

Duro-M - 4-Backen, Base and top 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 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.
- 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	160	200	200	250	250	315	315	315	400	400	500	500	630	630
Kurzkegel	4	4	5	5	6	6	8	6	8	11	8	11	11	15	11	15
A [mm] Außendurchmesser	125	160	160	200	200	250	250	315	315	315	400	400	500	500	630	630
B Aufnahme	63,5	63,5	82,5	82,5	106,4	106,4	139,7	106,4	139,7	196,9	139,7	196,6	196,9	285,8	196,9	285,8
D [mm] - Futterhöhe	69	66	66	74,5	74,5	83	83	96	96	104	106	106	122	122	137	137
E [mm] Durchgang (max)	32	42	42	55	55	76	76	103	103	103	136	136	190	190	192,7	240
F [mm]	85	85	104,8	104,8	133,4	133,4	171,4	133,4	171,4	235	171,4	235	235	330,2	235	330,2
K [mm] Größe Futterschlüssel	9	10	10	11	11	12	12	14	14	14	17	17	19	19	19	19
M [mm] Länge Grundbacke	56	66,7	66,7	79,5	79,5	95	95	109,5	109,5	109,5	127	127	127	127	127	127
Betätigung (Drehmomentschlüssel) [Nm]	80	110	110	140	140	150	150	180	180	180	240	240	260	260	280	280
Spannkraft [kN] max, gesamt	31	47	47	55	55	63	63	69	69	69	92	92	100	100	105	105
Drehzahl [min ⁻¹], max. zul.	5500	4600	4600	4000	4000	3000	3000	2300	2300	2300	1800	1800	1300	1300	850	850
Item no.	185484	185485	185486	185487	185488	185489	185490	185491	185492	185493	185494	185495	185496	185497	185498	185499