



## GEARED SCROLL CHUCKS

The RÖHM geared scroll chucks have proven themselves a thousand times over and have already been used successfully on lathes, rotary tables and dividing attachments for decades. The jaws can be adjusted over the entire clamping range in order to be able to very quickly clamp workpieces with a wide clamping diameter range without offsetting the jaws.

### ADVANTAGE AT A GLANCE

- ⊕ Quick jaw adjustment over the entire clamping range
- ⊕ Proven chuck with optimal price/performance ratio
- ⊕ Protection of the machine spindle by means of splash-water edge

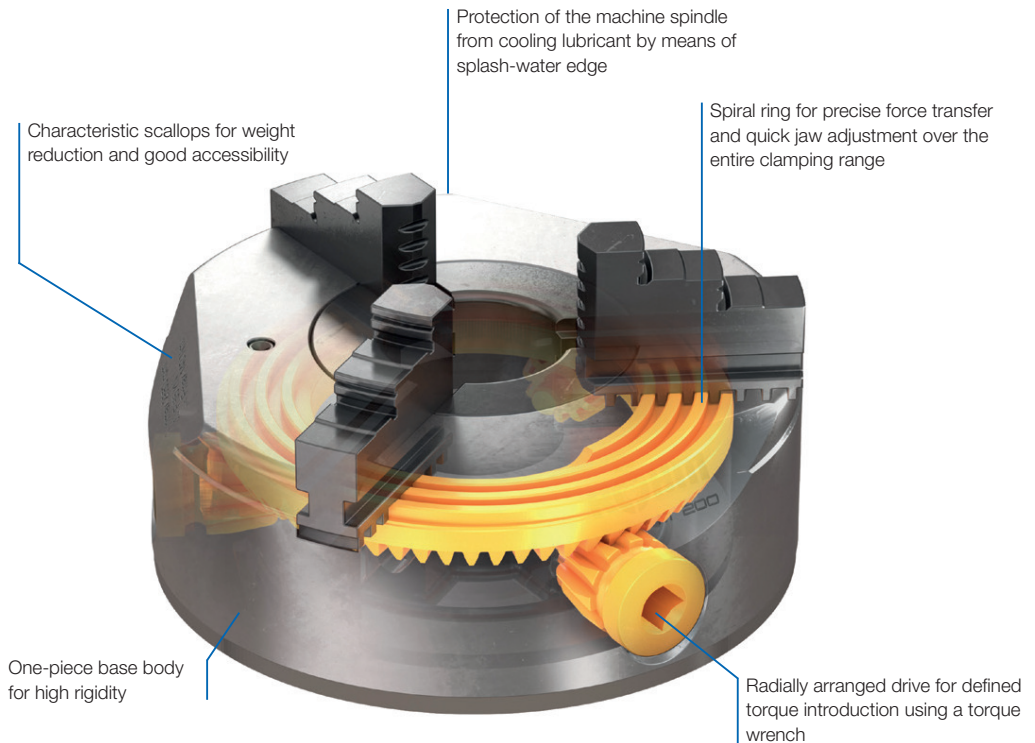
Geared scroll chucks

### PROVEN CHUCK WITH SPIRAL RING

The RÖHM geared scroll chucks have already been in use for decades and have proven themselves a thousand times over. The jaws can be quickly adjusted over the entire clamping range by means of the spiral ring. Using the radially arranged drive, the force is transferred to the hardened spiral ring via a bevel gearing and further conducted to the clamping jaws via the spiral.

And we are now continuing to write this story: with the new DURO-M scroll chuck - Made in Germany. It carries the genes of its predecessors and inherits their most important properties, such as durability, precise power transmission and fast jaw adjustment over the entire clamping range.

The most significant change: the characteristic scallops. They not only look good, but also have tangible benefits such as weight reduction and good accessibility. In addition, the DURO-M impresses with optimized power transmission and high rigidity. Due to the wide range of diameters, the DURO-M can be used on all common spindle interfaces and is thus designed for long-term and durable use.



# DURO-M - centric clamping



### 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 scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

### CUSTOMER BENEFITS

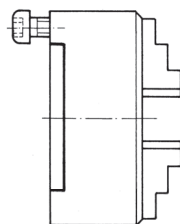
- ⊕ Jaws with gunmetal finish
- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant

### TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- Scope of delivery: chuck, chuck key, jaws



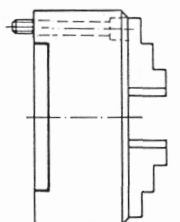
A09  
DIN 6350, cylindrical centre mount, form A



Size	ZA	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
74	56	15	185299	-	-	-	7000	30	11
80	56	19	185300	185323	-	-	7000	30	13
100	70	20	185301	185324	185310	185333	6300	60	27
125	95	32	185302	185325	185311	185334	5500	80	31
140	105	40	185585	-	-	-	5000	90	40
160	125	42	185303	185326	185312	185335	4600	110	47
200	160	55	185304	185327	185313	185336	4000	140	55
250	200	76	185305	185328	185314	185337	3000	150	63
315	260	103	185306	185329	185315	185338	2300	180	69
400	330	136	185307	185330	185316	185339	1800	240	92
500	420	190	185308	185331	185317	185340	1300	260	100
630	545	240	185309	185332	185318	185341	850	280	105
700	610	310	-	-	185319	185342	800	280	105
800	710	380	-	-	185320	185343	700	300	110
1000	910	460	-	-	185321	185344	560	450	115
1250	910	550	-	-	185322	185345	450	450	115

Further sizes and mountings available on request  
From size 400 no scallops due to design

A09  
Mounting from front, DIN 6350, cylindrical centre mount

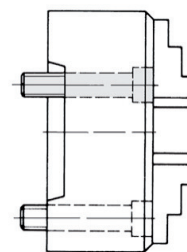


Size	ZA	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	95	32	185359	185367	5500	80	31
160	125	42	185360	185368	4600	110	47
200	160	55	185361	185369	4000	140	55
250	200	76	185362	185370	3000	150	63
315	260	103	185363	185371	2300	180	69
400	330	136	185364	185372	1800	240	92
500	420	190	185365	185373	1300	260	100
630	545	240	185366	185374	850	280	105

Further sizes and mountings available on request  
3-jaw chuck from size 400 no scallops due to design  
4-jaw chuck with mounting from front no scallops due to design

# DURO-M - centric clamping

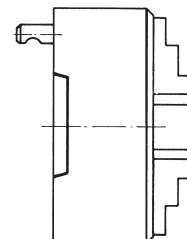
A09  
ISO 702-1 (DIN 55026), DIN 55021, ASA B 5.9, A1/A2 metr.; mounting from front



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	5	42	185375	185402	185389	185417	4600	110	47
200	5	42	185376	185403	185390	185418	4000	140	55
200	6	55	185377	185404	185391	185419	4000	140	55
250	5	76	185378	185405	185392	185420	3000	150	63
250	6	55	185379	185406	185393	185421	3000	150	63
250	8	76	185380	185407	185394	185422	3000	150	63
315	6	103	185381	185408	185395	185423	2300	180	69
315	8	76	185382	185409	185396	185424	2300	180	69
400	8	136	185383	185412	185397	185427	1800	240	92
400	11	125	185384	185413	185398	185428	1800	240	92
500	8	136	185385	-	-	-	1300	260	100
500	11	190	185386	185414	185399	185429	1300	260	100
630	11	190	185387	185415	185400	185430	850	280	105
630	15	190	185388	185416	185401	185431	850	280	105

1) Mounting from front in the inner bolt circle  
3-jaw chuck from size 400 no scallops due to design. 4-jaw chuck with mounting from front no scallops due to design.

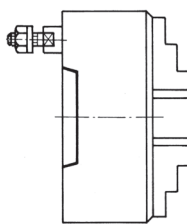
A09  
ISO 702-2 (DIN 55029), ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	3	32	185432	-	185450	-	5500	80	31
125	4	32	185433	185468	185451	185484	5500	80	31
160	4	42	185434	185469	185452	185485	4600	110	47
160	5	42	185435	185470	185453	185486	4600	110	47
200	5	55	185436	185471	185454	185487	4000	140	55
200	6	55	185437	185472	185455	185488	4000	140	55
250	6	76	185438	185473	185456	185489	3000	150	63
250	8	76	185439	185474	185457	185490	3000	150	63
315	6	103	185440	185475	185458	185491	2300	180	69
315	8	103	185441	185476	185459	185492	2300	180	69
315	11	103	185442	185477	185460	185493	2300	180	69
400	8	136	185443	185478	185461	185494	1800	240	92
400	11	136	185444	185479	185462	185495	1800	240	92
500	8	136	185445	-	185463	-	1300	260	100
500	11	190	185446	185480	185464	185496	1300	260	100
500	15	190	185447	185481	185465	185497	1300	260	100
630	11	192,7	185448	185482	185466	185498	850	280	105
630	15	240	185449	185483	185467	185499	850	280	105

Further sizes and mountings available on request  
From size 400 no scallops due to design

A09  
ISO 702-3 (DIN 55027), with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
100	3	20	185500	-	185519	-	6300	60	27
125	3	32	185501	-	185520	-	5500	80	31
125	4	32	185502	185538	185521	185554	5500	80	31
160	4	42	185503	185539	185522	185555	4600	110	47
160	5	42	185504	185540	185523	185556	4600	110	47
200	5	55	185505	185541	185524	185557	4000	140	55
200	6	55	185506	185542	185525	185558	4000	140	55
250	6	76	185507	185543	185526	185559	3000	150	63
250	8	76	185508	185544	185527	185560	3000	150	63
315	6	103	185509	185545	185528	185561	2300	180	69
315	8	103	185510	185546	185529	185562	2300	180	69
315	11	103	185511	185547	185530	185563	2300	180	69
400	8	136	185512	185548	185531	185564	1800	240	92
400	11	136	185513	185549	185532	185565	1800	240	92
500	8	136	185514	-	185533	-	1300	260	100
500	11	190	185515	185550	185534	185566	1300	260	100
500	15	190	185516	185551	185535	185567	1300	260	100
630	11	192,7	185517	185552	185536	185568	850	280	105
630	15	240	185518	185553	185537	185569	850	280	105

Further sizes and mountings available on request  
From size 400 no scallops due to design

# DURO-M - centric clamping

### 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

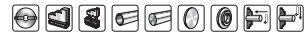
The DURO-M is a manually scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

### CUSTOMER BENEFITS

- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant
- ⊕ Control edge

### TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- Scope of delivery: chuck, chuck key, jaws

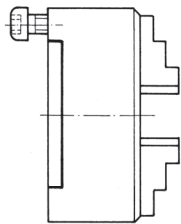


Geared scroll chucks  
DURO-M

A09  
DIN 6350, cylindrical centre mount, form A

Size	ZA	Through-hole mm	2-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
100	70	20	185587	2700	40	18
125	95	32	185588	2400	50	19
160	125	42	185589	2200	70	29
200	160	55	185590	1800	90	35
250	200	76	185591	1500	100	42
315	260	103	185592	1200	120	46
400	330	136	185593	950	160	60

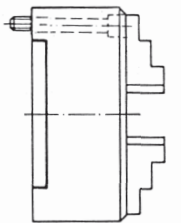
Further sizes and mountings available on request  
From size 400 no scallops due to design



A09  
Mounting from front, DIN 6350, cylindrical centre mount

Size	ZA	Through-hole mm	2-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	95	32	185594	2400	50	19
160	125	42	185595	2200	70	29
200	160	55	185596	1800	90	35
250	200	76	185597	1500	100	42
315	260	103	185598	1200	120	46
400	330	136	185599	950	160	60

Further sizes and mountings available on request  
From size 400 no scallops due to design



# DURO-M - centric clamping

### 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

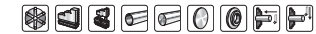
The DURO-M is a manually scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

### CUSTOMER BENEFITS

- ⊕ Spannbacken grundsätzlich brüniert
- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant
- ⊕ Control edge

### TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- Scope of delivery: chuck, chuck key, jaws

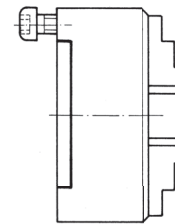


Geared scroll chucks  
DURO-M

A09  
DIN 6350, cylindrical centre mount, form A

Size	ZA	Through-hole mm	6-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	125	42	185347	4600	110	47
200	160	55	185348	4000	140	55
250	200	76	185349	3000	150	63
315	260	103	185350	2300	180	69
400	330	136	185351	1800	240	92

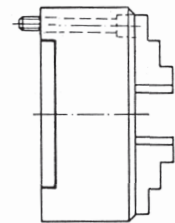
Further sizes and mountings available on request



A09  
Mounting from front, DIN 6350, cylindrical centre mount

Size	ZA	Through-hole mm	6-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	125	42	185600	4600	110	47
200	160	55	185601	4000	140	55
250	200	76	185602	3000	150	63
315	260	103	185603	2300	180	69
400	330	136	185604	1800	240	92

Further sizes and mountings available on request



# Jaws DURO-M

A09  
Inside jaw BB, DIN 6350, outward stepped jaw, hardened



Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
74	-	110154	-	-	32	23	10
80	-	110155	110063	-	37	26	12
100	-	110156	110064	-	48	33,5	14
125	-	110157	110065	-	52	41,5	18
140	-	110158	110066	-	61	41,5	18
160	-	110159	110067	150633	61	47,5	18
200	-	110160	110068	150634	69	53,5	20
250	-	110161	110069	150635	90	67,5	24
315	-	110162	110070	150636	130	79,5	34
350/400	-	110163	110071	150637	130	79,5	34
500/630	-	110164	110072	-	190	95	42

Additionally or later applied, hardened stepped jaws must be ground out in the chuck.  
For jaws which are applied later, send in the chuck.  
1) Reversible, can be used as outside and inside jaws.

A09  
Outside jaw DB, DIN 6350, inward stepped jaw, hardened



Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
80	-	110165	110073	-	37	26	12
100	-	110166	110074	-	48	33,5	14
125	-	110167	110075	-	52	41,5	18
140	-	110168	110076	-	61	41,5	18
160	-	110169	110077	150640	61	47,5	18
200	-	110170	110078	150641	69	53,5	20
250	-	110171	110079	150642	90	67,5	24
315	-	110016	110080	150643	130	79,5	34
350/400	-	110017	110081	150644	130	79,5	34
500/630	-	110018	110082	-	190	95	42

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 jaw BL, DIN 6350, unstepped, soft, material 16MnCr5

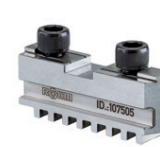


Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
74	-	109114	149304	-	32	23	10
80	-	107588	107598	-	37	26	12
100	-	107589	107599	-	48	33,5	14
125	-	107590	107600	-	52	41,5	18
140	-	107591	107601	-	61	41,5	18
160	-	107592	107602	150647	61	47,5	18
200	-	107593	107603	147218	69	53,5	20
250	-	107594	107604	147181	90	67,5	24
315	-	107595	107605	147361	130	79,5	34
350/400	-	107596	107644	151398	130	79,5	34
500/630	-	107597	107645	-	190	95	42

1) Reversible, can be used as outside DB and inside BB jaws.

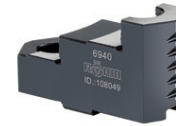
# Jaws DURO-M

A09  
Base jaw GB, DIN 6350, with fixing screw



Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw width mm
100	108950	107500	107542	-	46	14
125	108951	107501	107543	-	55	18
140	108952	107502	107544	-	65	18
160	108953	107503	107545	150650	65	18
200	108954	107504	107546	150651	78	20
250	108955	107505	107547	150652	92	24
315	108956	107506	107548	150653	108	34
350/400	108957	107507	107549	150654	127	34
500	-	107508	107550	-	165	42
630	-	107509	107551	-	203	42
800	-	105272	141616	-	291	55
1000	-	105274	141611	-	329	55
1250	-	105275	141614	-	367	55

A09  
Reversible top jaws UB, DIN 6350, hardened tongue and groove for external and internal clamping, material 16 MnCr5



Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
100	-	108045	108053	-	47	29,5	22
125	-	108046	108054	-	56	37,5	26
140/160	-	107936	107938	163832	66,7	41,5	28
200	-	107937	107939	186330	79,5	42,5	30
250	-	108049	108057	153324	95,3	52,5	36
315	-	108050	108058	148771	109,5	57,5	42
350/400	-	108051	108059	153319	127	64,5	42
500/630	-	108052	108060	-	127	79,5	50
800	-	105081	105085	-	210	89	68
1000/1250	-	105098	105101	-	210	110	68

Additionally or later applied hardened 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, soft, material 16MnCr5



Chuck Size	2-jaw set	3-jaw set	4-jaw set	6-jaw set	Jaw length mm	Jaw height mm	Jaw width mm
100	109497	107633	107641	-	53	30	22,5
125	109498	107634	107642	-	62	38	26,5
140/160	109499	108581	108583	186331	74	42	28,5
200	109501	108582	108584	10015381	87	43	30,5
250	109502	107637	107579	186332	103	53	36,5
315	109503	107638	107580	10013705	120	58	42,5
350	-	107639	107581	-	137	65	42,5
400	109504	107639	107581	186333	137	65	42,5
500/630	-	107640	107582	-	140	80	50,5
800	-	105103	105105	-	210	89	68
1000/1250	-	105107	105109	-	210	110	68

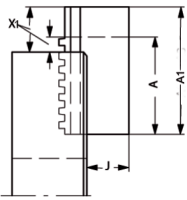
# Jaws DURO-M

A09

Unstepped jaw BL, special length, soft, material 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	A1 mm	X1 max. mm	A mm	J mm	X max. mm
200	130031	137073	100	50	69	32,5	19
250	132658	137074	120	56	90	41	26
315	132184	129894	160	70	130	46	40
350/400	137075	130442	160	70	130	42	40
500/630	131540	137079	220	80	190	55	50
200	130033	137077	120	70	69	32,5	19
250	128880	130610	140	76	90	41	26
315	118908	137078	200	110	130	46	40
350/400	137079	137080	200	110	130	42	40
500/630	137081	137082	280	140	190	55	50
315	121367	133691	250	160	130	46	40
350/400	137087	137088	250	160	130	42	40

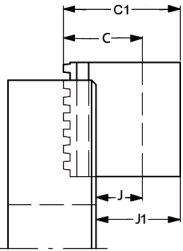


A09

Unstepped jaw BL, special height, soft, material 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	J1 mm	C mm	J mm
200	125710	132972	80	58,5	54	32,5
250	122188	134796	100	73	68	41
315	132186	137091	110	76	80	46
350/400	137092	131655	110	72	80	42
500/630	137093	137094	150	110	95	55
200	125712	137095	120	98,5	54	32,5
250	122189	130630	130	103	68	41
315	137096	137097	140	106	80	46
350/400	137098	137099	140	102	80	42
500/630	125117	137100	200	160	95	55
200	125714	137101	150	128,5	54	32,5
250	137102	137103	150	123	68	41
315	137104	130340	160	126	80	46
350/400	132879	110109	160	122	80	42



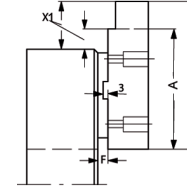
# Jaws DURO-M

A09

Top jaw AB, special length, soft, material 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	A1 mm	X1 max. mm	F mm	A mm	X max. mm
200	110086	148139	100	43	6,8	87	30
250	112122	129289	130	63	8	103	36
315	110624	143764	160	76	5,5	120	36
350/400	110626	141277	160	53	8,5	137	30
500/630	103014	103393	170	75	8,5	140	45
200	112120	148657	120	63	6,8	87	30
250	125428	128700	150	83	8	103	36
315	112091	147754	200	116	5,5	120	36
350/400	112118	141263	200	93	8,5	137	30
500/630	110632	148234	220	125	8,5	140	45
250	104710	146013	180	113	8	103	36
315	112089	147860	250	166	5,5	120	36
350/400	103654	149974	260	153	8,5	137	30
500/630	112127	148235	280	185	8,5	140	45

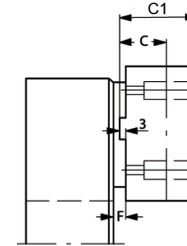


A09

Top jaw AB, special height, soft, material 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	C1 mm	C mm	F mm
200	132155	132181	60	43	6,8
250	119645	135867	70	53	8
315	110435	149975	80	58	5,5
350/400	126385	118373	90	65	8,5
500/630	128590	149985	100	80	8,5
200	128564	149976	80	43	6,8
250	128571	134999	100	53	8
315	110437	129691	110	58	5,5
350/400	110628	135426	120	65	8,5
500/630	110630	149977	130	80	8,5
250	128573	149978	150	53	8
315	128569	141671	150	58	5,5
350/400	128567	139591	160	65	8,5
500/630	128588	140427	160	80	8,5

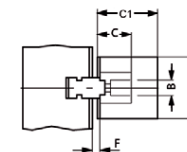


A09

Top jaw AB, special width and height, soft, material 16MnCr5, DIN 6350



Chuck Size	3-jaw set	4-jaw set	B1 mm	C1 mm	B mm	C mm
200	105057	105061	40	70	30,5	43
250	137090	141338	50	80	36,5	53
315	143063	149979	60	90	42	58
350/400	131567	149980	60	90	42,5	65
500/630	137064	149981	80	110	50,5	80
200	133259	149982	50	80	30,5	43
250	133653	137526	60	90	36,5	53
315	143057	149983	80	110	42	58
350/400	137086	149984	80	110	42,5	65



# Jaws DURO-M

C15  
Mounting bolt for top jaws, bolt 1



Item no.	Size	Thread	Contents of delivery
249299	100	M8x20	Stück
236949	125	M8x25	Stück
334571	160/200	M8x30	Stück
233025	250	M12x40	Stück
233026	315	M12x45	Stück
220565	350/400	M16x50	Stück
249003	500/630	M20x80	Stück

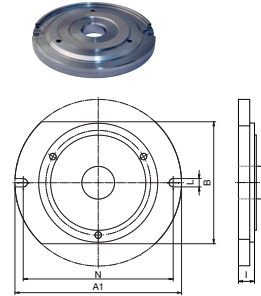
C15  
Mounting bolt for top jaws, bolt 2



Item no.	Size	Thread	Contents of delivery
216528	100	M6x16	Stück
233058	125/160/200	M8x20	Stück
227692	250	M12x25	Stück
233030	315	M12x30	Stück
220564	350/400	M16x35	Stück
233047	500/630	M20x40	Stück

# Accessories DURO-M

A09 Base plates for lathe chucks with cylindrical centre mount, DIN 63500



Item no.	Size	A1 mm	B mm	L mm	N mm	E mm	I mm
162793	160	240	-	14	212	42	27
162401	200	280	-	14	252	55	27
163036	250	330	-	18	303	76	27
133705	315	386	320	18	354	103	27
133706	400	470	405	18	438	136	27

A09 Special grease F80 for lathe chucks  
For lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge (DIN 1284) Ø 53.5x235mm	0,5 kg
028975	Tin	1 kg

A09 Chip guard, piece



Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/400	piece
108508	500/630	piece

C15 Grease gun DIN1283



Item no.	Connection	Contents of delivery
329093	M10x1	150 mm nozzle tube bent, needlepoint mouthpiece, top mouthpiece, 300 mm high pressure hose with 4 jaw hydraulics cross mouthpiece

A09 Scroll



Item no.	Size
102521	74
102183	80/85
101754	100
112660	110
101721	125
105827	140
100303	160
100003	200
100203	250
101552	315
105228	350
102497	400
162973	500
162964	630

A09 Driving pinion



Item no.	Size	Square
102522	74	6
102184	80	6
113198	85	6
101755	100	8
112662	110	8
101722	125	9
105828	140	9
100304	160	10
100005	200	11
100204	250	12
112267	270	12
101553	315	14
105229	350	14
102498	400	17
162974	500	19
162965	630	19

A09 Pinion holder screw



Item no.	Size
102523	74
102185	85
100305	100/125/160
100006	200/250
101554	315
102499	400
103300	500/630


A09 Standard key



Item no.	Size	Square	Hexagon	Length mm
107425	74	-	6	62
107426	80/85	6	-	62
107427	100/110	8	-	75
107428	125/140	9	-	80
107429	160	10	-	90
107430	200/230	11	-	100
107431	250/270	12	-	100
107432	315	14	-	110
107433	350	14	-	140
107434	400	17	-	140
107435	500/630	19	-	150


# Accessories DURO-M

## A09 Safety key with ejector



Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200
154377	350	14	200
154378	400	17	250
154379	500/630/700/800	19	250
160917	1000/1250	25	200


## A09 Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250


## A09 Safety adapter with ejector

For actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2
178573	400	17	1/2
178574	500/630/700/800	19	3/4
178575	1000/1250	24	3/4


## A09 Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12,7=1/2"	3%
10004117	60-320	659	12,7=1/2"	3%

## C15 Mounting screws


For cylindrical centre rim



Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece
229183	400-630	M16x60	piece


## C15 Mounting screws

For lathe chucks with direct short-taper, for front mounting




Item no.	Size	Thread	Contents of delivery	Chuck Size	Taper size
302195	74	M10x55	piece	160	5
200184	80	M10x65	piece	200	5
233006	85	M12x65	piece	200	6
233075	100	M10x90	piece	250	5
216549	110	M12x70	piece	250	6
302194	125	M16x70	piece	250	8
242954	140	M12x100	piece	315	6
358816	160	M16x85	piece	315	8
243665	200/230	M12x130	piece	350	6
236516	315	M16x110	piece	400	8
615744	350	M20x95	piece	400	11
010210	400	M20x130	piece	500	11
328925	500	M20x145	piece	630	11
367648	630	M24x125	piece	630	15

## A09 Set screw with nut, DIN 55021



Item no.	Thread	For taper	Quantity
107453	M10x30	4	3
107455	M10x35	5	4
107456	M12x40	6	4
107457	M16x45	8	4
107458	M20x55	11	6
127618	M24x65	15	6


## A09 Stud for Camlock ISO 702-2 (DIN 55029) and cylindrical studs



Item no.	Thread	For taper	Quantity
178364	M10x1	3	3
178365	M10x1	4	3
178366	M12x1	5	6
178367	M16x1,5	6	6
178368	M20x1,5	8	6
178369	M22x1,5	11	6
178370	M24x1,5	15	6
178371	M27x2	20	6


# Accessories DURO-M

## A09 Stud and locknut ISO 702-3 (DIN 55027)



Item no.	Thread	Contents of delivery	For taper	Quantity
107447	M10x34	Stück	3	3
107448	M10x39	Stück	4	3
107449	M10x43	Stück	5	4
107450	M12x50	Stück	6	4
107451	M16x60	Stück	8	4
107452	M20x75	Stück	11	6
125650	M24x90	Stück	15	6
130636	M24x100	Stück	20	6

## A09 Stud for Camlock ASA B 5.9 (DIN 55029) and cylindrical studs



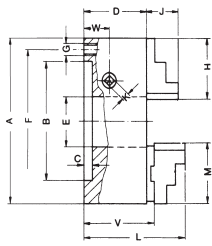
Item no.	Thread	For taper	Quantity
107465	7/16-20x35	3	3
107466	7/16-20x37	4	3
107467	1/2-20x43	5	6
107468	5/8-18x49	6	6
107469	3/4-16x55,5	8	6
107470	7/8-14x67	11	6
127621	1-14x76	15	6
130637	1 1/2-12x89	20	6

Accessories DURO-M

Accessories DURO-M

# Chuck dimensions DURO-M

Cylindrical centre mount DIN 6350

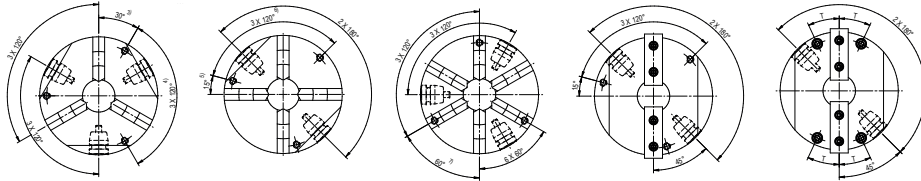


For mounting on dividing heads and other attachments from the front, the lathe chucks with a cylindrical centre mount can also be supplied pre-drilled (at surcharge) G<sub>1</sub>, it is also possible to enlarge the bore (measure E, at surcharge).

Size A	74	80	100	125	140	160	200	250	315	400	500	630
B <sup>1)</sup>	56	56	70	95	105	125	160	200	260	330	420	545
C	2,5	3	3	4	4	4	4	5	5	5	5	7
D	32,5	39,5	50	56	60	65	73,5	82	95	105	120	135
E	15	19	20	32	40	42	55	76	103	136	190	240
E <sub>max</sub>	-	-	21	33	43	50	70	92	114	150	210	253
F	63	67	83	108	120	140	176	224	286	362	458	586
G	3xM6	3xM6	3xM8	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	6xM16	6xM16
3B	G1	-	-	3xO9	-	3xO10,5	3xO11	3xO14	3xO14	3xO18	6xO18	6xO18
4B	G1	-	-	4xO9	-	3xO10,5	3xO11	3xO14	3xO14	3xO18	6xO18	6xO18
2B	G1	-	-	4xO9	-	4xO10,5	4xO11	4xO14	4xO14	4xO18	-	-
H	32	37	48	52	61	61	69	90	130	130	190	190
J	14	14	18	22,5	22,5	26	32,5	40	46	43	54,5	54,5
K	61)	6	8	9	9	10	11	12	14	17	19	19
L	-	-	80,5	95,5	106	108	119,6	139,6	155	171,5	201,5	216,5
M	-	-	47	56	66,7	66,7	79,5	95	109,5	127	127	127
V	-	-	53,6	61	-	69,7	80,2	89,9	100,4	113,4	128,4	143,3
W	13	14,5	18	20	21	22,45	25,7	26,5	30	35	38	48
3+4B <sup>2)</sup>	S	5,5	8	10	10	11	13	16	20	24	-	-
S	30°	30°	30°	26°	26°	30°	30°	30°	30°	30°	-	-
2B	R	-	-	17	20	-	23	25	32	38	-	-
S	-	-	-	30°	30°	-	30°	30°	30°	30°	-	-
T	-	-	-	24°	-	25°	25°	30°	30°	-	-	-
kg	0,9	1,3	2,5	4,3	5,7	7,5	13,0	22,8	43,3	75	131	217

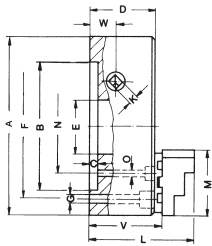
G<sub>1</sub> = Mounting from front \* 4-jaw = 4 x Ø 9

Position of the fastening screws for lathe chucks with cylindrical centring mount size 74-630



<sup>1)</sup> Hexagon, <sup>2)</sup> 25° for size 125-315 with fastening from the front, <sup>3)</sup> 6 X 6° for size 500 and 630, <sup>4)</sup> 25° for size 125 with fastening from the front, <sup>5)</sup> 4x90° for size 125 with fastening from the front, <sup>6)</sup> 6x60° for size 500 and 630, <sup>7)</sup> 30° for fastening from the front, <sup>8)</sup> not for 4B-chuk with fastening from the front

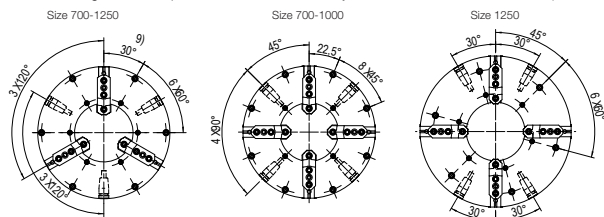
Cylindrical centre mount with front mounting



Size	ØA	700	800	1000	1250
B		610	710	910	910
C <sup>2)</sup>		7 <sup>+0,03</sup>	7 <sup>+0,03</sup>	7 <sup>+0,03</sup>	7 <sup>+0,03</sup>
D		147	147	157	157
E		310	380	460	550
E <sub>max</sub>		330	420	580	580
F		660	760	950	950
3-Jaw	G	6xO22	6xO22	6xO26	6xO26
4-Jaw	G	6xO22	6xO22	6xO26	6xO26
K		19	19	24	24
L		240,6	240,6	269,6	269,6
M		210	210	210	210
N		360	460	610	610
3-Jaw	O	6xO18	6xO18	6xO18	6xO18
4-Jaw	O	4xO18	4xO18	4xO18	6xO18
V		158	158	166	166
W		48	48	53	53
ca. kg		280	350	590	850

<sup>2)</sup> Adaptor plate dimension 7<sup>-0,03</sup>

Position of fixing screws and pinions on lathe chucks with cylindrical centre mount sizes 74-630 (size 350 on request)



<sup>3)</sup> 25° for size 1250

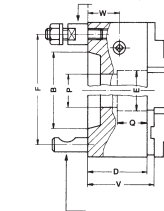
# Chuck dimensions DURO-M

Short taper mount

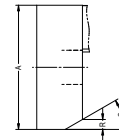
DIN 55021 with setscrews and locknuts



DIN 55027 with studs and nuts



DIN 55029 with studs for Camlock



Size	A	100	125	160	200
Taper size		3	3	4	4
B		53,9	53,9	63,5	63,5
D		75	69	66	66
E		20	32	32	42
DIN Caml.	F	75	75	85	85
P		70,6	70,6	82,5	82,5
Q		-	-	-	104,8
V		78,3	73,7	73,7	70,7
W		43	33	33	23,45
R		10	10	13	13
S		30°	26°	26°	30°
Mounting holes	DIN	3	3	3	3
ca. kg		4	5,5	8,5	15,5

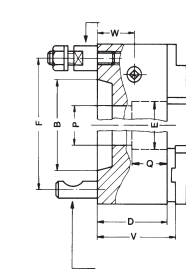
<sup>1)</sup> 50 with Camlock, other dimensions in the table on the top

Short taper mount

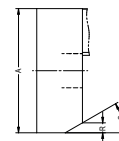
DIN 55021 with setscrews and locknuts



DIN 55027 with studs and nuts



DIN 55029 with studs for Camlock



Size A	250	315	350	400
Taper size	6	8	6	8
B	106,4	139,7	106,4	139,7
D	83	83	96	96
E	76	76	103	103
F	133,4	171,4	133,4	171,4
P	-	-	-	103
Q	-	-	-	81
V	90,9	90,9	101,4	101,4
W	27,5	27,5	31	31
R	20	20	24	24
S	30°	30°	30°	30°

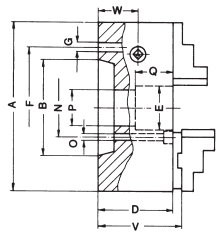
Size A	500	630
Taper size	8	11
B	139,7	196,9
D	122	122
E	136	190
F	171,4	235
P	136	-
Q	61	-
V	130,4	130,4
W	40	40
R	130,4	130,4
S	40	40
Mounting holes	DIN	4
ca. kg		150

All other dimensions should be taken from the table about chucks with cylindrical centre mount



# Chuck dimensions DURO-M

Short taper mount  
DIN 55026  
Mounting from front

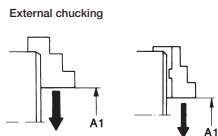


Size A	160		200		250		315		400	
Taper size	5	5	6	5	6	8	6	8	8	11
B	82,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	139,7	196,9
D	66	74,5	74,5	83	83	83	96	96	106	106
E	42	42	55	76	55	76	103	76	136	125
F <sup>2)</sup>	-	-	-	104,8	-	-	133,4	-	171,4	-
G	-	-	-	11 <sup>1)</sup>	-	-	14	-	18	-
N <sup>3)</sup>	61,9	61,9	82,6	-	82,6	111,1	-	111,1	-	165,1
O	11 <sup>1)</sup>	11 <sup>1)</sup>	14	-	14	18	-	18	-	22
V	70,7	81,2	81,2	90,9	90,9	90,9	101,4	101,4	114,4	114,4
W	23,45	26,7	26,7	27,5	27,5	27,5	31	31	36	36
R	13	16	16	20	20	20	24	24	-	-
S	30°	30°	30°	30°	30°	30°	30°	30°	-	-
Mounting holes	* 3	* 3	* 6	* 3	* 6	* 6	* 6	* 6	* 6	* 6
	** 4	** 4	** 4	** 4	** 4	** 4	** 4	** 4	** 4	** 4
approx. kg	8		14,5		25		44,5		82	

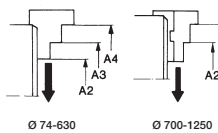
Size OA	500		630		700		800		1000		1250	
Taper size	8	11	11	15	11	15	11	15	20	15	20	20
B	139,7	196,9	196,9	285,9	196,9	285,9	196,9	285,9	412,8	285,9	412,8	285,9
D	122	122	137	137	149	149	149	149	159	159	159	159
E	136	190	190	190	310	285	380	380	380	460	505	550
F <sup>2)</sup>	171,4	235	235	-	235	330,2	235	330,2	463,6	330,2	463,6	330,2
G	18	22	22	-	22	26	22	26	26	26	26	26
N <sup>3)</sup>	-	-	-	247,6	-	-	-	-	-	-	-	-
O	-	-	-	26	-	-	-	-	-	-	-	-
P	-	-	-	-	193	281,2	193	281,2	-	281,2	407,5	281,2
Q	-	-	-	-	76	76	76	76	-	85	85	85
V	130	130,4	145,3	145,3	159,9	159,9	159,9	159,9	168	168	168	168
W	40	40	50	60	50	50	50	50	55	55	55	55
Mounting holes	* 6	* 6	* 6	* 6	* 6	* 6	* 6	* 6	* 8	* 8	* 8	* 8
	** 8	** 8	** 8	** 8	** 8	** 8	** 8	** 8	** 8	** 8	** 8	** 8
approx. kg	151		139		220		295		350		590	

<sup>1)</sup> 12 bei ASA B 5.9 A1 / A2 Zoll <sup>2)</sup> für DIN 55026 Form A und B; DIN 55021 Form A und B; ASA B 5.9 A1 / A2 <sup>3)</sup> für DIN 55026 Form B; ASA B 5.9 A1 / B1  
\* 3-Backen \*\* 4-Backen

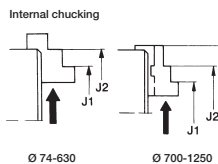
### Chucking capacities of jaw steps (standard values)



Size	74	80	100	125	140	160	200	250
A1 (BB)	2-24	2-30	3-38	3-63	3-63	4-72	4-100	5-122
A2 (DB)	2-24	2-30	3-38	3-63	3-63	3-72	4-100	5-122
A3 (DB)	23-46	27-55	38-71	39-89	47-97	47-116	56-152	73-190
A4 (DB)	45-68	52-80	70-100	75-125	91-140	91-160	104-200	131-250
max. swing dia.	88	104	128	157	174	194	238	302
Jaw movement	11	14	15	25	25	34	48	58



Size	315	400	500	630	700	800	1000	1250
A1	6-135	20-200	35-260	50-350	110-350	150-450	250-600	320-600
A2	6-135	20-200	35-260	50-350	280-672	325-853	425-1070	490-1150
A3	96-225	110-300	140-360	190-490	356-748	400-928	500-1150	564-1224
A4	186-315	200-400	280-500	330-630	-	-	-	-
max. swing dia.	395	480	600	730	1000	1170	1390	1476
Jaw movement	64	100	110	150	120	150	175	140



Size	74	80	100	125	140	160	200	250
J1	23-46	25-53	33-66	37-87	39-89	39-107	44-140	59-165
J2	45-68	50-78	65-94	73-123	83-132	83-152	92-186	119-236

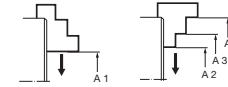
  

Size	315	400	500	630	700	800	1000	1250
J1	96-224	100-300	135-355	150-450	212-648	251-855	356-1080	426-1162
J2	186-305	190-390	275-460	290-590	290-758	326-930	430-1150	500-1236
J3	-	-	-	-	526-922	566-1094	660-1314	740-1400

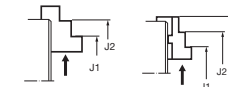
Clamping ranges for lathe chucks with individual adjustable jaws (ES) are in approximate conformity with the above values. They are valid for 3- and 4-jaw chucks and lathe chucks with reversible jaws.  
**Do not exceed maximum chucking ranges.**

# Jaw dimensions DURO-M

### External chucking



### Internal chucking



### Chuck capacities of jaw steps (reference values)

valid for 6-jaw chuck

Size	160	200	250	315	400
A1 (BB)	8-72	9-100	14-122	15-135	20-200
A2 (DB)	8-72	9-100	14-122	15-135	20-200
A3 (DB)	52-116	61-152	81-190	105-225	110-300
A4 (DB)	96-160	109-200	141-250	195-315	200-400
Biggest rotation-Ø	194	238	302	395	480
Jaw stroke	32	45	54	60	100

Size	160	200	250	315	400
J1	46-107	51-140	70-165	100-224	100-300
J2	89-152	97-186	128-236	190-305	190-390

### Max. permissible speeds for ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

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 speed limit for chucks with cast iron bodies is based on the permissible peripheral speed for cast iron. The specification DIN 6386 Part 1 shall be observed.

Size	3 and 4 jaws Steel body
74	-
80	7000
100	6300
125	5500
140	5000
160	4600
200	4000
250	3000
315	2300
400	1800
500	1300
630	850
700	800
800	700
1000	560
1250	450

### Clamping force 3 jaw chuck ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

The clamping force is sum total of all jaw forces acting radially on the stationary workpiece. The clamping forces are approximate values. To obtain the specified clamping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.

Size	Torque key	Total clamping force
74	30	11
80	30	13
100	60	27
125	80	31
140	90	40
160	110	47
200	140	55
250	150	63
315	180	69
400	240	92
500	260	100
630	280	105
700	280	105
800	300	110
1000	450	115
1250	450	115