Duro-M - 3-Backen, Inside and outside jaws, Camlock (ISO 702-2/DIN 55029)

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

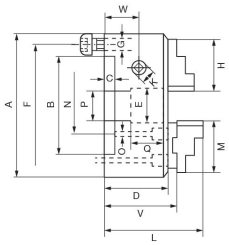
The Duro-A is a manually geared scroll chuck with through hole. that can be clamped automatically (hydraulically) by a CNC machine. It is mainly used for turning cylindrical and disc-shaped blanks.

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 ist ill available as residual gripping force if the maximum gripping is applied an 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 approximnate values. They apply to chucks in a perfect conditiion which have been lubricated with Röhm F80 grease.
- Scope of supply: chuck, operating key, jaws



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Size	125	125	160	160	200	200	250	250	315	315	315	400	400	500	500	500	630	630
Kurzkegel	3	4	4	5	5	6	6	8	6	8	11	8	11	8	11	15	11	15
A [mm] Außendurchmesser	125	125	160	160	200	200	250	250	315	315	315	400	400	500	500	500	630	630
B Aufnahme	53,9	63,5	63,5	82,5	82,5	106,4	106,4	139,7	106,4	139,7	196,9	139,7	196,6	139,7	196,9	285,8	196,9	285,8
D [mm] - Futterhöhe	69	69	66	66	74.5	74.5	83	83	96	96	104	106	106	122	122	122	137	137
E [mm] Durchgang (max)	32	32	42	42	55	55	76	76	103	103	103	136	136	136	190	190	192.7	240
F [mm]	75	85	85	104,8	104,8	133,4	133,4	171,4	133,4	171,4	235	171,4	235	171,4	235	330,2	235	330,2
H [mm] Länge Bohr- und Drehbacke	52	52	61	61	69	69	90	90	130	130	130	130	130	190	190	190	190	190
J [mm] Höhe Backe	22.5	22.5	26	26	32.5	32.5	40	40	46	46	46	43	43	54.5	54.5	54.5	54.5	54.5
K [mm] Größe Futterschlüssel	9	9	10	10	11	11	12	12	14	14	14	17	17	19	19	19	19	19
Betätigung (Drehmomentschlüssel) [Nm]	80	80	110	110	140	140	150	150	180	180	180	240	240	260	260	260	280	280
Spannkraft [kN) max, gesamt	31	31	47	47	55	55	63	63	69	69	69	92	92	100	100	100	105	105
Drehzahl [min-1], max. zul.	5500	5500	4600	4600	4000	4000	3000	3000	2300	2300	2300	1800	1800	1300	1300	1300	850	850
Item no.	185432	185433	185434	185435	185436	185437	185438	185439	185440	185441	185442	185443	185444	185445	185446	185447	185448	185449