

Duro-M - 2-Backen, Inside and outside jaws, Cylindrical center mount, mounting from front, (DIN 6350 modified)

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 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.
- 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

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Size	125	160	200	250	315	400
A [mm] Außendurchmesser	125	160	200	250	315	400
B Aufnahme	95	125	160	200	260	330
D [mm] - Futterhöhe	56	65	73.5	82	95	105
E [mm] Durchgang (max)	32	42	55	76	103	136
F [mm]	108	140	176	224	286	362
H [mm] Länge Bohr- und Drehbacke	52	61	69	90	130	130
J [mm] Höhe Backe	22.5	26	32.5	40	46	43
K [mm] Größe Futterschlüssel	9	10	11	12	14	17
Betätigung (Drehmomentschlüssel) [Nm]	50	70	90	100	120	160
Spannkraft [kN] max, gesamt	19	29	35	42	46	60
Drehzahl [min-1], max. zul.	2400	2200	1800	1500	1200	950
Item no.	185594 ▲	185595 ▲	185596 ▲	185597 ▲	185598 ▲	185599 ▲