

NEW



# DURO-TA XT KEY BAR CHUCK

The flexible lightweight for large and small workpieces

**RÖHM**  
driven by technology

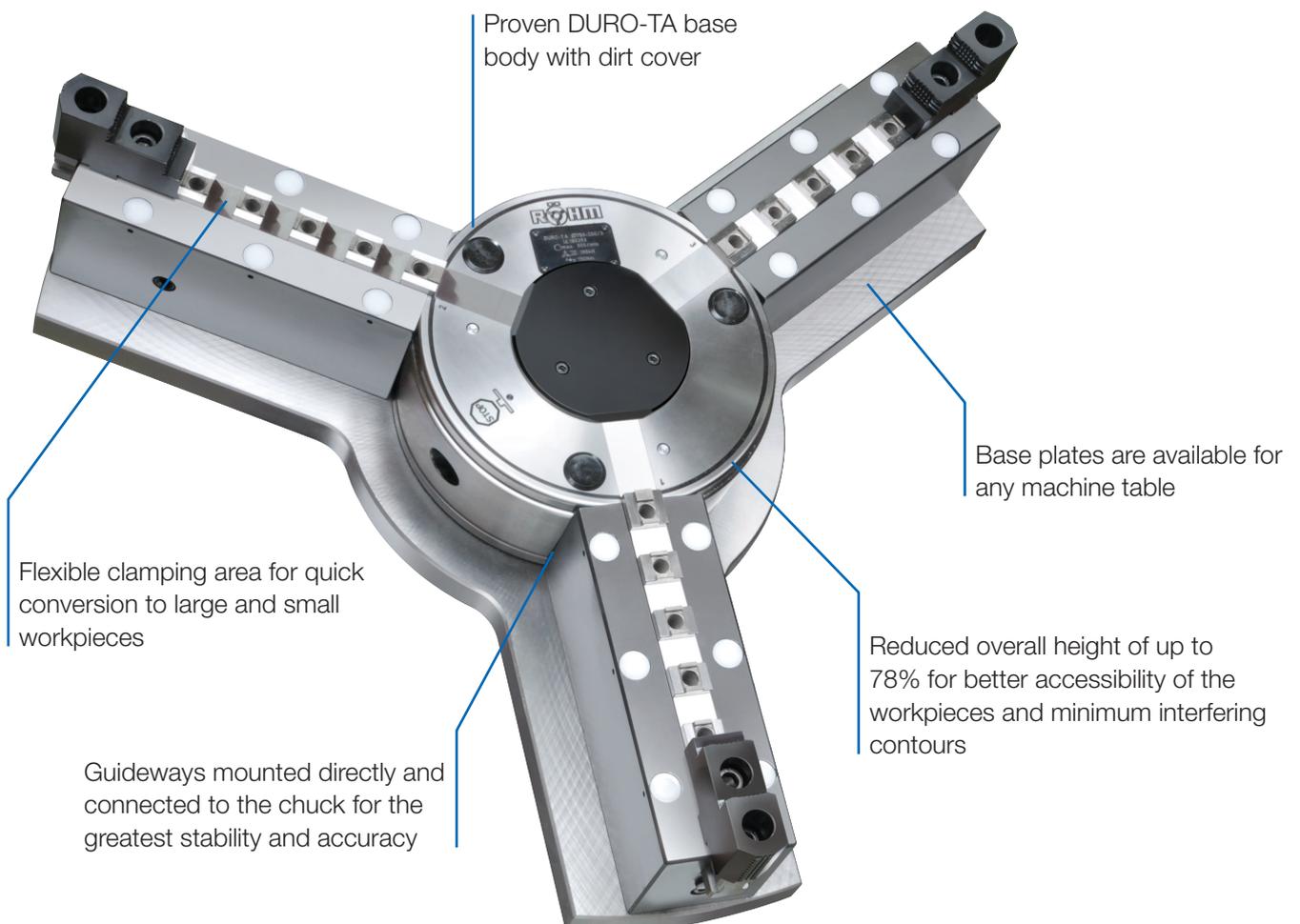
# DURO-TA XT KEY BAR CHUCK

To meet the requirements of turning and milling machines for flexibility, workpiece accessibility and weight reduction, RÖHM combines tried and proven technology with innovative concepts. Equipped with the proven DURO-TA base body and innovative guideways, the new DURO-TA XT is convincing as a flexible lightweight for machining large and small workpieces.

The new DURO-TA XT has an innovative concept for guideways that guarantees flexible and weight-reducing use. In contrast to other large chucks, the DURO-TA XT is up to 75 % lighter and that way makes maximum utilisation of the machine's potential possible and clamping of higher workpiece weights. Through the extended and easy to dis-

assemble guideways, the clamping area can be set flexibly and hence converted quickly to large and small workpieces. Through the direct mount on the base body, the guideways guarantee extremely high rigidity, stability and protection against penetration by dirt and dust.

## THE TRIED AND PROVEN – EVEN BETTER AND MORE FLEXIBLE



# BENEFITS AT A GLANCE

## WEIGHT-REDUCING BY UP TO 75%

- ⌚ Weight-reducing construction makes maximum utilisation of the machine's potential possible and clamping of higher workpiece weights
- ⌚ Protection of the machine's spindle and therefore lower maintenance costs

## MAXIMUM FLEXIBILITY AND FASTER CONVERSION

- ⌚ Flexible clamping area through extended guideways for fast conversion to large and small workpieces
- ⌚ Easy disassembling of the guideways for clamping smaller workpieces

## INNOVATIVE CONSTRUCTION

- ⌚ Minimum interfering contours and better workpiece accessibility through compact construction and reduced overall height by up to 78%
- ⌚ High stability through direct mounting of the firmly screwed guideways

# ONE CHUCK - TWO VARIANTS

For turning and milling machines

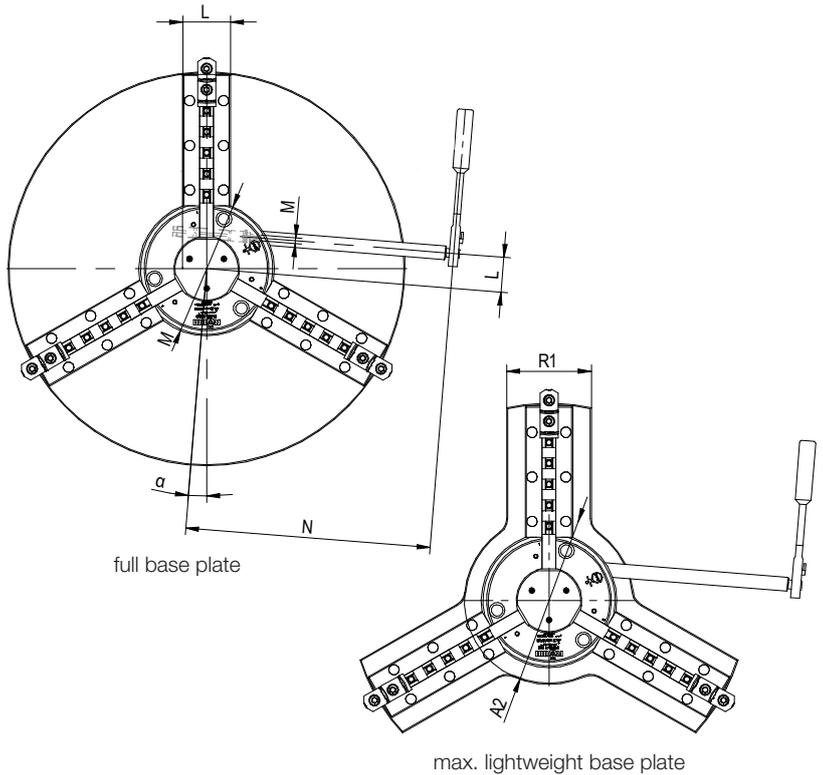


LARGE WORKPIECES  
DURO-TA XT with guideways



SMALL WORKPIECES  
DURO-TA XT without guideways

# DURO-TA XT



## DURO-TA XT key bar chuck, with complete base plate

Item no.	180312 ▲	180313 ▲	180314 ▲
Size	750 (250)	1000 (315)	1250 (500)
Max. total clamping force kN	185	190	290
Max. Torque Nm	190	210	320
Clamping range external with extended jaws* mm	145-715	220-995	220-1190
Clamping range external with standard jaws** mm	8-253	12-323	40-501
Interfering contour mm	804 / 769	1082 / 1014	1305
Speed max. min <sup>-1</sup>	800	570	570
Jaw travel mm	8	10,2	12,5
Weight kg	183	365	640
Weight reduction compared to a standard chuck %	75	68	65
Reduction of construction height compared to a standard chuck mm	78***	47***	22***

### Customized adaptations of the base plate for further weight reduction on the machine table on request

\* By disassembling of the stripping cap and use of standard reversible jaws

\*\* By shortening of the base jaws. Please consider shorter clamping ranges

\*\*\* Total height incl. top jaws

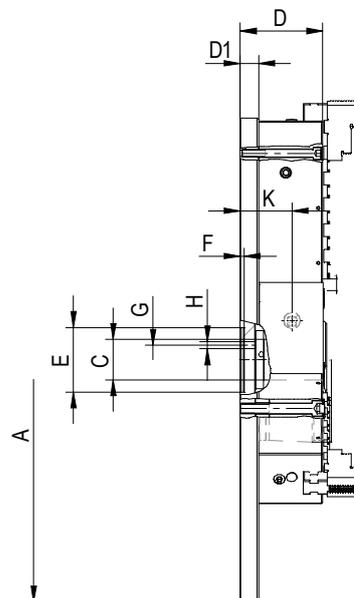
Further sizes and mountings available on request

Chuck Size A		750	1000	1250
Outer-ø Chuck	A1	256	322	507
Outer-ø Base plate	A2	320	400	590
Jaw movement	B	8	10,2	12,5
Bore <sup>1)</sup>	C	62	87	162
	D	127	152	160
	D <sup>1</sup>	28	34	35
	E <sup>2)</sup>	100	100	100
	F	6	6	6
	G	45	45	45
	H	11	11	11
	K	79,5	98,0	97,5
	L	66,5	86	152,5
	M	SW14	SW17	SW19
	N	464	565	724
	R	90	100	130
	R1	160	180	210
	S	370	495	615
Moment of inertia <sup>2)</sup>	kgm <sup>2</sup>	10,52	37,92	98,70
Moment of inertia <sup>2) 3)</sup>	kgm <sup>2</sup>	5,66	18,10	48,93
	α	4,6°	4,6°	4,5°
Weight approx.	kg	183	365	640
Weight approx. <sup>3)</sup>	kg	127	233	436

1) With dirt cover

2) The moment of inertia was measured with base jaws but without top jaws

3) With max. lightweight base plate



# JAWS DURO-TA XT

A28  
One-piece jaw EB, set, diagonally tothing, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094002	750 (250)	set	114	70	26
094003	1000 (315)	set	130	79	32
094043	1250 (500)	set	167	93	45

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

A28  
Unstepped jaw BL, set, diagonally tothing, unstepped, soft, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
249679	750 (250)	set	118,7	70	26
249680	1000 (315)	set	136,6	79	32
249681	1250 (500)	set	173,6	93	45

Jaws only usable in basic chuck.

A28  
Reversible top jaw UB, set, hardened, tongue and groove for external and internal clamping, material 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094014	750 (250)	set	92	50	34,4
094015	1000 (315)	set	107	56	35,7
094045	1250 (500)	set	130	72	50,4

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

A28  
Base jaw GB, set, diagonally tothing, with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw width mm
094006	750 (250)	set	110	26
094007	1000 (315)	set	125	32
094044	1250 (500)	set	160	45

Jaws only usable in basic chuck.

C 21  
Draw-down jaws, without clamping inserts, diagonally tothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
141041	750 (250)	118,7	58,5	26
141043	1000 (315)	136,4	63,9	32
141045	1250 (500)	173,6	73,4	45

Jaws only usable in basic chuck.

C 21  
Draw-down jaws, additional clamping range, for interchangeable clamping inserts, diagonally tothing, 1 piece, without clamping inserts



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
141042	750 (250)	118,7	58,5	26
141044	1000 (315)	136,4	63,9	32
141048	1250 (500)	173,6	73,4	45

Jaws only usable in basic chuck.

# JAWS DURO-TA XT

C 15  
Interchangeable clamping inserts, 1 piece, with claws



Item no.	Chuck Size
141052	750 (250)/1000 (315)
141055 ▲	1250 (500)

Jaws only usable in basic chuck.

C 15  
Interchangeable clamping inserts, 1 piece, with serrated toothing



Item no.	Chuck Size
141053	750 (250)/1000 (315)
141056 ▲	1250 (500)

Jaws only usable in basic chuck.

C 15  
Interchangeable clamping inserts, 1 piece, with heat treatable surface



Item no.	Chuck Size
141054	750 (250)/1000 (315)
141057 ▲	1250 (500)

Jaws only usable in basic chuck.

A28  
Reversible top jaw UB, set, hardened, tongue and groove for external and internal clamping, material 16 MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
180410 ▲	750	3	set	92	50	34,4
180411 ▲	1000	3	set	107	56	35,7
180412 ▲	1250	3	set	130	72	50,4

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

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



Item no.	Chuck Size	Contents of delivery	Jaw length mm	Jaw height mm	Jaw width mm
094010	750 (250)	set	125	50	30,4
094011	1000 (315)	set	145	50	34,3
094046	1250 (500)	set	180	73	50,5

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
137119	1250 (500)	124	62	50

# JAWS DURO-TA XT

C 21

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



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137109	750 (250)	72	55	34
137115	1000 (315)	86	62	34
137121	1250 (500)	100	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
137108	750 (250)	90	55	34
137114	1000 (315)	100	62	34
137120	1250 (500)	124	62	50

C 21

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



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137110	750 (250)	80	55	50
137116	1000 (315)	93	62	50

C 21

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



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137112	750 (250)	72	55	50
137118	1000 (315)	86	62	50

C 21

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



Item no.	Chuck Size	Jaw length mm	Jaw height mm	Jaw width mm
137111	750 (250)	90	55	50
137117	1000 (315)	106	62	50

## Accessories DURO-TA XT

C 15 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

C15 Torque wrench



Item no.	Torque Nm	Length mm	Output	Working accuracy
10004116	20-120	435	12.7=1/2"	3%
10004117	60-320	659	12.7=1/2"	3%

A08 Safety adapter



Item no.	Size	Square	Length mm	Mount
1129759	750 (250)	14	186	1/2"
1129449	1000 (315)	17	192	1/2"
1111583	1250 (500)	19	220	1/2"



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