

Steel / Cast iron body Independent chucks

Independent 4-jaw chucks - Jaws individually adjustable through threaded adjusting spindle.

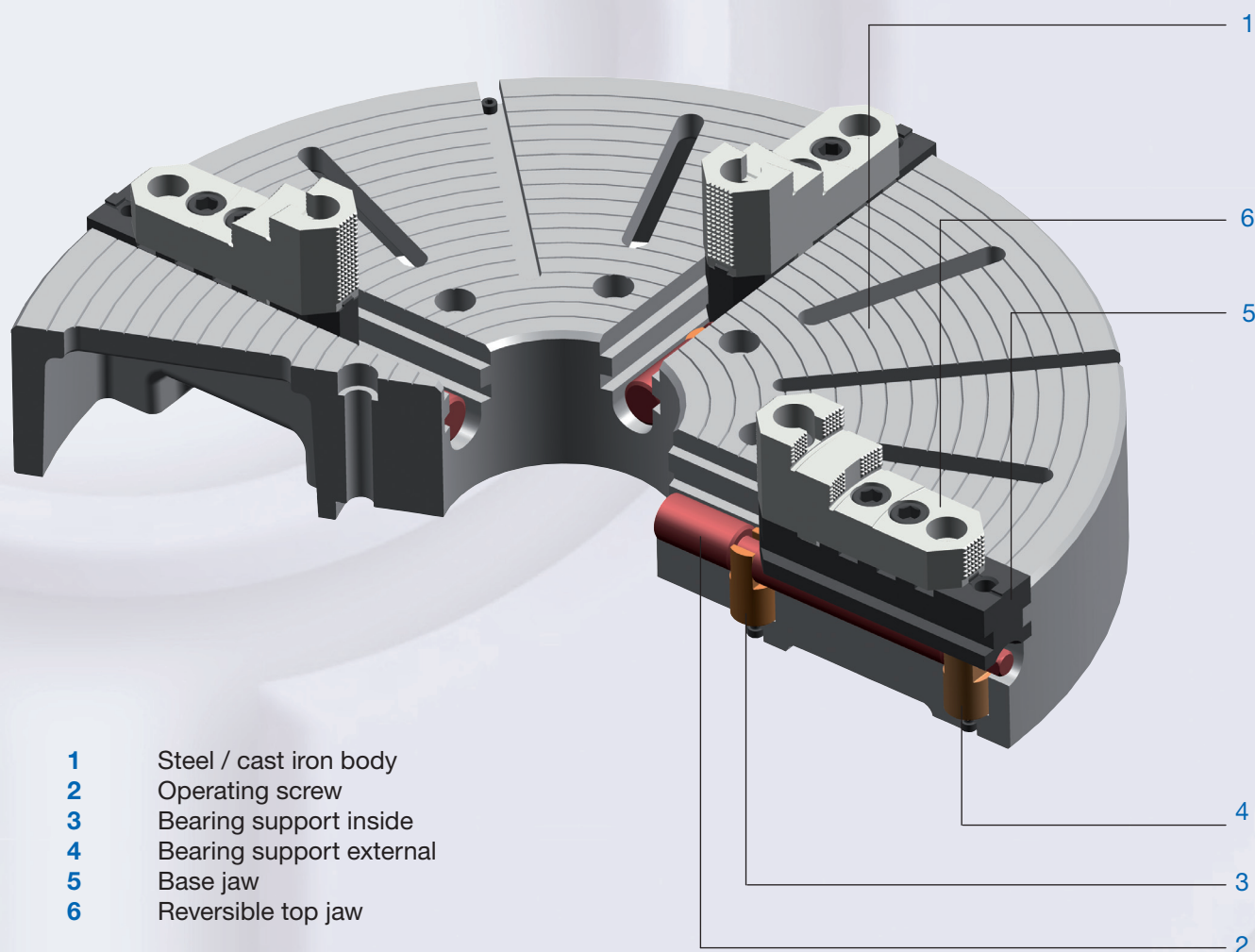
RÖHM-Independent chucks in steel or cast iron design with individually adjustable jaws are successfully established, where irregular, regular or round workpieces have to be clamped safely.

Mechanism

By turning the radial positioned pinion (2, hardened) the power will be transmitted to the clamping jaws (5, 6, hardened) directly. The operating screw will be kept in position by the bearing support (3, 4, hardened). Steel or cast iron body (1)

Lubrication

Independent chucks must be lubricated regularly to maintain their gripping force. Appropriate directions are included in the operating instructions supplied with each chuck.



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The jaws can be centered approximately by adjusting them to the concentric grooves, accurate centering requires the use of a dial indicator.

Independent 4-jaw chuck

Technical features:

- jaws individually adjustable through threaded adjusting spindle
- steel version, from size 400 with T-slots and bolt slots

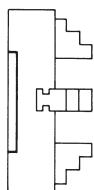
Delivery includes:

1 set of hard solid reversible jaws,
1 wrench,
mounting screws

or

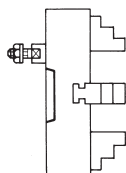
1 set of hard master jaws,
1 set of hard top jaws,
1 wrench,
mounting screws

Tool group A26
Steel independent chucks
cylindrical centre mount (without
mounting bolts)



Size	Through-hole	with one-piece reversible jaws	with reversible top jaws	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	70	139781 ■	137147 ■	2350	120	17
310	75	139796 ■	139720 ■	1970	120	17
400	95	139827 ■	135368 ■	1530	170	23
450	95	139842 ■	136944 ■	1360	170	23
500	95	139857 ■	135631 ■	1220	170	23
630	135	139887 ■	139723 ■	970	240	37
710	135	140800 ■	141097 ■	860	240	37
800	190	140801 ■	141106 ■	765	300	45

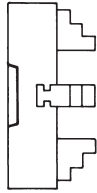
Tool group A26
Steel independent chucks
ISO 702-3 (DIN 55027), DIN 55022;
with studs and locknuts, optional
DIN 55021 with set screw and nut



Size	Mount short taper	Through-hole	with one-piece reversible jaws	with reversible top jaws	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	61	139782 ▲	137163 ▲	2350	120	17
260	5	70	139783 ▲	137164 ▲	2350	120	17
260	6	70	139784 ▲	137165 ▲	2350	120	17
310	5	75	139797 ▲	139724 ▲	1970	120	17
310	6	75	139798 ▲	139725 ▲	1970	120	17
310	8	75	139799 ▲	139726 ▲	1970	120	17
400	6	95	139828 ▲	135371 ▲	1530	170	23
400	8	95	139829 ■	135372 ▲	1530	170	23
400	11	95	139830 ▲	135358 ▲	1530	170	23
450	6	95	139843 ■	136947 ▲	1360	170	23
450	8	95	139844 ▲	136948 ▲	1360	170	23
450	11	95	139845 ▲	136957 ▲	1360	170	23
500	6	95	139858 ▲	135632 ▲	1220	170	23
500	8	95	139859 ■	135633 ▲	1220	170	23
500	11	95	139860 ▲	135696 ▲	1220	170	23
630	8	136	139888 ▲	139767 ▲	970	240	37
630	11	136	139889 ▲	139768 ▲	970	240	37
630	15	136	139890 ▲	139769 ▲	970	240	37
710	8	136	141088 ▲	141098 ▲	860	240	37
710	11	136	141089 ▲	141099 ▲	860	240	37
800	8	200	141092 ▲	141414 ▲	765	300	45
800	11	192	141093 ▲	600638 ▲	765	300	45
800	15	192	141094 ▲	141107 ▲	765	300	45
900	11	190	-	600639 ▲	680	300	45
900	15	190	-	600641 ▲	680	300	45
1000	11	190	-	141115 ▲	610	320	47
1000	15	190	-	141116 ▲	610	320	47
1000	20	190	-	600645 ▲	610	320	47
1100	11	190	-	150500 ▲	555	320	47
1100	15	190	-	600642 ▲	555	320	47
1100	20	190	-	600646 ▲	555	320	47
1200	11	190	-	150501 ▲	510	450	64
1200	15	190	-	600643 ▲	510	450	64
1200	20	190	-	600647 ▲	510	450	64

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Tool group A26
Steel independent chucks
ISO 702-1 (DIN 55026); DIN
55021, ASA B 5.9, A1/A2 metr.;
mounting from front (without
mounting bolts)

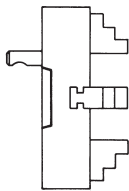


Size	Mount short taper	Through-hole	with one-piece reversible jaws	with reversible top jaws	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	61	139785 ¹⁾ ■	137260 ▲	2350	120	17
260	5	70	139786 ²⁾ ■	137261 ▲	2350	120	17
260	6	70	139787 ▲	137262 ▲	2350	120	17
310	5	75	139800 ²⁾ ■	139727 ▲	1970	120	17
310	6	75	139801 ▲	139728 ▲	1970	120	17
310	8	75	139802 ▲	139729 ▲	1970	120	17
400	6	95	139831 ▲	135373 ▲	1530	170	23
400	8	95	139832 ▲	135374 ▲	1530	170	23
400	11	95	139833 ▲	135360 ▲	1530	170	23
450	6	95	139846 ▲	136949 ▲	1360	170	23
450	8	95	139847 ▲	136950 ▲	1360	170	23
450	11	95	139848 ▲	136956 ▲	1360	170	23
500	6	95	139861 ▲	135700 ▲	1220	170	23
500	8	95	139862 ▲	135701 ▲	1220	170	23
500	11	95	139863 ▲	135702 ▲	1220	170	23
630	8	136	139891 ▲	139770 ▲	970	240	37
630	11	136	139892 ▲	139771 ▲	970	240	37
630	15	136	139893 ▲	139772 ▲	970	240	37
710	8	136	141090 ▲	141100 ▲	860	240	37
710	11	136	141091 ▲	141101 ▲	860	240	37
800	11	192	141095 ▲	141109 ▲	765	300	45
800	15	192	141096 ▲	141110 ▲	765	300	45
900	11	190	-	600650 ▲	600	300	45
900	15	190	-	600651 ▲	680	300	45
1000	11	190	-	141117 ▲	610	320	47
1000	15	190	-	141118 ▲	610	320	47
1000	20	190	-	600655 ▲	610	320	47
1100	11	190	-	150502 ▲	555	320	47
1100	15	190	-	600652 ▲	555	320	47
1100	20	190	-	600656 ▲	555	320	47
1200	11	190	-	150503 ▲	510	450	64
1200	15	190	-	600653 ▲	510	450	64
1200	20	190	-	600657 ▲	510	450	64

¹⁾ not for DIN 55021 or A1/A2 inch

²⁾ not for A1/A2 inch

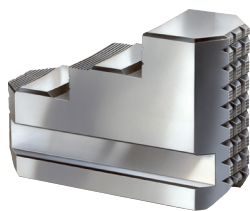
Tool group A26
Steel independent chucks
ISO 702-2 (DIN 55029); ASA B 5.9,
Type D, with studs for Camlock



Size	Mount short taper	Through-hole	with one-piece reversible jaws	with reversible top jaws	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	60	139791 ▲	137166 ▲	2350	120	17
260	5	70	139792 ▲	137254 ▲	2350	120	17
260	6	70	139793 ▲	137255 ▲	2350	120	17
310	5	75	139806 ▲	139733 ▲	1970	120	17
310	6	75	139807 ▲	139734 ▲	1970	120	17
310	8	75	139808 ▲	139735 ▲	1970	120	17
400	6	95	139837 ▲	135375 ▲	1530	170	23
400	8	95	139838 ▲	135376 ▲	1530	170	23
400	11	95	139839 ▲	135359 ▲	1530	170	23
450	6	95	139852 ▲	136951 ▲	1360	170	23
450	8	95	139853 ▲	136952 ▲	1360	170	23
450	11	95	139854 ▲	136955 ▲	1360	170	23
500	6	95	139867 ▲	135703 ▲	1220	170	23
500	8	95	139868 ▲	135704 ▲	1220	170	23
500	11	95	139869 ▲	135705 ▲	1220	170	23
630	8	136	139897 ▲	139776 ▲	970	240	37
630	11	136	139898 ▲	139777 ▲	970	240	37
630	15	136	139899 ▲	139778 ▲	970	240	37
710	8	136	140804 ▲	141102 ▲	860	240	37
710	11	136	140805 ▲	141103 ▲	860	240	37
710	15	136	-	141418 ▲	860	240	37
800	11	192	140810 ▲	141418 ▲	765	300	45
800	15	192	140811 ▲	600658 ▲	765	300	45
900	11	190	-	600660 ▲	680	300	45
900	15	190	-	600661 ▲	680	300	45
1000	11	190	-	141119 ▲	610	320	47
1000	15	190	-	141120 ▲	610	320	47
1000	20	190	-	600665 ▲	610	320	47
1100	11	190	-	150504 ▲	555	320	47
1100	15	190	-	600662 ▲	555	320	47
1100	20	190	-	600666 ▲	555	320	47
1200	11	190	-	150505 ▲	510	450	64
1200	15	190	-	600663 ▲	510	450	64
1200	20	190	-	600667 ▲	510	450	64

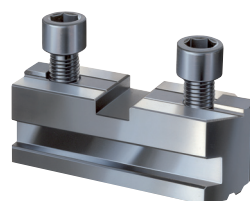
Jaws USE-USU

Tool group A09
Type 493 **Reversible jaw EB**
hardened



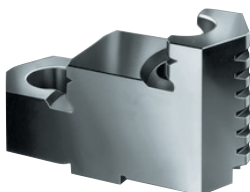
Item no.	Chuck Size	Number of jaws	Jaw length	Jaw height	Jaw width
022985 ■	260	4	85	64	35
022986 ■	310	4	94	66	35
163108 ■	400/450	4	112	80	40
163109 ■	500	4	136	88	40
175358 ■	630/710	4	172	108	45
247823 ■	800	4	185	130	60

Tool group A09
Type 497 **Base jaw GB**
with fixing screw



Item no.	Chuck Size	Number of jaws	Jaw length	Jaw height	Jaw width
304656 ■	260	4	91	40,1	35
304657 ■	310	4	107	40,1	35
304658 ■	400/450	4	126	47,1	40
304659 ■	500	4	164,4	47,1	40
304660 ■	630	4	165	51,1	45
304661 ■	710	4	202	51,1	45
304662 ■	800	4	240	61,1	60
150543 ▲	1200	4	350	92,2	70

Tool group A09
Type 403 **Reversible top jaws UB**
DIN 6350
hardened



Item no.	Chuck Size	Number of jaws	Jaw length	Jaw height	Jaw width
108057 ■	260	4	95,3	52,5	36
108058 ■	310	4	109,5	57,5	42
108059 ■	400/450	4	127	64,5	42
108060 ■	500/630/710	4	127	79,5	50
105085 ■	800/900	4	210	89	68
105101 ■	1000/1100/1200	4	210	110	68

Stepped and hardened jaws, supplied as supplement or as spares, must be ground on the chuck.
In case of a subsequent jaw delivery please return the chuck.

Tool group A09
Type 402 **Unstepped top jaw AB**
DIN 6350
soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Jaw length	Jaw height	Jaw width
107579 ●	260	4	103	53	36,5
107580 ●	310	4	120	58	42,5
107581 ●	400/450	4	137	65	42,5
107582 ●	500/630/710	4	140	80	50,5
105105 ■	800/900	4	210	89	68
105109 ■	1000/1100/1200	4	210	110	68

Accessories USE-USU

Tool group A26
Type 493 **Adjusting spindle**



Item no.	Size	Square	Hexagon
169142	260	10	-
166565	310	10	-
162110	400	13	-
162121	450	13	-
161629	500	13	-
161611	630	16	-
247826	800	18	-
150544	900	18	-
150545	1000	18	-
150546	1100	18	-
149776	1200	-	24

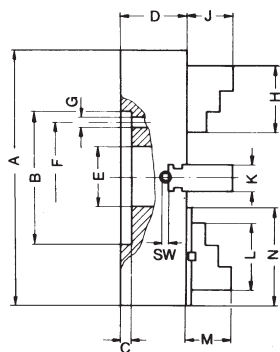
Tool group A26
Type 493 **Safety key**



Item no.	Size	Square	Hexagon
160096	260/310	10	-
160097	400	13	-
160098	450/500	13	-
160099	630/710	16	-
160100	800/900/1000/1100	18	-
150548	1200	-	24

Chuck dimensions steel body

Cylindrical centre mount



Size A	260	310	400	450	500	630	710	800	900	1000	1100	1200
BH ⁸	130	130	210	210	210	260	260	370	370	370	370	550
C	8	8	18	18	18	18	18	18	18	18	18	18
D USE-USU	85	95	112,5	112,5	112,5	122,5	132,5	145	145	160	160	200
E USE-USU	70	75	95	95	95	135	135	180	190	190	190	190
F	105	105	175	175	175	220	220	330	330	330	330	500
G	4x13,5	4x13,5	4x17	4x17	4x17	4x20,5	4x20,5	8x22	8x22	8x22	8x22	8x26
H	85	94	112	112	136	172	172	185	-	-	-	-
J	34	35	42	42	50	55,5	55,5	80	-	-	-	-
K	35	35	40	40	40	45	45	60	60	60	60	70
L	80	87	105	114	126	140	165	210	210	210	210	210
M	54	57	72	72	77	82	87	91	91	111	111	111
N	100	105	125	135	145	165	185	240	240	240	240	350
SW	10	10	13	13	13	16	16	18	18	18	18	24 ¹⁾
approx. kg	23	32	52	76	91	150	190	270	300	395	750	900

1) Outer hexagon

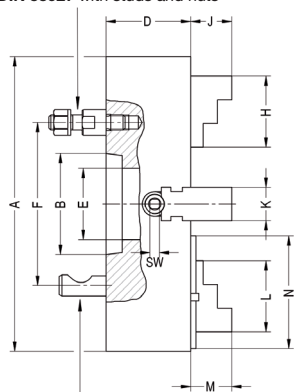
Short taper mount

DIN 55021 with setscrews and locknuts

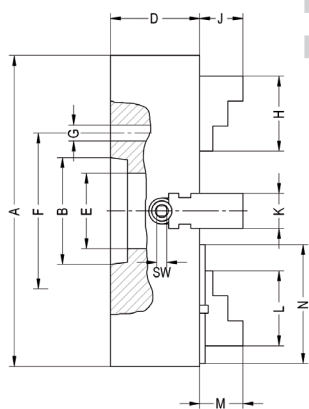


Size A		260			310			400			450			500			630		
Taper size		4 ¹⁾	5 ²⁾	6	5	6	8	6	8	11	6	8	11	6	8	11	8	11	15
B		63,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,9	139,7	196,9	285,8
D		75			82			112,5			112,5			112,5			122,5		
E		61	70	70	75			95			95			95			135		
F	DIN Camlock	85	104,8	133,4	104,8	133,4	171,4	133,4	171,4	235	133,4	171,4	235	133,4	171,4	235	171,4	235	330,2
		82,6																	
G		11	11	14	11	14	18	14	18	22	14	18	22	14	18	22	18	22	26
H		85			94			112			112			136			172		
J		34			35			42			42			50			55,5		
K	USE	35			35			40			40			40			45		
	USU	36			42			42			42			50			50		
L		95,3			109,5			127			127			127			127		
M		56,5			60,5			54			54			69			69		
N		91			107			126			126			164,4			165		
SW		10			10			13			13			13			16		
approx. kg		23			32			52			76			91			150		

DIN 55027 with studs and nuts



DIN 55029 with studs for camlock



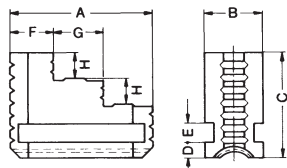
DIN 55026 mounting from front

- 1) Not for DIN 55021 or A1/A2 inch
2) Not for A1/A2 inch

Size A		710			800			900		1000			1100			1200		
Taper size		8	11	15	8	11	15	11	15	11	15	20	11	15	20	11	15	20
B		139,7	196,9	285,8	139,7	196,9	285,8	196,9	285,8	196,9	285,8	412,8	196,9	285,8	412,8	196,9	285,8	412,8
D		132,5			145			145		160			160			200		
E		135			180			190		190			190			190		
F		171,4	235	330,2	171,4	235	330,2	235	330,2	235	330,2	463,6	235	330,2	463,6	235	330,2	463,6
G		18	22	26	18	22	16	22	26	22	26	26	22	26	26	22	26	26
H		172			185			-		-			-			-		
J		55,5			80			-		-			-			-		
K	USE	45			60			60		60			60			70		
	USU	68			68			68		68			68			68		
L		210			210			210		210			210			210		
M		69			91			91		112			112			112		
N		202			240			240		240			240			350		
SW		16			18			18		18			18			24		
approx. kg		190			270			300		395			750			900		

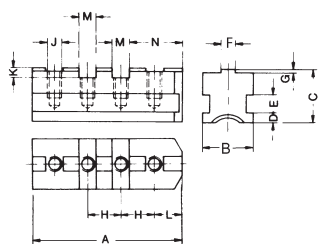
Jaw dimensions steel body

Reversible one-piece jaw EB



Size	260	310	400	450	500	630	710	800
A	85	94	112		136	172		185
B	35	35	40		40	45		60
C	64	66	80		88	108		130
D	10	10	10		10	12		14
E	12	12	14		14	14		18
F	27	30	36		42	52		55
G	29	32	38		46	60		65
H	14	15	19		23	26		30
approx. kg	0,8	0,9	1,6		2,25	3,5		4,2

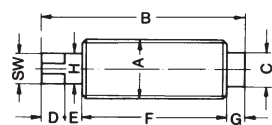
Base jaw GB



Size	260	310	400	450	630	710	800	900	1000	1100	1200
A	91	107	126		165	202		240			350
B	35	35	40		45	45		60			70
C	40,1	40,1	47,1		51,1	51,1		61,1			92,2
D	10	10	10		12	12		14			13
E	12	12	14		14	14		18			30
F	12,7	12,7	12,7		12,7	12,7		12,7			12,7
G	3,1	3,1	3,1		3,1	3,1		3,1			3,1
H	54	63,5	76,2		38,1	38,1		38,1			38,1
J	M12	M12	M16		M20	M20		M20			M20
K	7,6	7,6	10,8		10,8	10,8		10,8			10,8
L	21,2	24,4	27,5		27,5	27,5		27,5			26,4
M	19,03	19,03	19,03		19,03	19,03		19,03			19,03
N	38,7	46,6	56,1		56,1	56,1		56,1			55
Grooves	1	1	1		2	3		4			4
Tapped holes	2	2	2		4	5		6			9
approx. kg	0,8	0,9	1,1		1,4	2,2		2,8			3,5

Reversible top jaw UB and unstepped top jaw

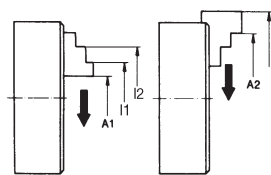
Adjusting spindle



Size	260	310	400	450	500	630	710	800	900	1000	1100	1200
A	26	26	30		30	34	34	40	40	40	40	48
B	83,5	99	129		167	200	200	240	290	323	372	425
C	14	14	16		16	28	28	33	33	33	33	-
D	13	15	16		16	20,5	20,5	24	24	24	24	35
E	13,5	15	18,5		18,5	21,5	21,5	24	24	24	24	30
F	45	55	78		116	143	143	172	222	265	305	360
G	12	14	16,5		16,5	13,5	13,5	20	20	20	20	-
H	14	14	16		16	20	20	22	22	22	22	28
SW	10	10	13		13	16	16	18	18	18	18	24 ¹⁾

1) with outer hexagon

Chuck capacities of jaw steps (standard values)



Size mm	260	310	400	450	500	630	710	800	900	1000	1100	1200
A1 min.	20	20	35	40	40	60	130	190	190	200	210	220
A2 max.	260	295	400	450	500	585	690	800	900	1000	1100	1200
I1 min.	75	80	90	100	145	145	145	170	170	195	195	195
I2 max.	260	310	400	450	520	650	730	820	960	1065	1165	1270
max. swing. dia.	305	355	465	510	570	675	785	870	1020	1120	1220	1320