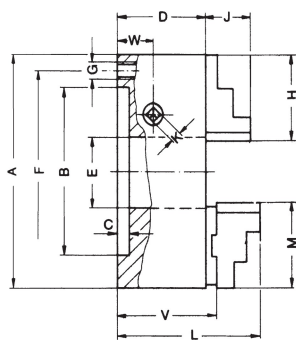


Chuck dimensions ZS - ZSU and Orange Line

For mounting on dividing heads and other attachments from the front, the lathe chucks with a cylindrical centre mount can also be supplied pre-drilled (at surcharge) G₁, it is also possible to enlarge the bore (measure E, at surcharge).

Cylindrical centre mount DIN 6350



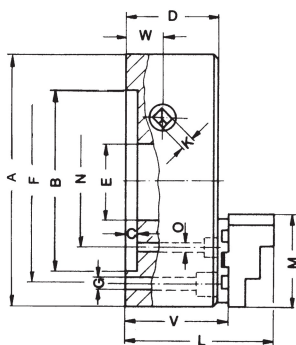
Enlarged bore max.

Size A	74	80	85	100	110	125	140	160	200	250	315	350	400	500	630
B ^{H6}	56	56	60	70	80	95	105	125	160	200	260	290	330	420	545
C	2,5	3	3	3	3	4	4	4	4	5	5	6	5	5	7
D	32,5	39,5	39,5	50	50	56	60	65	73,5	82	95	100	105	120	135
E	15	19	19	20	27	32	40	42	55	76	103	115	136	190	240
E _{max}	-	-	-	21	-	33	43	50	70	92	114	120	150	210	253
F	63	67	72	83	95	108	120	140	176	224	286	318	362	458	586
G	3xM6	3xM6	3xM6	3xM8	3xM8	3xM8	3xM8	3xM10	3xM10	3xM12	3xM16	3xM16	3xM16	6xM16	6xM16
G ₁	-	-	-	-	-	3xØ9*	-	3xØ10,5	3xØ11	3xØ14	3xØ14	-	3xØ18	6xØ18	6xØ18
H	32	37	37	48	48	52	61	61	69	90	130	130	130	190	190
J	14	14	14	18	18	22,5	22,5	26	32,5	40	46	45	43	54,5	54,5
K	6 ¹⁾	6	6	8	8	9	9	10	11	12	14	14	17	19	19
L	-	-	-	80,5	-	95,5	106	108	119,6	139,6	155	168,5	171,5	201,5	216,5
M	-	-	-	47	47	56	66,7	66,7	79,5	95	109,5	127	127	127	127
V	-	-	-	53,6	53,6	61	67,7	69,7	80,2	89,9	100,4	110,4	113,4	128,4	143,3
W	13	14,5	14,5	18	18	20	21	22,45	25,7	26,5	30	34	35	38	48
approx kg.	1	1,3	1,9	2,9	3,4	4,5	5,8	8,2	14,6	25,7	44,2	56	80	126	208

G₁ = Mounting from front

* 4-jaw = 4 x Ø 9

Cylindrical centre mount with front mounting



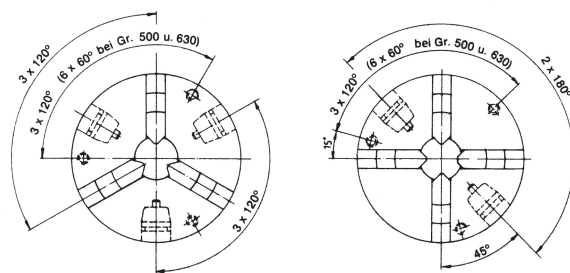
Enlarged bore max.

Size	ØA	700	800	1000	1250
B	610	710	910	910	
C ²⁾	7 ^{+0,03}	7 ^{+0,03}	7 ^{+0,03}	7 ^{+0,03}	7 ^{+0,03}
D	147	147	157	157	
E	310	380	460	550	
E _{max}	330	420	580	580	
F	660	760	950	950	
3-Jaw	G	6xØ22	6xØ22	6xØ26	6xØ26
4-Jaw	G	8xØ22	8xØ22	8xØ26	6xØ26
	K	19	19	24	24
	L	240,6	240,6	269,6	269,6
	M	210	210	210	210
	N	360	460	610	610
3-Jaw	O	6xØ18	6xØ18	6xØ18	6xØ18
4-Jaw	O	4xØ18	4xØ18	4xØ18	6xØ18
	V	158	158	166	166
	W	48	48	53	53
	ca. kg	280	350	590	850

1) Hexagon

2) Adaptor plate dimension 7_{-0,03}

Position of fixing screws and pinions on lathe chucks with cylindrical centre mount sizes 74-630 (size 350 on request)

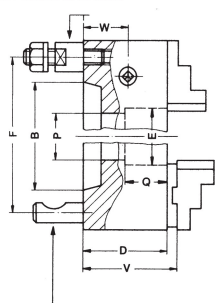


Short taper mount

DIN 55021 with setscrews and locknuts



DIN 55027 with studs and nuts



Size	A	100	125	140	160	200
Taper size		3	3	4	3	4
B	53,9	53,9	63,5	53,9	63,5	82,5
D	75	69	69	74	74	66
E	20	32	32	40	40	42
DIN	F	75	75	85	75	85
Caml.	F	70,6	70,6	82,5	70,6	82,5
	P	-	-	-	-	51,2
	Q	-	-	-	-	33
	V	78,3	73,7	73,7	81,7	70,7
	W	43	33	33	35	35 ¹⁾
Mounting holes	DIN	3	3	3	3	3
	ca. kg	4	5,5	7	8,5	15,5

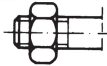
1) 50 with Camlock, other dimensions in the table on the top

DIN 55029 with studs for Camlock

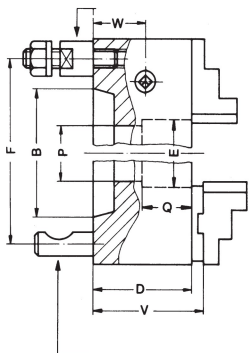
Chuck dimensions ZS - ZSU and Orange Line

Short taper mount

DIN 55021
with setscrews and locknuts



DIN 55027
with studs and nuts



DIN 55029
with studs for Camlock

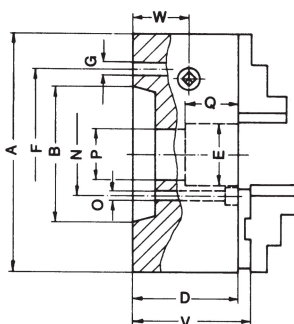
Size A	250				315				350				400				
Taper size	4	5	6	8	5	6	8	11	6	8	11	11	6	8	11		
B	63,5	82,5	106,4	139,7	82,5	106,4	139,7	196,9	106,4	139,7	196,9	196,9	106,4	139,7	196,6		
D	83	83	83	83	96	96	96	104	122	122	122	122	106	106	106		
E	60,7	76	76	76	79,6	103	103	103	103	115	115	103	136	136	136		
F	85				104,8	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235			
	DIN	82,5															
P	60,7	-	-	-	79,6	-	-	-	103	-	-	103	-	-	-		
Q	40,5	-	-	-	49	-	-	-	81	-	-	54	-	-	-		
V	90,9	90,9	90,9	90,9	101,4	101,4	101,4	109,4	127,4	127,4	127,4	114,4	114,4	114,4	114,4		
W	27,5	27,5	27,5	27,5	31	31	31	39	56	56	56	36	36	36	36		
Mounting holes	DIN	3	4	4	4	4	4	6	6	6	6	6	4	4	6		
	Caml.	3	6	6	6	6	6	6	6	6	6	6	6	6	6		
approx. kg		30				50				71				84			

Size A	500				630				700				800				1000				1250				
Taper size	8	11	15	11	15	15	11	15	15	20	15	20	15	20	15	20	15	20							
B	139,7	196,9	285,8	196,9	285,8	196,9	285,8	196,9	412,8	285,8	412,8	285,8	412,8	285,8	412,8	285,8	412,8	285,8							
D	122	122	122	137	137	149	149	149	149	149	149	159	159	159	159	159	159	159							
E	136	190	190	192,7	240	310	310	380	380	460	460	550	550	550	550	550	550	550							
F	171,4	235	330,2	235	330,2	235	330,2	330,2	463,6	330,2	463,6	330,2	463,6	330,2	463,6	330,2	463,6	330,2							
P	136	-	-	192,7	-	192,7	281,2	281,2	-	281,2	407,5	281,2	407,5	281,2	407,5	281,2	407,5	281,2							
Q	61	-	-	63	-	76	76	76	-	85	85	85	85	85	85	85	85	85							
V	130,4	130,4	130,4	145,3	145,3	160	160	160	160	168	168	168	168	168	168	168	168	168							
W	40	40	40	50	50	50	50	50	50	55	55	55	55	55	55	55	55	55							
Mounting holes	DIN	4	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6							
	Caml.	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6							
approx. kg		150				225				280				350				590				850			

All other dimensions should be taken from the table about chucks with cylindrical centre mount

Short taper mount

DIN 55026
Mounting from front



Size A	160	200		250			315		350		400	
Taper size	5	5	6	5	6	8	6	8	6	8	8	11
B	82,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	106,4	139,7	139,7	196,9
D	66	74,5	74,5	83	83	83	96	122	122	122	106	106
E	42	42	55	76	55	76	103	76	103	76	136	125
F ²⁾	-	-	-	104,8	-	-	133,4	-	133,4	-	171,4	-
G	-	-	-	11 ¹⁾	-	-	14	-	14	-	18	-
N ³⁾	61,9	61,9	82,6	-	82,6	111,1	-	111,1	-	111,1	-	165,1
O	11 ¹⁾	11 ¹⁾	14	-	14	18	-	18	-	18	-	22
V	70,7	81,2	81,2	90,9	90,9	90,9	101,4	101,4	127,4	127,4	114,4	114,4
W	23,45	26,7	26,7	27,5	27,5	27,5	31	31	56	56	36	36
Mounting holes	*	3	3	6	3	6	6	6	6	6	6	6
	**	4	4	4	4	4	4	4	4	4	4	4
approx. kg		8	14,5		25		44,5		71		82	

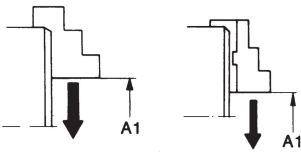
Size ØA	500	630			700			800			1000			1250		
Taper Size	11	11	15	11	15	11	15	20	15	20	15	20	15	20	15	20
B	196,9	196,9	285,9	196,9	285,9	196,9	285,9	412,8	285,9	412,8	285,9	412,8	285,9	412,8	285,9	412,8
D	122	137	137	149	149	149	149	149	159	159	159	159	159	159	159	159
E	190	190	190	310	285	380	380	380	460	505	550	550	550	550	550	550
F ²⁾	235	235	-	235	330,2	235	330,2	463,6	330,2	463,6	330,2	463,6	330,2	463,6	330,2	463,6
G	22	22	-	22	26	22	26	26	26	26	26	26	26	26	26	26
N ³⁾	-	-	247,6	-	-	-	-	-	-	-	-	-	-	-	-	-
O	-	-	26	-	-	-	-	-	-	-	-	-	-	-	-	-
P	-	-	-	193	281,2	193	281,2	-	281,2	407,5	281,2	407,5	281,2	407,5	281,2	407,5
Q	-	-	-	76	76	76	76	-	85	85	85	85	85	85	85	85
V	130,4	145,3	145,3	159,9	159,9	159,9	159,9	159,9	168	168	168	168	168	168	168	168
W	40	50	60	50	50	50	50	50	55	55	55	55	55	55	55	55
Mounting holes	*	3	6	6	6	6	6	6	8	8	8	8	8	8	8	8
	**	4	8	8	8	8	8	8	8	8	8	8	8	8	8	8
approx. kg		139	220		295		350		590		850		850		850	

1) 12 with ASA B 5.9 inch thread
 2) For DIN 55026 Form A and B; DIN 55021 Form A and B; ASA B 5.9 A1/A2
 3) For DIN 55026 Form B; ASA B 5.9 A1/B1

* 3-Jaw ** 4-Jaw

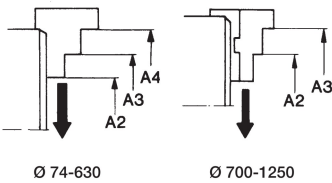
Chuck dimensions ZS - ZSU and Orange Line

External chucking



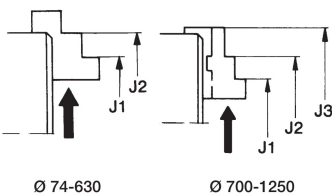
Chucking capacities of jaw steps (standard values)

Size	74	80	85	100	110	125	140	160	200	250
A1 (BB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	4-72	4-100	5-122
A2 (DB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	3-72	4-100	5-122
A3 (DB)	23-46	27-55	27-55	38-71	39-77	39-89	47-97	47-116	56-152	73-190
A4 (DB)	45-68	52-80	52-80	70-100	70-100	75-125	91-140	91-160	104-200	131-250
max. swing dia.	88	104	104	128	138	157	174	194	238	302
Jaw movement	11	14	14	15	19	25	25	34	48	58



Size	315	350	400	500	630	700	800	1000	1250
A1	6-135	20-180	20-200	35-260	50-350	110-350	150-450	250-600	320-600
A2	6-135	20-180	20-200	35-260	50-350	280-672	325-853	425-1070	490-1150
A3	96-225	110-270	110-300	140-360	190-490	356-748	400-928	500-1150	564-1224
A4	186-315	200-350	200-400	280-500	330-630	-	-	-	-
max. swing dia.	395	440	480	600	730	1000	1170	1390	1476
Jaw movement	64	80	100	110	150	120	150	175	140

Internal chucking



Size	74	80	85	100	110	125	140	160	200	250
J1	23-46	25-53	26-53	33-66	33-71	37-87	39-89	39-107	44-140	59-165
J2	45-68	50-78	50-78	65-94	65-104	73-123	83-132	83-152	92-186	119-236

Size	315	350	400	500	630	700	800	1000	1250
J1	96-224	100-260	100-300	135-355	150-450	212-648	251-855	356-1080	426-1162
J2	186-305	190-350	190-390	275-460	290-590	290-758	326-930	430-1150	500-1236
J3	-	-	-	-	-	526-922	566-1094	660-1314	740-1400

Clamping ranges for lathe chucks with individual adjustable jaws (ES) are in approximate conformity with the above values. They are valid for 3- and 4-jaw chucks and lathe chucks with reversible jaws.
Do not exceed maximum chucking ranges.

Max. permissible speeds for ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum gripping is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in perfect condition. The speed limit for chucks with cast iron bodies is based on the permissible peripheral speed for cast iron. The specification DIN 6386 Part 1 shall be observed.

Size	3 and 4 jaws	
	Cast iron body	Steel body
74	5000	-
80	5000	7000
100	4500	6300
125	4000	5500
140	3700	5000
160	3600	4600
200	3000	4000
250	2500	3000
315	2000	2300
350	1700	1900
400	1600	1800
500	1000	1300
630	800	850
700	650	800
800	600	700
1000	480	560
1250	380	450

Clamping force 3 jaw chuck ZS - ZSU, Orange Line, ZS Hi-Tru to DIN 6350

The clamping force is sum total of all jaw forces acting radially on the stationary workpiece. The clamping forces are approximate values. To obtain the specified clamping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.

Size	Torque key	Total clamping force
74	30	11
80	30	13
100	60	27
125	80	31
140	90	40
160	110	47
200	140	55
250	150	63
315	180	69
350	210	74
400	240	92
500	260	100
630	280	105
700	280	105
800	300	110
1000	450	115
1250	450	115