

# Duro-M - 4-Jaws, drilling and turning 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

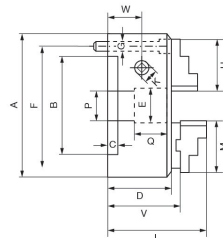
The Duro-M is a manually geared scroll chuck with through-hole, drilling and turning jaws with cylindrical mount. It is mainly used on conventional turning machines for machining turned parts.

## CUSTOMER BENEFITS

- ⊕ High concentricity up to 0.02 mm
- ⊕ 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
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered, the thread flanks are ground on both sides.
- 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 still 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. The DURO-M chucks are available as 2-, 3- and 4-jaw chucks up to and including Ø315mm size with the machined scallops. All 4-jaw chucks with front mounting have no scallops. All 6-jaw chucks also have no scallops.



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Size	80	100	125	160	200	250	315	400	500	630
A [mm] outer diameter	80	100	125	160	200	250	315	400	500	630
B Spindle mount	56	70	95	125	160	200	260	330	420	545
D [mm] Chuck height	39.5	50	56	65	73.5	82	95	105	120	135
E [mm] Bore (max.)	19	20	32	42	55	76	103	136	190	240
F [mm] Diameter pitch circle fixing screw	67	83	108	140	176	224	286	362	458	586
G Thread mounting screws	3xM6	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	6xM16	6xM16
H [mm] Length inside and outside jaw	37	48	52	61	69	90	130	130	190	190
J [mm] Height jaw	14	18	22.5	26	32.5	40	46	43	54.5	54.5
K [mm] Size chuck key	6	8	9	10	11	12	14	17	19	19
Actuation (torque wrench) [Nm]	30	60	80	110	140	150	180	240	260	280
Clamping force [kN] max., total	13	27	31	47	55	63	69	92	100	105
Speed [min-1], max. perm.	7000	6300	5500	4600	4000	3000	2300	1800	1300	850
Item no.	185323	185324	185325	185326	185327	185328	185329	185330	185331	185332