost of a new Live Center. If a Ready Tool Standard Live Center is beyond practical repair we will issue a 20% discount towards the purchase of a new equivalent Live Center. We regrind & repair Solid Centers of all makes.

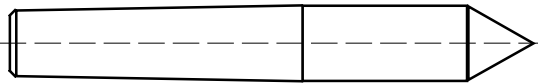
## Ready Tool Standard Solid Centers

**Accuracy:** To +/- .0001 TIR.

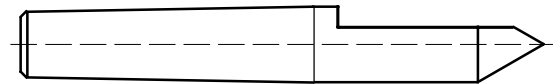
- \* High quality standard tool steel solid centers.
- \* Carbide hardness 77-79 Rc.
- \* Style -1 & -2 are through hardened 60-62 Rc.
- \* Style -3 & -4 the back end is hardend only.
- \* Points ground to  $60^{\circ} +30' / -0$ .

- \* Ready safety "Life Line" on carbide solid centers shows the safe regrind level.
- \* Carbide is brazed into socket for maximum rigidity and life.
- \* Use half centers -2 & -4 when tool or grinding wheel clearance is needed.

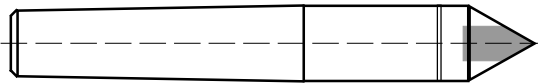
Style -1



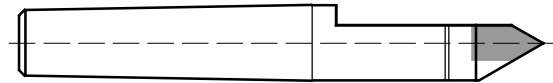
Style -2



Style -3



Style -4



### JARNO TAPER

Taper	A	B	C/H	D	E	F	G
6-4.5 J	4 1/2	3	.750	.600	3/8	3/16	1 1/8
6-5.5 J	5 1/2	3	.750	.600	3/8	3/16	2 3/16
6-6 J	6	3	.750	.600	3/8	3/16	2 1/2
7 J	5 1/4	3 1/2	.875	.700	3/8	3/16	1 3/16
8 J	6	4	1.000	.800	1/2	1/4	1 5/8
9 J	6 3/4	4 1/2	1.125	.900	1/2	1/4	1 7/8
10 J	7 1/2	5	1.250	1.000	1/2	1/4	2
11 J	8 1/4	5 1/2	1.375	1.100	1/2	1/4	2
12 J	9	6	1.500	1.200	5/8	5/16	2 1/4
13 J	9 3/4	6 1/2	1.625	1.300	5/8	5/16	2 1/2
14 J	10 1/2	7	1.750	1.400	5/8	5/16	3
15 J	11 1/4	7 1/2	1.875	1.500	5/8	5/16	3
16 J	12	8	2.000	1.600	3/4	3/8	3
20 J	15	10	2.500	2.000	X	1/2	4
36 J	27	18	4.500	3.600	X	7/8	7

### NORTON

Taper	A	B	C/H	D	E	F	G
12 N	9	6	1.500	1.197	5/8	5/16	2 1/2
16 N	12	8	2.000	1.599	3/4	3/8	3 5/8
24 N	16 3/4	12	3.000	2.398	X	3/4	5

Order by Taper & Style No. ie.....6-4.5J-1 or 5 B&S-3.

Specials also available with straight shanks.

Call us for LANDIS, HENDEY, & A.S.A. tapers.

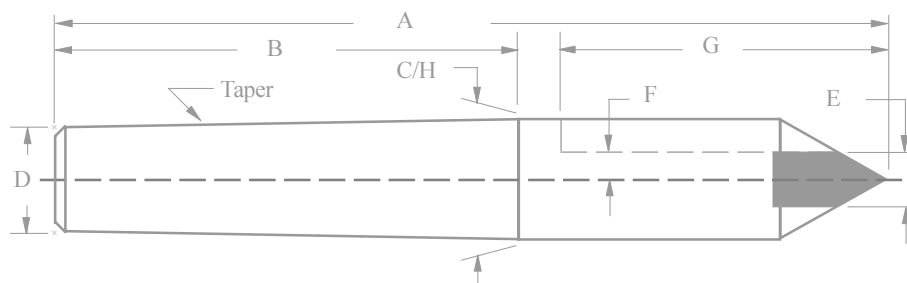
### MORSE TAPER

Taper	A	B	C/H	D	E	F	G
1 MT	3 5/16	2 1/8	.475	.369	1/4	1/8	1
2 MT	4 3/16	2 9/16	.700	.572	3/8	3/16	1 3/8
3 MT	5 1/4	3 3/16	.938	.778	1/2	1/4	1 11/16
4 MT	6 3/4	4 1/16	1.231	1.020	1/2	1/4	2 1/4
5 MT	8 1/2	5 3/16	1.748	1.475	5/8	5/16	2 3/4
6 MT	11 1/2	7 1/4	2.494	2.116	7/8	1/2	3 1/2
7 MT	15	10	3.270	2.750	X	3/4	4

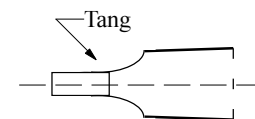
### BROWN & SHARPE

Taper	A	B	C/H	D	E	F	G
5 B&S	3 1/8	2	.533	.450	1/4	1/8	1 5/16
6 B&S	3 5/8	2 3/8	.599	.500	1/4	1/8	1 5/16
7 B&S	4 3/8	2 7/8	.720	.600	3/8	3/16	1 1/8
8 B&S	5 7/16	3 9/16	.898	.750	1/2	1/4	1 3/8
9 B&S	6 1/2	4 1/4	1.077	.901	1/2	1/4	2
10 B&S	7 7/8	5	1.260	1.045	1/2	1/4	2 1/4
10 CINN	8 9/16	5 11/16	1.289	1.045	1/2	1/4	2 1/4
11 B&S	9 5/16	5 15/16	1.498	1.250	5/8	5/16	2 1/2
11 CINN	10 1/8	6 3/4	1.531	1.250	5/8	5/16	2 1/2
12 B&S	11 1/8	7 1/8	1.797	1.500	5/8	5/16	3 1/4
13 B&S	11 3/4	7 3/4	2.073	1.750	7/8	7/16	3 1/2
15 B&S	13 1/2	8 3/4	2.615	2.250	X	1/2	4
17 B&S	14 1/2	9 3/4	3.156	2.750	X	3/4	4
18 B&S	15	10 1/4	3.427	3.000	X	3/4	4 1/2

X = Call for price & description.



Extend the life of your center by using our extreme pressure lubricant, see page 19.

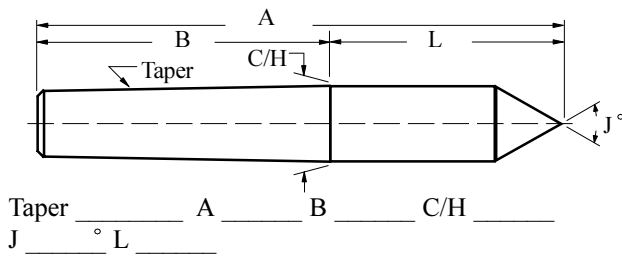


Any of our solid centers can be made with a Tang. Please Call.

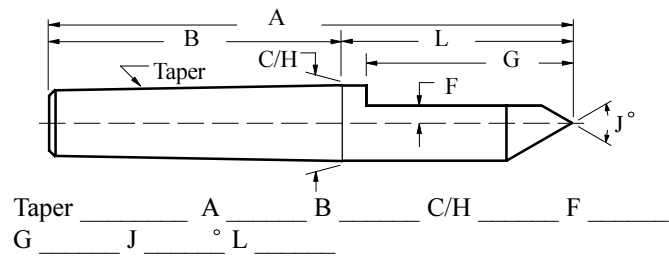
## Special Solid Centers

Fill in Dimensions and Fax in for Quotation

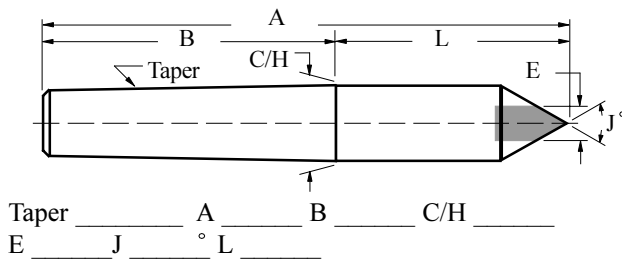
**FULL SOLID CENTER - Style -1**



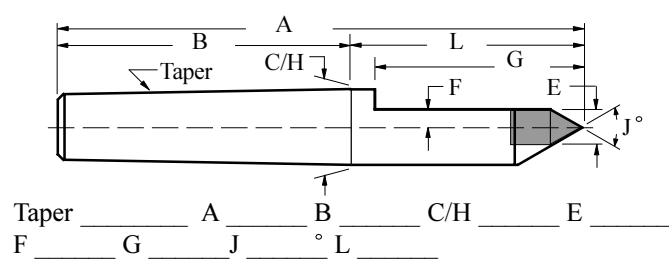
**HALF SOLID CENTER - Style -2**



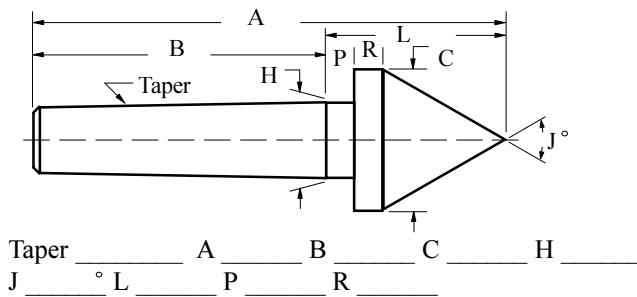
**CARBIDE TIP FULL SOLID CENTER - Style -3**



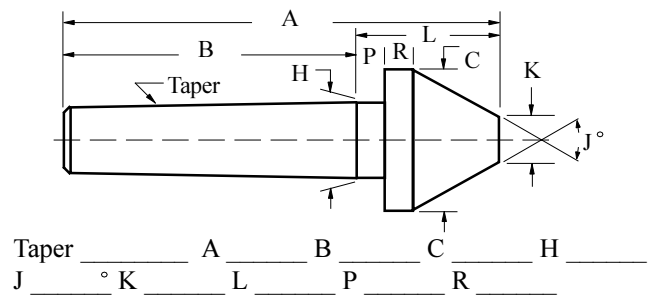
**CARBIDE TIP HALF SOLID CENTER - Style -4**



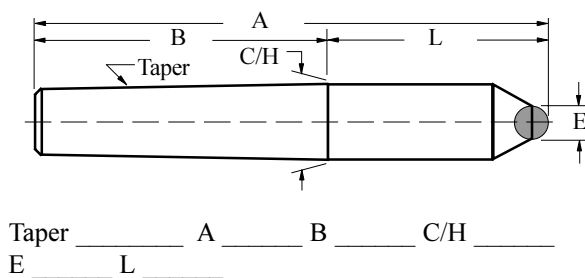
**PIPE SOLID CENTER**



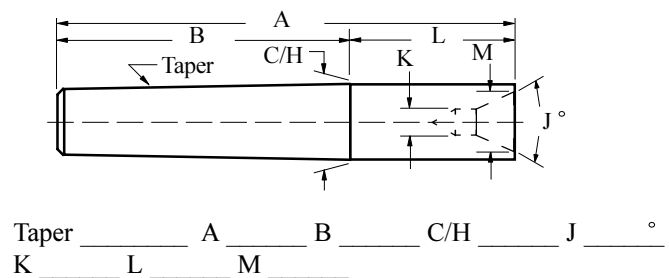
**BULL SOLID CENTER**



**CARBIDE TIP BALL SOLID CENTER**



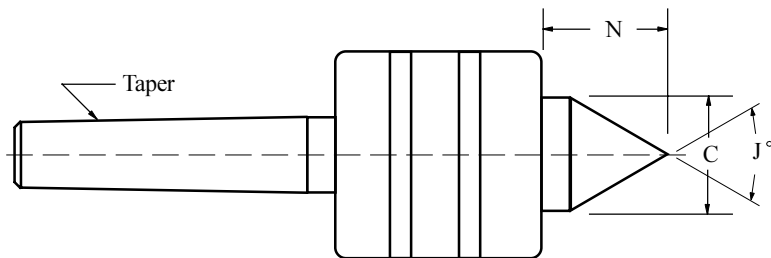
**FEMALE SOLID CENTER**



### Solid & Live Center Key

- |  |   |                               |
|--|---|-------------------------------|
| A - Over All Length                        | G - Cutout Length (Half Center)               | N - Point Length              |
| B - Taper Length                           | H - Gage Line Diameter                        | P - Gage Line to Back of Head |
| C - Point Diameter                         | J - Point Angle (Included)                    | R - Flat Length               |
| C2 - 2nd Point Dia. (Tracer Point)         | J2 - 2nd Point Angle (Tracer Point, Included) | S - Head Diameter             |
| D - Back End Diameter                      | K - Minimum Dia. (Female & Bull Center)       | T - Head Length               |
| E - Carbide Diameter                       | L - Gage Line to Point Length                 | V - Length to Keyway (center) |
| F - Height Above Center Line (Half Center) | M - Major Diameter (Female)                   |                               |

### Special Live Center



Simply fill out the dimensions and fax in this sheet and we will gladly quote you a custom live center to fit your specifications, or send us a sketch of the workpiece you need to hold and we will design a center for you.

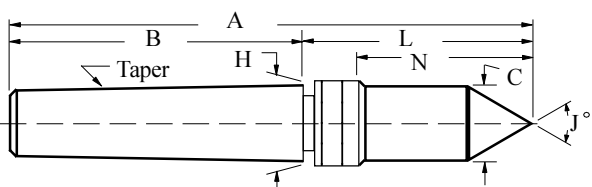
R.P.M. \_\_\_\_\_  
 Workpiece weight \_\_\_\_\_  
 Thrust load \_\_\_\_\_  
 Use \_\_\_\_\_

Taper \_\_\_\_\_ C \_\_\_\_\_  
 J \_\_\_\_\_ ° N \_\_\_\_\_

### Special Solid Centers

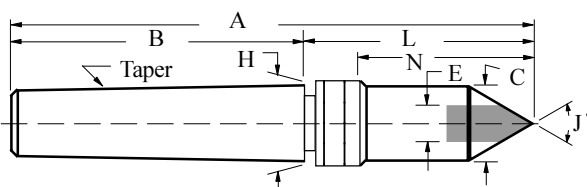
Fill in Dimensions and Fax in for Quotation

#### CNC-1 SOLID CENTER



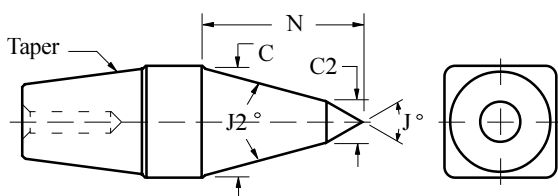
Taper \_\_\_\_\_ A \_\_\_\_\_ B \_\_\_\_\_ C \_\_\_\_\_ H \_\_\_\_\_  
 J \_\_\_\_\_ ° L \_\_\_\_\_ N \_\_\_\_\_

#### CNC-1 CARBIDE TIP SOLID CENTER



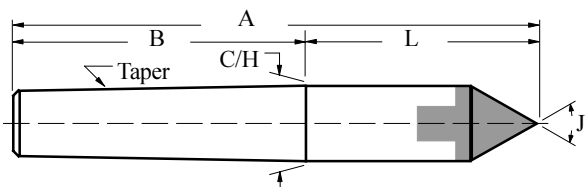
Taper \_\_\_\_\_ A \_\_\_\_\_ B \_\_\_\_\_ C \_\_\_\_\_ E \_\_\_\_\_  
 H \_\_\_\_\_ J \_\_\_\_\_ ° L \_\_\_\_\_ N \_\_\_\_\_

#### CINCINNATI STYLE SOLID CENTER



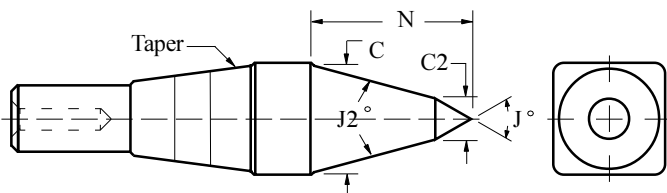
Mill Taper \_\_\_\_\_ C \_\_\_\_\_ C2 \_\_\_\_\_ J \_\_\_\_\_ °  
 J2 \_\_\_\_\_ ° N \_\_\_\_\_

#### CARBIDE TIP FULL FACE SOLID CENTER \*\*



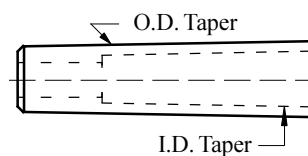
Taper \_\_\_\_\_ A \_\_\_\_\_ B \_\_\_\_\_ C/H \_\_\_\_\_  
 J \_\_\_\_\_ ° L \_\_\_\_\_

#### CINCINNATI STYLE SOLID CENTER



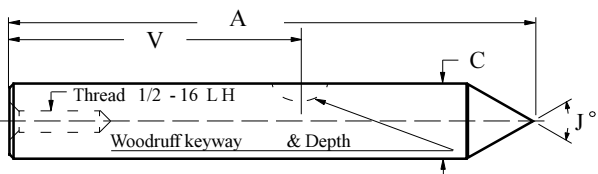
Mill Taper \_\_\_\_\_ C \_\_\_\_\_ C2 \_\_\_\_\_ J \_\_\_\_\_ °  
 J2 \_\_\_\_\_ ° N \_\_\_\_\_

#### TAPERED SLEEVE



O.D. Taper \_\_\_\_\_ I.D. Taper \_\_\_\_\_

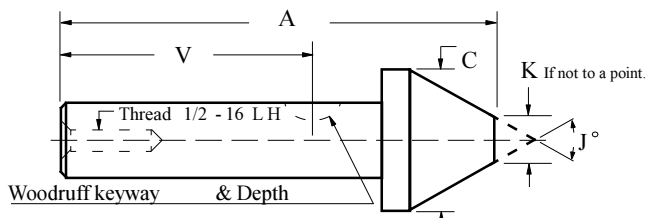
#### BARBER COLEMAN GEAR SHAPING SOLID CENTER\*



A \_\_\_\_\_ C \_\_\_\_\_ J \_\_\_\_\_ ° V \_\_\_\_\_

\* These centers are available with carbide tips, please call.  
 \*\* These centers are for light weight work only.

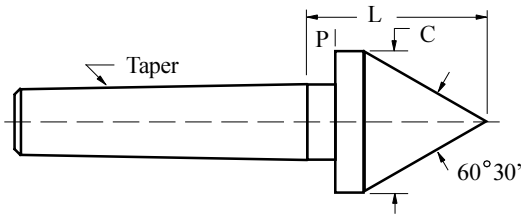
#### BARBER COLEMAN GEAR SHAPING PIPE or BULL SOLID CENTER\*



A \_\_\_\_\_ C \_\_\_\_\_ H \_\_\_\_\_ J \_\_\_\_\_ °

K \_\_\_\_\_ If not to a point.

# Pipe & Bull Solid Centers



## Ready Tool Standard Pipe Solid Centers

**Accuracy:** To +/- .0001 TIR.

\* Tool steel through hardened to 60-62 Rc.

\* For use in applications where a large point is needed for large center hole diameters.

Model No.	Taper	C	L	P
2 MTTSP	2 Morse	2 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
3 MTTSP	3 Morse	2 <sup>1</sup> / <sub>2</sub>	3 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>
4 MTTSP	4 Morse	2 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>
5 MTTSP	5 Morse	3 <sup>1</sup> / <sub>4</sub>	3 <sup>13</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>
6 JTSP	6 Jarno	2 <sup>1</sup> / <sub>4</sub>	3	1 <sup>1</sup> / <sub>2</sub>
10 JTSP	10 Jarno	2 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>
14 JTSP	14 Jarno	3 <sup>1</sup> / <sub>4</sub>	3 <sup>13</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>
10 B&STSP	10 B&S	2 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>

Order by Model No. ie.....2 MTTSP.

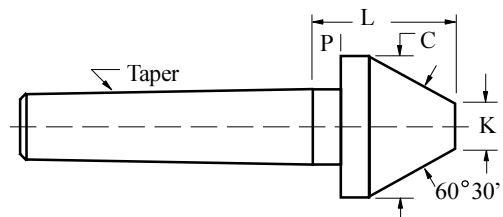
Also available with straight shanks.

## Ready Tool Standard Bull Solid Centers

**Accuracy:** To +/- .0001 TIR.

\* Tool steel through hardened to 60-62 Rc.

\* For use in applications where a large point is needed for large center hole diameters and point clearance is minimal.



Model No.	Taper	C	K	L	P
2 MTTSB	2 Morse	2 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
3 MTTSB	3 Morse	2 <sup>1</sup> / <sub>2</sub>	3 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
4 MTTSB	4 Morse	2 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
5 MTTSB	5 Morse	3 <sup>1</sup> / <sub>4</sub>	1	3	1 <sup>1</sup> / <sub>2</sub>
6 JTBSB	6 Jarno	2 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
10 JTBSB	10 Jarno	2 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
14 JTBSB	14 Jarno	3 <sup>1</sup> / <sub>4</sub>	1	3	1 <sup>1</sup> / <sub>2</sub>
10 B&STSB	10 B&S	2 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>

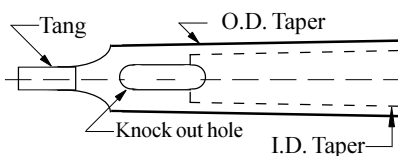
Order by Model No. ie.....2 MTTSB.

Also available with straight shanks.

## Morse Taper Sleeves

\* Soft with hardened tang or hardened and ground throughout.

\* Call for specials or fill in sketch on page 5 and fax it to us for a quick response.



Soft Model #	Hard Model #	Morse Taper I.D.	Morse Taper O.D.
MTSS-1-2	MTSH-1-2	1	2
MTSS-1-3	MTSH-1-3	1	3
MTSS-1-4	MTSH-1-4	1	4
MTSS-1-5	MTSH-1-5	1	5
MTSS-2-3	MTSH-2-3	2	3
MTSS-2-4	MTSH-2-4	2	4
MTSS-2-5	MTSH-2-5	2	5
MTSS-3-4	MTSH-3-4	3	4
MTSS-3-5	MTSH-3-5	3	5
MTSS-4-5	MTSH-4-5	4	5
MTSS-4-6	MTSH-4-6	4	6
MTSS-5-6	MTSH-5-6	5	6

Order by Model No. ie..... MTSS-1-2.

Hard Model #	Brown & Sharpe Taper I.D.	Brown & Sharpe Taper O.D.
B&SSH-5-7	5	7
B&SSH-7-9	7	9
B&SSH-7-10	7	10
B&SSH-7-11	7	11
B&SSH-9-10	9	10
B&SSH-9-11	9	11
B&SSH-10-11	10	11
B&SSH-10-12	10	12
B&SSH-11-12	11	12

Order by Model No. ie..... B&Sh-5-7.

Many other combinations also available; Morse to B&S and B&S to Morse. Straight shanks also available.

Call us for smaller, larger sizes and other styles of these quality imports. **Drift Keys** are also available.

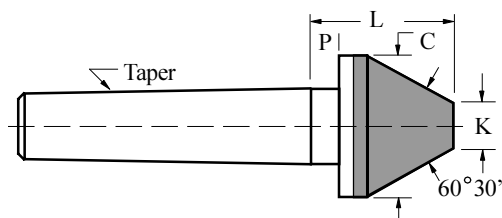
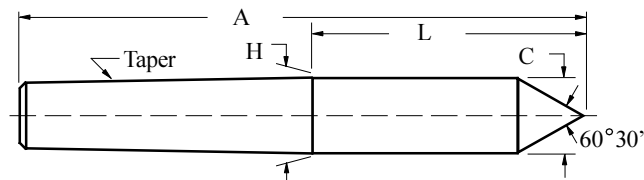
## Ready Tool Extra Long Full Solid Centers

**Accuracy:** To +/- .0001 TIR.

- \* Tool steel through hardened to 60-62 Rc.
- \* For use in applications where extra length and tool clearance are necessary.

Model No.	Taper	A	C/H	L
2 MTXLF	2 Morse	6	.700	3 <sup>7</sup> / <sub>16</sub>
3 MTXLF	3 Morse	7	.938	3 <sup>13</sup> / <sub>16</sub>
4 MTXLF	4 Morse	8	1.231	3 <sup>15</sup> / <sub>16</sub>
5 MTXLF	5 Morse	10	1.748	4 <sup>13</sup> / <sub>16</sub>
6 MTXLF	6 Morse	13	2.494	5 <sup>3</sup> / <sub>4</sub>
10 JXLF	10 Jarno	9	1.250	5
14 JXLF	14 Jarno	12	1.750	5
7 B&SXL	7 B&S	6	.720	3 <sup>5</sup> / <sub>8</sub>
10 B&SXL	10 B&S	10	1.289	4 <sup>5</sup> / <sub>16</sub>
12 B&SXL	12 B&S	13	1.797	5 <sup>7</sup> / <sub>8</sub>

Order by Model No. ie.....2 MTXLF.  
Also available with straight shanks.



## Ready Tool Large Diameter Carbide Tipped Bull Solid Centers

**Accuracy:** To +/- .0001 TIR.

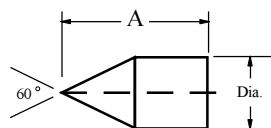
- \* Carbide hardness 77-79 Rc.
- \* Used when greater wear properties are required.
- \* Eliminates the need for various centers
- \* Used when full 60° is needed to be carbide

Model No.	Taper	C	K	L	P
2 MTCTB	2 Morse	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
3 MTCTB	3 Morse	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
4 MTCTB	4 Morse	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
5 MTCTB	5 Morse	2 <sup>1</sup> / <sub>2</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	<sup>1</sup> / <sub>2</sub>
6 JCTB	6 Jarno	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
9 JCTB	9 Jarno	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
10 JCTB	10 Jarno	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
14 JCTB	14 Jarno	2 <sup>1</sup> / <sub>2</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	<sup>1</sup> / <sub>2</sub>
6 B&SCTB	6 B&S	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
10 B&SCTB	10 B&S	2 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>
12 B&SCTB	12 B&S	2 <sup>1</sup> / <sub>2</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	<sup>1</sup> / <sub>2</sub>

Order by Model No. ie.....2 MTCTB.  
Also available with straight shanks.

### Solid Carbide Tips

- \* Replacement tips for Ready centers or your specific application.
- \* Grade C-2, Rc = 77-79.

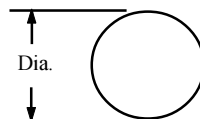


Model #	Dia. +.000	A Length -.002
CT-40	.250	.4375
CT-50	.313	.5625
CT-60	.375	.6875
CT-80	.500	.875
CT-100	.625	1.0625
CT-120	.750	1.250
CT-140	.875	1.375
CT-160	1.000	1.500
CT-180	1.125	1.625
CT-200	1.250	1.750
CT-220	1.375	1.875
CT-240	1.500	2.000

Special sizes available.

### Solid Carbide Balls

- \* Replacement balls for Ready centers or your specific application.
- \* Ground to tight tolerance +/- .0001



Model #	Dia.
CB-2	.0625
CB-4	.1250
CB-6	.1875
CB-8	.2500
CB-10	.3125
CB-12	.3750
CB-14	.4375
CB-16	.5000
CB-20	.6250
CB-32	1.000

Special sizes available.

# Large Carbide Tip Pipe & CNC Solid Centers

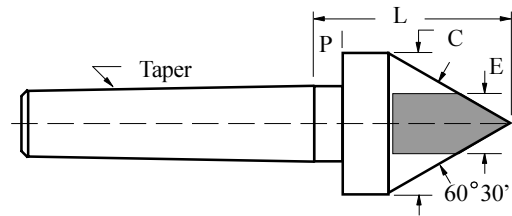
## Ready Tool Carbide Tipped Pipe Solid Centers

**Accuracy:** To +/- .0001 TIR.

- \* Carbide hardness 77-79 Rc.
- \* Used in a wide variety of applications.
- \* Large carbide provides for many regrinds.

Model No.	Taper	C	E	L	P
2 MTCTP	2 Morse	1 <sup>1</sup> / <sub>4</sub>	7 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
3 MTCTP	3 Morse	1 <sup>1</sup> / <sub>4</sub>	7 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
4 MTCTP	4 Morse	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
5 MTCTP	5 Morse	2	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
6 JCTP	6 Jarno	1 <sup>1</sup> / <sub>4</sub>	7 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
9 JCTP	9 Jarno	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
10 JCTP	10 Jarno	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
14 JCTP	14 Jarno	2	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
7 B&SCTP	7 B&S	1 <sup>1</sup> / <sub>4</sub>	7 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
9 B&SCTP	9 B&S	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>
10 B&SCTP	10 B&S	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
12 B&SCTP	12 B&S	2	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>

Order by Model No. ie.....2 MTCTP.  
Also available with straight shanks.



Model CNC-1



Model CNC-2

## Ready Tool CNC Morse Taper Tailstock Solid Centers

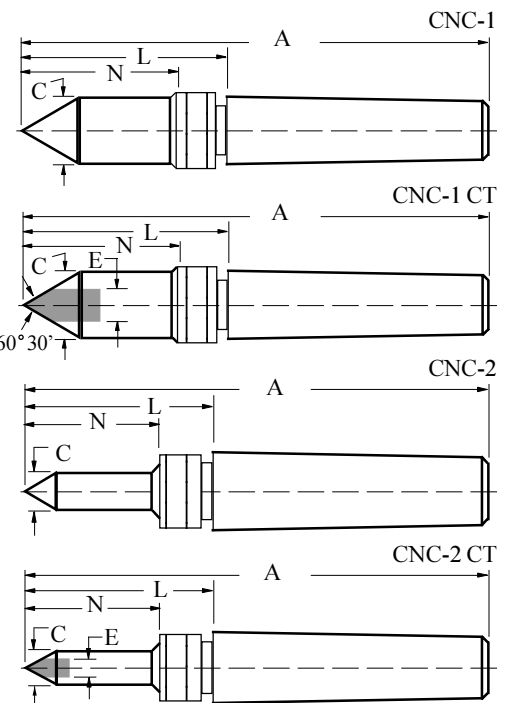
**Accuracy:** To +/- .0001-.0002 TIR.

- \* For use in N/C Turning Centers with live tailstocks.
- \* For use where there are no knock-out holes.
- \* Model CNC-1 has a standard male point.
- \* Model CNC-2 has a reduced diameter point for tool clearance.
- \* A Knock - Out Nut is included with each center.
- \* New carbide tipped series now available.

Tool Steel Model No.	Carbide Tip Model No.	A	C	E	N	L	Threads	Hex Nut
CNC-1 #3MT	CNC-1 #3MTCT	5 <sup>7</sup> / <sub>16</sub>	1	1 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub> - 12	Hex-3
CNC-1 #4MT	CNC-1 #4MTCT	7 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>8</sub> - 12	Hex-4
CNC-1 #5MT	CNC-1 #5MTCT	8 <sup>13</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	1	2 <sup>1</sup> / <sub>2</sub>	3 <sup>5</sup> / <sub>8</sub>	1 <sup>7</sup> / <sub>8</sub> - 12	Hex-5

Tool Steel Model No.	Carbide Tip Model No.	A	C	E	N	L	Threads	Hex Nut
CNC-2 #3MT	CNC-2 #3MTCT	5 <sup>13</sup> / <sub>16</sub>	1/2	1/4	2	2 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub> - 12	Hex-3
CNC-2 #4MT	CNC-2 #4MTCT	7 <sup>3</sup> / <sub>16</sub>	5/8	3/8	2 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>8</sub> - 12	Hex-4
CNC-2 #5MT	CNC-2 #5MTCT	8 <sup>13</sup> / <sub>16</sub>	7/8	1/2	2 <sup>1</sup> / <sub>2</sub>	3 <sup>5</sup> / <sub>8</sub>	1 <sup>7</sup> / <sub>8</sub> - 12	Hex-5

Order by Model No. ie.....CNC-1 #3MT or CNC-1 #3MTCT.  
Order extra hex nuts ie..... Hex-3  
Also available with straight shanks.  
See page 5 for specials of this style solid center.

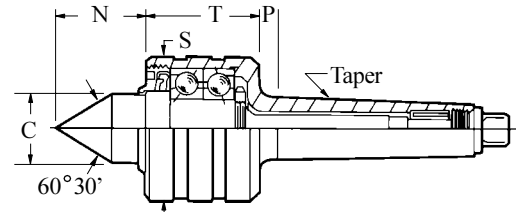


## Ready Tool Heavy Duty G Series

**Accuracy:** To +/- .0001 TIR.  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed with a high degree of accuracy for tight grinding tolerances. The Heavy Duty Center is engineered for the high R.P.M. required for CNC and Lathe applications.



Model No.	Morse Taper	Morse						Max. <sup>1</sup> Weight	Optional Tapers		
		C	N	S	T	P	B&S		Jarno	Norton	
G-220HD	2 MT	7/8	1 1/4	2	1 7/8	5/16	2000 lbs.	7-8	6-7	-	
G-230HD	3 MT	1	1 3/8	2 1/4	2 1/8	5/16	3000 lbs.	9	8-9	-	
G-240HD	4 MT	1 3/8	1 13/16	2 7/8	2 1/4	3/8	4500 lbs.	10-11	10-11-12	12	
G-250HD	5 MT	1 7/8	2 3/8	3 3/4	2 5/8	1/2	9000 lbs.	12-13-14	14-15-16	16	
G-260HD	6 MT	2 1/4	2 13/16	5 1/8	3 9/16	1/2	14000 lbs.	15-17	20	24	
G-270HD	7 MT	3	3 5/8	6 1/2	4 5/16	3/4	16000 lbs.	18	36	-	

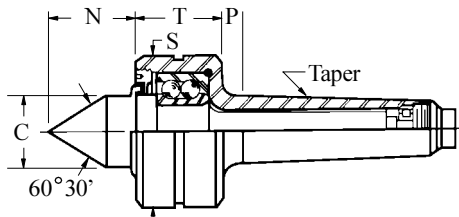


Order by Model No. and Taper ie.....G-220HD #2MT or G-220HD #7 Jarno.  
 See top of page 5 for specials of this style center.



## Ready Tool Heavy Duty R Series

**Accuracy:** To +/- .0002 TIR.  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed as a Heavy Duty general purpose center for Lathe applications.



Model No.	Std Morse Taper	Std Morse						Opt. Straight Shank(S.S.)	Max. <sup>1</sup> Weight
		C	N	S	T	P	Shank(S.S.)		
R-22HD	2 MT	7/8	1 1/8	2	1 7/16	5/16	3/4	1500 lbs.	
R-23HD	3 MT	1	1 3/8	2 1/4	1 3/4	5/16	1	2000 lbs.	
R-24HD	4 MT	1 3/8	1 13/16	2 7/8	1 7/8	3/8	1 1/4 - 1 1/2	3500 lbs.	
R-25HD	5 MT	1 7/8	2 3/8	4 1/8	2 7/16	1/2	1 3/4 - 2	10000 lbs.	
R-26HD	6 MT	2 1/4	3	6	3 3/8	1/2	2 1/4 - 3	15000 lbs.	
R-27HD	7 MT	3	3 5/8	7	3 15/16	3/4	3 1/4 - 3 1/2	18000 lbs.	

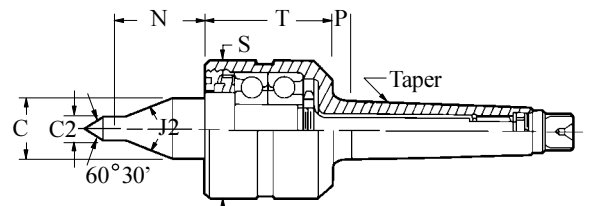
Order by Model No. and Taper ie.....R-22HD #2MT or R-22HD 3/4SS.  
 Also available with carbide tips, see page 15.  
 See top of page 5 for specials of this style center.

## Ready Tool TR Series

**Accuracy:** To +/- .0001 TIR.  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed for NC/CNC lathe, grinding or any application where an extended point is required for tool clearance.



Model No.	Std. Morse Taper	Std. Morse						J2°	Max. <sup>1</sup> Weight
		C	C2	N	S	T	P		
230TR	3 MT	1	3/8	2	2 1/4	2 1/8	5/16	45	2500 lbs.
240TR	4 MT	1	1/2	2 1/2	2 1/4	2 1/8	3/8	30	3000 lbs.
250TR	5 MT	1 3/8	1/2	2 1/2	2 7/8	2 1/4	1/2	45	4500 lbs.



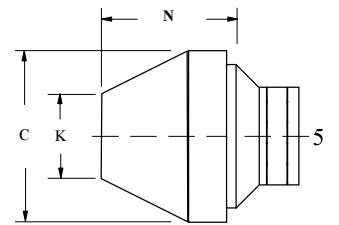
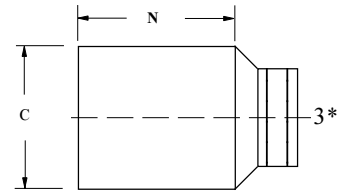
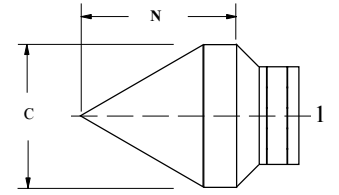
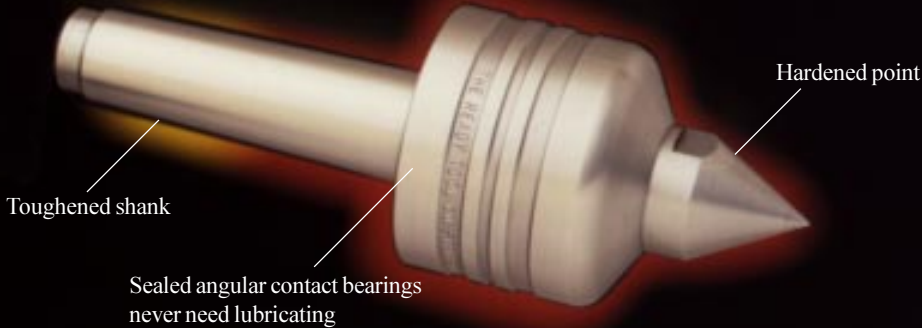
Order by Model No. and Taper ie.....230TR #3MT.  
 Call for specials on this style live center.

<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

# Replaceable Point Grinding & Lathe Live Centers

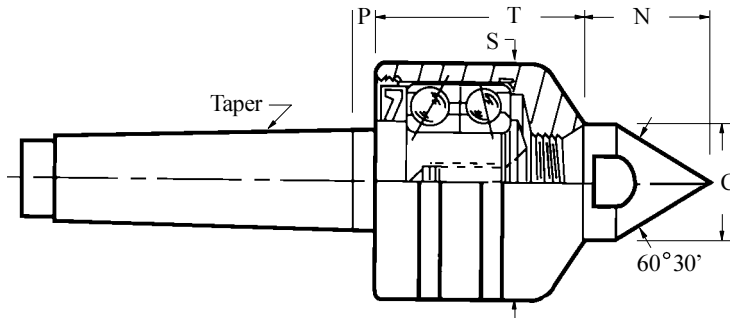
## TOOL MAKERS SET

Ask about our Tool Makers Set:  
 1 Live Center, with all 6 matching points.  
 Order by Model No., Taper and T.M.S.  
 ie.....G-10 #1MT.T.M.S.



## Ready Tool G Series Grinding and Lathe Centers

**Accuracy:** To +/- .0001 TIR.\*  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed to provide a high degree of accuracy for tight grinding tolerances. The G Series Center is engineered for the high R.P.M. required for CNC, Grinding and Lathe applications. One standard male point supplied with each center.  
**Point Hardness:** 58-62 Rc.



Model No.	Std Morse					Max. <sup>1</sup> Workpiece	Optional Tapers Available				
	Taper	C	N	S	T		B&S	Jarno	Norton	Landis	
G-10	1 MT	5/8	3/4	1 9/16	1 3/4	1/4	800 lbs.	5-6	4-5	-	-
G-20	2 MT	7/8	1	2	2 1/16	1/4	1400 lbs.	7-8	6-7	-	.8125
G-30	3 MT	1	1 3/16	2 1/4	2 1/4	1/4	2500 lbs.	9	8-9	-	-
G-40	4 MT	1 3/8	1 9/16	2 7/8	2 1/2	1/4	4000 lbs.	10-11	10-11-12	12	1.335
G-50	5 MT	1 7/8	2 1/16	3 3/4	3 1/16	1/4	6000 lbs.	12-13	14-15-16	16	1.750

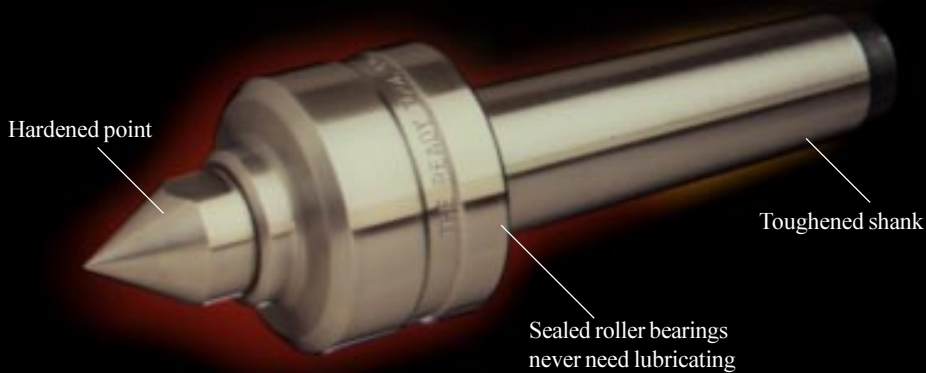
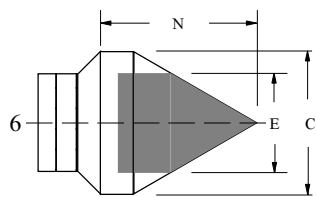
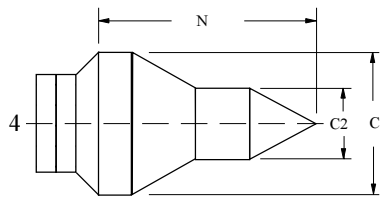
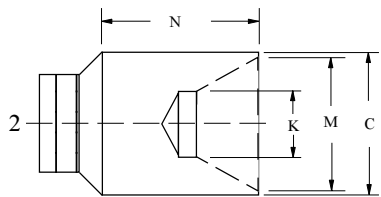
Order by Model No. and Taper ie.....G-10 #1MT or G-10 #5B&S.  
 Call for specials on this style live center.

\* All Round Blank Points are soft tool steel and not held to TIR.

<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

## Ready Tool R Series Lathe Centers

**Accuracy:** To +/- .0002 TIR.\*  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed to provide a high degree of accuracy for all your general purpose lathe applications. Engineered for high quality service with an economical price.  
 One standard male point supplied with each center.  
**Point Hardness:** 58-62 Rc.



### TOOL MAKERS SET

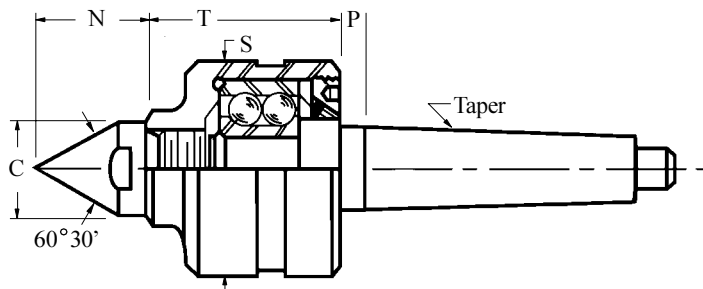
Ask about our Tool Makers Set:  
 1 Live Center, with all 6 matching points.  
 Order by Model No., Taper and T.M.S.  
 ie.....R-1N #1MT T.M.S.

Specify Basic No.	10	20	30	40	50
<b>Thread Size</b>	1/2 x 20	3/4 x 20	7/8 x 20	1 1/4 x 20	1 1/2 x 20
<b>Used on</b>	R-1N, R-2N	R-2HD, R-3N	R-4N, G-30	R-4HD, R-5N	G-50
<b>Model No.</b>	G-10, L-10	G-20, L-20	L-30	G-40, L-40	L-50
<b>Type of Points</b>	<b>Dimensions</b>				
<b>1 MALE</b>	C = 5/8	7/8	1	1 3/8	1 7/8
<b>2 FEMALE</b>	M = 1/2 K = 7/32	5/8 1/4	3/4 5/16	1 1/4 3/8	1 1/2 1/2
<b>3* ROUND BLANK Soft Tool Steel</b>	C = 5/8 N = 13/16	7/8 1	1 1 3/16	1 3/8 1 9/16	1 7/8 2 1/16
<b>4 TRACER</b>	N = 1 1/4 C2 = 1/4	1 9/16 3/8	1 3/4 1/2	2 3/8 5/8	3 1/4 3/4
<b>5 BULL</b>	C = 1 K = 1/2	2 1/2	3 1/2	3 1/2	3 1/2
<b>6 CARBIDE TIP</b>	C = 5/8 E = 3/8	7/8 5/8	1 3/4	1 3/8 1	1 7/8 1 1/4

Order by Basic No. and Type of Point ie.....#10 Male or #30 Tracer.  
 All points are 60° +30°/0, female points are 60°

Special points can be made to your specifications, just fill in the dimensions on the point sketches above and fax it in.

### Standard Points for Ready Tool's G Series and R Series Live Centers

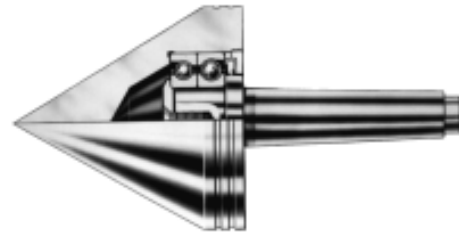
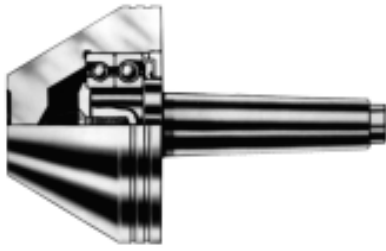


Model No.	Std. Morse Taper	C	N	S	T	P	Opt. Staight Shank(SS)	Max. 1 Workpiece
R-1N	1 MT	5/8	3/4	1 9/16	1 5/8	3/16	1/2 - 5/8	500 lbs.
R-2N	2 MT	5/8	3/4	1 9/16	1 5/8	9/32	3/4	600 lbs.
R-2HD	2 MT	7/8	1	2	1 13/16	1/4	3/4	1200 lbs.
R-3N	3 MT	7/8	1	2	1 13/16	1/4	1	1200 lbs.
R-4N	4 MT	1	1 3/16	2 1/4	1 5/16	1/4	1 1/4 - 1 1/2	1500 lbs.
R-4HD	4 MT	1 3/8	1 9/16	2 7/8	2 3/16	1/4	1 1/4 - 1 1/2	3000 lbs.
R-5N	5 MT	1 3/8	1 9/16	3 3/8	2 7/16	1/4	1 3/4 - 2	5000 lbs.

Order by Model No. and Taper ie.....R-1N #1MT or R-1N 1/2SS.  
 Call for specials on this style live center.

1 Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

# Grinding Bull & Pipe Live Centers



## Ready Tool GB Series

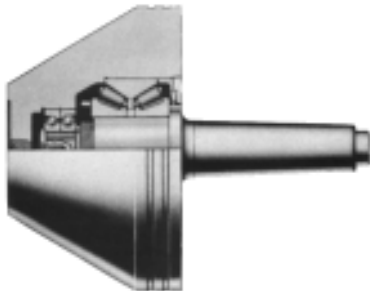
**Accuracy:** To +/- .0001 TIR  
**Speed Range:** 0-3000 R.P.M.  
**Application:** Designed for large work where clearance is limited. Provides a high degree of accuracy for grinding applications.  
**Hardness:** 58-62 Rc.

## Ready Tool GP Series

**Accuracy:** To +/- .0001 TIR  
**Speed Range:** 0-3000 R.P.M.  
**Application:** Designed for large range of center holes, pipe or tubing. Provides a high degree of accuracy for grinding applications.  
**Hardness:** 58-62 Rc.

Bull Head Model No.	Head			Pipe Head Model No.	Head			Std. Morse Taper	Gage Line P	Max. <sup>1</sup> Workpiece	Optional Tapers Available		
	Dia. C	Nose Dia. K	Head Length T		Dia. C	Head Length T	B&S				Jarno	Norton	
GB-1	1 <sup>3</sup> / <sub>4</sub>	1/2	2 <sup>5</sup> / <sub>16</sub>	GP-1	1 <sup>3</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 MT	1/4	800 lbs.	5-6	4-5	-	
GB-2	2	1/2	2 <sup>13</sup> / <sub>16</sub>	GP-2	2	3 <sup>1</sup> / <sub>4</sub>	2 MT	1/4	1400 lbs.	7-8	6-7	-	
GB-3	2 <sup>1</sup> / <sub>2</sub>	1	2 <sup>15</sup> / <sub>16</sub>	GP-3	2 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>4</sub>	3 MT	1/4	2500 lbs.	9	8-9	-	
GB-4	3	1	3 <sup>11</sup> / <sub>16</sub>	GP-4	3	4 <sup>1</sup> / <sub>2</sub>	4 MT	1/4	4000 lbs.	10-11	10-11-12	12	
GB-5	3 <sup>1</sup> / <sub>2</sub>	1	3 <sup>11</sup> / <sub>16</sub>	GP-5	3 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>2</sub>	4 MT	1/4	4000 lbs.	10-11	10-11-12	12	
GB-6	4	1 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>8</sub>	GP-6	4	5 <sup>7</sup> / <sub>16</sub>	5 MT	1/4	6000 lbs.	12-13	14-15-16	12	
GB-7	5	2	3 <sup>11</sup> / <sub>16</sub>	GP-7	5	5 <sup>7</sup> / <sub>16</sub>	5 MT	1/4	6000 lbs.	12-15	16-20	16-24	
GB-8	6	3	3 <sup>1</sup> / <sub>2</sub>	GP-8	6	6	5 MT	1/4	6000 lbs.	12-15	16-20	16-24	
GB-9	7 <sup>1</sup> / <sub>2</sub>	3	4 <sup>3</sup> / <sub>4</sub>	GP-9	7 <sup>1</sup> / <sub>2</sub>	7 <sup>5</sup> / <sub>16</sub>	6 MT	1/4	7000 lbs.	12-15	16-20	16-24	

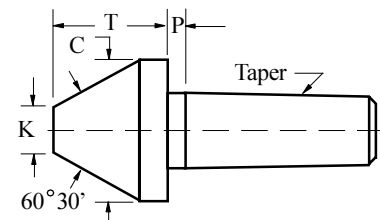
Order by Model No. and Taper ie....GB-1 #1MT or GP-1 #5 Jarno.  
 Call for specials on this style live center.



## Ready Tool GB Heavy Duty Series

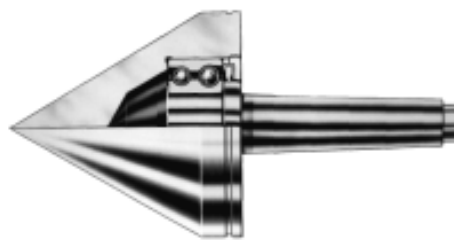
**Accuracy:** To +/- .0001 TIR  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed for large heavy work pieces where clearance is limited. Provides a high degree of accuracy for grinding applications.  
**Hardness:** 58-62 Rc.

Model No.	Std. Morse Taper	Head			Gage Line P	Max. <sup>1</sup> Workpiece	Optional Tapers Available		
		Dia. C	Nose Dia. K	Head Length T			B&S	Jarno	Norton
GB-200	4 MT	4	1 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>4</sub>	1/4	8000 lbs.	10-11	14	12
GB-300	4 MT	5	2	3 <sup>3</sup> / <sub>4</sub>	1/4	8000 lbs.	12-13	16-20	12-16
GB-400	5 MT	6	3	3 <sup>3</sup> / <sub>4</sub>	1/4	8000 lbs.	12-15	16-20	12-16
GB-500	6 MT	8 <sup>1</sup> / <sub>2</sub>	3	7	1/2	14000 lbs.	14-18	20	16-24
GB-550	6 MT	9	4	6 <sup>1</sup> / <sub>8</sub>	1/2	14000 lbs.	14-18	20	16-24
GB-600	6 MT	10	4	6 <sup>1</sup> / <sub>8</sub>	1/2	14000 lbs.	17-18	20	24
GB-700	7 MT	12	6	7	1/2	20000 lbs.	17-18	36	24
GB-800	7 MT	14	7	7	1/2	20000 lbs.	17-18	36	24



Order by Model No. and Taper ie....GB-200 #4MT or GB-200 #10 B&S.

<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.



## Ready Tool LB Series

**Accuracy:** To +/- .0002 TIR  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed for large work where clearance is limited for pipe or tubing.  
**Hardness:** 58-62 Rc.

## Ready Tool LP Series

**Accuracy:** To +/- .0002 TIR  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed for large range of center holes, for pipe or tubing.  
**Hardness:** 58-62 Rc.

Bull Head Model No.	Head			Pipe Head Model No.	Head			Std. Morse Taper	Opt. Morse Taper	Opt. Straight Staigt (SS)	Gage	
	Dia. C	Dia. K	Nose Length T		Dia. C	Dia. T	Nose Length T				Line P	Max. <sup>1</sup> Workpiece
LB-1	1 3/4	1/2	2 3/16	LP-1	1 3/4	2 5/8	1 MT	2 MT	1/2 - 3/4	3/16	600 lbs.	
LB-2	2	1/2	2 11/16	LP-2	2	3 1/8	2 MT	3 MT	5/8 - 1	1/4	1200 lbs.	
LB-3	2 1/2	1	2 5/8	LP-3	2 1/2	3 1/2	2 MT	4 MT	5/8 - 3/4	1/4	1500 lbs.	
LB-4	2 1/2	1	2 5/8	LP-4	2 1/2	3 1/2	3 MT	5 MT	3/4 - 1 1/2	1/4	1500 lbs.	
LB-5	3	1	3 3/8	LP-5	3	4 1/8	3 MT	5 MT	3/4 - 1	1/4	3000 lbs.	
LB-6	3 1/2	1	3 7/16	LP-6	3 1/2	4 1/4	3 MT	5 MT	3/4 - 1	1/4	3000 lbs.	
LB-7	3	1	3 3/8	LP-7	3	4 1/8	4 MT	6 MT	1 - 1 1/2	1/4	3000 lbs.	
LB-8	3 1/2	1	3 7/16	LP-8	3 1/2	4 1/4	4 MT	6 MT	1 - 1 1/2	1/4	3000 lbs.	
LB-9	4	1 1/2	3 5/8	LP-9	4	4 7/8	4 MT	2-3-5 MT	1 1/4 - 2	1/4	5000 lbs.	
LB-10	5	2	3 3/8	LP-10	5	5 1/8	4 MT	2-3 MT	1 1/4 - 2	1/4	5000 lbs.	
LB-11	5	2	3 3/8	LP-11	5	5 1/8	5 MT	6 MT	1 1/2 - 2	1/4	5000 lbs.	
LB-12	6	3	3 3/8	LP-12	6	6	5 MT	4-6 MT	1 3/4 - 2 1/4	1/4	8000 lbs.	
LB-13	7 1/2	3	4 5/8	LP-13	7 1/2	7 1/4	6 MT	5 MT	1 3/4 - 2 1/4	1/4	8000 lbs.	

Order by Model No. and Taper ie.....LB-1 #1MT or LP-1 3/4SS.  
 Call for specials on this style live center.

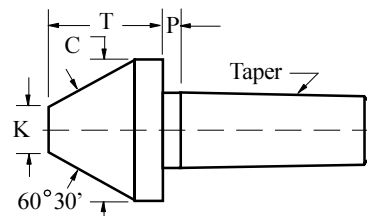


## Ready Tool HD Heavy Duty Series

**Accuracy:** To +/- .0002 TIR  
**Speed Range:** 0-1000 R.P.M.  
**Application:** Designed for large heavy work pieces where clearance is limited. Provides a high degree of accuracy for lathe applications.  
**Hardness:** 58-62 Rc.

Model No.	Std Morse		Opt. Straight Shank	Head Dia. C	Nose Dia. K	Head Length T	Gage Line P	Max. <sup>1</sup> Workpiece
	Taper	Taper						
HD-200	4 MT	3 MT	1 1/2 - 1 3/4	4	1 1/2	4 3/4	1/4	8000 lbs.
HD-300	4 MT	5 MT	1 1/2 - 1 3/4	5	2	4 1/4	1/4	8000 lbs.
HD-400	5 MT	4 MT	1 1/2 - 1 3/4	6	3	5 1/4	1/4	10000 lbs.
HD-500	6 MT	5 MT	2 - 2 1/2	8 1/2	3	7	1/2	14000 lbs.
HD-550	6 MT	5 MT	2 - 2 1/2	9	4	6 1/8	1/2	14000 lbs.
HD-600	6 MT	5 MT	2 1/2 - 2 3/4	10	4	6 1/8	1/2	14000 lbs.
HD-700	7 MT	6 MT	3 - 3 1/2	12	6	7	1/2	20000 lbs.
HD-800	7 MT	6 MT	3 - 3 1/2	14	7	7	1/2	20000 lbs.

Order by Model No. and Taper ie.....HD-200 #4MT or HD-200 1 1/2 SS.

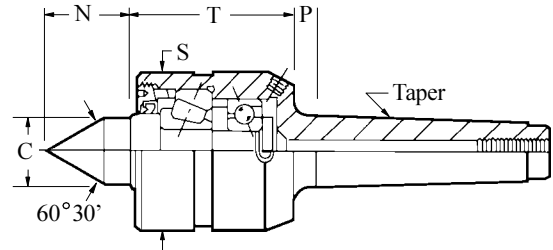


<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

# Thrust Load Live Centers

## Ready Tool TL Series

**Accuracy:** To +/- .0002 - .0003 TIR  
**Speed Range:** 0-1000 R.P.M.  
**Application:** Designed for lower R.P.M. and higher thrust capacity. Incorporates small head diameter for tool clearance.



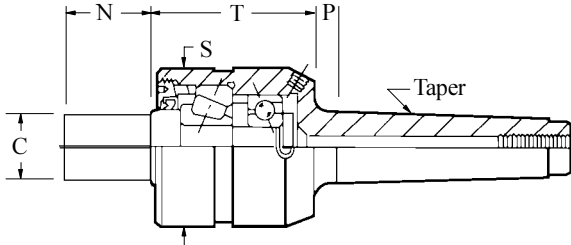
Model No.	Std. Morse Taper	C	N	S	T	P	Max. Thrust Capacity	Max. <sup>1</sup> Workpiece
TL-2	2 MT	7/8	1 1/4	2	2 3/8	5/16	800 lbs.	1000 lbs.
TL-3	3 MT	7/8	1 1/4	2	2 3/8	5/16	900 lbs.	1500 lbs.
TL-4	4 MT	1 1/8	1 1/2	2 3/4	2 3/4	3/8	2350 lbs.	2000 lbs.
TL-5	5 MT	1 1/2	1 7/8	3 1/2	3	1/2	3500 lbs.	3000 lbs.

Order by Model No. and Taper ie.....TL-2 #2MT.  
 Call for specials on this style live center.



## Ready Tool TS Series

**Accuracy:** To +/- .0002 - .0003 TIR  
**Speed Range:** 0-1000 R.P.M.  
**Application:** Designed for lower R.P.M. and higher thrust capacity. For spinning applications, special can be manufactured or furnished with pilot point as shown.

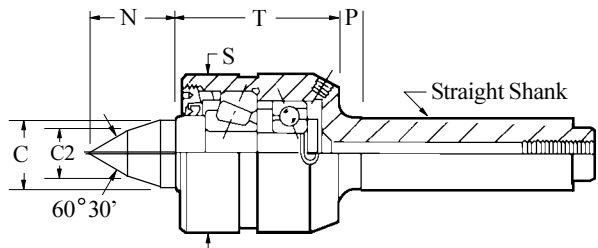
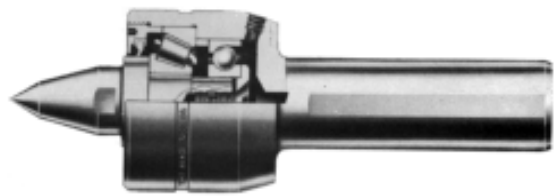


Model No.	Std. Morse Taper	C	N	S	T	P	Max. Thrust Capacity	Max. <sup>1</sup> Workpiece
TS-2	2 MT	7/8	1 1/4	2	2 3/8	5/16	800 lbs.	1000 lbs.
TS-3	3 MT	7/8	1 1/4	2	2 3/8	5/16	900 lbs.	1500 lbs.
TS-4	4 MT	1 1/8	1 1/2	2 3/4	2 3/4	3/8	2350 lbs.	2000 lbs.
TS-5	5 MT	1 1/2	1 7/8	3 1/2	3	1/2	3500 lbs.	3000 lbs.

Order by Model No. and Taper ie.....TS-2 #2MT.  
 Call for specials on this style live center.

## Ready Tool TT Series

**Accuracy:** To +/- .0002 - .0003 TIR  
**Speed Range:** 0-1000 R.P.M.  
**Application:** Designed for lower R.P.M. and higher thrust capacity. Extended spindle point with progressive reduction in diameter for tool clearance. Straight shanks for Turret Lathes.



Model No.	Straight Shank Dia. (S.S.)	C	C2	N	S	T	P	Max. Thrust Capacity
TT-2	3/4	7/8	1/2	1 5/8	2	2 3/8	5/16	800 lbs.
TT-3	1	7/8	1/2	1 5/8	2	2 3/8	5/16	800 lbs.
TT-4	1 1/4 - 1 1/2	1 1/8	5/8	2	2 3/4	2 3/4	3/8	2000 lbs.
TT-5	1 3/4 - 2 1/4	1 1/2	3/4	2 1/2	3 1/2	3	1/2	3000 lbs.

Order by Model No. and Taper ie.....TT-2 3/4SS.  
 Call for specials on this style live center.

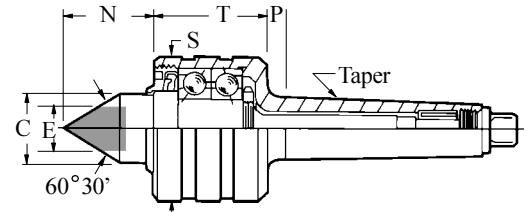
<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

## Ready Tool Heavy Duty Carbide Tip G Series

**Accuracy:** To +/- .0001 TIR.  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed with a high degree of accuracy for tight grinding tolerances. The Heavy Duty Center is engineered for the high R.P.M. required for CNC and Lathe applications where a carbide insert is needed.



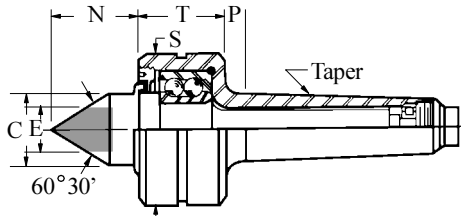
Model No.	Morse Taper	C	E	N	S	T	P	Max. <sup>1</sup> Weight	Optional Tapers	
									B&S	Jarno
G-220CT	2 MT	7/8	5/8	1 1/4	2	1 7/8	5/16	1500 lbs.	7-8	6-7
G-230CT	3 MT	1	3/4	1 3/8	2 1/4	2 1/8	5/16	2000 lbs.	9	8-9
G-240CT	4 MT	1 3/8	1 1/8	1 13/16	2 7/8	2 1/4	3/8	3500 lbs.	10-11	10-11-12
G-250CT	5 MT	1 7/8	1 3/8	2 3/8	3 3/4	2 5/8	1/2	7000 lbs.	12-13-14	14-15-16
G-260CT	6 MT	2 1/4	1 1/2	2 13/16	5 1/8	3 9/16	1/2	12000 lbs.	15-17	20



Order by Model No. and Taper ie.....G-220CT #2MT or G-220CT #7 Jarno.  
 Call for specials on this style live center.

## Ready Tool Heavy Duty Carbide Tip R Series

**Accuracy:** To +/- .0002 TIR.  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed as a Heavy Duty general purpose center for Lathe applications where a harder carbide point is needed for better wearability.

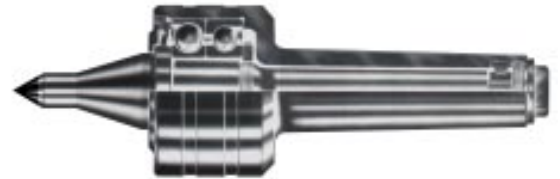


Model No.	Std Morse Taper	C	E	N	S	T	P	Opt. Straight Shank(S.S.)	Max. <sup>1</sup> Weight
R-23CT	3 MT	1	3/4	1 3/8	2 1/4	1 3/4	5/16	1	1500 lbs.
R-24CT	4 MT	1 3/8	1 1/8	1 13/16	2 7/8	1 7/8	3/8	1 1/4 - 1 1/2	2500 lbs.
R-25CT	5 MT	1 7/8	1 3/8	2 3/8	4 1/8	2 7/16	1/2	1 3/4 - 2	8000 lbs.
R-26CT	6 MT	2 1/4	1 1/2	3	6	3 3/8	1/2	2 1/4 - 3	12000 lbs.

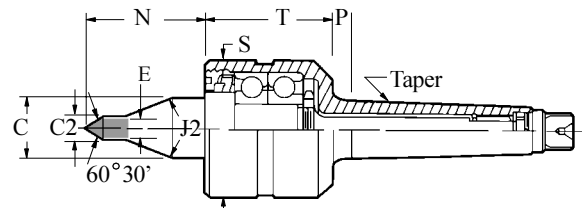
Order by Model No. and Taper ie.....R-22CT #2MT or R-22CT 3/4SS.  
 See top of page 5 for specials of this style center.

## Ready Tool Tracer Point Carbide Tip TR Series

**Accuracy:** To +/- .0001 TIR.  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed for NC/CNC lathe, grinding, or any application where an extended point is required for tool clearance and carbide hardness is needed.



Model No.	Std. Morse Taper	C	C2	E	N	S	T	P	J2°	Max. <sup>1</sup> Weight
240TRCT	4 MT	1	1/2	3/8	2 1/2	2 1/4	2 1/8	3/8	30	2000 lbs.
250TRCT	5 MT	1 3/8	1/2	3/8	2 1/2	2 7/8	2 1/4	1/2	45	3500 lbs.



Order by Model No. and Taper ie.....230TR #3MTCT.  
 Call for specials on this style live center.

<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

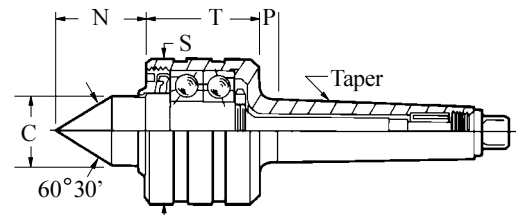
## Ready Tool Heavy Duty L Series

**Accuracy:** To +/- .0002 - .0003 TIR.  
**Speed Range:** 0-4000 R.P.M.  
**Application:** Designed to provide a degree of accuracy for general grinding and lathe operations. The Heavy Duty Center is engineered for the high R.P.M. required for CNC and Lathe applications at a economical price.



Model No.	Morse Taper	C	N	S	T	P	Max. <sup>1</sup> Weight
L-220HD	2 MT	7/8	1 1/4	2	1 7/8	5/16	2000 lbs.
L-230HD	3 MT	1	1 3/8	2 1/4	2 1/8	5/16	3000 lbs.
L-240HD	4 MT	1 3/8	1 13/16	2 7/8	2 1/4	3/8	4500 lbs.
L-250HD	5 MT	1 7/8	2 3/8	3 3/4	2 5/8	1/2	9000 lbs.
L-260HD	6 MT	2 1/4	2 13/16	5 1/8	3 9/16	1/2	14000 lbs.
L-270HD	7 MT	3	3 5/8	6 1/2	4 5/16	3/4	16000 lbs.

Order by Model No. and Taper ie.....L-220HD #2MT.  
 Please call for optional tapers.

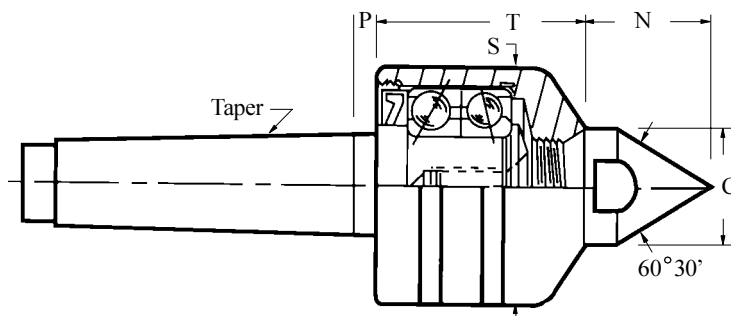


## Ready Tool L Series Grinding and Lathe Centers

**Accuracy:** To +/- .0002 - .0003 TIR.  
**Speed Range:** 0-4000 R.P.M.  
**Application:** Designed to provide a degree of accuracy for general grinding and lathe tolerances. The L Series Center is engineered for the high R.P.M. required for CNC and Lathe applications at a great price.  
**Point Hardness:** 58-62 Rc. Ref: points on page 10-11 for G-Series

Model No.	Std Morse Taper	C	N	S	T	P	Max. <sup>1</sup> Workpiece
L-10	1 MT	5/8	3/4	1 9/16	1 3/4	1/4	800 lbs.
L-20	2 MT	7/8	1	2	2 1/16	1/4	1400 lbs.
L-30	3 MT	1	1 3/16	2 1/4	2 1/4	1/4	2500 lbs.
L-40	4 MT	1 3/8	1 9/16	2 7/8	2 1/2	1/4	4000 lbs.
L-50	5 MT	1 7/8	2 1/16	3 3/4	3 1/16	1/4	6000 lbs.

Order by Model No. and Taper ie.....L-10 #1MT.  
 Please call for optional tapers.



<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

## Ready Tool Spring Loaded Climax Live Centers

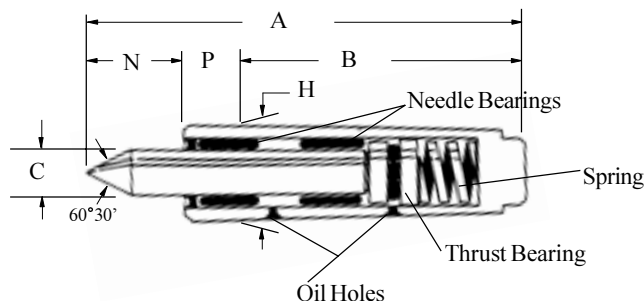
**Accuracy:** To +/- .0001 TIR.  
**Speed Range:** 0-5000 R.P.M.  
**Application:** Designed with a high degree of accuracy for tight grinding and lathe tolerances. The Spring loaded low profile center is engineered for use where head clearance and load compensation is necessary. Hardened and Ground



Model No.	Taper	A	B	C	H	N	P	Thrust*	Load** <sup>1</sup>
CLX-2MT	2 MT	3 <sup>3</sup> / <sub>4</sub>	2 <sup>9</sup> / <sub>16</sub>	.314	.700	1 <sup>13</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>8</sub>	250 lbs.	900 lbs.
CLX-3MT	3 MT	4 <sup>11</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	.502	.938	1	1 <sup>1</sup> / <sub>2</sub>	350	1400
CLX-4MT	4 MT	4 <sup>11</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>16</sub>	.688	1.231	1 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	550	1900
CLX-5MT	5 MT	7 <sup>3</sup> / <sub>4</sub>	5 <sup>1</sup> / <sub>4</sub>	1.104	1.748	2	1 <sup>1</sup> / <sub>2</sub>	750	2800
CLX-.750SS	.75 Str Shk	3 <sup>13</sup> / <sub>16</sub>	3	.314	.750	1 <sup>13</sup> / <sub>16</sub>	-	250	900
CLX-1.00SS	1.00 Str Shk	4 <sup>11</sup> / <sub>16</sub>	3 <sup>11</sup> / <sub>16</sub>	.502	1.000	1	-	350	1400
CLX-1.25SS	1.25 Str Shk	5 <sup>15</sup> / <sub>16</sub>	4 <sup>9</sup> / <sub>16</sub>	.688	1.250	1 <sup>3</sup> / <sub>8</sub>	-	550	1900
CLX-1.75SS	1.75 Str Shk	7 <sup>3</sup> / <sub>4</sub>	5 <sup>3</sup> / <sub>4</sub>	1.104	1.750	2	-	750	2800

\*Max thrust in lbs to bottom spring. \*\*Radial loads for continuous service. May be increased by 50% for intermittent operations.  
 Order by Model No. ie.....CLX-#2MT or CLX-1.25SS.

No Specials or alterations made on these style centers.

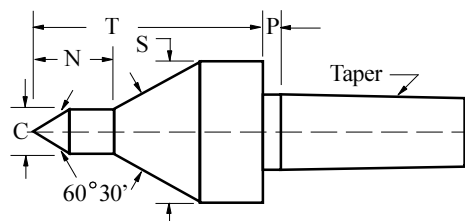


## Ready Tool Duel Point Live Centers Series

**Accuracy:** To +/- .0001 - .0002 TIR.  
**Speed Range:** 0-4000 R.P.M.  
**Application:** Multi purpose duel point live centers. Abec 7/9 angular contact bearings provide an excellent radial and thrust load center. Used in Grinding, Lathe and multi step applications. Head is hardened. Shank is toughend.

Model No.	Std Morse						Max <sup>1</sup> Weight	Optional Tapers		
	Taper	C	N	S	T	P		Morse	B&S	Jarno
DP-1	1 MT	1/2	7/8	2 <sup>1</sup> / <sub>8</sub>	3 <sup>9</sup> / <sub>16</sub>	1/4	600 lbs.	-	5-6	4-5
DP-2	2 MT	1/2	7/8	2 <sup>1</sup> / <sub>8</sub>	3 <sup>7</sup> / <sub>8</sub>	1/4	600 lbs.	3	6-7-8	6-7
DP-3	3 MT	3/4	1 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>8</sub>	5 <sup>1</sup> / <sub>8</sub>	1/4	800 lbs.	-	10	10
DP-4	4 MT	3/4	1 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>8</sub>	5 <sup>1</sup> / <sub>8</sub>	1/4	1200 lbs.	-	11	11-12
DP-5	5 MT	3/4	1 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>8</sub>	5 <sup>1</sup> / <sub>8</sub>	1/4	1500 lbs.	-	-	-

Order by Model No. and Taper ie.....DP-1 #1MT or DP-2 #7 Jarno.  
 Call for specials on this style live center.

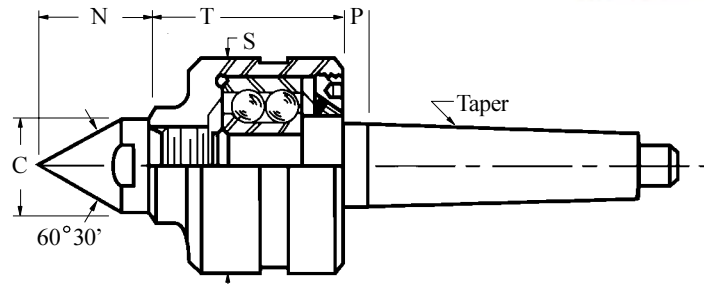


<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

# Stainless Steel Live Centers & Taper Socket Cleaners

## Ready Tool Stainless Steel Live Center\*

**Accuracy:** To +/- .0002 - .0003 TIR  
**Speed Range:** 0-2000 R.P.M.  
**Application:** Designed for use where corrosive solvents and other fluids would deteriorate standard steel centers.  
**Point Hardness:** 58-62 Rc.



Model No.*	Std. Morse						Opt. Staight		Max. <sup>1</sup> Workpiece
	Taper	C	N	S	T	P	Shank(SS)		
STS-1N	1 MT	5/8	3/4	1 <sup>9</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>8</sub>	3/16	1/2 - 5/8	500 lbs.	
STS-2N	2 MT	5/8	3/4	1 <sup>9</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>8</sub>	9/32	3/4	600 lbs.	
STS-3N	3 MT	7/8	1	2	1 <sup>13</sup> / <sub>16</sub>	1/4	1	1200 lbs.	
STS-4N	4 MT	1	1 <sup>3</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>4</sub>	1 <sup>5</sup> / <sub>16</sub>	1/4	1 <sup>1</sup> / <sub>4</sub> - 1 <sup>1</sup> / <sub>2</sub>	1500 lbs.	
STS-5N	5 MT	1 <sup>3</sup> / <sub>8</sub>	1 <sup>9</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>8</sub>	2 <sup>7</sup> / <sub>16</sub>	1/4	1 <sup>3</sup> / <sub>4</sub> - 2	5000 lbs.	



Order by Model No. and Taper ie.....STS-1N #1MT or STS-3N 1 SS.  
 \* Entire body is made of 303 Stainless Steel, points are 440 Stainless Steel, bearing are carbon steel and nylon.  
 \* These centers are made to order.

## Ready Tool Taper-Mate Precision Socket Cleaners

Designed to be a simple and efficient method of cleaning, chips, burrs, dust, lint, lubricant, cutting fluid and anything else that is not welded in the taper tool connection. This will allow for maximum contact between the center and taper giving you the best surface contact so your center will run true.



Model No.	Description
GW R-8	R-8 Taper
GW MT-1	#1 Morse Taper
GW MT-2	#2 Morse Taper
GW MT-3	#3 Morse Taper
GW MT-4	#4 Morse Taper
GW MT-5	#5 Morse Taper
GW BS-11	#11 Brown & Sharp Taper
GW ASA-30	#30 American Standard Taper
GW ASA-40	#40 American Standard Taper
GW ASA-50	#50 American Standard Taper

Order by Model No. ie.....GWR-8 or GWASA-30.

## Lathe Dogs

Bent tail and Straight tail Lathe Dogs are of drop forged steel construction for a long lasting tool.



Capacity Inches	Bent Tail Model #	Straight Tail Model #
1/2	BT-5	ST-5
3/4	BT-.75	ST-.75
1	BT-1	ST-1
1 1/4	BT-1.25	ST-1.25
1 1/2	BT-1.5	ST-1.5
1 3/4	BT-1.75	ST-1.75
2	BT-2	ST-2
2 1/2	BT-2.5	ST-2.5
3	BT-3	ST-3
4	BT-4	ST-4

Order by Model No. ie..... BT-.5 or ST-2.5 .  
 Call us for these quality imports.

<sup>1</sup> Workpiece Weight Capacity is in lbs and less than half of that listed as the Max Weight, see page 2 for details.

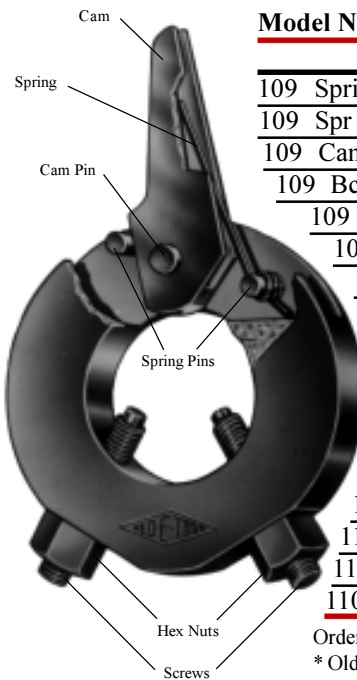
## Ready Tool Cam Action Series

Designed to hold and turn the workpiece for cylindrical grinding. Our Cam Dog is engineered for easy adjustment and quick change over for production grinding. Available with steel cam and screws for hardened workpieces, brass cam and screws for soft workpieces, or any combination of brass and steel.

Steel Model No.	Brass Model No.	Capacity
109	109B	1/8 to 1/2
110	110B	1/4 to 3/4
111	111B	1/2 to 1 1/8
112	112B	7/8 to 1 1/2
113	113B	1 3/8 to 2
114	114B	1 7/8 to 2 1/2
115	115B	2 3/8 to 3
116	116B	2 7/8 to 3 1/2
117	117B	3 3/8 to 4
118	118B	4 to 4 1/2
119	119B	4 1/2 to 5
120	120B	5 to 5 1/2
121	121B	5 1/2 to 6

Order by Model No. ie.....109 or 109 B.

Grinder Dogs can be repaired at 45% of List price.



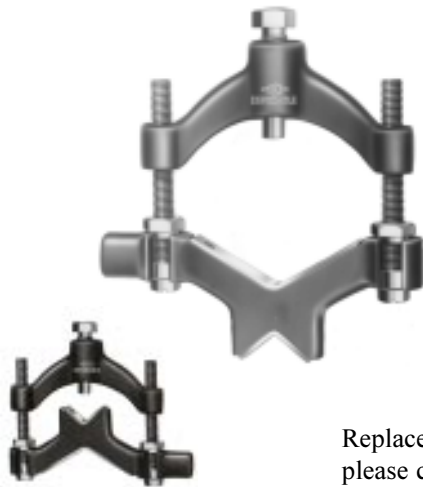
### Replacement Parts:

Model No.	Description
For 109 Grinder Dog	
109 Spring	Spring
109 Spr Pin	Spring Pin
109 Cam Pin	Cam Pin
109 Bcam	Brass Cam
109 Scam	Steel Cam
109 Bscr	Brass Screw
109 Sscr	Steel Screw
109 Nut	10-32 Hex Nut
For 110 thru 121 Grinder Dogs	
110-121 Spring	Spring
110-121 Spr Pin	Spring Pin
110-121 Cam Pin	Cam Pin
110-121 Bcam	Brass Cam
110-121 Scam	Steel Cam
110-121 Bscr	Brass Screw*
110-121 Sscr	Steel Screw*
110-121 Nut	5/16-18 Hex Nut*

Order by Model No. ie.....109 Spring or 110-121 Bcam.

\* Older 110 model had a 1/4-20 thread, please check your grinder dog for correct thread.

## Ready Tool Reversible Grinder Dog



Replacement parts available, please call.

### Reversible Grinder Dog Features

- Drop forged steel construction.*
- Unbreakable strong material
- Reversible Jaw.*
- Accepts various diameter pieces
- Brass tip and plate.*
- Will not harm workpiece
- Black Oxide*
- Rust-proof

Reversible Grinder Dogs	
Model No.	Capacity
503	1 1/2 - 2 1/2
504	1 3/4 - 4

### Extreme Pressure Lube #3 4 oz tube.

*Concentrated center point lubricant. Anti-Scoring.*

#### Recommended Applications:

<i>Lathe centers</i>	<i>Grinding centers</i>
<i>Milling machine centers</i>	<i>Solid centers</i>
<i>Screw machine centers</i>	<i>Ball bearings</i>
<i>Roller bearings</i>	<i>Steady rest</i>



### Extreme Pressure Grease

Model No.  
**CMD**



## The Ready Tool Repair Guarantee

*Our Standard Live Center will be totally reconditioned at 45% of the list cost of a new Live Center. If a Ready Tool Standard Live Center is beyond practical repair we will issue a 20% discount towards the purchase of a new equivalent Live Center. We regrind & repair Solid Centers of all makes.*



***The Ready Tool Co.***

One Carney Rd.

West Hartford, CT 06110

Tel: 860-524-7811 Fax: 860-524-7813

<http://www.readytool.com> E-Mail [sales@readytool.com](mailto:sales@readytool.com)

Tel: 1-800-872-8876 Fax: 1-800-348-9922

Toll Free 1-800-USA-TURN

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