

Manual chucks DURO-T

Wedge bar principle, with jaw safeguard

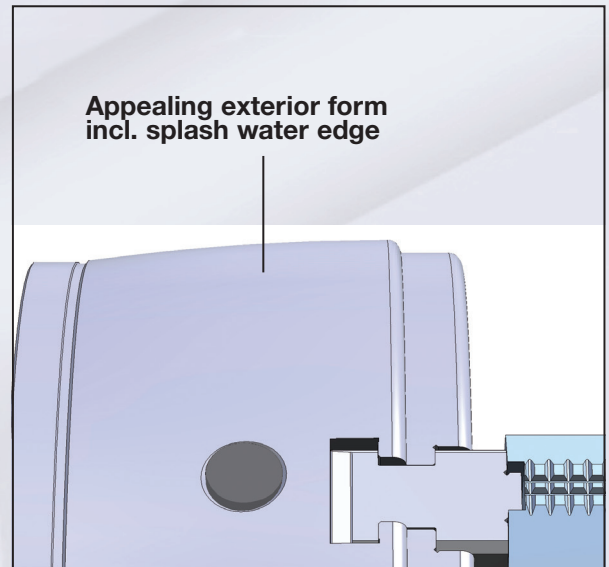


AMTE

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DURO-T



Technical features

RÖHM DURO-T Manual chucks:

- 20% higher clamping forces
- Chuck body stiffer (guarantees precision at higher loads)
- Surface of chuck body completely hardened
- Highly operator friendly
- Superior Design:
 - Indicator marks for quick jaw adjustment
 - Meaningful lettering engraved in body front face (i.e. chuck number, techn. details)
 - attractive, tared shape incl. drop-off wedge for water
- High jaw-changing repeatability
- Optimized wearing parts (i.e. safety lock)
- Chuck statically balanced
- Enhanced life at higher precision
- Radial and axial run-out tolerances only half of the permitted values according to the DIN-accuracy class 1
- Better corrosion prevention
- Lubrication possibility of the highly loaded sliding surfaces:
 - Spindle thread and spindle-counterface
 - wedge bars
 - drive ring
 - slides
- With safety key (required acc. DIN EN 1550)
- Base- and top-jaws of other manufacturers are compatible

Clamping force comparison DURO vs. DURO-T

Chuck size		125	160	200	250	315	400	500	630
Total gripping force DURO¹⁾	kN	8	25	40	55	67	85	93	93
Total gripping force DURO-T¹⁾	kN	8,5	30	48	66	80	95	102	102

1) Maintaining the accuracy

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 F 79 and F 80.

DURO-T

The Key bar chuck DURO-T replaces the well-tried RÖHM-Chuck DURO and ensures ultimate precision by the latest manufacturing technology. The DURO-T features 20% more clamping force and is statically balanced.

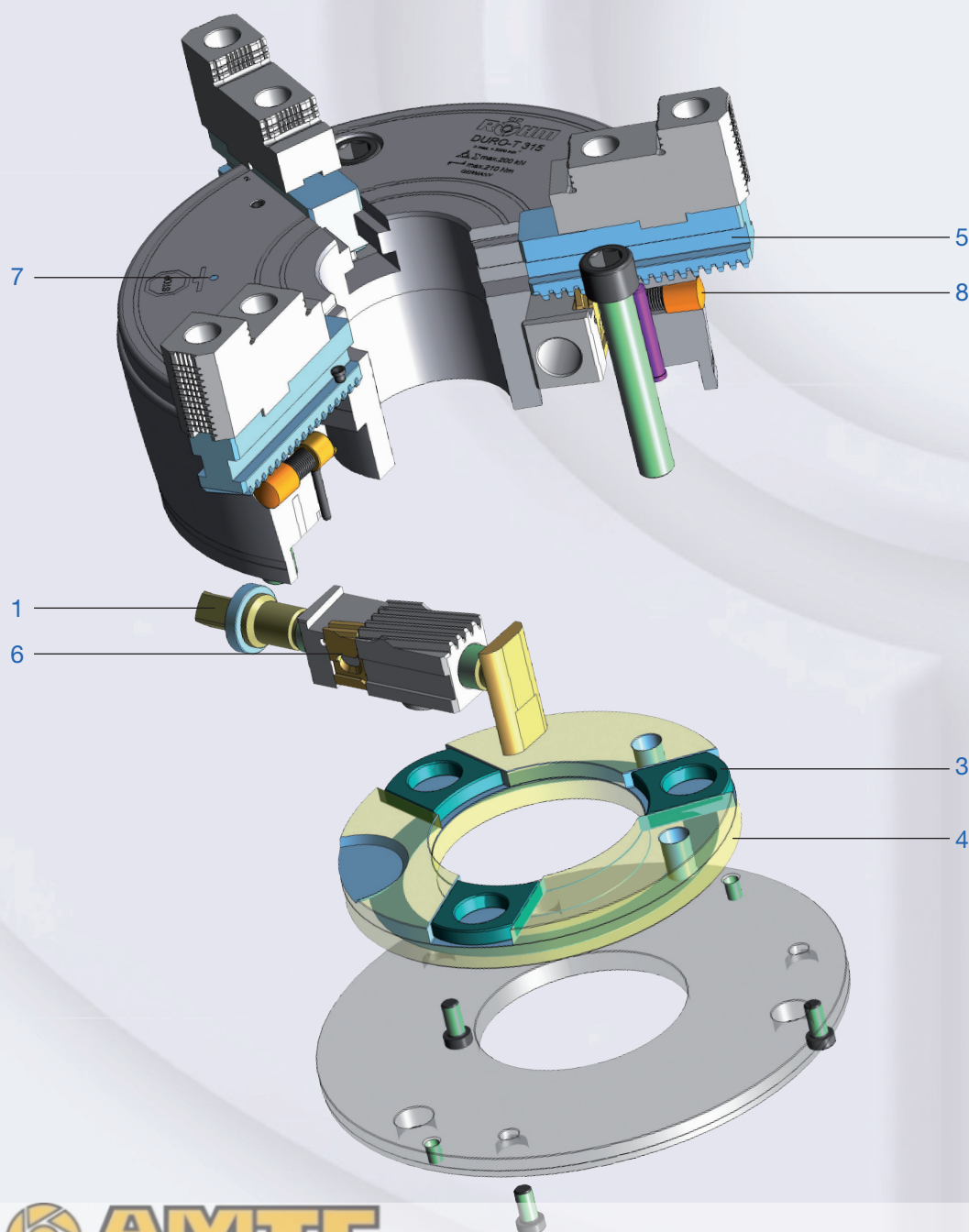
Mechanism

The tangentially arranged operating screw (1) engages the internal thread of the actuating key bar (2) to move a slide (3) which in turn moves the drive ring. Two further slides in the drive ring (4) transmit the force to the other two key bars. The key bars are provided with helical teeth which engage the teeth of the base jaws (5) so that the workpiece is gripped accurately and concentrically. The jaws can be quickly and conveniently reversed, exchanged or relocated over the entire gripping range after disengaging the key bar by turning the wrench counterclockwise, the indicator pin appears (7). In this position, the jaws are safely locked (6) against movement so that they cannot fly out if the machine spindle is started inadvertently. Each jaw must therefore be unlocked by pressing the corresponding pin (8) on the outside diameter of the chuck.

Large, straight surfaces transmitting the force from the key bar to the jaw teeth guarantee long life and produce a very high gripping force combined with an accuracy which is twice as high as required by DIN 6386. The high gripping force is achieved without much physical effort by manually turning the key.

Lubrication

Lathe chucks must be lubricated regularly to maintain their gripping force. Appropriate directions are included in the operating instructions supplied with each chuck. All lathe chucks are equipped with grease nipples for convenient maintenance.



DURO-T



DURO-T key bar chucks are successfully used wherever extremely high tension forces, high concentric accuracy and reliable continuous repeatability are needed.

For lathes. Suitable for milling machines, dividing attachments and machining centres in connection with a base plate, non rotating.

The jaws can be quickly and easily reversed, exchanged or relocated over the entire gripping range.

The jaws retain their accuracy if they are always used on the same chuck and when base jaws and top jaws are kept screwed together as a matched set for recurring work.

It is therefore advisable to stock several jaw sets.

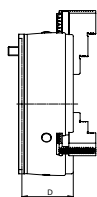
Technical features:

- with jaw safeguard
- chuck body stiffer (guarantees precision at higher loads)
- indicator marks for quick jaw adjustment
- attractive shape incl. drop-off edge for water
- radial and axial run-out tolerances only half of the permitted values according to the DIN-accuracy class 1
- lubrication possibility of the highly loaded sliding surfaces
- With safety key (required acc. DIN EN 1550)

Customer advantage:

- higher clamping forces
- high jaw-changing repeatability
- optimized wearing parts
- better corrosion prevention
- base- and top-jaws of other manufacturers are compatible

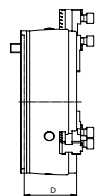
Tool group A08
Type 000 with reversible one-piece jaws
cylindrical centre mount



Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total clamping force kN
437475	125	5	32	46,5	6000	20	8,5
437476	160	6 1/4	42	63	5400	40	30
437477	200	8	52	81	4600	60	48
437478	250	10	62	92	4200	70	66
437479	315	12 1/2	87	111	3300	80	80
437480	400	15 3/4	102	118	2200	90	95
437481	500	20	162	118	1900	100	102

1) by conserving the precision

Tool group A08
Type 001 with base jaws only
cylindrical centre mount

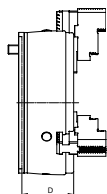


Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total clamping force kN
437482	125	5	32	46,5	6000	20	8,5
437483	160	6 1/4	42	63	5400	40	30
437484	200	8	52	81	4600	60	48
437485	250	10	62	92	4200	70	66
437486	315	12 1/2	87	111	3300	80	80
437487	400	15 3/4	102	118	2200	90	95
437488	500	20	162	118	1900	100	102
437489 ¹⁾	630	25	252	143	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

Tool group A08
Type 003 with base jaws and reversible top jaws
cylindrical centre mount



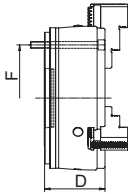
Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total clamping force kN
437490	160	6 1/4	42	63	5400	40	30
437491	200	8	52	81	4600	60	48
437492	250	10	62	92	4200	70	66
437493	315	12 1/2	87	111	3300	80	80
437494	400	15 3/4	102	118	2200	90	95
437495	500	20	162	118	1900	100	102
437496 ¹⁾	630	25	252	143	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

DURO-T

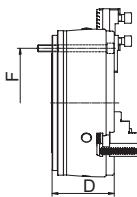
Tool group A08
Type 011 **with reversible one-piece jaws**
DIN 55026, DIN 55021, mounting from front



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437570	160	4	42	76	82,62	5400	40	30
437571	160	5	42	79	104,8	5400	40	30
437572	200	5	52	93	104,8	4600	60	48
437573	200	6	52	97	133,4	4600	60	48
437574	250	6	62	108	133,4	4200	70	66
437575	315	6	87	124	133,4	3300	80	80
437576	315	8	87	130	171,4	3300	80	80
437577	400	8	102	135	171,4	2200	90	95
437578	500	11	162	138	235	1900	100	102

1) by conserving the precision

Tool group A08
Type 012 **with base jaws only**
DIN 55026, DIN 55021, mounting from front

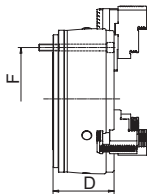


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437580	160	4	42	76	82,62	5400	40	30
437581	160	5	42	79	104,8	5400	40	30
437582	200	5	52	93	104,8	4600	60	48
437583	200	6	52	97	133,4	4600	60	48
437584	250	6	62	108	133,4	4200	70	66
437585	315	6	87	124	133,4	3300	80	80
437586	315	8	87	130	171,4	3300	80	80
437587	400	8	102	135	171,4	2200	90	95
437588	500	11	162	138	235	1900	100	102
437590 ¹⁾	630	15	252	167	330,2	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

Tool group A08
Type 014 **with base jaws and reversible top jaws**
DIN 55026, DIN 55021, mounting from front

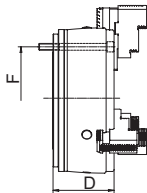


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437591	160	4	42	76	82,62	5400	40	30
437592	160	5	42	79	104,8	5400	40	30
437593	200	5	52	93	104,8	4600	60	48
437594	200	6	52	97	133,4	4600	60	48
437595	250	6	62	108	133,4	4200	70	66
437596	315	6	87	124	133,4	3300	80	80
437597	315	8	87	130	171,4	3300	80	80
437598	400	8	102	135	171,4	2200	90	95
437599	500	11	162	138	235	1900	100	102
437601 ¹⁾	630	15	252	167	330,2	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

Tool group A08
Type 015 **with reversible one-piece jaws**
DIN 55027, with studs and locknuts

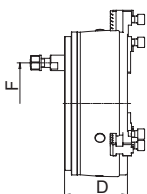


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437497	125	3	32	60	75	6000	20	8,5
437498	125	4	32	60	85	6000	20	8,5
437499	125	5	32	67	104,8	6000	20	8,5
437500	160	4	42	76	85	5400	40	30
437501	160	5	42	78	104,8	5400	40	30
437502	160	6	42	85	133,4	5400	40	30
437503	200	4	52	94	85	4600	60	48
437504	200	5	52	96	104,8	4600	60	48
437505	200	6	52	97	133,4	4600	60	48
437506	200	8	52	108	171,4	4600	60	48
437507	250	4	62	105	85	4200	70	66
437508	250	5	62	107	104,8	4200	70	66
437509	250	6	62	108	133,4	4200	70	66
437510	250	8	62	110	171,4	4200	70	66
437511	315	6	87	127	133,4	3300	80	80
437512	315	8	87	129	171,4	3300	80	80
437513	315	11	87	131	235	3300	80	80
437514	400	6	102	138	133,4	2200	90	95
437515	400	8	102	138	171,4	2200	90	95
437516	400	11	102	138	235	2200	90	95
437517	400	15	102	160	330,2	2200	90	95
437518	500	8	135	156	171,4	1900	100	102
437519	500	11	162	156	235	1900	100	102
437520	500	15	162	163	330,2	1900	100	102

1) by conserving the precision

DURO-T

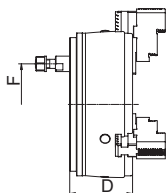
Tool group A08
Type 016 **with base jaws only**
DIN 55027, with studs and locknuts



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437521	125	3	32	60	75	6000	20	8,5
437522	125	4	32	60	85	6000	20	8,5
437523	125	5	32	67	104,8	6000	20	8,5
437524	160	4	42	76	85	5400	40	30
437525	160	5	42	78	104,8	5400	40	30
437526	160	6	42	85	133,4	5400	40	30
437527	200	4	52	94	85	4600	60	48
437528	200	5	52	96	104,8	4600	60	48
437529	200	6	52	97	133,4	4600	60	48
437530	200	8	52	108	171,4	4600	60	48
437531	250	4	60	105	85	4200	70	66
437532	250	5	62	107	104,8	4200	70	66
437533	250	6	62	108	133,4	4200	70	66
437534	250	8	62	110	171,4	4200	70	66
437535	315	6	87	127	133,4	3300	80	80
437536	315	8	87	129	171,4	3300	80	80
437537	315	11	87	131	235	3300	80	80
437538	400	6	102	138	133,4	2200	90	95
437539	400	8	102	138	171,4	2200	90	95
437540	400	11	102	138	235	2200	90	95
437541	400	15	102	160	330,2	2200	90	95
437542	500	8	135	156	171,4	1900	100	102
437543	500	11	162	156	235	1900	100	102
437544	500	15	162	163	330,2	1900	100	102
437545 ¹⁾	630	11	192	165	235	1100	100	102
437546 ¹⁾	630	15	252	167	330,2	1100	100	102

1) by conserving the precision
2) at size 630 chuck body without convex outer contours

Tool group A08
Type 018 **with base jaws and reversible top jaws**
DIN 55027, with studs and locknuts

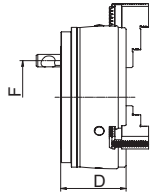


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437547	160	4	42	76	85	5400	40	30
437548	160	5	42	78	104,8	5400	40	30
437549	160	6	42	85	133,4	5400	40	30
437550	200	4	52	94	85	4600	60	48
437551	200	5	52	96	104,8	4600	60	48
437552	200	6	52	97	133,4	4600	60	48
437553	200	8	52	108	171,4	4600	60	48
437554	250	4	60	105	85	4200	70	66
437555	250	5	62	107	104,8	4200	70	66
437556	250	6	62	108	133,4	4200	70	66
437557	250	8	62	110	171,4	4200	70	66
437558	315	6	87	127	133,4	3300	80	80
437559	315	8	87	129	171,4	3300	80	80
437560	315	11	87	131	235	3300	80	80
437561	400	6	102	138	133,4	2200	90	95
437562	400	8	102	138	171,4	2200	90	95
437563	400	11	102	138	235	2200	90	95
437564	400	15	102	160	330,2	2200	90	95
437565	500	8	135	156	171,4	1900	100	102
437566	500	11	162	156	235	1900	100	102
437567	500	15	162	163	330,2	1900	100	102
437568 ¹⁾	630	11	192	165	235	1100	100	105
437569 ¹⁾	630	15	252	167	330,2	1100	100	102

1) by conserving the precision
2) at size 630 chuck body without convex outer contours

DURO-T

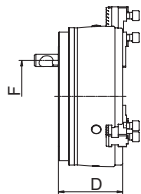
Tool group A08
Type 030 with reversible one-
piece jaws
DIN 55029, Stud for Camlock



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437602	125	3	32	67	70,66	6000	20	8,5
437603	125	4	32	68	82,6	6000	20	8,5
437604	160	4	42	83,5	82,6	5400	40	30
437605	160	5	42	87	104,8	5400	40	30
437606	160	6	42	104	133,4	5400	40	30
437607	200	4	52	97,5	82,6	4600	60	30
437608	200	5	52	101	104,8	4600	60	48
437609	200	6	52	106	133,4	4600	60	48
437610	200	8	52	125	171,4	4600	60	48
437611	250	4	60	118,5	82,6	4200	70	66
437612	250	5	62	112	104,8	4200	70	66
437613	250	6	62	117	133,4	4200	70	66
437614	250	8	62	120	171,4	4200	70	66
437615	315	6	87	145	133,4	3300	80	80
437616	315	8	87	136	171,4	3300	80	80
437617	315	11	87	143	235	3300	80	80
437618	400	6	102	153	133,4	2200	90	95
437619	400	8	102	141	171,4	2200	90	95
437620	400	11	102	148	235	2200	90	95
437621	400	15	102	168	330,2	2200	90	95
437622	500	8	135	143	171,4	1900	100	102
437623	500	11	162	148	235	1900	100	102
437624	500	15	162	153	330,2	1900	100	102

1) by conserving the precision

Tool group A08
Type 031 with base jaws only
DIN 55029, Stud for Camlock



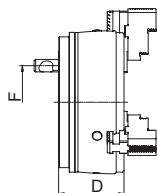
Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437625	125	3	32	67	70,66	6000	20	8,5
437626	125	4	32	68	82,6	6000	20	8,5
437627	160	4	42	83,5	82,6	5400	40	30
437628	160	5	42	87	104,8	5400	40	30
437629	160	6	42	104	133,4	5400	40	30
437630	200	4	52	97,5	82,6	4600	60	48
437631	200	5	52	101	104,8	4600	60	48
437632	200	6	52	106	133,4	4600	60	48
437633	200	8	52	125	171,4	4600	60	48
437634	250	4	60	118,5	82,6	4200	70	66
437635	250	5	62	112	104,8	4200	70	66
437636	250	6	62	117	133,4	4200	70	66
437637	250	8	62	120	171,4	4200	70	66
437638	315	6	87	145	133,4	3300	80	80
437639	315	8	87	136	171,4	3300	80	80
437640	315	11	87	143	235	3300	80	80
437641	400	6	102	153	133,4	2200	90	95
437642	400	8	102	141	171,4	2200	90	95
437643	400	11	102	148	235	2200	90	100
437644	400	15	102	168	330,2	2200	90	95
437645	500	8	135	143	171,4	1900	100	102
437646	500	11	162	148	235	1900	100	102
437647	500	15	162	153	330,2	1900	100	102
437648 ¹⁾	630	11	192	170	235	1100	100	102
437649 ¹⁾	630	15	252	175	330,2	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

DURO-T

Tool group A08
Type 033 **with base jaws and re-
versible top jaws**
DIN 55029, Stud for Camlock



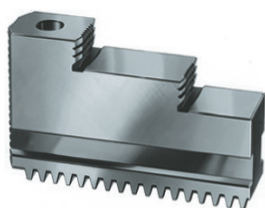
Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total clamping force kN
437650	160	4	42	83,5	82,6	5400	40	30
437651	160	5	42	87	104,8	5400	40	30
437652	160	6	42	104	133,4	5400	40	30
437653	200	4	52	97,5	82,6	4600	60	48
437654	200	5	52	101	104,8	4600	60	48
437655	200	6	52	106	133,4	4600	60	48
437656	200	8	52	125	171,4	4600	60	48
437657	250	4	60	118,5	82,6	4200	70	66
437658	250	5	62	112	104,8	4200	70	66
437659	250	6	62	117	133,4	4200	70	66
437660	250	8	62	120	171,4	4200	70	66
437661	315	6	87	145	133,4	3300	80	80
437662	315	8	87	136	171,4	3300	80	80
437663	315	11	87	143	235	3300	80	80
437664	400	6	102	153	133,4	2200	90	95
437665	400	8	102	141	171,4	2200	90	95
437666	400	11	102	148	235	2200	90	95
437667	400	15	102	168	330,2	2200	90	95
437668	500	8	135	143	171,4	1900	100	102
437669	500	11	162	148	235	1900	100	102
437670	500	15	162	153	330,2	1900	100	102
437671 ¹⁾	630	11	192	170	235	1100	100	102
437672 ¹⁾	630	15	252	175	330,2	1100	100	102

1) by conserving the precision

2) at size 630 chuck body without convex outer contours

Jaws DURO-T

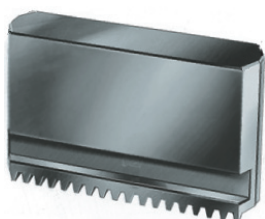
Tool group A28
Type 000 **One-piece jaw EB**, set
hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
212121	125	3	set	50	34	14
094000	160	3	set	77,7	45	20
094001	200	3	set	94,7	60	22
094002	250	3	set	114	70	26
094003	315	3	set	130	79	32
094043	400/500	3	set	167	93	45

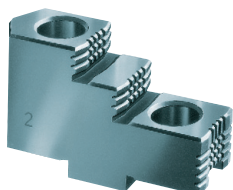
Stepped and hardened jaws, supplied as supplement or as spares, must be ground on the chuck.
In case of a subsequent jaw delivery please return the chuck.

Tool group A28
Type 000 **Unstepped jaw BL**, set
unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
304864	125	3	set	53	34	14
241699	160	3	set	84,4	45	20
249678	200	3	set	98,4	60	22
249679	250	3	set	118,7	70	26
249680	315	3	set	136,6	79	32
249681	400/500	3	set	173,6	93	45

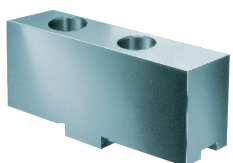
Tool group A28
Type 003 **Reversible top jaw UB**, set
hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
094012	160	3	set	61,5	32,5	20,4
094013	200	3	set	70,5	38	24,4
094014	250	3	set	92	50	34,4
094015	315	3	set	107	56	35,7
094045	400/500	3	set	130	72	50,4
140715	630	3	Satz	185	102	68

Hardened jaws, supplied as supplement or as spares, must be ground on the chuck.
In case of a subsequent jaw delivery please return the chuck.

Tool group A28
Type 002 **Unstepped top jaw AB**, set
standard design, soft, material 16MnCr5



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

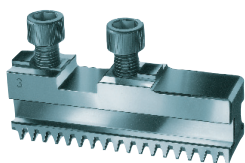
Tool group A28
Type 002 **Unstepped top jaw AB**, set
extendend design, soft, material 16MnCr5



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

Jaws DURO-T

Tool group A28
Type 002 **Base jaw GB**, set
with mounting bolts



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw width
212119	125	3	set	47	14
094004	160	3	set	74	20
094005	200	3	set	90	22
094006	250	3	set	110	26
094007	315	3	set	125	32
094044	400/500	3	set	160	45
140194	630	3	set	230	65

Tool group C15
Type 0040-Y **Jaw mounting bolt**,
piece

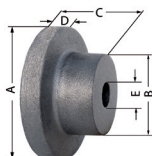


Item no.	Size	Thread
243893	125	M6x10
200182	160/200	M8x1x22
200183	250	M12x1,5x30
202402	315	M12x1,5x35
227618	400/500	M16x1,5x40
249388	630	M20x50

Accessories DURO-T

Tool group A08

Type 004 **Rough adaptor plate** for DURO-chucks with
cylindrical centre mount



Item no.	Chuck Size	A	B	C	D	E
206652	160	155	80	60	40	30
206653	200	195	80	65	40	40
206654	250	245	120	90	45	50
206655	314	310	165	100	45	50
229081	400	390	230	130	50	70
241780	500	475	240	145	50	80

Tool group A08

Type 000 **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

Tool group A08

Type 000 **Key**



Item no.	Size	Square	L
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

Tool group A08

Type 000 **Safety key**



Item no.	Size	Square	L
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

Tool group A08

Type 000 **Chip guard, set**



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

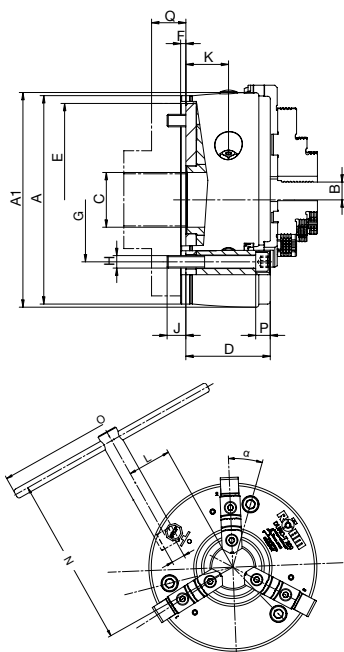
Tool group C15

Type 1028 **Special grease F80** for **lathe chucks**
for lubrication and conservation of chucking power



Item no.	Design	Contents
630886	tube	0,1 kg
304345	Tin	0,25 kg

Chuck dimensions DURO-T



Chuck size A		125	160	200	250	315	400	500	630
Outer-Ø	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 can 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 GD ² 1)	kgm ²	-	0,13	0,41	1,14	3,25	8,8	22	70
	α	21° 35'	22°	18°	19°	17°	20°	15°	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 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 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.

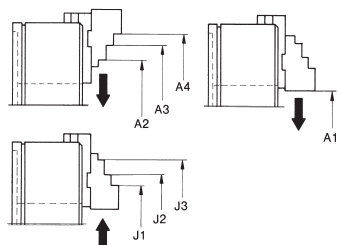
The specified gripping forces are standard values.

They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F 79 and F 80.

Chuck size		125	160	200	250	315	400	500	630
Torque applied on key 1)	Nm	20	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

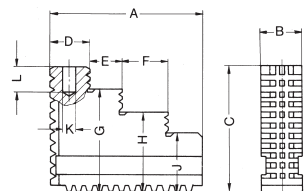
Chuck capacities of jaw steps



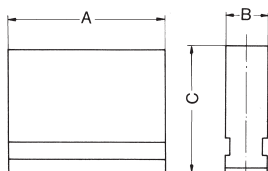
Chuck size		125	160	200	250	315	400	500	630
External chucking	Jaw position	A1	3-30	5-51	7-70	8-97	12-131	16-168	64-256
		A2	31-65	45-91	58-123	82-172	93-216	119-278	167-360
		A3	63-97	89-135	114-179	-	-	-	-
		A4	95-129	115-161	142-207	163-253	201-323	260-413	308-501
Internal chucking	Jaw position	J1	26-59	67-105	71-131	99-182	102-213	120-272	166-360
		J2	57-91	93-132	99-159	-	-	-	-
		J3	89-123	135-174	154-214	178-261	207-319	260-412	306-500

Jaw dimensions DURO-T

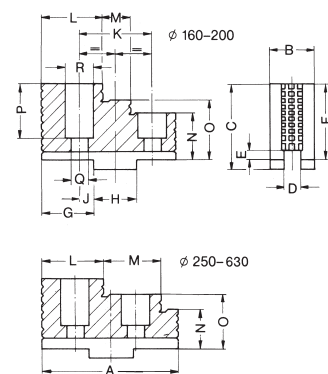
Reversible one-piece jaw **EB**, hardened and ground, jaw steps not ground



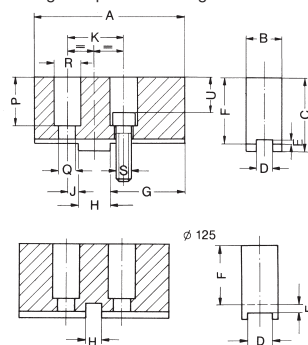
Block jaw **BL**, unstepped, soft, thread and jaw guides hardened and ground



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

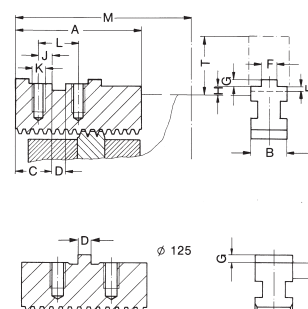


Unstepped soft top jaw **AB**, for turning out special chucking diameters



Dimensions for extendend design

Base jaws **GB**, hardened and 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

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

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

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

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	399
Jaw approx. kg	0,200	0,265	0,365	0,700	1,065	2,350	5,665

¹⁾ Dimension marked on base jaw