

**Operating instructions**  
**Live stay**  
for lathes with cylindrical guideways  
D2000      D2400      D3000

**WABECO**

MASCHINENMANUFAKTUR seit 1885

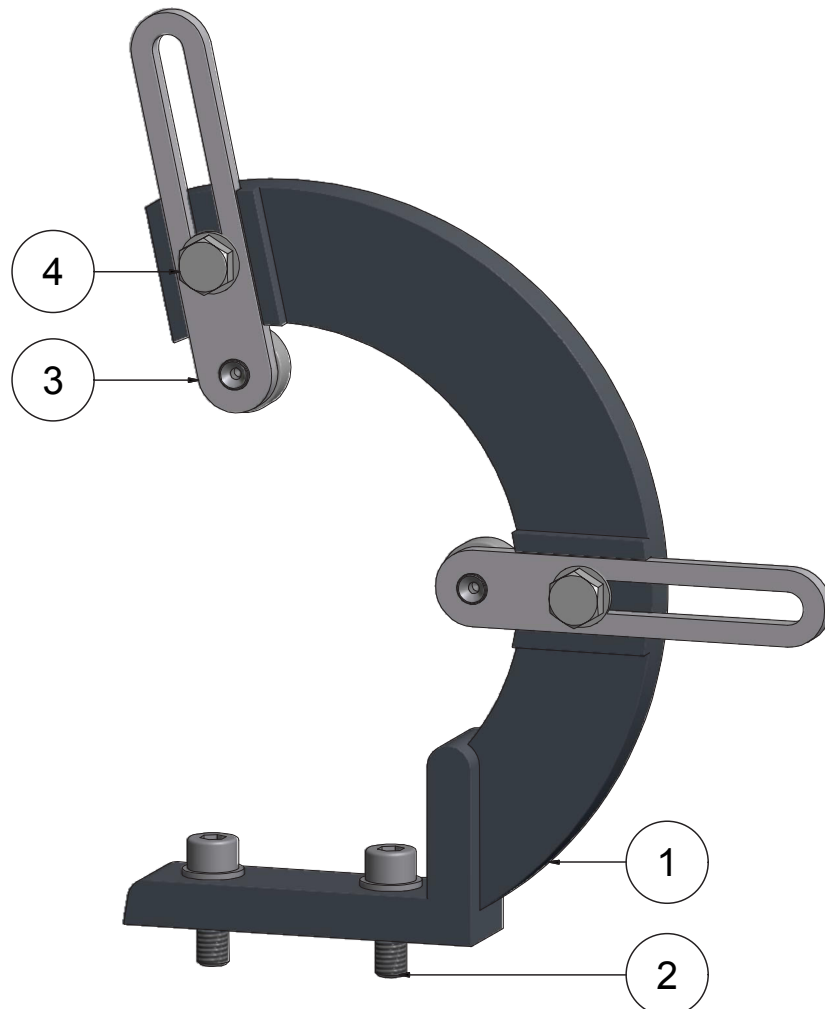
## 1. Live stay

**Bezels counteract the bending of longer shafts that is caused by shaving forces. The roll jaws prevent the bending of the turning elements.**

They are to be set in such a way that the rotating axis of the work piece is precisely flush with the rotating axis of the machine. At the support position, the turning parts must be accurately rounded.

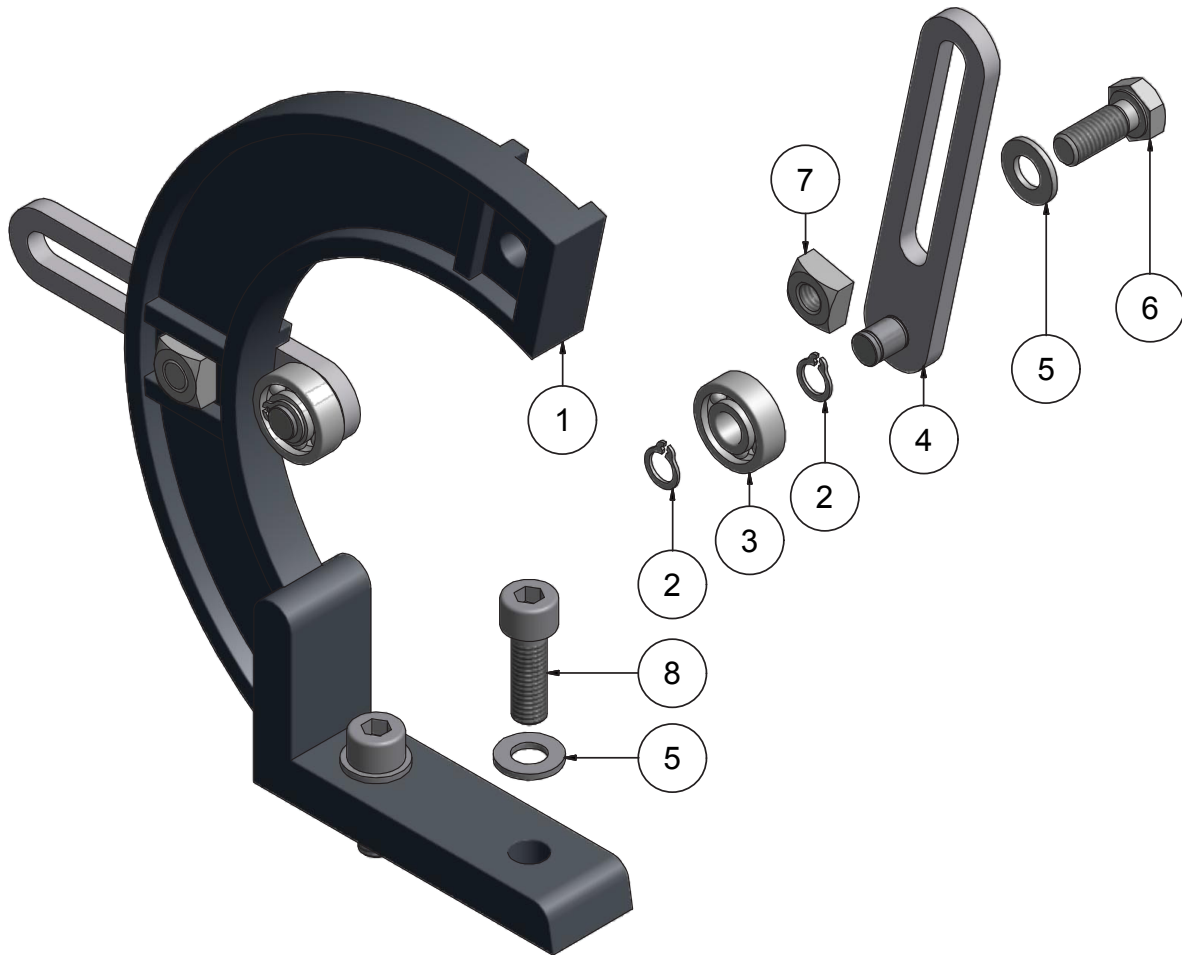
### 1.1 Operating the live stay

1. The live stay is used, primarily, when turning thin, long shafts and when turning longer threaded spindles.
2. The bezel (1) is screwed to the intended threaded holes in the tool skid using the two fixture screws (2).
3. The roll jaws should be as close to the tool cutting edge of the turning chisel as possible to ensure that the work piece cannot bend.
4. The slider (3) can be moved by opening the clamping screws (4), afterwards the clamping screws (4) must be tightened up again.



# 1. Live stay

## 1.2 Drawing and legend



Part No.	Items	Order No.	Description
1	1	51006831-0032	Basic body
2	4	16147100008000	Securing ring
3	2	51502117	Ball bearing
4	2	51401533-0001	Slider with axis
5	4	16112500008001	Washer
6	2	16193300008020	Screw
7	2	16155700008000	Nut
8	2	16191200008025	Screw

