Operation guide





TYPE	DURO-A	KFD-HS	KFD-HE	KFG	PKF
	Power chucks with through-hole				
Feature	Constant clamping force distribution for more than 500,000 cycles	larger than average through-hole, high clamping precision, low centrifugal force losses	large through-hole, proven standard	large through-hole, large jaw stroke	maximum concentricity and axial run-out precision
Size	110 - 400	110 - 400	170 - 315	160 - 350	100 - 200
Chucking capacities	6 - 478 mm	6 - 478 mm	20 - 393 mm	5 - 472 mm	-
Power transmission	wedge	wedge	wedge	angle lever	wedge
Clamping force	■■■■■	■■■■■	■■■■□	■□□□□	■□□□□
Speeds	■■■■■	■■■■■	■■■■□	■■□□□	■■■□□
Number of jaws	3	2, 3	3	3	3
Type of jaws	90°	90°, tongue and groove	90°, 60°	60°	pin mounting
Workpiece	pipe, bar, disc, flange	pipe, bar, disc, flange	pipe, bar, disc, flange	pipe, bar, disc, flange	disc, flange
Machining	✓	✓	✓	✓	✓
Mount	ISO 702-4, ISO 702-1	DIN 6353, ISO 702-1 (DIN 55026) DIN 55021	DIN 6353	✓	✓
Page	6014	6025	6036	6046	6050

2-jaw chuck
3-jaw chuck
60° serration 60°
90° serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

ROHM Power chucks, cylinders and steady rests

Operation guide



TYPE	KFD-EC	KFD	KFD-G
	Power chucks without through-hole		
Feature	low-maintenance and -wear	proven standard chuck for numerous applications	large jaw stroke, reduced interference contours
Size	200 - 400	85 - 630	125 - 315
Chucking capacities	16 - 490 mm	4 - 720 mm	-
Power transmission	wedge	wedge	wedge
Clamping force	■■■■■	■■■■■	■■■□□
Speeds	■■■□□	■■■□□	■■■□□
Number of jaws			
Type of jaws	90°	90°	90°
Workpiece			
Machining			
Mount	DIN 6353	DIN 6353 similar DIN 6353	
Page	6056	6061	6072

side machining
length machining
short taper mount
cylindrical centre mount

Operation guide

Power chucks, cylinders and steady rests

Operation guide



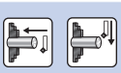
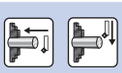
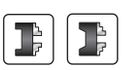


TYPE	DURO-A RC	DURO-NCSE	DURO-NC	LVE	LVE large through-hole
	Power chucks with quick jaw change system			Air-operated self-contained chucks	
Feature	individual jaw unlocking	individual jaw unlocking	central jaw unlocking	incorporated actuating cylinder	incorporated actuating cylinder, large through-hole
Size	180 - 400	180 - 630	140 - 630	125 - 315	400 - 1000
Chucking capacities	11 - 351 mm	11 - 667 mm	5 - 780 mm	12 - 400 mm	85 - 1135 mm
Power transmission	wedge bar	wedge bar	wedge	wedge	wedge
Clamping force	■■■■■	■■■■■	■■■■■	■■■□□	■■■□□
Speeds	■■■■■	■■■■■	■■■■■	■■□□□	■■□□□
Number of jaws	3	3	3	3	3
Type of jaws	tongue and groove	tongue and groove	tongue and groove	90°	90°
Workpiece	pipe, bar, flange, disc	pipe, bar, flange, disc	pipe, bar, flange, disc	pipe, bar, flange	pipe, bar, flange
Machining	✓	✓	✓	✓	✓
Mount	**ISO 702-4**, **ISO 702-1**	**DIN 6353**, **ISO 702-1** (DIN 55026) **DIN 55021**	**DIN 6353**	✓	✓
Page	6078	6088	6098	6112	6118

2-jaw chuck
3-jaw chuck
serration 60°
serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

Operation guide




TYPE	KBF-N draw-down chuck	ZFM draw-down chuck	KFD-AF compensating chuck	GF gripper chuck
	Application chucks			
Feature	for internal and external clamping, active pull down, hermetically sealed with oil bath lubrication	active pull down, only external clamping	compensating jaws, interchangeable centering inserts	automatic jaw resetting
Size	170 - 400	160 - 315	160 - 315	80 - 125
Chucking capacities	-	-	5 - 393 mm	-
Power transmission	wedge	draw rod studs system	wedge	spring system
Clamping force	■■■□□	■■□□□	■■■■□	■□□□□
Speeds	■■■■□	■■■■■	■■■□□	stationary
Number of jaws				
Type of jaws		-		
Workpiece				
Machining				no machining (only gripping and positioning)
Mount	 **DIN 6353**  **ISO 702-1** (DIN 55026) **DIN 55021**		 with option for radial fine adjustment	cylindrical shank DIN 69880
Page	6130	6134	61236	6140

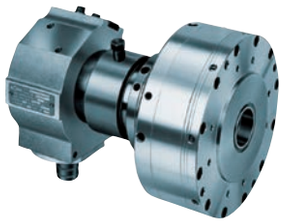
 side machining

 length machining

 short taper mount

 cylindrical centre mount

Operation guide



TYPE	SZS	LHS-L
	Cylinder with through-hole	
Feature	hydraulical cylinder with through-hole for operating pressure 8 - 45 bar	pneumatical cylinder with through-hole for operating pressure 1,5 - 8 bar
Through-hole	46 - 127 mm	26 - 42 mm
Stroke max.	25 - 40 mm	20 - 32 mm
Pull force	46 - 145 kN (45 bar operating pressure)	10 - 16 kN (6 bar operating pressure)
Actuation		
Max. Speeds	7000 - 3200 m^{-1}	6500 - 4000 m^{-1}
Installation position	horizontal	horizontal, vertical
Feature	short design	short design
Workpiece		
Page	6148	6150

 2-jaw chuck

 3-jaw chuck

 serration 60°

 serration 90°

 tongue and groove

 pipe

 bar

 disc

 flange

 asymmetrical workpiece

Operation guide

TYPE	OVS	LVS
	Cylinder without through-hole	
Feature	hydraulical cylinder without through-hole for operating pressure 8 - 80 bar	pneumatical cylinder without through-hole for operating pressure 2 - 10 bar
Through-hole	-	-
Stroke max.	32 - 50 mm	32 - 45 mm
Pull force	30 - 166 kN (60 bar operation pressure)	3 - 57 kN (6 operating pressure)
Actuation		
Max. Speeds	8000 - 4500 m^{-1}	5000 - 3200 m^{-1}
Installation position	horizontal, vertical	horizontal, vertical
Feature	prepared for media feed-through	media feed-through on request
Workpiece		
Page	6156	6160

 side machining

 length machining

 short taper mount

 cylindrical centre mount

 hydraulical actuated

 pneumatically actuated

Operation guide





TYPE	SLZN	SLZNB	SLZ	SLZC	SLZK
	Self-centering steady rests				
Feature	standard version with cylinder mounted at rear	with side mounted cylinder	heavy design for high loads	compact design, extra large clamping range	slim clamping arms
Chucking capacities	4 - 350	8 - 350	40 - 800	60 - 520	8 - 250
Max. clamping force per roller	1040 - 16000 N	3500 - 16000 N	35000 - 80000 N	14500 - 25000 N	2700 - 7500 N
Centering accuracy over the entire clamping range	0,02 - 0,06*	0,02 - 0,06*	0,04 - 0,06*	0,05 - 0,06*	0,03 - 0,06*
Repeatability at same clamping-Ø	0,005 - 0,01*	0,005 - 0,01*	0,01*	0,007 - 0,01*	0,007 - 0,01*
Rollers	cylindrical or convex	cylindrical or convex	cylindrical or convex	cylindrical or convex	cylindrical
Chip protection	with and without	with and without	with and without	with and without	with and without
Page	6170	6174	6178	6180	6182

* At constant pressure

2-jaw chuck
3-jaw chuck
60° serration 60°
90° serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

Power chucks, cylinders and steady rests

Operation guide




TYPE	KZS-P / KZS-PG	KZS-H / KZS-HG	SSP	F-senso chuck
	Stationary power chucks			Clamping force measurement device
Feature	pneumatically, centering vices, KZS-PG with long jaw moveement	hydraulically, centering vices, KZS-HG with long jaw movement	pneumatically, without through-hole	measurement device incl. tablet and software
Size	64 - 250	64 - 250	160 - 315	-
Chucking capacities	-	-	28 - 400	75 - 175
Power transmission	wedge	wedge	wedge	-
Clamping force	■■□□□	■■□□□		max. 300 kN
Speeds	stationary	stationary	-	max. 8250 min^{-1}
Number of jaws				2-jaw (stationary) 3-jaw (rotating)
Type of jaws	60°	60°	90°	-
Workpiece				-
Machining				-
Mount	clamping sleeve DIN 7346	clamping sleeve DIN 7346	flange	-
Speciality	optimally suited for automated work sequences	optimally suited for automated work sequences	serration 60°, tongue and groove and / or through-hole on request	delivered in the practical hard-shell case
Page	6190	6196	6202	6209

side machining
length machining
short taper mount
cylindrical centre mount

Technical data

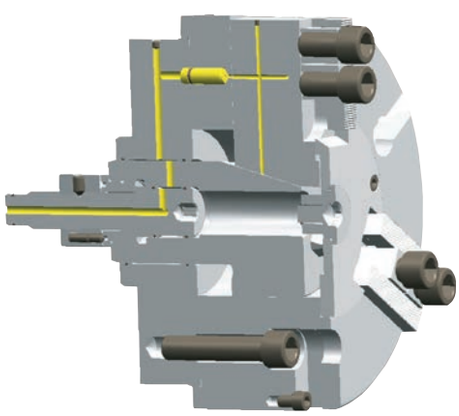
Flexibility of the media feed-through

For power chucks with and without through-hole

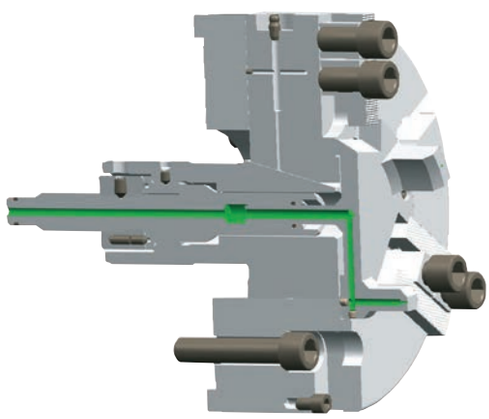
Available on request:

- With air feed-through for air sensing, purge or blast air
- Central lubrication
- With guided and sealed piston neck
- With water drain groove or water drain bore as well as cover or inserts for the through-hole bore

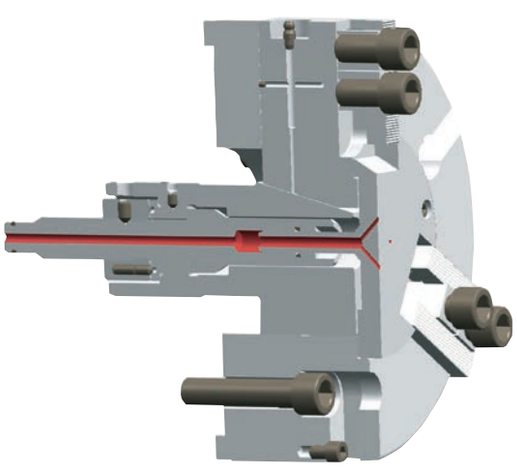
Examples of modified power chucks with feed-through for:



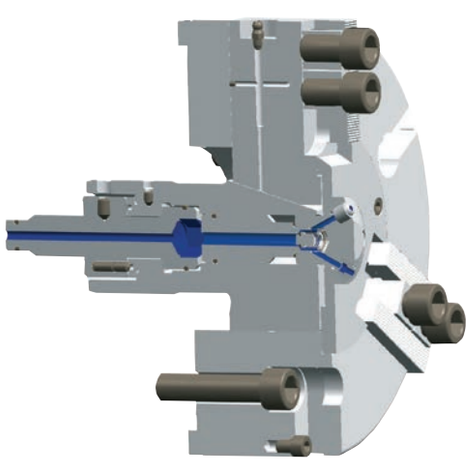
Central lubrication via distributor flange with dosing units



Air sensing



Blast air



Coolant

Double feed-throughs, e.g. for central lubrication and air sensing, are possible.

Notes