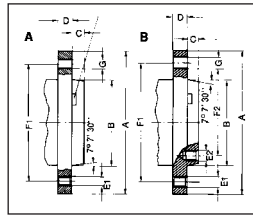


The latest edition of the DIN sheet is binding

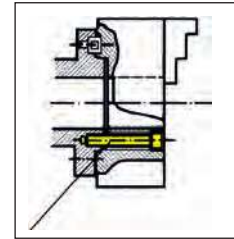
DIN 55026 from taper size 4 with driver.

Spindle head size	A mm	B mm	C1 mm	C2 mm	D mm	Number of holes outer Hole circle (F1) E1 mm	F1 (outer Hole circle) mm	Number of holes inner Hole circle (F2) E2 mm	F2 (inner Hole circle) mm
4	108	63.521	11	-	20	11 x M10	82.6	-	-
5	133	82.573	13	14.288	22	11 x M10	104.8	8 x M10	61.9
6	165	106.385	14	15.875	25	11 x M12	133.4	8 x M12	82.6
8	210	139.731	16	17.462	28	11 x M16	171.4	8 x M16	111.1
11	280	196.883	18	19.050	35	11 x M20	235.0	8 x M20	165.1
15	380	285.791	19	20.638	42	12 x M24	330.2	11 x M24	247.6
20	520	412.795	21	22.225	48	12 x M24	463.6	11 x M24	368.3



Shape A: Threaded holes in the flange (outer hole circle) without inner hole circle.

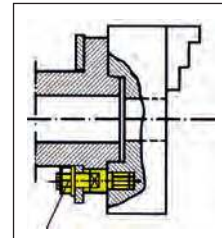
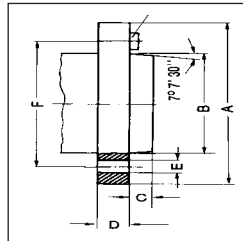
Shape B: Threaded holes in flange (outer hole circle) and inner hole circle.



Mounting with hexagon socket-head bolts on the spindle head

DIN 55027 and 55022 Bayonet disc mounting (ISO 702/III)

Spindle head size	A mm	B mm	C mm	D mm	Number of holes x E mm	F mm
3	102	53.985	11	16	3 x 21	75.0
4	112	63.525	11	20	3 x 21	85.0
5	135	82.575	13	22	4 x 21	104.8
6	170	106.390	14	25	4 x 23	133.4
8	220	139.735	16	28	4 x 29	171.4
11	290	196.885	18	35	6 x 36	235.0
15	400	285.800	19	42	6 x 43	330.2
20	540	412.800	21	48	6 x 43	463.6

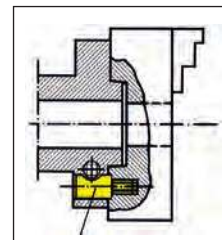
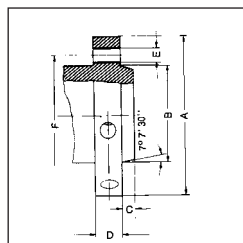


Mounting with stud bolts and collar nuts



DIN 55029 and ASA B 5.9 D 1 Camlock mounting (ISO 702/II)

Spindle head size	A mm	B mm	C mm	D mm	Number of holes x E mm	F mm
3	92.1	53.985	11.1	31.8	3 x 15.1	70.66
4	117.5	63.525	11.1	33.3	3 x 16.7	82.55
5	146.0	82.575	12.7	38.1	6 x 19.8	104.8
6	181.0	106.390	14.3	44.5	6 x 23.0	133.4
8	225.4	139.735	15.9	50.8	6 x 26.2	171.4
11	298.5	196.885	17.5	60.3	6 x 31.0	235.0
15	403.0	285.800	19.0	69.9	6 x 35.7	330.2
20	546.0	412.800	21.0	82.5	6 x 42.1	463.6



Mounting with Camlock stud bolts



26035

Lathe chuck flanges



Design

- Short taper adapter in accordance with **DIN 55027** (DIN 55022 with bayonet disc fastener) stud bolt and collar nut
- Cast body, finished on machine side, faced on chuck side

Applications

Mounting lathe chucks and face plates with centring mount in accordance with DIN 6350.

Note:

Flanges for long taper adapters and made of steel on request.



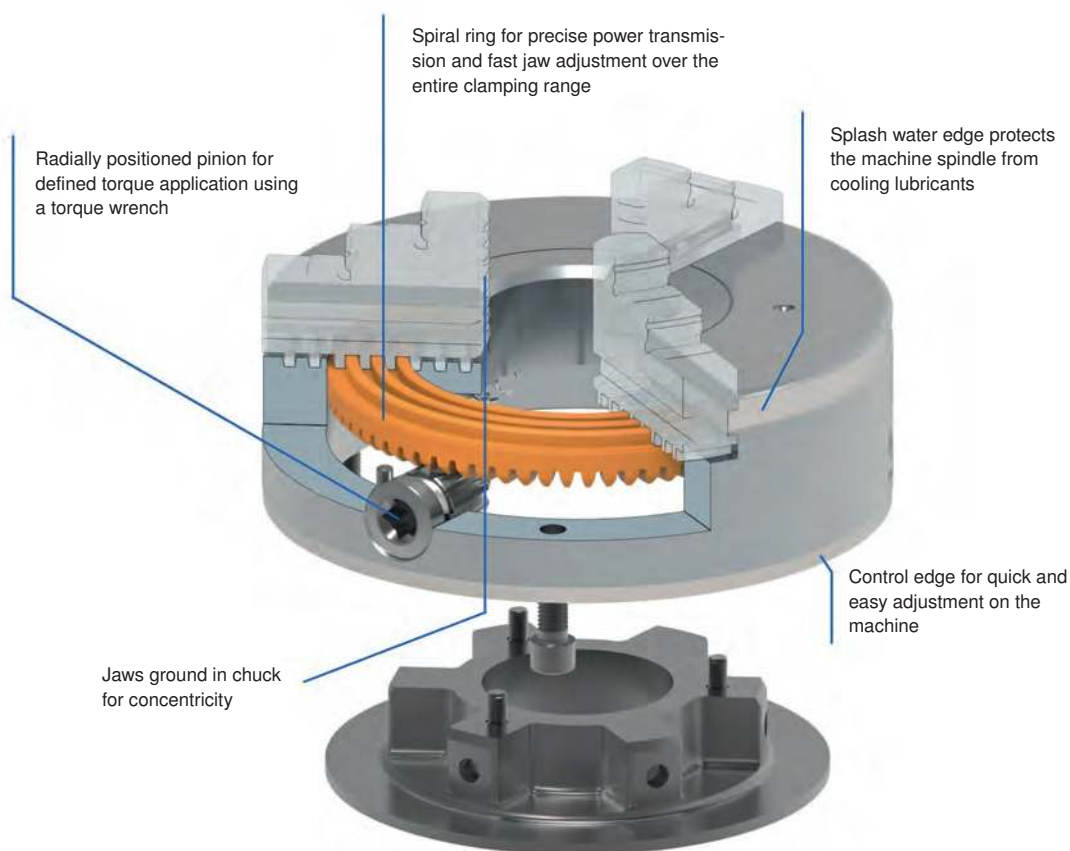
26035

For chuck Ø mm	Short taper size	26035	...
160	3		201
160	4		211
160	5		202
200	5		204
200	6		205

For chuck Ø mm	Short taper size	26035	...
250	6		206
250	8		207
315	6		208
315	8		209
400	11		210

Info

Lathe chucks with spiral rings: Cushman system



Clamping technology



Note:

For spare jaws and auxiliary jaws see art. no. 26270–26278.

26250–26251 + 26257 + 26261

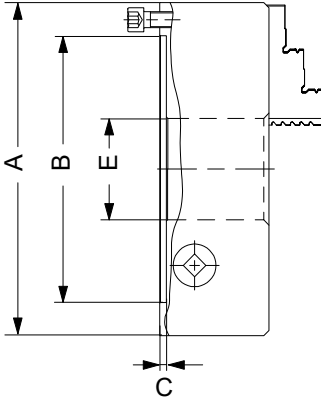
Scope of delivery:

- With one set of internally stepped turning jaws
- With one set of externally stepped drill jaws

26252

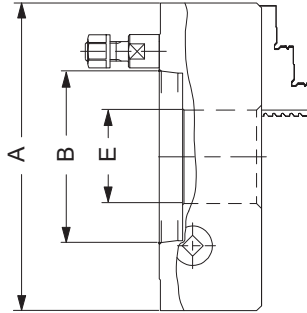
Scope of delivery

- With one set of reversible jaws: Combination for internal and external applications



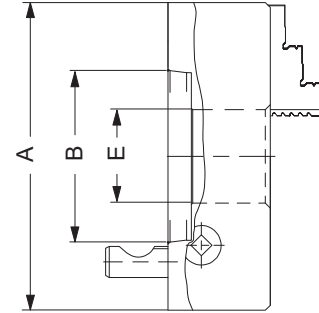
Centring mount in accordance with DIN 6350

(fixing screws from the rear)
For art. no. 26250–26252



Short taper adapter in accordance with DIN 55027

(Stud bolt and collar nut)
For art. no. 26257



Short taper adapter in accordance with DIN 55029

(Stud bolts for Camlock)
For art. no. 26261

DIN 6350						RÖHM Cast body 26250	...	RÖHM Steel body 26251	...	HHW Steel body 26252	...
Size Ø A mm	B mm	C mm	Borehole E mm	max. rpm no. 26250	max. rpm no. 26251/26252						
80	56	3.0	19	5000	7000					102	102
100	70	3.0	20	4500	6300			103		103	103
125	95	4.0	32	4000	5500			104		104	104
160	125	4.0	42	3600	4600			106		106	106
200	160	4.0	55	3000	4000			107		107	107
250	200	5.0	76	2500	3000			108		108	108
315	260	5.0	103	2000	2300			109		109	109
400	330	5.0	136	1600	1800					111	

DIN 55027						RÖHM Steel body 26257	...
Size Ø A mm	B mm	Short taper size	Borehole E mm	Max. rotation speed rpm			
125	63.5	4	32	5500			104
160	82.5	5	42	4600			108
200	82.5	5	55	4000			109
200	106.4	6	55	4000			110
250	106.4	6	76	3000			111
250	139.7	8	76	3000			112
315	139.7	8	103	2300			114

DIN 55029						RÖHM Steel body 26261	...
Size Ø A mm	B mm	Short taper size	Borehole E mm	Max. rotation speed rpm			
160	63.5	4	42	4600			103
160	82.5	5	42	4600			110
200	82.5	5	55	4000			105
200	106.4	6	55	4000			106
250	106.4	6	76	3000			107
315	139.7	8	103	2300			108
315	196.9	11	103	2300			109



Design

Set = 3 pieces.

Interchangeable provided that the jaw guides are not worn.

Note:

Replacement hard jaws must have their bearing surfaces ground in using a grinding attachment on the lathe to achieve the original concentricity.

26270



Drilling jaws
Hard, outwards stepped.

26271



Turning jaws
Hard, inwards stepped.

26272



Block jaws
Unstepped, soft can be hardened.

26277



Plain jaws
Hard. For attaching soft interchangeable jaw grips no. 26278.

26278



Interchangeable jaw grips
Soft, can be hardened. For bolting on to plain jaws.

For size mm	26270	...	26271	...	26272	...	26277	...	26278	...
80		101		101		101				
100		102		102		102		102		102
125		103		103		103		103		103
160		105		105		105		105		105
200		106		106		106		106		106
250		107		107		107		107		107
315		108		108		108		108		108
350/400		109		109		109		109		109

26316 - 26319

Four-jaw lathe chucks

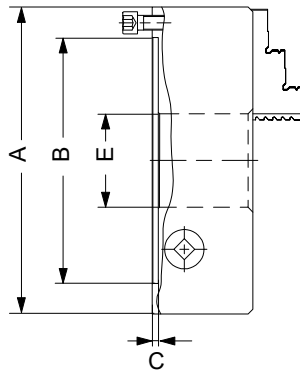


Scope of delivery

- With one set of internally stepped turning jaws
- With one set of externally stepped drill jaws
- Spanner
- Fastening screws

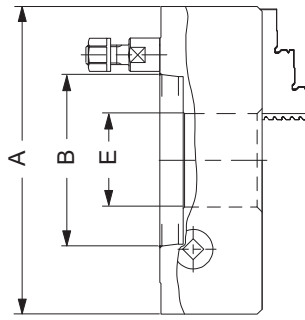
Note:

For spare jaws and auxiliary jaws see art. no. 26330–26334.



Centring mount in accordance with DIN 6350

(fixing screws from rear)
For art. no. 26316–26317



Short taper adapter in accordance with DIN 55027

(Stud bolt and collar nut)
For art. no. 26319

26316 - 26319



DIN 6350						Cast body	Steel body
Size Ø A	B	C	Borehole E	Max. rpm no. 26316	Max. rpm no. 26317	26316	26317
mm	mm	mm	mm		
80	56	3	19	5000	7000		101
100	70	3	20	4500	6300	102	102
125	95	4	32	4000	5500	103	103
160	125	4	42	3600	4600	105	105
200	160	4	55	3000	4000	106	106
250	200	5	76	2500	3000	107	107
315	260	5	103	2000	2300	108	108

DIN 55027						Steel body
Size Ø A	B	Short taper size	Borehole E	Max. rotation speed rpm		26319
mm	mm		mm			...
125	63.5	4	32	5500		303
160	63.5	4	42	4600		308
160	82.5	5	42	4600		307
200	82.5	5	55	4000		309
200	106.4	6	55	4000		310
250	106.4	6	76	3000		311
250	139.7	8	76	3000		312
315	139.7	8	103	2300		314

26330 - 26334

Jaw sets for four-jaw lathe chucks



Design

Set = 4 pieces.

Interchangeable provided that the jaw guides are not worn.

Note:

Replacement hard jaws must have their bearing surfaces ground in using a grinding attachment on the lathe to achieve the original concentricity.



Drilling jaws
Hard, outwards stepped.



Turning jaws
Hard, inwards stepped.



Block jaws
Unstepped, soft can be hardened.



Interchangeable jaw grips
Soft, can be hardened.

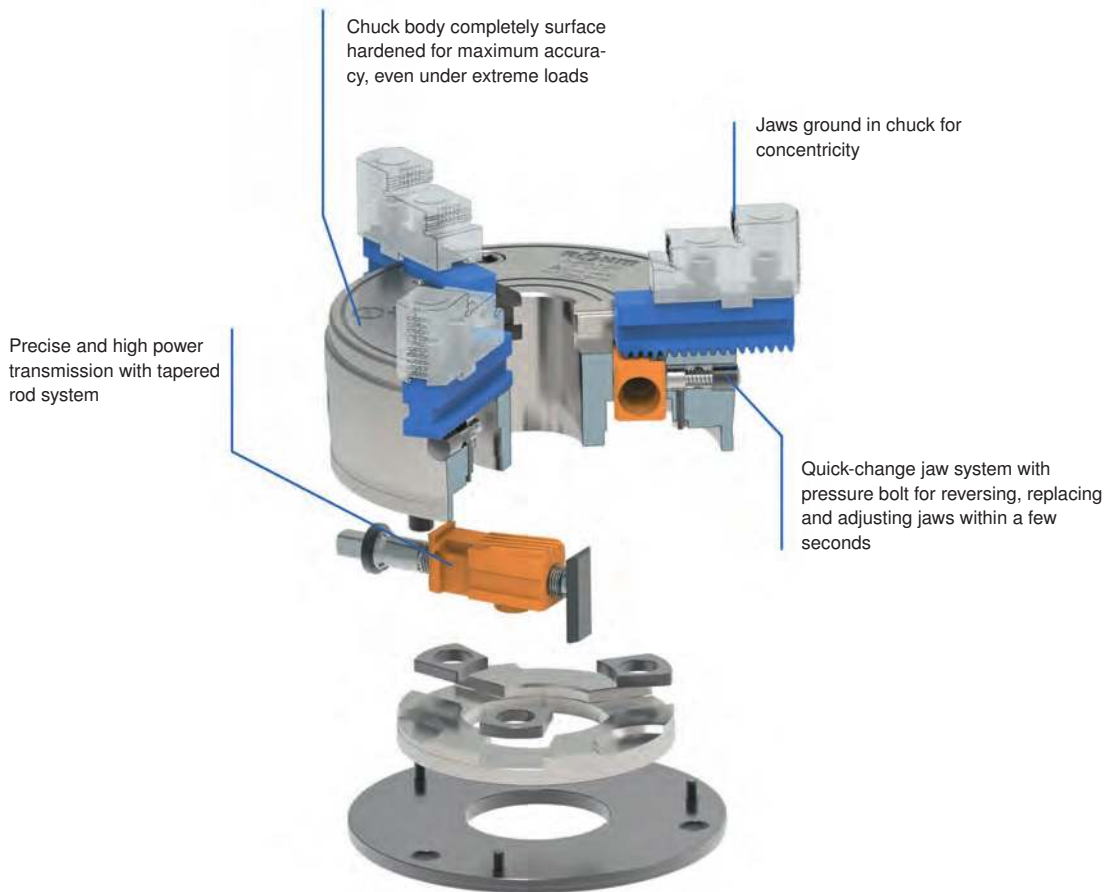


Plain jaws
Hard. For attaching soft interchangeable jaw grips no. 26333.

For size mm	26330	...	26331	...	26332	...	26333	...	26334	...
80		101		101		101				
100		102		102		102	102			102
125		103		103		103	103			103
160		105		105		105	105			105
200		106		106		106	106			106
250		107		107		107	107			107
315		108		108		108	108			108

Info

Tapered rod chucks



26405 - 26408 Three-jaw tapered-rod lathe chuck

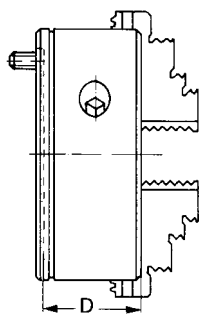


Scope of delivery:

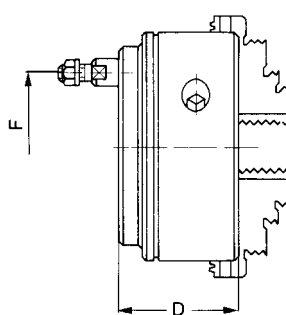
- With plain jaws and hard interchangeable jaw grips reversible as turning and drilling jaws

Note:

For replacement jaws, see art. no. 26440-26443.



Centring mount in accordance with DIN 6350 (fixing screws from the rear) For art. no. 26405



Short taper adapter in accordance with DIN 55027 (Stud bolt and collar nut) For art. no. 26408

26405 - 26408



DIN 6350

Size mm	Clamping range outer mm	Clamping range inner mm	Borehole mm	Jaw stroke without offset mm	Rotation speed max. rpm	D mm	26405	...
125	3-129	26-123	32	4.8	6000	46.5		100
160	5-161	67-174	42	6.2	5400	63.0		101
200	7-207	71-214	52	6.8	4600	81.0		102
250	8-253	99-261	62	8.0	4200	92.0		103
315	12-323	102-319	87	10.2	3300	111.0		104

DIN 55027

Size mm	Short taper size mm	Clamping range outer mm	Clamping range inner mm	Borehole mm	Jaw stroke without offset mm	Rotation speed max. rpm	D mm	Outer hole circle F mm	26408	...
160	5	5-161	67-174	42	6.2	5400	78	104.8		102
200	5	6-207	71-214	52	6.8	4600	96	104.8		103
200	6	6-207	71-214	52	6.8	4600	97	133.4		104
250	6	8-253	99-261	62	8.0	4200	108	133.4		106
250	8	8-253	99-261	62	8.0	4200	110	171.4		107
315	8	12-323	102-319	87	10.2	3300	129	171.4		109



Design**Set = 3 pieces.****Applications**For three-jaw tapered-rod lathe chucks
art.-no. 26405–26408.**Note:***Replacement hard interchangeable jaw grips
and undivided, hard stepped jaws are not ground
for concentricity on the clamping surfaces.**They must be ground in the chuck with
clamping pressure applied while running.*

26440

Stepped jawsHard, undivided, reversible
turning and drilling jaws.

26441

Plain jaws

Hard.



26442

Interchangeable jaw gripsHard, reversible as
turning and drilling jaws.

26443

Interchangeable jaw grips

Soft.

For Size	26440	...	26441	...	26442	...	26443	...
125		100		100				100
160		101		101		101		101
200		102		102		102		102
250		103		103		103		103
315		104		104		104		104
400				105		105		105

26495

Lathe chuck jaws recessing attachment

**Design**

Setting jaws reversible and continuously adjustable.

ApplicationsFor 3-jaw lathe chucks. For recessing unhardened
lathe chuck jaws and grinding hardened lathe chuck
jaws.

26495

Size	Inner Ø mm	Outer Ø mm	Working range Inner Ø mm	Working range Outer Ø mm	For chuck Ø 26495	...
0	153	110	50–115	150–215	125	101
1	176	110	35–125	170–260	200	102
2	215	135	70–140	215–285	250	103
3	244	162	100–175	240–315	250	104
4	290	208	145–215	290–360	315	105



26497 - 26498 Workpiece stops for lathe chucks

Design

- Made from aluminium
- Precision-ground bearing surfaces
- The material stop is attached to the lathe chuck by three magnets incorporated into the stop by simply placing it on the lathe chuck body
- Clamps turning workpieces from 15 to 130 mm diameter
- Suitable for three-jaw lathe chucks with jaw widths up to 56 mm

Applications

For clamping short turning workpieces in three-jaw chucks.

26497

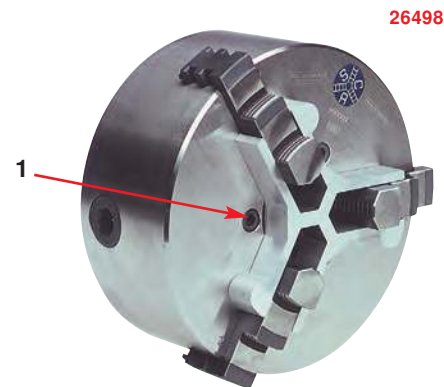
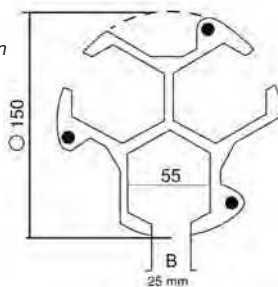
- Five pieces in set, in wooden case
- Stop height 15/20/25/30/35 mm

26498

- Material stop, single piece

Note:

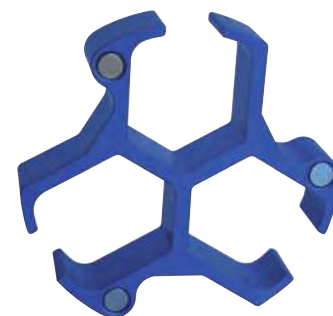
1) Material stop
Example application



26498

Set	
Stop height (thickness) mm	26497 ...
Set 15-35	101

Individual	
Stop height (thickness) mm	26498 ...
15	101
20	102
25	103
30	104
35	105



26910 Safety square stud keys

Design

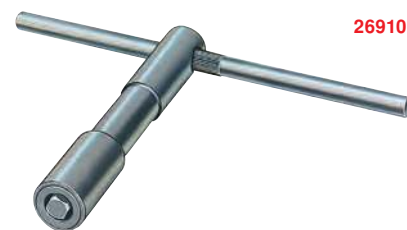
With ejector pin in the face of the square.

Applications

For lathe chucks.

Note:

The key must be firmly pressed into the lathe chuck drive and held there until the clamping procedure is complete. The key is automatically ejected when the pressure is released.



26910

Square mm	26910 ...
8	102
9	103
10	104
11	105
12	106
14	107
17	108

26920 Hollow spindle stops

Design

With spreader key.

Applications

For lathes used for series production and single-part production.

Note:

The hollow spindle stop is clamped at the desired location in the machine spindle using the spreader key.

26920



Size	For spindle bore mm	26920 ...
1	20-27	101
2	25-33	103
3	32-41	104
4	40-50	105
5	48-60	106
6	58-76	107
7	75-96	109



- For straight-toothed jaws
- Jaw quick-change system with individual unlocking action
- Secures the positions of plain jaws



- The special construction with the tangentially arranged tapered rods has a positive effect on the centrifugal characteristics of the chuck
- This means lower clamping force losses and even higher rotation speeds (with large apertures)
- The individual unlocking action makes handling large workpiece-related special attachment jaws particularly easy

Further power chucks for high speeds



KFD-HS

- Power chuck with two, three and four jaws
- Large aperture
- High residual clamping force without centrifugal force compensation elements



DURO-NC

- Power chuck with quick jaw-change system
- Central unlocking of jaws
- Large aperture
- Universal pull bar connection



KFD U

- Power chuck with large aperture
- High concentricity and axial runout precision



KFD-N

- Power-clamp low-pull chuck only for external clamping
- High clamping accuracy



LVE

- Air-operated front end chuck
- High clamping force starting from 6 bar

26929

Three-jaw tapered-rod power chuck DIN 55028



Design

- All-steel with hardened and ground guides and extremely large aperture
- With direct short taper adapter in accordance with DIN 55028
- Plain jaw intake 1/16 inch x 90°

Advantages:

- High clamping force and excellent clamping accuracy

- High maximum speed
- Low installation height

Scope of delivery:

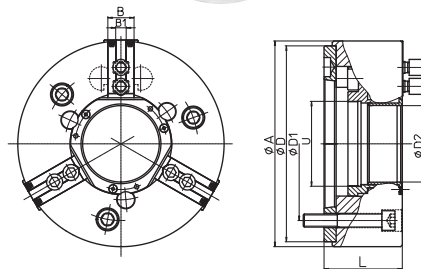
Chuck with hard interchangeable jaw grips including T-slot screws and nuts.

Note:

Piston adapter (blank) with pre-bored hole diameter 20 mm for adaptation to the pull bar, see art. no. 26929 201–203.



26929



No.	26929 101	26929 102	26929 103
L mm:	91.5	100.0	118.5
W mm:	28	32	40
D h6 mm:	140	170	220
D1 mm:	104.8	133.4	171.4
D2 mm:	45	68	91
U mm:	M 55 x 1.5	M 80 x 1.5	M 102 x 1.5
B1 H7 mm:	10	12	14
Jaw stroke mm:	4.4	5.7	5.7
Max. clamping force kN:	60	90	118
Piston stroke mm:	13.5	17.5	17.5
Max. actuation force kN:	25	40	60
Weight kg:	11.5	17.5	30

Chuck Ø mm	Taper adapter	Clamping range mm	Max. rotation speed rpm	Power chucks		Piston adapters	
				26929	...	26929	...
160	A2-5	9-160	6300			101	201
200	A2-6	20-198	6300			102	202
250	A2-8	20-255	4500			103	203

26930 - 26931

Soft interchangeable jaw grips with 1/16 inch x 90° serration

Design

Set = 3 pieces.

Applications

Suitable for power chuck brands: Berg, Forkardt, Gamet, Geiger and Haag, Pratt Burnerd, Röhm, SCHUNK, SMW and Autoblock.

26930

Normal version

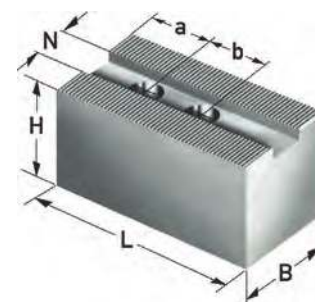
26931

Long version

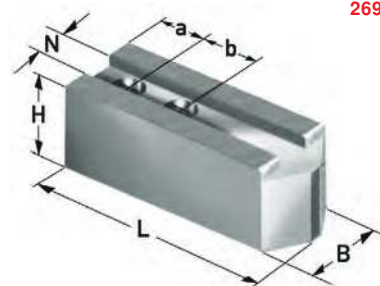
Bevelled for small clamping diameters.

Note:

Please compare tooting, groove width (N) and hole spacing (a, b) to make adjustments to the power chuck.



26930



26931

For chuck Ø mm	Dim. L x W x H mm	a mm	b mm	Groove N mm	Thread DIN 912	Weight Approx. kg	Normal	
							26930	...
160	70 x 40 x 60	15	22	17	M 12	3.1		101
200	90 x 40 x 60	25	22	17	M 12	4.2		102
250/315	120 x 50 x 80	30	28	21	M 16	9.3		103
400/500/630	155 x 60 x 90	30	35	25.5	M 20	16.3		104

For chuck Ø mm	Dim. L x W x H mm	a mm	b mm	Groove N mm	Thread DIN 912	Weight Approx. kg	Long	
							26931	...
160	78 x 35 x 40	15	22	17	M 12	1.7		101
200	98 x 35 x 40	15	22	17	M 12	2.4		102
250	120 x 50 x 50	20	28	21	M 16	5.4		103
315	140 x 50 x 50	30	28	21	M 16	6.2		104

Clamping technology



26934

Sliding blocks for chucks with serration

Design

- With cheese head DIN 912-12.9
- Precision-ground and tempered

Applications

Suitable for all standard power chucks of brands: SCHUNK, Forkardt, Röhm and SMW.



Groove width S	G6	H x h	Max. tightening torque	Thread	Suitable for	26934	...
mm		mm	Nm	DIN 912	Brands/type		
17.0		23 x 9	70	M 12	Forkardt: NH 160-200, NHF 160-200		101
17.0		23 x 9	70	M 12	Schunk: TH 165-210, THF 165-210		
17.0		23 x 9	70	M 12	SMW: HFKS 160-200, HFK 160-200		
17.0		22 x 9	70	M 12	Röhm: KFD 160-200, KFH 160-200		102
21.0		27 x 11	150	M 16	Forkardt: NH 250-315, NHF 250-315		103
21.0		27 x 11	150	M 16	Schunk: TH 250-315, THF 250-315		
21.0		27 x 11	150	M 16	SMW: HFKS 250-315, HFK 250-315		
21.0		25.5 x 11	150	M 16	Röhm: KFD 250-315, KFH 250-315		104
25.5		29 x 11	220	M 20	Forkardt: NH 400-500, NHF 400-500		105
25.5		29 x 11	220	M 20	Schunk: TH 380-500, THF 380-500		
25.5		29 x 11	220	M 20	SMW: HFKS 400, HFK 400-500		
25.5		33.7 x 15.5	220	M 20	Röhm: KFD 400-500, KFH 400-500		106

26936 - 26937

Soft interchangeable jaw grips with 1.5 mm x 60° serration

Design

Set = 3 pieces.

Applications

Suitable for lathe chuck brands: Kitagawa and Matsumoto.

Note:

Please compare tooting, groove width (N) and hole spacing (a, b) to make adjustments to the power chuck.

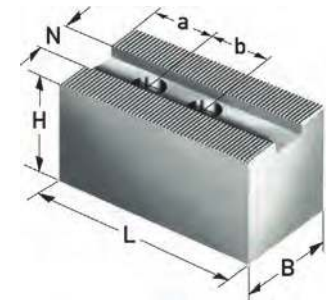
26936

Normal version

26937

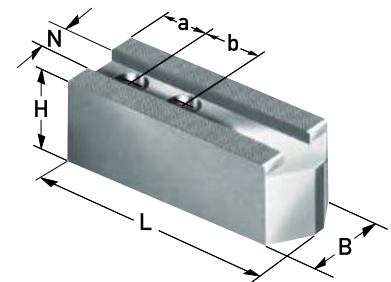
Long version

Bevelled for small clamping diameters.



For chuck Ø	Dim. L x W x H	a	b	Groove N	Thread	Weight	Normal	
							26936	...
mm	mm	mm	mm	mm	DIN 912	Approx. kg		
152	72 x 31 x 32	15	20	12	M 10	1.4		101
200	95 x 35 x 40	24	25	14	M 12	2.6		102
254	110 x 40 x 42	30	30	16	M 12	3.9		103
305	130 x 50 x 50	40	30	18	M 14	6.5		104
305/21	129 x 50 x 60	39	30	21	M 16	7.8		105

For chuck Ø	Dim. L x W x H	a	b	Groove N	Thread	Weight	Long	
							26937	...
mm	mm	mm	mm	mm	DIN 912	Approx. kg		
152	82 x 31 x 32	15	20	12	M 10	1.5		101
200	102 x 35 x 40	20	25	14	M 12	2.5		102
254	125 x 40 x 40	30	30	16	M 12	4.2		103
305	145 x 50 x 50	30	30	18	M 14	7.0		104



26939

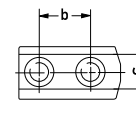
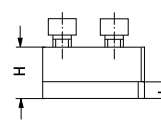
Sliding blocks suitable for Kitagawa chucks

Design

- With cheese head DIN 912-12.9
- Tempered

Applications

For Japanese lathe chucks with 60° serration.



Groove width S	H/h	b	Max. tightening torque	Thread	Suitable for	26939	...
mm	mm	mm	Nm	DIN 912-12.9	Kitagawa chucks		
12	18.5/7.5	20	50	M 10	B06/B106/B206/BB06/BB206/ BBT206/BL206/BLT206/BS306/ BT206/H0H06/H0H106/H0H206/ML06/ MLT06/B07		101
14	20.5/8.5	25	70	M 12	B208/BB08/BB208 /BBT208/BL208/BLT 208/BS308/BT208/ H0H108/H0H208/MLT08		102
16	21.5/8.5	30	70	M 12	B210/BB10/BB210/BB BBT210/BL210/BLT210/ BS310/BT210/ H0H-10K/H0H110		103
18	33.5/13.5	30	130	M 14	B12/B300/HLA6-12/H0H12/H0S12/HLA6-15		104
21	28.0/11.5	30	150	M 16	BBT212/BL212/BLT212/BT212/H0H112/H0H112/H0H-12K		105