

## GEARED SCROLL CHUCKS

The RÖHM geared scroll chucks have proven themselves a thousand times over and have already been used successfully on lathes, rotary tables and dividing attachments for decades. The jaws can be adjusted over the entire clamping range in order to be able to very quickly clamp workpieces with a wide clamping diameter range without offsetting the jaws.

### ADVANTAGE AT A GLANCE

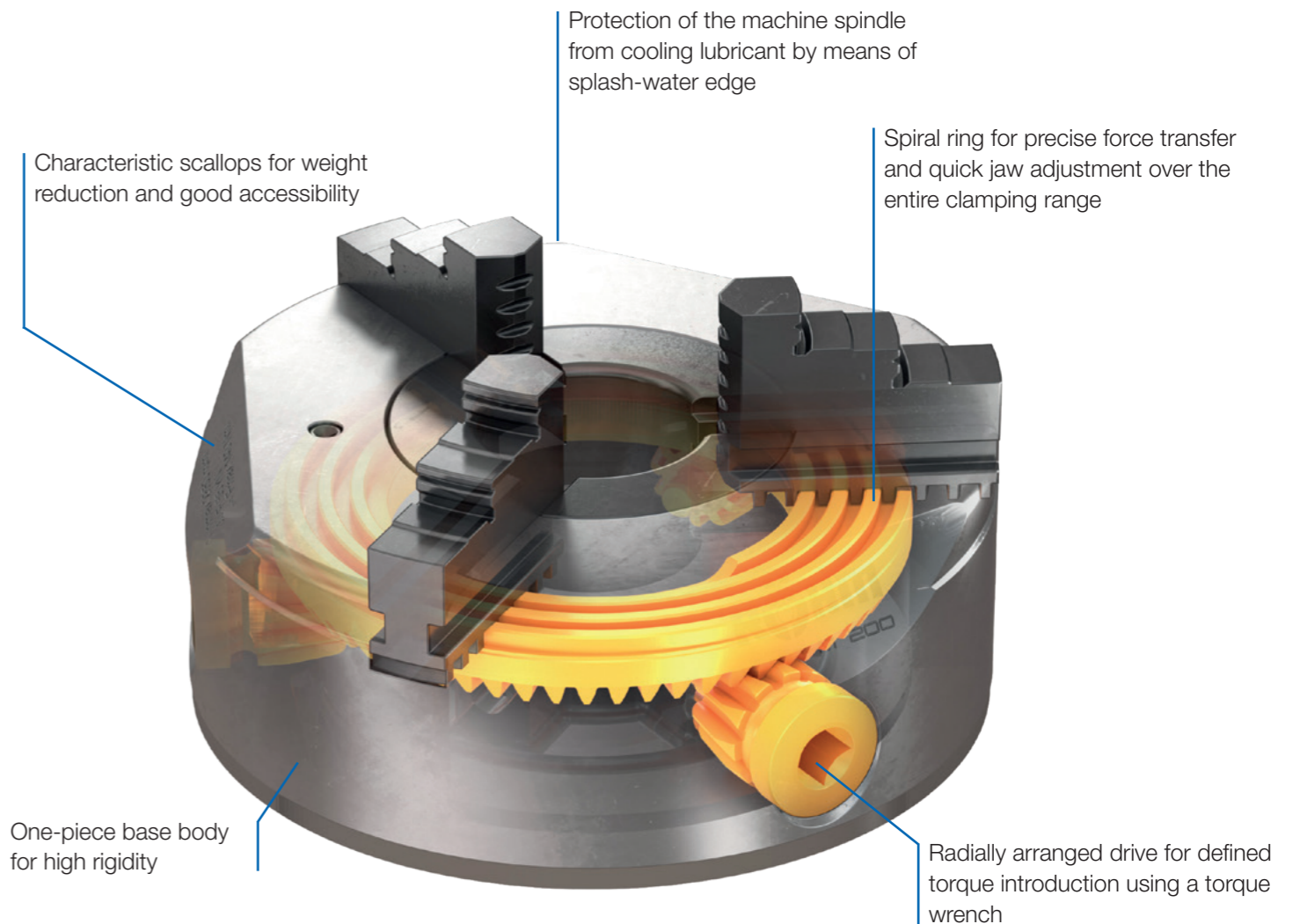
- ⊕ Quick jaw adjustment over the entire clamping range
- ⊕ Proven chuck with optimal price/performance ratio
- ⊕ Protection of the machine spindle by means of splash-water edge

### PROVEN CHUCK WITH SPIRAL RING

The RÖHM geared scroll chucks have already been in use for decades and have proven themselves a thousand times over. The jaws can be quickly adjusted over the entire clamping range by means of the spiral ring. Using the radially arranged drive, the force is transferred to the hardened spiral ring via a bevel gearing and further conducted to the clamping jaws via the spiral.

And we are now continuing to write this story: with the new DURO-M scroll chuck - Made in Germany. It carries the genes of its predecessors and inherits their most important properties, such as durability, precise power transmission and fast jaw adjustment over the entire clamping range.

The most significant change: the characteristic scallops. They not only look good, but also have tangible benefits such as weight reduction and good accessibility. In addition, the DURO-M impresses with optimized power transmission and high rigidity. Due to the wide range of diameters, the DURO-M can be used on all common spindle interfaces and is thus designed for long-term and durable use.



# DURO-M - centric clamping



### APPLICATION

Conventional clamping horizontal and vertical turning machines, as well as milling machines, rotary tables and dividing attachments. Predominantly for use in single or small batch production or in repair shops. Clamping of rotationally symmetrical parts for turning and milling.

### TYPE

The DURO-M is a manually scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

### CUSTOMER BENEFITS

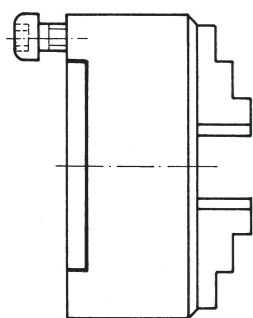
- ⊕ Jaws with gunmetal finish
- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant

### TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- Scope of delivery: chuck, chuck key, jaws



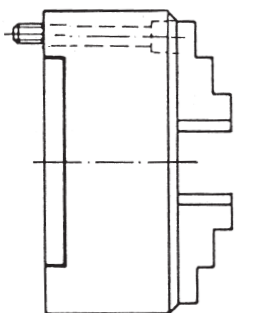
A09  
DIN 6350, cylindrical centre mount, form A



Size	ZA	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
74	56	15	185299	-	-	-	7000	30	11
80	56	19	185300	185323	-	-	7000	30	13
100	70	20	185301	185324	185310	185333	6300	60	27
125	95	32	185302	185325	185311	185334	5500	80	31
140	105	40	185585	-	-	-	5000	90	40
160	125	42	185303	185326	185312	185335	4600	110	47
200	160	55	185304	185327	185313	185336	4000	140	55
250	200	76	185305	185328	185314	185337	3000	150	63
315	260	103	185306	185329	185315	185338	2300	180	69
400	330	136	185307	185330	185316	185339	1800	240	92
500	420	190	185308	185331	185317	185340	1300	260	100
630	545	240	185309	185332	185318	185341	850	280	105
700	610	310	-	-	185319	185342	800	280	105
800	710	380	-	-	185320	185343	700	300	110
1000	910	460	-	-	185321	185344	560	450	115
1250	910	550	-	-	185322	185345	450	450	115

Further sizes and mountings available on request  
From size 400 no scallops due to design

A09  
Mounting from front, DIN 6350, cylindrical centre mount

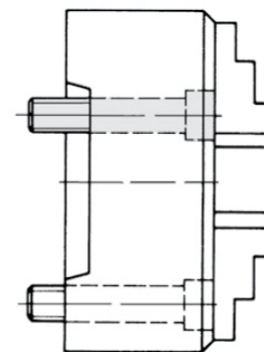


Size	ZA	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	95	32	185359	185367	5500	80	31
160	125	42	185360	185368	4600	110	47
200	160	55	185361	185369	4000	140	55
250	200	76	185362	185370	3000	150	63
315	260	103	185363	185371	2300	180	69
400	330	136	185364	185372	1800	240	92
500	420	190	185365	185373	1300	260	100
630	545	240	185366	185374	850	280	105

Further sizes and mountings available on request  
3-jaw chuck from size 400 no scallops due to design  
4-jaw chuck with mounting from front no scallops due to design

# DURO-M - centric clamping

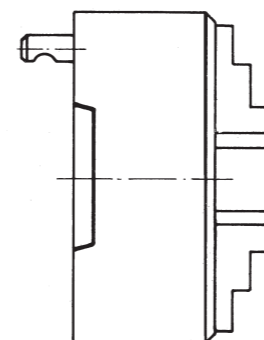
A09  
ISO 702-1 (DIN 55026), DIN 55021, ASA B 5.9, A1/A2 metr.; mounting from front



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	5	42	185375	185402	185389	185417	4600	110	47
200	5	42	185376	185403	185390	185418	4000	140	55
200	6	55	185377	185404	185391	185419	4000	140	55
250	5	76	185378	185405	185392	185420	3000	150	63
250	6	55	185379	185406	185393	185421	3000	150	63
250	8	76	185380	185407	185394	185422	3000	150	63
315	6	103	185381	185408	185395	185423	2300	180	69
315	8	76	185382	185409	185396	185424	2300	180	69
400	8	136	185383	185412	185397	185427	1800	240	92
400	11	125	185384	185413	185398	185428	1800	240	92
500	8	136	185385	-	-	-	1300	260	100
500	11	190	185386	185414	185399	185429	1300	260	100
630	11	190	185387	185415	185400	185430	850	280	105
630	15	190	185388	185416	185401	185431	850	280	105

<sup>1)</sup> Mounting from front in the inner bolt circle  
3-jaw chuck from size 400 no scallops due to design. 4-jaw chuck with mounting from front no scallops due to design.

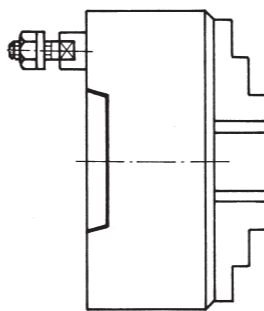
A09  
ISO 702-2 (DIN 55029), ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	3	32	185432	-	185450	-	5500	80	31
125	4	32	185433	185468	185451	185484	5500	80	31
160	4	42	185434	185469	185452	185485	4600	110	47
160	5	42	185435	185470	185453	185486	4600	110	47
200	5	55	185436	185471	185454	185487	4000	140	55
200	6	55	185437	185472	185455	185488	4000	140	55
250	6	76	185438	185473	185456	185489	3000	150	63
250	8	76	185439	185474	185457	185490	3000	150	63
315	6	103	185440	185475	185458	185491	2300	180	69
315	8	103	185441	185476	185459	185492	2300	180	69
315	11	103	185442	185477	185460	185493	2300	180	69
400	8	136	185443	185478	185461	185494	1800	240	92
400	11	136	185444	185479	185462	185495	1800	240	92
500	8	136	185445	-	185463	-	1300	260	100
500	11	190	185446	185480	185464	185496	1300	260	100
500	15	190	185447	185481	185465	185497	1300	260	100
630	11	192,7	185448	185482	185466	185498	850	280	105
630	15	240	185449	185483	185467	185499	850	280	105

Further sizes and mountings available on request  
From size 400 no scallops due to design

A09  
ISO 702-3 (DIN 55027), with studs and locknuts, optional DIN 55021 with set screw and nut



Size	Mount short taper	Through-hole mm	3-jaw chuck with inside and outside jaw	4-jaw chuck with inside and outside jaw	3-jaw chuck with base and reversible top jaw	4-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
100	3	20	185500	-	185519	-	6300	60	27
125	3	32	185501	-	185520	-	5500	80	31
125	4	32	185502	185538	185521	185554	5500	80	31
160	4	42	185503	185539	185522	185555	4600	110	47
160	5	42	185504	185540	185523	185556	4600	110	47
200	5	55	185505	185541	185524	185557	4000	140	55
200	6	55	185506	185542	185525	185558	4000	140	55
250	6	76	185507	185543	185526	185559	3000	150	63
250	8	76	185508	185544	185527	185560	3000	150	63
315	6	103	185509	185545	185528	185561	2300	180	69
315	8	103	185510	185546	185529	185562	2300	180	69
315	11	103	185511	185547	185530	185563	2300	180	69
400	8	136	185512	185548	185531	185564	1800	240	92
400	11	136	185513	185549	185532	185565	1800	240	92
500	8	136	185514	-	185533	-	1300	260	100
500	11	190	185515	185550	185534	185566	1300	260	100
500	15	190	185516	185551	185535	185567	1300	260	100
630	11	192,7	185517	185552	185536	185568	850	280	105
630	15	240	185518	185553	185537	185569	850	280	105

Further sizes and mountings available on request  
From size 400 no scallops due to design



# DURO-M - centric clamping

## APPLICATION

Conventional clamping horizontal and vertical turning machines, as well as milling machines, rotary tables and dividing attachments. Predominantly for use in single or small batch production or in repair shops. Clamping of rotationally symmetrical parts for turning and milling.

## TYPE

The DURO-M is a manually scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

## CUSTOMER BENEFITS

- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant
- ⊕ Control edge

## TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
- Zero drive determined in the factory as precision drive
- Scope of delivery: chuck, chuck key, jaws



Geared scroll chucks  
DURO-M

A09  
DIN 6350, cylindrical centre mount, form A

Size	ZA	Through-hole mm	2-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
100	70	20	185587	2700	40	18
125	95	32	185588	2400	50	19
160	125	42	185589	2200	70	29
200	160	55	185590	1800	90	35
250	200	76	185591	1500	100	42
315	260	103	185592	1200	120	46
400	330	136	185593	950	160	60

Further sizes and mountings available on request  
From size 400 no scallops due to design

A09  
Mounting from front, DIN 6350, cylindrical centre mount

Size	ZA	Through-hole mm	2-jaw chuck with base and reversible top jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
125	95	32	185594	2400	50	19
160	125	42	185595	2200	70	29
200	160	55	185596	1800	90	35
250	200	76	185597	1500	100	42
315	260	103	185598	1200	120	46
400	330	136	185599	950	160	60

Further sizes and mountings available on request  
From size 400 no scallops due to design

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## TYPE

The DURO-M is a manually scroll chuck with through-hole. 2-, 3-, 4- or 6-jaw design.

## CUSTOMER BENEFITS

- ⊕ Spannbacken grundsätzlich brüniert
- ⊕ Minimal interference contour
- ⊕ Optimum force transmission
- ⊕ Drip edge for coolant
- ⊕ Control edge

## TECHNICAL FEATURES

- Chuck body made of steel
- Centric clamping via scroll ring
- Scroll plate drop forged and highly tempered
- Jaws in chuck ground out for concentricity
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- Scope of delivery: chuck, chuck key, jaws



Geared scroll chucks  
DURO-M

A09  
DIN 6350, cylindrical centre mount, form A

Size	ZA	Through-hole mm	6-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	125	42	185347	4600	110	47
200	160	55	185348	4000	140	55
250	200	76	185349	3000	150	63
315	260	103	185350	2300	180	69
400	330	136	185351	1800	240	92

Further sizes and mountings available on request

A09  
Mounting from front, DIN 6350, cylindrical centre mount

Size	ZA	Through-hole mm	6-jaw chuck with inside and outside jaw	Speed max. min <sup>-1</sup>	Torque Nm	Total clamping force kN
160	125	42	185600	4600	110	47
200	160	55	185601	4000	140	55
250	200	76	185602	3000	150	63
315	260	103	185603	2300	180	69
400	330	136	185604	1800	240	92

Further sizes and mountings available on request