

DURO-NCSE



APPLICATION

Premium power chuck with through-hole for flexible use thanks to quick-action jaw change system for maximum speeds.

TYPE

Power chuck available with cylindrical center mount or short taper mount. 3-jaw version.

CUSTOMER BENEFITS

- ④ Easy handling of the jaw change thanks to individual jaw unlocking
- ④ Universal: Jaws can be offset, exchanged or turned
- ④ For very high speeds - Low centrifugal force losses thanks to low jaw weights and wedge bar construction
- ④ High clamping precision and clamping force thanks to rigid chuck construction
- ④ Large through-hole for hollow or partially hollow clamping

TECHNICAL FEATURES

- Power transmission by means of wedge bar system
- Lubricated base jaw guides
- The toothing of the wedge bar always engages completely in the jaw
- Base jaws with straight teeth

Note:

- 1) Included in the scope of delivery: Chuck, chuck and jaw mounting screws, base jaws, safety wrench, mounting wrench.
- 2) The safety key can only be pulled out once the jaws are locked. This setup in combination with the key switch integrated in the machine also prevents the machine spindle from starting up unintentionally when the jaws are unlocked.

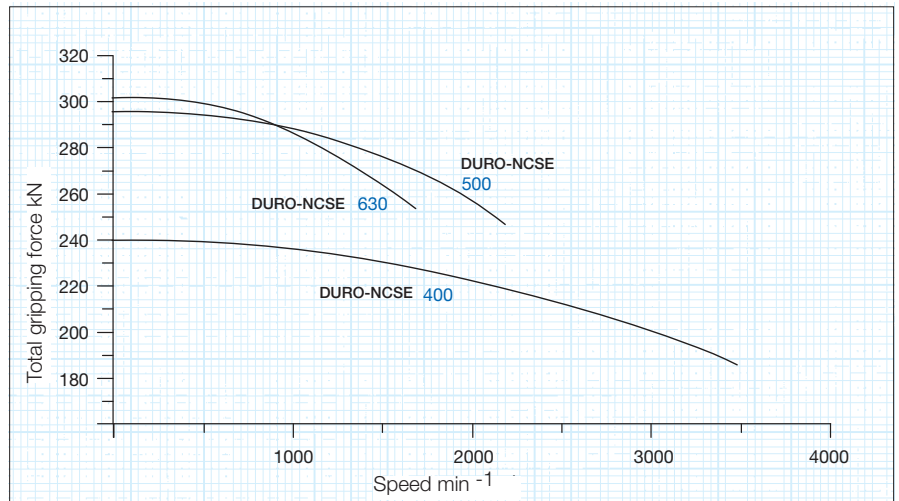
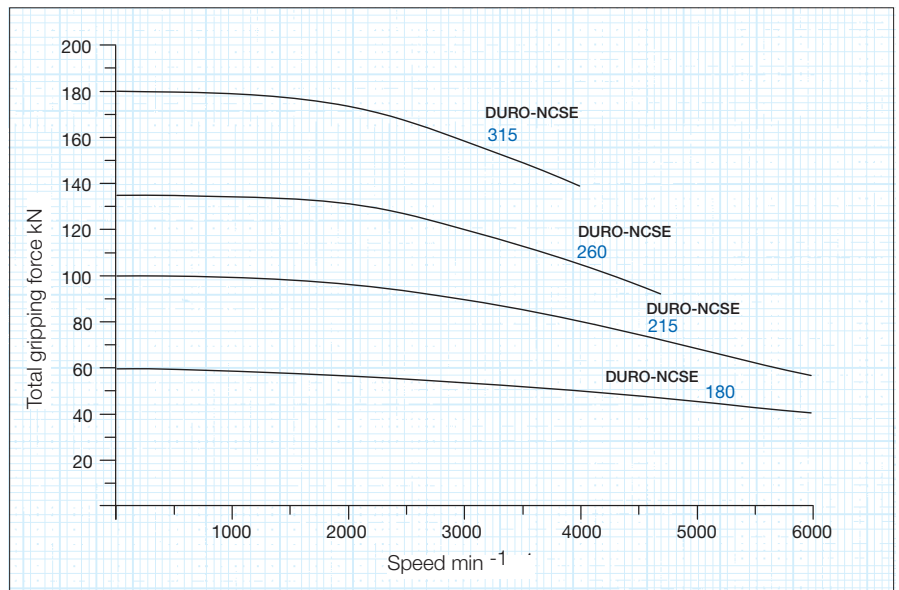
Gripping force / speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

curve:
max. centrifugal
force of top jaw



To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM. Measuring point near chuck face.

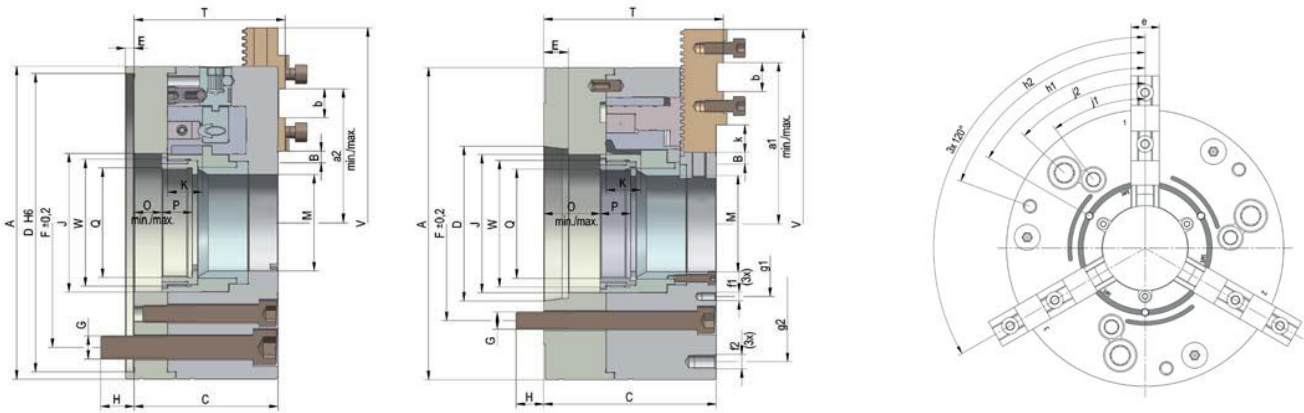


Quick-acting jaw change system with individual jaw unlocking

The individual locking arrangement means that handling is particularly easy with special large jaw pads when the workpiece requires them: Push key till stop, then turn in arrow direction.



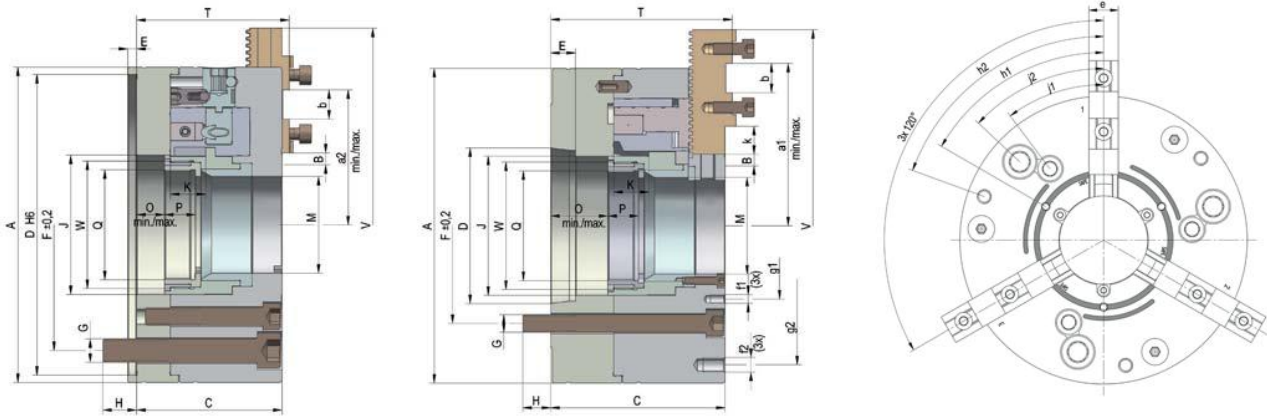
DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth



C 15
3-jaw power-chucks DURO-NCSE, quick-acting jaw change system, with individual jaw unlocking, with straight teeth
 Cylindrical center mount DIN 6353 / short taper mount ISO 702-1 (DIN 55026/55021)

| Item no. | 438355 | 438356 | 438357 | 438358 | 438359 | 438360 | 438361 | 438362 | 438363 | 438364 | 438365 |
|---|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|
| Size | 180 | 180 | 180 | 180 | 215 | 215 | 215 | 260 | 260 | 260 | 260 |
| Toothing | 4,712 | 4,712 | 4,712 | 4,712 | 4,712 | 4,712 | 4,712 | 5,498 | 5,498 | 5,498 | 5,498 |
| A mm | 180 | 180 | 180 | 180 | 215 | 215 | 215 | 260 | 260 | 260 | 260 |
| Jaw travel B mm | 6,9 | 6,9 | 6,9 | 6,9 | 7,8 | 7,8 | 7,8 | 8,8 | 8,8 | 8,8 | 8,8 |
| C mm | 91,8 | 91,8 | 104,8 | 105,8 | 105 | 119 | 121 | 121 | 121 | 136 | 138 |
| D mm | ZA 140 | ZA 170 | KK 5 | KK 6 | ZA 170 | KK 6 | KK 8 | ZA 170 | ZA 220 | KK 6 | KK 8 |
| E mm | 6 | 6 | 16 | 17 | 6 | 17 | 19 | 6 | 6 | 17 | 19 |
| F mm | 104,8 | 133,4 | 104,8 | 133,4 | 133,4 | 133,4 | 171,4 | 133,4 | 171,4 | 133,4 | 171,4 |
| G mm | M10 | M12 | M10 | M12 | M12 | M12 | M16 | M12 | M16 | M12 | M16 |
| H mm | 14 | 16 | 16 | 17 | 17 | 18 | 24 | 17 | 26 | 17 | 24 |
| J mm | 78 | 78 | 78 | 78 | 95 | 95 | 95 | 115 | 115 | 110 | 110 |
| Wedge stroke K mm | 21 | 21 | 21 | 21 | 24 | 24 | 24 | 28 | 28 | 28 | 28 |
| M mm | 53 | 53 | 53 | 53 | 66 | 66 | 66 | 81 | 81 | 81 | 81 |
| O min. | 1 | 1 | 14 | 15 | 1 | 15 | 17 | 1 | 1 | 15 | 17 |
| O max. | 22 | 22 | 35 | 36 | 25 | 39 | 51 | 29 | 29 | 43 | 45 |
| P mm | 17 | 17 | 17 | 17 | 21 | 21 | 21 | 22 | 22 | 22 | 22 |
| Q mm | M60x1,5 | M60x1,5 | M60x1,5 | M60x1,5 | M75x1,5 | M75x1,5 | M75x1,5 | M90x1,5 | M90x1,5 | M87x1,5 | M87x1,5 |
| T mm | 98,2 | 98,2 | 111,2 | 112,2 | 109,9 | 123,9 | 125,9 | 129,5 | 129,5 | 144,5 | 146,5 |
| V max. mm | 213 | 213 | 213 | 213 | 269 | 269 | 269 | 313 | 313 | 313 | 313 |
| W mm | M72x1,5 | M72x1,5 | M72x1,5 | M72x1,5 | M87x2 | M87x2 | M87x2 | M105x1,5 | M105x1,5 | M105x1,5 | M105x1,5 |
| a min. | 59,1 | 59,1 | 59,1 | 59,1 | 77,9 | 77,9 | 77,9 | 96,8 | 96,8 | 96,8 | 96,8 |
| a max. | 87,4 | 87,4 | 87,4 | 87,4 | 110,9 | 110,9 | 110,9 | 129,8 | 129,8 | 129,8 | 129,8 |
| a 2 min. | 50,1 | 50,1 | 50,1 | 50,1 | 58,9 | 58,9 | 58,9 | 64,8 | 64,8 | 64,8 | 64,8 |
| a 2 max. | 78,4 | 78,4 | 78,4 | 78,4 | 91,9 | 91,9 | 91,9 | 97,8 | 97,8 | 97,8 | 97,8 |
| Index adjustment | 6 (x4,712 =28,3) | 6 (x4,712 =28,3) | 6 (x4,712 =28,3) | 6 (x4,712 =28,3) | 7 (x4,712 =32,98) | 7 (x4,712 =32,98) | 7 (x4,712 =32,98) | 6 (x5,5 =33) | 6 (x5,5 =33) | 6 (x5,5 =33) | 6 (x5,5 =33) |
| b mm | 18 | 18 | 18 | 18 | 20 | 20 | 20 | 20 | 20 | 20 | 20 |
| e mm | 20 | 20 | 20 | 20 | 22 | 22 | 22 | 26 | 26 | 26 | 26 |
| f1 | M6/10 | M6/10 | M6/10 | M6/10 | M6/10 | M6/10 | M6/10 | M8/15 | M8/15 | M8/15 | M8/15 |
| f2 | M8/15 | M8/15 | M8/15 | M8/15 | M10/15 | M10/15 | M10/15 | M10/15 | M10/15 | M10/15 | M10/15 |
| g1 mm | 83 | 83 | 83 | 83 | 94 | 100 | 100 | 124 | 124 | 124 | 124 |
| g2 mm | 155 | 155 | 155 | 155 | 190 | 190 | 190 | 220 | 220 | 220 | 220 |
| h1 | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° |
| h2 | 60° | 60° | 60° | 60° | 70° | 70° | 70° | 77° | 77° | 77° | 77° |
| j1 | 35° | 35° | 35° | 35° | 37° | 37° | 37° | 30° | 30° | 30° | 30° |
| j2 | 45° | 45° | 45° | 45° | 47° | 47° | 47° | 40° | 40° | 40° | 40° |
| k mm | 9 | 9 | 9 | 9 | 19 | 19 | 19 | 32 | 32 | 32 | 32 |
| Maximum draw bar pull kN | 33 | 33 | 33 | 33 | 52 | 53 | 53 | 73 | 73 | 73 | 73 |
| Max. total clamping force approx. kN | 60 | 60 | 60 | 60 | 95 | 100 | 100 | 135 | 135 | 135 | 135 |
| Max. admissible speed min ⁻¹ | 6300 | 6300 | 6300 | 6300 | 6000 | 6000 | 6000 | 4700 | 4700 | 4700 | 4700 |
| Weight without jaws approx. kg | 18 | 18 | 18 | 18 | 24 | 26 | 26 | 44 | 44 | 47 | 49 |
| Actuating cylinders (recommended) | OVS-105 / SZS-52/130 | OVS-105 / SZS-52/130 | OVS-105 / SZS-52/130 | OVS-105 / SZS-52/130 | OVS-130 / SZS-67/130 | OVS-130 / SZS-67/130 | OVS-130 / SZS-67/130 | OVS-150 / SZS-86/200 | OVS-150 / SZS-86/200 | OVS-150 / SZS-85/200 | OVS-150 / SZS-85/200 |

DURO-NCSE 3-jaw, individual jaw unlocking, straight teeth



C 15

3-jaw power-chucks DURO-NCSE, quick-acting jaw change system, with individual jaw unlocking, with straight teeth

Cylindrical center mount DIN 6353 /short taper mount ISO 702-1 (DIN 55026/55021)

| Item no. | 438366 | 438367 | 438368 | 438369 | 438370 | 438371 | 438372 | 438373 | 438374 ▲ | 438375 ▲ | 438376 ▲ | 438377 ▲ | 438378 ▲ |
|--------------------------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|------------|------------|------------|------------|------------|
| Size | 315 | 315 | 315 | 315 | 400 | 400 | 400 | 400 | 500 | 500 | 500 | 630 | 630 |
| Toothing | 5,498 | 5,498 | 5,498 | 5,498 | 5,498 | 5,498 | 5,498 | 5,498 | 7 | 7 | 7 | 7 | 7 |
| A mm | 315 | 315 | 315 | 315 | 400 | 400 | 400 | 400 | 500 | 500 | 500 | 630 | 630 |
| Jaw travel B mm | 9,1 | 9,1 | 9,1 | 9,1 | 9,8 | 9,8 | 9,8 | 9,8 | 11,4 | 11,4 | 11,4 | 12,6 | 12,6 |
| C mm | 130 | 130 | 146 | 148 | 138 | 138 | 156 | 157 | 162 | 180 | 181 | 179,5 | 198,5 |
| D mm | ZA 220 | ZA 300 | KK 8 | KK 11 | ZA 300 | ZA 380 | KK 11 | KK 15 | ZA 380 | KK 11 | KK 15 | ZA 520 | KK 15 |
| E mm | 6 | 6 | 19 | 21 | 8 | 8 | 21 | 23 | 8 | 21 | 23 | 8 | 23 |
| F mm | 171,4 | 235 | 171,4 | 235 | 235 | 330,2 | 235 | 330,2 | 330,2 | 235 | 330,2 | 463,6 | 330,2 |
| G mm | M16 | M20 | M16 | M20 | M20 | M24 | M20 | M24 | M24 | M20 | M24 | M24 | M24 |
| H mm | 27 | 27 | 26 | 24 | 26 | 36,5 | 28 | 37,5 | 36 | 30 | 37 | 36 | 37 |
| J mm | 140 | 140 | 140 | 140 | 175,5 | 175,5 | 175,5 | 175,5 | 207 | 207 | 207 | 235 | 235 |
| Wedge stroke K mm | 28 | 28 | 28 | 28 | 30 | 30 | 30 | 30 | 35 | 35 | 35 | 40 | 40 |
| M mm | 104 | 104 | 104 | 104 | 128 | 128 | 128 | 128 | 155 | 155 | 155 | 167 | 167 |
| O min. | 1,5 | 1,5 | 17,5 | 19,5 | 1,5 | 1,5 | 19,5 | 20,5 | 1,5 | 19,5 | 20,5 | 1,5 | 20,5 |
| O max. | 29,5 | 29,5 | 45,5 | 47,5 | 31,5 | 31,5 | 49,5 | 50,5 | 36,5 | 54,5 | 55,5 | 41,5 | 60,5 |
| P mm | 25 | 25 | 25 | 25 | 29 | 29 | 29 | 29 | 29 | 29 | 29 | 35 | 35 |
| Q mm | M110x2 | M110x2 | M110x2 | M110x2 | 138x2 | 138,2 | M138x2 | M138x2 | M165x2 | M165x2 | M165x2 | M180x2 | M180x2 |
| T mm | 139 | 139 | 155 | 157 | 147 | 147 | 165 | 166 | 172 | 190 | 191 | 189,5 | 208,5 |
| V max. mm | 351 | 351 | 351 | 351 | 424 | 424 | 424 | 424 | 524 | 524 | 524 | 643 | 643 |
| W mm | M130x1,5 | M130x1,5 | M130x1,5 | M130x1,5 | M160x2 | M160x2 | M160x2 | M160x2 | M188x2 | M188x2 | M188x2 | M215x2 | M215x2 |
| a min. | 110,4 | 110,4 | 110,4 | 110,4 | 115,5 | 115,5 | 115,5 | 115,5 | 155,9 | 155,9 | 155,9 | 194,4 | 194,4 |
| a max. | 159,9 | 159,9 | 159,9 | 159,9 | 181,5 | 181,5 | 181,5 | 181,5 | 225,9 | 225,9 | 225,9 | 285,4 | 285,4 |
| a 2 min. | 66,4 | 66,4 | 66,4 | 66,4 | 76,5 | 76,5 | 76,5 | 76,5 | 94,9 | 94,9 | 94,9 | 94,4 | 94,4 |
| a 2 max. | 115,9 | 115,9 | 115,9 | 115,9 | 142,5 | 142,5 | 142,5 | 142,5 | 164,9 | 164,9 | 164,9 | 185,4 | 185,4 |
| Index adjustment | 9 (x5,5=49,5) | 9 (x5,5=49,5) | 9 (x5,5=49,5) | 9 (x5,5=49,5) | 12 (x5,5=66) | 12 (x5,5=66) | 12 (x5,5=66) | 12 (x5,5=66) | 10 (x7=70) | 10 (x7=70) | 10 (x7=70) | 13 (x7=91) | 13 (x7=91) |
| b mm | 20 | 20 | 20 | 20 | 26 | 26 | 26 | 26 | 30 | 30 | 30 | 30 | 30 |
| e mm | 32 | 32 | 32 | 32 | 32 | 32 | 32 | 32 | 45 | 45 | 45 | 45 | 45 |
| f1 | M8/15 | M8/15 | M8/15 | M8/15 | M8/15 | M8/15 | M8/15 | M8/15 | M8/16 | M8/16 | M8/16 | M8/16 | M8/16 |
| f2 | M12/20 | M12/20 | M12/20 | M12/20 | M16/20 | M16/20 | M16/20 | M16/20 | M20/37 | M20/37 | M20/37 | M16/30 | M16/30 |
| g1 mm | 140 | 140 | 140 | 140 | 170 | 170 | 170 | 170 | 200 | 200 | 200 | 245 | 245 |
| g2 mm | 268 | 238 | 268 | 268 | 330,2 | 330,2 | 330,2 | 330,2 | 420 | 420 | 420 | 520 | 520 |
| h1 | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° | 60° |
| h2 | 77° | 77° | 77° | 77° | 70° | 70° | 70° | 70° | 77° | 77° | 77° | 47° | 47° |
| j1 | 40° | 40° | 40° | 40° | 42,5° | 42,5° | 42,5° | 42,5° | 30° | 30° | 30° | 45° | 45° |
| j2 | 45° | 45° | 45° | 45° | 45° | 45° | 45° | 45° | 45° | 45° | 45° | 60° | 60° |
| k mm | 43 | 43 | 43 | 43 | 39 | 39 | 39 | 39 | 57 | 57 | 57 | 97 | 97 |
| Maximum draw bar pull kN | 100 | 100 | 100 | 100 | 133 | 133 | 133 | 133 | 173 | 173 | 173 | 173 | 173 |
| Max. total clamping force approx. kN | 180 | 180 | 180 | 180 | 240 | 240 | 240 | 240 | 305 | 305 | 305 | 312 | 312 |
| Max. admissible speed min-1 | 4000 | 4000 | 4000 | 4000 | 3500 | 3500 | 3500 | 3500 | 2200 | 2200 | 2200 | 1700 | 1700 |
| Moment of inertia J kgm2 | 0,96 | 0,96 | 0,96 | 0,96 | 2,67 | 2,67 | 2,67 | 2,67 | 16,1 | 16,1 | 16,1 | 22,8 | 22,8 |
| Weight without jaws approx. kg | 66 | 66 | 69 | 70 | 110 | 110 | 118 | 121 | 216 | 233 | 235 | 393 | 430 |
| Actuating cylinders (recommended) | OVS-200 / SZS-110/230 | OVS-200 / SZS-110/230 | OVS-200 / SZS-110/250 | OVS-200 / SZS-110/250 | OVS-200 / SZS-127/325 | OVS-200 / SZS-127/325 | OVS-200 / SZS-127/325 | OVS-200 / SZS-127/325 | OVS-200 | OVS-200 | OVS-200 | OVS-200 | OVS-200 |

Balancing quality G 6.3 in acc. with DIN 1940

Jaws DURO-NCSE

C 21
Base jaws, 3-jaw-set, hardened straight tothing, incl. cylinder screws, DIN 912-12.9



| Item no. | Chuck Size | Jaw length mm | Jaw width mm |
|----------|------------|---------------|--------------|
| 463548 | 180 | 65 | 20 |
| 463549 | 215 | 85 | 22 |
| 463550 | 260 | 104 | 26 |
| 463551 | 315 | 115 | 32 |
| 463552 | 400 | 125 | 32 |
| 463553 | 500 | 160 | 45 |
| 463554 ▲ | 630 | 200 | 45 |

A 36
Reversible top jaws, 3-jaw set, hardened tongue and groove for external and internal clamping - Material: 16 MnCr 5



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 094012 | 180 | 61,5 | 32,5 | 20,4 |
| 094013 | 215 | 70,5 | 38 | 24,4 |
| 094014 | 260/315 | 92 | 50 | 34,4 |
| 094015 | 400 | 107 | 56 | 35,7 |
| 094045 | 500/630 | 130 | 72 | 50,4 |

Additionally or later applied, hardened stepped jaws must be ground out in the chuck.

A28
Unstepped top jaw AB, 3-jaw set standard design, soft, material 16MnCr5



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 094008 | 180 | 85 | 36,5 | 20,3 |
| 094009 | 215 | 105 | 40 | 22 |
| 094010 | 260/315 | 125 | 50 | 30,4 |
| 094011 | 400 | 145 | 50 | 34,3 |
| 094046 | 500/630 | 180 | 73 | 50,5 |

C 21
One-piece reversible jaws, 3-jaw set, hardened straight tothing - material: 16 MnCr 5



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 463555 | 180 | 58 | 44 | 20 |
| 463556 | 215 | 75 | 51 | 22 |
| 463557 | 260 | 90 | 60 | 26 |
| 463558 | 315 | 117 | 66 | 32 |
| 463559 | 400 | 137 | 70 | 32 |
| 463560 ▲ | 500 | 176 | 93 | 45 |

Additionally or later applied, hardened jaws must be ground out in the chuck.

C 21
Soft one-piece jaws, 3-jaw set, can be hardened straight tothing, guidance hardened and ground - material: 16 MnCr 5



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 463562 ▲ | 180 | 65 | 55 | 20 |
| 463563 ▲ | 215 | 84 | 65 | 22 |
| 463564 | 260 | 99 | 84 | 26 |
| 463565 | 315 | 121 | 90 | 32 |
| 463566 ▲ | 400 | 148 | 100 | 32 |
| 463567 ▲ | 500 | 175 | 124 | 45 |
| 463568 ▲ | 630 | 230 | 134 | 45 |

Configure your individual clamping jaws online! www.web2product.biz

Jaws DURO-NCSE

C 21

Reversible claw-type top jaws, standard design tongue and groove, large clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137060 | 180 | 66 | 37,5 | 24 |
| 137119 | 500/630 | 124 | 62 | 50 |

C 21

Reversible claw-type top jaws, standard design tongue and groove, small clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137061 | 180 | 66 | 37,5 | 20 |
| 137064 | 215 | 81 | 43 | 24 |
| 137108 | 260/315 | 90 | 55 | 34 |
| 137114 | 400 | 100 | 62 | 34 |
| 137120 | 500/630 | 124 | 62 | 50 |

C 21

Reversible claw-type top jaws, standard design tongue and groove, medium clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137062 | 180 | 56 | 37,5 | 20 |
| 137065 | 215 | 66 | 43 | 24 |
| 137109 | 260/315 | 72 | 55 | 34 |
| 137115 | 400 | 86 | 62 | 34 |
| 137121 | 500/630 | 100 | 62 | 50 |

C 21

Reversible claw-type top jaws, wide version tongue and groove, small clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137066 | 215 | 79 | 43 | 34 |
| 137110 | 260/315 | 80 | 55 | 50 |
| 137116 | 400 | 93 | 62 | 50 |

C 21

Reversible claw-type top jaws, wide version tongue and groove, large clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137067 | 215 | 81 | 43 | 34 |
| 137111 | 260/315 | 90 | 55 | 50 |
| 137117 | 400 | 106 | 62 | 50 |

C 21

Reversible claw-type top jaws, wide version tongue and groove, medium clamping range, 1 piece, hardened



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 137068 | 215 | 66 | 43 | 34 |
| 137112 | 260/315 | 72 | 55 | 50 |
| 137118 | 400 | 86 | 62 | 50 |

Configure your individual clamping jaws online! www.web2product.biz

Jaws DURO-NCSE

C 21

Draw-down jaws, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 485522 ▲ | 180 | 65 | 43 | 20 |
| 485524 ▲ | 215 | 85 | 47 | 22 |
| 485526 | 260 | 104 | 58 | 26 |
| 485528 ▲ | 315 | 115 | 63 | 32 |
| 485530 ▲ | 400 | 125 | 63 | 32 |
| 485532 ▲ | 500 | 160 | 81 | 45 |

C 21

Draw-down jaws, additional clamping range, for interchangeable clamping inserts straight toothing, 1 piece, without clamping inserts



| Item no. | Chuck Size | Jaw length mm | Jaw height mm | Jaw width mm |
|----------|------------|---------------|---------------|--------------|
| 485523 ▲ | 180 | 72 | 43 | 20 |
| 485525 ▲ | 215 | 95 | 47 | 22 |
| 485527 ▲ | 260 | 104 | 58 | 26 |
| 485529 ▲ | 315 | 123 | 63 | 32 |
| 485531 ▲ | 400 | 134 | 63 | 32 |
| 485533 ▲ | 500 | 160 | 81 | 45 |

C 15

Interchangeable clamping inserts, 1 piece with claws



| Item no. | Chuck Size |
|----------|-------------|
| 141049 | 180/215 |
| 141052 | 260/315/400 |
| 141055 | 500 |

C 15

Interchangeable clamping inserts, 1 piece with serrated toothing



| Item no. | Chuck Size |
|----------|-------------|
| 141050 | 180/215 |
| 141053 | 260/315/400 |
| 141056 | 500 |

C 15

Interchangeable clamping inserts, 1 piece with heat treatable surface



| Item no. | Chuck Size |
|----------|-------------|
| 141051 | 180/215 |
| 141054 | 260/315/400 |
| 141057 | 500 |

Accessories DURO-NCSE

C 15

Mounting screws



| Item no. | Size | Contents of delivery | Thread |
|----------|-------------|----------------------|--------|
| 233058 | 180/215 | piece | M8x20 |
| 233030 | 260/315/400 | piece | M12x30 |
| 216569 | 500/630 | piece | M16x40 |

Socket head cap screw to DIN 912, 12.9

C 15

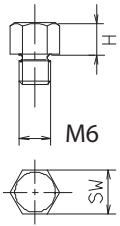
Special grease F80 for lathe chucks for lubrication and conservation of clamping force



| Item no. | Design | Contents |
|----------|-----------|----------|
| 308555 | Cartridge | 0,5 kg |
| 028975 | Tin | 1 kg |

C 15

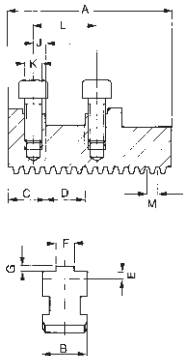
Changeable workpiece rests (in different lengths)



| Item no. | H mm | M | Key-width SW |
|----------|------|----|--------------|
| 289188 | 5 | M6 | 9 |
| 138950 | 10 | M6 | 9 |
| 725581 | 15 | M6 | 9 |

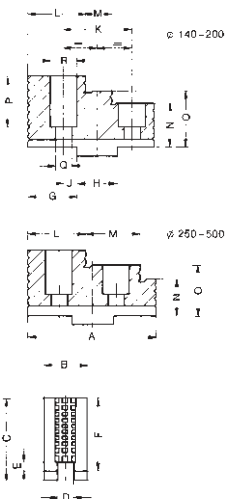
Jaw dimensions DURO-NCSE

Base jaw GB, with screws



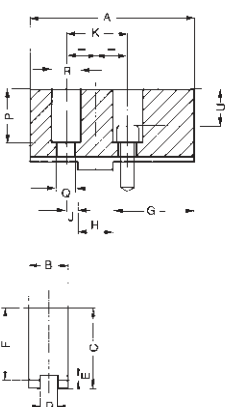
| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|----------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
| Type | 574-11 | 574-11 | 574-11 | 574-11 | 574-11 | 574-11 | 574-11 |
| Item no. 3-jaw | 463548 | 463549 | 463550 | 463551 | 463552 | 463553 | 463554 |
| A | 65 | 85 | 104 | 115 | 125 | 160 | 200 |
| B | 20 | 22 | 26 | 32 | 32 | 45 | 45 |
| C | 19 | 23 | 26 | 26 | 30 | 35 | 35 |
| DH7 | 18 | 20 | 20 | 20 | 26 | 30 | 30 |
| E | 5 | 4,5 | 5,5 | 6 | 6 | 9 | 9 |
| F | 8 | 10 | 12 | 12 | 12 | 16 | 18 |
| G | 2,5 | 2,5 | 3 | 3 | 3 | 4 | 4 |
| J | 7 | 10 | 10 | 10 | 14 | 15 | 15 |
| K | M8 | M8 | M12 | M12 | M12 | M16 | M16 |
| L | 32 | 40 | 40 | 40 | 54 | 60 | 60 |
| M | 4,712 | 4,712 | 5,498 | 5,498 | 5,498 | 7 | 7 |
| Weight/set kg | 0,7 | 1,0 | 1,8 | 2,7 | 3,0 | 7,1 | 9 |

Reversible top jaws UB, hardened



| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|----------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
| Type | 003-20 | 003-25 | 003-30 | 003-30 | 003-35 | 003-40 | 003-40 |
| Item no. 3-jaw | 094012 | 094013 | 094014 | 094014 | 094015 | 094045 | 094045 |
| A | 61,5 | 70,35 | 92 | 92 | 107 | 130 | 130 |
| B | 20,4 | 24,4 | 34,4 | 34,4 | 37,5 | 50,4 | 50,4 |
| C | 37 | 43 | 55 | 55 | 62 | 79 | 79 |
| D | 8 | 10 | 12 | 12 | 12 | 18 | 18 |
| E | 3 | 3,5 | 3,5 | 3,5 | 3,5 | 4,5 | 4,5 |
| F | 32,5 | 38 | 50 | 50 | 56 | 72 | 72 |
| G | 22,5 | 25,5 | 30 | 30 | 35,5 | 41,4 | 41,4 |
| H | 18 | 20 | 20 | 20 | 26 | 30 | 30 |
| J | 7 | 10 | 10 | 10 | 14 | 15 | 15 |
| K | 32 | 40 | 40 | 40 | 54 | 60 | 60 |
| L | 26,5 | 28,5 | 41 | 41 | 40 | 51 | 51 |
| M | 13 | 14 | 40,5 | 40,5 | 54 | 71 | 71 |
| N | 17,5 | 18 | 22 | 22 | 26 | 32 | 32 |
| O | 25 | 28 | 36 | 36 | 41 | 52 | 52 |
| P | 23,5 | 29 | 39 | 39 | 40 | 57 | 57 |
| Q | 9 | 9 | 14 | 14 | 14 | 18 | 18 |
| R | 15 | 15 | 20 | 20 | 20 | 26 | 26 |
| Weight/set kg | 0,6 | 1,0 | 2,4 | 2,4 | 3,4 | 7,6 | 7,6 |

Soft top jaws AB, material 16MnCr5

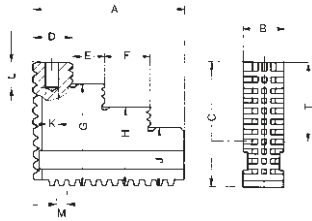


| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|----------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
| Type | 002-20 | 002-25 | 002-30 | 002-30 | 002-35 | 002-40 | 002-40 |
| Item no. 3-jaw | 094008 | 094009 | 094010 | 094010 | 094011 | 094046 | 094046 |
| A | 85 | 105 | 125 | 125 | 145 | 180 | 180 |
| B | 20,3 | 22 | 30,4 | 30,4 | 34,3 | 50,5 | 50,5 |
| C | 41 | 45 | 55 | 55 | 56 | 80 | 80 |
| D | 8 | 10 | 12 | 12 | 12 | 18 | 18 |
| E | 3 | 3,5 | 3,5 | 3,5 | 3,5 | 4,5 | 4,5 |
| F | 36,5 | 40 | 50 | 50 | 50 | 73 | 73 |
| G | 42 | 50 | 70 | 70 | 74 | 100 | 100 |
| H | 18 | 20 | 20 | 20 | 26 | 30 | 30 |
| J | 7 | 10 | 10 | 10 | 14 | 15 | 15 |
| K | 32 | 40 | 40 | 40 | 54 | 60 | 60 |
| P | 27,5 | 31 | 39 | 39 | 34 | 58 | 58 |
| Q | 9 | 9 | 14 | 14 | 14 | 18 | 18 |
| R | 15 | 15 | 20 | 20 | 20 | 26 | 26 |
| U | 19,5 | 23 | 27 | 27 | 22 | 42 | 42 |
| Weight/set kg | 1,3 | 2,2 | 4,5 | 4,5 | 6,8 | 13,2 | 13,2 |

 Jaw dimensions
DURO-NCSE

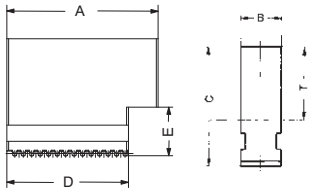
Jaw dimensions und Chucking capacities DURO-NCSE

Reversible one-piece jaws EB



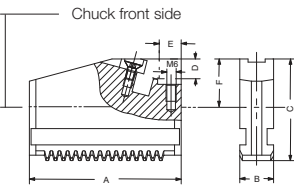
| Chuck size | 180 | 215 | 260 | 315 | 400 | 500/630 |
|----------------|--------|--------|--------|--------|--------|---------|
| Type | 574-27 | 574-27 | 574-27 | 574-27 | 574-27 | 574-27 |
| Item no. 3-jaw | 463555 | 463556 | 463557 | 463558 | 463559 | 463560 |
| A | 58 | 75 | 90 | 117 | 137 | 176 |
| B | 20 | 22 | 26 | 32 | 32 | 45 |
| C | 44 | 51 | 60 | 66 | 70 | 93 |
| G | 37 | 43 | 50 | 56 | 59 | 73 |
| H | 30 | 35 | 40 | 46 | 48 | - |
| J | 23 | 27 | 30 | 36 | 37 | 53 |
| M | 4,712 | 4,712 | 5,498 | 5,498 | 5,498 | 7 |
| T | 23 | 26 | 31 | 32 | 36 | 46 |
| Weight/set kg | 0,6 | 1,3 | 2,0 | 3,4 | 4,4 | 11,7 |

Soft one-piece jaws BL, material 16MnCr5



| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|----------------|--------|--------|--------|--------|--------|--------|--------|
| Type | 574-37 | 574-37 | 574-37 | 574-37 | 574-37 | 574-37 | 574-37 |
| Item no. 3-jaw | 463562 | 463563 | 463564 | 463565 | 463566 | 463567 | 463568 |
| A | 65 | 84 | 99 | 121 | 148 | 175 | 230 |
| B | 20 | 22 | 26 | 32 | 32 | 45 | 45 |
| C | 55 | 65 | 84 | 90 | 100 | 124 | 134 |
| D | 56 | 67,5 | 77 | 93 | 120 | 154 | 200 |
| E | 25 | 27 | 36 | 41 | 41 | 54 | 54 |
| T | 33 | 38 | 53 | 54 | 64 | 77 | 87 |
| Weight/set kg | 1,3 | 2,2 | 4,3 | 6,7 | 9,2 | 20,5 | 29,2 |

Draw-down jaws NBG, Straight toothing, for interchangeable clamping inserts (jaw without insert)

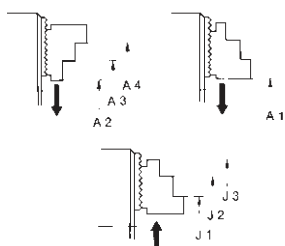


| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 |
|---------------------|-------------|---------|---------|---------|---------|---------|
| Jaw design | Type 545-30 | | | | | |
| Item no. Piece | 485522 | 485524 | 485526 | 485528 | 485530 | 485532 |
| A | 65 | 85 | 104 | 115 | 125 | 160 |
| B | 20 | 22 | 26 | 32 | 32 | 45 |
| C | 43 | 47 | 58 | 63 | 63 | 81 |
| D | 15 | 15 | 20 | 20 | 20 | 20 |
| E | 11 | 12 | 12 | 12 | 12 | 12 |
| F | 22,5 | 22,5 | 29,5 | 29,5 | 29,5 | 34 |
| Capacities external | 38-71 | 38-102 | 45-124 | 42-164 | 50-190 | 67-217 |
| Capacities internal | 125-160 | 170-223 | 207-289 | 234-344 | 252-397 | 346-500 |
| Max. swing | 197 | 251 | 306 | 374 | 425 | 524 |

Draw-down jaws NBG, for interchangeable clamping inserts (jaw without insert) Jaws for further clamping ranges

| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 |
|---------------------|-------------|---------|---------|---------|---------|---------|
| Jaw design | Type 549-30 | | | | | |
| Item no. Piece | 485523 | 485525 | 485527 | 485529 | 485531 | 485533 |
| A | 72 | 95 | 104 | 123 | 134 | 160 |
| E | 30 | 45 | 50,5 | 61,5 | 67 | 96 |
| Capacities external | 78-110 | 113-168 | 123-202 | 146-262 | 160-305 | 230-384 |
| Capacities internal | 98-122 | 114-166 | 131-214 | 136-245 | 140-285 | 180-332 |
| Max. swing | 197 | 271 | 306 | 390 | 443 | 524 |

Chucking capacities with reversible top jaws UB

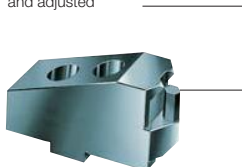


| Chuck size | Jaw position | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|-------------------|--------------|---------|---------|---------|---------|---------|---------|---------|
| External chucking | A1 | 11-68 | 18-84 | 27-104 | 25-163 | 28-240 | 30-304 | 30-425 |
| | A2 | 33-90 | 59-125 | - | - | - | - | - |
| | A3 | 77-134 | 115-181 | 83-149 | 111-213 | 98-243 | 54-290 | 55-407 |
| | A4 | 103-160 | 143-209 | 165-230 | 193-295 | 206-351 | 195-430 | 195-549 |
| Internal chucking | J1 | 65-122 | 75-141 | 108-185 | 143-245 | 85-230 | 133-408 | 133-525 |
| | J2 | 91-148 | 103-169 | 189-266 | 225-327 | 192-337 | 233-548 | 272-667 |
| | J3 | 135-192 | 159-225 | - | - | - | - | - |

Jaw dimensions DURO-NCSE

Reversible claw-type top jaws KB, standard design

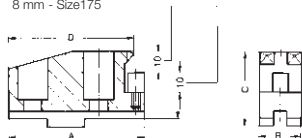
Workpiece stop, can be changed and adjusted



| Chuck size | 180 | 500 | 630 |
|---------------------|-----------------------------|---------|---------|
| Jaw design | Type 544-00 Standard design | | |
| Item no. Piece | 137060 | 137119 | 137119 |
| A | 66 | 124 | 124 |
| B | 24 | 50 | 50 |
| C | 37,5 | 62 | 62 |
| D | 17 | 39 | 39 |
| Capacities external | 130-159 | 314-477 | 390-584 |
| Capacities internal | 53-84 | 101-249 | 101-290 |

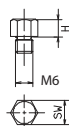
Jaws for further clamping ranges

8 mm - Size175



| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|---------------------|-----------------------------|---------|--------|---------|---------|---------|---------|
| Jaw design | Type 544-00 Standard design | | | | | | |
| Item no. Piece | 137061 | 137064 | 137108 | 137108 | 137114 | 137120 | 137120 |
| A | 66 | 81 | 90 | 90 | 100 | 124 | 124 |
| B | 20 | 24 | 34 | 34 | 34 | 50 | 50 |
| C | 37,5 | 43 | 55 | 55 | 62 | 62 | 62 |
| D | 61 | 71 | 78 | 78 | 90 | 112 | 112 |
| Capacities external | 25-56 | 41-103 | 48-150 | 48-210 | 53-237 | 143-294 | 216-411 |
| Capacities internal | 136-188 | 181-255 | 85-238 | 136-300 | 240-435 | 268-420 | 265-460 |

Accessories: Interchangeable workpiece stop (different lengths)

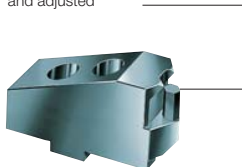


| Item no. | 289188 | 138950 | 725581 |
|----------|--------|--------|--------|
| M | M6 | | |
| H | 5 | 10 | 15 |
| SW | 9 | | |

| Chuck size | 180 | 215 | 260 | 315 | 400 | 500 | 630 |
|---------------------|-----------------------------|---------|--------|---------|---------|---------|---------|
| Jaw design | Type 544-00 Standard design | | | | | | |
| Item no. Piece | 137062 | 137065 | 137109 | 137109 | 137115 | 137121 | 137121 |
| A | 56 | 66 | 72 | 72 | 86 | 100 | 100 |
| B | 20 | 24 | 34 | 34 | 34 | 50 | 50 |
| C | 37,5 | 43 | 55 | 55 | 62 | 62 | 62 |
| D | 29 | 38,5 | 38 | 38 | 42 | 48 | 48 |
| Capacities external | 68-120 | 94-168 | 77-230 | 127-292 | 172-333 | 270-422 | 345-540 |
| Capacities internal | 93-126 | 116-200 | 85-238 | 136-300 | 168-329 | 142-293 | 139-333 |

Reversible claw-type top jaws KB, large design

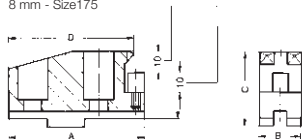
Workpiece stop, can be changed and adjusted



| Chuck size | 215 | 260 | 315 | 400 |
|---------------------|--------------------------|--------|--------|---------|
| Jaw design | Type 544-05 Large design | | | |
| Item no. Piece | 137066 | 137110 | 137110 | 137116 |
| A | 79 | 80 | 80 | 93 |
| B | 34 | 50 | 50 | 50 |
| C | 43 | 55 | 55 | 62 |
| D | 29,5 | 29 | 29 | 30 |
| Capacities external | 121-226 | - | - | - |
| Capacities internal | 74-172 | 73-203 | 80-264 | 130-291 |

Jaws for further clamping ranges

8 mm - Size175



| Chuck size | 215 | 260 | 315 | 400 |
|---------------------|--------------------------|---------|---------|---------|
| Jaw design | Type 544-05 Large design | | | |
| Item no. Piece | 137067 | 137111 | 137111 | 137117 |
| A | 81 | 90 | 90 | 106 |
| B | 34 | 50 | 50 | 50 |
| C | 43 | 55 | 55 | 62 |
| D | 71 | 78 | 78 | 90 |
| Capacities external | 44-124 | 53-152 | 70-214 | 76-237 |
| Capacities internal | 160-274 | 163-322 | 222-384 | 168-425 |

| Chuck size | 215 | 260 | 315 | 400 |
|---------------------|--------------------------|--------|---------|---------|
| Jaw design | Type 544-05 Large design | | | |
| Item no. Piece | 137068 | 137112 | 137112 | 137118 |
| A | 66 | 72 | 72 | 86 |
| B | 34 | 50 | 50 | 50 |
| C | 43 | 55 | 55 | 62 |
| D | 38,5 | 38 | 38 | 42 |
| Capacities external | 79-188 | 77-230 | 127-292 | 172-333 |
| Capacities internal | 105-210 | 85-238 | 136-300 | 168-329 |