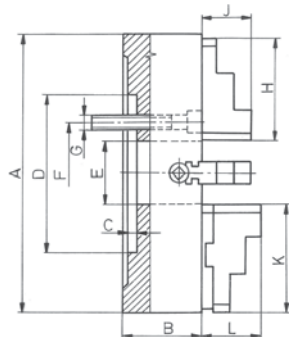


# MAIN DIMENSIONS OF 4-JAW INDEPENDENT CHUCKS



## PLAIN BACK MOUNTING

Chuck size	85	100	125	160	200	250	315
A	86	100	130	156	200	250	315
B	40	40	43	43	80	85	95
C	5	2.5	2.5	2.5	5	7	7
D H7	62	79.38	69.85	82.55	110	150	175
E	25	25	26	42	50	65	80
F	72	54	54	69.85	82.6	104.8	133.4
G	4xM6	4xM8	4xM8	4xM10	4xM10	4xM12	4xM16
H	34	34	51	51	81	96.5	111
J	17	17	20	20	40.3	40.3	49.8
L	-	-	-	-	46.4	60.4	60.9
K	-	-	-	-	82	96.5	112.5
Weight approx. kg	1.9	2.4	3.8	4.3	14.0	25.0	39.0

Chuck size	350	400	500	630	800	915	1000	1250
A	350	400	500	630	800	915	1000	1250
B	95	105	120	140	160	170	170	190
C	7	10	12	12	12	18	18	18
D H7	175	200	270	270	380	370	370	550
E	80	100	125	160	200	190	190	190
F	133.4	171.4	235	235	330	330	330	500
G	4xM16	4xM16	4xM20	4xM20	4xM24	8xM24	8xM24	8xM24
H	111	129	152.5	177	202	-	-	-
J	49.8	49.8	59.8	59.8	70.8	-	-	-
L	-	72.3	90.3	97.8	93.8	102.8	102.8	102.8
K	-	129	136	136	136	160	160	160
Weight approx. kg	47.5	61.0	105	163	319	350	410	950

## DIN 55026

## FORM A MOUNTING

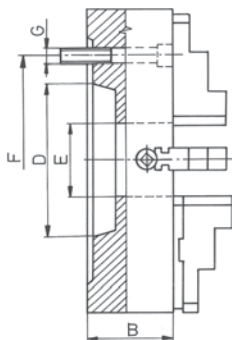
Chuck size	200			250				315		
Short taper 1: 4	4	5	6	4	5	6	8	5	6	8
B	80			85				95		
D min	63.513	82.563	106.375	63.513	82.563	106.375	139.719	82.563	106.375	139.719
D max	63.526	82.578	106.390	63.526	82.578	106.390	139.734	82.578	106.390	139.734
E	50			65				80		
F	82.6	104.8	133.4	82.6	104.8	133.4	171.4	104.8	133.4	171.4
G	4xM10	4xM10	4xM12	8xM10	8xM10	4xM12	4xM16	4xM10	8xM12	4xM16
Weight approx. kg	17.0			25.5				40.0		

Chuck size	400			500				630		
Short taper 1: 4	6	8	11	6	8	11	15	8	11	15
B	105			120				140		
D min	106.375	139.719	196.869	106.375	139.719	196.869	285.775	139.719	196.869	285.775
D max	106.390	139.734	196.887	106.390	139.734	196.887	285.795	139.734	196.887	285.795
E	100			100	125		125			
F	133.4	171.7	235	133.4	171.4	235	330.2	171.4	235	330.2
G	8xM12	4xM16	4xM20	4xM12	8xM16	8xM20	4xM24	8xM16	8xM20	4xM24
Weight approx. kg	65			114.0				165.0		

Chuck size	800				915		1000		
Short taper 1: 4	8	11	15	20	11	15	11	15	20
B	160	170	170						
D min	139.719	196.869	285.775	412.775	196.869	285.775	196.869	285.775	412.775
D max	139.734	196.887	285.795	412.802	196.887	285.795	196.887	285.795	412.802
E	125	180	200	200*	190		190		
F	171.4	235	330.2	463.6	235	330.2	235	330.2	463.6
G	4xM16	8xM20	8xM24	4xM24	8xM20	8xM24	8xM20	8xM24	8xM24
Weight approx. kg	305				315.0		395.0		

Chuck size	1250		
Short taper 1: 4	11	15	20
B	190		
D min	196.869	285.775	412.775
D max	196.887	285.795	412.802
E	190		
F	235	330.2	463.6
G	8xM20	8xM24	8xM24
Weight approx. kg	950		

\* 320 mm - on request





# MAIN DIMENSIONS OF 4-JAW INDEPENDENT CHUCKS

## DIN 55027 AND DIN 55029

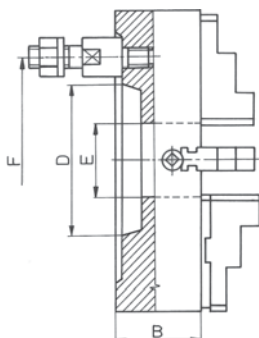
### BAYONET & CAMLOCK TYPES OF MOUNTING

Chuck size		160					200					250					
Short taper 1 : 4		3	3	4	5	6	3	4	5	6	8	3	4	5	6	8	
B		54					80					85					
D max		53.988	53.988	63.526	82.578	106.390	53.988	63.526	82.578	106.390	139.734	53.988	63.526	82.578	106.390	139.734	
D min		53.975	53.975	63.513	82.563	106.375	53.975	63.513	82.563	106.375	139.719	53.975	63.513	82.563	106.375	139.719	
E		42					50					50					
F		70.6					85 <sup>1)</sup>					82.6					
qty.of mounting studs	Bayonet	-	-	-	3	4	4	-	-	4	4	4	3	3	6	6	6
	Camlock	3	3	-	3	6	6	3	3	6	6	6	3	3	6	6	6
Weight approx. kg		6.0					16.5					27.5					

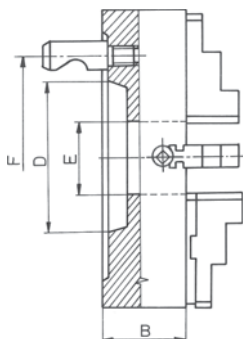
Chuck size		315					400														
Short taper 1 : 4		5	6	8	11	5	6	8	11	5	6	8	11								
B		95					105														
D max		82.578	106.390	139.734	196.887	82.578	106.390	139.734	196.887	82.578	106.390	139.734	196.887								
D min		82.563	106.375	139.719	196.869	82.563	106.375	139.719	196.869	82.563	106.375	139.719	196.869								
E		80					79.5					100									
F		104.8					133.4					171.4									
qty.of mounting studs	Bayonet	4	4	4	6	4	4	4	6	4	4	4	6	4	4	4	6	4	4	4	6
	Camlock	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
Weight approx. kg		39.5					60.0														

Chuck size		500				630				800			
Short taper 1 : 4		6	8	11	15	8	11	15	8	11	15	20	
B		120				140				160			
D max		106.390	139.734	196.887	285.795	139.734	196.887	285.795	139.734	196.887	285.795	412.802	
D min		106.375	139.719	196.869	285.775	139.719	196.869	285.775	139.719	196.869	285.775	412.775	
E		100				125				160			
F		133.4				171.4				235			
qty.of mounting studs	Bayonet	4	4	6	6	4	6	6	4	6	6	6	
	Camlock	6	6	6	6	6	6	6	6	6	6	6	
Weight approx. kg		95.5				165.0				298.0			

Chuck size		915		1000			1250	
Short taper 1 : 4		11	15	11	15	20	11	15
B		170		170			190	
D max		196.887	285.795	196.887	285.795	412.802	196.887	285.795
D min		196.869	285.775	196.869	285.775	412.775	196.869	285.775
E		190		190			190	
F		235		330.2			463.6	
qty.of mounting studs	Bayonet	6	6	6	6	6	6	6
	Camlock	6	6	6	6	6	6	6
Weight approx. kg		326.0		386.0			950	



DIN 55027

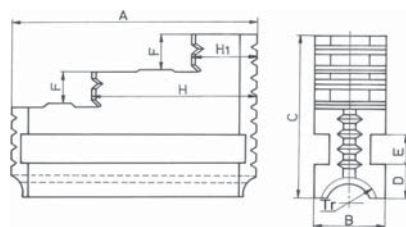


DIN 55029

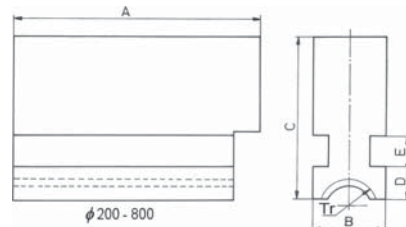
<sup>1)</sup> For bayonet type

All other dimensions should be taken from the table about chuck with plain back mounting.

# MAIN DIMENSIONS OF ONE-PIECE & TWO-PIECE REVERSIBLE JAWS



One-piece solid reversible jaws

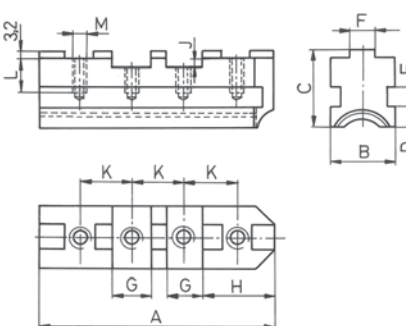


Soft solid jaws

## ONE-PIECE SOLID REVERSIBLE JAWS

Chuck size	85	100	125	160	200	250
A	34	34	51	51	81	96.5
B	13	13	16	16	32	32
C	30	30	34.5	34.5	63	63
D	4.5	4.5	6	6	8.7	8.7
E	5	5	5	5	10	10
F	7	7	8	8	14	14
H1	8	8	12.5	12.5	17.5	23
H	17.5	17.5	31.5	31.5	48.5	59
Tr-left hand	Tr 16x2	Tr 16x2	Tr 18x4	Tr 18x4	Tr 28x5	Tr 28x5
Weight approx. kg	0.1	0.1	0.12	0.12	0.72	1.3

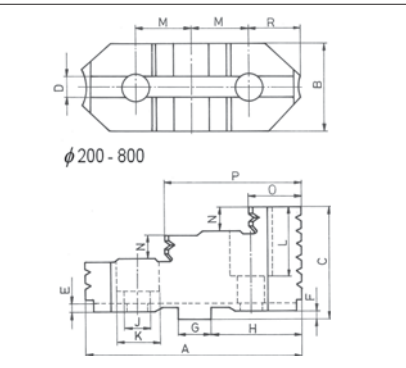
Chuck size	315	350	400	500	630	800
A	111	111	129	152.5	177	202
B	40	40	40	52	52	70
C	76.5	76.5	76.5	93.5	93.5	114.5
D	9.7	9.7	9.7	11.7	11.7	15.7
E	12	12	12	15	15	20
F	18	18	18	22	25	25
H1	27	27	32.5	35	45	44
H	67	67	78.5	93	109	122
Tr-left hand	Tr 32x6	Tr 32x6	Tr 32x6	Tr 36x6	Tr 40x6	Tr 44x8
Weight approx. kg	1.5	1.5	1.8	3.4	4.0	7.8



Hard master jaws

## HARD MASTER JAWS

Chuck size	200	250	315	400	500	630	800	915	1000	1250
A	79	94	110	129	168	206	206	244	244	244
B	32	32	40	40	52	52	70	70	70	70
C	32	38	39	44	59	59	59	59	59	59
D	8.7	8.7	9.7	9.7	11.7	11.7	15.7	15.7	15.7	15.7
E	10	10	12	12	15	15	20	20	20	20
F-0.03	7.94	12.7	12.7	12.7	12.7	12.7	12.7	12.7	12.7	12.7
G+0.01	12.69	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04
H	33.2	37.5	45.4	54.9	55.5	55.5	55.5	55.5	55.5	55.5
J	4	4	4	7.2	7.2	7.2	7.2	7.2	7.2	7.2
K	22.25	27	31.75	38.1	38.1	38.1	38.1	38.1	38.1	38.1
L	14	20	17.5	22	33.5	33.5	33.5	33.5	33.5	33.5
M	M10	M12	M12	M16	M20	M20	M20	M20	M20	M20
	3/8"-16	1/2"-13	1/2"-13	5/8"-11	3/4"-10	3/4"-10	3/4"-10	3/4"-10	3/4"-10	3/4"-10
Tr-left hand	Tr 28x5	Tr 28x5	Tr 32x6	Tr 32x6	Tr 36x6	Tr 40x6	Tr 44x8	Tr 44x6	Tr 44x6	Tr 44x8
Weight approx. kg	0.6	0.9	1.1	1.2	1.5	2.4	2.4	5.4	5.4	5.4



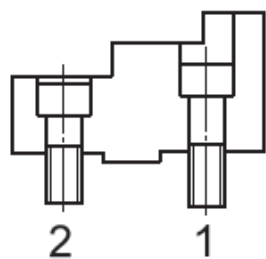
Hard top jaws

## HARD TOP JAWS

Chuck size	200	250	315	400	500	630	800	915	1000	1250
A	82	96.5	112.5	129	136	136	136	160	160	160
B	34	34	42	42	54	54	72	72	72	72
C	43.5	51.5	55	64.5	74.5	82	88	97	97	97
D	7.95	12.71	12.71	12.71	12.71	12.71	12.71	12.71	12.71	12.71
E	4	4	4	4	4	4	4	4	4	4
F-0.03	3.2	3.2	3.2	6.3	6.3	6.3	6.3	6.3	6.3	6.3
G + 0.01	12.69	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04
H	35.2	40	47.9	57.4	58	58	58	58	58	58
J	11	14	14	18	22	22	22	22	22	22
K	18	20	20	26	33	33	33	33	33	33
L	21.5	26.5	27.5	32	39.5	43	46	71	71	71
M	22.25	27	31.75	38.1	38.1	38.1	38.1	38.1	38.1	38.1
N	9.5	12	13	13.5	18	21	24	50	50	50
O	22	25	27	26.5	37.5	37.5	40	60	60	60
P	53	62	70.5	79	87	87	89	-	-	-
R	19.3	22.5	25.7	28.8	29.4	29.4	29.4	29.4	29.4	29.4
Weight approx. kg	0.5	0.7	1.3	2.1	3.0	3.0	4.2	4.2	4.2	4.2

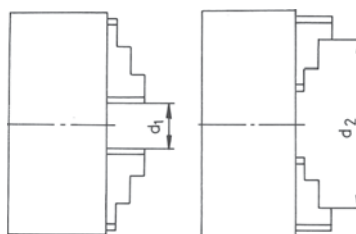


# MOUNTING BOLTS FOR TOP JAWS



Chuck size	Bolt 1	Bolt 2
200	M10x30	M10x20
250	M12x40	M12x25
315	M12x40	M12x25
400	M16x45	M16x30
500	M20x55	M20x40
630	M20x60	M20x40
800	M20x65	M20x40
915	M20x45	M20x45
1000	M20x45	M20x45
1250	M20x45	M20x45

## ENGINEERING DATA FOR 4-JAW INDEPENDENT CHUCKS



### GRIPPING RANGES

Chuck size	85	100	125	160	200	250	315	350
d1 min	3	3	8	8	10	10	15	15
d2 max	85	100	125	160	200	250	315	350
max swing dia.	101	116	150	185	235	296	369	404

Chuck size	400	500	630	800	915	1000	1250
d1 min	20	45	50	50	120	170	170
d2 max	400	500	630	800	915	1000	1250
max swing dia.	465	570	720	888	1003	1088	1338

Gripping ranges are valid for lathe chucks with reversible jaws. Do not exceed maximum chucking ranges.

### MAXIMUM PERMISSIBLE ROTATIONAL SPEEDS \* (rpm)

Chuck size	85	100	125	160	200	250	315	350
Cast steel or steel body	4000	3800	3500	3200	2500	2000	1500	1500
Cast iron body	-	-	-	-	1800	1500	1200	1200

Chuck size	400	500	630	800	915	1000	1250
Cast steel or steel body	1100	700	550	450	200	200	150
Cast iron body	800	500	400	300	150	150	100

\* Valid for symmetrical gripping of the workpiece