

ZS Hi-Tru



Lathe and grinding chucks ZS Hi-Tru

APPLICATION

Optimized for machining workpieces which must be produced with **maximum concentricity**. Can be universally used, but is especially advantageous on turning and grinding machines as well as dividing units.

TYPE

Face spiral chuck in steel design, with which the workpiece can be adjusted very sensitively to the desired concentricity via 3 tangentially arranged adjusting spindles.

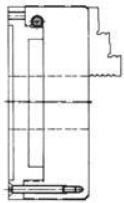
CUSTOMER BENEFITS

- ⊕ Radial fine adjustment for maximum concentricity
- ⊕ Repeatability 0.015 mm
- ⊕ Adjusting accuracy within 0.005 mm
- ⊕ Precision adjustment without opening the mounting screws
- ⊕ Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of turning and drilling jaws
- Hardened adjusting spindles, as well as their support surfaces
- Hardened spiral ring
- Steel take-up flange

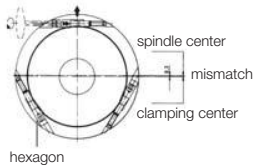
A09
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws DIN 6350, cylindrical centre mount, Form A



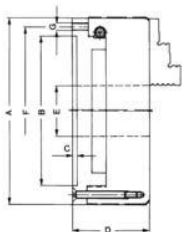
Item no.	Size	Cylindrical centre mount	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Total clamping force kN
180259	80	56	19	7000	30	13
180261	100	70	20	6300	60	27
180263	125	95	32	5500	80	31
180265	160	125	42	4600	110	47
180267	200	160	55	4000	140	55
180269	250	200	76	3000	150	63
180271	315	260	103	2300	180	69

On request from size 125 with 6 jaws or with short-taper mount to ISO 702-3 (DIN 55027) or ISO 702-2 (DIN 55029) Camlock
Further sizes and mountings available on request

DIN 6350
Dimensions ZS Hi-Tru
Cylindrical centre mount,
Form A



Size A	Zoll	B ^{+0,02}	C	D	F	G	Hexagon	Weight
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws								
80	3 ^{1/4}	56	3	50,5	67	3xM6	4	1,7
100	4	70	3	63	83	3xM8	5	3,6
125	5	95	4	72	108	3xM8	5	5,6
160	6 ^{1/4}	125	4	81	140	3xM10	6	10
200	8	160	4	89,5	176	3xM10	6	17,2
250	10	200	5	102	224	3xM12	8	34,5
315	12 ^{1/2}	260	5	122	286	3xM16	8	57,5



Jaws ZS Hi-Tru

A09
Inside jaw BB DIN 6350, outward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110155	80	set	37	26	12
110156	100	set	48	33,5	14
110157	125	set	52	41,5	18
110159	160	set	61	47,5	18
110160	200	set	69	53,5	20
110161	250	set	90	67,5	24
110162	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Outside jaw DB DIN 6350, inward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110165	80	set	37	26	12
110166	100	set	48	33,5	14
110167	125	set	52	41,5	18
110169	160	set	61	47,5	18
110170	200	set	69	53,5	20
110171	250	set	90	67,5	24
110016	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09
Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107588	80	set	37	26	12
107589	100	set	48	33,5	14
107590	125	set	52	41,5	18
107592	160	set	61	47,5	18
107593	200	set	69	53,5	20
107594	250	set	90	67,5	24
107595	315	set	130	79,5	34

A09
Base jaw GB DIN 6350, with fixing screw



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
107500	100	set	46	14
107501	125	set	55	18
107503	160	set	65	18
107504	200	set	78	20
107505	250	set	92	24
107506	315	set	108	34

A09
Reversible top jaws UB DIN 6350, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108045	100	set	47	29,5	22
108046	125	set	56	37,5	26
107936	160	set	66,7	41,5	28
107937	200	set	79,5	42,5	30
108049	250	set	95,3	52,5	36
108050	315	set	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

Jaws ZS Hi-Tru

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Jaws ZS Hi-Tru

A09

Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



Item no.	Chuck size	Contents of delivery	Jaw length	Jaw height	Jaw width
107633	100	Satz	53	30	22,5
107634	125	Satz	62	38	26,5
108581	160	Satz	74	42	28,5
108582	200	Satz	87	43	30,5
107637	250	Satz	103	53	36,5
107638	315	Satz	120	58	42,5

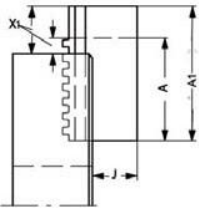
Jaws ZS Hi-Tru

A09

Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	A1 mm	X1 max. mm	A	J	X max.
130031	200	100	50	69	32,5	19
132658	250	120	56	90	41	26
132184	315	160	70	130	46	40
130033	200	120	70	69	32,5	19
128880	250	140	76	90	41	26
118908	315	200	110	130	46	40
121367	315	250	160	130	46	40

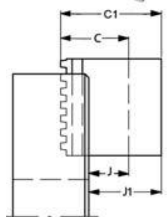


A09

Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	C1	J1 mm	C	J
125710	200	80	58,5	54	32,5
122188	250	100	73	68	41
132186	315	110	76	80	46
125712	200	120	98,5	54	32,5
122189	250	130	103	68	41
137096	315	140	106	80	46
125714	200	150	128,5	54	32,5
137102	250	150	123	68	41
137104	315	160	126	80	46

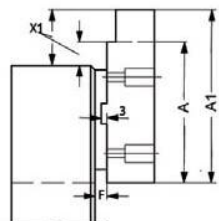


A09

Top jaw AB, special length, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	A1 mm	X1 max. mm	F	A	X max.
110086	200	100	43	6,8	87	30
112122	250	130	63	8	103	36
110624	315	160	76	5,5	120	36
112120	200	120	63	6,8	87	30
125428	250	150	83	8	103	36
112091	315	200	116	5,5	120	36
104710	250	180	113	8	103	36
112089	315	250	166	5,5	120	36

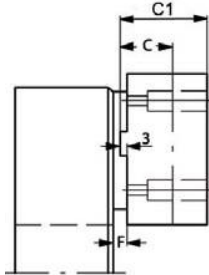


Jaws ZS Hi-Tru

A09
Top jaw AB, special height, soft, 16MnCr5, DIN 6350



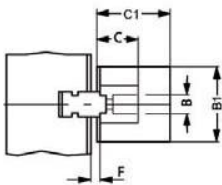
Item no.	Chuck size	C1	C	F
132155	200	60	43	6,8
119645	250	70	53	8
110435	315	80	58	5,5
128564	200	80	43	6,8
128571	250	100	53	8
110437	315	110	58	5,5
128573	250	150	53	8
128569	315	150	58	5,5



A09
Top jaw AB, special width and height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	B1	C1	B	C
105057	200	40	70	30,5	43
137090	250	50	80	36,5	53
143053	315	60	90	42	58
133259	200	50	80	30,5	43
133653	250	60	90	36,5	53
143057	315	80	110	42	58



C15
Mounting bolt for top jaws, bolt 1



Item no.	Chuck size	Thread	Contents of delivery
249299	100	M6x20	Stück
236949	125	M8x25	Stück
334571	160/200	M8x30	Stück
233025	250	M12x40	Stück
233026	315	M12x45	Stück

C15
Mounting bolt for top jaws, bolt 2



Id.-Nr.	Chuck size	Thread	Contents of delivery
216528	100	M6x16	Stück
233058	125/160/200	M8x20	Stück
227692	250	M12x25	Stück
233030	315	M12x30	Stück

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Jaws ZS Hi-Tru

Accessories ZS Hi-Tru

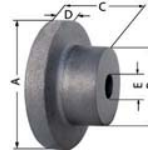
Accessories ZS Hi-Tru

A09 **Base plates** for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09 **Unfinished adapter plates** for **cylindrical mount**
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017113	80	3 ¼	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 ¼	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09 **Chip guard, piece**



Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09 **Special grease F80 for lathe chucks**
for lubrication and conservation of chucking power



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

A09 **Scroll**



Item no.	Size
102183	80/85
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315

A09 **Driving pinion**



Item no.	Size	Hexagon
178473	100	9
178474	110	9
178475	125	10
178476	140	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17

A09 **Pinion holder screw**



Item no.	Size
102185	85
100305	160
100006	270
101554	315

A09 **Standard key**



Item no.	Size	Square	Length mm
107426	80/85	6	62
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09 **Safety key with ejector**



Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09 **Elongated safety key with ejector**



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09 **Safety adapter with ejector**
for actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09 **Mounting screws**
with **cylindrical centre rim**

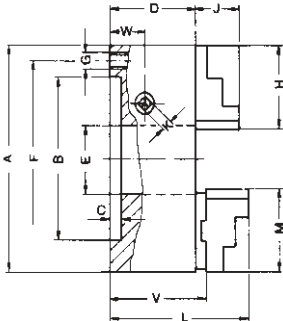


Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece

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.

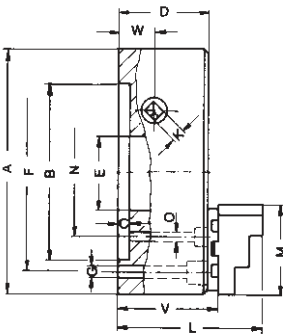
Size A	74	80	85	100	110	125	140	160	200	250	315	350	400	500	630
B ^{H6}	56	56	60	70	80	95	105	125	160	200	260	290	330	420	545
C	2,5	3	3	3	3	4	4	4	4	5	5	6	5	5	7
D	32,5	39,5	39,5	50	50	56	60	65	73,5	82	95	100	105	120	135
E	15	19	19	20	27	32	40	42	55	76	103	115	136	190	240
E _{max}	-	-	-	21	-	33	43	50	70	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

Chuck dimensions

Cylindrical centre mount



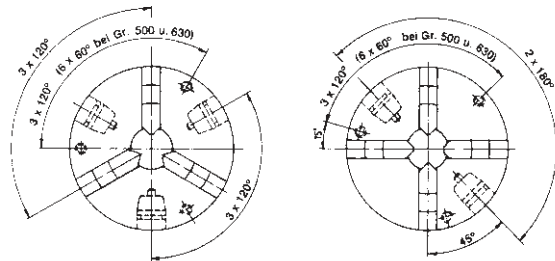
Enlarged bore max.

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	157
E	310	380	460	550	550
E _{max}	330	420	580	580	580
F	660	760	950	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)

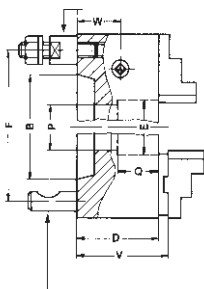


Short taper mount

DIN 55021, with setscrews and locknuts



DIN 55027, with setscrews and locknuts



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
	D	75	69	69	74	74
	E	20	32	32	40	40
DIN	F	75	75	85	75	85
Caml.	F	70,6	70,6	82,5	70,6	82,5
	P	-	-	-	-	-
	Q	-	-	-	-	-
	V	78,3	73,7	73,7	81,7	81,7
	W	43	33	33	35	35
Mounting holes	DIN	3	3	3	3	3
		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

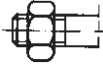
DIN 55029, with studs for Camlock

Chuck dimensions ZS - ZSU and Orange Line

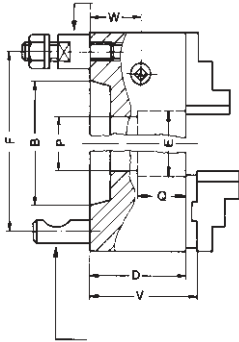
Chuck dimensions

Short taper mount

DIN 55021,
with setscrews and locknuts



DIN 55027,
with studs and nuts



DIN 55029,
with studs for Camlock

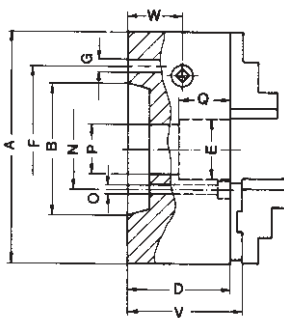
Size A	250				315				350			400			
Taper size	4	5	6	8	5	6	8	11	6	8	11	6	8	11	
B	63,5	82,5	106,4	139,7	82,5	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,6	
D	83	83	83	83	96	96	96	104	122	122	122	106	106	106	
E	60,7	76	76	76	79,6	103	103	103	103	115	115	103	136	136	
F	85 82,5	104,8	133,4	171,4	104,8	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235	
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	
W	27,5	27,5	27,5	27,5	31	31	31	39	56	56	56	36	36	36	
Mounting holes	DIN 3	4	4	4	4	4	4	6	4	4	6	4	4	6	
	Caml.	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	11	15	15	15	20	15	20	15	20	
B	139,7	196,9	285,8	196,9	285,8	196,9	285,8	285,8	285,8	412,8	285,8	412,8	285,8	412,8	
D	122	122	122	137	137	149	149	149	149	159	159	159	159	159	
E	136	190	190	192,7	240	310	310	380	380	460	460	550	550	550	
F	171,4	235	330,2	235	330,2	235	330,2	330,2	330,2	463,6	330,2	463,6	330,2	463,6	
P	136	-	-	192,7	-	192,7	281,2	281,2	-	281,2	407,5	281,2	407,5		
Q	61	-	-	63	-	76	76	76	-	85	85	85	85		
V	130,4	130,4	130,4	145,3	145,3	160	160	160	160	168	168	168	168		
W	40	40	40	50	50	50	50	50	50	55	55	55	55		
Mounting holes	DIN 4	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		
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	96	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	275	275	275	31	31	56	56	36	36
Mounting holes	*	3	6	3	6	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	

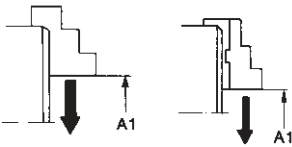
Size ØA	500	630		700		800		1000		1250	
Taper Size	11	11	15	11	15	11	15	15	20	15	20
B	196,9	196,9	285,9	196,9	285,9	196,9	285,9	412,8	285,9	412,8	285,9
D	122	137	137	149	149	149	149	149	159	159	159
E	190	190	190	310	285	380	380	380	460	505	550
F ²⁾	235	235	-	235	330,2	235	330,2	463,6	330,2	463,6	330,2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

1) 12 with ASA B 5.9 inch thread 2) With DIN 55026 Forme A and B; DIN 55021 Forme A and B; ASA B 5.9 A1/A2
 3) With DIN 55026 Forme B; ASA B 5.9 A1/B1 * 3-Jaw ** 4-Jaw

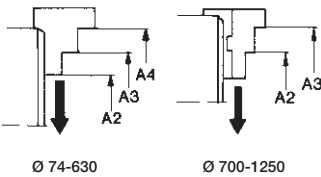
Chuck dimensions ZS - ZSU and Orange Line

Chucking capacities of jaw steps (standard values)

External chucking

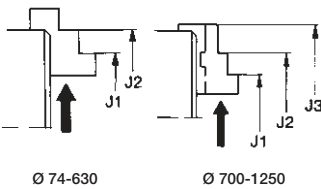


Size	74	80	85	100	110	125	140	160	200	250
A1 (BB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	4-72	4-100	5-122
A2 (DB)	2-24	2-30	2-30	3-38	3-42	3-53	3-53	3-72	4-100	5-122
A3 (DB)	23-46	27-55	27-55	38-71	39-77	39-89	47-97	47-116	56-152	73-190
A4 (DB)	45-68	52-80	52-80	70-100	70-100	75-125	91-140	91-160	104-200	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 (EG-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 ZG-ZS, ZGU-ZSU, ZG Hi-Tru chucks 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

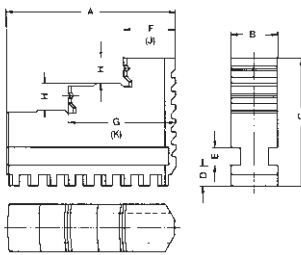
The clamping force is sum total of all jaw forces acting radially on the stationary workpiece. The clamping forces are approximate values. To obtain the specified clamping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RÖHM.

Size	Torque key	Total clamping force
74	30	11
80	30	13
100	60	27
125	80	31
140	90	40
160	11	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

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Dimensions F and G apply to outward stepped jaws **BB**
 Dimensions J and K apply to inward stepped jaws **DB**

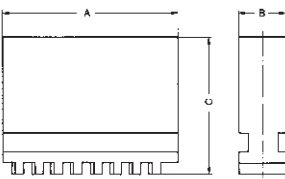
Outward stepped jaw (inside jaw) **BB**



Size	74 ¹⁾	80/85	100/110	125	140	160	200	250	315	300/400	500/630	
A	32	37	48	52	61	61	69	90	130	130	190	
B	10	12	14	18	18	18	20	24	34	34	42	
C	23	26	33,5	41,5	41,5	47,5	53,5	67,5	79,5	79,5	95	
D	4,7	4,8	6,3	7,3	8,3	8,3	8,3	10,3	11,3	11,3	14,9	
E	4	4,5	6	7	7	7	8	10	15	15	15	
F	10	12	15	17	18	18	20	27	41,5	41,5	50	
G	21	24,5	31	35	40	40	44	57	86,5	86,5	120	
H	5	6	6	8	8	10	10	14	15	15	20	
J	-	12	14	16	17	17	19	26	40	40	50	
K	-	24,5	30	34	39	39	43	56	85	85	120	
Jaw approx. kg	BB	0,03	0,05	0,1	0,2	0,22	0,25	0,3	0,7	1,8	1,8	3,8
	BL	0,05	0,08	0,15	0,27	0,32	0,38	0,52	1	2,4	2,4	5,2

1) Reversible jaws

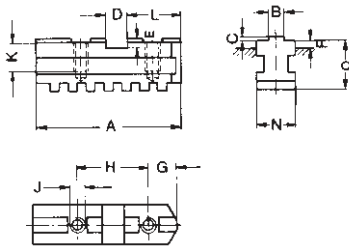
Unstepped jaw, soft (block jaw) **BL**



Jaw dimensions

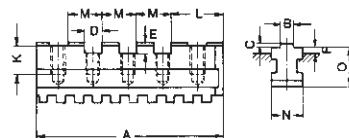
Base jaw **GB**

Ø 100-400

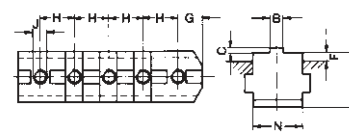


Size	100/110	125	140	160	200	250	315	350/400	500	630
A	46	55	65	65	78	92	108	127	165	203
B _{0,05}	7,94	7,94	7,94	7,94	7,94	12,7	12,7	12,7	12,7	12,7
C	2,5	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1	3,1
D ^{+0,01}	9,5	12,68	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03
E	6	7,6	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8
F	3,4	4,8	7,8	4,8	6,8	8	5,5	10,5 ²⁾	8,5	8,5
G	12	13	15,8	15,8	19	22,2	25,4	28,5	28,5	28,5
H	24	32	38,1	38,1	44,45	54	63,5	76,2	38,1	38,1
J	metr. M6	M8	M8	M8	M8	M12	M12	M16	M20	M20
	UNC 1/4"-20	5/16"-18	3/8"-16	3/8"-16	3/8"-16	1/2"-13	1/2"-13	5/8"-11	3/4"-10	3/4"-10
K	12	14,5	16	16	16	20	25	29	33	33
L	19,25	22,6	28,5	28,5	34,9	39,7	47,6	57,1	57,1	57,1
M	-	-	-	-	-	-	-	-	38,1	38,1
N	14	18	18	18	20	24	34	34	42	42
O	19,5	24	27	27	28	35	40	45	49	49
Grooves	1	1	1	1	1	1	1	1	2	3
Tapped holes	2	2	2	2	2	2	2	2	4	5
Jaw approx. kg	0,06	0,12	0,17	0,17	0,22	0,4	0,78	1	1,72	2,1

Ø 500-630



Ø 700-1250



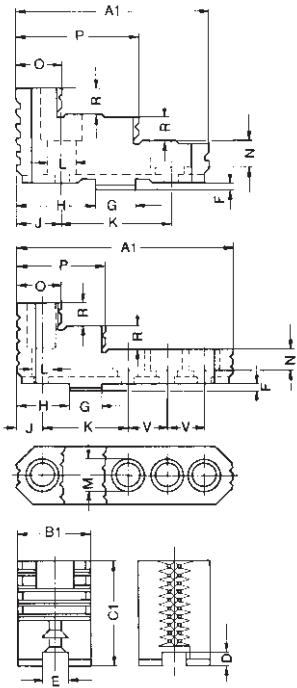
Size	700	800	1000	1250
A	253	291	329	367
B _{0,05}	12,7	12,7	12,7	12,7
C	3,1	3,1	3,1	3,1
D ^{+0,01}	19,03	19,03	19,03	19,03
E	10,8	10,8	10,8	10,8
F	11	11	9	9
G	28,5	28,5	28,5	28,5
H	38,1	38,1	38,1	38,1
J	metr. M20	M20	M20	M20
	UNC 3/4"-10	3/4"-10	3/4"-10	3/4"-10
K	37	37	37	37
L	57,1	57,1	57,1	57,1
M	38,1	38,1	38,1	38,1
N	55	55	55	55
O	62	62	62	62
Grooves	4	5	6	7
Tapped holes	6	7	8	9
Jaw approx. kg	6,2	7,1	8	9

1) Reversible jaws

2) Size

Jaw dimensions ZS - ZSU, Orange Line, ZS Hi-Tru

Reversible top jaw UB

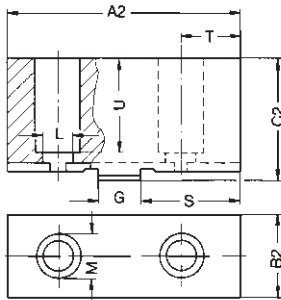


Chuck Size		100 110	125	140 160	200 230	250 270	315	350 400	500 630	700 800	1000 1250
A	1	47	56	66,7	79,5	95,3	109,5	127	127	210	210
	2	53	62	74	87	103	120	137	140	210	210
B	1	22	26	28	30	36	42	42	50	68	68
	2	22,5	26,5	28,5	30,5	36,5	42,5	42,5	50,5	68	68
C	1	29,5	37,5	41,5	42,5	52,5	57,5	64,5	79,5	89	110
	2	30	38	42	43	53	58	65	80	89	110
D		5,5	7,6	7,6	7,6	7,6	7,6	10,8	10,8	10,8	10,8
E		7,96	7,96	7,96	7,96	12,72	12,72	12,72	12,72	12,72	12,72
F		2,5	3,1	3,1	3,1	3,1	3,1	6,35	6,35	6,35	6,35
G		9,50	12,68	12,68	12,68	19,03	19,03	19,03	19,03	19,03	19,03
H		19,25	22,6	28,5	34,9	39,7	47,6	57,1	57,1	57,1	57,1
J		12	13	15,8	19	22,2	25,4	28,5	28,5	28,5	28,5
K		24	32	38,1	44,45	53,95	63,5	76,2	76,2	76,2	76,2
L		6,6	9	9 ¹⁾ 10,5 ²⁾	9 ¹⁾ 10,5 ²⁾	14	14	18	22	22	22
M		11	15	15 ¹⁾ 16 ²⁾	15 ¹⁾ 16 ²⁾	20	20	26	33	33	33
N		7	9	10	10	13,5	13,5	17	21	21,5	21,5
O		12	13	15,8	19	22,2	25,4	28,5	54,6	51	51
P		29,5	35	42,8	51,5	60,2	67,4	77	88,5	89	89
R		6	8	10	10	14	15	15	20	22	25
S		22,25	25,6	32,2	38,7	43,5	52,9	62,1	63,6	70	70
T		15	16	19,5	22,8	26	30,7	33,55	35	41,5	41,5
U		19	27	30	30	41	43	47	61	65	71
V		-	-	-	-	-	-	-	-	38,1	38,1
Jaw approx. kg	UB	0,12	0,19	0,27	0,39	0,66	1,02	1,27	2	4,45	6,1
	AB	0,21	0,34	0,5	0,7	1,2	1,86	2,18	3,04	8	10,8

Jaw dimensions

Saw-tooth standard model Cross-grooving from size 250 available from size 700 standard-model

Unstepped top jaw soft AB



Special-design jaws
for non-rotating clamping devices, for symmetrical components, for machine vices and NC-compact vices available in all desired modifications

