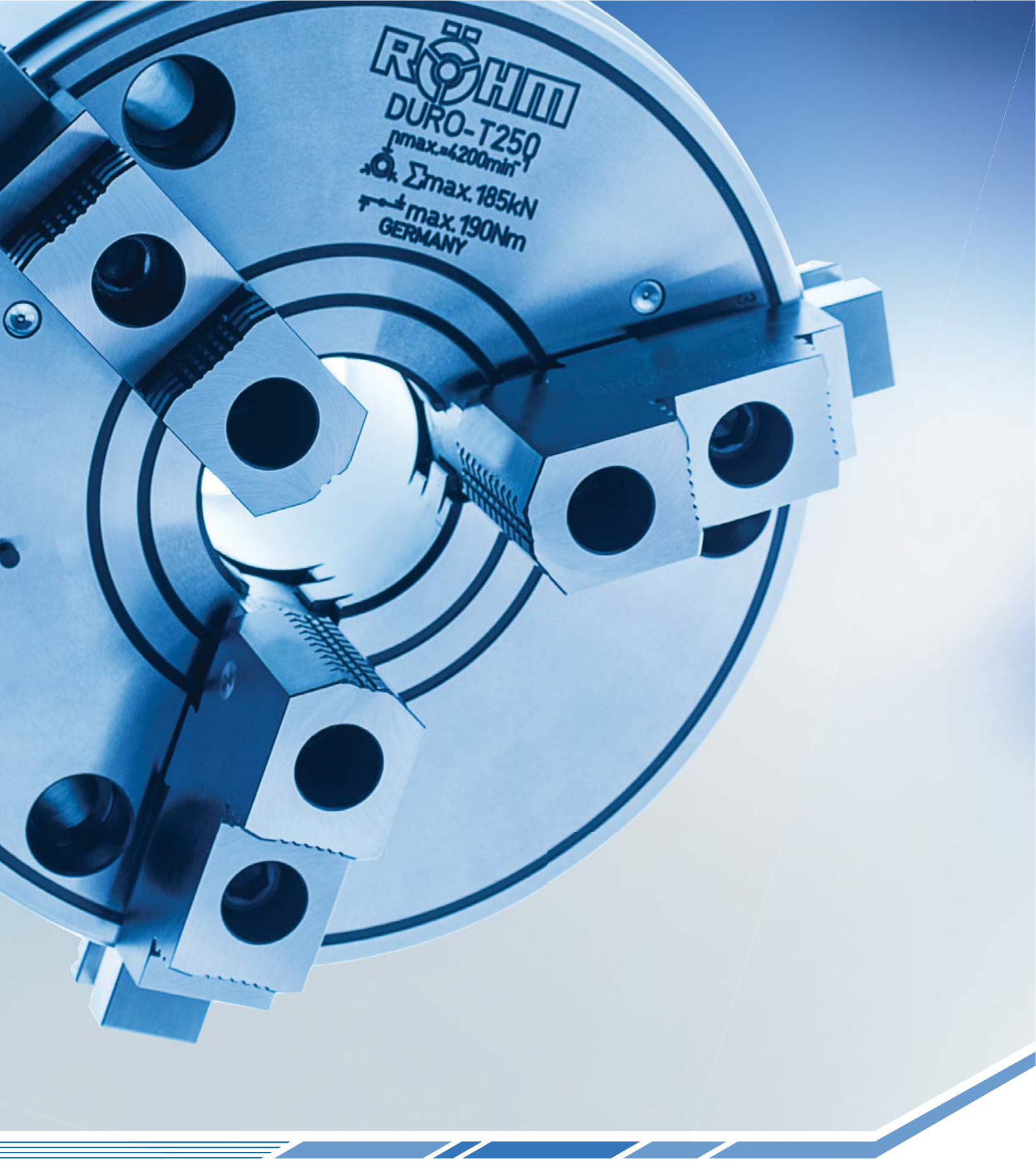


LATHE CHUCKS
INDEPENDENT CHUCKS

RÖHM
driven by technology

2015/2016

We work for customers who have a weakness for our strengths.

Companies intent on making a difference are obliged to develop constantly as well as deploy their strengths to the benefit of customers. At RÖHM, we have set ourselves high targets and are doing our very best to achieve them. This is why we support our customers all over the world by means of the six performance indicators so typical of RÖHM:

Dynamism
Variety
Security
Partnership
Globality
Innovation


RÖHM
DURO-T200
nmax=4600min-1
Smax. 114kN
max. 155Nm
GERMANY
Achtung

Table of contents

LATHE CHUCKS I INDEPENDENT CHUCKS

Operation guide





TYPE	DURO-T	DURO-TA	DURO-TA XT	ZS - ZSU	Orange Line
	Key bar chucks with quick-acting jaw change system			Geared scroll chucks	
Chucking capacities	3 - 630 mm	3 - 646 mm	8 - 1190 mm	2 - 1224 mm	3 - 315 mm
Mount	Cylindrical centre mount DIN 6350 ISO 702-3 (DIN 55027)	Cylindrical centre mount DIN 6350	Individual	Cylindrical centre mount DIN 6350 ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027) DIN 6350 BW (mounting from front)	Cylindrical centre mount DIN 6350
Through-hole	✔			✔	✔
Number of jaws	3	3	3	3 / 4	3 / 4
Types of jaws	■ ■ ■	■ ■ ■	■ ■ ■	■ ■	■ ■
Workpiece	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■
Machining	■ ■	■ ■	■ ■	■ ■	■ ■
Rotating/ Stationary	■ ■	■ ■	■ ■	■ ■	■ ■
Clamping	■	■	■	■	■
Clamping force	■■■■□	■■■■□	■■■■□	■■■□□	■■■□□
Speed max.	■■■■■	■■■■■	■■■□□	■■■□□	■■□□□
Precision	■■■■□	■■■■□	■■■□□	■■□□□	■■□□□
Feature	quick-acting jaw change system	grinding chuck with quick-acting jaw change system	weight reduced	with splash water groove and control edge	with splash water groove and control edge
Page	3009	3018	3025	3034	3042

✔ yes

3-jaw chuck

4-jaw chuck

pipe

bar

disc

flange

asymmetrical workpiece

Operation guide





TYPE	ZS Hi-Tru	ES	KRF	USE - USU	UGE - UGU
	Geared scroll chucks			Independent chucks	
Chucking capacities	2 - 315 mm	3 - 630 mm	2 - 200 mm	20 - 1270 mm	8 - 1250 mm
Mount	Cylindrical centre mount DIN 6350	Cylindrical centre mount DIN 6351	Cylindrical centre mount DIN 6350	Cylindrical centre mount ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027)	Cylindrical centre mount ISO 702-2 (DIN 55029) ISO 702-3 (DIN 55027)
Through-hole	✔	✔	✔	✔	✔
Number of jaws	3	3 / 4	3 / 4	3	3
Types of jaws	inside jaw + outside jaw, reversible jaw	reversible jaw	reversible jaw	inside jaw + outside jaw, reversible jaw	inside jaw + outside jaw, reversible jaw
Workpiece	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw	base jaw, base and top jaw
Machining	lenght machining, side machining	lenght machining, side machining		lenght machining, side machining	lenght machining, side machining
Rotating/ Stationary	rotating, stationary	rotating, stationary	stationary	rotating, stationary	rotating, stationary
Clamping	self-centering	self-centering	self-centering	self-centering	self-centering
Clamping force	■■■□□	■■■□□	■□□□□	■■□□□	■■□□□
Speed max.	■■■□□	■■■□□	■□□□□	■■□□□	■□□□□
Precision	■■■■■	■■□□□	■□□□□	■■□□□	■■□□□
Feature	radial precision adjustment, with special seal for grinding machines	independently adjustable jaws	keyless clamping, specially for measu-ring and grinding machines	independently adjustable jaws	independently adjustable jaws
Page	3048	3059	3066	3074	3080

 inside jaw + outside jaw

 reversible jaw

 rotating

 independently adjustable

 base jaw

 lenght machining

 stationary

 base and top jaw

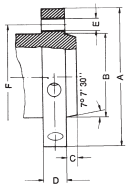
 side machining

 self-centering

Machine spindle noses for DIN and ASA B 5.9

Machine spindle noses (not included in the scope of delivery)

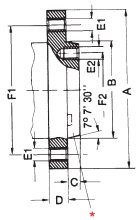
ISO 702-2 (DIN 55029 and ASA B 5.9 D1)
Camlock fixing (ISO 702-2)



Spindle nose size	A	B	C	D	E	F
3	92,1	53,985	11,1	31,8	3x15,1	70,66
4	117,5	63,525	11,1	33,3	3x16,7	82,55
5	146	82,575	12,7	38,1	6x19,8	104,8
6	181	106,390	14,3	44,5	6x23	133,4
8	225,4	139,735	15,9	50,8	6x26,2	171,4
11	298,5	196,885	17,5	60,3	6x31	235
15	403	285,800	19	69,9	6x35,7	330,2
20	546	412,800	21	82,5	6x42,1	463,6

Latest edition of relevant DIN standard applies in each case

Typ A1-A2, B1-B2



A1: Tapped holes in flange (outer bolt circle) and inner bolt circle. From taper size 4 with driver.

A2: Tapped holes in flange (outer bolt circle) without inner bolt circle.

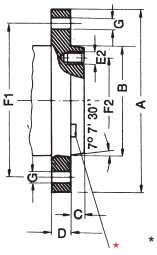
Spindle nose size	A	B	$C_{-0,025}$	D	Holes on outer bolt circle (F1) E1	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
A1 (corresponds ISO 702-1)								
5	133,4	82,575	14,288	22,2	11x $^{7}/_{16}$-14 UNC	104,8	8x $^{7}/_{16}$-14 UNC	61,9
6	165,1	106,390	15,875	25,4	11x $^{1}/_{2}$-13 UNC	133,4	8x $^{1}/_{2}$-13 UNC	82,6
8	209,5	139,735	17,462	28,6	11x $^{5}/_{8}$-11 UNC	171,4	8x $^{5}/_{8}$-11 UNC	111,1
11	279,4	196,885	19,05	34,9	11x $^{3}/_{4}$-10 UNC	235	8x $^{3}/_{4}$-10 UNC	165,1
15	381	285,800	20,638	41,3	12x $^{7}/_{8}$-9 UNC	330,2	11x $^{7}/_{8}$-9 UNC	247,6
20	520	412,800	22,225	47,6	12x 1-8 UNC	463,6	12x $^{1-8}$ UNC	368,3

Spindle nose size	A	B	C	D	Holes on outer bolt circle (F1) E1	Outer bolt circle F1
A2 (entspricht ISO 702-1)						
3	92,1	53,985	11,1	15,9	3x $^{7}/_{16}$-14 UNC	70,66
4	108	63,525	11,1	19	11x $^{7}/_{16}$-14 UNC	82,55
5	133,4	82,575	12,7	22,2	11x $^{7}/_{16}$-14 UNC	104,8
6	165,1	106,390	14,3	25,4	11x $^{1}/_{2}$-13 UNC	133,4
8	209,5	139,735	15,9	28,6	11x $^{5}/_{8}$-11 UNC	171,4
11	279,4	196,885	17,5	34,9	11x $^{3}/_{14}$-10 UNC	235
15	381	285,800	19	41,3	12x $^{7}/_{8}$-9 UNC	330,2
20	520	412,800	20,6	47,6	12x 1-8 UNC	463,6

B1: Through-holes in flange (outer bolt circle), tapped holes in inner bolt circle - from taper size 4 with driver.

B2: Through-holes in flange (outer bolt circle) **without** inner bolt circle.

Spindle nose size	A	B	$C_{-0,025}$	D	F1 G	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
B1								
5	133,4	82,575	14,288	22,2	11x11,9	104,8	8x $^{7}/_{16}$-14 UNC	61,9
6	165,1	106,390	15,875	25,4	11x13,5	133,4	8x $^{1}/_{2}$-13 UNC	82,6
8	209,5	139,735	17,462	28,6	11x16,7	171,4	8x $^{5}/_{8}$-11 UNC	111,1
11	279,4	196,885	19,05	34,9	11x20,2	235	8x $^{3}/_{4}$-10 UNC	165,1
15	381	285,800	20,638	41,3	12x23,4	330,2	11x $^{7}/_{8}$-9 UNC	247,6
20	520	412,800	22,225	47,6	12x26,6	463,6	12x 1-8 UNC	368,3



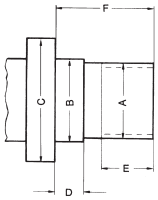
* From taper size 4 with driver

Spindle nose size	A	B	C	D	G	Outer bolt circle F1
B2						
3	92,1	53,985	11,1	15,9	3x11,9	70,66
4	108	63,525	11,1	19	11x11,9	82,55
5	133,4	82,575	12,7	22,2	11x11,9	104,8
6	165,1	106,390	14,3	25,4	11x13,5	133,4
8	209,5	139,735	15,9	28,6	11x16,7	171,4
11	279,4	196,885	17,5	34,9	11x20,2	235
15	381	285,800	19	41,3	12x23,4	330,2
20	520	412,800	20,6	47,6	12x26,6	463,6

Machine spindle noses for DIN and ASA B 5.9

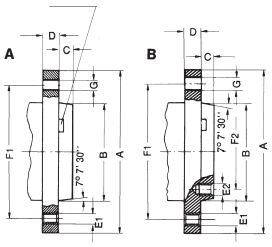
Machine spindle noses (not included in the scope of delivery)

DIN 800, with thread



Mean tol. A	Bg5	Minimum C	D	E	F
M20	21	30	6,3	10	20
M24	25	36	8	12	24
M33	34	50	9	14	30
M39	40	56	10	16	35
M45	46	67	11	18	40
M52	55	80	12	20	45
M60	62	90	14	22	50
M76x6	78	112	16	30	63
M105x6	106	150	20	40	80

DIN 55021
From taper size 4 with driver

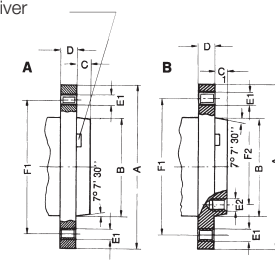


Spindle nose size	A	B	C	D	Holes on outer bolt circle (F1) E1	G	Outer bolt circle F1	Holes on inner bolt-circle (F2) E2	Inner bolt circle F2
3	102	53,985	11	16	3xM10	3x10,5	75	-	-
4	112	63,525	11	20	3xM10	3x10,5	85	-	-
5	135	82,575	13	22	7xM10	4x10,5	104,8	8xM10	61,9
6	170	106,390	14	25	7xM12	4x13	133,4	8xM12	82,6
8	220	139,735	16	28	7xM16	4x17	171,4	8xM16	111,1
11	290	196,885	18	35	12xM20	6x21	235	11xM20	165,1
15	380	285,800	20	42	12xM24	6x25	330,2	11xM24	247,6
20	520	412,800	21	48	12xM24	6x25	463,6	11xM24	368,3

Form A: Tapped holes and through-holes in flange (**without** inner bolt circle)

Form B: Tapped holes and through-holes in flange (outer bolt circle) **and** tapped holes in inner bolt circle

ISO 702-1 (DIN 55026)
From taper size 4 with driver

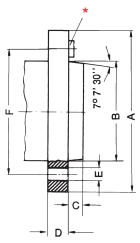


Spindle nose size	A	B	C	C_1	D	Holes on outer bolt circle E1	Outer bolt circle F1	Holes on inner bolt circle (F2) E2	Inner bolt circle F2
3	92	53,983	11	-	16	3xM10	70,6	-	-
4	108	63,521	11	-	20	11xM10	82,6	-	-
5	133	82,573	13	14,288	22	11xM10	104,8	8xM10	61,9
6	165	106,385	14	15,875	25	11xM12	133,4	8xM12	82,6
8	210	139,731	16	17,462	28	11xM16	171,4	8xM16	111,1
11	280	196,883	18	19,05	35	11xM20	235	8xM20	165,1
15	380	285,791	19	20,638	42	12xM24	330,2	11xM24	247,6
20	520	412,795	21	22,225	48	12xM24	463,6	11xM24	368,3

Form A: Tapped holes in flange (outer bolt circle) without inner bolt circle.

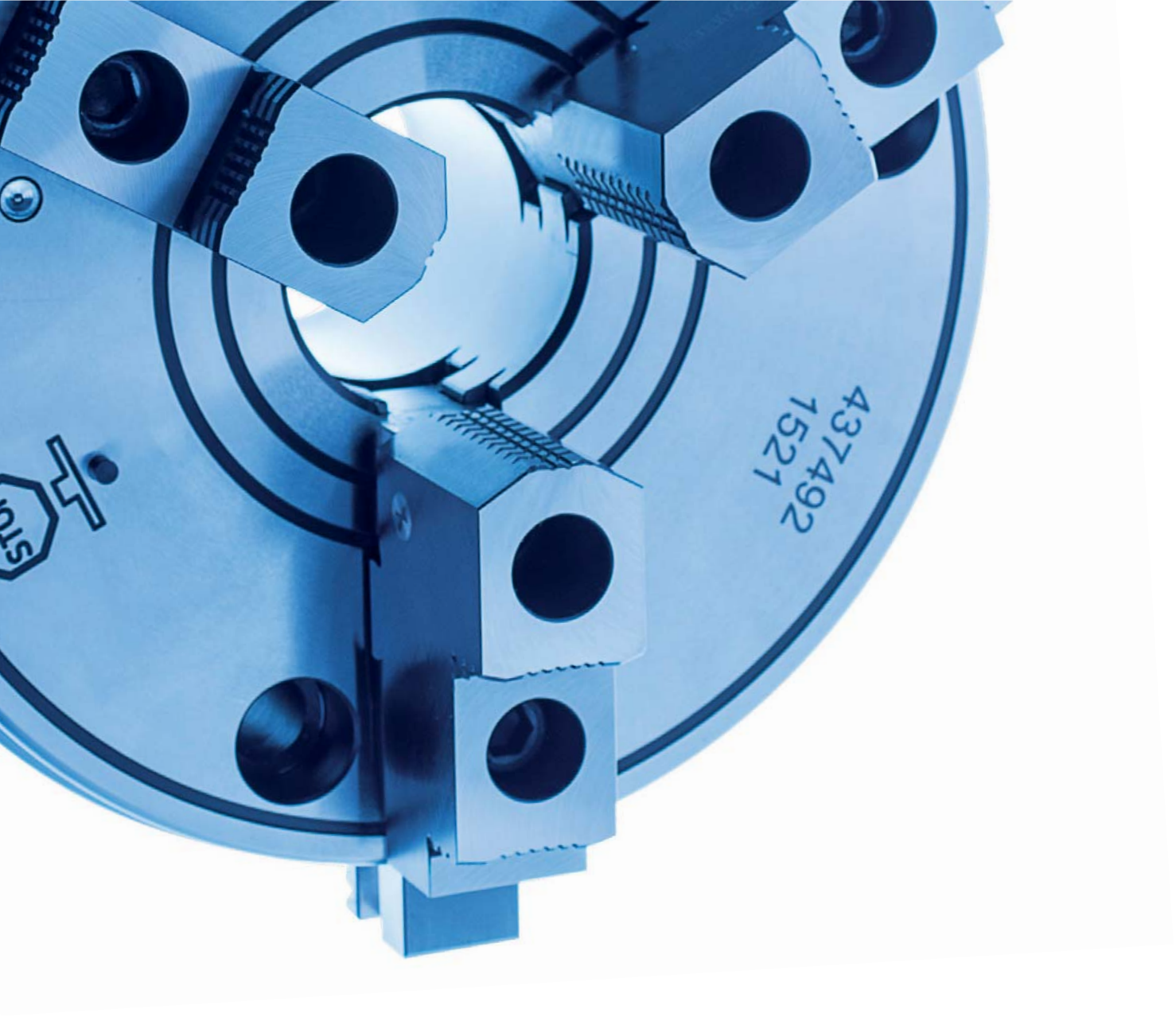
Form B: Tapped holes in flange (outer bolt circle) and in inner bolt circle.

ISO 702-3 (DIN 55027 und 55022)
With bayonet ring fixing (ISO 702/III)



* From taper size 4 with driver

Spindle nose size	A	B	C	D	Number of holes x E	F
3	102	53,985	11	16	3x21	75
4	112	63,525	11	20	3x21	85
5	135	82,575	13	22	4x21	104,8
6	170	106,390	14	25	4x23	133,4
8	220	139,735	16	28	4x29	171,4
11	290	196,885	18	35	6x36	235
15	400	285,800	19	42	6x43	330,2
20	540	412,800	21	48	6x43	463,6



QUICK-ACTING JAW CHANGE SYSTEM

The RÖHM key bar chucks with quick-acting jaw change system convince in two ways. On the one hand the jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds. On the other the key bar chucks convince with maximum clamping forces and maximum accurancy thanks to direct force transfer via the key bar system. Large, straight surfaces transmitting the force from the key bar to the jaw teeth guarantee long life and produce a very high clamping force combined with an accurancy which is twice high as required by DIN 6386. The high clamping force is achieved without much physical effort by manually turning the key.

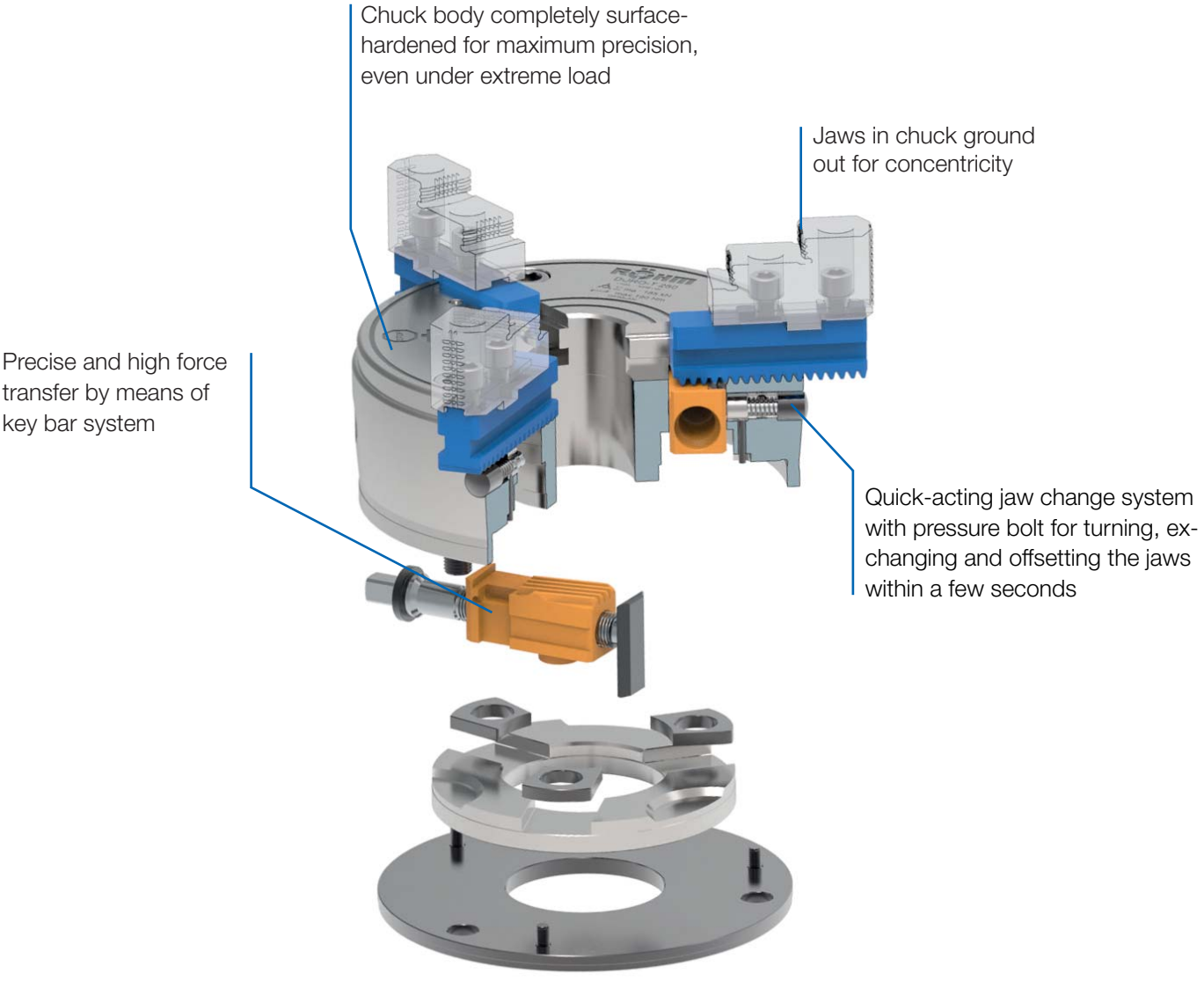
Video DURO-T

KEY BAR CHUCK WITH QUICK-ACTION JAW CHANGE SYSTEM

The RÖHM key bar chucks with quick-acting jaw change system are used successfully in areas where extremely high clamping forces, high concentricity and reliable long-term repeatability are required. Thanks to the quick-acting jaw change system, the jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds.

ADVANTAGES AT A GLANCE

- Maximum clamping forces thanks to direct force transfer via the key bar system
- Maximum concentricity and axial run-out tolerance
- High user-friendliness thanks to quick-acting jaw change system



DURO-T

The DURO-T key bar chuck guarantees maximum precision, maximum clamping force and is completely balanced ex works

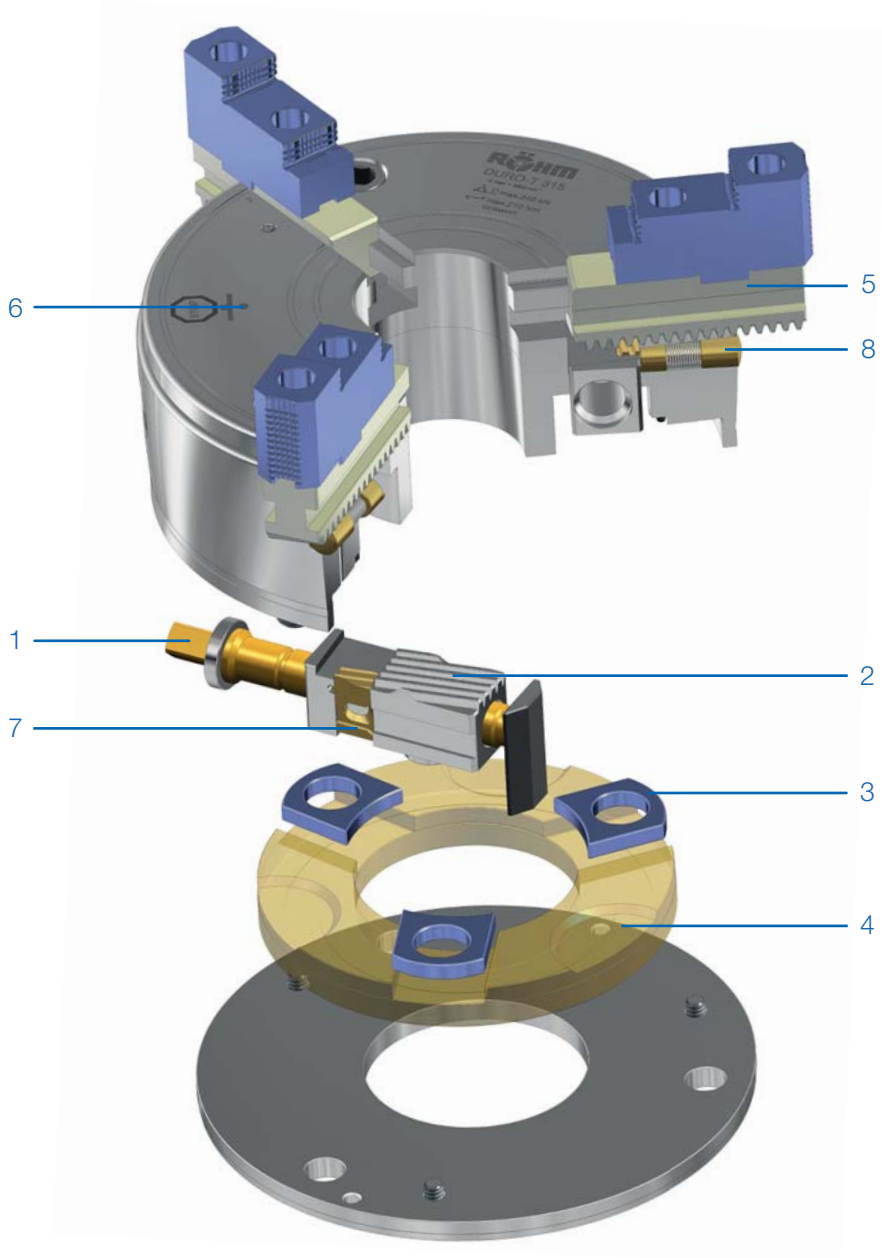
Principle of operation

Thanks to the tangentially arranged threaded spindle (1), the force is transferred via a key bar (2) having an internal thread. The key bar moves the drive ring via a slide (3). Two other slides in the drive ring (4) transfer the forces to the other two key bars. The key bars having an inclined profile engage in the base jaws (5), thereby guaranteeing exact, centric clamping. The jaws can be quickly and easily turned, changed or offset over the entire clamping range within a few seconds. To do this, the key bars must be disengaged by turning the key to the left; the indicator pin (6) will project here. In this position, the jaws are secured against being hurled out in the event the machine spindle is started up unintentionally. Therefore, the gate valve (7) of each jaw must be unlocked via the corresponding pressure bolt (8) on the outer diameter of the chuck.

Large, straight-line force transfer surfaces between the key bar and jaw toothing yield a very high clamping force over a long service life and precision which is twice as high as prescribed by DIN 6386. The high clamping force is achieved without exerting any special amount of force by manually turning the key.

Lubrication

To maintain the clamping force, rotary chucks must be lubricated regularly. You will find corresponding information in the operating instructions which are enclosed with every chuck. For easy maintenance, DURO-T chucks are equipped with three additional grease nipples on the front side.



DURO-T

APPLICATION

Optimized for turning applications, which require extremely high clamping forces, maximum concentricity, as well as reliable long-term repeatability.
In combination with a base plate, stationary use on milling machines, dividing units and machining centers.

TYPE

Key bar chuck with quick-action jaw change system.
Guaranteed maximum jaw precision as far as these are only used on the same chuck, and base and top jaws are kept screwed on for recurring work.

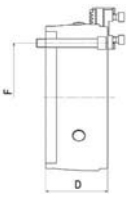
CUSTOMER BENEFITS

- Maximum clamping force thanks to key bar system
- Concentricity and axial run-out tolerance twice as exact as required in DIN precision class 1
- Very high jaw-change repeatability
- Balanced and jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With jaw safeguard
- Chuck body completely surface-hardened
- Visual marking for quick jaw adjustment
- External shape incl. splash-water edge
- Fastening options for strongly stressed sliding surfaces
- Incl. safety key
- High corrosion protection

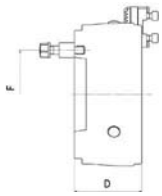
A08
Cylindrical centre mount



Size	Inch	Through-hole mm	With one-piece reversible jaws	With base jaws and reversible top jaws	D mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
125	5	32	**437475**	-	46,5	6000	40	23
160	6 1/4	42	**437476**	**437490**	63	5400	120	73
200	8	52	**437477**	**437491**	81	4600	155	114
250	10	62	**437478**	**437492**	92	4200	190	185
315	12 1/2	87	**437479**	**437493**	111	3300	210	240
400	15 3/4	102	**437480**	**437494**	118	2200	260	260
500	20	162	**437481**	**437495**	118	1900	320	290
630	25	252	-	**437496**	143	1100	350	320

1) at size 630 chuck body without convex outer contours
Further sizes and mountings available on request

A08
ISO 702-3 (DIN 55027), with studs and locknuts



Size	Mount short taper	Through-hole mm	With one-piece reversible jaws	With base jaws and reversible top jaws	D mm	F mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
125	5	32	**437499**	-	67	104,8	6000	40	23
160	5	42	**437501**	**437548**	78	104,8	5400	120	73
160	6	42	**437502**	**437549**	85	133,4	5400	120	73
200	5	52	**437504**	**437551**	96	104,8	4600	155	114
200	6	52	**437505**	**437552**	97	133,4	4600	155	114
250	6	62	**437509**	**437556**	108	133,4	4200	190	185
250	8	62	**437510**	**437557**	110	171,4	4200	190	185
315	8	87	**437512**	**437559**	129	171,4	3300	210	240
315	11	87	**437513**	**437560**	131	235	3300	210	240
400	8	102	**437515** ▲	**437562** ▲	138	171,4	2200	260	260
400	11	102	**437516** ▲	**437563** ▲	138	235	2200	260	260
500	11	162	**437519** ▲	**437566** ▲	156	235	1900	320	290
500	15	162	**437520** ▲	**437567** ▲	163	330,2	1900	320	290
630	11	192	-	**437568** ▲	165	235	1100	350	320
630	15	252	-	**437569** ▲	167	330,2	1100	350	320

1) at size 630 chuck body without convex outer contours
Further sizes and mountings available on request

Jaws DURO-T

A28
One-piece jaw EB, set, diagonally toothing, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
212121	125	set	50	34	14
094000	160	set	77,7	45	20
094001	200	set	94,7	60	22
094002	250	set	114	70	26
094003	315	set	130	79	32
094043	400/500	set	167	93	45

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped Jaw BL, set, diagonally toothing, unstepped, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
304864	125	set	53	34	14
241699	160	set	84,4	45	20
249678	200	set	98,4	60	22
249679	250	set	118,7	70	26
249680	315	set	136,6	79	32
249681	400/500	set	173,6	93	45

A28
Reversible top jaw UB, set, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094012	160	set	61,5	32,5	20,4
094013	200	set	70,5	38	24,4
094014	250	set	92	50	34,4
094015	315	set	107	56	35,7
094045	400/500	set	130	72	50,4
140715	630	Satz	185	102	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, set, **standard design**, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
212123	125	set	55	25,5	20,7
094008	160	set	85	36,5	20,3
094009	200	set	105	40	22
094010	250	set	125	50	30,4
094011	315	set	145	50	34,3
094046	400/500	set	180	73	50,5
140716	630	set	260	102	68

A28
Unstepped top jaw AB, set, **extendend design**, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
137055	160	set	85	42,5	24,4
137056	200	set	105	51	34,3
137057	250	set	125	75	50,5
137058	315	set	145	74	50,5

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws DURO-T

A28
Base jaw GB, set, diagonally toothing, with mounting bolts

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
212119	125	set	47	14
094004	160	set	74	20
094005	200	set	90	22
094006	250	set	110	26
094007	315	set	125	32
094044	400/500	set	160	45
140194	630	set	230	65

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **large clamping range**, 1 piece hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137060	160	66	37,5	24
137119	400/500	124	62	50
151289	630	144	78	70

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **small clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137061	160	66	37,5	20
137064	200	81	43	24
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **middle sized clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137062	160	56	37,5	20
137065	200	66	43	24
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **small clamping range**, 1 piece hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137066	160/200	79	43	34
137110	250	80	55	50
137116	315	93	62	50

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Jaws DURO-T

C 21
Reversible claw-type top jaws, large design, tongue and groove, **large clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137067	160/200	81	43	34
137111	250	90	55	50
137117	315	106	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **middle sized clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137068	160/200	66	43	34
137112	250	72	55	50
137118	315	86	62	50

C 21
Draw-down jaws, without clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141037	160	84,4	43,5	20
141039	200	98,4	47,5	22
141041	250	118,7	58,5	26
141043	315	136,4	63,9	32
141045	400/500	173,6	73,4	45

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141038	160	84,4	43,5	20
141040	200	98,4	47,5	22
141042	250	118,7	58,5	26
141044	315	136,4	63,9	32
141046	400	173,6	73,4	45
141048	500	173,6	73,4	45

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Jaws DURO-T

C 15
Interchangeable clamping inserts, 1 piece **with claws**

Item no.	Chuck Size
141049	160/200
141052	250/315
141055	400/500/630

C 15
Interchangeable clamping inserts, 1 piece with **serrated toothing**

Item no.	Chuck Size
141050	160/200
141053	250/315
141056	400/500

C 15
Interchangeable clamping inserts, 1 piece **with heat treatable surface**

Item no.	Chuck Size
141051	160/200
141054	250/315
141057	400/500

C15
Jaw mounting bolt, piece

Item no.	Size	Thread	Contents of delivery
243893	125	M6x10	piece
200182	160/200	M8x1x22	piece
200183	250	M12x1,5x30	piece
202402	315	M12x1,5x35	piece
227618	400/500	M16x1,5x40	piece
249388	630	M20x50	piece

Accessories DURO-T

A08

Base plate with fixing slots
Complete with mounting screws and fixed T-slot nuts. Other sizes available on request.

Item no.	Size
143163	160
143165	200
143167	250

A08

Key

Item no.	Size	Square	L mm
212124	125	8	85
094016	160	10	140
094017	200	12	160
094018	250	14	220
094019	315	17	230
094047	500	19	250
332938	630	24	410

Only for stationary used chucks

A08

Safety key

Item no.	Size	Square	L mm
242172	125	8	85
242173	160	10	140
242174	200	12	160
242175	250	14	220
242176	315	17	230
242177	500	19	250
332939	630	24	410

corresponding with DIN 1550 for rotating chucks

A08

Chip guard, set

Item no.	Size	Contents of delivery
212122	125	set
236439	160	set
236440	200	set
236441	250	set
236442	315	set
236443	500	set

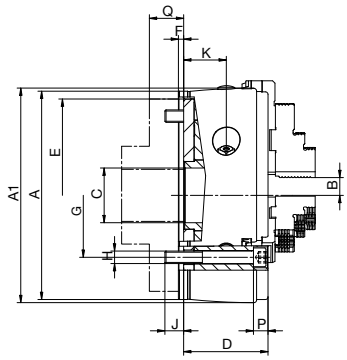
C15

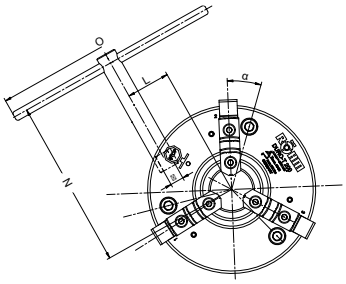
Special grease F80 **for lathe chucks**
For lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

▲ on request

Technical Data DURO-T





Chuck size A		125	160	200	250	315	400	500	630
Outer diameter	A1	128	164	206	256	322	407	507	630
Jaw movement	B	4,8	6,2	6,8	8	10,2	12,5	12,5	14
Bore	C	32	42	52	62	87	102	162	252
Bore cab be enlarged	C max.	35	45	55	75	102	130	180	270
	D	46,5	63	81	92	111	118	118	143
	E^{H6}	115	145	185	235	300	380	460	580
	F	4	5	5	6	6	6	6	6
	G	100	125	160	200	250	315	400	520
	H	3xM8	3xM10	3xM12	3xM16	3xM20	3xM24	3xM24	3xM24
	J	12	15	18	25	30	37	37	37
	K	22,5	31,5	43	47	59	57,7	57,5	72
	L	32,5	42	53,5	66,5	86	110	152,5	196
	M	SW8	SW10	SW12	SW14	SW17	SW19	SW19	SW24
	N	117	182	211	284	309	359	356	570
	O	180	210	270	450	500	600	600	600
	P	8,5	13	14	17	21	25	25	29
Min. thickness of flange	Q	17	30	30	35	35	40	45	55
Moment of inertia GD2 1)	kgm^2	0,01	0,03	0,10	0,29	0,87	2,37	5,78	17,04
	α	21° 35´	22°	18°	19°	17°	20°	42°	69° 30´
approx. kg	kg	4,0	9,3	18,6	34,5	64	112	166	300

1) The moment of inertia was measured with base jaws but without top jaws or back plate
The bore could be enlarged (measure C, at surcharge)
Enlarged bore max.

Max. permissible speed

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

Chuck size		125	160	200	250	315	400	500	630
Max. speed	min^{-1}	6000	5400	4600	4200	3300	2200	1900	1100

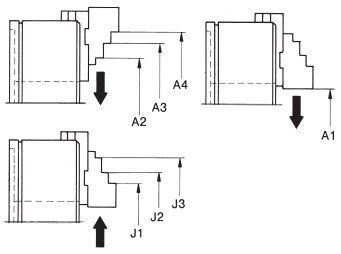
Gripping force

The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F80.

Chuck size		125	160	200	250	315	400	500	630
Torque applied on key 1)	Nm	10	40	60	70	80	90	100	100
Total gripping force 1)	kN	8,5	30	48	66	80	95	102	102
Torque applied on key	Nm	40	120	155	190	210	260	320	350
Max. total gripping force	kN	23	73	114	185	240	260	290	320

1) maintaining the accuracy

At this torque the clamping jaws have been ground at the factory,
for testing the chuck must be clamped with this torque

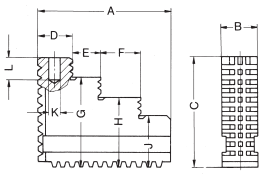


Chuck capacities of jaw steps

Chuck size			125	160	200	250	315	400	500	630
External chucking	Jaw position	A1	3-30	5-51	7-70	8-97	12-131	16-168	40-256	20-322
		A2	31-65	45-91	58-123	82-172	93-216	119-278	167-360	200-490
		A3	63-97	89-135	114-179	-	-	-	-	-
		A4	95-129	115-161	142-207	163-253	201-323	260-413	308-501	360-650
Internal chucking		J1	26-59	67-105	71-131	99-182	102-213	120-272	166-360	184-489
		J2	57-91	93-132	99-159	-	-	-	-	-
		J3	89-123	135-174	154-214	178-261	207-319	260-412	306-500	341-646

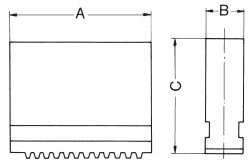
Jaw dimensions DURO-T

Reversible one-piece jaw **EB**, hardened and ground, jaw steps not ground



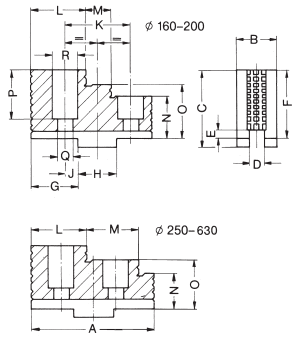
Chuck size	125	160	200	250	315	400+500
A	50	77,7	94,7	114	130	167
B	14	20	22	26	32	45
C	34	45	60	70	79	93
D	10,7	20,6	23	41,5	40,2	50,5
E	16	18,9	19,5	40,3	54	71
F	16	22	28	-	-	-
G	29	37,5	50	56	64	73
H	24	30	40	-	-	-
J	19	22,5	30	42	49	53
K	-	8	10	13	13	20
L	-	16	15	19,5	19,5	30
Jaw approx. kg	0,400	0,500	0,635	1,135	1,835	3,665

Block jaw **BL**, unstepped, soft, thread and jaw guides hardened and ground



Chuck size	125	160	200	250	315	400+500
A	53	84,4	98,4	118,7	136,6	173,6
B	14	20	22	26	32	45
C	34	45	60	70	79	93
Jaw approx. kg	0,435	0,500	0,900	1,535	2,400	5

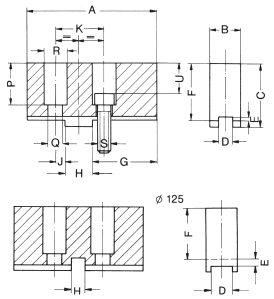
Reversible top jaw **UB**, completely hardened, cross tenon ground, jaw steps not ground



Chuck size	160	200	250	315	400+500	630
A	61,5	70,5	92	107	130	185
B	20,4	24,4	34,4	35,7	50,4	68
C	37	43	55	62	79	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	56	72	102
G	22,5	25,5	30	35,5	41,4	59
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
L	26,5	28,5	41	40	51	80
M	13	14	40,5	54	71	80
N	17,5	18	22	26	32	42
O	25	28	36	41	52	72
P	23,5	29	39	40	57	82
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
T[1)]	38,5	45	57	63,6	80,6	114
Jaw approx. kg	0,200	0,335	0,800	1,135	2,535	6,350

1) Dimension marked on base jaw

Unstepped soft top jaw **AB**, for turning out special chucking diameters

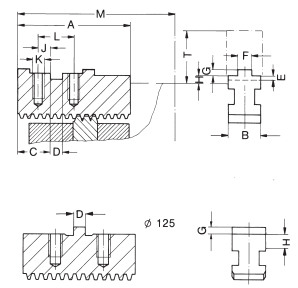


Dimensions for extendend design

Chuck size	125	160		200		250		315		400+500	630
A	55	85	**85**	105	**105**	125	**125**	145	**145**	180	260
B	20,7	20,3	**24,4**	22	**34,3**	30,4	**50,5**	34,3	**50,5**	50,5	68
C	31,3	41	**47**	45	**56**	55	**80**	56	**80**	80	110
D	14	8	**8**	10	**10**	12	**12**	12	**12**	18	24
E	3,3	3	**3**	3,5	**3,5**	3,5	**3,5**	3,5	**3,5**	4,5	4,5
F	25,5	36,5	**42,5**	40	**51**	50	**75**	50	**74**	73	102
G	25	42	**42**	50	**50**	70	**70**	74	**74**	100	150
H	5	18	**18**	20	**20**	20	**20**	26	**26**	30	40
J	7,5	7	**7**	10	**10**	10	**10**	14	**14**	15	21
K	20	32	**32**	40	**40**	40	**40**	54	**54**	60	82
P	24	27,5	**33,5**	31	**42**	39	**54**	34	**48**	58	83
Q	6,5	9	**9**	9	**9**	14	**14**	14	**14**	18	22
R	11	15	**15**	15	**15**	20	**20**	20	**20**	26	33
S	M6	M8x1	**M8x1**	M8x1	**M8x1**	M12x1,5	**M12x1,5**	M12x1,5	**M12x1,5**	M16x1,5	M20
T[1)]	32	42,5	**48,5**	47	**58**	57	**72**	57,6	**71,6**	81,6	114
U	18	19,5	**25,5**	23	**34**	27	**42**	22	**36**	42	63
Jaw approx. kg	0,200	0,435	**0,600**	0,735	**1,400**	1,500	**3,700**	2,265	**4,800**	4,500	13,350

1) Dimension marked on base jaw

Base jaws **GB,** hardened and ground



Chuck size	125	160	200	250	315	400+500	630
A	47	74	90	110	125	160	230
B	14	20	22	26	32	45	65
C	21	19	23	26	30	35	52
D	5	18	20	20	26	30	40
E	-	5	5,5	5,5	6,5	7,5	9
F	-	8	10	12	12	18	24
G	2,8	2,5	3	3	3	4	4
H	3,55	6	7	7	7,6	8,6	12
J	7,5	7	10	10	14	15	21
K	M6	M8x1	M8x1	M12x1,5	M12x1,5	M16x1,5	M20
L	20	32	40	40	54	60	82
M	72	103	129	163	196	250 | 294	399
Jaw approx. kg	0,200	0,265	0,365	0,700	1,065	2,350	5,665

Notes

DURO-TA - sealed design

APPLICATION

Specially for grinding machines.
Optimized for extremely high clamping forces, maximum concentricity, as well as reliable long-term repeatability.

TYPE

Key bar chuck with quick-action jaw change system.
Guaranteed maximum jaw precision as far as these are only used on the same chuck, and base and top jaws are kept screwed on for recurring work.

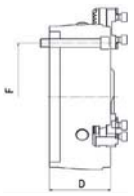
CUSTOMER BENEFITS

- Maximum clamping force thanks to key bar system
- With cover for protection against dust on the face
- Very high jaw-change repeatability

TECHNICAL FEATURES

- With jaw safeguard
- Chuck body completely surface-hardened
- Visual marking for quick jaw adjustment
- External shape incl. splash-water edge
- Fastening options for strongly stressed sliding surfaces
- Incl. safety key
- High corrosion protection

A08
Cylindrical centre mount



Size	Inch	With base jaws	With inside and outside jaw	D mm	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN
160	6 1/4	**439606**	**439605**	63	5400	120	73
200	8	**439608**	**439607**	81	4600	155	114
250	10	**439610**	**439609**	92	4200	190	185

Further sizes and mountings available on request

▲ on request

Jaws DURO-TA

A28
Outside jaw DB, set, inward stepped jaw, hardened

Item no.	Chuck Size	Contents of delivery	Jaw width
329041	160	set	20
329042	200	set	22
329043	250	set	26

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Inside jaw BB, set, outward stepped jaw, hardened

Item no.	Chuck Size	Contents of delivery	Jaw width
329038	160	set	20
329039	200	set	22
329040	250	set	26

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, **set,** soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
329044	160	set	90	36,5	20,3
329045	200	set	100	40	22
094010	250	set	125	50	30,4

A28
Base jaw GB, **set,** hardened, with mounting bolts

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
329047	160	set	74	8	20
329048	200	set	90	10	22
329049	250	set	110	12	26

C15
Jaw mounting bolt, 1 piece

Item no.	Chuck Size	Thread	Contents of delivery
200182	160/200	M8x1x22	piece
200183	250	M12x1,5x30	piece

Configure your individual clamping jaws online! www.web2product.biz

Accessories DURO-TA

A08

Base plate with fixing slots
Complete with mounting screws and fixed T-slot nuts. Other sizes available on request.

Item no.	Size
143163	160
143165	200
143167	250

A08

Key

Item no.	Size	Square	L mm
094016	160	10	140
094017	200	12	160
094018	250	14	220

Only for stationary used chucks

A08

Safety key

Item no.	Size	Square	L mm
242173	160	10	140
242174	200	12	160
242175	250	14	220

corresponding with DIN 1550 for rotating chucks

A08

Chip guard, set

Item no.	Size	Contents of delivery
236439	160	set
236440	200	set
236441	250	set

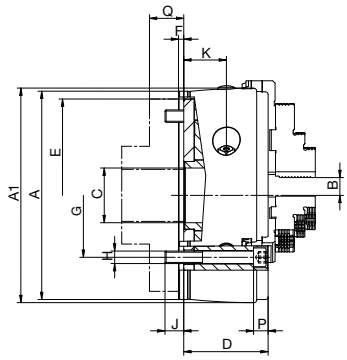
A08

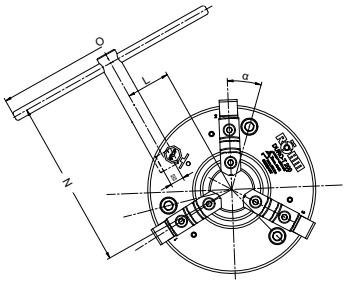
Special grease F80 for **lathe chucks**
For lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

▲ on request

Technical data DURO-TA





Chuck size		160	200	250
Outer diameter	A	160	206	255
Jaw movement	B	6,2	6,8	8
Bore	C	42	52	62
Bore can be enlarged	C max.	45	55	75
	D	63	81	92
	E^{H6}	145	185	235
	F	5	5	6
	G	125	160	200
	H	3xM10	3xM12	3xM16
	J	15	18	25
	K	31,5	43	47
	L	42	53,5	66,5
	M	SW10	SW12	SW14
	N	182	211	284
	O	210	270	450
	P	13	14	17
Min. thickness of flange	Q	30	30	35
Moment of inertia 1)	kgm^2	0,03	0,10	0,29
	α	22°	18°	19°
Weight approx	kg	9,5	20°	35

1) The moment of inertia was measured with base jaws but without top jaws or back plate
The bore could be enlarged (measure C, at surcharge)

Enlarged bore max.

Max. permissible speed
The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

Chuck size		160	200	250
Max. speed	min^{-1}	5400	4600	4200

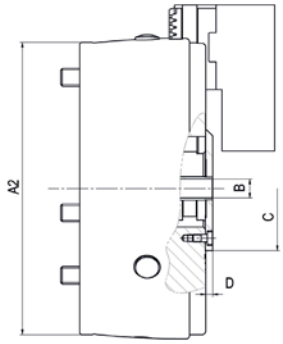
Gripping force
The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F80.

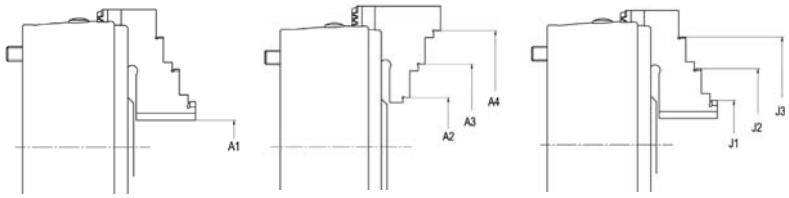
Chuck size		160	200	250
Torque applied on key in1)	Nm	20	30	35
Total gripping force1)	kN	15	24	33
Torque applied on key in	Nm	120	155	190
Max. total gripping force	kN	73	114	185

1) maintaining the accuracy

Chucking capacities of jaw steps

Chuck size			160	200	250
External chucking	Jaw position.	A1	5-51	7-70	8-97
		A2	45-91	58-123	82-172
		A3	89-135	114-179	-
		A4	115-161	142-207	163-253
Internal chucking		J1	67-105	71-131	99-182
		J2	93-132	99-159	-
		J3	135-174	154-214	178-261

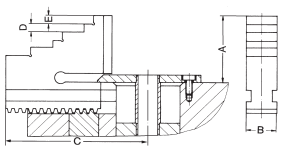




Chuck dimensions DURO-TA - Main dimensions (other dimensions on the table on the top)

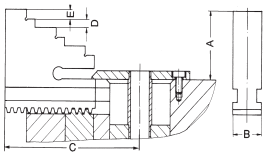
Chuck size		160	200	250
Outer diameter	A	160	206	255
External chucking with BB-jaws		3-46	3-60	5-66
External chucking with DB-jaws		23-160	32-200	65-243
Internal chucking with BB jaws		28-156	32-195	47-225
Central bor for coolant	B	13	13	13
	C	70	85	92
	D	5	6	5

Jaw dimensions and chucking capacity DURO-TA



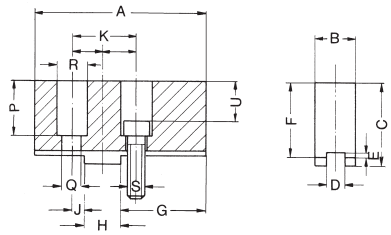
Outward stepped jaw **BB**

Chuck size	160	200	250
A	46	55	60
B	20	22	26
C max.	95	120	143,5
C min.	72	91	113
D	5	7	6
E	6	6	8
Jaw approx. kg	0,465	0,643	1,065



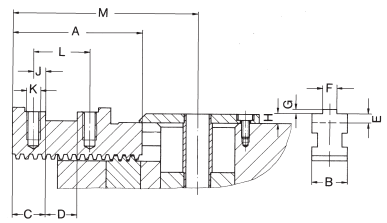
Inward stepped jaw **DB**

Chuck size	160	200	250
A	43	50	50
B	20	22	26
C max.	95	120	143,5
C min.	72	91	113
D	5	7	6
E	6	6	8
Jaw approx. kg	0,435	0,600	1,065



Unstepped soft top jaw **AB**

Chuck size	160	200	250
A	90	100	125
B	20,3	22	30
C	41	45	55
D	8	10	12
E	3	3,5	3,5
F	36,5	40	50
G	55	61	70
H	18	20	20
J	6	6	10
K	30	32	40
P	27,5	31	39
Q	9	9	14
R	15	15	20
S	M8x1	M8x1	M12x1,5
U	19,5	23	27
Jaw approx. kg	0,435	0,800	1,500



Base jaw **GB**

Chuck size	160	200	250
A	74	90	110
B	20	22	26
C	17	19	26
D	18	20	20
E	5	5,5	5,5
F	8	10	12
G	2,5	7	7
H	6	20	20
J	7	6	10
K	M8x1	M8x1	M12x1,5
L	32	32	40
M max.	105	127	148,5
M min.	91	103	125
Jaw approx. kg	0,335	0,365	0,700

Notes

DURO-TA XT

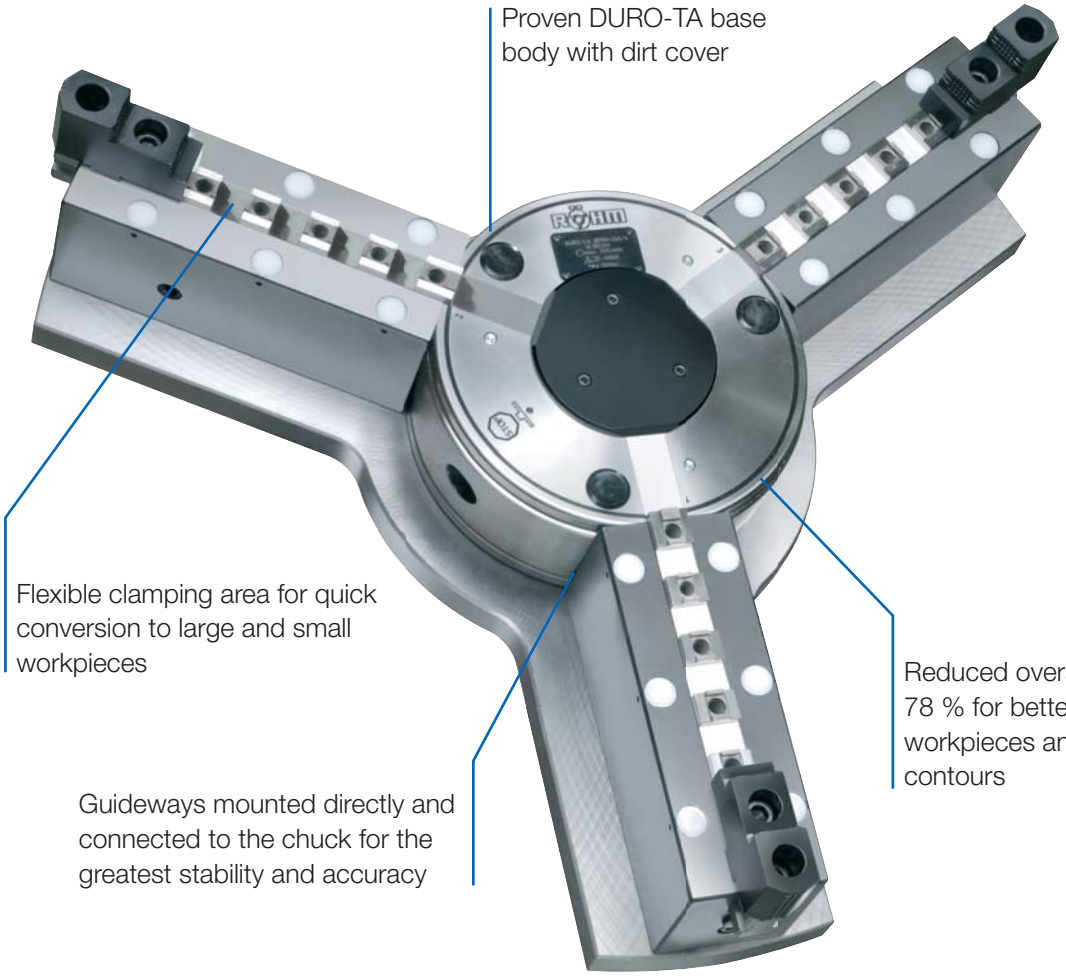
Equipped with extended and easy to assemble guideways the new lightweight DURO-TA XT is convincing with a flexible clamping area for machining large and small workpieces. Weight-reducing by up to 75 % makes maximum utilisation of the machine's potential possible.

Guideways

The new DURO-TA XT has an innovative concept for guideways that guarantees flexible and weight-reducing use. In contrast to other large chucks, the DURO-TA XT is up to 75 % lighter and that way makes maximum utilisation of the machine's potential possible and clamping of higher workpiece weights. Through the extended and easy to assemble guideways, the clamping area can be set flexibly and hence converted quickly to large and small workpieces. Through the direct mount on the base body, the guideways guarantee extremely high rigidity, stability and protection against penetration by dirt and dust.

Principle of operation

Thanks to the tangentially arranged threaded spindle, the force is transferred via a key bar having an internal thread. The key bar moves the drive ring via a slide. Two other slides in the drive ring transfer the forces to the other two key bars. The key bars having an inclined profile engage in the base jaws, thereby guaranteeing exact, centric clamping.



DURO-TA XT

APPLICATION

On turning and milling machines.

TYPE

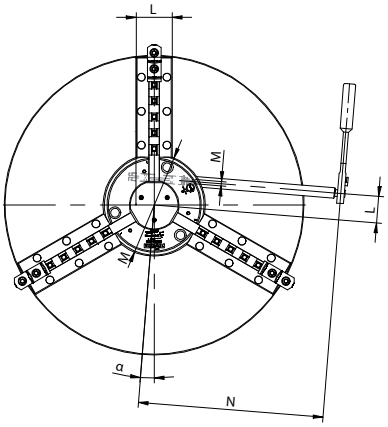
Key bar chuck (DURO-TA) with removable guideways.

CUSTOMER BENEFITS

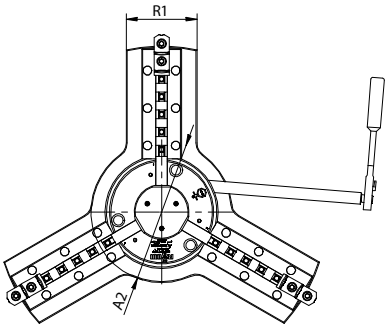
- Weight reduction by up to 75 %
- Maximum flexibility and faster conversion
- Innovative design with minimum interference contour and maximum stability

TECHNICAL FEATURES

- Weight reduction by up to 75 % allows maximum utilization of the machine potential and the clamping of heavier workpieces
- Flexible clamping range thanks to elongated guideways for faster conversion between large and small workpieces
- Easy dismounting of the guideways for clamping smaller workpieces
- Minimum interference contour and better workpiece accessibility thanks to compact design and a reduced design height by up to 78 %
- High stability thanks to direct support of the permanently screwed guideways



full base plate



max. lightweight base plate

A08

DURO-TA XT key bar chuck, with complete base plate

Item no.	Size	Clamping range external with extended jaws mm	Clamping range external with standard jaws * mm	Interfering contour ** mm	Jaw travel mm	Weight kg	Speed max. min^{-1}	Max. Torque Nm	Max. total clamping force kN	Weight reduction compared to a standard chuck %
180312	750 (250)	145-715	8-253	804 / 769	8	183	800	190	185	75
180313	1000 (315)	220-995	12-323	1082 / 1014	10,2	365	570	210	190	68
180314 ▲	1250 (500)	220-1190	40-501	1305	12,5	640	570	320	290	65

Customized adaptations of the base plate for further weight reduction on the machine table on request

* By disassembling of the stripping cap and use of standard reversible jaws

** By shortening of the base jaws. Please consider shorter clamping ranges

Further sizes and mountings available on request

Jaws DURO-TA XT

A28
One-piece jaw EB, set, diagonally toothing, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094002	750 (250)	set	114	70	26
094003	1000 (315)	set	130	79	32
094043	1250 (500)	set	167	93	45

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.
Jaws only usable in basic chuck.

A28
Unstepped Jaw BL, set, diagonally toothing, unstepped, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
249679	750 (250)	set	118,7	70	26
249680	1000 (315)	set	136,6	79	32
249681	1250 (500)	set	173,6	93	45

Jaws only usable in basic chuck.

A28
Reversible top jaw UB, set, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094014	750 (250)	set	92	50	34,4
094015	1000 (315)	set	107	56	35,7
094045	1250 (500)	set	130	72	50,4

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.
Jaws only usable in basic chuck.

A28
Base jaw GB, set, diagonally toothing, with mounting bolts

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
094006	750 (250)	set	110	26
094007	1000 (315)	set	125	32
094044	1250 (500)	set	160	45

Jaws only usable in basic chuck.

C 21
Draw-down jaws, without clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141041	750 (250)	118,7	58,5	26
141043	1000 (315)	136,4	63,9	32
141045	1250 (500)	173,6	73,4	45

Jaws only usable in basic chuck.

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts, **diagonally toothing**, 1 piece, without clamping inserts

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
141042	750 (250)	118,7	58,5	26
141044	1000 (315)	136,4	63,9	32
141048	1250 (500)	173,6	73,4	45

Jaws only usable in basic chuck.

▲ on request

Jaws DURO-TA XT

C 15
Interchangeable clamping inserts, 1 piece, **with claws**

Item no.	Chuck Size
141052	750 (250) / 1000 (315)
141055	1250 (500)

Jaws only usable in basic chuck.

C 15
Interchangeable clamping inserts, 1 piece, **with serrated toothing**

Item no.	Chuck Size
141053	750 (250) / 1000 (315)
141056	1250 (500)

Jaws only usable in basic chuck.

C 15
Interchangeable clamping inserts, 1 piece, **with heat treatable surface**

Item no.	Chuck Size
141054	750 (250) / 1000 (315)
141057	1250 (500)

Jaws only usable in basic chuck.

A28
Reversible top jaw UB, set, hardened

Id.-Nr.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
180410	750	set	92	50	34,4
180411	1000	set	107	56	35,7
180412	1250	set	130	72	50,4

Additionally or later purchased, hardened jaws must be ground out in the chuck..
For jaws which are applied later, send in the chuck.

A28
Unstepped top jaw AB, **set, standard design**, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
094010	250	set	125	50	30,4
094011	315	set	145	50	34,3
094046	400/500	set	180	73	50,5

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **large clamping range,** 1 piece hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137119	400/500	124	62	50

Jaws DURO-TA XT

C 21
Reversible claw-type top jaws, **standard design,** tongue and groove, **middle sized clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 21
Reversible claw-type top jaws, standard design, tongue and groove, **small clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **small clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137110	250	80	55	50
137116	315	93	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **middle sized clamping range**, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137112	250	72	55	50
137118	315	86	62	50

C 21
Reversible claw-type top jaws, large design, tongue and groove, **large clamping range,** 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137111	250	90	55	50
137117	315	106	62	50

Accessories DURO-TA XT

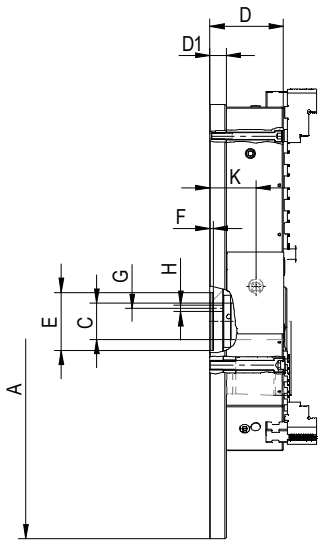
C15

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

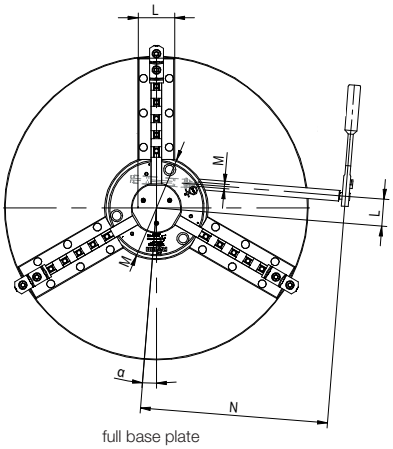
▲ on request

Technical data DURO-TA XT

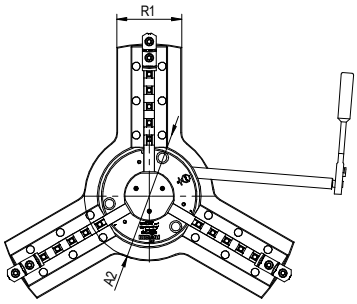


Chuck size A		750	1000	1250
Outer diameter Chuck	A1	256	322	507
Outer diameter Base plate	A2	320	400	590
Jaw movement	B	8	10,2	12,5
Bore 1)	C	62	87	162
	D	127	152	160
	D^1	28	34	35
	E^{H6}	100	100	100
	F	6	6	6
	G	45	45	45
	H	11	11	11
	K	79,5	98,0	97,5
	L	66,5	86	152,5
	M	SW14	SW17	SW19
	N	464	565	724
	R	90	100	130
	R1	160	180	210
	S	370	495	615
Moment of inertia GD2 2)	kgm^2	10,52	37,92	98,70
Moment of inertia GD2 2) 3)	kgm^2	5,66	18,10	48,93
	α	4,6°	4,6°	4,5°
approx. kg	kg	183	365	640
approx. kg 3)	kg	127	233	436

1) With dirt cover
2) The moment of inertia was measured with base jaws but without top jaws
3) With max. lightweight base plate



full base plate



max. lightweight base plate

Max. permissible speed
The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum grippping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The specification DIN 6386 Part 1 shall be observed.

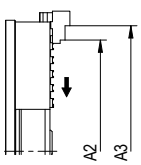
Chuck size		750	1000	1250
Max. speed	min^{-1}	800	570	450

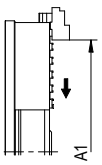
Gripping force
The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece.
The specified gripping forces are standard values.
They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F79 and F8**0.**

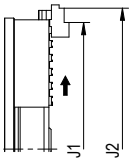
Chuck size		750	1000	1250
Torque applied on key 1)	Nm	70	80	100
Total gripping force 1)	kN	66	80	102
Torque applied on key	Nm	190	210	320
Max. total gripping force	kN	185	240	290

1) Maintaining the accuracy

At this torque the clamping jaws have been ground at the factory,
for testing the chuck must be clamped with this torque







Chuck capacities of jaw steps

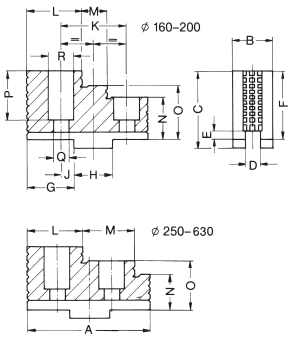
Chuck size			750	1000	1250
External chucking	Jaw position	A1	144-618	215-864	215-1140
		A2	144-638	330-890	199-1159
		A3	224-719	223-995	340-1200
Internal chucking		J1	227-700	298-946	318-1141
		J2	307-780	404-1052	459-1282
max. interfering contour			808/**773	1086/**1018	1309

** By shortening of the base jaws. Please consider shorter clamping ranges.

Jaw dimensions DURO-TA XT

Reversible top jaw UB, completely hardened, cross tenon ground, jaw steps not ground

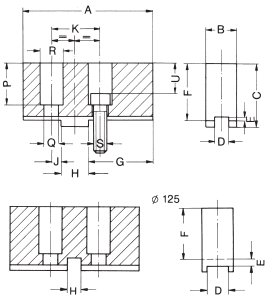
Jaws only usable in basic chuck.



Chuck size	750	1000	1250
A	92	107	130
B	34,4	35,7	50,4
C	55	62	79
D	12	12	18
E	3,5	3,5	4,5
F	50	56	72
G	30	35,5	41,4
H	20	26	30
J	10	14	15
K	40	54	60
L	41	40	51
M	40,5	54	71
N	22	26	32
O	36	41	52
P	39	40	57
Q	14	14	18
R	20	20	26
T[1)]	57	63,6	80,6
Jaw approx. kg	0,800	1,135	2,535

1) Dimension marked on base jaw

Unstepped soft top jaw **AB**, for turning out special chucking diameters

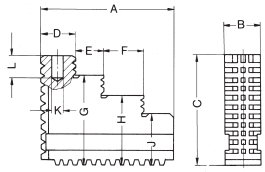


Dimensions for extendend design

Chuck size	750		1000		1250
A	125	**125**	145	**145**	180
B	30,4	**50,5**	34,3	**50,5**	50,5
C	55	**80**	56	**80**	80
D	12	**12**	12	**12**	18
E	3,5	**3,5**	3,5	**3,5**	4,5
F	50	**75**	50	**74**	73
G	70	**70**	74	**74**	100
H	20	**20**	26	**26**	30
J	10	**10**	14	**14**	15
K	40	**40**	54	**54**	60
P	39	**54**	34	**48**	58
Q	14	**14**	14	**14**	18
R	20	**20**	20	**20**	26
S	M12x1,5	**M12x1,5**	M12x1,5	**M12x1,5**	M16x1,5
T[1)]	57	**72**	57,6	**71,6**	81,6
U	27	**42**	22	**36**	42
Jaw approx. kg	1,500	**3,700**	2,265	**4,800**	4,500

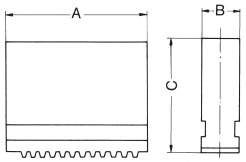
1) Dimension marked on base jaw

Reversible one-piece jaw **EB**, hardened and ground, jaw steps not ground
Jaws only usable in basic chuck.



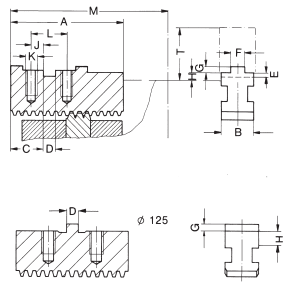
Chuck size	750	1000	1250
A	114	130	167
B	26	32	45
C	70	79	93
D	41,5	40,2	50,5
E	40,3	54	71
F	-	-	-
G	56	64	73
H	-	-	-
J	42	49	53
K	13	13	20
L	19,5	19,5	30
Jaw approx. kg	1,135	1,835	3,665

Blockbacken **BL**, ungestuft, ungehärtet, Verzahnung und Führung gehärtet und geschliffen. **Jaws only usable in basic chuck.**



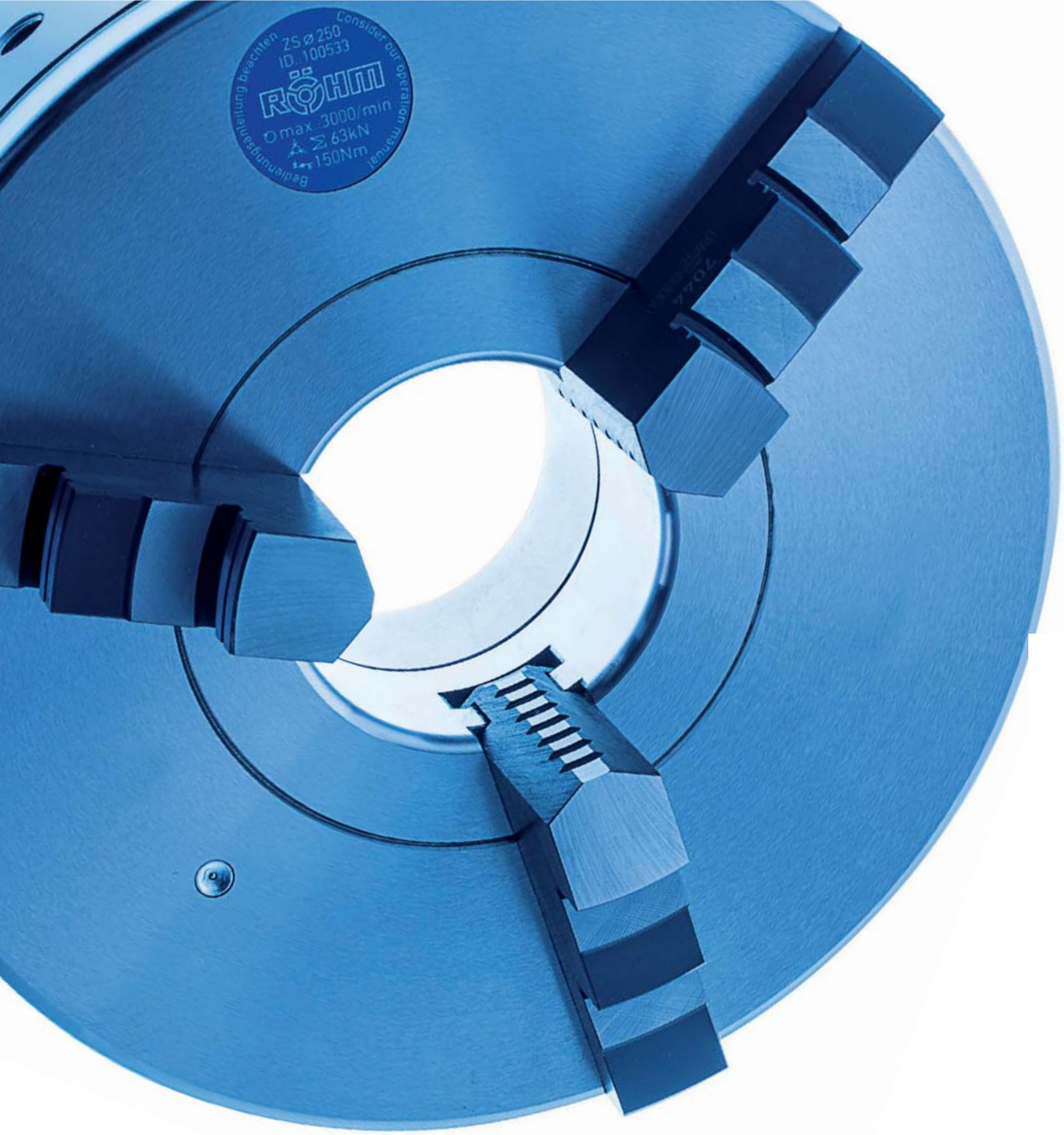
Chuck size	750	1000	1250
A	118,7	136,6	173,6
B	26	32	45
C	70	79	93
Jaw approx. kg	1,535	2,400	5

Base jaws **GB**, hardened and ground
Jaws only usable in basic chuck.



Chuck size	750	1000	1250
A	110	125	160
B	26	32	45
C	26	30	35
D	20	26	30
E	5,5	6,5	7,5
F	12	12	18
G	3	3	4
H	7	7,6	8,6
J	10	14	15
K	M12x1,5	M12x1,5	M16x1,5
L	40	54	60
M	163	196	250 294
Jaw approx. kg	0,700	1,065	2,350

Notes



PROVEN CHUCK WITH SPIRAL RING

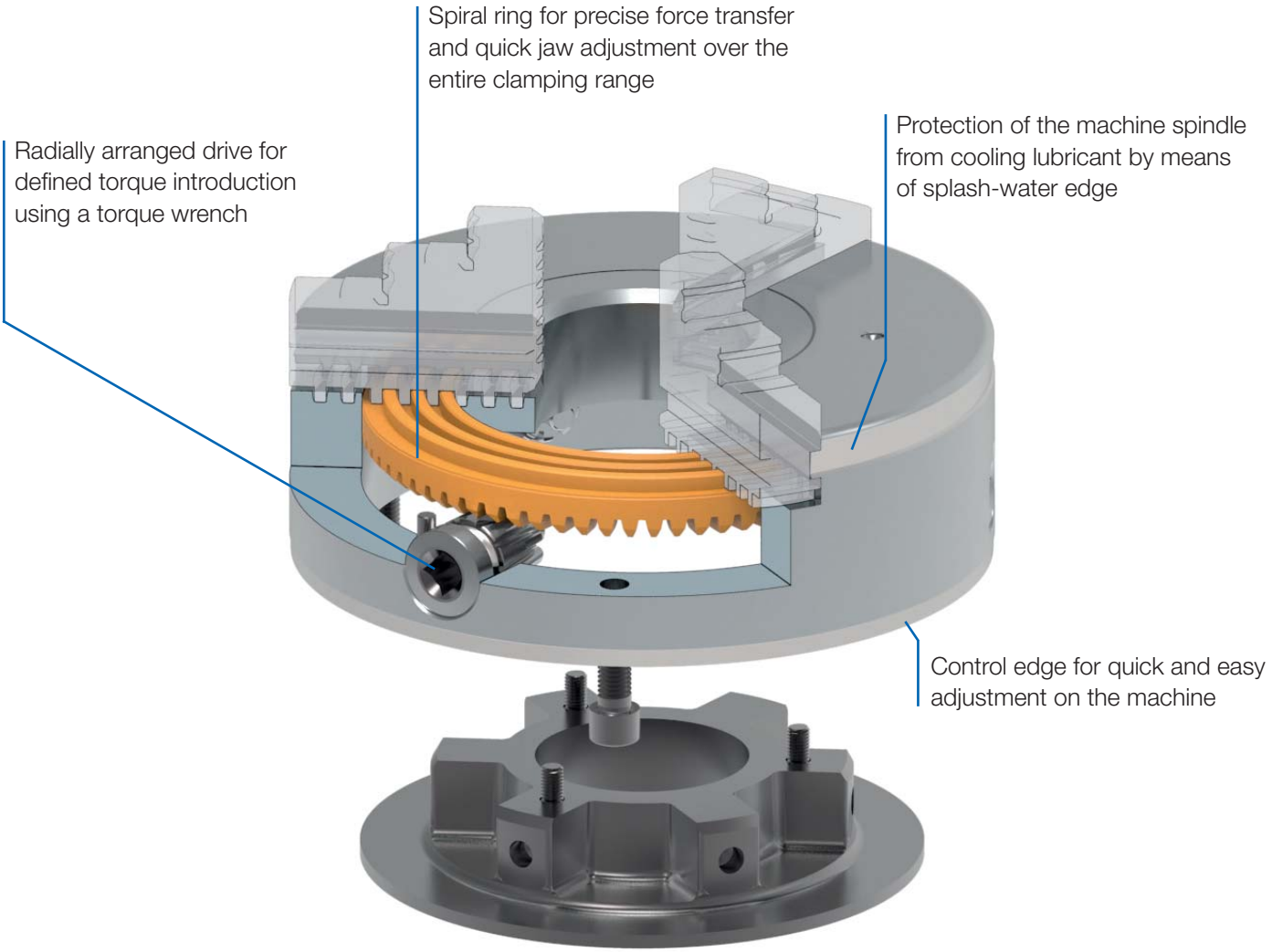
The RÖHM geared scroll chucks have already been in use for decades and have proven themselves a thousand times over. The jaws can be quickly adjusted over the entire clamping range by means of the spiral ring. Using the radially arranged drive, the force is transferred to the hardened spiral ring via a bevel gearing and further conducted to the clamping jaws via the spiral.

GEARED SCROLL CHUCKS

The RÖHM geared scroll chucks have proven themselves a thousand times over and have already been used successfully on lathes, rotary tables and dividing attachments for decades. The jaws can be adjusted over the entire clamping range in order to be able to very quickly clamp workpieces with a wide clamping diameter range without offsetting the jaws.

ADVANTAGE AT A GLANCE

- Quick jaw adjustment over the entire clamping range
- Proven chuck with optimal price/performance ratio
- Protection of the machine spindle by means of splash-water edge



ZS - ZSU

APPLICATION

Proven rotary chuck for use in areas requiring high clamping forces, high concentricity as well as reliable long-term repeatability.
For universal use on lathes, rotary tables, dividing units, etc.

TYPE

Geared scroll chucks in steel design.

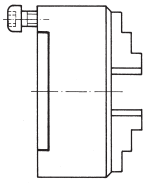
CUSTOMER BENEFITS

- High clamping force
- Special flat design with direct mounting
- The jaws can be adjusted over the entire clamping range by turning the key. This allows workpieces with different clamping diameters to be quickly clamped
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one-piece jaws or with base and top jaws
- Steel body and spiral ring die-forged
- Series-balanced and hardened

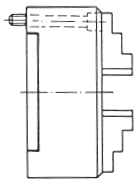
A09
DIN 6350, cylindrical centre mount, form A



Size	Cylindrical centre mount	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	3 jaw chuck with base and reversible top jaw	4 jaw chuck with base and reversible top jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
80	56	19	**102513**	**102505**	-	-	7000	30	13
100	70	20	**101782**	**102130**	**101788**	**102136**	6300	60	27
125	95	32	**101672**	**106075**	**101678**	**106081**	5500	80	31
160	125	42	**100717**	**101164**	**100725**	**101170**	4600	110	47
200	160	55	**100186**	**100466**	**100189**	**100484**	4000	140	55
250	200	76	**100533**	**101030**	**100541**	**101036**	3000	150	63
315	260	103	**101344**	**101598**	**101350**	**101901**	2300	180	69
400	330	136	**102062**	**102330**	**102068**	**102336**	1800	240	92
500	420	190	**102555**	**103340**	**102585**	**103346**	1300	260	100
630	545	240	**102720**	**102856**	**102726**	**102862**	850	280	105
800	710	380	**104913**	**104917**	-	-	700	300	110
1000	910	460	**104925**	**104929**	-	-	560	450	115
1250	910	550	**104941**	**104945**	-	-	450	450	115

Further sizes and mountings available on request

A09
Mounting from front, DIN 6350, cylindrical centre mount



Size	Cylindrical centre mount	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	95	32	**120155**	**124447**	5500	80	31
160	125	42	**115568**	**125802**	4600	110	47
200	160	55	**113158**	**113160**	4000	140	55
250	200	76	**114304**	**114306**	3000	150	63
315	260	103	**120270**	**129946**	2300	180	69
400	330	136	**123475** ▲	**134401** ▲	1800	240	92
500	420	190	**127616** ▲	**123465** ▲	1300	260	100
630	545	240	**128545** ▲	**135061** ▲	850	280	105

Further sizes and mountings available on request

▲ on request

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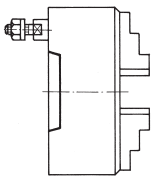
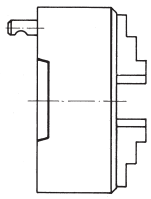
A09
ISO 702-3 (DIN 55027), with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	3 jaw chuck with base and reversible top jaw	4 jaw chuck with base and reversible top jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	4	32	**101692**	**107015**	**101695**	**107021**	5500	80	31
160	4	42	**100740**	**101184**	**100743**	**101187**	4600	110	47
160	5	42	**100744**	**101188**	**100747**	**101191**	4600	110	47
200	5	55	**100152**	**100472**	**100155**	**101420**	4000	140	55
200	6	55	**100156**	**101422**	**100159**	**101428**	4000	140	55
250	6	76	**100555**	**101050**	**100564**	**101059**	3000	150	63
250	8	76	**100556**	**101051**	**100565**	**101060**	3000	150	63
315	6	103	**101364**	**101919**	**101373**	**101922**	2300	180	69
315	8	103	**101365**	**101923**	**101374**	**101926**	2300	180	69
315	11	103	**101366**	**101927**	**101375**	**101930**	2300	180	69
400	8	136	**102202**	**101876**	**102208**	**101882**	1800	240	92
400	11	136	**102210**	**101884**	**102216**	**101890**	1800	240	92
500	11	190	**102548** ▲	**102971** ▲	**102554** ▲	**102977** ▲	1300	260	100
500	15	190	**102915** ▲	**103227** ▲	**102921** ▲	**103233** ▲	1300	260	100
630	11	192,7	**102752** ▲	**102888** ▲	**102758** ▲	**102894** ▲	850	280	105
630	15	240	**102760** ▲	**103084** ▲	**102766** ▲	**103090** ▲	850	280	105

Further sizes and mountings available on request

A09
ISO 702-2 (DIN 55029); ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	Through-hole mm	3 jaw chuck with inside and outside jaw	4 jaw chuck with inside and outside jaw	3 jaw chuck with base and reversible top jaw	4 jaw chuck with base and reversible top jaw	Speed max. min^{-1}	Torque Nm	Total clamping force kN
125	4	32	**108895**	**109208**	**105870**	**105872**	5500	80	31
160	4	42	**108897**	**109210**	**105882**	**105886**	4600	110	47
160	5	42	**109150**	**109213**	**105898**	**106302**	4600	110	47
200	5	55	**109151**	**109214**	**106330**	**106334**	4000	140	55
200	6	55	**109154**	**109217**	**106346**	**106350**	4000	140	55
250	6	76	**109155**	**109218**	**106386**	**106390**	3000	150	63
250	8	76	**109159**	**109222**	**106402**	**106406**	3000	150	63
315	6	103	**109156**	**109219**	**106442**	**106446**	2300	180	69
315	8	103	**109160**	**109223**	**106458**	**106462**	2300	180	69
315	11	103	**109165**	**109228**	**106474**	**106478**	2300	180	69
400	8	136	**109161**	**109224**	**106498**	**106602**	1800	240	92
400	11	136	**109166**	**109229**	**106614**	**106618**	1800	240	92
500	11	190	**109167** ▲	**109230** ▲	**103274** ▲	**106646** ▲	1300	260	100
500	15	190	**109170** ▲	**109233** ▲	**103275** ▲	**103271** ▲	1300	260	100
630	11	192,7	**109168** ▲	**109231** ▲	**106658** ▲	**106662** ▲	850	280	105
630	15	240	**109171** ▲	**109234** ▲	**103328** ▲	**106251** ▲	850	280	105

Further sizes and mountings available on request

Jaws ZS - ZSU

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**110155**	**110063**	37	26	12
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20
250	**110161**	**110069**	90	67,5	24
315	**110162**	**110070**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**110165**	**110073**	37	26	12
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20
250	**110171**	**110079**	90	67,5	24
315	**110016**	**110080**	130	79,5	34
400	**110017**	**110081**	130	79,5	34
500/630	**110018**	**110082**	190	95	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
80	**107588**	**107598**	37	26	12
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20
250	**107594**	**107604**	90	67,5	24
315	**107595**	**107605**	130	79,5	34
400	**107596**	**107644**	130	79,5	34
500/630	**107597**	**107645**	190	95	42

A09
Base jaw GB DIN 6350 with fixing screw

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw width
100	**107500**	**107542**	46	14
125	**107501**	**107543**	55	18
160	**107503**	**107545**	65	18
200	**107504**	**107546**	78	20
250	**107505**	**107547**	92	24
315	**107506**	**107548**	108	34
400	**107507**	**107549**	127	34
500	**107508**	**107550**	165	42
630	**107509**	**107551**	203	42
800	**105272**	**141616**	291	55
1000	**105274**	**141611**	329	55
1250	**105275**	**141614**	367	55

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Jaws ZS - ZSU

A09
Reversible top jaws UB DIN 6350, hardened

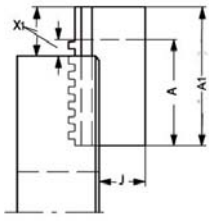
Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**108045**	**108053**	47	29,5	22
125	**108046**	**108054**	56	37,5	26
160	**107936**	**107938**	66,7	41,5	28
200	**107937**	**107939**	79,5	42,5	30
250	**108049**	**108057**	95,3	52,5	36
315	**108050**	**108058**	109,5	57,5	42
400	**108051**	**108059**	127	64,5	42
500/630	**108052**	**108060**	127	79,5	50
800	**105081**	**105085**	210	89	68
1000/1250	**105098**	**105101**	210	110	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5

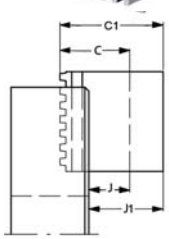
Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107633**	**107641**	53	30	22,5
125	**107634**	**107642**	62	38	26,5
160	**108581**	**108583**	74	42	28,5
200	**108582**	**108584**	87	43	30,5
250	**107637**	**107579**	103	53	36,5
315	**107638**	**107580**	120	58	42,5
400	**107639**	**107581**	137	65	42,5
500/630	**107640**	**107582**	140	80	50,5
800	**105103**	**105105**	210	89	68
1000/1250	**105107**	**105109**	210	110	68

A09
Unstepped jaw BL, special length, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	A mm	J mm	X max. mm
200	**130031**	**137073**	100	50	69	32,5	19
250	**132658**	**137074**	120	56	90	41	26
315	**132184**	**129894**	160	70	130	46	40
400	**137075**	**130442**	160	70	130	42	40
500/630	**131540**	**137076**	220	80	190	55	50
200	**130033**	**137077**	120	70	69	32,5	19
250	**128880**	**130610**	140	76	90	41	26
315	**118908**	**137078**	200	110	130	46	40
400	**137079**	**137080**	200	110	130	42	40
500/630	**137081**	**137082**	280	140	190	55	50
315	**121367**	**133691**	250	160	130	46	40
400	**137087**	**137088**	250	160	130	42	40

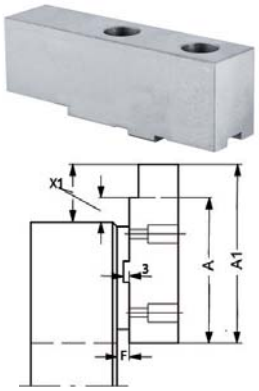
A09
Unstepped jaw BL, special height, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	J1	C mm	J mm
200	**125710**	**132972**	80	58,5	54	32,5
250	**122188**	**134796**	100	73	68	41
315	**132186**	**137091**	110	76	80	46
400	**137092**	**131655**	110	72	80	42
500/630	**137093**	**137094**	150	110	95	55
200	**125712**	**137095**	120	98,5	54	32,5
250	**122189**	**130630**	130	103	68	41
315	**137096**	**137097**	140	106	80	46
400	**137098**	**137099**	140	102	80	42
500/630	**125117**	**137100**	200	160	95	55
200	**125714**	**137101**	150	128,5	54	32,5
250	**137102**	**137103**	150	123	68	41
315	**137104**	**130340**	160	126	80	46
400	**132879**	**110109**	160	122	80	42

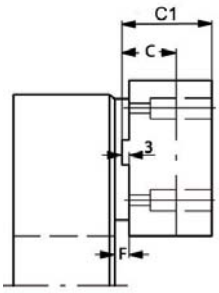
Jaws ZS - ZSU

A09
Top jaw AB, special length, soft, 16MnCr5 DIN 6350



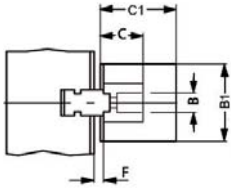
Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	F mm	A mm	X max. mm
200	**110086**	**148139**	100	43	6,8	87	30
250	**112122**	**129289**	130	63	8	103	36
315	**110624**	**143764**	160	76	5,5	120	36
400	**110626**	**141277**	160	53	8,5	137	30
500/630	**103014**	**103393**	170	75	8,5	140	45
200	**112120**	**148657**	120	63	6,8	87	30
250	**125428**	**128700**	150	83	8	103	36
315	**112091**	**147754**	200	116	5,5	120	36
400	**112118**	**141263**	200	93	8,5	137	30
500/630	**110632**	**148234**	220	125	8,5	140	45
250	**104710**	**146013**	180	113	8	103	36
315	**112089**	**147860**	250	166	5,5	120	36
400	**103654**	**149974**	260	153	8,5	137	30
500/630	**112127**	**148235**	280	185	8,5	140	45

A09
Top jaw AB, special height, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	C mm	F mm
200	**132155**	**132181**	60	43	6,8
250	**119645**	**135867**	70	53	8
315	**110435**	**149975**	80	58	5,5
400	**126385**	**118373**	90	65	8,5
500/630	**128590**	**149985**	100	80	8,5
200	**128564**	**149976**	80	43	6,8
250	**128571**	**134999**	100	53	8
315	**110437**	**129691**	110	58	5,5
400	**110628**	**135426**	120	65	8,5
500/630	**110630**	**149977**	130	80	8,5
250	**128573**	**149978**	150	53	8
315	**128569**	**141671**	150	58	5,5
400	**128567**	**139591**	160	65	8,5
500/630	**128588**	**140427**	160	80	8,5

A09
Top jaw AB, special width and height, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	B_1 mm	C1 mm	B mm	C mm
200	**105057**	**105061**	40	70	30.5	43
250	**137090**	**141338**	50	80	36.5	53
315	**143053**	**149979**	60	90	42	58
400	**131567**	**149980**	60	90	42.5	65
500/630	**137084**	**149981**	80	110	50.5	80
200	**133259**	**149982**	50	80	30.5	43
250	**133653**	**137526**	60	90	36.5	53
315	**143057**	**149983**	80	110	42	58
400	**137086**	**149984**	80	110	42.5	65

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Jaws ZS - ZSU

C15
Mounting bolt for top jaws, bolt 1

Item no.	Size	Thread	Contents of delivery
249299	100	M6x20	piece
236949	125	M8x25	piece
334571	160/200	M8x30	piece
233025	250	M12x40	piece
233026	315	M12x45	piece
220565	400	M16x50	piece
249003	500/630	M20x80	piece

C15
Mounting bolt for top jaws, bolt 2

Item no.	Size	Thread	Contents of delivery
216528	100	M6x16	piece
233058	125/160/200	M8x20	piece
227692	250	M12x25	piece
233030	315	M12x30	piece
220564	400	M16x35	piece
233047	500/630	M20x40	piece

Accessories ZS - ZSU

A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350

Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side

Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017123	74	3	80	56	45	15	-
017113	80	3 ¼	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017125	140	5 ½	150	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50
017119	315	12 ½	330	165	100	30	50
017124	350	14	365	180	120	30	60

A09

Chip guard, piece

Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece
108508	500/630	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

Accessories ZS - ZSU

A09

Scroll

Item no.	Size
102521	74
102183	80/85
101754	100
112660	110
101721	125
105827	140
100303	160
100003	200
100203	250
101552	315
105228	350
102497	400
162973	500
162964	630

A09

Driving pinion

Item no.	Size	Square
102522	74	6
102184	80	6
113198	85	6
101755	100	8
112662	110	8
101722	125	9
105828	140	9
100304	160	10
100005	200	11
100204	250	12
112267	270	12
101553	315	14
105229	350	14
102498	400	17
162974	500	19
162965	630	19

A09

Pinion holder screw

Item no.	Size
102523	74
102185	85
100305	160
100006	270
101554	315
102499	400
103300	630

A09

Standard key

Item no.	Size	Square	Hexagon	Length mm
006325	74	-	6	55
107426	80/85	6	-	62
107427	100/110	8	-	75
107428	125/140	9	-	80
107429	160	10	-	90
107430	200/230	11	-	100
107431	250/270	12	-	100
107432	315	14	-	110
107433	350	14	-	140
107434	400	17	-	140
107435	500/630	19	-	150

A09

Safety key with ejector

Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200
154377	350	14	200
154378	400	17	250
154379	500/630	19	250

A09

Elongated safety key with ejector

Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector

for actuating the chuck with torque (defined torque introduction)

Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2
178573	400	17	1/2
178574	500/630/700/800	19	3/4
178575	1000/1250	24	3/4

A09

Mounting screws

with **cylindrical centre rim**

Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece
229183	400-630	M16x60	piece

▲ on request

Accessories ZS - ZSU

C15

Mounting screws
for lathe chucks with direct **short-taper**, **for front mounting**

Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
302195	74	M10x55	piece	160	5
200184	80	M10x65	piece	200	5
233006	85	M12x65	piece	200	6
233075	100	M10x90	piece	250	5
216549	110	M12x70	piece	250	6
302194	125	M16x70	piece	250	8
242954	140	M12x100	piece	315	6
358816	160	M16x85	piece	315	8
243665	200/230	M12x130	piece	350	6
236516	315	M16x110	piece	400	8
615744	350	M20x95	piece	400	11
010210	400	M20x130	piece	500	11
328925	500	M20x145	piece	630	11
367648	630	M24x125	piece	630	15

C15

Set screw with nut DIN 55021

Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud for Camlock ISO 702-2 (DIN 55029) **and cylindrical studs**

Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

A09

Stud and locknut ISO 702-3 (DIN 55027)

Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6
130636	M24x100	piece	20	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) **and cylindrical studs**

Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6
130637	1½-12x89	20	6

Orange Line

ORANGE LINE

APPLICATION

Proven rotary chuck for use in areas requiring high clamping forces, high concentricity as well as reliable long-term repeatability.
Cross tenon to ISO 3442 and ASA B 5.8.

TYPE

Geared scroll chucks in cast iron design.
Special flat design with direct mounting.

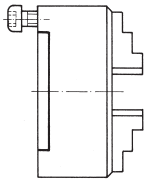
CUSTOMER BENEFITS

- Good price/performance ratio
- Special flat design with direct mounting
- The jaws can be adjusted over the entire clamping range by turning the key. This allows workpieces with different clamping diameters to be quickly clamped
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of one-piece outward- and inward stepped jaws
- Vibration-damping body made of special cast iron
- Spiral ring die-forged as well as balanced and hardened

A09
DIN 6350, cylindrical centre mount, form A



Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	Speed max. min^{-1}	Torque Nm	Total clamping force kN
100	70	20	**101781**	**102129**	4500	60	27
125	95	32	**101628**	**106074**	4000	80	31
160	125	42	**100300**	**100325**	3600	110	47
200	160	55	**100000**	**100465**	3000	140	55
250	200	76	**100200**	**100834**	2500	150	63
315	260	103	**101248**	**101567**	2000	180	69

▲ on request

Jaws Orange Line

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20
250	**110161**	**110069**	90	67,5	24
315	**110162**	**110070**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20
250	**110171**	**110079**	90	67,5	24
315	**110016**	**110080**	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20
250	**107594**	**107604**	90	67,5	24
315	**107595**	**107605**	130	79,5	34

A09
Base jaw GB DIN 6350, with fixing screw

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw width
100	**107500**	**107542**	46	14
125	**107501**	**107543**	55	18
160	**107503**	**107545**	65	18
200	**107504**	**107546**	78	20
250	**107505**	**107547**	92	24
315	**107506**	**107548**	108	34

A09
Reversible top jaws UB DIN 6350, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**108045**	**108053**	47	29,5	22
125	**108046**	**108054**	56	37,5	26
160	**107936**	**107938**	66,7	41,5	28
200	**107937**	**107939**	79,5	42,5	30
250	**108049**	**108057**	95,3	52,5	36
315	**108050**	**108058**	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

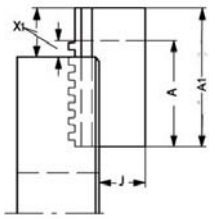
Configure your individual clamping jaws online! www.web2product.biz

Jaws Orange Line

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5

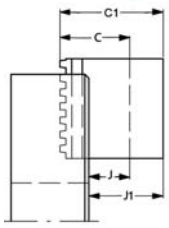
Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**107633**	**107641**	53	30	22,5
125	**107634**	**107642**	62	38	26,5
160	**108581**	**108583**	74	42	28,5
200	**108582**	**108584**	87	43	30,5
250	**107637**	**107579**	103	53	36,5
315	**107638**	**107580**	120	58	42,5

A09
Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350



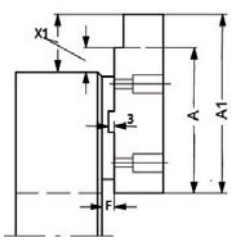
Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	A mm	J mm	X max. mm
200	**130031**	**137073**	100	50	69	32,5	19
250	**132658**	**137074**	120	56	90	41	26
315	**132184**	**129894**	160	70	130	46	40
200	**130033**	**137077**	120	70	69	32,5	19
250	**128880**	**130610**	140	76	90	41	26
315	**118908**	**137078**	200	110	130	46	40
315	**121367**	**133691**	250	160	130	46	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	J1	C mm	J mm
200	**125710**	**132972**	80	58,5	54	32,5
250	**122188**	**134796**	100	73	68	41
315	**132186**	**137091**	110	76	80	46
200	**125712**	**137095**	120	98,5	54	32,5
250	**122189**	**130630**	130	103	68	41
315	**137096**	**137097**	140	106	80	46
200	**125714**	**137101**	150	128,5	54	32,5
250	**137102**	**137103**	150	123	68	41
315	**137104**	**130340**	160	126	80	46

A09
Top jaw AB, special length, soft, 16MnCr5, DIN 6350

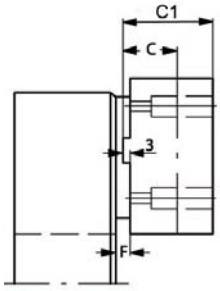


Chuck Size	3-jaw set	4-jaw set	A1	X1 max.	F mm	A mm	X max. mm
200	**110086**	**148139**	100	43	6,8	87	30
250	**112122**	**129289**	130	63	8	103	36
315	**110624**	**143764**	160	76	5,5	120	36
200	**112120**	**148657**	120	63	6,8	87	30
250	**125428**	**128700**	150	83	8	103	36
315	**112091**	**147754**	200	116	5,5	120	36
250	**104710**	**146013**	180	113	8	103	36
315	**112089**	**147860**	250	166	5,5	120	36

▲ on request

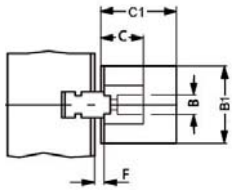
Jaws Orange Line

A09
Top jaw AB, special height, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	C mm	F mm
200	**132155**	**132181**	60	43	6,8
250	**119645**	**135867**	70	53	8
315	**110435**	**149975**	80	58	5,5
200	**128564**	**149976**	80	43	6,8
250	**128571**	**134999**	100	53	8
315	**110437**	**129691**	110	58	5,5
250	**128573**	**149978**	150	53	8
315	**128569**	**141671**	150	58	5,5

A09
Top jaw AB, special width and height, soft, 16MnCr5 DIN 6350



Chuck Size	3-jaw set	4-jaw set	B_1 mm	C1 mm	B mm	C mm
200	**105057**	**105061**	40	70	30.5	43
250	**137090**	**141338**	50	80	36.5	53
315	**143053**	**149979**	60	90	42	58
200	**133259**	**149982**	50	80	30.5	43
250	**133653**	**137526**	60	90	36.5	53
315	**143057**	**149983**	80	110	42	58

C15
Mounting bolt for top jaws, bolt 1

Item no.	Size	Thread	Contents of delivery
249299	100	M6x20	piece
236949	125	M8x25	piece
334571	160	M8x30	piece
233025	250	M12x40	piece
233026	315	M12x45	piece

C15
Mounting bolt for top jaws, bolt 2

Item no.	Size	Thread	Contents of delivery
216528	100	M6x16	piece
233058	125/160/200	M8x20	piece
227692	250	M12x25	piece
233030	315	M12x30	piece

Configure your individual clamping jaws online! www.web2product.biz

Accessories Orange Line

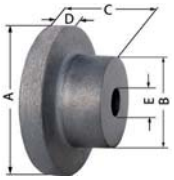
A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350

Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09

Chip guard, piece

Item no.	Size	Contents of delivery
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

A09

Scroll

Item no.	Size
101754	100
112660	110
101721	125
105827	140
100303	160
100003	200
100203	250
101552	315

A09

Driving pinion

Item no.	Size	Square
101755	100	8
112662	110	8
101722	125	9
105828	140	9
100304	160	10
100005	200	11
100204	250	12
112267	270	12
101553	315	14

A09

Pinion holder screw

Item no.	Size
100305	160
100006	270
101554	315

A09

Standard key

Item no.	Size	Square	Length mm
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09

Safety key with ejector

Item no.	Size	Square	Length mm
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09

Elongated safety key with ejector

Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

▲ on request

Accessories Orange Line

A09

Safety adapter with ejector
for actuating the chuck with torque (defined torque introduction)

Item no.	Size	Square	Inch
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09

Mounting screws
with **cylindrical centre rim**

Item no.	Size	Thread	Contents of delivery
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece

C15

Mounting screws
for lathe chucks with direct **short-taper, for front mounting**

Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
233075	100	M10x90	piece	250	5
216549	110	M12x70	piece	250	6
302194	125	M16x70	piece	250	8
242954	140	M12x100	piece	315	6
358816	160	M16x85	piece	315	8
243665	200/230	M12x130	piece	350	6
236516	315	M16x110	piece	400	8

C15

Set screw with nut DIN 55021

Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud for Camlock ISO 702-2 (DIN 55029) **and cylindrical studs**

Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

A09

Stud and locknut ISO 702-3 (DIN 55027)

Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6
130636	M24x100	piece	20	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) **and cylindrical studs**

Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6
130637	1½-12x89	20	6

ZS Hi-Tru

APPLICATION

Optimized for machining workpieces which must be produced with **maximum concentricity.**
Can be universally used, but is especially advantageous on turning and grinding machines as well as dividing units.

TYPE

Face spiral chuck in steel design, with which the workpiece can be adjusted very sensitively to the desired concentricity via 3 tangentially arranged adjusting spindles.

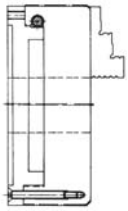
CUSTOMER BENEFITS

- Radial fine adjustment for maximum concentricity
- Repeatability 0.015 mm
- Adjusting accuracy within 0.005 mm
- Precision adjustment without opening the mounting screws
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of turning and drilling jaws
- Hardened adjusting spindles, as well as their support surfaces
- Hardened spiral ring
- Steel take-up flange

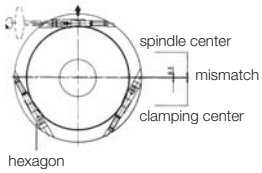
A09
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws DIN 6350, cylindrical centre mount, Form A

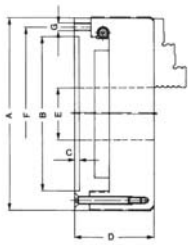


Item no.	Size	Cylindrical centre mount	Through-hole mm	Speed max. min^{-1}	Torque Nm	Total clamping force kN
180259	80	56	19	7000	30	13
180261	100	70	20	6300	60	27
180263	125	95	32	5500	80	31
180265	160	125	42	4600	110	47
180267	200	160	55	4000	140	55
180269	250	200	76	3000	150	63
180271	315	260	103	2300	180	69

On request from size 125 with 6 jaws or with short-taper mount to ISO 702-3 (DIN 55027) or ISO 702-2 (DIN 55029) Camlock
Further sizes and mountings available on request

DIN 6350
Dimensions ZS Hi-Tru
Cylindrical centre mount, Form A





Size A	Zoll	B$^{+0,02}$	C	D	F	G	Hexagon	Weight
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws								
80	3$^{1/4}$	56	3	50,5	67	3xM6	4	1,7
100	4	70	3	63	83	3xM8	5	3,6
125	5	95	4	72	108	3xM8	5	5,6
160	6$^{1/4}$	125	4	81	140	3xM10	6	10
200	8	160	4	89,5	176	3xM10	6	17,2
250	10	200	5	102	224	3xM12	8	34,5
315	12$^{1/2}$	260	5	122	286	3xM16	8	57,5

▲ on request

Jaws ZS Hi-Tru

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110155	80	set	37	26	12
110156	100	set	48	33,5	14
110157	125	set	52	41,5	18
110159	160	set	61	47,5	18
110160	200	set	69	53,5	20
110161	250	set	90	67,5	24
110162	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110165	80	set	37	26	12
110166	100	set	48	33,5	14
110167	125	set	52	41,5	18
110169	160	set	61	47,5	18
110170	200	set	69	53,5	20
110171	250	set	90	67,5	24
110016	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107588	80	set	37	26	12
107589	100	set	48	33,5	14
107590	125	set	52	41,5	18
107592	160	set	61	47,5	18
107593	200	set	69	53,5	20
107594	250	set	90	67,5	24
107595	315	set	130	79,5	34

A09
Base jaw GB DIN 6350, with fixing screw

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
107500	100	set	46	14
107501	125	set	55	18
107503	160	set	65	18
107504	200	set	78	20
107505	250	set	92	24
107506	315	set	108	34

A09
Reversible top jaws UB DIN 6350, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108045	100	set	47	29,5	22
108046	125	set	56	37,5	26
107936	160	set	66,7	41,5	28
107937	200	set	79,5	42,5	30
108049	250	set	95,3	52,5	36
108050	315	set	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

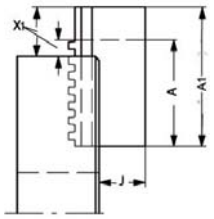
Configure your individual clamping jaws online! www.web2product.biz

Jaws ZS Hi-Tru

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5

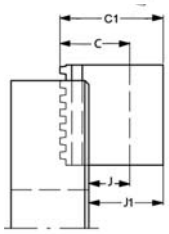
Item no.	Chuck size	Contents of delivery	Jaw length	Jaw height	Jaw width
107633	100	Satz	53	30	22,5
107634	125	Satz	62	38	26,5
108581	160	Satz	74	42	28,5
108582	200	Satz	87	43	30,5
107637	250	Satz	103	53	36,5
107638	315	Satz	120	58	42,5

A09
Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350



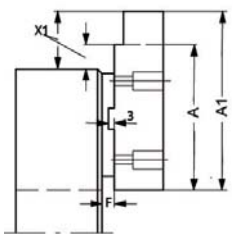
Item no.	Chuck size	A1 mm	X1 max. mm	A	J	X max.
130031	200	100	50	69	32,5	19
132658	250	120	56	90	41	26
132184	315	160	70	130	46	40
130033	200	120	70	69	32,5	19
128880	250	140	76	90	41	26
118908	315	200	110	130	46	40
121367	315	250	160	130	46	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	C1	J1 mm	C	J
125710	200	80	58,5	54	32,5
122188	250	100	73	68	41
132186	315	110	76	80	46
125712	200	120	98,5	54	32,5
122189	250	130	103	68	41
137096	315	140	106	80	46
125714	200	150	128,5	54	32,5
137102	250	150	123	68	41
137104	315	160	126	80	46

A09
Top jaw AB, special length, soft, 16MnCr5, DIN 6350

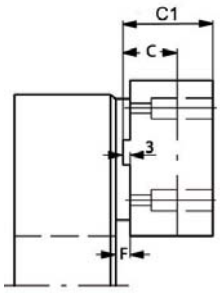


Item no.	Chuck size	A1 mm	X1 max. mm	F	A	X max.
110086	200	100	43	6,8	87	30
112122	250	130	63	8	103	36
110624	315	160	76	5,5	120	36
112120	200	120	63	6,8	87	30
125428	250	150	83	8	103	36
112091	315	200	116	5,5	120	36
104710	250	180	113	8	103	36
112089	315	250	166	5,5	120	36

▲ on request

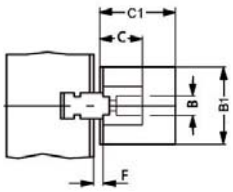
Jaws ZS Hi-Tru

A09
Top jaw AB, special height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	C1	C	F
132155	200	60	43	6,8
119645	250	70	53	8
110435	315	80	58	5,5
128564	200	80	43	6,8
128571	250	100	53	8
110437	315	110	58	5,5
128573	250	150	53	8
128569	315	150	58	5,5

A09
Top jaw AB, special width and height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	B1	C1	B	C
105057	200	40	70	30.5	43
137090	250	50	80	36.5	53
143053	315	60	90	42	58
133259	200	50	80	30.5	43
133653	250	60	90	36.5	53
143057	315	80	110	42	58

C15
Mounting bolt for top jaws, bolt 1

Item no.	Chuck size	Thread	Contents of delivery
249299	100	M6x20	Stück
236949	125	M8x25	Stück
334571	160/200	M8x30	Stück
233025	250	M12x40	Stück
233026	315	M12x45	Stück

C15
Mounting bolt for top jaws, bolt 2

Id.-Nr.	Chuck size	Thread	Contents of delivery
216528	100	M6x16	Stück
233058	125/160/200	M8x20	Stück
227692	250	M12x25	Stück
233030	315	M12x30	Stück

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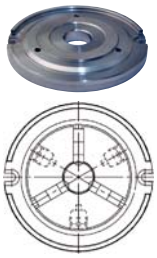
Accessories ZS Hi-Tru

A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side

Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017113	80	3 ¼	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09

Chip guard, piece

Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

A09

Scroll

Item no.	Size
102183	80/85
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315

A09

Driving pinion

Item no.	Size	Hexagon
178473	100	9
178474	110	9
178475	125	10
178476	140	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17

A09

Pinion holder screw

Item no.	Size
102185	85
100305	160
100006	270
101554	315

A09

Standard key

Item no.	Size	Square	Length mm
107426	80/85	6	62
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09

Safety key with ejector

Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09

Elongated safety key with ejector

Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector
for actuating the chuck with torque (defined torque introduction)

Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09

Mounting screws
with **cylindrical centre rim**

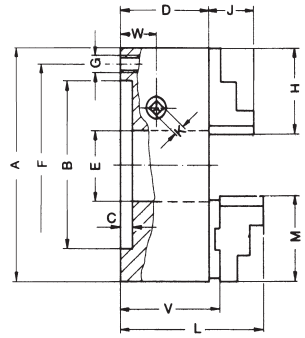
Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece

▲ on request

Chuck dimensions ZS - ZSU and Orange Line

For mounting on dividing heads and other attachments from the front, the lathe chucks with a cylindrical centre mount can also be supplied pre-drilled (at surcharge) G1, it is also possible to enlarge the bore (measure E, at surcharge)

Cylindrical centre mount DIN 6350

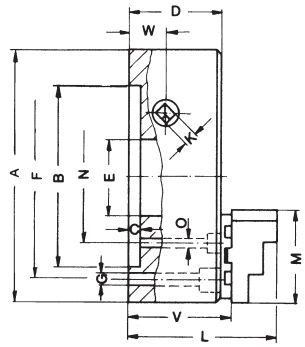


Enlarged bore max.

Size A	74	80	85	100	110	125	140	160	200	250	315	350	400	500	630
B^{H6}	56	56	60	70	80	95	105	125	160	200	260	290	330	420	545
C	2,5	3	3	3	3	4	4	4	4	5	5	6	5	5	7
D	32,5	39,5	39,5	50	50	56	60	65	73,5	82	95	100	105	120	135
E	15	19	19	20	27	32	40	42	55	76	103	115	136	190	240
E_{max}	-	-	-	21	-	33	43	50	70	92	114	120	150	210	253
F	63	67	72	83	95	108	120	140	176	224	286	318	362	458	586
G	3xM6	3xM6	3xM6	3xM8	3xM8	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	3xM16	6xM16	6xM16
G_1	-	-	-	-	-	3xØ9*	-	3xØ10,5	3xØ11	3xØ14	3xØ14	-	3xØ18	6xØ18	6xØ18
H	32	37	37	48	48	52	61	61	69	90	130	130	130	190	190
J	14	14	14	18	18	22,5	22,5	26	32,5	40	46	45	43	54,5	54,5
K	6[1)]	6	6	8	8	9	9	10	11	12	14	14	17	19	19
L	-	-	-	80,5	-	95,5	106	108	119,6	139,6	155	168,5	171,5	201,5	216,5
M	-	-	-	47	47	56	66,7	66,7	79,5	95	109,5	127	127	127	127
V	-	-	-	53,6	53,6	61	67,7	69,7	80,2	89,9	100,4	110,4	113,4	128,4	143,3
W	13	14,5	14,5	18	18	20	21	22,45	25,7	26,5	30	34	35	38	48
approx kg.	1	1,3	1,9	2,9	3,4	4,5	5,8	8,2	14,6	25,7	44,2	56	80	126	208

G1 = Mounting from front * 4-jaw

Cylindrical centre mount

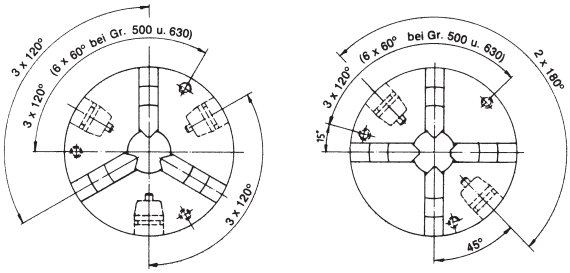


Enlarged bore max.

SIze	ØA	700	800	1000	1250
	B	610	710	910	910
	C[2)]	$7^{+0,03}$	$7^{+0,03}$	$7^{+0,03}$	$7^{+0,03}$
	D	147	147	157	157
	E	310	380	460	550
	$E_{max.}$	330	420	580	580
	F	660	760	950	950
3-Jaw 4-Jaw	G	6xØ22 8xØ22	6xØ22 8xØ22	6xØ26 8xØ26	6xØ26 6xØ26
	K	19	19	24	24
	L	240,6	240,6	269,6	269,6
	M	210	210	210	210
	N	360	460	610	610
3-Jaw 4-Jaw	O	6xØ18 4xØ18	6xØ18 4xØ18	6xØ18 4xØ18	6xØ18 6xØ18
	V	158	158	166	166
	W	48	48	53	53
	ca. kg	280	350	590	850

1) Hexagon 2) Adaptor plate dimension 7-0,03

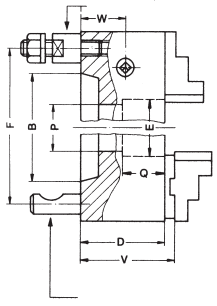
Position of fixing screws and pinions on lathe chucks with cylindrical centre mount sizes 74-630 (size 350 on request)



Short taper mount

DIN 55021, with setscrews and locknuts

DIN 55027, with setscrews and locknuts



DIN 55029, with studs for Camlock

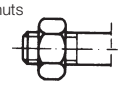
Size	A	100	125		140			160			200			
Taper size		3	3	4	3	4	5	3	4	5	3	4	5	6
	B	53,9	53,9	63,5	53,9	63,5	82,5	53,9	63,5	82,5	53,9	63,5	82,5	106,4
	D	75	69	69	74	74	74	66	66	66	74,5	74,5	74,5	74,5
	E	20	32	32	40	40	40	42	42	42	51,2	55	55	55
DIN Caml.	F	75 70,6	75 70,6	85 82,5	75 70,6	85 82,5	104,8	75 70,6	85 82,5	104,8	75 70,6	85 82,5	104,8	133,4
	P	-	-	-	-	-	-	-	-	-	51,2	-	-	-
	Q	-	-	-	-	-	-	-	-	-	33	-	-	-
	V	78,3	73,7	73,7	81,7	81,7	81,7	70,7	70,7	70,7	81,2	81,2	81,2	81,2
	W	43	33	33	35	35	35[1)]	23,45	23,45	23,45	26,7	26,7	26,7	26,7
Mounting holes	DIN	3 3	3 3	3 3	3 3	3 3	4 6	3 3	3 3	4 6	3 3	3 3	4 6	4 6
	ca. kg	4	5,5		7			8,5			15,5			

1) 50 with Camlock, other dimensions in the table on the top

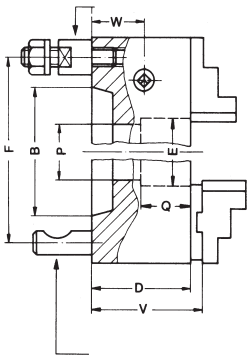
Chuck dimensions ZS - ZSU and Orange Line

Short taper mount

DIN 55021,
with setscrews and locknuts



DIN 55027,
with studs and nuts



DIN 55029,
with studs for Camlock

Size A		250				315				350			400		
Taper size		4	5	6	8	5	6	8	11	6	8	11	6	8	11
B		63,5	82,5	106,4	139,7	82,5	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,6
D		83	83	83	83	96	96	96	104	122	122	122	106	106	106
E		60,7	76	76	76	79,6	103	103	103	103	115	115	103	136	136
F	DIN	85	104,8	133,4	171,4	104,8	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235
	Caml.	82,5													
P		60,7	-	-	-	79,6	-	-	-	103	-	-	103	-	-
Q		40,5	-	-	-	49	-	-	-	81	-	-	54	-	-
V		90,9	90,9	90,9	90,9	101,4	101,4	101,4	109,4	127,4	127,4	127,4	114,4	114,4	114,4
W		27,5	27,5	27,5	27,5	31	31	31	39	56	56	56	36	36	36
Mounting holes	DIN	3	4	4	4	4	4	4	6	4	4	6	4	4	6
	Caml.	3	6	6	6	6	6	6	6	6	6	6	6	6	6
approx. kg		30				50				71			84		

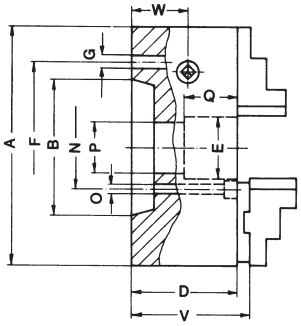
Size A		500			630		700		800		1000		1250	
Taper size		8	11	15	11	15	11	15	15	20	15	20	15	20
B		139,7	196,9	285,8	196,9	285,8	196,9	285,8	285,8	412,8	285,8	412,8	285,8	412,8
D		122	122	122	137	137	149	149	149	149	159	159	159	159
E		136	190	190	192,7	240	310	310	380	380	460	460	550	550
F		171,4	235	330,2	235	330,2	235	330,2	330,2	463,6	330,2	463,6	330,2	463,6
P		136	-	-	192,7	-	192,7	281,2	281,2	-	281,2	407,5	281,2	407,5
Q		61	-	-	63	-	76	76	76	-	85	85	85	85
V		130,4	130,4	130,4	145,3	145,3	160	160	160	160	168	168	168	168
W		40	40	40	50	50	50	50	50	50	55	55	55	55
Mounting holes	DIN	4	6	6	6	6	6	6	6	6	6	6	6	6
	Caml.	6	6	6	6	6	6	6	6	6	6	6	6	6
approx. kg		150			225		280		350		590		850	

All other dimensions should be taken from the table about chucks with cylindrical centre mount

---

Short taper mount

DIN 55026
Mounting from front



Size A		160	200		250			315		350		400	
Taper size		5	5	6	5	6	8	6	8	6	8	8	11
B		82,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	106,4	139,7	139,7	196,9
D		66	74,5	74,5	83	83	83	96	96	122	122	106	106
E		42	42	55	76	55	76	103	76	103	76	136	125
F[2)]		-	-	-	104,8	-	-	133,4	-	133,4	-	171,4	-
G		-	-	-	11[1)]	-	-	14	-	14	-	18	-
N[3)]		61,9	61,9	82,6	-	82,6	111,1	-	111,1	-	111,1	-	165,1
O		11[1)]	11[1)]	14	-	14	18	-	18	-	18	-	22
V		70,7	81,2	81,2	90,9	90,9	90,9	101,4	101,4	127,4	127,4	114,4	114,4
W		23,45	26,7	26,7	275	275	275	31	31	56	56	36	36
Mounting holes	*	3	3	6	3	6	6	6	6	6	6	6	6
	**	4	4	4	4	4	4	4	4	4	4	4	4
approx. kg		8	14,5		25			44,5		71		82	

Size ØA		500	630		700		800			1000		1250	
Taper Size		11	11	15	11	15	11	15	20	15	20	15	20
B		196,9	196,9	285,9	196,9	285,9	196,9	285,9	412,8	285,9	412,8	285,9	412,8
D		122	137	137	149	149	149	149	149	159	159	159	159
E		190	190	190	310	285	380	380	380	460	505	550	550
F[2)]		235	235	-	235	330,2	235	330,2	463,6	330,2	463,6	330,2	463,62
G		22	22	-	22	26	22	26	26	26	26	26	26
N[3)]		-	-	247,6	-	-	-	-	-	-	-	-	-
O		-	-	26	-	-	-	-	-	-	-	-	-
P		-	-	-	193	281,2	193	281,2	-	281,2	407,5	281,2	407,5
Q		-	-	-	76	76	76	76	-	85	85	85	85
V		130,4	145,3	145,3	159,9	159,9	159,9	159,9	159,9	168	168	168	168
W		40	50	60	50	50	50	50	50	55	55	55	55
Mounting holes	*	3	6	6	6	6	6	6	6	8	8	8	8
	**	4	8	8	8	8	8	8	8	8	8	8	8
approx. kg		139	220		295		350			590		850	

1) 12 with ASA B 5.9 inch thread

2) With DIN 55026 Forme A and B; DIN 55021 Forme A and B; ASA B 5.9 A1/A2

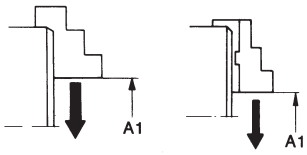
3) With DIN 55026 Forme B; ASA B 5.9 A1/B1

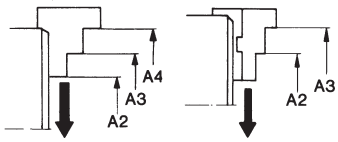
* 3-Jaw

** 4-Jaw

Chuck dimensions ZS - ZSU and Orange Line

External chucking





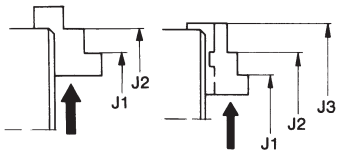
Ø 74-630 Ø 700-1250

Chucking capacities of jaw steps (standard values)

Size	74	80	85	100	110	125	140	160	200	250
A1 (BB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	4-72	4-100	5-122
A2 (DB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	3-72	4-100	5-122
A3 (DB)	23-46	27-55	27-55	38-71	39-77	39-89	47-97	47-116	56-152	73-190
A4 (DB)	45-68	52-80	52-80	70-100	70-100	75-125	91-140	91-160	104-200	131-250
max. swing dia.	88	104	104	128	138	157	174	194	238	302
Jaw movement	11	14	14	15	19	25	25	34	48	58

Size	315	350	400	500	630	700	800	1000	1250
A1	6-135	20-180	20-200	35-260	50-350	110-350	150-450	250-600	320-600
A2	6-135	20-180	20-200	35-260	50-350	280-672	325-853	425-1070	490-1150
A3	96-225	110-270	110-300	140-360	190-490	356-748	400-928	500-1150	564-1224
A4	186-315	200-350	200-400	280-500	330-630	-	-	-	-
max. swing dia.	395	440	480	600	730	1000	1170	1390	1476
Jaw movement	64	80	100	110	150	120	150	175	140

Internal chucking



Ø 74-630 Ø 700-1250

Size	74	80	85	100	110	125	140	160	200	250
J1	23-46	25-53	26-53	33-66	33-71	37-87	39-89	39-107	44-140	59-165
J2	45-68	50-78	50-78	65-94	65-104	73-123	83-132	83-152	92-186	119-236

Size	315	350	400	500	630	700	800	1000	1250
J1	96-224	100-260	100-300	135-355	150-450	212-648	251-855	356-1080	426-1162
J2	186-305	190-350	190-390	275-460	290-590	290-758	326-930	430-1150	500-1236
J3	-	-	-	-	-	526-922	566-1094	660-1314	740-1400

Clamping ranges for lathe chucks with individual adjustable jaws (EG-ES) are in approximate conformity with the above values. They are valid for 3- and 4-jaw chucks and lathe chucks with reversible jaws.
Do not exceed maximum chucking ranges.

Max. permissible speeds for ZG-ZS, ZGU-ZSU, ZG Hi-Tru chucks to DIN 6350

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum gripping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The speed limit for chucks with cast iron bodies is based on the permissible peripheral speed for cast iron. The specification DIN 6386 Part 1 shall be observed.

Size	3 and 4 jaws	
	Cast iron body	Steel body
74	5000	-
80	5000	7000
100	4500	6300
125	4000	5500
140	3700	5000
160	3600	4600
200	3000	4000
250	2500	3000
315	2000	2300
350	1700	1900
400	1600	1800
500	1000	1300
630	800	850
700	650	800
800	600	700
1000	480	560
1250	380	450

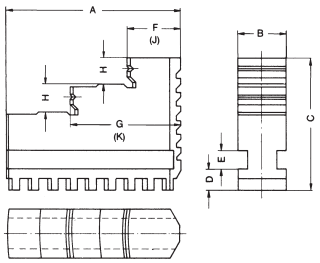
Claming force 3 jaw chuck ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

The clamping force is sum total of all jaw forces acting radially on the stationary workpiece. The clamping forces are approximate values. To obtain the specified clamping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.

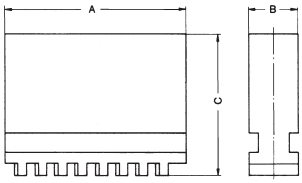
Size	Torque key	Total clamping force
74	30	11
80	30	13
100	60	27
125	80	31
140	90	40
160	11	47
200	140	55
250	150	63
315	180	69
350	210	74
400	240	92
500	260	100
630	280	105
700	280	105
800	300	110
1000	450	115
1250	450	115

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Outward stepped jaw (inside jaw) **BB**



Unstepped jaw, soft (block jaw) **BL**



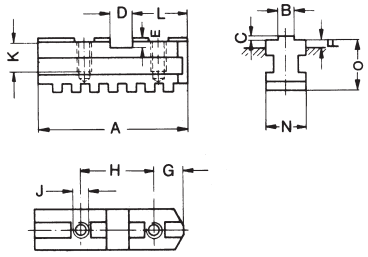
Dimensions F and G apply to outward stepped jaws **BB**
Dimensions J and K apply to inward stepped jaws **DB**

Size		74[1]	80/85	100/110	125	140	160	200	250	315	300/400	500/630
A		32	37	48	52	61	61	69	90	130	130	190
B		10	12	14	18	18	18	20	24	34	34	42
C		23	26	33,5	41,5	41,5	47,5	53,5	67,5	79,5	79,5	95
D		4,7	4,8	6,3	7,3	8,3	8,3	8,3	10,3	11,3	11,3	14,9
E		4	4,5	6	7	7	7	8	10	15	15	15
F		10	12	15	17	18	18	20	27	41,5	41,5	50
G		21	24,5	31	35	40	40	44	57	86,5	86,5	120
H		5	6	6	8	8	10	10	14	15	15	20
J		-	12	14	16	17	17	19	26	40	40	50
K		-	24,5	30	34	39	39	43	56	85	85	120
Jaw approx. kg	BB	0,03	0,05	0,1	0,2	0,22	0,25	0,3	0,7	1,8	1,8	3,8
	BL	0,05	0,08	0,15	0,27	0,32	0,38	0,52	1	2,4	2,4	5,2

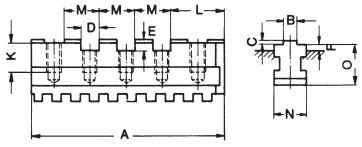
1) Reversible jaws

Base jaw **GB**

Ø 100-400

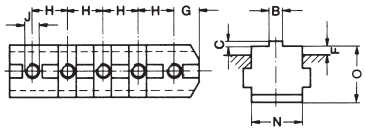


Ø 500-630



Size		100/110	125	140	160	200	250	315	350/400	500	630
A		46	55	65	65	78	92	108	127	165	203
$B_{-0,05}$		7,94	7,94	7,94	7,94	7,94	12,7	12,7	12,7	12,7	12,7
C		2,5	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1
$D^{+0,01}$		9,5	12,68	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03
E		6	7,6	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8
F		3,4	4,8	7,8	4,8	6,8	8	5,5	10,5[2]	8,5	8,5
G		12	13	15,8	15,8	19	22,2	25,4	28,5	28,5	28,5
H		24	32	38,1	38,1	44,45	54	63,5	76,2	38,1	38,1
J	metr.	M6	M8	M8	M8	M8	M12	M12	M16	M20	M20
	UNC	1/4"-20	5/16"-18	3/8"-16	3/8"-16	3/8"-16	1/2"-13	1/2"-13	5/8"-11	3/4"-10	3/4"-10
K		12	14,5	16	16	16	20	25	29	33	33
L		19,25	22,6	28,5	28,5	34,9	39,7	47,6	57,1	57,1	57,1
M		-	-	-	-	-	-	-	-	38,1	38,1
N		14	18	18	18	20	24	34	34	42	42
O		19,5	24	27	27	28	35	40	45	49	49
Grooves		1	1	1	1	1	1	1	1	2	3
Tapped holes		2	2	2	2	2	2	2	2	4	5
Jaw approx. kg		0,06	0,12	0,17	0,17	0,22	0,4	0,78	1	1,72	2,1

Ø 700-1250

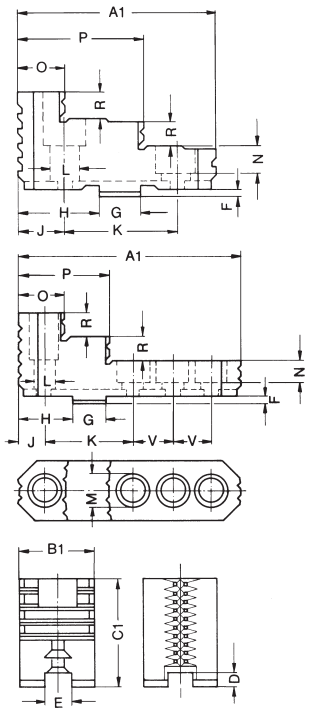


Size		700	800	1000	1250
A		253	291	329	367
$B_{-0,05}$		12,7	12,7	12,7	12,7
C		3,1	3,1	3,1	3,1
$D^{+0,01}$		19,03	19,03	19,03	19,03
E		10,8	10,8	10,8	10,8
F		11	11	9	9
G		28,5	28,5	28,5	28,5
H		38,1	38,1	38,1	38,1
J	metr.	M20	M20	M20	M20
	UNC	3/4"-10	3/4"-10	3/4"-10	3/4"-10
K		37	37	37	37
L		57,1	57,1	57,1	57,1
M		38,1	38,1	38,1	38,1
N		55	55	55	55
O		62	62	62	62
Grooves		4	5	6	7
Tapped holes		6	7	8	9
Jaw approx. kg		6,2	7,1	8	9

1) Reversible jaws 2) Size

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Reversible top jaw **UB**

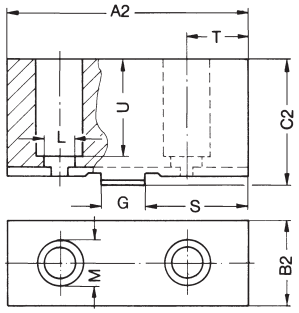


Chuck Size		100 110	125	140 160	200 230	250 270	315	350 400	500 630	700 800	1000 1250
A	1	47	56	66,7	79,5	95,3	109,5	127	127	210	210
	2	53	62	74	87	103	120	137	140	210	210
B	1	22	26	28	30	36	42	42	50	68	68
	2	22,5	26,5	28,5	30,5	36,5	42,5	42,5	50,5	68	68
C	1	29,5	37,5	41,5	42,5	52,5	57,5	64,5	79,5	89	110
	2	30	38	42	43	53	58	65	80	89	110
D		5,5	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8	10,8
E		7,96	7,96	7,96	7,96	12,72	12,72	12,72	12,72	12,72	12,72
F		2,5	3,1	3,1	3,1	3,1	3,1	6,35	6,35	6,35	6,35
G		9,50	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03	19,03
H		19,25	22,6	28,5	34,9	39,7	47,6	57,1	57,1	57,1	57,1
J		12	13	15,8	19	22,2	25,4	28,5	28,5	28,5	28,5
K		24	32	38,1	44,45	53,95	63,5	76,2	76,2	76,2	76,2
L		6,6	9	9[1] 10,5[2]	9[1] 10,5[2]	14	14	18	22	22	22
M		11	15	15[1] 16[2]	15[1] 16[2]	20	20	26	33	33	33
N		7	9	10	10	13,5	13,5	17	21	21,5	21,5
O		12	13	15,8	19	22,2	25,4	28,5	54,6	51	51
P		29,5	35	42,8	51,5	60,2	67,4	77	88,5	89	89
R		6	8	10	10	14	15	15	20	22	25
S		22,25	25,6	32,2	38,7	43,5	52,9	62,1	63,6	70	70
T		15	16	19,5	22,8	26	30,7	33,55	35	41,5	41,5
U		19	27	30	30	41	43	47	61	65	71
V		-	-	-	-	-	-	-	-	38,1	38,1
Jaw approx. kg	UB	0,12	0,19	0,27	0,39	0,66	1,02	1,27	2	4,45	6,1
	AB	0,21	0,34	0,5	0,7	1,2	1,86	2,18	3,04	8	10,8

Saw-tooth standard model

Cross-grooving
from size 250 available
from size 700 standard-model

Unstepped top jaw soft **AB**



Special-design jaws

for non-rotating clamping devices, for symmetrical components, for machine vices and NC-compact vices available in all desired modifications

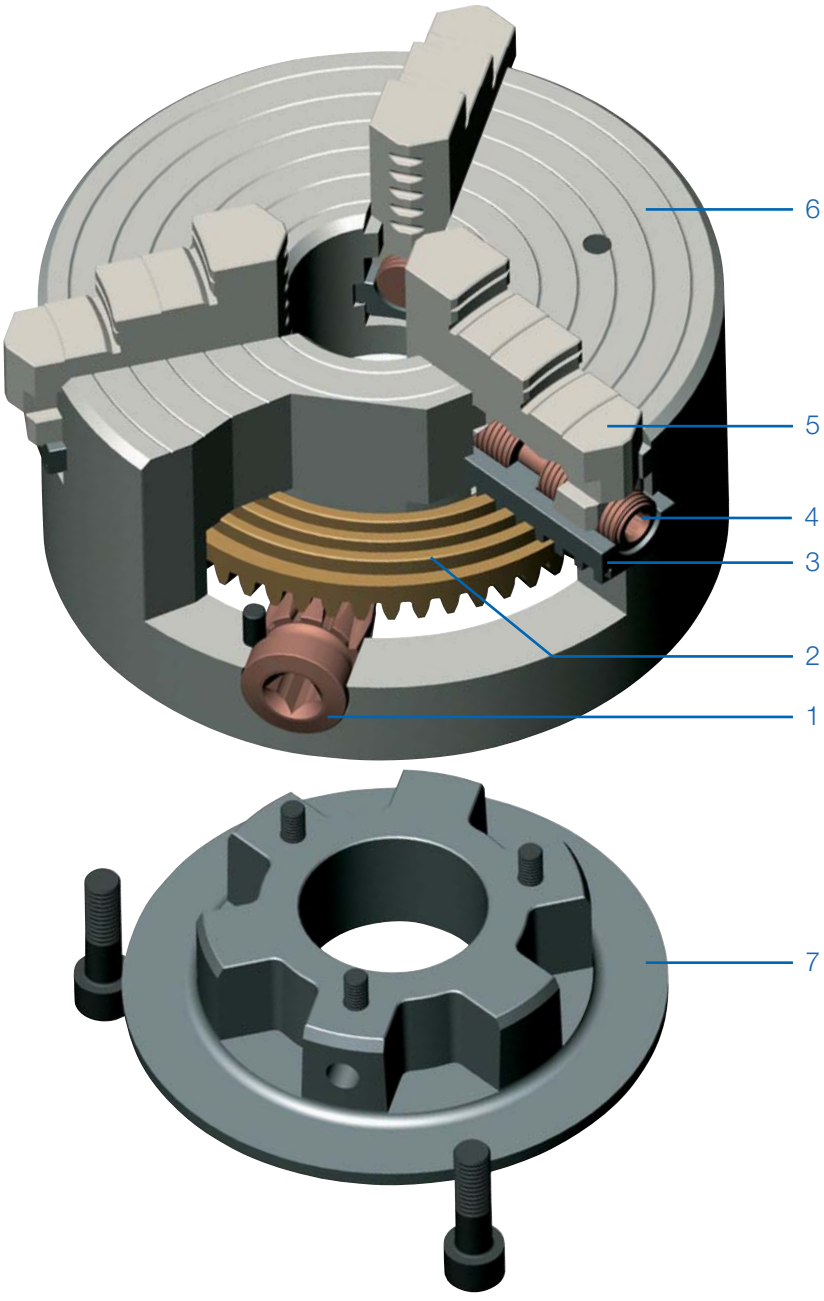
ES

This chuck is used for aligning irregularly shaped workpieces.

Principle of operation
Through a radially arranged drive (1, hardened), the force is transferred via a bevel gearing to a hardened spiral ring (2) and further conducted via the spiral to the base jaws (3, hardened and ground), spindle (4, hardened) and reversible jaws (5, hardened and ground). The position of the workpiece can be adjusted by turning the spindle. Steel body (6), cover (7).

Clamping force transfer system
The jaws can be adjusted over the entire clamping range by turning the key.

Lubrication
To maintain the clamping force, rotary chucks must be lubricated regularly. You will find corresponding information in the operating instructions which are enclosed with every chuck. All rotary chucks are provided with grease nipples for easy maintenance.



Base jaw GB,
hardened and ground

Reversible top jaw UB,
hardened and ground

Unstepped jaw BL
unstepped, soft, material 16MnCr5

ES

APPLICATION

Optimized for the machining of irregularly shaped workpieces.

TYPE

Face spiral chucks in steel design with which irregularly shaped workpieces can be aligned via adjusting spindles.

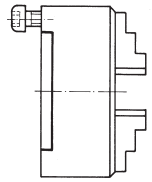
CUSTOMER BENEFITS

- Exact alignment of irregularly shaped workpieces
- Jaws centrically clamping and individually adjustable
- Die-forged spiral ring, series-balanced and hardened
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of base and reversible jaws
- Clamping wrench
- Dimensions and take-ups in acc. with DIN 6351
- Hardened spiral ring
- Die-forged steel body

A09
DIN 6351, cylindrical centre mount, form A



Size	Cylindrical centre mount	Through-hole mm	3 jaw chuck steel	4 jaw chuck steel	Torque Nm	Total clamping force kN
160	125	42	**111360**	**111789**	110	47
200	160	55	**111365**	**111793**	140	55
250	200	76	**111370**	**111797**	150	63
315	260	103	**111375**	**111801**	180	69
400	330	136	**111380** ▲	**111805** ▲	240	92
500	420	190	**111385** ▲	**111809** ▲	260	100
630	545	240	**111390** ▲	**111813** ▲	280	105

Further sizes and mountings available on request

▲ on request

Jaws ES

A09
Reversible jaw UB, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**110118**	**110124**	69	50	20
200	**139666**	**139670**	85	57,5	24
250	**139667**	**139671**	90	67,5	24
315/400	**139668**	**139672**	130	79,5	34
500/630	**139669**	**139673**	190	95	42

A09
Unstepped jaw BL, unstepped, soft

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**107669**	**107675**	69	50	20
200	**139674**	**139678**	85	57,5	24
250	**139675**	**139679**	90	67,5	24
315/400	**139676**	**139680**	130	79,5	34
500/630	**139677**	**139681**	190	95	42

A09
Base jaw GB, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
160	**107654**	**107662**	62	15,3	26
200	**139682**	**139686**	78	17,8	30
250	**139683**	**139687**	86	17,8	30
315	**139684**	**139688**	118	22,7	44
400	**139685**	**139689**	118	22,7	44
500/630	**107659**	**107667**	176	25	54

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Accessories ES

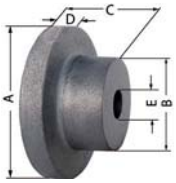
A09

Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350

Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09

Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

C15

Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C15

Adjusting spindle

Item no.	For chuck size
103199	100
104251	125
104271	160
137735	200
137643	250
137701	400
137716	500

A09

Adjusting key

Item no.	For chuck size	Square	Hexagon
107444	160	5,5	-
139695	400	-	8
139696	500	-	12

A09

Scroll

Item no.	Size
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315
102497	400
162973	500
162964	630

A09

Driving pinion

Item no.	Size	Hexagon
178473	100	9
178475	125	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17
178483	400	19
178484	500	22
178485	630	22

A09

Pinion holder screw

Item no.	Size
100305	160
100006	270
101554	315
102499	400
103300	630

Accessories ES

A09

Standard key

Item no.	Size	Square	Length mm
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110
107433	350	14	140
107434	400	17	140
107435	500/630	19	150

A09

Safety key with ejector

Item no.	Size	Square	Length mm
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200
154377	350	14	200
154378	400	17	250
154379	500/630	19	250

A09

Elongated safety key with ejector

Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09

Safety adapter with ejector

for actuating the chuck with torque (defined torque introduction)

Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

C15

Mounting screws

for lathe chucks with direct **short-taper**, **for front mounting**

Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
233059	74	M10x70	piece	160	5
308436	80	M10x85	piece	200	5
200186	85	M12x85	piece	200	6
234615	100	M10x110	piece	250	5
302215	110	M12x90	piece	250	6
202439	125	M16x90	piece	250	8
316244	140	M12x120	piece	315	6
308439	160	M16x105	piece	315	8
342701	315	M16x130	piece	400	8
698878	350	M20x115	piece	400	11
011528	400	M20x155	piece	500	11
358815	500	M20x170	piece	630	11
202509	630	M24x150	piece	630	15

C15

Set screw with nut DIN 55021

Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6

A09

Stud and locknut ISO 702-3 (DIN 55027)

Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	piece	3	3
107448	M10x39	piece	4	3
107449	M10x43	piece	5	4
107450	M12x50	piece	6	4
107451	M16x60	piece	8	4
107452	M20x75	piece	11	6
125650	M24x90	piece	15	6

A09

Stud for Camlock ASA B 5.9 (DIN 55029) and cylindrical studs

Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	½-20x43	5	6
107468	5/8-18x49	6	6
107469	¾-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6

A09

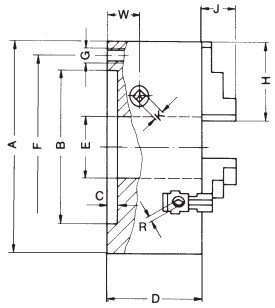
Stud for Camlock ISO 702-2 (DIN 55029) and cylindrical studs

Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6

▲ on request

Chuck dimensions ES

Cylindrical centre mount DIN 6351



The bore could be enlarged (measure E, at surcharge)

Enlarged bore max.

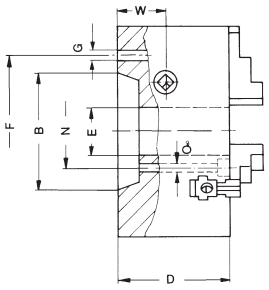
Size A	100	125	160	200	250	315	400	500	630
B^{H6}	70	95	125	160	200	260	330	420	545
C	3	4	4	4	5	5	5	5	7
D	67	71	80	95,5	100	117	123	145	160
E	20	32	42	55	76	103	136	190	240
$E_{max.}$	21	33	50	70	92	114	150	210	253
F	83	108	140	176	224	286	362	458	586
G	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	6xM16	6xM16
H	56	56	69	85	90	130	130	190	190
J	22	21	28	32,5	40,6	46,5	47	55	55
K	8	9	10	11	12	14	17	19	19
R*	5,5	5,5	5,5	8	8	8	8	12	12
W	20	20	22,45	25,7	26,5	30	35	38	48
approx. kg	4	6	10	18	29	54	88	145	240

* from Ø 200 hexagon

Short taper mount

DIN 55021 with setscrews and nuts

DIN 55027 with studs and locknuts
Available on request!



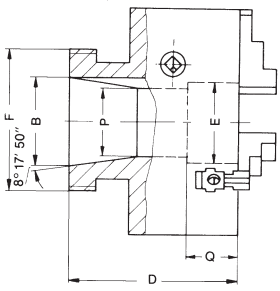
DIN 55029 with studs for camlock
Available on request!

Size A		125		160			200			250		
Short-taper size		3	4	4	5	6	4	5	6	5	6	8
B		53,9	63,5	63,5	82,5	106,4	63,5	82,5	106,4	82,5	106,4	139,7
D		84	84	81	81	81	96,5	96,5	96,5	101	101	101
E		32	32	42	42	42	55	55	55	76	76	76
F	DIN	75	85	85	104,8	133,4	85	104,8	133,4	104,8	133,4	171,4
	Camlock	70,6	82,5	82,5			82,5					
W		21	21	23,45	23,45	23,45	26,7	26,7	26,7	27,5	27,5	27,5
Mouting holes	DIN	3	3	3	4	4	3	4	4	4	4	4
	Camlock	3	3	3	6	6	3	6	6	6	6	6
approx. kg		6		10			19			30		

Size A		315			400		500		630	
Short-taper size		6	8	11	8	11	11	15	11	15
B		106,4	139,7	196,9	139,7	196,9	196,9	285,8	196,9	285,8
D		118	118	118	124	124	147	147	162	162
E		103	103	103	136	136	190	190	240	240
F		133,4	171,4	235	171,4	235	235	330,2	235	330,2
P		-	-	-	-	-	-	-	192,7	-
Q		-	-	-	-	-	-	-	88	-
W		31	31	31	36	36	40	40	50	50
Mouting holes	DIN	4	4	6	4	6	6	6	6	6
	Camlock	6	6	6	6	6	6	6	6	6
aporox. kg		56			92		155		250	

All other dimensions should be taken from the table on the top

DIN 55026
Mounting from front
Available on request!



Size A		160	200		250		315		400		500	630	
Short-taper size		5	5	6	6	8	6	8	8	11	11	11	15
B		82,5	82,5	106,4	106,4	139,7	106,4	139,7	139,7	196,9	196,9	196,9	285,8
D		81	96,5	96,5	101	101	118	118	124	124	147	162	162
E		42	42	55	55	76	103	76	136	125	190	190	190
F[3]		-	-	-	-	-	133,4	-	171,4	-	235	235	-
G		-	-	-	-	-	14	-	18	-	22	22	-
N[2]		61,9	61,9	82,6	82,6	111,1	-	111,1	-	165,1	-	-	247,6
O		11[1]	11[1]	14	14	18	-	18	-	22	-	-	26
W		23,45	26,7	26,7	27,5	27,5	31	31	36	36	40	50	50
Mouting holes	*	3	3	6	6	6	6	6	6	6	6	6	6
	**	4	4	4	4	4	4	4	4	4	8	8	8
approx. kg		10	19		30		56		92		154	250	238

1) 12 with ASA B 5.9 A1/A2 inch, all other dim. should be taken from the above table.

2) With DIN 55026 form B; ASA B 5.9 A1/B1
* 3-Jaw
** 4-Jaw

3) With DIN 55026 Form A and B; DIN 55021 Forme A and B; ASA B 5.9 A1/A2

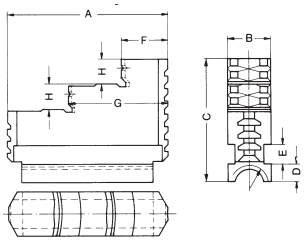
Chuck dimensions ES

Max. permissible speeds for chucks EG-ES to DIN 6351

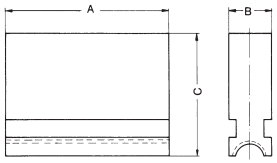
The specified values are only applicable for workpieces not exceeding a specific unbalance of 25 gmm/kg.

Size	3-Jaw Steel body	4-Jaw Steel body
100	-	-
125	-	-
160	3200	2850
200	2650	2350
250	2200	1900
315	1400	1220
400	1400	1220
500	880	770
630	750	660

Reversible jaw **UB**



Left-hand thread



Size	100	125	160	200	250	315	400	500	630
A	56	56	69	85	90	130	130	190	190
B	18	18	20	24	24	34	34	42	42
C	41,5	41,5	50	57,5	67,5	79,5	79,5	95	95
D	8,7	8,7	9,7	9,7	9,7	11,15	11,15	15	15
E	7	7	8	10	10	15	15	15	15
F	17	17	19	25	26	40	40	50	50
G	35	35	43	54	56	85	85	120	120
H	8	8	10	12	14	15	15	20	20
Thread	Tr14x3	Tr14x3	Tr16x4	Tr18x2	Tr18x2	Tr20x2	Tr20x2	Tr26x3	Tr26x3
approx. kg	0,18	0,18	0,3	0,53	0,7	1,7	1,7	3,7	3,7

Notes

KRF

APPLICATION

Three- and four-jaw chuck for positioning and conveying workpieces, e.g. on measuring machines.

TYPE

Face spiral chuck in cast iron version.

CUSTOMER BENEFITS

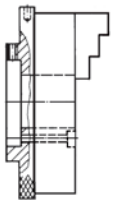
- Easy clamping of the workpiece by turning the clamping ring
- Sizes 125 - 200: 4 setscrews for fine adjustment
- Cast iron body
- Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- 6 jaw chuck for grinding twist drills on request available

A09

Lever scroll chucks KRF, cylindrical centre mount



Size	Cylindrical centre mount	Through-hole mm	**3 jaw chuck with inside and outside jaw**	**4 jaw chuck with inside and outside jaw**	Torque Nm	Total clamping force kN
70	48	16	**148793**[1)]	**148794**	12	2,5
110	75	26	**148757**	**148772**	26	3,2
125	70	35	**150757**	**150758**	36	3,5
160	78,5	52	**150759**	**150760**	50	4
200	115	64	**150761**	**150762**	60	4,5

[1)] jaws reversible
Sizes 125 - 200: 4 setscrews for fine adjustment
Further sizes and mountings available on request

▲ on request

KRF - on base plate

APPLICATION

Three-jaw chuck with base plate for positioning and conveying workpieces, e.g. on measuring machines.

TYPE

Face spiral chuck in cast iron version.

CUSTOMER BENEFITS

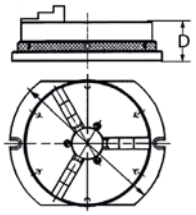
- Easy clamping of the workpiece by turning the clamping ring
- Sizes 125 - 200: 4 setscrews for fine adjustment
- Cast iron body

TECHNICAL FEATURES

- Mounted in the chuck with one set of jaws stepped outward (BB)
- One set of jaws stepped inward (DB)
- Size 70 with reversible jaws
- Fastening screws

A09

Lever scroll chucks with base plate 3-jaw-chuck cast iron body



Item no.	Size	Through-hole mm	D mm	Torque Nm	Total clamping force kN
150595[1)]	70	16	46,4	12	2,5
150596	110	26	50	26	3,2
150597	125	35	59	36	3,5
150598	160	52	59	50	4
150599	200	64	69	60	4,5

[1)] jaws reversible

Further sizes and mountings available on request

Jaws KRF

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
70	**110154**[1] ▲	**149305**[1]	32	23	10
100	**110156**	**110064**	48	33,5	14
125	**110157**	**110065**	52	41,5	18
160	**110159**	**110067**	61	47,5	18
200	**110160**	**110068**	69	53,5	20

[1] Reversible, for use as turning or inside jaws
Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
100	**110166**	**110074**	48	33,5	14
125	**110167**	**110075**	52	41,5	18
160	**110169**	**110077**	61	47,5	18
200	**110170**	**110078**	69	53,5	20

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5

Chuck Size	3-jaw set	4-jaw set	Jaw length	Jaw height	Jaw width
70	**109114**[1]	**149304**[1]	32	23	10
100	**107589**	**107599**	48	33,5	14
125	**107590**	**107600**	52	41,5	18
160	**107592**	**107602**	61	47,5	18
200	**107593**	**107603**	69	53,5	20

[1] Reversible

Accessories KRF

A09
Unfinished adapter plates for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side

Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40

A09
Chip guard, piece

Item no.	Size	Contents of delivery
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece

C15
Special grease F80 for **lathe chucks**
for lubrication and conservation of chucking power

Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

Configure your individual clamping jaws online! www.web2product.biz

▲ on request

Notes

BAV

APPLICATION

For turning out unhardened and grinding out hardened jaws, adjusting jaws reversible and infinitely variably adjustable.

TYPE

Lightweight design.

CUSTOMER BENEFITS

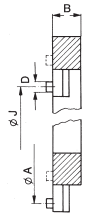
- Using the BAV, the chuck can be put into the status it assumes later during workpiece machining (preclamping) within a few seconds
- The turned clamping surfaces of the chuck jaws are thus form-fit and exactly concentric in the clamped state
- Bypassing a large clamping range

TECHNICAL FEATURES

- Only applicable with base jaws (GB) and top jaws (AB)

A09

Jaw cutting attachment for **three-jaw chucks**

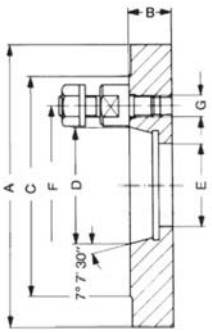


Item no.	Size	For chuck size	Clamping force max. kN	External Ø mm	Inner Ø	Overhang distance Ø J mm	Overhang distance Ø A mm	B mm	Thread	Weight approx. kg
220206	0	125	15	153	110	50-115	150-215	20	M5	1,6
220207	1	200	30	176	110	35-125	170-260	31	M8	3,4
220208	2	250	30	215	135	70-140	215-285	31	M8	5
220209	3	250	30	244	162	100-175	240-315	31	M8	5,7
220210	4	315	30	290	208	145-215	290-360	31	M8	6,9
220211	5	400	40	342	260	160-270	330-440	31	M10	8,5

▲ on request

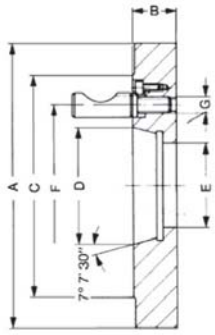
Adapter plates

A09
Short-taper adapter plate ISO 702-3 (DIN 55027) and 55022 with studs and locknuts



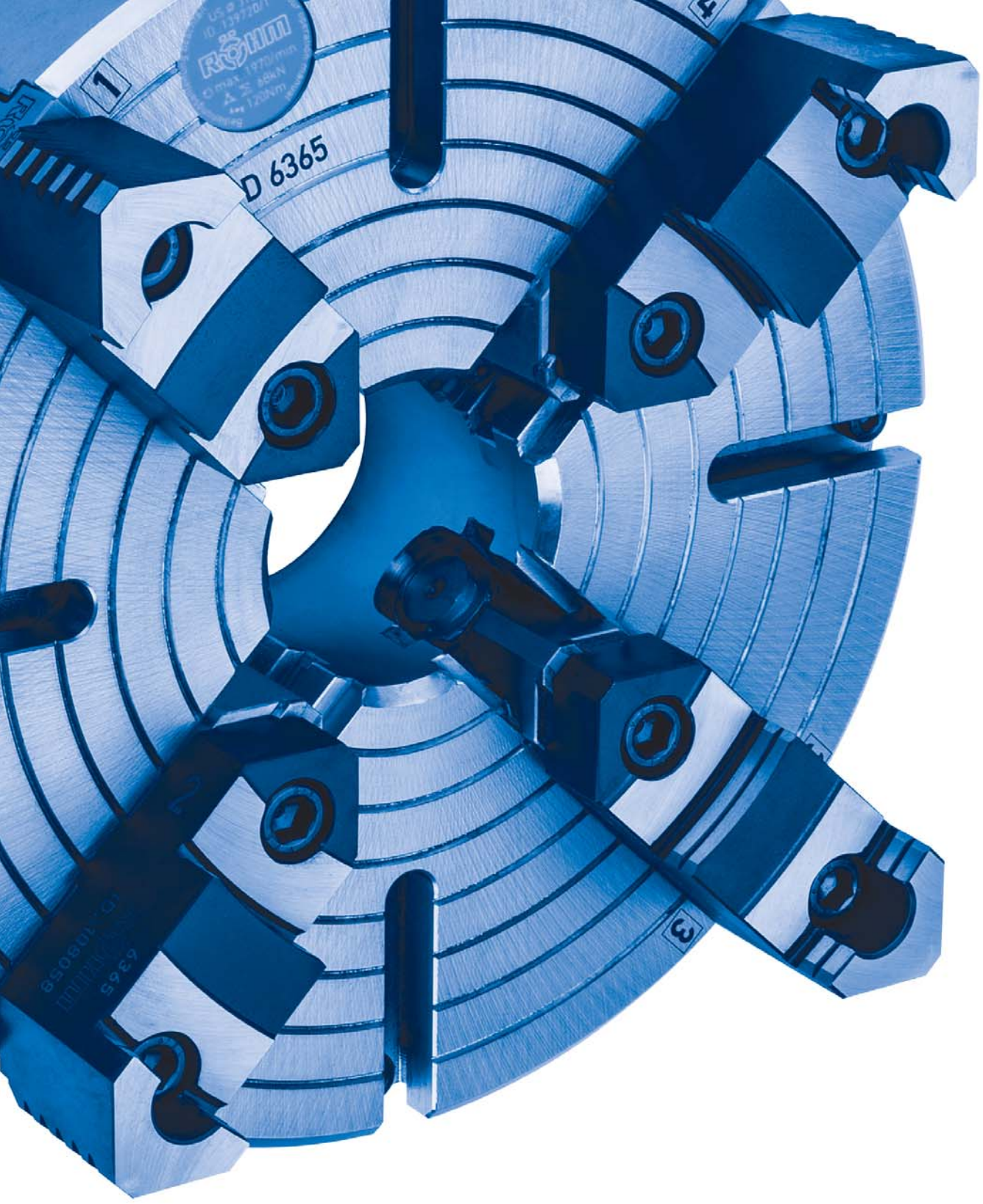
Item no.	Ø A mm	Taper	Inch	B mm	C mm	D mm	E mm	F mm	G	Weight approx. kg
319650	125	3	5	19	102	53,975	40	75	M10	2,3
319651	125	4	5	19	112	63,513	40	85	M10	2,2
319652	160	3	6 ¼	21	102	53,975	40	75	M10	3,9
319653	160	4	6 ¼	21	112	63,513	40	85	M10	3,9
319654	160	5	6 ¼	21	135	82,563	40	104,8	M10	4,6
319655	200	4	8	21	112	63,513	50	85	M10	6,4
319656	200	5	8	21	135	82,563	50	104,8	M10	7,4
319657	200	6	8	23	170	106,375	50	133,4	M12	8,4
319658	250	4	1	21	112	63,513	61	85	M10	10,2
319659	250	5	10	21	135	82,563	63	104,8	M10	11,6
319660	250	6	10	23	170	106,375	63	133,4	M12	13,3
319661	250	8	10	26	220	139,719	63	171,4	M16	13,8
319662	315	5	12 ¼	26	135	82,563	63	104,8	M10	18,6
319663	315	6	12 ¼	26	170	106,375	63	133,4	M12	21,5
319664	315	8	12 ¼	26	220	139,719	63	171,4	M16	22,6
319665	315	11	12 ¼	33	290	196,869	63	235	M20	25,2
319666	400	6	15 ¾	31	170	106,375	63	133,4	M12	35
319667	400	8	15,75	31	220	139,719	63	171,4	M16	37,2
319668	400	11	15,75	31	290	196,869	63	235	M20	42
319669	400	15	15,75	33	400	285,775	63	330,2	M24	42,1
319670	500	8	20	41	220	139,719	80	171,4	M16	62
319671	500	11	20	41	290	196,869	80	235	M20	67
319672	500	15	20	41	400	285,775	80	330,2	M24	68

A09
Short-taper adapter plate ISO 702-2 (DIN 55029) **and ASA B 5.9 D1,** Camlock



Item no.	Ø A mm	Taper	Inch	B mm	C mm	D mm	E mm	F mm	G	Weight approx. kg
319673	125	3	5	27	92,1	53,975	40	70,66	7/16 - 20	2,3
319674	125	4	5	28	117,5	63,513	40	82,55	7/16 - 20	2,2
319675	160	3	6 ¼	27	92,1	53,975	40	70,66	7/16 - 20	3,9
319676	160	4	6 ¼	28	117,5	63,513	40	82,55	7/16 - 20	3,9
319677	160	5	6 ¼	31	146	82,563	40	104,8	½ - 20	4,6
319678	200	4	8	28	117,5	63,513	50	82,55	7/16 - 20	6,4
319679	200	5	8	31	146	82,563	50	104,8	½ - 20	7,4
319680	200	6	8	36	181	106,375	50	133,4	5/8 - 18	8,4
319681	250	4	1	28	117,5	63,513	61	82,55	7/16 - 20	10,2
319682	250	5	10	31	146	82,563	63	104,8	½ - 20	11,6
319683	250	6	10	36	181	106,375	63	133,4	5/8 - 18	13,3
319684	250	8	10	39	225,4	139,719	63	171,4	¾ - 16	13,8
319685	315	5	12 ¼	31	146	82,563	63	104,8	½ - 20	18,6
319686	315	6	12 ¼	36	181	106,375	63	133,4	5/8 - 18	21,5
319687	315	8	12 ¼	39	225,4	139,719	63	171,4	¾ - 16	22,6
319688	315	11	12 ¼	45	298,4	196,869	63	235	7/8 - 14	25,2
319689	400	6	15 ¾	36	181	106,375	63	133,4	5/8 - 18	35
319690	400	8	15,75	39	225,4	139,719	63	171,4	¾ - 16	37,2
319691	400	11	15,75	45	298,4	196,869	63	235	7/8 - 14	42
319692	400	15	15,75	50	403	285,775	63	330,2	1 - 14	42,1
319693	500	8	20	41	225,4	139,719	80	171,4	¾ - 16	62
319694	500	11	20	45	298,4	196,869	80	235	7/8 - 14	67
319695	500	15	20	50	403	285,775	80	330,2	1 - 14	68

Further sizes and designs, such as ISO 702-1, available on request!



JAWS INDIVIDUALLY ADJUSTABLE

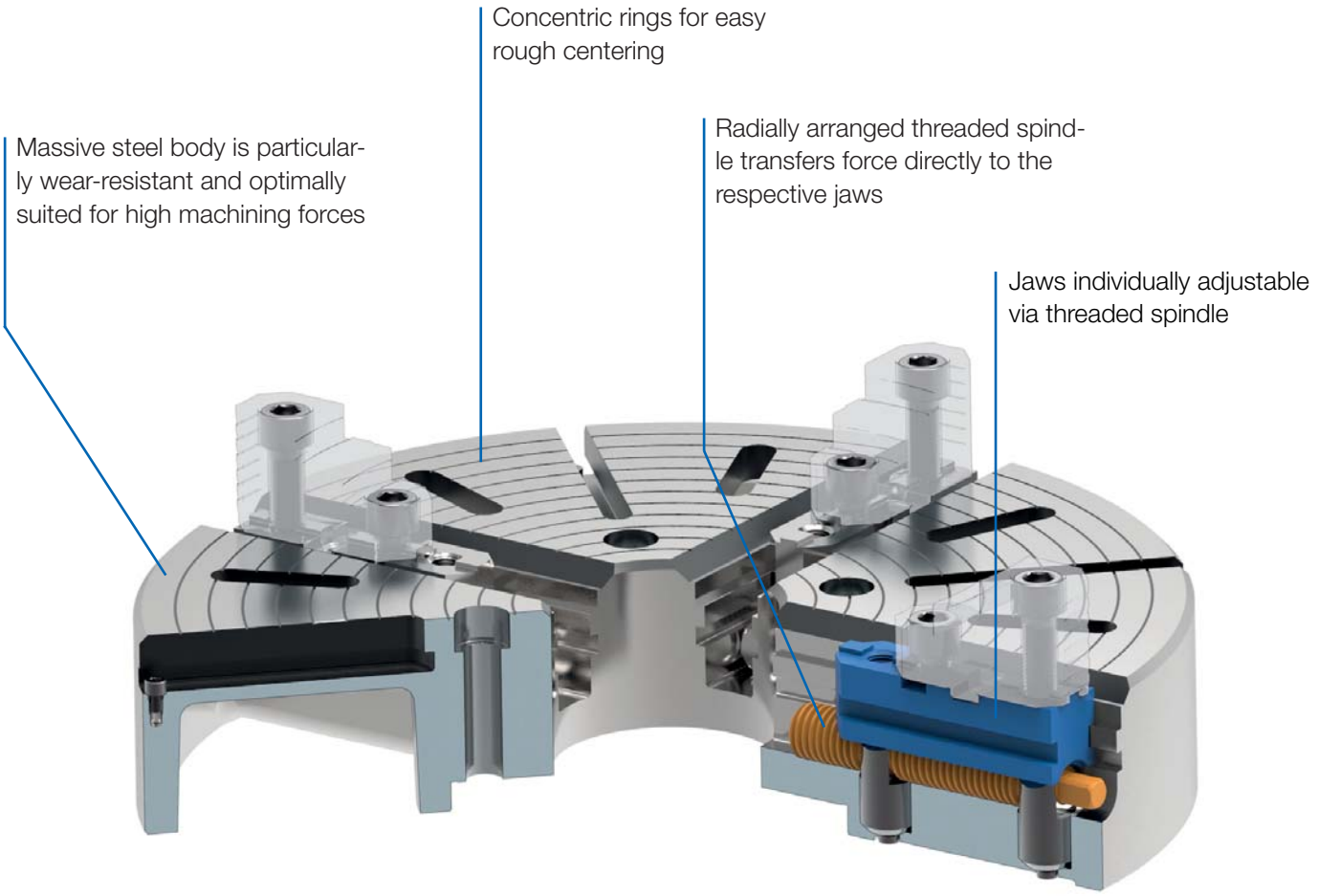
The four jaws can be independently adjusted via the threaded spindle, thereby allowing the safe and secure clamping of irregular, regular, as well as round workpieces.

INDEPENDENT CHUCKS

Independent chucks from RÖHM are particularly successful and effective when force has top priority. Due to the increased rigidity and optimal wear behavior, they are especially suitable for the initial machining of irregular, regular and round workpieces and make high machining forces and a longer machine service life possible.

ADVANTAGES AT A GLANCE

- Safe and easy clamping of irregular, regular, as well as round workpieces by four independently adjustable jaws
- Easy rough centering by means of concentric rings on the chuck body
- Direct force transfer through radially arranged threaded spindles



USE - USU

APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped.

TYPE

Independent four-jaw chuck in steel design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 315 with T-slots. Starting from size 1100 with T-slots and set-up slots.

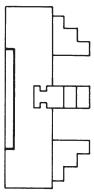
CUSTOMER BENEFITS

- Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

- Steel design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

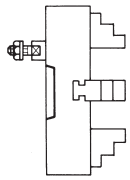
A26
Cylindrical centre mount (without mounting bolts)



Size	with one-piece reversible jaws	with base jaws and top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	139781 ▲	**137147 ▲**	70	2350	120	17
310	139796 ▲	**139720 ▲**	75	1970	120	17
400	139827 ▲	**135368 ▲**	95	1530	170	23
450	139842 ▲	**136944 ▲**	95	1360	170	23
500	139857 ▲	**135631 ▲**	95	1220	170	23
630	139887 ▲	**139723 ▲**	135	970	240	37
710	140800 ▲	**141097 ▲**	135	860	240	37
800	140801 ▲	**141106 ▲**	190	765	300	45

Further sizes and mountings available on request

A26
ISO 702-3 (DIN 55027), DIN 55022



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	4	**139782 ▲**	**137163 ▲**	61	2350	120	17
260	5	**139783 ▲**	**137164 ▲**	70	2350	120	17
260	6	**139784 ▲**	**137165 ▲**	70	2350	120	17
310	5	**139797 ▲**	**139724 ▲**	75	1970	120	17
310	6	**139798 ▲**	**139725 ▲**	75	1970	120	17
310	8	**139799 ▲**	**139726 ▲**	75	1970	120	17
400	6	**139828 ▲**	**135371 ▲**	95	1530	170	23
400	8	**139829 ▲**	**135372 ▲**	95	1530	170	23
400	11	**139830 ▲**	**135358 ▲**	95	1530	170	23
450	6	**139843 ▲**	**136947 ▲**	95	1360	170	23
450	8	**139844 ▲**	**136948 ▲**	95	1360	170	23
450	11	**139845 ▲**	**136957 ▲**	95	1360	170	23
500	6	**139858 ▲**	**135632 ▲**	95	1220	170	23
500	8	**139859 ▲**	**135633 ▲**	95	1220	170	23
500	11	**139860 ▲**	**135696 ▲**	95	1220	170	23
630	8	**139888 ▲**	**139767 ▲**	136	970	240	37
630	11	**139889 ▲**	**139768 ▲**	136	970	240	37
630	15	**139890 ▲**	**139769 ▲**	136	970	240	37
710	8	**141088 ▲**	**141098 ▲**	136	860	240	37
710	11	**141089 ▲**	**141099 ▲**	136	860	240	37
800	8	**141092 ▲**	**600638 ▲**	200	765	300	45
800	11	**141093 ▲**	**141107 ▲**	192	765	300	45
800	15	**141094 ▲**	**141108 ▲**	192	765	300	45
900	11	-	**600639 ▲**	190	680	300	45
900	15	-	**600641 ▲**	190	680	300	45

Further sizes and mountings available on request

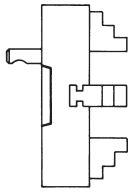
▲ on request

USE - USU

Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
1000	11	-	**141115** ▲	190	610	320	47
1000	15	-	**141116** ▲	190	610	320	47
1000	20	-	**600645** ▲	190	610	320	47
1100	11	-	**150500** ▲	190	555	320	47
1100	15	-	**600642** ▲	190	555	320	47
1100	20	-	**600646** ▲	190	555	320	47
1200	11	-	**150501** ▲	190	510	450	64
1200	15	-	**600643** ▲	190	510	450	64
1200	20	-	**600647** ▲	190	510	450	64

Further sizes and mountings available on request

A26
ISO 702-2 (DIN 55029), ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}	Torque Nm	Clamping force/ jaw kN
260	4	**139791** ▲	**137166** ▲	60	2350	120	17
260	5	**139792** ▲	**137254** ▲	70	2350	120	17
260	6	**139793** ▲	**137255** ▲	70	2350	120	17
310	5	**139806** ▲	**139733** ▲	75	1970	120	17
310	6	**139807** ▲	**139734** ▲	75	1970	120	17
310	8	**139808** ▲	**139735** ▲	75	1970	120	17
400	6	**139837** ▲	**135375** ▲	95	1530	170	23
400	8	**139838** ▲	**135376** ▲	95	1530	170	23
400	11	**139839** ▲	**135359** ▲	95	1530	170	23
450	6	**139852** ▲	**136951** ▲	95	1360	170	23
450	8	**139853** ▲	**136952** ▲	95	1360	170	23
450	11	**139854** ▲	**136955** ▲	95	1360	170	23
500	6	**139867** ▲	**135703** ▲	95	1220	170	23
500	8	**139868** ▲	**135704** ▲	95	1220	170	23
500	11	**139869** ▲	**135705** ▲	95	1220	170	23
630	8	**139897** ▲	**139776** ▲	136	970	240	37
630	11	**139898** ▲	**139777** ▲	136	970	240	37
630	15	**139899** ▲	**139778** ▲	136	970	240	37
710	8	**140804** ▲	**141102** ▲	136	860	240	37
710	11	**140805** ▲	**141103** ▲	136	860	240	37
710	15	-	**141418** ▲	136	860	240	37
800	11	**140810** ▲	**141111** ▲	192	765	300	45
800	15	**140811** ▲	**141112** ▲	192	765	300	45
900	11	-	**600660** ▲	190	680	300	45
900	15	-	**600661** ▲	190	680	300	45
1000	11	-	**141119** ▲	190	610	320	47
1000	15	-	**141120** ▲	190	610	320	47
1000	20	-	**600665** ▲	190	610	320	47
1100	11	-	**150504** ▲	190	555	320	47
1100	15	-	**600662** ▲	190	555	320	47
1100	20	-	**600666** ▲	190	555	320	47
1200	11	-	**150505** ▲	190	510	450	64
1200	15	-	**600663** ▲	190	510	450	64
1200	20	-	**600667** ▲	190	510	450	64

Further sizes and mountings available on request

Jaws USE - USU

A09
Reversible jaw EB, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
022985	260	set	85	64	35
022986	310	set	94	66	35
163108 ▲	400/450	set	112	80	40
163109 ▲	500	set	136	88	40
175358 ▲	630/710	set	172	108	45
247823 ▲	800	set	185	130	60

A09
Base jaw GB with fixing screw

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
304656 ▲	260	set	91	40,1	35
304657 ▲	310	set	107	40,1	35
304658 ▲	400/450	set	126	47,1	40
304659 ▲	500	set	164,4	47,1	40
304660 ▲	630	set	165	51,1	45
304661 ▲	710	set	202	51,1	45
304662 ▲	800/900/1000/1100	set	240	61,1	60
150543 ▲	1200	set	350	92,2	70

A09
Reversible top jaws UB DIN 6350, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108057	260	set	95,3	52,5	36
108058	310	set	109,5	57,5	42
108059	400/450	set	127	64,5	42
108060	500/630/710	set	127	79,5	50
105085	800/900	set	210	89	68
105101	1000/1100/1200	set	210	110	68

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107579	260	set	103	53	36,5
107580	310	set	120	58	42,5
107581	400/450	set	137	65	42,5
107582	500/630/710	set	140	80	50,5
105105	800/900	set	210	89	68
105109	1000/1100/1200	set	210	110	68

Configure your individual clamping jaws online! www.web2product.biz

Accessories USE - USU

A26
Adjusting spindle

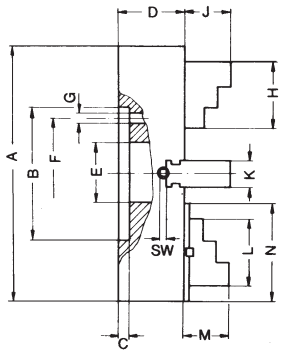
Item no.	Size	Square	Hexagon
169142 ▲	260	10	-
166565 ▲	310	10	-
162110 ▲	400	13	-
162121 ▲	450	13	-
161629 ▲	500	13	-
161611 ▲	630	16	-
247826 ▲	800	18	-
150544 ▲	900	18	-
150545 ▲	1000	18	-
150546 ▲	1100	18	-
149776 ▲	1200	-	24

A26
Safety key

Item no.	Size	Square	Hexagon
160096 ▲	260/310	10	-
160097 ▲	400	13	-
160098 ▲	450/500	13	-
160099 ▲	630/710	16	-
160100 ▲	800/900/1000/1100	18	-
150548 ▲	1200	-	24

Chuck dimensions USE - USU

Cylindrical centre mount



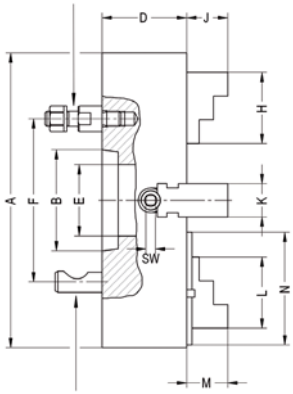
Size A		260	310	400	450	500	630	710	800
B^{H8}		130	130	210	210	210	260	260	370
C		8	8	18	18	18	18	18	18
D	USE - USU	85	95	112,5	112,5	112,5	122,5	132,5	145
E	USE - USU	70	75	95	95	95	135	135	180
F		105	105	175	175	175	220	220	330
G		4x13,5	4x13,5	4x17	4x17	4x17	4x20,5	4x20,5	8x22
H		85	94	112	112	136	172	172	185
J		34	35	41,5	42	50	55,5	55,5	80
K		35	35	40	40	40	45	45	60
L		80	87	105	114	126	140	165	210
M		56,5	60,5	54	54	69	69	69	91
N		100	105	125	135	145	165	185	240
SW		10	10	13	13	13	16	16	18
approx. kg		23	32	52	76	91	150	190	270

1) Outer hexagon

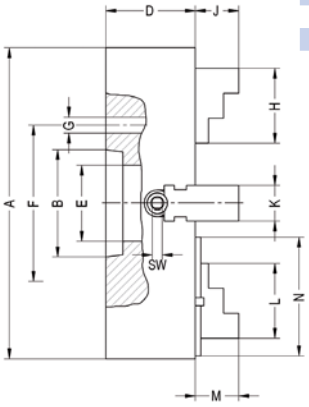
Short taper mount

DIN 55021 with setscrews and locknuts

DIN 55027 with studs and nuts



DIN 55029 with studs for camlock



DIN 55026 mounting from front

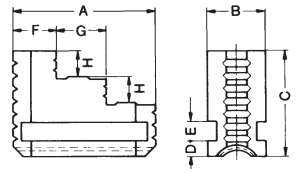
Size A		260			310			400			450			500			630		
Taper size		4[1]	5[2]	6	5	6	8	6	8	11	6	8	11	6	8	11	8	11	15
B		63,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,9	139,7	196,9	285,8
D		75			82			112,5			112,5			112,5			122,5		
E		61	70	70	75			95			95			95			135		
F	DIN	85	104,8	133,4	104,8	133,4	171,4	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235	171,4	235	330,2
	Camlock	82,6																	
G		11	11	14	11	14	18	14	18	22	14	18	22	14	18	22	18	22	26
H		85			94			112			112			136			172		
J		34			35			42			42			50			55,5		
K	USE	35			35			40			40			40			45		
	USU	36			42			42			42			50			50		
L		95,3			109,5			127			127			127			127		
M		56,5			60,5			54			54			69			69		
N		91			107			126			126			164,4			165		
SW		10			10			13			13			13			16		
approx. kg		23			32			52			76			91			150		

Size A		710			800		
Taper size		8	11	15	8	11	15
B		139,7	196,9	285,8	139,7	196,9	285,8
D		132,5			145		
E		135			180		
F		171,4	235	330,2	171,4	235	330,2
G		18	22	26	18	22	16
H		172			185		
J		55,5			80		
K	USE	45			60		
	USU	68			68		
L		210			210		
M		69			91		
N		202			240		
SW		16			18		
approx. kg		190			270		

1) Not for DIN 55021 or A1/A2 inch
2) Not for A1/A2 inch

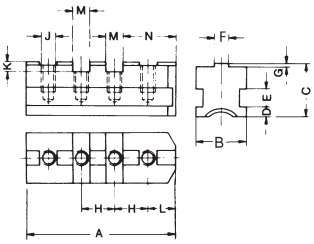
Jaw dimensions USE - USU

Reversible one-piece jaw EB



Size	260	310	400	450	500	630	710	800
A	85	94	112		136	172		185
B	35	35	40		40	45		60
C	64	66	80		88	108		130
D	10	10	10		10	12		14
E	12	12	14		14	14		18
F	27	30	36		42	52		55
G	29	32	38		46	60		65
H	14	15	19		23	26		30
approx. kg	0,8	0,9	1,6		2,25	3,5		4,2

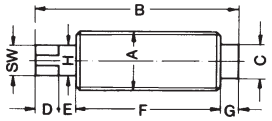
Base jaw GB



Size	260	310	400	450	630	710	800
A	91	107	126		165	202	240
B	35	35	40		45	45	60
C	40,1	40,1	47,1		51,1	51,1	61,1
D	10	10	10		12	12	14
E	12	12	14		14	14	18
F	12,7	12,7	12,7		12,7	12,7	12,7
G	3,1	3,1	3,1		3,1	3,1	3,1
H	54	63,5	76,2		38,1	38,1	38,1
J	M12	M12	M16		M20	M20	M20
K	7,6	7,6	10,8		10,8	10,8	10,8
L	21,2	24,4	27,5		27,5	27,5	27,5
M	19,03	19,03	19,03		19,03	19,03	19,03
N	38,7	46,6	56,1		56,1	56,1	56,1
Grooves	1	1	1		2	3	4
Tapped holes	2	2	2		4	5	6
approx. kg	0,8	0,9	1,1		1,4	2,2	2,8

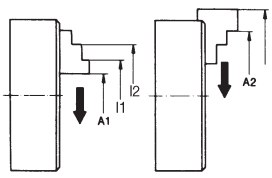
Reversible top jaw UB and unstepped top jaw

Adjusting spindle



Size	260	310	400	450	500	630	710	800
A	26	26	30	30		34	34	40
B	83,5	99	129	167		200	200	240
C	14	14	16	16		28	28	33
D	13	15	16	16		20,5	20,5	24
E	13,5	15	18,5	18,5		21,5	21,5	24
F	45	55	78	116		143	143	172
G	12	14	16,5	16,5		13,5	13,5	20
H	14	14	16	16		20	20	22
SW	10	10	13	13		16	16	18

1) with outer hexagon



Chucking capacities of jaw steps (standard values)

Size mm	260	310	400	450	500	630	710	800
A1 min.	20	20	35	40	40	60	130	190
A2 max.	260	295	400	450	500	585	690	800
l1 min.	75	80	90	100	145	145	145	170
l2 max.	260	310	400	450	520	650	730	820
max. swing. dia.	305	355	465	510	570	675	785	870

UGE - UGU

APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped.

TYPE

Independent four-jaw chuck in cast iron design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 400 with T-slots and set-up slots.

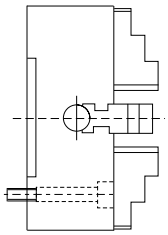
CUSTOMER BENEFITS

- Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

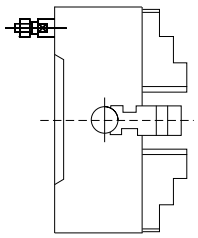
- Cast iron design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

A26
Cylindrical centre mount



Size	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min^{-1}
160	**1189704** ▲	-	45	2000
200	**1189705** ▲	**1189780** ▲	56	1800
250	**1189706** ▲	**1189781** ▲	65	1500
315	**1189707** ▲	**1189782** ▲	80	1200
400	**1189708** ▲	**1189783** ▲	100	800
500	**1189709** ▲	**1189784** ▲	125	500

A26
ISO 702-3 (DIN 55027), DIN 55022, with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	With one-piece reversible jaws	With reversible top jaws	Through-hole mm	Speed max. min^{-1}
200	5	**1189714** ▲	**1189789** ▲	56	1800
200	6	**1189715** ▲	**1189790** ▲	56	1800
250	5	**1189716** ▲	**1189791** ▲	65	1500
250	6	**1189717** ▲	**1189792** ▲	65	1500
250	8	**1189718** ▲	**1189793** ▲	65	1500
315	5	**1189719** ▲	**1189794** ▲	80	1200
315	6	**1189720** ▲	**1189795** ▲	80	1200
315	8	**1189721** ▲	**1189796** ▲	80	1200
400	6	**1189722** ▲	**1189797** ▲	100	800
400	8	**1189723** ▲	**1189798** ▲	100	800
400	11	**1189724** ▲	**1189799** ▲	100	800
500	6	**1189725** ▲	**1189800** ▲	100	500
500	8	**1189726** ▲	**1189801** ▲	125	500
500	11	**1189727** ▲	**1189802** ▲	125	500

▲ on request

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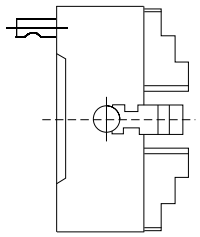
A26
ISO 702-2 (DIN 55029), ASA B 5.9, Type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min^{-1}
200	4	**1189733** ▲	**1189812** ▲	56	1800
200	5	**1189734** ▲	**1189813** ▲	56	1800
200	6	**1189735** ▲	**1189943** ▲	56	1800
250	4	**1189736** ▲	**1189814** ▲	60	1500
250	5	**1189737** ▲	**1189815** ▲	65	1500
250	6	**1189738** ▲	**1189816** ▲	65	1500
250	8	**1189739** ▲	**1189817** ▲	65	1500
315	5	**1189740** ▲	**1189818** ▲	80	1200
315	6	**1189741** ▲	**1189819** ▲	80	1200
315	8	**1189742** ▲	**1189820** ▲	80	1200
400	6	**1189743** ▲	**1189821** ▲	100	800
400	8	**1189744** ▲	**1189822** ▲	100	800
400	11	**1189745** ▲	**1189823** ▲	100	800
500	8	**1189746** ▲	**1189824** ▲	125	500
500	11	**1189747** ▲	**1189825** ▲	125	500

Jaws UGE - UGU

A09
Reversible jaw EB, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189865 ▲	160	set	61,5	51	20
1189866 ▲	200	set	85	61,5	27
1189867 ▲	250	set	92	61,5	27
1189868 ▲	315	set	111	76,5	40
1189871 ▲	400	set	129	76,5	40
1189872 ▲	500	set	152,5	93,5	52

A09
Base jaw GB with mounting bolts

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189895 ▲	200	set	79	32	27
1189896 ▲	250	set	94	38	27
1189897 ▲	315	set	110	39	40
1189898 ▲	400	set	129	44	40
1189899 ▲	500	set	168	59	52

A09
Unstepped top jaw AB, soft

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189877 ▲	200	set	90	43,5	40
1189878 ▲	250	set	106	51,5	47
1189879 ▲	315	set	120	55	52
1189880 ▲	400	set	140	64,5	52
1189881 ▲	500	set	145	82	60

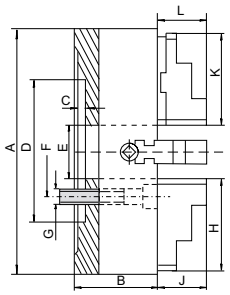
A09
Reversible top jaws UB, hardened

Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189886 ▲	200	set	82	43,5	34
1189887 ▲	250	set	96,5	51,5	34
1189888 ▲	315	set	112,5	55	42
1189889 ▲	400	set	129	64,5	42
1189890 ▲	500	set	136	74,5	54

▲ on request

Chuck dimensions UGE - UGU

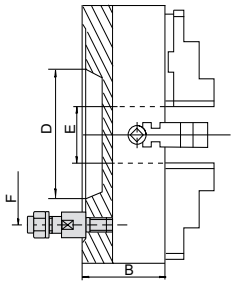
Cylindrical centre mount



Size	160	200	250	315	400	500
A	160	200	250	315	400	500
B	65	75	85	95	105	120
C	5	6	7	7	10	12
D^{H7}	65	75	150	175	200	270
E	45	56	65	80	100	125
F	95	95	104,8	133,4	171,4	235
G	4xM10	4xM10	4xM12	4xM16	4xM16	4xM20
H	61,5	85	96,5	111	129	152,5
J	31,5	35	40,3	49,8	49,8	59,8
L	-	46,4	60,4	60,9	72,3	90,3
K	-	82	96,5	112,5	129	136
approx. kg	7,5	10	25	39	61	105

Short taper mount

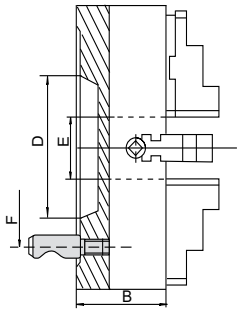
DIN 55027 with studs and locknuts



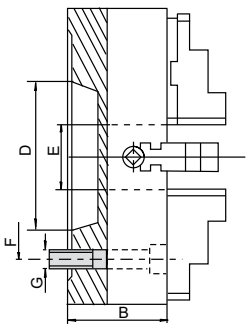
Size		200			250				315		
Taper size		4	5	6	4	5	6	8	5	6	8
B		75	75	75	85	85	85	85	95	95	95
D		63,5	82,5	106,3	63,5	82,5	106,3	139,7	82,5	106,3	139,7
E		56	56	56	60	65	65	65	80	80	80
F		85 [1] / 82,6	104,8	133,4	82,6	104,8	133,4	171,4	104,8	133,4	171,4
Mounting holes	DIN	3	4	4	-	4	4	4	4	4	4
	Camlock	3	6	6	3	6	6	6	6	6	6
approx. kg		10	10	10	27,5	27,5	27,5	27,5	39,5	39,5	39,5

Size		400			500		
Taper size		6	8	11	6	8	11
B		105	105	105	120	120	120
D		106,3	139,7	196,8	106,3	139,7	196,8
E		100	100	100	100	125	125
F		133,4	171,4	235	133,4	171,4	235
Mounting holes	DIN	4	4	6	4	4	6
	Camlock	6	6	6	6	6	6
approx. kg		60	60	60	95,5	95,5	95,5

DIN 55029 with studs for camlock



DIN 55026 mounting from front

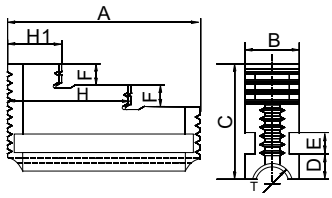


Size	200		250			315			400		
Taper size	5	6	5	6	8	5	6	8	6	8	11
B	75	75	85	85	85	95	95	95	105	105	105
D	82,5	106,3	82,5	106,3	139,7	82,5	106,3	139,7	106,3	139,7	196,8
E	50	50	65	65	65	80	80	80	100	100	100
F	104,8	133,4	104,8	133,4	171,4	104,8	133,4	171,4	133,4	171,4	235
G	4xM10	4xM12	8xM10	4xM12	4xM16	4xM10	8xM12	4xM16	8xM12	4xM16	4xM20
approx. kg	17	17	25,5	25,5	25,5	40	40	40	65	65	65

Size	500		
Taper size	6	8	11
B	120	120	120
D	106,3	139,7	196,8
E	100	125	125
F	133,4	171,4	235
G	4xM12	8xM16	8xM20
approx. kg	114	114	114

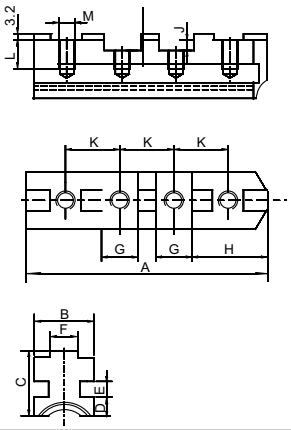
Jaw dimensions UGE - UGU

Reversible one-piece jaw EB



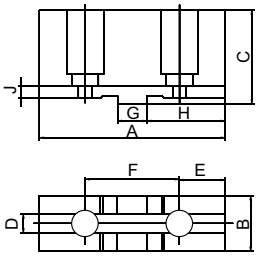
Size	160	200	250	315	400	500
A	61,5	85	92	111	129	152,5
B	20	27	27	40	40	52
C	51	61,5	61,	76,5	76,5	93,5
D	9	11,5	11,5	9,7	9,7	11,7
E	10	10	10	12	12	15
F	10	12	12	18	18	22
H1	20	30,5	30,5	27	32,5	35
H	41	58	65,5	67	78,5	93
Thread T	22x4	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Base jaw GB



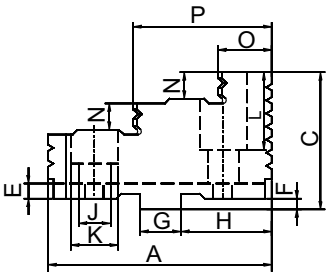
Size	200	250	315	400	500
A	79	94	110	129	168
B	27	27	40	40	52
C	32	38	39	44	59
D	11,5	11,5	9,7	9,7	11,7
E	10	10	12	12	15
$F_{-0,03}$	7,94	12,7	12,7	12,7	12,7
$G^{+0,01}$	12,69	19,04	19,04	19,04	19,04
H	33,2	37,5	45,4	54,9	55,5
J	4	4	4	7,2	7,2
K	22,25	27	31,75	38,1	38,1
L	14	20	17,5	22	33,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
Thread T	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Unstepped soft top jaw AB

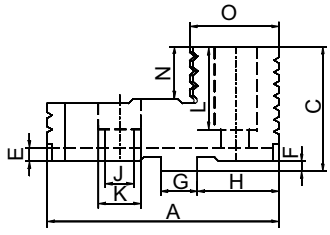


Size	200	250	315	400	500
A	90	106	120	140	145
B	40	47	52	52	60
C	43,5	51,5	55	64,5	82
D	7,95	12,71	12,71	12,71	12,71
E	24	27,5	30,7	34,4	34,4
F	44,5	54	63,5	76,2	76,2
G	12,69	19,04	19,04	19,04	19,04
H	40	45	53	63	63
J	4	4	4	4	4

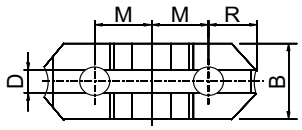
Reversible top jaw UB



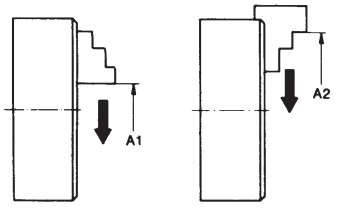
Ø 200-800mm



Ø 1000-12500 mm



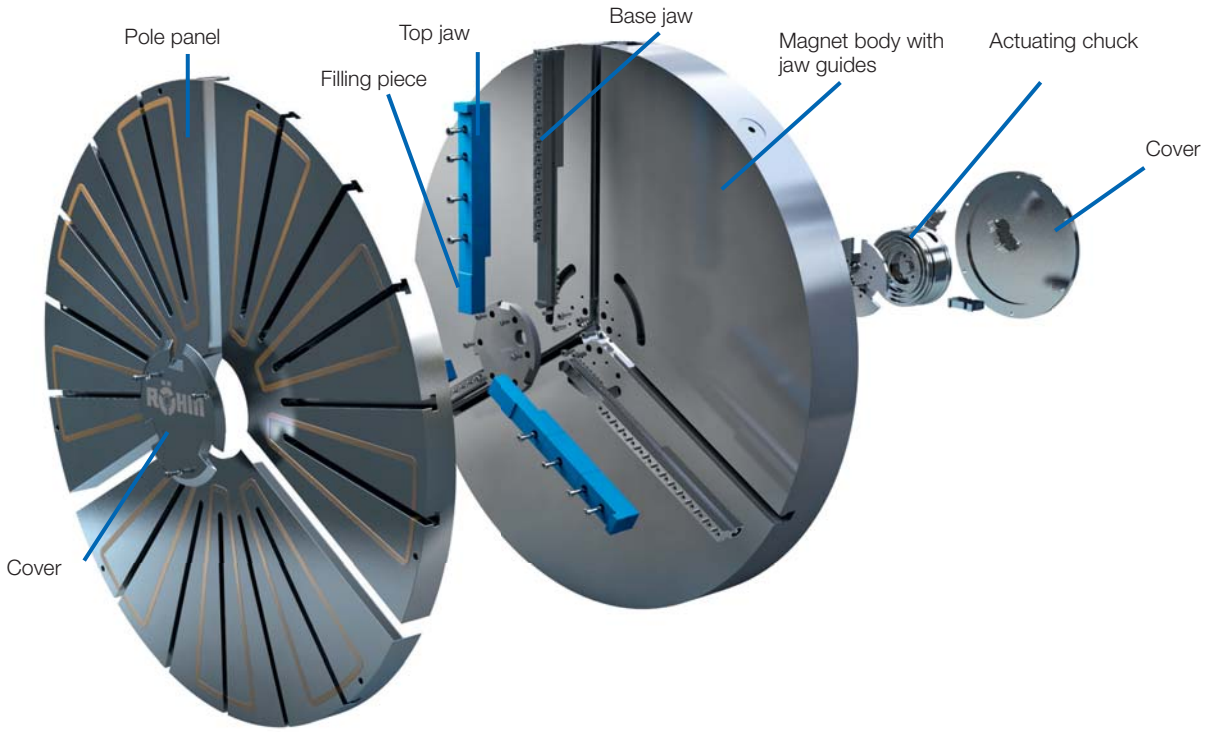
Size	200	250	315	400	500
A	82	96,5	112,5	129	136
B	34	34	42	42	54
C	43,5	51,5	55	64,5	74,5
D	7,95	12,71	12,71	12,71	12,71
E	4	4	4	4	4
$F_{-0,03}$	3,2	3,2	3,2	6,3	6,3
$G^{+0,01}$	12,69	19,04	19,04	19,04	19,04
H	35,2	40	47,9	57,4	58
J	11	14	14	18	22
K	18	20	20	26	33
L	21,5	26,5	27,5	32	39,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
N	9,5	12	13	13,5	18
O	22	25	27	26,5	37,5
P	53	62	70,5	79	87
R	19,3	22,5	25,7	28,8	29,4



Chucking capacities of jaw steps (standard values)

Size mm	160	200	250	315	400	500
A1 min.	8	10	10	15	20	45
A2 max.	160	200	250	315	400	500
max. swing. dia.	185	235	296	369	465	570

MZMF Hybrid chuck



Combined 2-jaw centering chuck with magnetic clamping plate

A precisely centered and deformation-free setup is of utmost importance, especially for easily deformable workpieces which require turning machining from all three sides within one working operation. Thanks to the combination of magnetic clamping force and deformation-free centering, workpieces, such as rings or other hard-to-grip parts having a wide range of sizes and contours, can be precisely clamped within seconds with the hybrid chuck MZMF.

Technische Merkmale:

- Set-up times reduced by up to 50%
- Machine downtimes reduced to a minimum
- 3-side machining for turning and grinding parts
- 16 individually adjustable adhesion stages
- Uniform and deformation-free setup
- Combined magnetic and centering chuck clamping are possible
- High process reliability for rational series production
- Fast amortization

Other special solutions

For special customer demands, RÖHM offers an individual range of special solutions, which goes far beyond the standard product range. From the smallest „micro technology“ clamping chuck for watches and jewelry machining to impressive chucks with a diameter of over 5.5 meters and weight of 25 tons for rail vehicles or the energy sector.

Machining of large bearings and rotary unions
Chuck for turning machining

- Constant clamping force at high speeds by means of centrifugal force compensation
- Integrated quick-acting jaw change system for mini mum setup times

Machining of large bearings and rotary unions
Chuck for drilling machining

- Centrically clamping wedge hook chuck
- Quickly adjustable clamping jaws and stops for minimum set-up times

Clamping chucks for rail traffic

- Clamping diameters of up to 1.3 meters with flexible set-up for individually changing workpiece sizes
- Automated jaw adjustment for inner and outer machining

Independent chucks for power plants and steel mills

- Clamping diameter of up to 5 meters
- Safe clamping using power spindles allows up to 50 tons of clamping force per jaw

For further informations of our special solutions in any areas visit our homepage:
http://www.roehm.biz/downloads/

F-senso chuck clamping force measuring device

With F-senso chuck, check both the clamping force as well as the speed behavior of the clamping device
Maximum flexibility through large clamping range from 75-175 mm by means of exchangeable pressure bolts and large measuring range from 0-100 kN per jaw. Suitable for 3-jaw chuck as well as vices. Dynamic clamping force measurement under rotation up to 8250 rpm. For clamping chucks, both the clamping force as well as the speed are measured. The centrifugal force behavior is transferred to the Tablet (included in delivery) in real time via Blue-Tooth and is evaluated with the already-installed software.

Video F-senso chuck

ADVANTAGES AT A GLANCE

- Direct output of the centrifugal force behavior through combined measurement of clamping force and speed
- Flexibility through large clamping and measuring range
- Easy handling without additional set-ups on the machine

Included in the scope of delivery:
- Base with foam insert
- Clamping force measuring head, F-senso chuck
- Pressure bolts in lengths 5 mm, 15 mm, 25 mm and 30 mm
- Pressure bolt elongation in length 25 mm
- Practical insertion aid
- Tablet PC with pre-installed measuring and evaluation program

C 15
Clamping force measurement device F-senso chuck

Item no.	179800
Measuring range / Clamping force kN	2 jaws: 0 - 200; 3 jaws: 0 - 300
Measuring range / Rotation speed min-1	0 - 8250
Accuracy	Force <0.5% / Rotation speed ±10 rpm within the complete measuring range
Clamping Ø mm	75 - 175
Dimensions (base unit)	Ø 75/80 x 130

Power-Grip zero-point clamping system

Palletizing systems, such as the Power-Grip zero-point clamping system from RÖHM, achieve a drastic increase in production. This modular system meets the demands for customized solutions with the best possible utilization of the machine capacity. While the machine tool was stopped for the time of the set-up operation before, now the workpiece can be clamped and positioned on the pallet outside of the machine tool.
The set-up time is now only limited to the changing in and out of the pallet within a few seconds.If several production processes are necessary for machining, the pallet can be used along with the workpiece without a zero-point loss. Due to the sturdy and rust-resistant design, the Power-Grip zero-point clamping system is universally suitable for applications ranging from cutting machining to electrical discharge machining all the way to measuring machines.

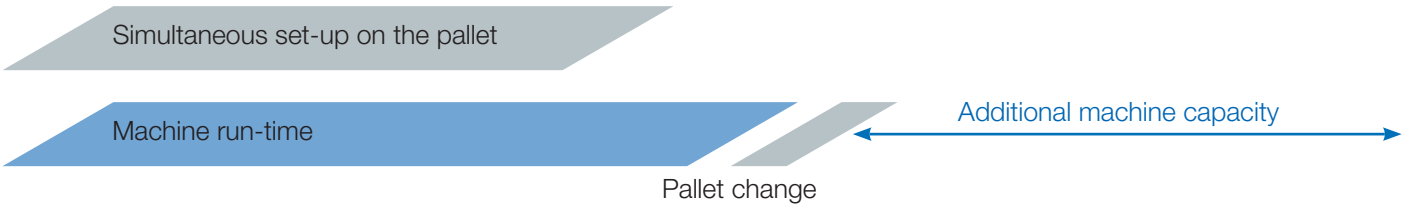
ADVANTAGES AT A GLANCE

- Increase in productivity thanks to set-up time reduction up to 90 %
- Maximum precision and repeatability of 0.002 mm
- Palletizing and clamping device from one source

SET-UP TIME REDUCTION BY UP TO 90 %

Without palletizing system

With Power-Grip zero-point clamping system



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