Operation guide




TYPE	KFD-HS	KFD-HE	KFG	PKF
	Power chucks with through-hole			
Feature	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	170 - 315	160 - 350	100 - 200
Chucking capacities	6 - 478 mm	20 - 393 mm	5 - 472 mm	-
Power transmission	wedge	wedge	angle lever	wedge
Clamping force	■■■■■	■■■■□	■□□□□	■□□□□
Speeds	■■■■■	■■■■□	■■□□□	■■■□□
Number of jaws	2-jaw chuck, 3-jaw chuck	3-jaw chuck	3-jaw chuck	3-jaw chuck
Type of jaws	90°, tongue and groove	90°, 60°	60°	pin mounting
Workpiece	pipe, bar, flange, asymmetrical workpiece	pipe, bar, flange, asymmetrical workpiece	pipe, bar, flange, asymmetrical workpiece	flange, asymmetrical workpiece
Machining				
Mount	**DIN 6353** **ISO 702-1** (DIN 55026) **DIN 55021**	**DIN 6353**		
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2-jaw chuck
3-jaw chuck
60° serration 60°
90° serration 90°
tongue and groove
pipe
bar
disc
flange
asymmetrical workpiece

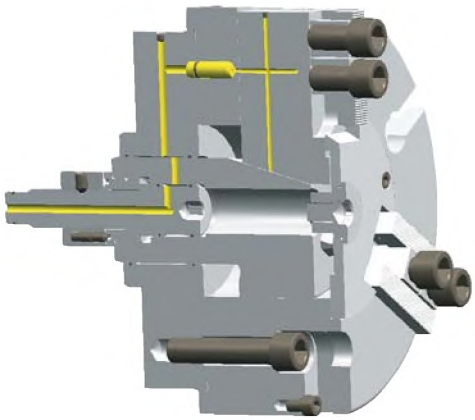
Flexibility of the media feed-through

For power chucks with and without through-hole

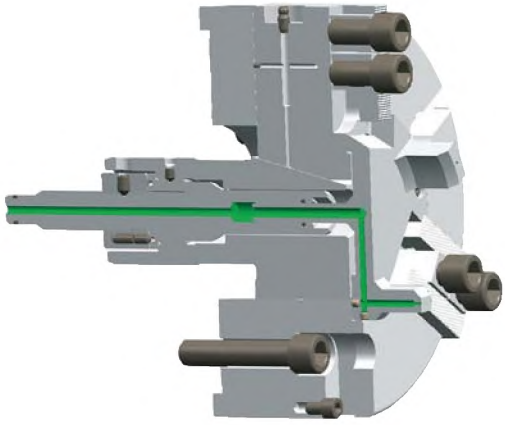
Available on request:

- 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

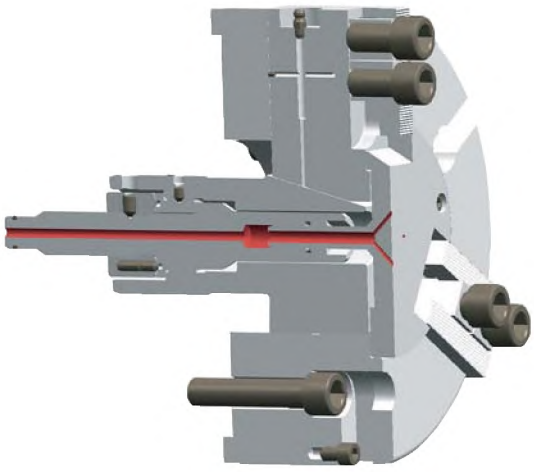
Examples of modified power chucks with feed-through for:



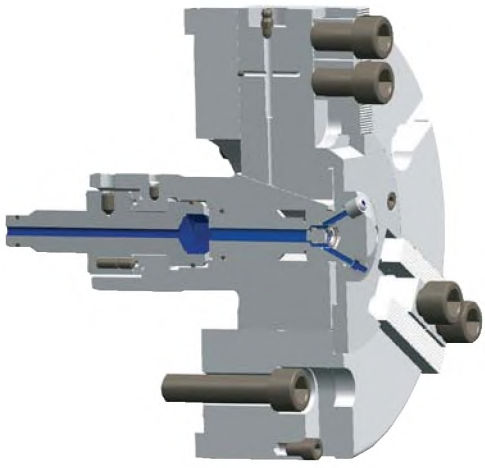
Central lubrication via distributor flange with dosing units



Air sensing



Blast air

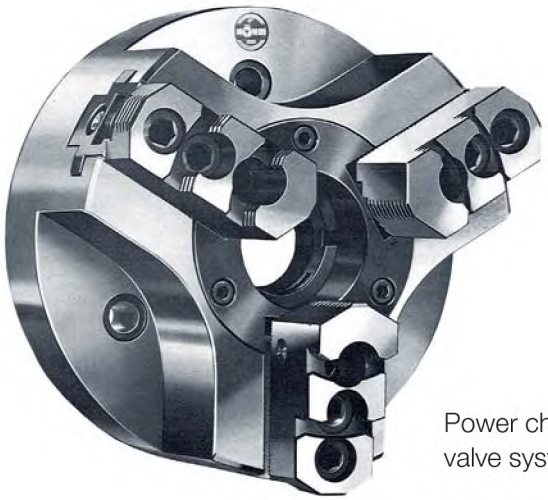


Coolant

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

USED UNIVERSALLY FOR DECADES

Founded in 1909, RÖHM began successively expanding their product range by the area of power chuck technology starting in 1950. Decades of experience and knowledge about power chucks make today's RÖHM power chucks so successful. Especially for the machining of bar material, these are not only characterized by the high flexibility due to the large through-hole, but also by the long service life, top precision and reliability.



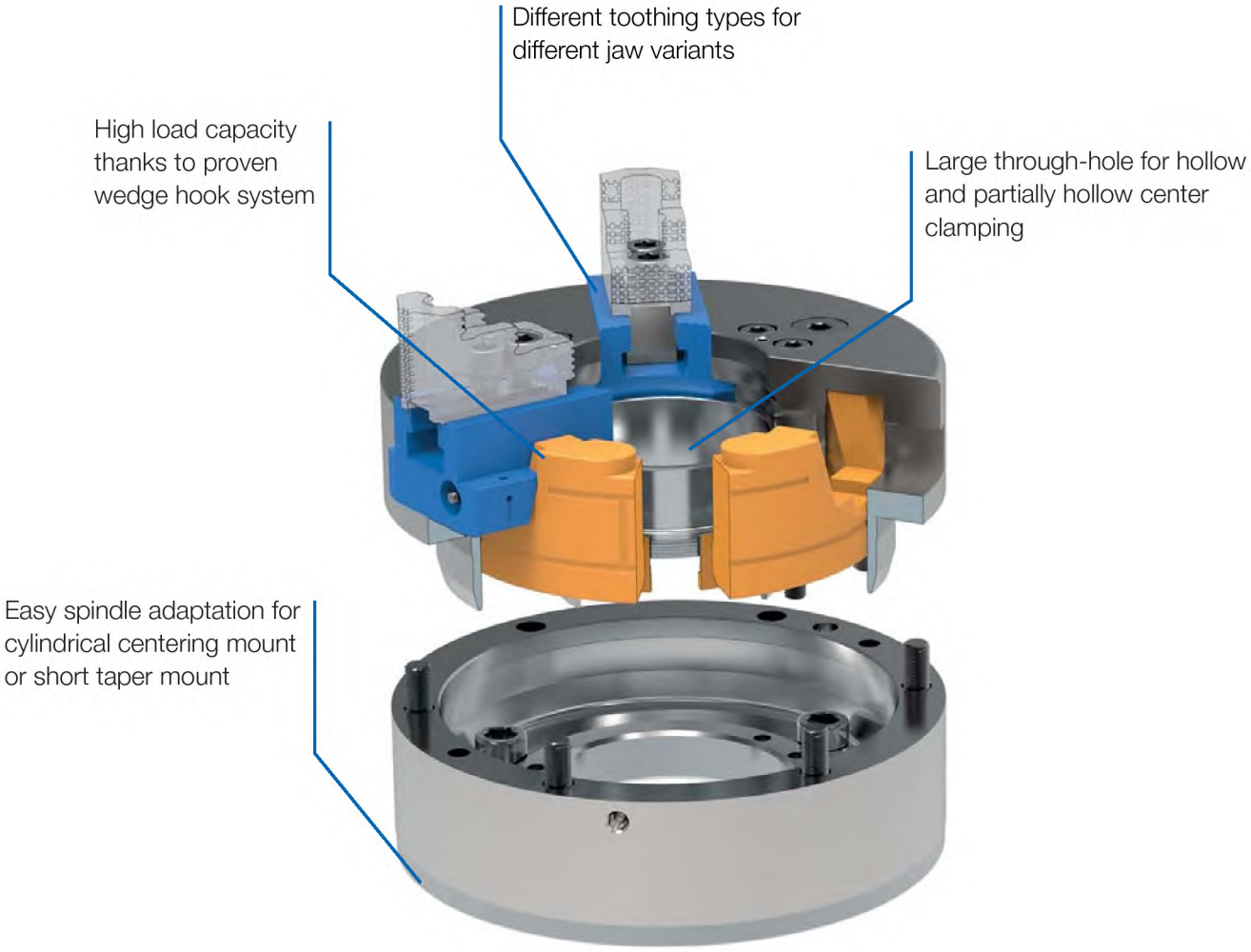
Power chucks with single wedge gate valve system and through-hole

POWER CHUCKS WITH THROUGH-HOLE

RÖHM power chucks with through-hole are successfully used both in bar and pipe machining, as well as in the machining of flange-type workpieces. The proven wedge system allows maximum clamping forces with maximum clamping precision at the same time. The rigidity of the power chucks which contributes to this is achieved with a sturdy chuck construction.

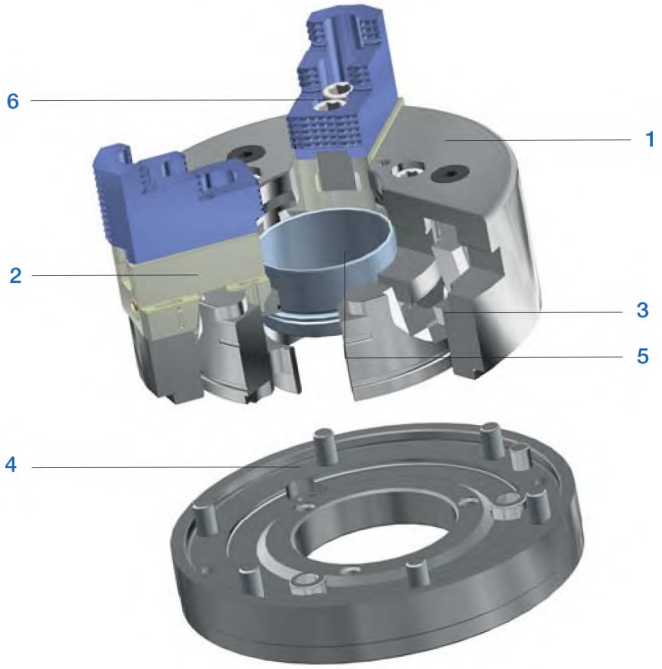
ADVANTAGES AT A GLANCE

- Large through-hole optimal for bar machining
- Proven power chucks with long service life
- Wedge hook system for high load capacity and clamping precision



KFD-HS - low centrifugal force losses

2- and 3-jaw chuck, with large through-hole, for very high speeds.
The construction principle of the power chuck KFD-HS consists of absorbing the centrifugal forces which occur during machining to the degree that the clamping force is hardly influenced.This occurs thanks to a special type of wedge hook connection. Even for extremely high speeds, the clamping force drop is very low. The high rigidity is achieved through the screw connection between the chuck body and chuck flange. Thus, this chuck type offers the optimal precondition for exactly machining shaft-type and flange-type workpieces.

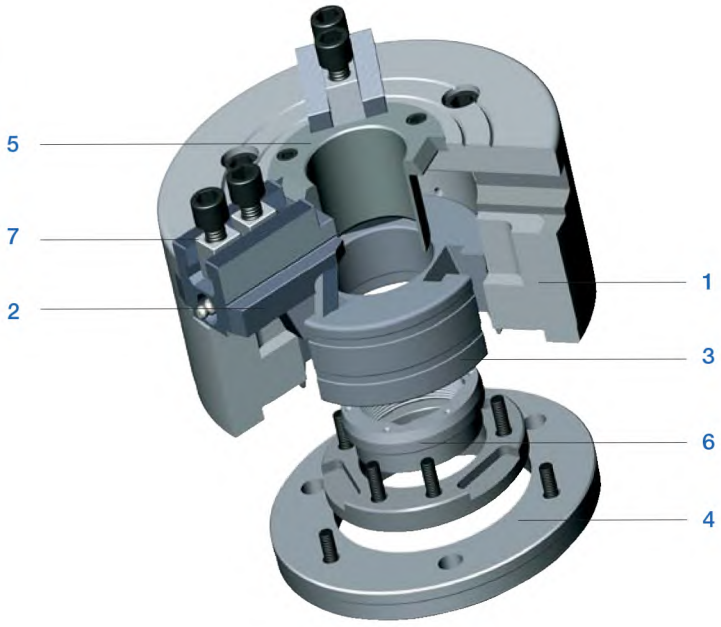


KFD-HS components

1. Body
2. Base jaw
3. Clamping piston
4. Chuck flange
5. Protective bushing
6. Slot nut

KFD-HE

Standard chuck for use on modern turning machines. A large through-hole allows both bar and pipe machining as well as the machining of flange-type workpieces. The power is transmitted via the proven wedge hook system.



KFD-HE components

1. Body
2. Base jaw
3. Piston
4. Chuck flange
5. Protective bushing
6. Ring nut
7. Slot nut