

# Duro-M - 3-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

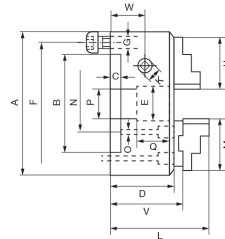
The Duro-A is a manually geared scroll chuck with through hole. that can be clamped automatically (hydraulically) by a CNC machine. It is mainly used for turning cylindrical and disc-shaped blanks.

## CUSTOMER BENEFITS

- ③ High concentricity up to 0.02
- ③ Jaws with gunmetal finish
- ③ Minimal interference contour
- ③ Optimum force transmission
- ③ 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 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



A09 600

Size	125	160	200	250	315	400	500	630
A [mm] outer diameter	125	160	200	250	315	400	500	630
B Spindle mount	95	125	160	200	260	330	420	545
D [mm] Chuck height	56	65	73.5	82	95	105	120	135
E [mm] Bore (max.)	32	42	55	76	103	136	190	240
F [mm] Diameter pitch circle fixing screw	108	140	176	224	286	362	458	586
H [mm] Length inside and outside jaw	52	61	69	90	130	130	190	190
J [mm] Height jaw	22.5	26	32.5	40	46	43	54.5	54.5
K [mm] Size chuck key	9	10	11	12	14	17	19	19
Actuation (torque wrench) [Nm]	80	110	140	150	180	240	260	280
Clamping force [kN] max., total	31	47	55	63	69	92	100	105
Speed [min-1], max. perm.	5500	4600	4000	3000	2300	1800	1300	850
Item no.	R:14981_80421	R:14981_80406	R:14981_80410▲	R:14981_80407▲	R:14981_80409▲	R:14981_80405▲	R:14981_80391▲	R:14981_80550▲