

QUICK JAW CHANGE SYSTEM WITH INDIVIDUAL JAW UNLOCKING



The quick jaw change system allows flexible use of the power chuck and drastically reduces set-up times. The jaws can be flexibly offset, turned or changed.

Thanks to the individual jaw unlocking on the DURO-NCSE power chuck, handling with large, workpiece-specific customized top jaws is especially easy: Push the key till stop, then turn in the direction of the arrow.



Video DURO-NCSE



Video DURO-NC

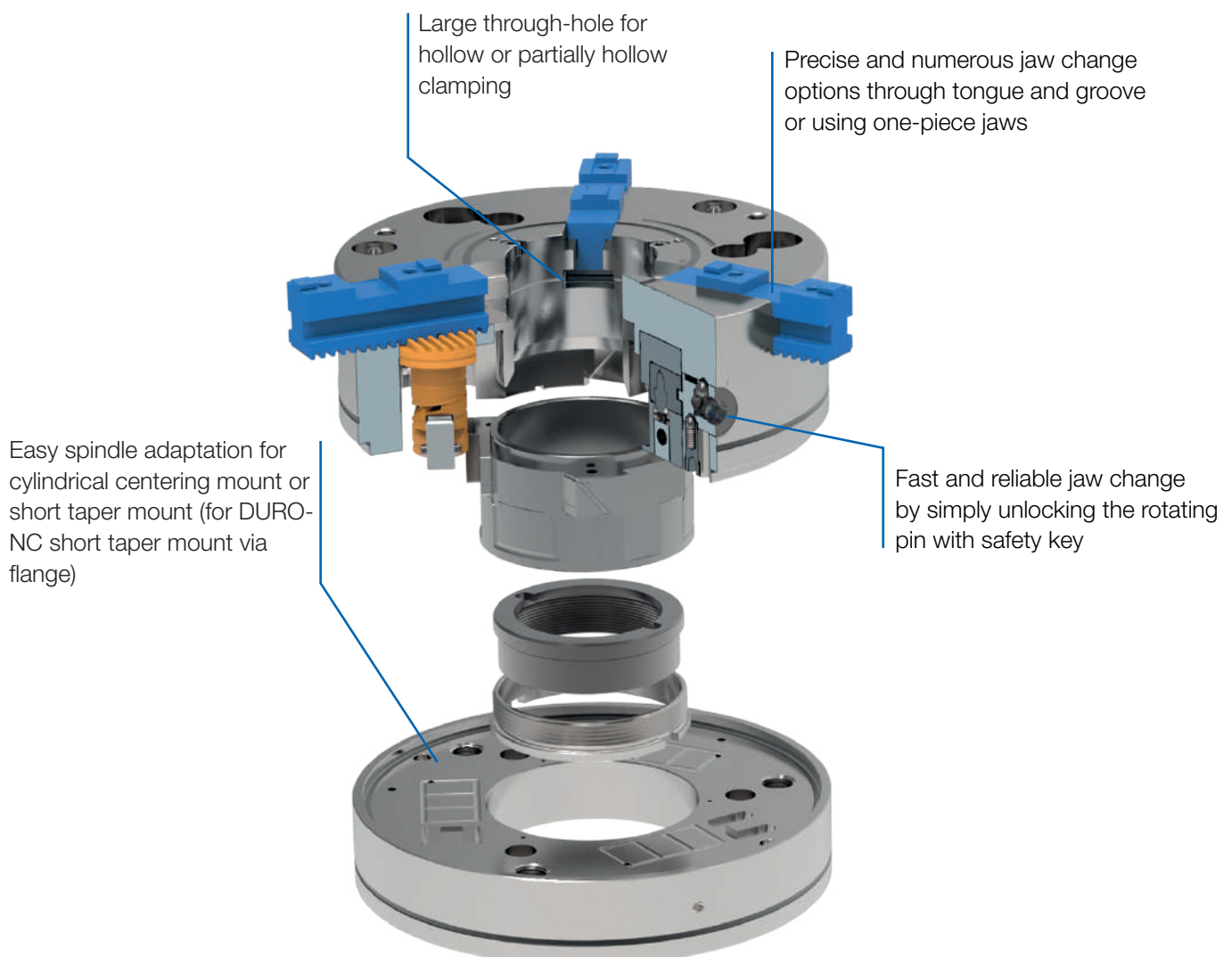


POWER CHUCKS WITH QUICK JAW CHANGE

Fast jaw change, high clamping precision and high clamping force characterize the power chucks DURO-NCSE and DURO-NC. Thanks to the quick jaw change system, the jaws can be flexibly offset, turned or changed. The clamping precision of the chuck is always retained.

ADVANTAGES AT A GLANCE

- ⊕ Flexible use thanks to quick jaw change reducing set-up times
- ⊕ Secure jaw lock via the safety key
- ⊕ Large through-hole optimal for bar machining



Power chuck with quick jaw change



Power chucks with quick jaw change system

DURO-A RC - jaw change in 50 seconds



APPLICATION

Premium power chuck with through-hole for the machining of bar, pipes and discs. Maximum speeds and flexible use thanks to quick jaw change system with individual jaw unlocking.

TYPE

3-jaw chuck with cylindrical centre mount. Short taper mounting adapter (DIN ISO 702-1) as option.

CUSTOMER BENEFITS

- ⊕ Quick jaw change in 50 seconds
- ⊕ 3-year warranty (pursuant to DURO-A RC warranty)
- ⊕ Excellent price/performance ratio
- ⊕ Overall height reduced by up to 14% and up to 17% weight reduction
- ⊕ High clamping accuracy and clamping force through very stable construction

TECHNICAL FEATURES

- High speeds and optimum centrifugal force behaviour due to low jaw weight and key bar design
- Large through-hole for hollow and partly-hollow clamping
- Base jaws with straight teeth

Included in the scope of delivery:

Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench

A RC = Automatic, Rapid, Change



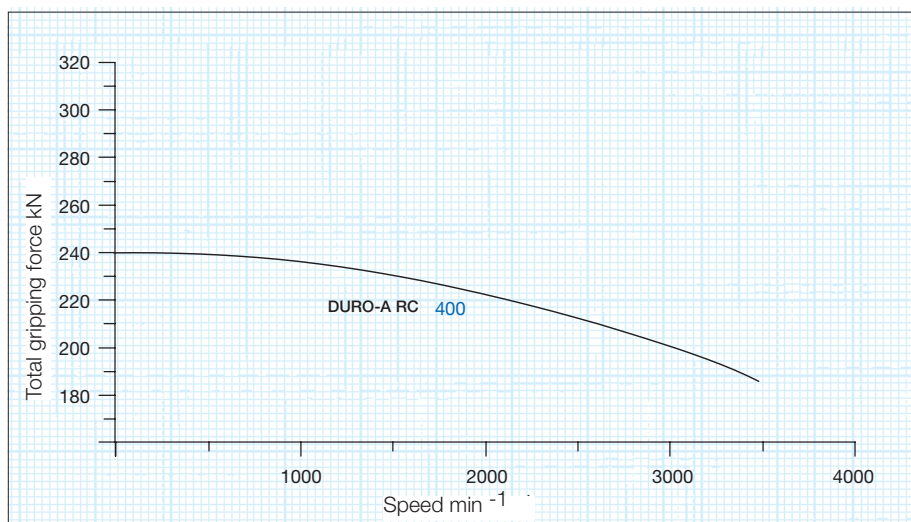
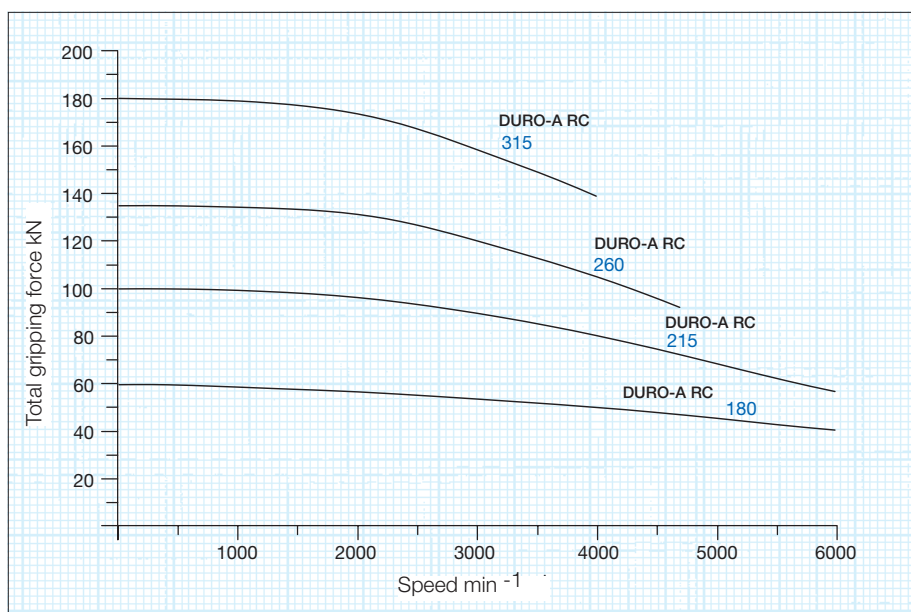
Gripping force / speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

Curve:
max. centrifugal
force of top jaw



To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.



Quick jaw change system with individual jaw unlocking

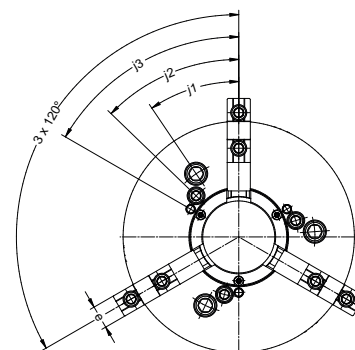
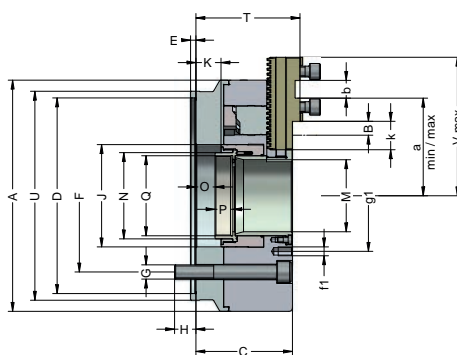
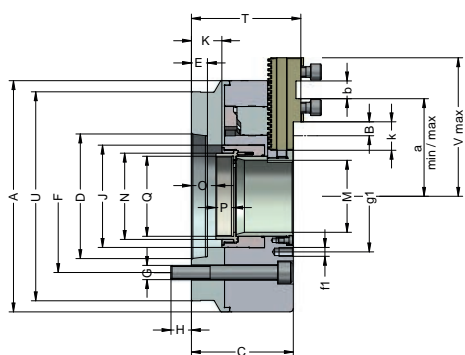
The individual locking arrangement means that handling is particularly easy with special large jaw pads when the workpiece requires them: push key till stop, then turn in arrow direction.





Power chucks with quick jaw change system

DURO-A RC 3-jaw, individual jaw unlocking, straight teeth



C 15
3-jaw power chucks DURO-A RC with quick jaw change system, with individual jaw unlocking, with straight teeth, Cylindrical centre mount DIN ISO 702-4

Item No.	183100	183101	183104	183106	183107	183108	183111	183112	183114	183115
Size A mm	180	180	215	215	260	260	315	315	400	400
Jaw travel B mm	6,8	6,8	7,4	7,4	8,2	8,2	8,8	8,8	9,4	9,4
C mm	83,9	83,9	95,9	113,9	108,5	108,5	117,7	117,7	125,7	125,7
D mm	ZA 140	ZA 170	ZA 170	KK8	ZA 170	ZA 220	ZA220	ZA 300	ZA 300	ZA 380
E mm	6	6	6	18	6	6	6	6	6	6
F mm	104,8	133,4	133,4	171,4	133,4	171,4	171,4	235	235	330,2
G mm	M10	M12	M12	M16	M12	M16	M16	M20	M20	M24
H mm	18	19,1	24	26	21,5	21	29,8	38,8	39,8	31,6
J mm	78	78	93	93	115	115	140	140	175	175
Wedge stroke K mm	20	20	25	25	28	28	28	28	30	30
M mm	53	53	66	66	81	81	104	104	128	128
N mm	64,9	64,9	80,9	80,9	96,9	96,9	119,9	119,9	149,9	149,9
O max.	11,8	11,8	16,8	34,8	19,5	19,5	18	18	17	17
O min.	-8,2	-8,2	-8,2	9,8	-8,5	-8,5	-10,2	-10,2	-13,2	-13,2
P mm	19	19	19	19	20	20	22	22	25	25
Q mm	M60x1,5	M60x1,5	M75x1,5	M75x1,5	M90x1,5	M90x1,5	M110x2	M110x2	M138x2	M138x2
T mm	90,3	90,3	100,8	118,8	117	117	129	129	137	137
U mm	155	180	195	205	218	235	285	315	365	400
V max. mm	103	103	134	134	155,5	155,5	181	181	214	214
a max.	66	66	90,2	90,2	109,7	109,7	135,2	135,2	158,4	158,4
a min.	37,7	37,7	57,9	57,9	76,7	76,7	85,7	85,7	92,9	92,9
Index adjustment	6(x4,712=28,3)	6(x4,712=28,3)	7(x4,712=32,98)	7(x4,712=32,98)	6(x5,5=33)	6(x5,5=33)	9(x5,5=49,5)	9(x5,5=49,5)	12(x5,5=66)	12(x5,5=66)
b mm	18	18	20	20	20	20	20	20	26	26
e mm	20	20	22	22	26	26	32	32	32	32
f1	M8/14	M8/14	M8/14	M8/14	M10/16	M10/16	M10/16	M10/16	M10/16	M10/16
g1 mm	96	96	108	108	125	125	156	156	190	190
j3	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
j1	29°	29°	31°	31°	46°	46°	29°	29°	29°	29°
j2	36°	36°	39°	39°	34°	34°	40°	40°	40°	40°
k mm	9	9	19	19	32	32	43	43	39	39
Maximum draw bar pull kN	32	32	47	47	63	63	90	90	120	120
Max. total clamping force approx. kN	64	64	100	100	135	135	180	180	240	240
Max. admissible speed min ⁻¹	6300	6300	6000	6000	4700	4700	4000	4000	3500	3500
Moment of inertia J kgm ²	0,056	0,056	0,14	0,15	0,32	0,33	0,8	0,84	2,3	2,4
Weight without top jaws ca. kg	12,7	13,5	21,2	24	34,7	34,8	57,5	60	104	108
Universal draw tube adapter	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available
Adaption to short taper mount DIN ISO 702-1	optionally available	optionally available	optionally available	-	optionally available	optionally available	optionally available	optionally available	optionally available	optionally available

Power chuck
DURO-A RC



Power chucks with quick jaw change system

Jaws DURO-A RC

C 21
Base jaws, 3-jaw-set, hardened, straight tothing, incl. cylinder screws, DIN 912-12.9



Item no.	Chuck Size	Jaw length mm	Jaw width mm
463548	180	65	20
463549	215	85	22
463550	260	104	26
463551	315	115	32
463552	400	125	32

A 36
Reversible top jaws, 3-jaw set, hardened tongue and groove for external and internal clamping - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094012	180	61,5	32,5	20,4
094013	215	70,5	38	24,4
094014	260/315	92	50	34,4
094015	400	107	56	35,7

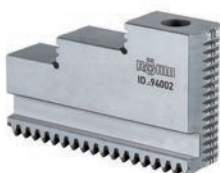
Additionally or later applied, hardened stepped jaws must be ground out in the chuck.

A28
Unstepped top jaw AB, 3-jaw set standard design, soft - material 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094008	180	85	36,5	20,3
094009	215	105	40	22
094010	260/315	125	50	30
094011	400	145	50	34,3

C 21
One-piece reversible jaws, 3-jaw set, hardened straight tothing - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463555	180	58	44	20
463556	215	75	51	22
463557	260	90	60	26
463558	315	117	66	32
463559	400	137	70	32

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft one-piece jaws, 3-jaw set, can be hardened straight tothing, guidance hardened and ground - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463562 ▲	180	65	55	20
463563 ▲	215	84	65	22
463564	260	99	84	26
463565	315	121	90	32
463566 ▲	400	148	100	32

Jaws DURO-A RC



Power chucks with quick jaw change system

Jaws DURO-A RC

C 21

Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137060	180	66	37,5	24

C 21

Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137061	180	66	37,5	20
137064	215	81	43	24
137108	260/315	90	55	34
137114	400	100	62	34

C 21

Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137062	180	56	37,5	20
137065	215	66	43	24
137109	260/315	72	55	34
137115	400	86	62	34

C 21

Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137066	215	79	43	34
137110	260/315	80	55	50
137116	400	93	62	50

C 21

Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137067	215	81	43	34
137111	260/315	90	55	50
137117	400	106	62	50

C 21

Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137068	215	66	43	34
137112	260/315	72	55	50
137118	400	86	62	50

Jaws DURO-A RC



Power chucks with quick jaw change system

Jaws DURO-A RC

C 21
Draw-down jaws, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485522 ▲	180	65	43	20
485524 ▲	215	85	47	22
485526	260	104	58	26
485528 ▲	315	115	63	32
485530 ▲	400	125	63	32

C 21
Draw-down jaws, additional clamping range, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485523 ▲	180	72	43	20
485525 ▲	215	95	47	22
485527 ▲	260	104	58	26
485529 ▲	315	123	63	32
485531 ▲	400	134	63	32

C 15
Interchangeable clamping inserts, 1 piece with claws



Item no.	Chuck Size
141049	180/215
141052	260/315/400

C 15
Interchangeable clamping inserts, 1 piece with serrated toothing



Item no.	Chuck Size
141050	180/215
141053	260/315/400

C 15
Interchangeable clamping inserts, 1 piece with heat treatable surface



Item no.	Chuck Size
141051	180/215
141054	260/315/400

Jaws DURO-A RC



Power chucks with quick jaw change system

Accessories DURO-A RC

C 15 Mounting screws



Item no.	Size	Contents of delivery	Thread
233058	180/215	piece	M8x20
233030	260/315/400	piece	M12x30

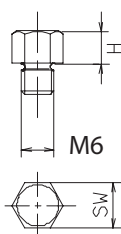
Socket head cap screw to DIN 912, 12.9

C 15 Special grease F80 for lathe chucks for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C 15 Changeable workpiece rests (in different lengths)



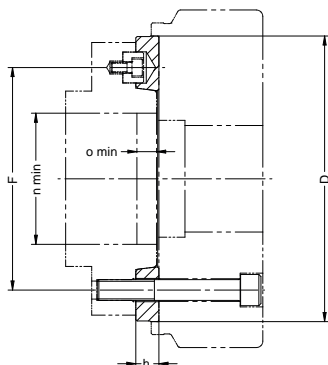
Item no.	H mm	M	Key-width SW
289188	5	M6	9
138950	10	M6	9
725581	15	M6	9

C15 Grease gun DIN1283



Item no.	Conne- tion	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

C 15 Intermediate adaptor plate with cylindrical centre mount DIN ISO 702-4 for DURO-A RC Mounting from front to DIN ISO 702-1



Item No.	Chuck size	D mm	Spindle nose size	h mm	F mm	n min.	o min.
183131	180	140	5	15	104,8	65	8,5
183132	180	170	6	16	133,4	65	8,5
183133	215	170	6	16	133,4	81	8,5
183134	260	170	6	16	133,4	97	9
183135	260	220	8	18	171,4	97	9
183136	315	220	8	28	171,4	120	10
183137	315	300	11	19	235	120	10
183138	400	300	11	19	235	150	14
183139	400	380	15	21	330,2	150	14

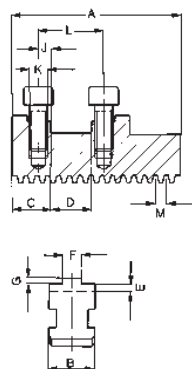
All fastening parts are included



Technical data

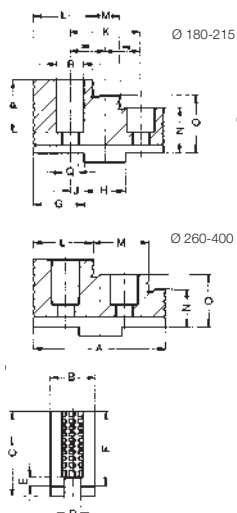
Jaw dimensions DURO-A RC

Base jaw GB, with screws



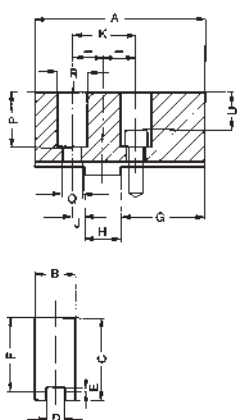
Chuck size	180	215	260	315	400
Type	574-11	574-11	574-11	574-11	574-11
Item no. 3-jaw set	463548	463549	463550	463551	463552
A	65	85	104	115	125
B	20	22	26	32	32
C	19	23	26	26	30
DH7	18	20	20	20	26
E	5	4,5	5,5	6	6
F	8	10	12	12	12
G	2,5	2,5	3	3	3
J	7	10	10	10	14
K	M8	M8	M12	M12	M12
L	32	40	40	40	54
M	4,712	4,712	5,498	5,498	5,498
Weight/set kg	0,7	1,0	1,8	2,7	3,0

Reversible top jaws UB, hardened



Chuck size	180	215	260	315	400
Type	003-20	003-25	003-30	003-30	003-35
Item no. 3-jaw set	094012	094013	094014	094014	094015
A	61,5	70,35	92	92	107
B	20,4	24,4	34,4	34,4	37,5
C	37	43	55	55	62
D	8	10	12	12	12
E	3	3,5	3,5	3,5	3,5
F	32,5	38	50	50	56
G	22,5	25,5	30	30	35,5
H	18	20	20	20	26
J	7	10	10	10	14
K	32	40	40	40	54
L	26,5	28,5	41	41	40
M	13	14	40,5	40,5	54
N	17,5	18	22	22	26
O	25	28	36	36	41
P	23,5	29	39	39	40
Q	9	9	14	14	14
R	15	15	20	20	20
Weight/set kg	0,6	1,0	2,4	2,4	3,4

Soft top jaws AB, material 16MnCr5



Chuck size	180	215	260	315	400
Type	002-20	002-25	002-30	002-30	002-35
Item no. 3-jaw set	094008	094009	094010	094010	094011
A	85	105	125	125	145
B	20,3	22	30	30	34,3
C	41	45	55	55	56
D	8	10	12	12	12
E	3	3,5	3,5	3,5	3,5
F	36,5	40	50	50	50
G	42	50	70	70	74
H	18	20	20	20	26
J	7	10	10	10	14
K	32	40	40	40	54
P	27,5	31	39	39	34
Q	9	9	14	14	14
R	15	15	20	20	20
U	19,5	23	27	27	22
Weight/set kg	1,3	2,2	4,5	4,5	6,8

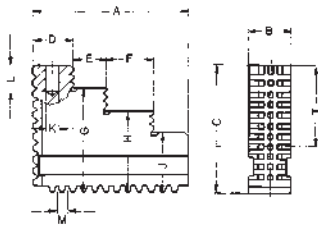
Jaw dimensions DURO-A RC



Technical data

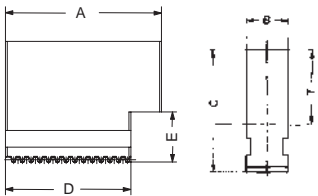
Jaw dimensions and chucking capacities DURO-A RC

Reversible one-piece jaws EB



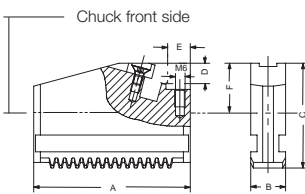
Chuck size	180	215	260	315	400
Type	574-27	574-27	574-27	574-27	574-27
Item no. 3-jaw set	463555	463556	463557	463558	463559
A	58	75	90	117	137
B	20	22	26	32	32
C	44	51	60	66	70
G	37	43	50	56	59
H	30	35	40	46	48
J	23	27	30	36	37
M	4,712	4,712	5,498	5,498	5,498
T	23	26	31	32	36
Weight/set kg	0,6	1,3	2,0	3,4	4,4

Soft one-piece jaws BL, material 16MnCr5



Chuck size	180	215	260	315	400
Type	574-37	574-37	574-37	574-37	574-37
Item no. 3-jaw set	463562	463563	463564	463565	463566
A	65	84	99	121	148
B	20	22	26	32	32
C	55	65	84	90	100
D	56	67,5	77	93	120
E	25	27	36	41	41
T	33	38	53	54	64
Weight/set kg	1,3	2,2	4,3	6,7	9,2

Draw-down jaws NBG, Straight toothing, for interchangeable clamping inserts (jaw without insert)

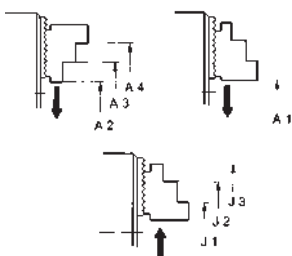


Chuck size	180	215	260	315	400
Jaw design	Type 545-30				
Item no. piece	485522	485524	485526	485528	485530
A	65	85	104	115	125
B	20	22	26	32	32
C	43	47	58	63	63
D	15	15	20	20	20
E	11	12	12	12	12
F	22,5	22,5	29,5	29,5	29,5
Capacities external	38-71	38-102	45-124	42-164	50-190
Capacities internal	125-160	170-223	207-289	234-344	252-397
Max. swing	197	251	306	374	425

Draw-down jaws NBG, for interchangeable clamping inserts (jaw without insert), jaws for further clamping ranges

Chuck size	180	215	260	315	400
Jaw design	Type 549-30				
Item no. piece	485523	485525	485527	485529	485531
A	72	95	104	123	134
E	30	45	50,5	61,5	67
Capacities external	78-110	113-168	123-202	146-262	160-305
Capacities internal	98-122	114-166	131-214	136-245	140-285
Max. swing	197	271	306	390	443

Chucking capacities with reversible top jaws UB



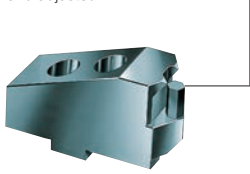
Chuck size	Jaw position	180	215	260	315	400
External chucking	A1	11-68	18-84	27-104	25-163	28-240
	A2	33-90	59-125	-	-	-
	A3	77-134	115-181	83-149	111-213	98-243
	A4	103-160	143-209	165-230	193-295	206-351
Internal chucking	J1	65-122	75-141	108-185	143-245	85-230
	J2	91-148	103-169	189-266	225-327	192-337
	J3	135-192	159-225	-	-	-

Jaw dimensions and Chucking capacities

Jaw dimensions DURO-A RC

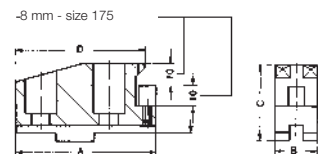
Reversible claw-type top jaws KB, standard design

Workpiece stop can be changed and adjusted



Chuck size	180
Jaw design	Type 544-00 Standard design
Item no. piece	137060
A	66
B	24
C	37,5
D	17
Capacities external	130-159
Capacities internal	53-84

Jaws for further clamping ranges



Chuck size	180	215	260	315	400
Jaw design	Type 544-00 Standard design				
Item no. piece	137061	137064	137108	137108	137114
A	66	81	90	90	100
B	20	24	34	34	34
C	37,5	43	55	55	62
D	61	71	78	78	90
Capacities external	25-56	41-103	48-150	48-210	53-237
Capacities internal	136-188	181-255	85-238	136-300	240-435

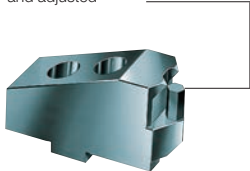
Accessories: interchangeable workpiece stop (different lengths)

Item no.	289188	138950	725581
M	M6	M6	
H	5	10	15
SW		9	

Chuck size	180	215	260	315	400
Jaw design	Type 544-00 Standard design				
Item no. piece	137062	137065	137109	137109	137115
A	56	66	72	72	86
B	20	24	34	34	34
C	37,5	43	55	55	62
D	29	38,5	38	38	42
Capacities external	68-120	94-168	77-230	127-292	172-333
Capacities internal	93-126	116-200	85-238	136-300	168-329

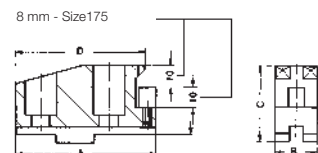
Reversible claw-type top jaws KB, large design

Workpiece stop can be changed and adjusted



Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137066	137110	137110	137116
A	79	80	80	93
B	34	50	50	50
C	43	55	55	62
D	29,5	29	29	30
Capacities external	121-226	-	-	-
Capacities internal	74-172	73-203	80-264	130-291

Jaws for further clamping ranges



Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137067	137111	137111	137117
A	81	90	90	106
B	34	50	50	50
C	43	55	55	62
D	71	78	78	90
Capacities external	44-124	53-152	70-214	76-237
Capacities internal	160-274	163-322	222-384	168-425

Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137068	137112	137112	137118
A	66	72	72	86
B	34	50	50	50
C	43	55	55	62
D	38,5	38	38	42
Capacities external	79-188	77-230	127-292	172-333
Capacities internal	105-210	85-238	136-300	168-329



Notes

Notes



Power chucks with quick jaw change system

DURO-NCSE - individual jaw unlocking



APPLICATION

Premium power chuck with through-hole for flexible use thanks to quick jaw change system for maximum speeds.

TYPE

Power chuck available with cylindrical centre mount or short taper mount. 3-jaw version.

CUSTOMER BENEFITS

- ③ Easy handling of the jaw change thanks to individual jaw unlocking
- ③ Universal: jaws can be offset, exchanged or turned
- ③ For very high speeds - low centrifugal force losses thanks to low jaw weights and wedge bar construction
- ③ High clamping precision and clamping force thanks to rigid chuck construction
- ③ Large through-hole for hollow or partially hollow clamping

TECHNICAL FEATURES

- Power transmission by means of wedge bar system
- The tothing of the wedge bar always engages completely in the jaw
- Base jaws with straight teeth

Note:

The safety key can only be pulled out once the jaws are locked. This setup in combination with the key switch integrated in the machine also prevents the machine spindle from starting up unintentionally when the jaws are unlocked.

Included in the scope of delivery:

Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench

NCSE = NC machine, quick, individual jaw unlocking



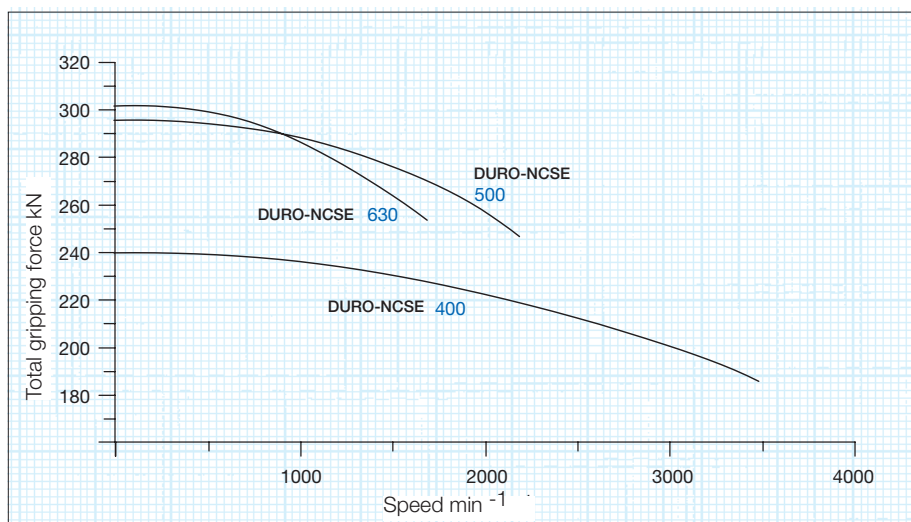
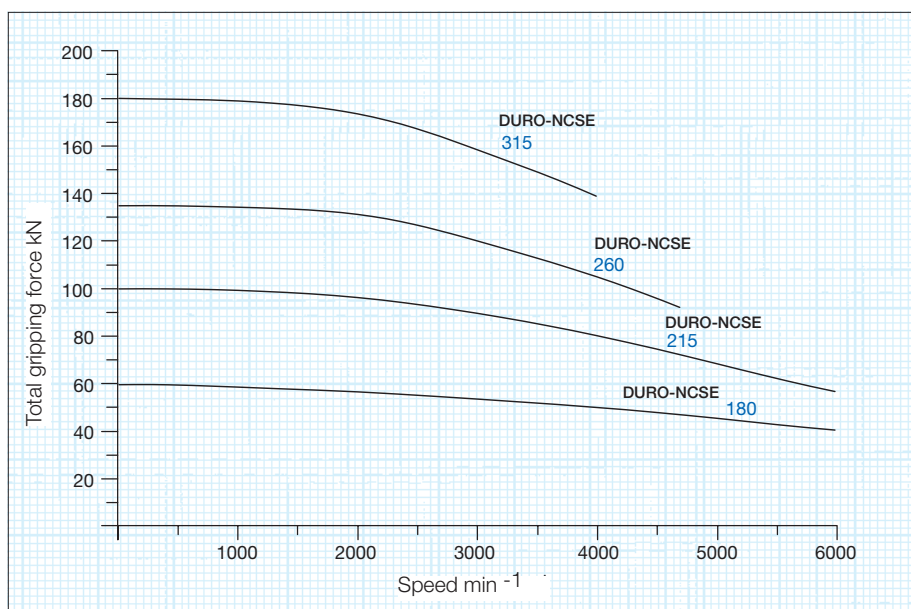
Gripping force / speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

Curve:
max. centrifugal
force of top jaw



To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.



Quick jaw change system with individual jaw unlocking

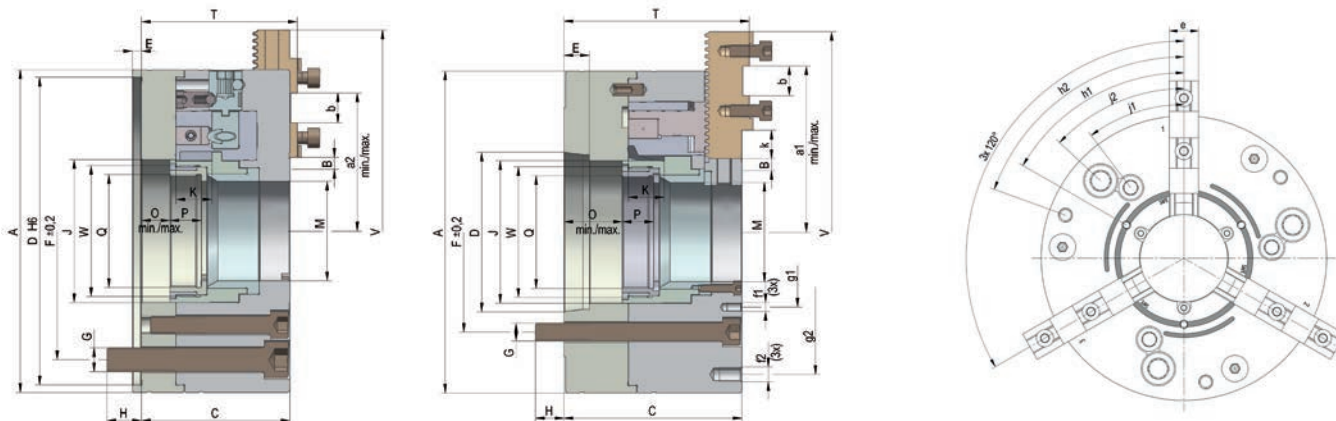
The individual locking arrangement means that handling is particularly easy with special large jaw pads when the workpiece requires them: push key till stop, then turn in arrow direction.





Power chucks with quick jaw change system

DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth



C 15
3-jaw power chucks DURO-NCSE with quick jaw change system, with individual jaw unlocking, with straight teeth
Cylindrical centre mount DIN 6353 / short taper mount ISO 702-1 (DIN 55026/55021)

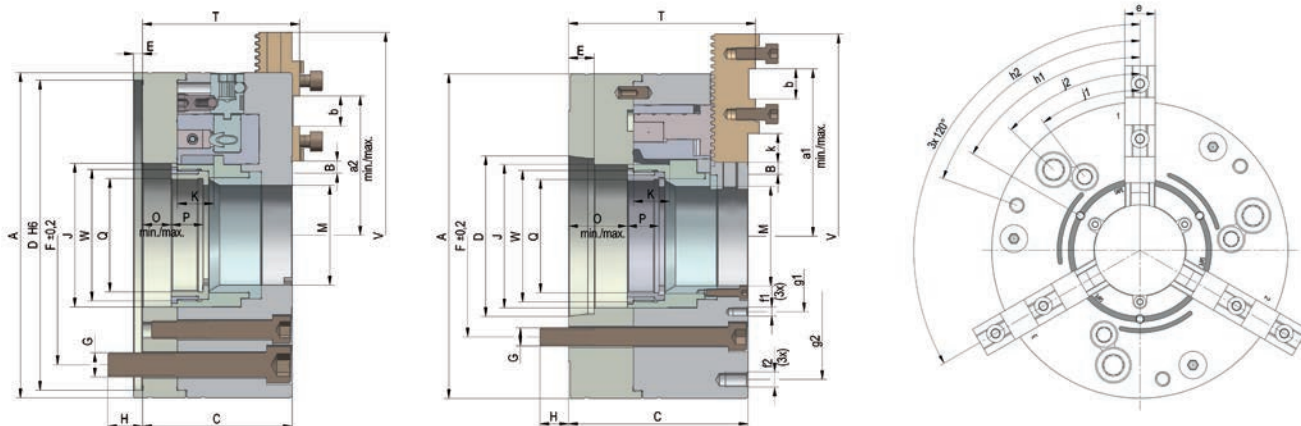
Item No.	438355 ▲	438356 ▲	438357 ▲	438358 ▲	438359 ▲	438360 ▲	438361 ▲	438362 ▲	438363 ▲	438364 ▲	438365 ▲
Size	180	180	180	180	215	215	215	260	260	260	260
Toothing	4,712	4,712	4,712	4,712	4,712	4,712	4,712	5,498	5,498	5,498	5,498
A mm	180	180	180	180	215	215	215	260	260	260	260
Jaw travel B mm	6,9	6,9	6,9	6,9	7,8	7,8	7,8	8,8	8,8	8,8	8,8
C mm	91,8	91,8	104,8	105,8	105	119	121	121	121	136	138
D mm	ZA 140	ZA 170	KK 5	KK 6	ZA 170	KK 6	KK 8	ZA 170	ZA 220	KK 6	KK 8
E mm	6	6	16	17	6	17	19	6	6	17	19
F mm	104,8	133,4	104,8	133,4	133,4	133,4	171,4	133,4	171,4	133,4	171,4
G mm	M10	M12	M10	M12	M12	M12	M16	M12	M16	M12	M16
H mm	14	16	16	17	17	17	24	17	26	17	24
J mm	78	78	78	78	95	95	95	115	115	110	110
Wedge stroke K mm	21	21	21	21	24	24	24	28	28	28	28
M mm	53	53	53	53	66	66	66	81	81	81	81
O min.	1	1	14	15	1	15	17	1	1	15	17
O max.	22	22	35	36	25	39	51	29	29	43	45
P mm	17	17	17	17	21	21	21	22	22	22	22
Q mm	M60x1,5	M60x1,5	M60x1,5	M60x1,5	M75x1,5	M75x1,5	M75x1,5	M90x1,5	M90x1,5	M90x1,5	M90x1,5
T mm	98,2	98,2	111,2	112,2	109,9	123,9	125,9	129,5	129,5	144,5	146,5
V max. mm	213	213	213	213	269	269	269	313	313	313	313
W mm	M72x1,5	M72x1,5	M72x1,5	M72x1,5	M87x2	M87x2	M87x2	M105x1,5	M105x1,5	M105x1,5	M105x1,5
a min.	59,1	59,1	59,1	59,1	77,9	77,9	77,9	96,8	96,8	96,8	96,8
a max.	87,4	87,4	87,4	87,4	110,9	110,9	110,9	129,8	129,8	129,8	129,8
a 2 min.	50,1	50,1	50,1	50,1	58,9	58,9	58,9	64,8	64,8	64,8	64,8
a 2 max.	78,4	78,4	78,4	78,4	91,9	91,9	91,9	97,8	97,8	97,8	97,8
Index adjustment	6 (x4,712 =28,3)	6 (x4,712 =28,3)	6 (x4,712 =28,3)	6 (x4,712 =28,3)	7 (x4,712 =32,98)	7 (x4,712 =32,98)	7 (x4,712 =32,98)	6 (x5,5 =33)	6 (x5,5 =33)	6 (x5,5 =33)	6 (x5,5 =33)
b mm	18	18	18	18	20	20	20	20	20	20	20
e mm	20	20	20	20	22	22	22	26	26	26	26
f1	M6/10	M6/10	M6/10	M6/10	M6/10	M6/10	M6/10	M8/15	M8/15	M8/15	M8/15
f2	M8/15	M8/15	M8/15	M8/15	M10/15	M10/15	M10/15	M10/15	M10/15	M10/15	M10/15
g1 mm	83	83	83	83	94	100	100	124	124	124	124
g2 mm	155	155	155	155	190	190	190	220	220	220	220
h1	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
h2	60°	60°	60°	60°	70°	70°	70°	77°	77°	77°	77°
j1	35°	35°	35°	35°	37°	37°	37°	30°	30°	30°	30°
j2	45°	45°	45°	45°	47°	47°	47°	40°	40°	40°	40°
k mm	9	9	9	9	19	19	19	32	32	32	32
Maximum draw bar pull kN	33	33	33	33	52	53	53	73	73	73	73
Max. total clamping force approx. kN	60	60	60	60	95	100	100	135	135	135	135
Max. admissible speed min ⁻¹	6300	6300	6300	6300	6000	6000	6000	4700	4700	4700	4700
Weight without jaws approx. kg	18	18	18	18	24	26	26	44	44	47	49
Actuating cylinders (recommended)	OVS-105 / SZS-52/130	OVS-105 / SZS-52/130	OVS-105 / SZS-52/130	OVS-105 / SZS-52/130	OVS-130 / SZS-67/130	OVS-130 / SZS-67/130	OVS-130 / SZS-67/130	OVS-150 / SZS-86/200	OVS-150 / SZS-86/200	OVS-150 / SZS-85/200	OVS-150 / SZS-85/200

Power chuck
DURO-NCSE



Power chucks with quick jaw change system

DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth



C 15
3-jaw power chucks DURO-NCSE with quick jaw change system, with individual jaw unlocking, with straight teeth
Cylindrical centre mount DIN 6353 / short taper mount ISO 702-1 (DIN 55026/55021)

Item No.	438366	438367 ▲	438368	438369	438370 ▲	438371 ▲	438372	438373	438374 ▲	438375 ▲	438376 ▲	438377 ▲	438378 ▲
Size	315	315	315	315	400	400	400	400	500	500	500	630	630
Toothing	5,498	5,498	5,498	5,498	5,498	5,498	5,498	5,498	7	7	7	7	7
A mm	315	315	315	315	400	400	400	400	500	500	500	630	630
Jaw travel B mm	9,1	9,1	9,1	9,1	9,8	9,8	9,8	9,8	11,4	11,4	11,4	12,6	12,6
C mm	130	130	146	148	138	138	156	157	162	180	181	179,5	198,5
D mm	ZA 220	ZA 300	KK 8	KK 11	ZA 300	ZA 380	KK 11	KK 15	ZA 380	KK 11	KK 15	ZA 520	KK 15
E mm	6	6	19	21	8	8	21	23	8	21	23	8	23
F mm	171,4	235	171,4	235	235	330,2	235	330,2	330,2	235	330,2	463,6	330,2
G mm	M16	M20	M16	M20	M20	M24	M20	M24	M24	M20	M24	M24	M24
H mm	27	27	26	24	26	36,5	28	37,5	36	30	37	36	37
J mm	140	140	140	140	175,5	175,5	175,5	175,5	207	207	207	235	235
Wedge stroke K mm	28	28	28	28	30	30	30	30	35	35	35	40	40
M mm	104	104	104	104	128	128	128	128	155	155	155	167	167
O min.	1,5	1,5	17,5	19,5	1,5	1,5	19,5	20,5	1,5	19,5	20,5	1,5	20,5
O max.	29,5	29,5	45,5	47,5	31,5	31,5	49,5	50,5	36,5	54,5	55,5	41,5	60,5
P mm	25	25	25	25	29	29	29	29	29	29	29	35	35
Q mm	M110x2	M110x2	M110x2	M110x2	M138x2	M138x2	M138x2	M138x2	M165x2	M165x2	M165x2	M180x2	M180x2
T mm	139	139	155	157	147	147	165	166	172	190	191	189,5	208,5
V max. mm	351	351	351	351	424	424	424	424	524	524	524	643	643
W mm	M130x1,5	M130x1,5	M130x1,5	M130x1,5	M160x2	M160x2	M160x2	M160x2	M188x2	M188x2	M188x2	M215x2	M215x2
a min.	110,4	110,4	110,4	110,4	115,5	115,5	115,5	115,5	155,9	155,9	155,9	194,4	194,4
a max.	159,9	159,9	159,9	159,9	181,5	181,5	181,5	181,5	225,9	225,9	225,9	285,4	285,4
a 2 min.	66,4	66,4	66,4	66,4	76,5	76,5	76,5	76,5	94,9	94,9	94,9	94,4	94,4
a 2 max.	115,9	115,9	115,9	115,9	142,5	142,5	142,5	142,5	164,9	164,9	164,9	185,4	185,4
Index adjustment	9 (x5,5=49,5)	9 (x5,5=49,5)	9 (x5,5=49,5)	9 (x5,5=49,5)	12 (x5,5=66)	12 (x5,5=66)	12 (x5,5=66)	12 (x5,5=66)	10 (x7=70)	10 (x7=70)	10 (x7=70)	13 (x7=91)	13 (x7=91)
b mm	20	20	20	20	26	26	26	26	30	30	30	30	30
e mm	32	32	32	32	32	32	32	32	45	45	45	45	45
f1	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/15	M8/16	M8/16	M8/16	M8/16	M8/16
f2	M12/20	M12/20	M12/20	M12/20	M16/20	M16/20	M16/20	M16/20	M20/37	M20/37	M20/37	M16/30	M16/30
g1 mm	140	140	140	140	170	170	170	170	200	200	200	245	245
g2 mm	268	238	268	268	330,2	330,2	330,2	330,2	420	420	420	520	520
h1	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
h2	77°	77°	77°	77°	70°	70°	70°	70°	77°	77°	77°	47°	47°
j1	40°	40°	40°	40°	42,5°	42,5°	42,5°	42,5°	30°	30°	30°	45°	45°
j2	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	45°	60°	60°
k mm	43	43	43	43	39	39	39	39	57	57	57	97	97
Maximum draw bar pull kN	100	100	100	100	133	133	133	133	173	173	173	173	173
Max. total clamping force approx. kN	180	180	180	180	240	240	240	240	305	305	305	312	312
Max. admissible speed min ⁻¹	4000	4000	4000	4000	3500	3500	3500	3500	2200	2200	2200	1700	1700
Moment of inertia J kgm ²	0,96	0,96	0,96	0,96	2,67	2,67	2,67	2,67	16,1	16,1	16,1	22,8	22,8
Weight without jaws approx. kg	66	66	69	70	110	110	118	121	216	233	235	393	430
Actuating cylinders (recommended)	OVS-200 / SZS-110/230	OVS-200 / SZS-110/230	OVS-200 / SZS-110/250	OVS-200 / SZS-110/250	OVS-200 / SZS-127/325	OVS-200 / SZS-127/325	OVS-200 / SZS-127/325	OVS-200 / SZS-127/325	OVS-200	OVS-200	OVS-200	OVS-200	OVS-200

Balancing quality G 6.3 in acc. with DIN 1940

Power chuck
DURO-NCSE



Power chucks with quick jaw change system

Jaws DURO-NCSE

C 21

Base jaws, 3-jaw-set, hardened straight toothing, incl. cylinder screws, DIN 912-12.9



Item no.	Chuck Size	Jaw length mm	Jaw width mm
463548	180	65	20
463549	215	85	22
463550	260	104	26
463551	315	115	32
463552	400	125	32
463553	500	160	45
463554▲	630	200	45

A 36

Reversible top jaws, 3-jaw set, hardened tongue and groove for external and internal clamping - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094012	180	61,5	32,5	20,4
094013	215	70,5	38	24,4
094014	260/315	92	50	34,4
094015	400	107	56	35,7
094045	500/630	130	72	50,4

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

A28

Unstepped top jaw AB, 3-jaw set standard design, soft, material 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
094008	180	85	36,5	20,3
094009	215	105	40	22
094010	260/315	125	50	30
094011	400	145	50	34,3
094046	500/630	180	73	50,5

C 21

One-piece reversible jaws, 3-jaw set, hardened, straight toothing - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463555	180	58	44	20
463556	215	75	51	22
463557	260	90	60	26
463558	315	117	66	32
463559	400	137	70	32
463560▲	500	176	93	45

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21

Soft one-piece jaws, 3-jaw set, can be hardened, straight toothing, guidance hardened and ground - material: 16MnCr5



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
463562▲	180	65	55	20
463563▲	215	84	65	22
463564	260	99	84	26
463565	315	121	90	32
463566▲	400	148	100	32
463567▲	500	175	124	45
463568▲	630	230	134	45



Power chucks with quick jaw change system

Jaws DURO-NCSE

C 21
Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137060	180	66	37,5	24
137119	500/630	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137061	180	66	37,5	20
137064	215	81	43	24
137108	260/315	90	55	34
137114	400	100	62	34
137120	500/630	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137062	180	56	37,5	20
137065	215	66	43	24
137109	260/315	72	55	34
137115	400	86	62	34
137121	500/630	100	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137066	215	79	43	34
137110	260/315	80	55	50
137116	400	93	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137067	215	81	43	34
137111	260/315	90	55	50
137117	400	106	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137068	215	66	43	34
137112	260/315	72	55	50
137118	400	86	62	50

Jaws DURO-NCSE



Power chucks with quick jaw change system

Jaws DURO-NCSE

C 21

Draw-down jaws, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485522 ▲	180	65	43	20
485524 ▲	215	85	47	22
485526	260	104	58	26
485528 ▲	315	115	63	32
485530 ▲	400	125	63	32
485532 ▲	500	160	81	45

C 21

Draw-down jaws, additional clamping range, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
485523 ▲	180	72	43	20
485525 ▲	215	95	47	22
485527 ▲	260	104	58	26
485529 ▲	315	123	63	32
485531 ▲	400	134	63	32
485533 ▲	500	160	81	45

C 15

Interchangeable clamping inserts, 1 piece with claws



Item no.	Chuck Size
141049	180/215
141052	260/315/400
141055 ▲	500

C 15

Interchangeable clamping inserts, 1 piece with serrated toothing



Item no.	Chuck Size
141050	180/215
141053	260/315/400
141056 ▲	500

C 15

Interchangeable clamping inserts, 1 piece with heat treatable surface



Item no.	Chuck Size
141051	180/215
141054	260/315/400
141057 ▲	500

Jaws DURO-NCSE



Power chucks with quick jaw change system

Accessories DURO-NCSE

C 15 Mounting screws



Item no.	Size	Contents of delivery	Thread
233058	180/215	piece	M8x20
233030	260/315/400	piece	M12x30
216569	500/630	piece	M16x40

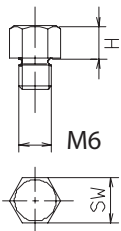
Socket head cap screw to DIN 912, 12.9

C 15 Special grease F80 for lathe chucks for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C 15 Changeable workpiece rests (in different lengths)



Item no.	H mm	M	Key-width SW
289188	5	M6	9
138950	10	M6	9
725581	15	M6	9

C15 Grease gun DIN1283



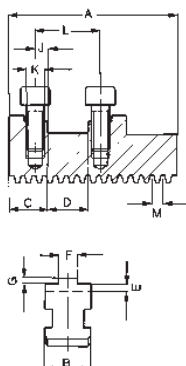
Item no.	Connection	Contents of delivery
329093	M10x1	150 mm nozzle tube bent, needlepoint mouthpiece, top mouthpiece, 300 mm high pressure hose with 4 jaw hydraulics cross mouthpiece



Technical data

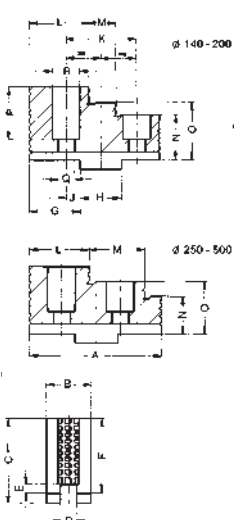
Jaw dimensions DURO-NCSE

Base jaw GB, with screws



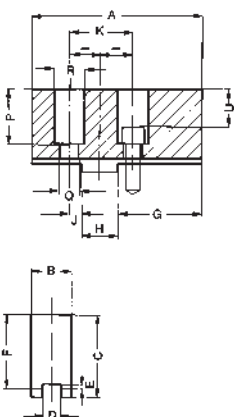
Chuck size	180	215	260	315	400	500	630
Type	574-11	574-11	574-11	574-11	574-11	574-11	574-11
Item no. 3-jaw set	463548	463549	463550	463551	463552	463553	463554
A	65	85	104	115	125	160	200
B	20	22	26	32	32	45	45
C	19	23	26	26	30	35	35
DH7	18	20	20	20	26	30	30
E	5	4,5	5,5	6	6	9	9
F	8	10	12	12	12	16	18
G	2,5	2,5	3	3	3	4	4
J	7	10	10	10	14	15	15
K	M8	M8	M12	M12	M12	M16	M16
L	32	40	40	40	54	60	60
M	4,712	4,712	5,498	5,498	5,498	7	7
Weight/set kg	0,7	1,0	1,8	2,7	3,0	7,1	9

Reversible top jaws UB, hardened



Chuck size	180	215	260	315	400	500	630
Type	003-20	003-25	003-30	003-30	003-35	003-40	003-40
Item no. 3-jaw set	094012	094013	094014	094014	094015	094045	094045
A	61,5	70,35	92	92	107	130	130
B	20,4	24,4	34,4	34,4	37,5	50,4	50,4
C	37	43	55	55	62	79	79
D	8	10	12	12	12	18	18
E	3	3,5	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	50	56	72	72
G	22,5	25,5	30	30	35,5	41,4	41,4
H	18	20	20	20	26	30	30
J	7	10	10	10	14	15	15
K	32	40	40	40	54	60	60
L	26,5	28,5	41	41	40	51	51
M	13	14	40,5	40,5	54	71	71
N	17,5	18	22	22	26	32	32
O	25	28	36	36	41	52	52
P	23,5	29	39	39	40	57	57
Q	9	9	14	14	14	18	18
R	15	15	20	20	20	26	26
Weight/set kg	0,6	1,0	2,4	2,4	3,4	7,6	7,6

Soft top jaws AB, material 16MnCr5



Chuck size	180	215	260	315	400	500	630
Type	002-20	002-25	002-30	002-30	002-35	002-40	002-40
Item no. 3-jaw set	094008	094009	094010	094010	094011	094046	094046
A	85	105	125	125	145	180	180
B	20,3	22	30	30	34,3	50,5	50,5
C	41	45	55	55	56	80	80
D	8	10	12	12	12	18	18
E	3	3,5	3,5	3,5	3,5	4,5	4,5
F	36,5	40	50	50	50	73	73
G	42	50	70	70	74	100	100
H	18	20	20	20	26	30	30
J	7	10	10	10	14	15	15
K	32	40	40	40	54	60	60
P	27,5	31	39	39	34	58	58
Q	9	9	14	14	14	18	18
R	15	15	20	20	20	26	26
U	19,5	23	27	27	22	42	42
Weight/set kg	1,3	2,2	4,5	4,5	6,8	13,2	13,2

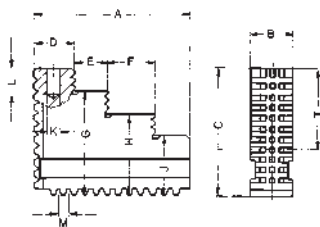
Jaw dimensions
DURO-NCSE



Technical data

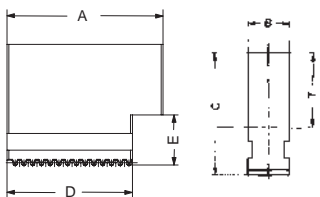
Jaw dimensions and chucking capacities DURO-NCSE

Reversible one-piece jaws EB



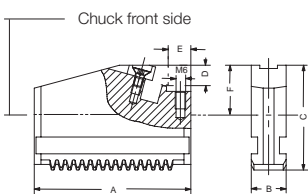
Chuck size	180	215	260	315	400	500/630
Type	574-27	574-27	574-27	574-27	574-27	574-27
Item no. 3-jaw set	463555	463556	463557	463558	463559	463560
A	58	75	90	117	137	176
B	20	22	26	32	32	45
C	44	51	60	66	70	93
G	37	43	50	56	59	73
H	30	35	40	46	48	-
J	23	27	30	36	37	53
M	4,712	4,712	5,498	5,498	5,498	7
T	23	26	31	32	36	46
Weight/set kg	0,6	1,3	2,0	3,4	4,4	11,7

Soft one-piece jaws BL, material 16MnCr5



Chuck size	180	215	260	315	400	500	630
Type	574-37	574-37	574-37	574-37	574-37	574-37	574-37
Item no. 3-jaw set	463562	463563	463564	463565	463566	463567	463568
A	65	84	99	121	148	175	230
B	20	22	26	32	32	45	45
C	55	65	84	90	100	124	134
D	56	67,5	77	93	120	154	200
E	25	27	36	41	41	54	54
T	33	38	53	54	64	77	87
Weight/set kg	1,3	2,2	4,3	6,7	9,2	20,5	29,2

Draw-down jaws NBG, Straight toothing, for interchangeable clamping inserts (jaw with insert)

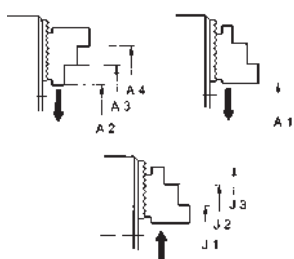


Chuck size	180	215	260	315	400	500
Jaw design	Type 545-30					
Item no. piece	485522	485524	485526	485528	485530	485532
A	65	85	104	115	125	160
B	20	22	26	32	32	45
C	43	47	58	63	63	81
D	15	15	20	20	20	20
E	11	12	12	12	12	12
F	22,5	22,5	29,5	29,5	29,5	34
Capacities external	38-71	38-102	45-124	42-164	50-190	67-217
Capacities internal	125-160	170-223	207-289	234-344	252-397	346-500
Max. swing	197	251	306	374	425	524

Draw-down jaws NBG, for interchangeable clamping inserts (jaw without insert), jaws for further clamping ranges

Chuck size	180	215	260	315	400	500
Jaw design	Type 549-30					
Item no. piece	485523	485525	485527	485529	485531	485533
A	72	95	104	123	134	160
E	30	45	50,5	61,5	67	96
Capacities external	78-110	113-168	123-202	146-262	160-305	230-384
Capacities internal	98-122	114-166	131-214	136-245	140-285	180-332
Max. swing	197	271	306	390	443	524

Chucking capacities with reversible top jaws UB

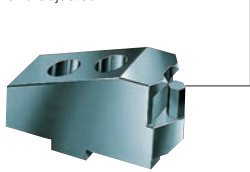


Chuck size	Jaw position	180	215	260	315	400	500	630
External chucking	A1	11-68	18-84	27-104	25-163	28-240	30-304	30-425
	A2	33-90	59-125	-	-	-	-	-
	A3	77-134	115-181	83-149	111-213	98-243	54-290	55-407
	A4	103-160	143-209	165-230	193-295	206-351	195-430	195-549
Internal chucking	J1	65-122	75-141	108-185	143-245	85-230	133-408	133-525
	J2	91-148	103-169	189-266	225-327	192-337	233-548	272-667
	J3	135-192	159-225	-	-	-	-	-

Jaw dimensions DURO-NCSE

Reversible claw-type top jaws KB, standard design

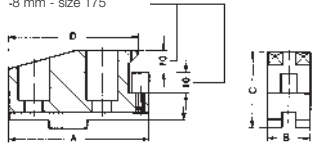
Workpiece stop can be changed and adjusted



Chuck size	180	500	630
Jaw design	Type 544-00 Standard design		
Item no. piece	137060	137119	137119
A	66	124	124
B	24	50	50
C	37,5	62	62
D	17	39	39
Capacities external	130-159	314-477	390-584
Capacities internal	53-84	101-249	101-290

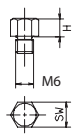
Jaws for further clamping ranges

-8 mm - size 175



Chuck size	180	215	260	315	400	500	630
Jaw design	Type 544-00 Standard design						
Item no. piece	137061	137064	137108	137108	137114	137120	137120
A	66	81	90	90	100	124	124
B	20	24	34	34	34	50	50
C	37,5	43	55	55	62	62	62
D	61	71	78	78	90	112	112
Capacities external	25-56	41-103	48-150	48-210	53-237	143-294	216-411
Capacities internal	136-188	181-255	85-238	136-300	240-435	268-420	265-460

Accessories: interchangeable workpiece stop (different lengths)

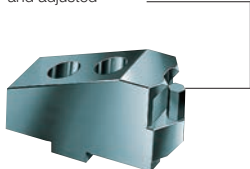


Item no.	289188	138950	725581
M	M6	M6	
H	5	10	15
SW		9	

Chuck size	180	215	260	315	400	500	630
Jaw design	Type 544-00 Standard design						
Item no. piece	137062	137065	137109	137109	137115	137121	137121
A	56	66	72	72	86	100	100
B	20	24	34	34	34	50	50
C	37,5	43	55	55	62	62	62
D	29	38,5	38	38	42	48	48
Capacities external	68-120	94-168	77-230	127-292	172-333	270-422	345-540
Capacities internal	93-126	116-200	85-238	136-300	168-329	142-293	139-333

Reversible claw-type top jaws KB, large design

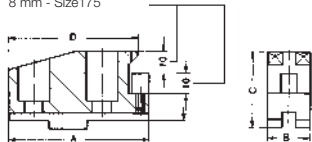
Workpiece stop can be changed and adjusted



Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137066	137110	137110	137116
A	79	80	80	93
B	34	50	50	50
C	43	55	55	62
D	29,5	29	29	30
Capacities external	121-226	-	-	-
Capacities internal	74-172	73-203	80-264	130-291

Jaws for further clamping ranges

8 mm - Size175



Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137067	137111	137111	137117
A	81	90	90	106
B	34	50	50	50
C	43	55	55	62
D	71	78	78	90
Capacities external	44-124	53-152	70-214	76-237
Capacities internal	160-274	163-322	222-384	168-425

Chuck size	215	260	315	400
Jaw design	Type 544-05 Large design			
Item no. piece	137068	137112	137112	137118
A	66	72	72	86
B	34	50	50	50
C	43	55	55	62
D	38,5	38	38	42
Capacities external	79-188	77-230	127-292	172-333
Capacities internal	105-210	85-238	136-300	168-329



Power chucks with quick jaw change system

DURO-NC - central jaw unlocking



APPLICATION

Standard power chuck with through-hole for flexible use thanks to quick jaw change system.

TYPE

Power chuck available with cylindrical centre mount.
3-jaw version.

CUSTOMER BENEFITS

- ③ Universal: Jaws can be offset, exchanged or turned
- ③ For high speeds thanks to lightweight jaws
- ③ High clamping precision and clamping force thanks to proven wedge hook system
- ③ Possible to use jaw units of the DURO manual clamping chuck

TECHNICAL FEATURES

- Central locking of the quick jaw change system
- Power transmission by means of wedge hook system
- Base jaws angle-serrated

Note:

The safety key can only be pulled out once the jaws are locked. This setup in combination with the key switch integrated in the machine also prevents the machine spindle from starting up unintentionally when the jaws are unlocked.

Included in the scope of delivery:

Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench

NC = NC machine



Gripping force / speed diagrams

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

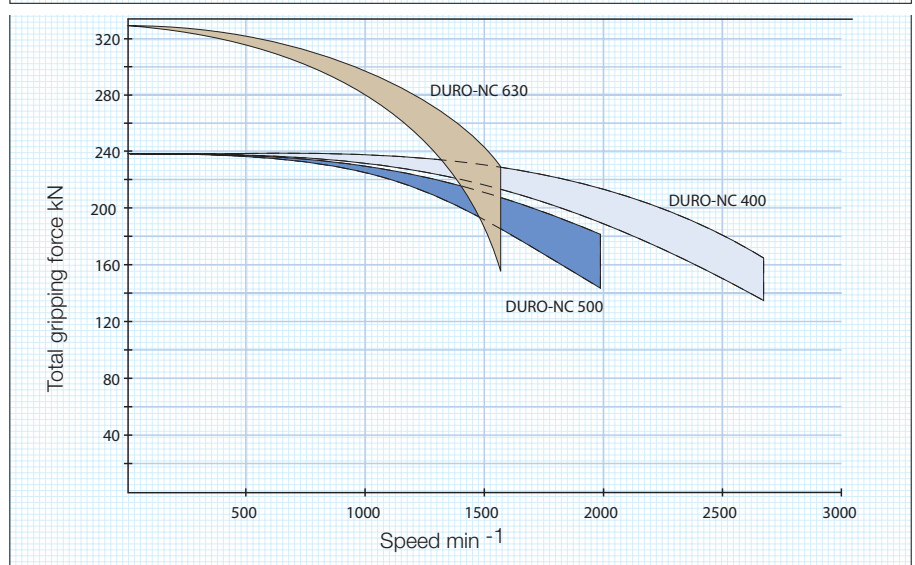
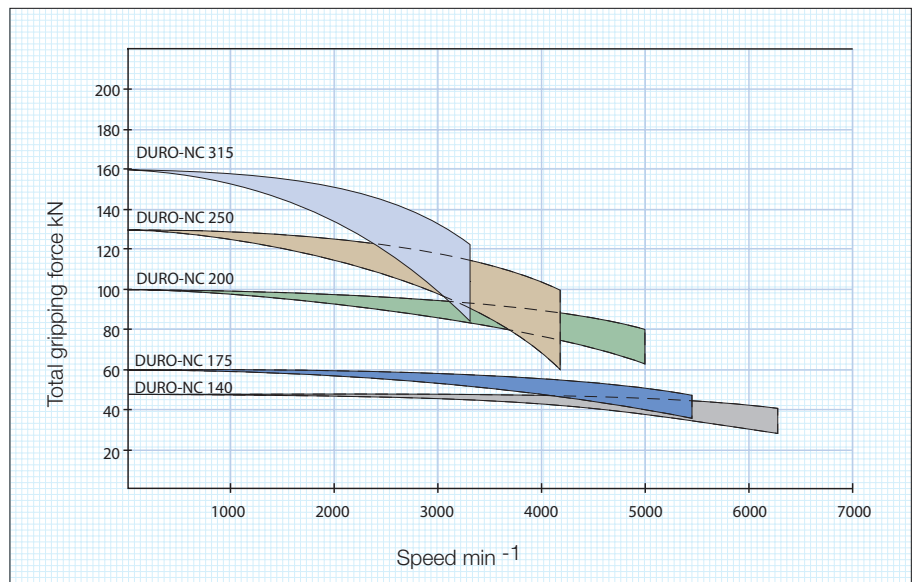
Upper curve:
min. centrifugal
force of top jaw



Lower curve:
max. centrifugal
force of top jaw



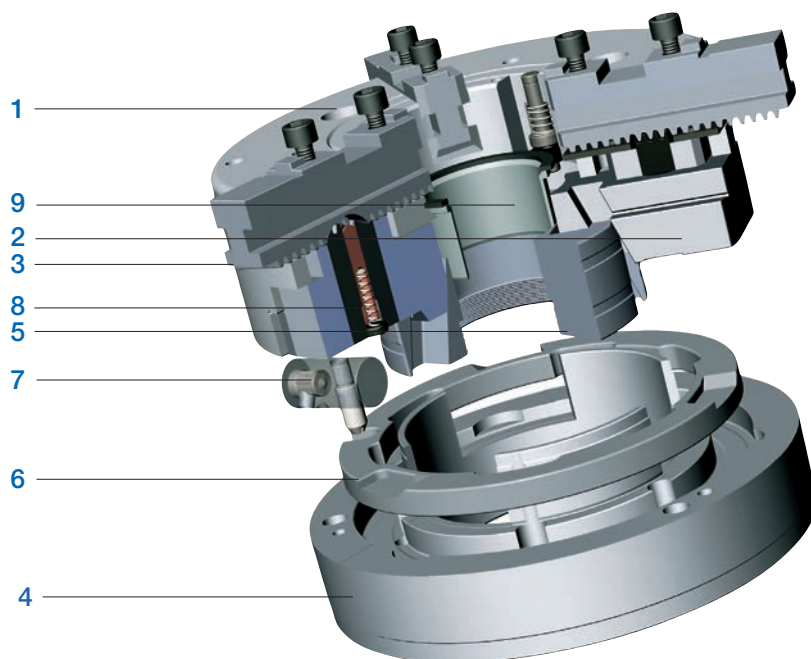
To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.
Measuring point near chuck face.



Power chuck with quick jaw change system



Structure DURO-NC - central jaw unlocking



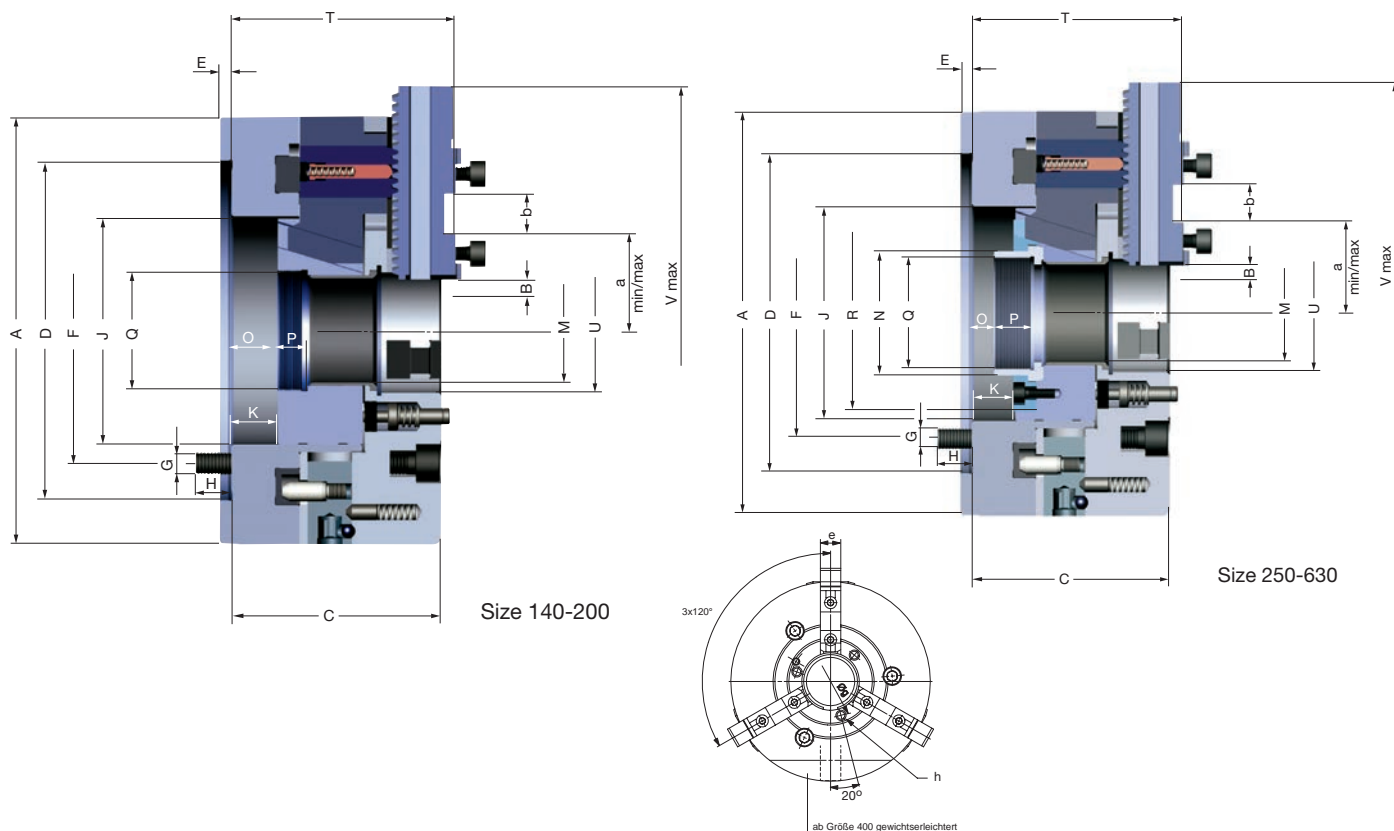
Components:

1. Body
2. Guide jaw
3. Base jaw
4. Adaptor plate
5. Piston
6. Adjusting ring
7. Turnable bolt
8. Rack
9. Protective bush



Power chucks with quick jaw change system

DURO-NC 3-jaw, central jaw unlocking, angle-serrated



C 15

3-jaws power chuck DURO-NC, with quick jaw change systems, central jaw unlocking, angle-serrated
Cylindrical centre mount, mounting dimensions to DIN 6353

Item No.	159455 ▲	159456	159457	159458	159459	159460 ▲	159461 ▲	159462 ▲
Size	140	175	200	250	315	400	500	630
A mm	145	175	215	260	320	400	500	630
Jaw travel B mm	4,9	6,7	7	8,25	10,1	11,5	11,5	11,5
C mm	83	99	105	126	152	149	149	169
Mount D ¹⁶	120	140	170	220	300	380	380	380
E mm	6	6	6	6	6	6	6	6
F mm	104,8	104,8	133,4	171,4	235	330,2	330,2	330,2
G mm	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 20	3 x M 24	3 x M 24	6 x M 24
H mm	18	15	18	21	29	35	35	36
J mm	80	88	114	147	173	210	210	286
Wedge stroke K mm	16	22	23	27	33	46	46	46
M mm	35	43	52	72	91	108	108	140
N mm	-	-	-	-	-	124	124	160
O min.	0,5	0	0	0	0	-61	-61	-41
O max.	16,5	22	23	27	33	-15	-15	5
P mm	9	10	15	15	19	35	35	25
Q mm	M 45 x 1,5	M 50 x 1,5	M 60 x 1,5	M 80 x 1,5	M 100 x 2	M 115 x 2	M 115 x 2	M 148 x 2
R mm	-	-	-	130	160	169	169	219
T mm	89	105	112	134	160,6	158,6	158,6	185
U mm	40	50	62	81	103	120	120	192
V max. mm	181	236	294	351	423	523	570	771
a min.	31,4	33,2	35,5	42,8	52,3	67,1	73,5	86,8
a max.	53,2	62,3	79,5	91,1	115,7	135,5	159	206,1
b mm	18	18	20	20	26	30	30	40
e mm	18	20	22	26	32	45	45	65
Ø g	54	64	76	93	120	140	140	210
h	M 5 x 8	M 6 x 10	M 6 x 10	M 6 x 10	M 6 x 10	M 8 x 12	M 8 x 12	M 8 x 12
Maximum draw bar pull kN	25	30	50	65	80	110	110	150
Max. total clamping force approx. kN	49	60	100	130	160	240	240	330
Max. admissible speed min ⁻¹	6300	5300	5000	4300	3200	2700	2000	1500
Moment of inertia J kgm ²	0,029	0,068	0,162	0,39	1,08	2,5	5	15,4
Weight without jaws approx. kg	11	18	28	46	85	126	185	310
Actuating cylinders (recommended)	OVS-105 / SZS-37/70	OVS-105 / SZS-46/103	OVS-130 / SZS-52/130	OVS-150 / SZS-67/150	OVS-150 / SZS-92/225	OVS-200 / SZS-110/230	OVS-200 / SZS-110/250	OVS-200 / SZS-127/325



Power chucks with quick jaw change system

Jaws DURO-NC

A28

Base jaw GB, 3-jaw set diagonally toothing, with mounting bolts



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw width mm
140636	140	3	set	56	18
094004	175	3	set	74	20
094005	200	3	set	90	22
094006	250	3	set	110	26
094007	315	3	set	125	32
094044	400/500	3	set	160	45
140194	630	3	set	230	65

A28

Unstepped top jaw AB, 3-jaw set standard design, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094008	140/175	3	set	85	36,5	20,3
094009	200	3	set	105	40	22
094010	250	3	set	125	50	30
094011	315	3	set	145	50	34,3
094046	400/500	3	set	180	73	50,5
140716	630	3	set	260	102	68

A28

Reversible top jaw UB, 3-jaw set hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094012	140/175	3	set	61,5	32,5	20,4
094013	200	3	set	70,5	38	24,4
094014	250	3	set	92	50	34,4
094015	315	3	set	107	56	35,7
094045	400/500	3	set	130	72	50,4
140715	630	3	set	185	102	68

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

A28

Unstepped Jaw BL, 3-jaw set diagonally toothing, unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
626158	140	3	set	70,5	41,5	18
241699	175	3	set	84,4	45	20
249678	200	3	set	98,4	60	22
249679	250	3	set	118,7	70	26
249680	315	3	set	136,6	79	32
249681	400/500	3	set	173,6	93	45

A28

One-piece jaw EB, 3-jaw set diagonally toothing, hardened



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
140764	140	3	set	62	49,5	18
094000	175	3	set	77,7	45	20
094001	200	3	set	94,7	60	22
094002	250	3	set	114	70	26
094003	315	3	set	130	79	32
094043	400/500	3	set	167	93	45

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



Power chucks with quick jaw change system

Jaws DURO-NC

C 21
Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137060	140/175	66	37,5	24
137119	400/500	124	62	50
151288	630	144	78	70

C 21
Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137061	140/175	66	37,5	20
137064	200	81	43	24
137108	250	90	55	34
137114	315	100	62	34
137120	400/500	124	62	50

C 21
Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137062	140/175	56	37,5	20
137065	200	66	43	24
137109	250	72	55	34
137115	315	86	62	34
137121	400/500	100	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137066	200	79	43	34
137110	250	80	55	50
137116	315	93	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137067	200	81	43	34
137111	250	90	55	50
137117	315	106	62	50

C 21
Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137068	200	66	43	34
137112	250	72	55	50
137118	315	86	62	50

Jaws DURO-NC



Power chucks with quick jaw change system

Jaws DURO-NC

C 21

Draw-down jaws, for interchangeable clamping inserts diagonally toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
151030 ▲	140	63	41,5	18
141037	175	84,4	43,5	20
141039	200	98,4	47,5	22
141041	250	118,7	58,5	26
141043	315	136,4	63,9	32
141045	400/500	173,6	73,4	45

C 21

Draw-down jaws, additional clamping range, for interchangeable clamping inserts diagonally toothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
151031 ▲	140	63	41,5	18
141038	175	84,4	43,5	20
141040	200	98,4	47,5	22
141042	250	118,7	58,5	26
141044	315	136,4	63,9	32
141046	400	173,6	73,4	45
141048	500	173,6	73,4	45

C 15

Interchangeable clamping inserts, 1 piece with claws



Item no.	Chuck Size
151029 ▲	140
141049	200
141052	250/315
141055 ▲	400/500

C 15

Interchangeable clamping inserts, 1 piece with serrated toothing



Item no.	Chuck Size
151039 ▲	140
141050	175/200
141053	250/315
141056 ▲	400/500

C 15

Interchangeable clamping inserts, 1 piece with heat treatable surface



Item no.	Chuck Size
151040 ▲	140
141051	200
141054	250/315
141057 ▲	400/500



Power chucks with quick jaw change system

Accessories DURO-NC

C 15 Mounting screws



Item no.	Size	Contents of delivery	Thread
200182	140/175/200	piece	M8x1x22
200183	250	piece	M12x1,5x30
202402	315	piece	M12x1,5x35
227618	400/500	piece	M16x1,5x40
249388	630	piece	M20x50

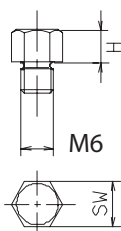
Socket head cap screw to DIN 912, 12.9

C 15 Special grease F80 for lathe chucks for lubrication and conservation of clamping force



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

C 15 Changeable workpiece rests (in different lengths)



Item no.	H mm	M	Key-width SW
289188	5	M6	9
138950	10	M6	9
725581	15	M6	9

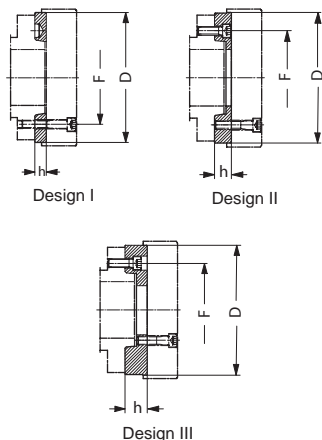
C15 Grease gun DIN1283



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

C 15

Intermediate adaptor plates with cylindrical centre mount **DIN 6353** for 3-jaw chucks
Mounting from front to **ISO 702-1 (DIN 55026/55021)** and **ASA B 5.9 A1/A2** with metric mounting bolts



Item no.	Spindle nose size	Size	Design	h mm	F mm	D mm
159878 ▲	5	140	I	15	104,8	120
145153	5	175	I	15	104,8	140
145297	6	175	III	35	133,4	140
182667	6	200	I	16	133,4	170
145131	6	250	II	27	133,4	220
145135	8	200	III	39	171,4	170
145157	8	250	I	18	171,4	220
145139 ▲	8	315	II	38	171,4	300
145143 ▲	11	250	III	48	235	220
145159	11	315	I	19	235	300
145147	11	400	II	40	235	380
145161	15	400/500/630	I	21	330,2	380

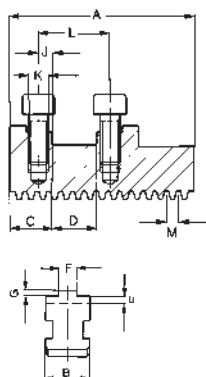
All fastening parts are included



Technical data

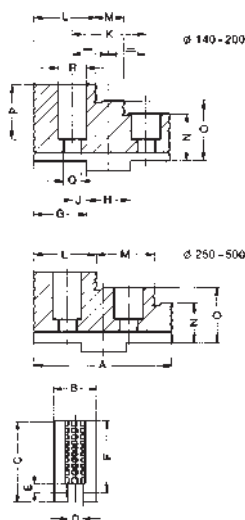
Jaw dimensions DURO-NC

Base jaw GB with screws



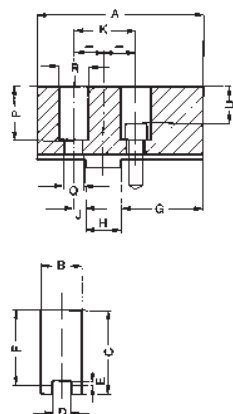
Chuck size	140	175	200	250	315	400/500	630
Type	503-80	002-20	002-25	002-30	002-35	002-40	002-50
Item no. 3-jaw set	140636	094004	094005	094006	094007	094044	140194
A	56	74	90	110	125	160	230
B	18	20	22	26	32	45	65
C	19	19	23	26	30	35	52
D ^{H6}	18	18	20	20	26	30	40
E	5	5	5,5	5,5	6,5	7,5	9
F	8	8	10	12	12	18	24
G	2,5	2,5	3	3	3	4	4
J	7	7	10	10	14	15	21
K	M8x1	M8x1	M8x1	M12x1,5	M12x1,5	M16x1,5	M20
L	32	32	40	40	54	60	82
M	3,63	4,84	4,89	6,03	7,05	8,55	8,53
Weight/set kg	0,43	0,8	1,1	2,1	3,2	7	17

Reversible top jaws UB, hardened



Chuck size	140/175	200	250	315	400/500	630
Type	003-20	003-25	003-30	003-35	003-40	003-50
Item no. 3-jaw set	094012	094013	094014	094015	094045	140715
A	61,5	70,35	92	107	130	185
B	20,4	24,4	34,4	37,5	50,4	68
C	37	43	55	62	79	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	32,5	38	50	56	72	102
G	22,5	25,5	30	35,5	41,4	59
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
L	26,5	28,5	41	40	51	80
M	13	14	40,5	54	71	80
N	17,5	18	22	26	32	42
O	25	28	36	41	52	72
P	23,5	29	39	40	57	82
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
Weight/set kg	0,6	1,0	2,4	3,4	7,6	19

Soft top jaws AB, material 16MnCr5



Chuck size	140/175	200	250	315	400/500	630
Type	002-20	002-25	002-30	002-35	002-40	002-50
Item no. 3-jaw set	094008	094009	094010	094011	094046	140716
A	85	105	125	145	180	260
B	20,3	22	30	34,3	50,5	68
C	41	45	55	56	80	110
D	8	10	12	12	18	24
E	3	3,5	3,5	3,5	4,5	4,5
F	36,5	40	50	50	73	102
G	42	50	70	74	100	150
H	18	20	20	26	30	40
J	7	10	10	14	15	21
K	32	40	40	54	60	82
P	27,5	31	39	34	58	83
Q	9	9	14	14	18	22
R	15	15	20	20	26	33
U	19,5	23	27	22	42	63
Weight/set kg	1,3	2,2	4,5	6,8	13,5	40

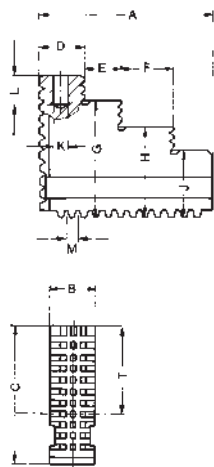
Jaw dimensions
DURO-NC



Technical data

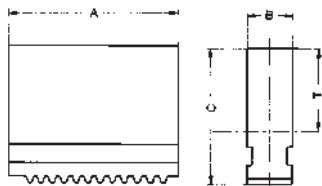
Jaw dimensions DURO-NC

One-piece reversible jaws EB



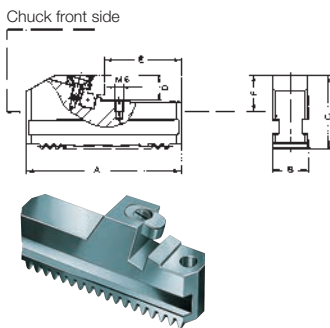
Chuck size	140	175	200	250	315	400/500
Type	503-80	000-20	000-25	000-30	000-35	000-40
Item no. 3-jaw	140764	094000	094001	094002	094003	0940043
A	62	77,7	94,7	114	130	167
B	18	20	22	26	32	45
C	49,5	45	60	70	79	93
D	16,6	20,6	23	41,5	40,2	50,6
E	15,9	18,9	19,5	40,3	54	71
F	18	22	28	-	-	-
G	42	37,5	50	56	64	73
H	34,5	30	40	-	-	-
J	27	22,5	30	42	49	53
K	7	8	10	13	13	20
L	16	16	15	19,5	19,5	30
M	3,63	4,84	4,89	6,03	7,05	8,55
T	29	24	35	41	44,5	54
Weight/set kg	1,2	1,5	1,9	3,4	5,5	11

Soft one-piece jaws BL, material 16MnCr5



Chuck size	140	175	200	250	315	400/500
Type	503-80	000-20	000-25	000-30	000-35	000-40
Item no. 3-jaw	626158	241699	249678	249679	249680	249681
A	70,5	84,5	98,4	118,7	136,6	173,6
B	18	20	22	26	32	45
C	41,5	45	60	70	79	93
T	21	24	35	41	44,5	54
Weight/set kg	1,3	1,5	2,7	4,4	7,2	15

Draw-down jaws NB for interchangeable clamping inserts (jaw without insert)



Chuck size	140	175	200	250	315	400	500
Type	545-00	545-00	545-00	545-00	545-00	545-00	545-00
Item no. Piece	151030	141037	141039	141041	141043	141045	141045
A	63	84,4	98,4	118,7	136,4	173,6	173,6
B	18	20	22	26	32	45	45
C	41,5	43,5	47,5	58,5	63,9	73,4	73,4
D	15	15	15	20	20	25	25
E	10,5	11	12	12	12	12	12
F	22,5	22,5	22,5	29,5	29,5	34,3	34,3
Capacities external	40-85	29-80	34-112	38-133	43-170	48-185	48-250
Capacities internal	124-168	162-205	190-263	235-325	275-398	360-490	354-556

Draw-down jaws NB for interchangeable clamping inserts (jaw without insert), jaws for further clamping ranges

Chuck size	140	175	200	250	315	400	500
Type	545-00	545-00	545-00	545-00	545-00	545-00	545-00
Item no. Piece	151031	141038	141040	141042	141044	141046	141048
E	31,5	32	48	58	72	77	110
Capacities external	80-125	70-120	104-185	128-225	160-290	175-316	240-450
Capacities internal	85-126	120-164	120-192	145-236	158-278	230-362	162-360

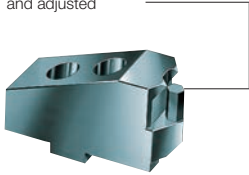
Accessories: changeable workpiece rests (in different lengths)

	2		
Item no.	289188	138950	725581
M	M6		
H	5	10	15
SW	9		

Jaw dimensions DURO-NC

Reversible claw-type top jaws KB, Standard design

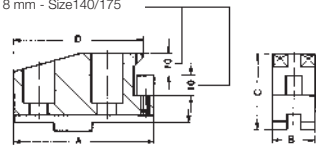
Workpiece stop can be changed and adjusted



Chuck size	140	175	400	500	630
Jaw design	Type 544-00 Standard design				
Item no. piece	137060		137119		151289
A	66		124		144
B	24		50		70
C	37,5		62		78
D	17		39		61
Capacities external	115-158	115-209	-	-	230-655
Capacities internal	50-84	50-136	100-350	100-410	185-610

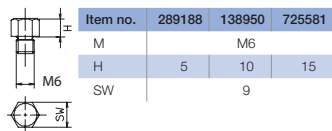
Jaws for further clamping ranges

8 mm - Size140/175



Chuck size	140	175	200	250	315	400	500
Jaw design	Type 544-00 Standard design						
Item no. piece	137061		137064	137108	137114	137120	
A	66		81	90	100		124
B	20		24	34	34		50
C	37,5		43	55	62		62
D	61		71	78	90		112
Capacities external	24-60	24-110	40-130	50-185	50-222	50-270	50-335
Capacities internal	142-182	142-236	166-288	180-350	212-410	280-515	280-580

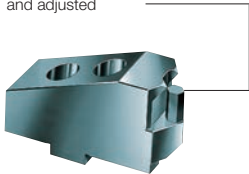
Accessories: changeable workpiece rests (in different lengths)



Chuck size	140	175	200	250	315	400	500
Jaw design	Type 544-00 Standard design						
Item no. piece	137062		137065	137109	137115	137121	
A	56		66	72	86		100
B	20		24	34	34		50
C	37,5		43	55	62		62
D	29		38,5	38	42		48
Capacities external	74-118	47-170	76-200	94-260	120-320	165-400	165-465
Capacities internal	80-130	80-176	98-224	104-272	116-315	155-395	155-455

Reversible claw-type top jaws KB, large design

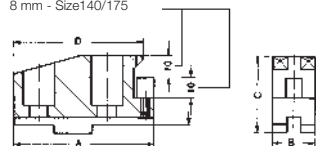
Workpiece stop can be changed and adjusted



Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. piece	137066	137110	137116
A	79	80	93
B	34	50	50
C	43	55	62
D	29,5	29	30
Capacities external	121-226	-	-
Capacities internal	74-172	70-235	80-275

Jaws for further clamping ranges

8 mm - Size140/175



Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. piece	137067	137111	137117
A	81	90	100
B	34	50	50
C	43	55	62
D	71	78	90
Capacities external	44-124	50-185	50-222
Capacities internal	160-274	180-350	212-410

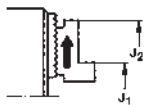
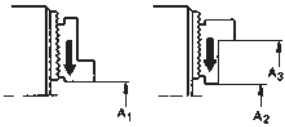
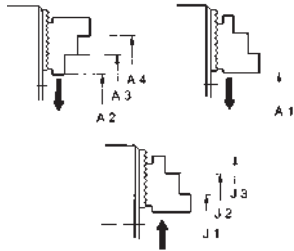
Chuck size	200	250	315
Jaw design	Type 544-05 Large design		
Item no. piece	137068	137112	137118
A	66	72	86
B	34	50	50
C	43	55	62
D	38,5	38	42
Capacities external	79-188	94-260	120-320
Capacities internal	105-210	104-272	116-315



Technical data

Chucking capacities DURO-NC

Chucking capacities with reversible top jaws UB



Chuck size		140	160	175	200	250	315	400	500	630
with reversible jaws	Type	003-20	003-20	003-20	003-25	003-30	003-35	003-40	003-40	003-50
	Jaw position									
External chucking	A1	10-58	5-51	5-60	5-65	8-93	30-125	55-156	45-230	42-468
	A2	14-62	45-94	45-103	58-118	-	-	-	-	-
	A3	57-105	89-138	89-147	114-174	82-168	93-210	119-260	122-326	112-487
	A4	89-131	115-164	115-173	142-202	163-249	201-317	260-401	264-470	275-650
Internal chucking	J1	65-112	67-108	67-117	71-126	99-178	120-207	155-260	155-460	195-615
	J2	91-138	93-135	93-144	99-154	178-257	207-313	260-400	265-600	355-780
	J3	133-182	135-177	135-186	154-209	-	-	-	-	-



Notes

Notes