

NEW



DURO-TA XT KEY BAR CHUCK

The flexible lightweight for large and small workpieces

RÖHM
driven by technology

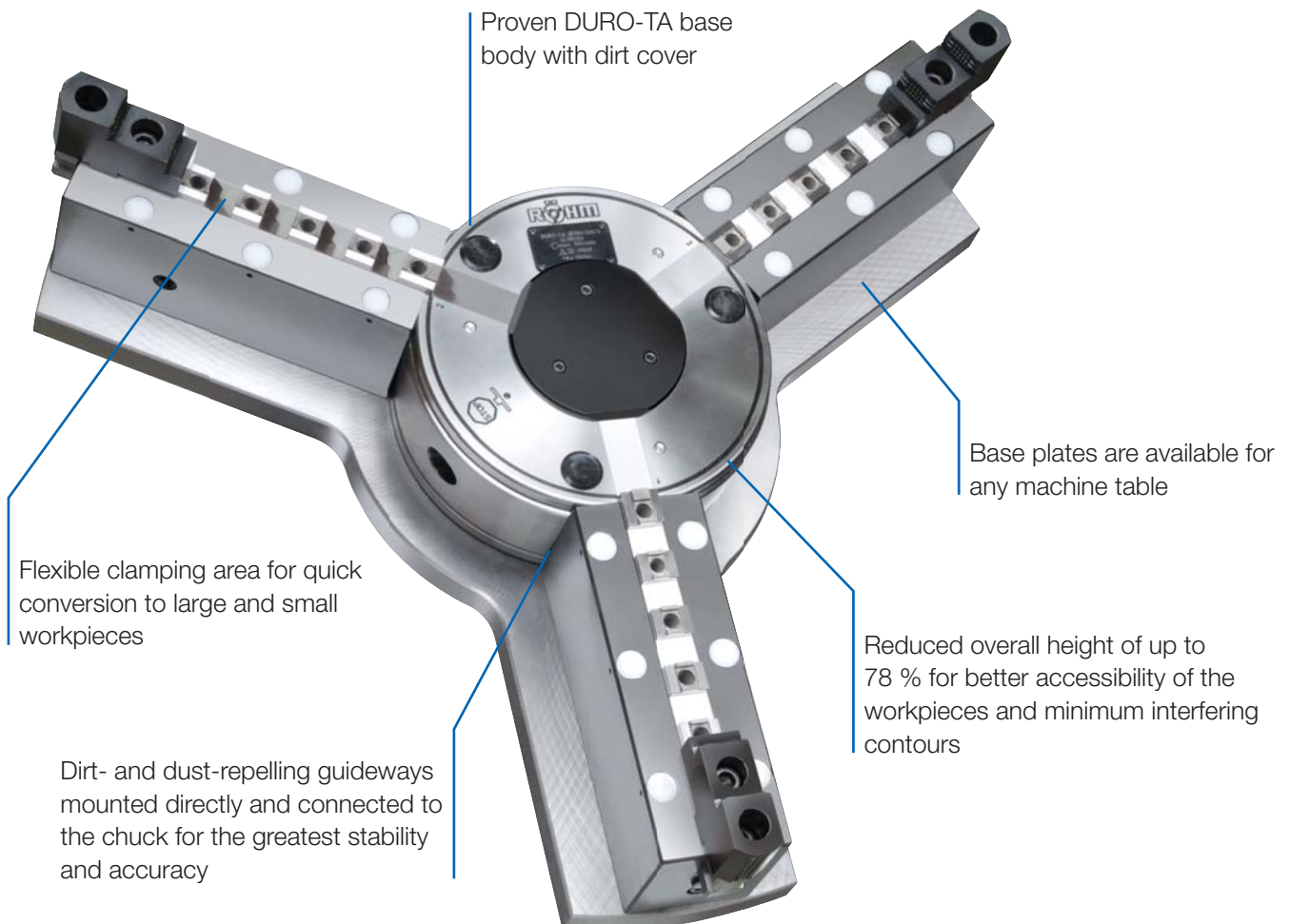
DURO-TA XT KEY BAR CHUCK

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

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

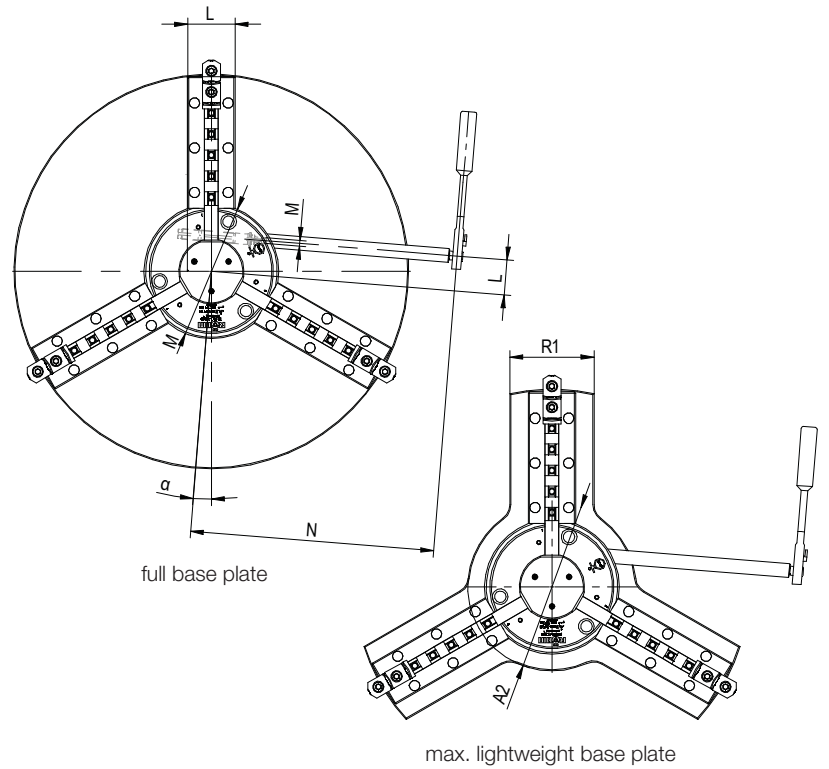


LARGE WORKPIECES
DURO-TA XT with guideways



SMALL WORKPIECES
DURO-TA XT without guideways

DURO-TA XT

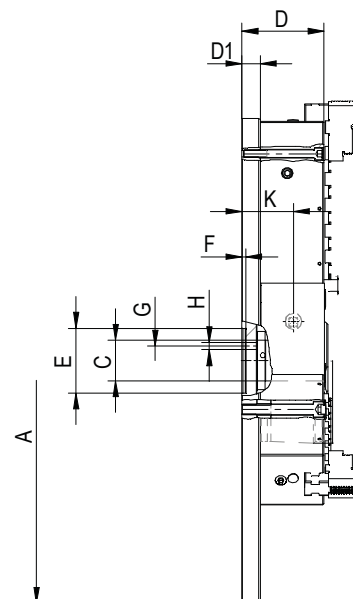


DURO-TA XT Key bar chuck

Item no.	180312	180313	180314
Size	750 (250)	1000 (315)	1250 (500)
Clamping force kN	185	240	290
Torque Nm	190	210	320
Clamping range external with extended jaws mm	Ø 145-715	Ø 220-995	Ø 220-1190
Clamping range external with standard jaws mm	Ø 8-253*	Ø 12-323*	Ø 40-501*
Interfering contour mm	804 / 769**	1082 / 1014**	1305
Rotation speed min ⁻¹	800	570	450
Clamping stroke mm	8	10,2	12,5
Weight kg	130	235	440
Weight reduction compared to a standard chuck %	75	68	65
Reduction of construction height compared to a standard chuck mm	78***	47***	22***

* 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.

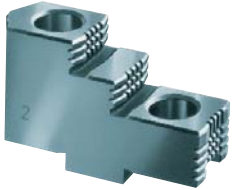
Chuck Size A		750	1000	1250
Outer-Ø Chuck	A1	256	322	507
Outer-Ø Base plate	A2	320	400	590
Jaw movement	B	8	10,2	12,5
Bore ¹⁾	C	62	87	162
	D	127	152	160
	D1	28	34	35
	EH6	100	100	100
	F	6	6	6
	G	45	45	45
	H	11	11	11
	K	79,5	98,0	97,5
	L	66,5	86	152,5
	M	SW14	SW17	SW19
	N	464	565	724
	R	90	100	130
	R1	160	180	210
	S	370	495	615
Moment of inertia ²⁾	kgm ²	10,52	37,92	98,70
Moment of inertia ^{2) 3)}	kgm ²	5,66	18,10	48,93
	α	4,6°	4,6°	4,5°
Weight approx.	kg	183	365	640
Weight approx. ³⁾	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

Type 003 **Reversible top jaw UB**, set hardened



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

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.

Type 002 **Unstepped top jaw AB**, set standard design, soft, material 16MnCr5



Item no.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
094010	750	3	Satz	125	50	30,4
094011	1000	3	Satz	145	50	34,3
094046	1250	3	Satz	180	73	50,5

Type 544-00 **reversible claw-type top jaws, standard design** tongue and groove, **small clamping range**, 1 piece hardened



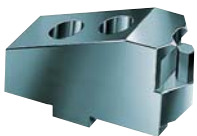
Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137119	1250	124	62	50

Type 544-00 **reversible claw-type top jaws, standard design** tongue and groove, **large clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137108	750	90	55	34
137114	1000	100	62	34
137120	1250	124	62	50

Type 544-00 **reversible claw-type top jaws, standard design** tongue and groove, **middle sized clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137109	750	72	55	34
137115	1000	86	62	34
137121	1250	100	62	50

Type 544-05 **reversible claw-type top jaws, large design** tongue and groove, **small clamping range**, 1 piece, hardened



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137110	750	80	55	50
137116	1000	93	62	50

JAWS DURO-TA XT

Type 544-05 reversible claw-type top jaws, large design tongue and groove, large clamping range, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137111	750	90	55	50
137117	1000	106	62	50



Type 544-05 reversible claw-type top jaws, large design tongue and groove, middle sized clamping range, 1 piece, hardened

Item no.	Chuck Size	Jaw length	Jaw height	Jaw width
137112	750	72	55	50
137118	1000	86	62	50



Type 000 One-piece jaw EB, set hardened

Item No.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
094002*	750	3	Satz	114	70	26
094003*	1000	3	Satz	130	79	32
094043*	1250	3	Satz	167	93	45



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.
* only usable in basic chuck.

Type 000 Unstepped Jaw BL, set unstepped, soft, material 16MnCr5

Item No.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
249679*	750	3	Satz	118,7	70	26
249680*	1000	3	Satz	136,6	79	32
249681*	1250	3	Satz	173,6	93	45



* only usable in basic chuck.

Type 003 Reversible top jaw UB, set hardened

Item No.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw height	Jaw width
094014*	750	3	Satz	92	50	34,4
094015*	1000	3	Satz	107	56	35,7
094045*	1250	3	Satz	130	72	50,4



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.
* only usable in basic chuck.

JAWS DURO-TA XT

Type 002 **Base jaw GB**, set with mounting bolts



Item No.	Chuck Size	Number of jaws	Contents of delivery	Jaw length	Jaw width
094006*	750	3	Satz	110	26
094007*	1000	3	Satz	125	32
094044*	1250	3	Satz	160	45

* only usable in basic chuck.

Type 545-00 **Draw-down jaws**, for interchangeable clamping inserts, **diagonally toothed**, 1 piece, without clamping inserts



Item No.	Chuck Size	Jaw length	Jaw height	Jaw width
141041*	750	118,7	58,5	26
141043*	1000	136,4	63,9	32
141045*	1250	173,6	73,4	45

* only usable in basic chuck.

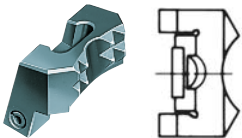
Type 545-00 **Draw-down jaws**, **additional clamping range**, for interchangeable clamping inserts **diagonally toothed**, 1 piece, without clamping inserts



Item No.	Chuck Size	Jaw length	Jaw height	Jaw width
141042*	750	118,7	58,5	26
141044*	1000	136,4	63,9	32
141048*	1250	173,6	73,4	45

* only usable in basic chuck.

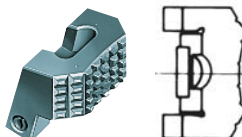
Type 545-60 **Interchangeable clamping inserts**, 1 piece **with claws**



Item no.	Chuck Size
141052*	750/1000
141055*	1250

* only usable in basic chuck.

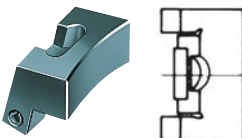
Type 545-70 **Interchangeable clamping inserts**, 1 piece **with serrated toothing**



Item no.	Chuck Size
141053*	750/1000
141056*	1250

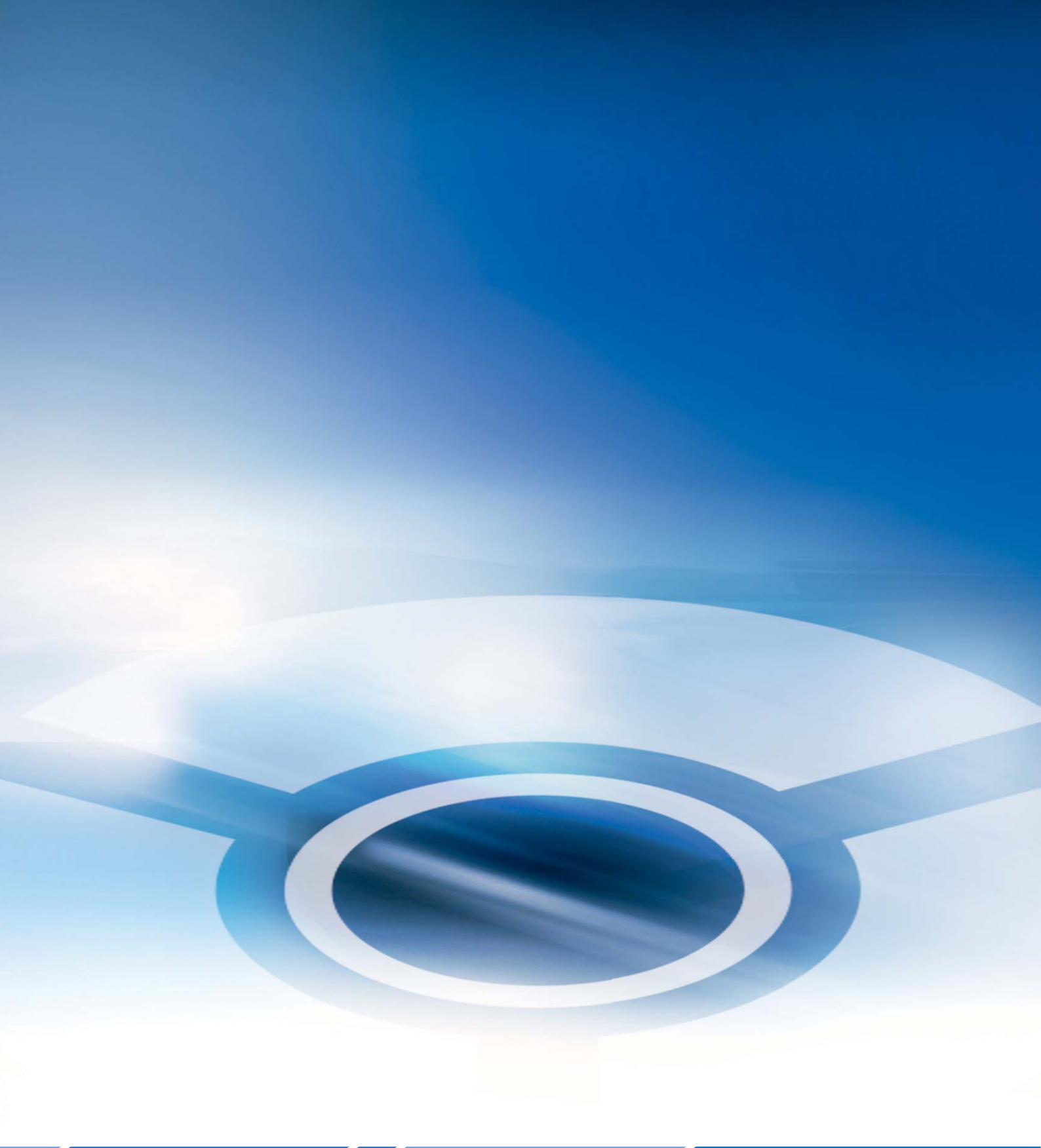
* only usable in basic chuck.

Type 545-80 **Interchangeable clamping inserts**, 1 piece **with heat treatable surface**



Item no.	Chuck Size
141054*	750/1000
141057*	1250

* only usable in basic chuck.



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