DURO-M - 3-Jaws, Inside and outside jaws, Short tapper mount, mounting from front (ISO 702-1/DIN 55026)

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

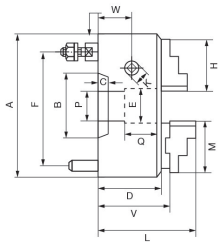
The Duro-M is a manually geared scroll chuck with through-hole, drilling and turning jaws with cylindrical mount. It is mainly used on conventional turning machines for machining turned parts.

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 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. 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.



A09 DURO-M - 3-Jaws, Inside and outside jaws, Short tapper mount, mounting from front (ISO 702-1/DIN 55026)

Size	160 1)1)	200 1)1)	200 1)1)	250	250 1)1)	250 1)1)	315	315 1)1)	400	400 1)1)	500	500	630	630 1)1)
Short taper	5	5	6	5	6	8	6	8	8	11	8	11	11	15
A [mm] outer diameter	160[1)]	200[1)]	200[1)]	250	250[1)]	250[1)]	315	315[1)]	400	400[1)]	500	500	630	630[1)]
B Spindle mount	82,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	139,7	196,9	139,7	196,9	196,9	285,9
D [mm] Chuck height	66	74.5	74.5	83	83	83	96	96	106	106	122	122	137	137
E [mm] Bore (max.)	42	42	55	76	55	76	103	76	136	125	136	190	190	190
F [mm] Diameter pitch circle fixing screw	61,9	61,9	82,6	104,8	82,6	111,1	133,4	111,1	171,4	165,1	171,4	235	235	247,6
H [mm] Length inside and outside jaw	61	69	69	90	90	90	130	130	130	130	190	190	190	190
J [mm] Height jaw	26	32.5	32.5	40	40	40	46	46	43	43	54.5	54.5	54.5	54.5
K [mm] Size chuck key	10	11	11	12	12	12	14	14	17	17	19	19	19	19
Actuation (torque wrench) [Nm]	110	140	140	150	150	150	180	180	240	240	260	260	280	280
Clamping force [kN] max., total	47	55	55	63	63	63	69	69	92	92	100	100	105	105
Speed [min-1], max. perm.	4600	4000	4000	3000	3000	3000	2300	2300	1800	1800	1300	1300	850	850
Item no.	185375	185376	185377	185378	185379	185380	185381	185382	185383	185384	185385	185386	185387	185388

Mounting from front in the inner bolt circle;
3-jaw chuck from size 400 no scallops due to design.