

Duro-M - 2-jaws, base and unstepped top 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 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. 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	100	125	160	200	250	315	400
A [mm] outer diameter	100	125	160	200	250	315	400
B Spindle mount	70	95	125	160	200	260	330
D [mm] Chuck height	50	56	65	73.5	82	95	105
E [mm] Bore (max.)	20	32	42	55	76	103	136
F [mm] Diameter pitch circle fixing screw	83	108	140	176	224	286	362
G Thread mounting screws	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16
H [mm] Length inside and outside jaw	48	52	61	69	90	130	130
J [mm] Height jaw	18	22.5	26	32.5	40	46	43
K [mm] Size chuck key	8	9	10	11	12	14	17
Actuation (torque wrench) [Nm]	40	50	70	90	100	120	160
Clamping force [kN] max., total	18	19	29	35	42	46	60
Speed [min-1], max. perm.	2700	2400	2200	1800	1500	1200	950
Item no.	185587	185588	185589	185590	185591	185592	185593