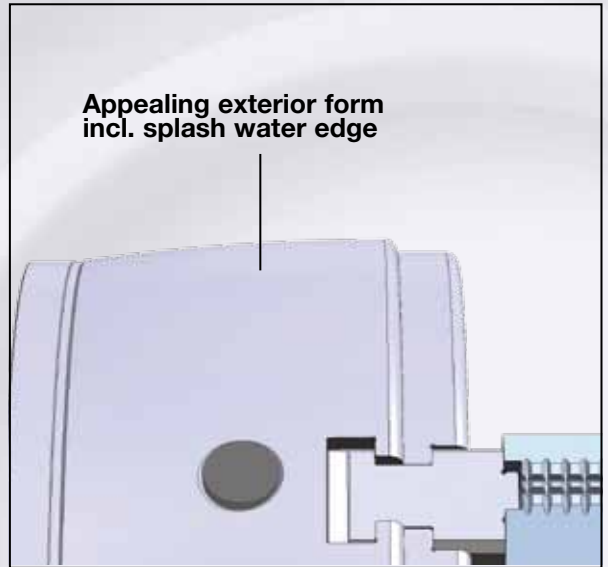


DURO-T



Technical features

RÖHM DURO-T Manual chucks:

- 20% higher clamping forces
- Chuck body stiffer (guarantees precision at higher loads)
- Surface of chuck body completely hardened
- Highly operator friendly
- Superior Design:
 - Indicator marks for quick jaw adjustment
 - lettering engraved in body front face
 - meaningful lettering (i.e. chuck number, techn. details)
 - attractive shape incl. drop-off wedge for water
- High jaw-changing repeatability
- Optimized wearing parts (i.e. safety lock)
- Chuck statically balanced
- **Futterkörper austarisiert???**
- Enhanced life at higher precision
- Radial and axial run-out tolerances only half of the permitted values according to the DIN-accuracy class 1
- Better corrosion prevention
- Lubrication possibility of the highly loaded sliding surfaces:
 - Spindle thread and spindle-counterface
 - wedge bars
 - drive ring
 - slides
- With safety key (required acc. DIN EN 1550)
- Base- and top-jaws of other manufacturers are compatible

Clamping force comparison DURO vs. DURO-T

Chuck size		125	160	200	250	315	400	500	630
Total gripping force DURO¹⁾	kN	8	25	40	55	67	85	93	93
Total gripping force DURO-T¹⁾	kN	9	30	48	66	80	100	105	105

1) Maintaining the accuracy

Gripping force

The gripping force is the sum total of all jaw forces acting radially on the stationary workpiece. The specified gripping forces are standard values.

They apply to chucks in a perfect condition which have been lubricated with RÖHM grease F 79 and F 80.

DURO-T

The Key bar chuck DURO-T replaces the well-tried RÖHM-Chuck DURO and ensures ultimate precision by the latest manufacturing technology. The DURO-T features 20% more clamping force and is statically balanced.

Mechanism

The tangentially arranged operating screw (1) engages the internal thread of the actuating key bar (2) to move a slide (3) which in turn moves the drive ring. Two further slides in the drive ring (4) transmit the force to the other two key bars. The key bars are provided with helical teeth which engage the teeth of the base jaws (5) so that the workpiece is gripped accurately and concentrically. The jaws can be quickly and conveniently reversed, exchanged or relocated over the entire gripping range after disengaging the key bar by turning the wrench counterclockwise, the indicator pin appears (7). In this position, the jaws are safely locked (6) against movement so that they cannot fly out if the machine spindle is started inadvertently. Each jaw must therefore be unlocked by pressing the corresponding pin (8) on the outside diameter of the chuck.

Large, straight surfaces transmitting the force from the key bar to the jaw teeth guarantee long life and produce a very high gripping force combined with an accuracy which is twice high as required by DIN 6386. The high gripping force is achieved without much physical effort by manually turning the key.

Lubrication

Lathe chucks must be lubricated regularly to maintain their gripping force. Appropriate directions are included in the operating instructions supplied with each chuck. All lathe chucks are equipped with grease nipples for convenient maintenance.

