

# Duro-M - 3-Jaws, Base and top jaws, With studs and locknuts (ISO 702-3/DIN 55027)

## 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

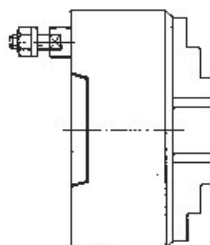
The Duro-M is a manually geared scroll chuck with through-hole, drilling and turning jaws with cylindrical mount. It is mainly used on conventional turning machines for machining turned parts.

## 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	125	160	160	200	200	250	250	315	315	315	400	400	500	500	500	630	630
Short taper	3	3	4	4	5	5	6	6	8	6	8	11	8	11	8	11	15	11	15
A [mm] outer diameter	100	125	125	160	160	200	200	250	250	315	315	315	400	400	500	500	500	630	630
B Spindle mount	53,9	53,9	63,5	63,5	82,5	82,5	106,4	106,4	139,7	106,4	139,7	196,9	139,7	196,6	139,7	196,9	285,8	196,9	285,8
D [mm] Chuck height	75	69	69	66	66	74,5	74,5	83	83	96	96	104	106	106	122	122	122	137	137
E [mm] Bore (max.)	20	32	32	42	42	55	55	76	76	103	103	103	136	136	136	190	190	192,7	240
F [mm] Diameter pitch circle fixing screw	75	75	85	85	104,8	104,8	133,4	133,4	171,4	133,4	171,4	235	171,4	235	171,4	235	330,2	235	330,2
K [mm] Size chuck key	8	9	9	10	10	11	11	12	12	14	14	14	17	17	19	19	19	19	19
M [mm] Base jaw length	47	56	56	66,7	66,7	79,5	79,5	95	95	109,5	109,5	109,5	127	127	127	127	127	127	127
Actuation (torque wrench) [Nm]	60	80	80	110	110	140	140	150	150	180	180	180	240	240	260	260	260	280	280
Clamping force [kN] max., total	27	31	31	47	47	55	55	63	63	69	69	69	92	92	100	100	100	105	105
Speed [min-1], max. perm.	6300	5500	5500	4600	4600	4000	4000	3000	3000	2300	2300	2300	1800	1800	1300	1300	1300	850	850
Item no.	185511	185520	185521	185522	185523	185524	185525	185526	185527	185528	185529	185530	185531	185532	185533	185534	185535	185536	185537