

# Duro-M - 3-Backen, Inside and outside jaws, Cylindrical center mount (DIN 6350, Form A)

## APPLICATION

Conventional clamping horizontal and vertical turning machines, as well as milling machines, rotary tables and dividing attachments. Predominantly for use in single or small batch production or in repair shops.  
Clamping of rotationally symmetrical parts for turning and milling

## TYPE

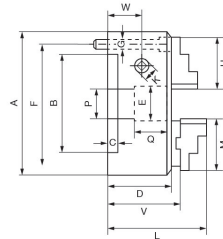
The Duro-A is a manually geared scroll chuck with through hole. that can be clamped automatically (hydraulically) by a CNC machine. It is mainly used for turning cylindrical and disc-shaped blanks.

## CUSTOMER BENEFITS

- ⊕ High concentricity up to 0.02
- ⊕ Jaws with gunmetal finish
- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant

## TECHNICAL FEATURES

- Chuck body (and all other components) made of steel
- ENG Zentrisch spannend über Planspirale
- ENG Planspirale im Gesenk geschmiedet und hochvergütet, Gewindeflanken beidseitig geschliffen
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- The maximum permissible speed has been fixed so that 1/3 of the gripping force is available as residual gripping force if the maximum gripping is applied on 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.
- Clamping force to DIN 6350: The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece. The specified gripping forces are approximate values. They apply to chucks in a perfect condition which have been lubricated with RöhM F80 grease.
- Scope of supply: chuck, operating key, jaws



A09 300 600

Size	74	80	100	125	160	200	250	315	400	500	630	140
A [mm] Außendurchmesser	74	80	100	125	160	200	250	315	400	500	630	140
B Aufnahme	56	56	70	95	125	160	200	260	330	420	545	105
D [mm] - Futterhöhe	32.5	39.5	50	56	65	73.5	82	95	105	120	135	60
E [mm] Durchgang (max)	15	19	20	32	42	55	76	103	136	190	240	40
F [mm]	63	67	83	108	140	176	224	286	362	458	586	120
G Gewinde Befestigungsschrauben	3xM6	3xM6	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	6xM16	6xM16	3xM8
H [mm] Länge Bohr- und Drehbacke	32	37	48	52	61	69	90	130	130	190	190	61
J [mm] Höhe Backe	14	14	18	22.5	26	32.5	40	46	43	54.5	54.5	22.5
K [mm] Größe Futterschlüssel	6 (6-kant)	6	8	9	10	11	12	14	17	19	19	9
Betätigung (Drehmomentschlüssel) [Nm]	30	30	60	80	110	140	150	180	240	260	280	90
Spannkraft [kN] max. gesamt	11	13	27	31	47	55	63	69	92	100	105	40
Drehzahl [min-1], max. zul.	7000	7000	6300	5500	4600	4000	3000	2300	1800	1300	850	5000
Item no.	185299 ▲	185300	185301	185302 ▲	185303	185304	185305	185306 ▲	185307 ▲	185308 ▲	185309 ▲	185585 ▲