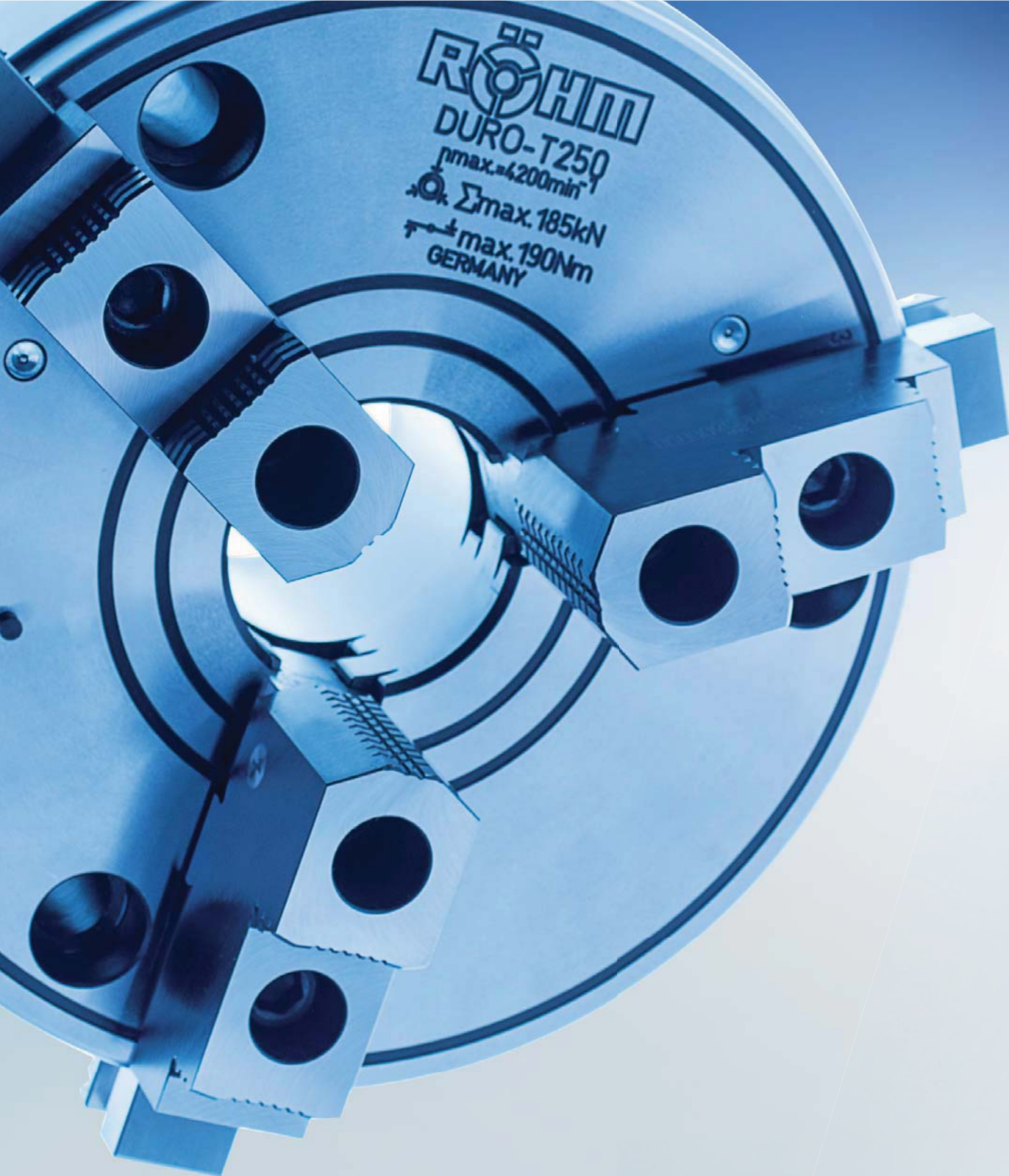




LATHE CHUCKS INDEPENDENT CHUCKS

EDITION 8

RÖHM
driven by technology



RÖHM

DURO-T200

$n_{max} = 600 \text{ min}^{-1}$

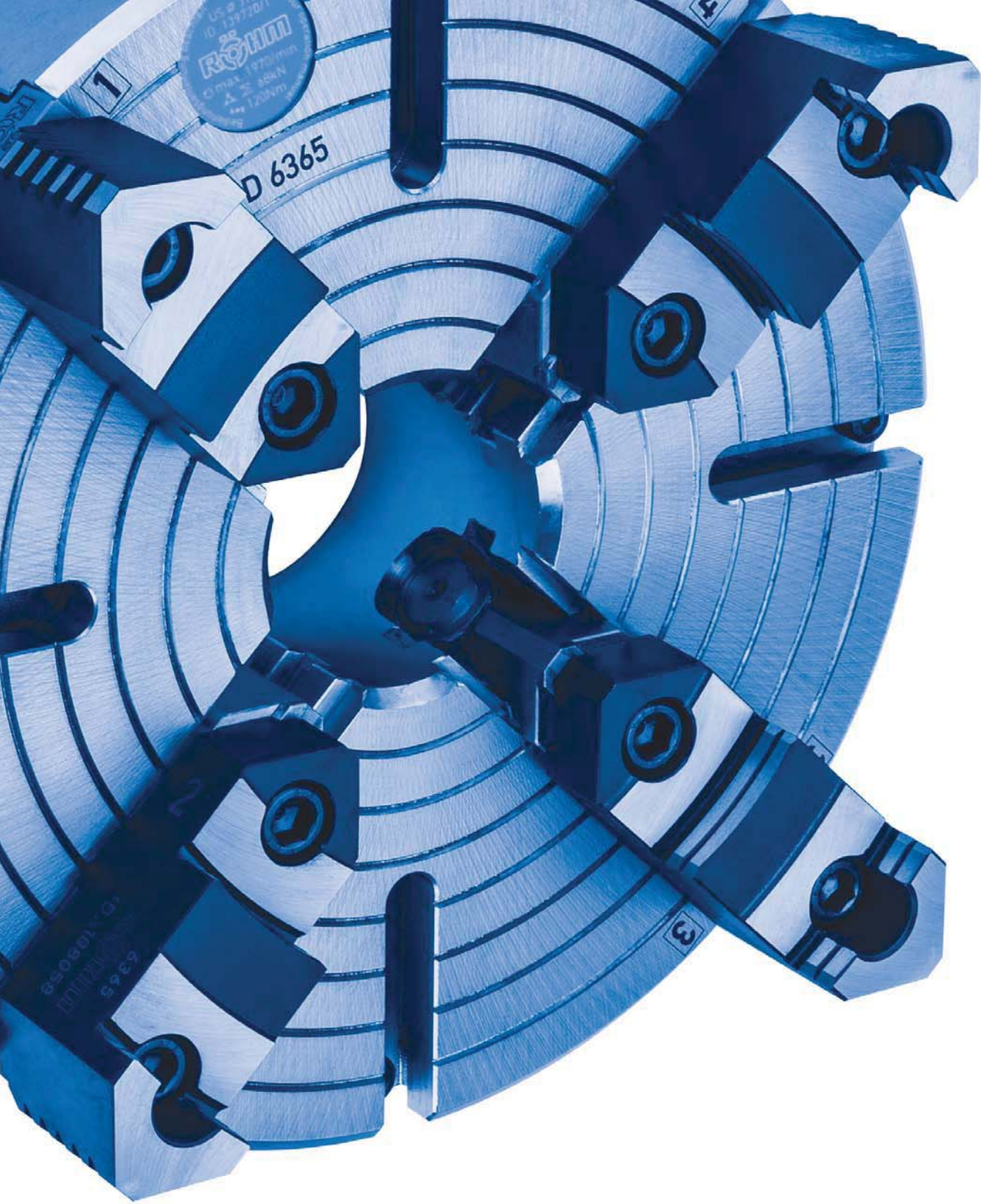
$F_{max} = 11 \text{ kN}$

$T_{max} = 155 \text{ Nm}$

GERMANY

Achtung
Bei Buchsenverstellung
Futter und Anschlag
entlasten
2,5 Drucklasten heben

4/5



JAWS INDIVIDUALLY ADJUSTABLE

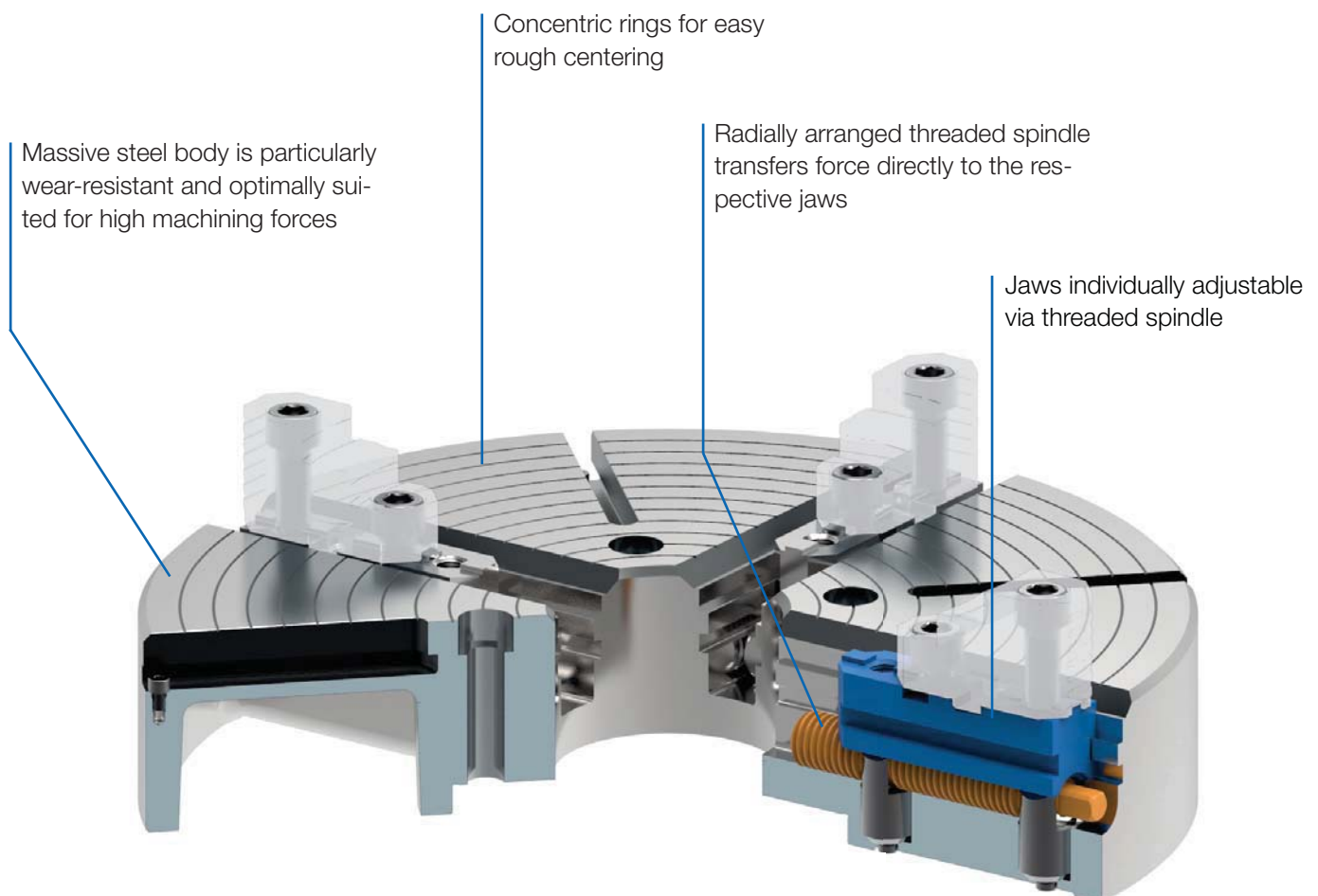
The four jaws can be independently adjusted via the threaded spindle, thereby allowing the safe and secure clamping of irregular, regular, as well as round workpieces.

INDEPENDENT CHUCKS

Independent chucks from RÖHM are particularly successful and effective when force has top priority. Due to the increased rigidity and optimal wear behavior, they are especially suitable for the initial machining of irregular, regular and round workpieces and make high machining forces and a longer machine service life possible.

ADVANTAGES AT A GLANCE

- ③ Safe and easy clamping of irregular, regular, as well as round workpieces by four independently adjustable jaws
- ③ Easy rough centering by means of concentric rings on the chuck body
- ③ Direct force transfer through radially arranged threaded spindles



USE - USU - individually adjustable jaws



APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped.

TYPE

Independent 4-jaw chuck in steel design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 315 with T-slots. Starting from size 1100 with T-slots and set-up slots.

CUSTOMER BENEFITS

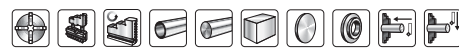
- Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

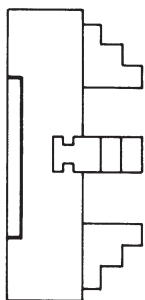
- Steel design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

USE = individually adjustable jaws, steel, one-piece jaws

USU = individually adjustable jaws, steel, reversible top jaws



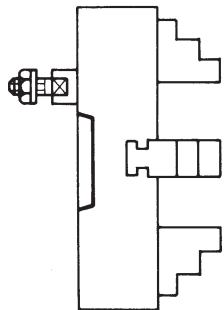
A26
Cylindrical centre mount (without mounting bolts)



Size	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	139781 ▲	137147 ▲	70	2350	120	17
310	139796 ▲	139720 ▲	75	1970	120	17
400	139827 ▲	135368 ▲	95	1530	170	23
450	139842 ▲	136944 ▲	95	1360	170	23
500	139857 ▲	135631 ▲	95	1220	170	23
630	139887 ▲	139723 ▲	135	970	240	37
710	140800 ▲	141097 ▲	135	860	240	37
800	140801 ▲	141106 ▲	190	765	300	45

Further sizes and mountings available on request

A26
ISO 702-3 (DIN 55027), DIN 55022, with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	139782 ▲	137163 ▲	61	2350	120	17
260	5	139783 ▲	137164 ▲	70	2350	120	17
260	6	139784 ▲	137165 ▲	70	2350	120	17
310	5	139797 ▲	139724 ▲	75	1970	120	17
310	6	139798 ▲	139725 ▲	75	1970	120	17
310	8	139799 ▲	139726 ▲	75	1970	120	17
400	6	139828 ▲	135371 ▲	95	1530	170	23
400	8	139829 ▲	135372 ▲	95	1530	170	23
400	11	139830 ▲	135358 ▲	95	1530	170	23
450	6	139843 ▲	136947 ▲	95	1360	170	23
450	8	139844 ▲	136948 ▲	95	1360	170	23
450	11	139845 ▲	136957 ▲	95	1360	170	23
500	6	139858 ▲	135632 ▲	95	1220	170	23
500	8	139859 ▲	135633 ▲	95	1220	170	23
500	11	139860 ▲	135696 ▲	95	1220	170	23
630	8	139888 ▲	139767 ▲	136	970	240	37
630	11	139889 ▲	139768 ▲	136	970	240	37
630	15	139890 ▲	139769 ▲	136	970	240	37
710	8	141088 ▲	141098 ▲	136	860	240	37
710	11	141089 ▲	141099 ▲	136	860	240	37
800	8	141092 ▲	600638 ▲	200	765	300	45
800	11	141093 ▲	141107 ▲	192	765	300	45

Further sizes and mountings available on request

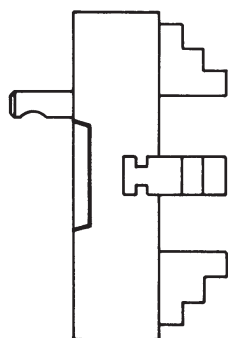
USE - USU - individually adjustable jaws

Size	Mount short taper	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/ jaw kN
800	15	141094 ▲	141108 ▲	192	765	300	45
900	11	-	600639 ▲	190	680	300	45
900	15	-	600641 ▲	190	680	300	45
1000	11	-	141115 ▲	190	610	320	47
1000	15	-	141116 ▲	190	610	320	47
1000	20	-	600645 ▲	190	610	320	47
1100	11	-	150500 ▲	190	555	320	47
1100	15	-	600642 ▲	190	555	320	47
1100	20	-	600646 ▲	190	555	320	47
1200	11	-	150501 ▲	190	510	450	64
1200	15	-	600643 ▲	190	510	450	64
1200	20	-	600647 ▲	190	510	450	64

Further sizes and mountings available on request

A26

ISO 702-2 (DIN 55029), ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/ jaw kN
260	4	139791 ▲	137166 ▲	60	2350	120	17
260	5	139792 ▲	137254 ▲	70	2350	120	17
260	6	139793 ▲	137255 ▲	70	2350	120	17
310	5	139806 ▲	139733 ▲	75	1970	120	17
310	6	139807 ▲	139734 ▲	75	1970	120	17
310	8	139808 ▲	139735 ▲	75	1970	120	17
400	6	139837 ▲	135375 ▲	95	1530	170	23
400	8	139838 ▲	135376 ▲	95	1530	170	23
400	11	139839 ▲	135359 ▲	95	1530	170	23
450	6	139852 ▲	136951 ▲	95	1360	170	23
450	8	139853 ▲	136952 ▲	95	1360	170	23
450	11	139854 ▲	136955 ▲	95	1360	170	23
500	6	139867 ▲	135703 ▲	95	1220	170	23
500	8	139868 ▲	135704 ▲	95	1220	170	23
500	11	139869 ▲	135705 ▲	95	1220	170	23
630	8	139897 ▲	139776 ▲	136	970	240	37
630	11	139898 ▲	139777 ▲	136	970	240	37
630	15	139899 ▲	139778 ▲	136	970	240	37
710	8	140804 ▲	141102 ▲	136	860	240	37
710	11	140805 ▲	141103 ▲	136	860	240	37
710	15	-	141418	136	860	240	37
800	11	140810 ▲	141418 ▲	192	765	300	45
800	15	140811 ▲	141112	192	765	300	45
900	11	-	600660 ▲	190	680	300	45
900	15	-	600661 ▲	190	680	300	45
1000	11	-	141119 ▲	190	610	320	47
1000	15	-	141120 ▲	190	610	320	47
1000	20	-	600665 ▲	190	610	320	47
1100	11	-	150504 ▲	190	555	320	47
1100	15	-	600662 ▲	190	555	320	47
1100	20	-	600666 ▲	190	555	320	47
1200	11	-	150505 ▲	190	510	450	64
1200	15	-	600663 ▲	190	510	450	64
1200	20	-	600667 ▲	190	510	450	64

Further sizes and mountings available on request

Jaws USE - USU

A09

Reversible jaw EB, 4-jaw set, hardened tongue and groove for external and internal clamping, material 16 MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
022985	260	set	85	64	35
022986	310	set	94	66	35
163108 ▲	400/450	set	112	80	40
163109 ▲	500	set	136	88	40
175358 ▲	630/710	set	172	108	45
247823 ▲	800	set	185	130	60

A09

Base jaw GB, 4-jaw set, with fixing screw



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
304656 ▲	260	set	91	40,1	35
304657 ▲	310	set	107	40,1	35
304658 ▲	400/450	set	126	47,1	40
304659 ▲	500	set	164,4	47,1	40
304660 ▲	630	set	165	51,1	45
304661 ▲	710	set	202	51,1	45
304662 ▲	800/900/1000/1100	set	240	61,1	60
150543 ▲	1200	set	350	92,2	70

A09

Reversible top jaws UB DIN 6350, hardened, tongue and groove for external and internal clamping, material 16 MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
108057	260	4	set	95,3	52,5	36
108058	310	4	set	109,5	57,5	42
108059	400/450	4	set	127	64,5	42
108060	500/630/710	4	set	127	79,5	50
105085	800/900	4	set	210	89	68
105101	1000/1100/1200	4	set	210	110	68

Additionally or later applied, hardened stepped jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09

Unstepped top jaw AB DIN 6350, 4-jaw set, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
107579	260	4	set	103	53	36,5
107580	310	4	set	120	58	42,5
107581	400/450	4	set	137	65	42,5
107582	500/630/710	4	set	140	80	50,5
105105	800/900	4	set	210	89	68
105109	1000/1100/1200	4	set	210	110	68

Accessories USE - USU

A26

Adjusting spindle



Item no.	Size	Square	Hexagon
169142 ▲	260	10	-
166565 ▲	310	10	-
162110 ▲	400	13	-
162121 ▲	450	13	-
161629 ▲	500	13	-
161611 ▲	630	16	-
161583 ▲	710	16	-
247826 ▲	800	18	-
150544 ▲	900	18	-
150545 ▲	1000	18	-
150546 ▲	1100	18	-
149776 ▲	1200	-	24

A26

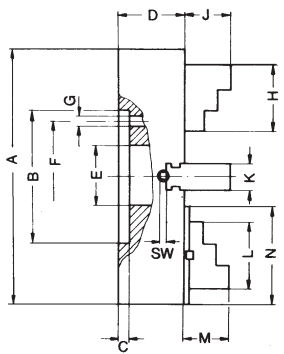
Safety key



Item no.	Size	Square	Hexagon
160096 ▲	260/310	10	-
160097 ▲	400	13	-
160098 ▲	450/500	13	-
160099 ▲	630/710	16	-
160100 ▲	800/900/1000/1100	18	-
150548 ▲	1200	-	24

Chuck dimensions USE - USU

Cylindrical centre mount



Size A	260	310	400	450	500	630	710	800
BH ⁸	130	130	210	210	210	260	260	370
C	8	8	18	18	18	18	18	18
D	USE - USU	85	95	112,5	112,5	112,5	122,5	132,5
E	USE - USU	70	75	95	95	95	135	180
F		105	105	175	175	175	220	330
G		4x13,5	4x13,5	4x17	4x17	4x17	4x20,5	4x20,5
H		85	94	112	112	136	172	185
J		34	35	41,5	42	50	55,5	80
K		35	35	40	40	40	45	60
L		80	87	105	114	126	140	165
M		56,5	60,5	54	54	69	69	91
N		100	105	125	135	145	165	240
SW		10	10	13	13	13	16	18
approx. kg		23	32	52	76	91	150	270

1) Outer hexagon

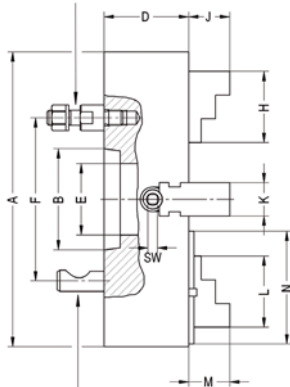
Short taper mount

DIN 55021 with setscrews and locknuts

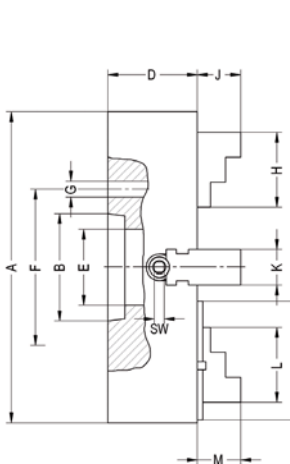


Size A	260			310			400			450			500			630		
Taper size	4 ¹⁾	5 ²⁾	6	5	6	8	6	8	11	6	8	11	6	8	11	8	11	15
B	63,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,9	139,7	196,9	285,8
D		75			82			112,5			112,5			112,5		122,5		
E		61	70	70		75		95			95			95		135		
F	DIN Camlock	85	104,8	133,4	104,8	133,4	171,4	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235	171,4	235
G		11	11	14	11	14	18	14	18	22	14	18	22	14	18	22	18	22
H			85			94		112			112			136			172	
J			34			35		42			42			50			55,5	
K	USE		35			35		40			40			40			45	
L	USU		36			42		42			42			50			50	
M			95,3			109,5		127			127			127			127	
N			56,5			60,5		54			54			69			69	
SW			91			107		126			126			164,4			165	
approx. kg			10			10		13			13			13			16	
			23			32		52			76			91			150	

DIN 55027 with studs and nuts



DIN 55029 with studs for camlock



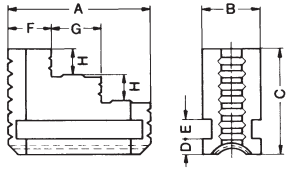
Size A	710			800		
Taper size	8	11	15	8	11	15
B	139,7	196,9	285,8	139,7	196,9	285,8
D		132,5			145	
E		135			180	
F	171,4	235	330,2	171,4	235	330,2
G	18	22	26	18	22	16
H		172			185	
J		55,5			80	
K	USE	45			60	
L	USU	68			68	
M		210			210	
N		69			91	
SW		202			240	
approx. kg		16			18	
		190			270	

DIN 55026 mounting from front

- 1) Not for DIN 55021 or A1/A2 inch
- 2) Not for A1/A2 inch

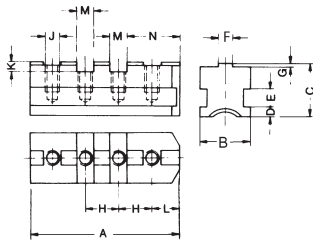
Jaw dimensions USE - USU

Reversible one-piece jaw EB



Size	260	310	400	450	500	630	710	800
A	85	94	112		136	172		185
B	35	35	40		40	45		60
C	64	66	80		88	108		130
D	10	10	10		10	12		14
E	12	12	14		14	14		18
F	27	30	36		42	52		55
G	29	32	38		46	60		65
H	14	15	19		23	26		30
approx. kg	0,8	0,9	1,6		2,25	3,5		4,2

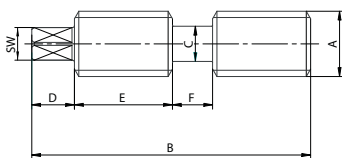
Base jaw GB



Size	260	310	400	450	630	710	800
A	91	107	126		165	202	240
B	35	35	40		45	45	60
C	40,1	40,1	47,1		51,1	51,1	61,1
D	10	10	10		12	12	14
E	12	12	14		14	14	18
F	12,7	12,7	12,7		12,7	12,7	12,7
G	3,1	3,1	3,1		3,1	3,1	3,1
H	54	63,5	76,2		38,1	38,1	38,1
J	M12	M12	M16		M20	M20	M20
K	7,6	7,6	10,8		10,8	10,8	10,8
L	21,2	24,4	27,5		27,5	27,5	27,5
M	19,03	19,03	19,03		19,03	19,03	19,03
N	38,7	46,6	56,1		56,1	56,1	56,1
Grooves	1	1	1		2	3	4
Tapped holes	2	2	2		4	5	6
approx. kg	0,8	0,9	1,1		1,4	2,2	2,8

Reversible top jaw UB and unstepped top jaw

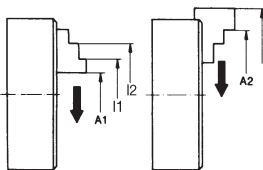
Adjusting spindle



Size	260	310	400	450	500	630	710	800	900	1000	1100	1200
A	26	26	30	30	30	34	34	40	40	40	40	48
B	92	111	145	170	170	215	255	260	310	343	393	425
C	14	14	16	16	16	20	20	22	22	22	22	28
D	14	17	38	38	41	48	48	48	48	48	48	65
E	27,5	39	55	70	62	95	105	127	177	201	251	210
F	16	16	20	20	20	20	20	24	24	24	24	30
SW	10	10	13	13	13	16	16	18	18	18	18	24 ¹⁾

¹⁾With outer hexagon

Chucking capacities of jaw steps (standard values)



Size mm	260	310	400	450	500	630	710	800
A1 min.	20	20	35	40	40	60	130	190
A2 max.	260	295	400	450	500	585	690	800
I1 min.	75	80	90	100	145	145	245	170
I2 max.	260	310	360	450	520	650	730	820
max. swing. dia.	305	355	465	510	610	675	785	870