

## DURO



DURO-key bar chucks are successfully used wherever extremely high tension forces, high concentric accuracy and reliable continuous repeatability are needed.

For lathes. Suitable for milling machines, dividing attachments and machining centres in connection with a base plate, non rotating.

The jaws can be quickly and easily reversed, exchanged or relocated over the entire gripping range.

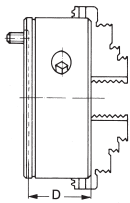
The jaws retain their accuracy if they are always used on the same chuck and when base jaws and top jaws are kept screwed together as a matched set for recurring work.

It is therefore advisable to stock several jaw sets.

**Technical features:**

- with safety feature
- self-centering
- steel body, jaw guides hardened and ground
- high speeds
- larger through-hole
- lathe chucks must be lubricated regularly to maintain their gripping force

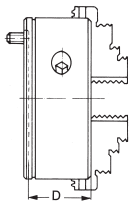
Tool group A08  
Type 000  
**with reversible one-piece jaws  
cylindrical centre mount**



Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total Clamping force kN
236492	125	5	32	46,5	6000	20	8
229035	160	6¼	42	63	5400	40	25
229036	200	8	52	81	4600	60	40
229037	250	10	62	92	4200	70	55
229038	315	12½	87	111	3300	80	67
229039	400	15¾	102	118	2200	90	85
241758	500	20	162	118	1900	100	93

at size 125 jaw guides only ground from diameter 630 mm on request

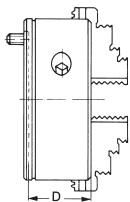
Tool group A08  
Type 003  
**with reversible top jaws  
cylindrical centre mount**



Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total Clamping force kN
094060	160	6¼	42	63	5400	40	25
094061	200	8	52	81	4600	60	40
094062	250	10	62	92	4200	70	55
094063	315	12½	87	111	3300	80	67
094064	400	15¾	102	118	2200	90	85
241782	500	20	162	118	1900	100	93
353873	630	25	252	143	1100	100	93

from diameter 630 mm on request

Tool group A08  
Type 001  
**with base jaws only  
cylindrical centre mount**

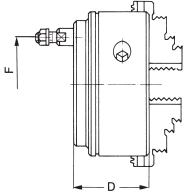


Item no.	Size	Inch	Through-hole	D	Speed max. min-1	Torque Nm	Total Clamping force kN
236480	125	5	32	46,5	6000	20	8
235040	160	6¼	42	63	5400	40	25
235041	200	8	52	81	4600	60	40
235042	250	10	62	92	4200	70	55
235043	315	12½	87	111	3300	80	67
235043	315	12½	87	111	3300	80	67
235044	400	15¾	102	118	2200	90	85
241769	500	20	162	118	1900	100	93
361198	630	25	252	143	1100	100	93

at size 125 jaw guides only ground from diameter 630 mm on request

# DURO

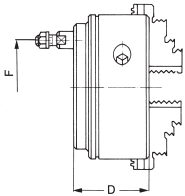
Tool group A08  
Type 015  
**with reversible one-piece jaws**  
**DIN 55027**, with studs and  
locknuts, optional DIN 55021  
with set screw and nut



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
236494	125	3	32	46,5	75	6000	20	8
236496	125	4	32	46,5	85	6000	20	8
236498	125	5	32	46,5	104,8	6000	20	8
229040	160	4	42	63	85	5400	40	25
229041	160	5	42	63	104,8	5400	40	25
229042	160	6	42	63	133,4	5400	40	25
229043	200	4	52	81	85	4600	60	40
229044	200	5	52	81	104,8	4600	60	40
229045	200	6	52	81	133,4	4600	60	40
229046	200	8	52	81	171,4	4600	60	40
229047	250	4	62	92	85	4200	70	55
229048	250	5	62	92	104,8	4200	70	55
229049	250	6	62	92	133,4	4200	70	55
229050	250	8	62	92	171,4	4200	70	55
229052	315	6	87	111	133,4	3300	80	67
229053	315	8	87	111	171,4	3300	80	67
229054	315	11	87	111	235	3300	80	67
229055	400	6	102	118	133,4	2200	90	85
229056	400	8	102	118	171,4	2200	90	85
229057	400	11	102	118	235	2200	90	85
236467	400	15	102	118	330,2	2200	90	85
241761	500	8	162	118	171,4	1900	100	93
241762	500	11	162	118	235	1900	100	93
242773	500	15	162	118	330,2	1900	100	93

at size 125 jaw guides only ground  
from diameter 630 mm on request

Tool group A08  
Type 018  
**with reversible top jaws**  
**DIN 55027**, with studs and  
locknuts, optional DIN 55021  
with set screw and nut

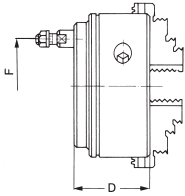


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
094065	160	4	42	63	85	5400	40	25
094066	160	5	42	63	104,8	5400	40	25
094067	160	6	42	63	133,4	5400	40	25
094068	200	4	52	81	85	4600	60	40
094069	200	5	52	81	104,8	4600	60	40
094070	200	6	52	81	133,4	4600	60	40
094071	200	8	52	81	171,4	4600	60	40
094072	250	4	62	92	85	4200	70	55
094073	250	5	62	92	104,8	4200	70	55
094074	250	6	62	92	133,4	4200	70	55
094075	250	8	62	92	171,4	4200	70	55
094077	315	6	87	111	133,4	3300	80	67
094078	315	8	87	111	171,4	3300	80	67
094079	315	11	87	111	235	3300	80	67
094080	400	6	102	118	133,4	2200	90	85
094081	400	8	102	118	171,4	2200	90	85
094082	400	11	102	118	235	2200	90	85
236471	400	15	102	118	330,2	2200	90	85
241785	500	8	162	118	171,4	1900	100	93
241786	500	11	162	118	235	1900	100	93
242781	500	15	162	118	330,2	1900	100	93
361207	630	11	252	143	235	1100	100	93
361208	630	15	252	143	330,2	1100	100	93

from diameter 630 mm on request

# DURO

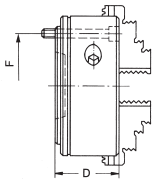
Tool group A08  
Type 016  
**with base jaws only**  
**DIN 55027**, with studs and locknuts, optional DIN 55021 with set screw and nut



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
236482	125	3	32	46,5	75	6000	20	8
236484	125	4	32	46,5	85	6000	20	8
236486	125	5	32	46,5	104,8	6000	20	8
235045	160	4	42	63	85	5400	40	25
235046	160	5	42	63	104,8	5400	40	25
235047	160	6	42	63	133,4	5400	40	25
235048	200	4	52	81	85	4600	60	40
235049	200	5	52	81	104,8	4600	60	40
235050	200	6	52	81	133,4	4600	60	40
235051	200	8	52	81	171,4	4600	60	40
235052	250	4	62	92	85	4200	70	55
235053	250	5	62	92	104,8	4200	70	55
235054	250	6	62	92	133,4	4200	70	55
235055	250	8	62	92	171,4	4200	70	55
235057	315	6	87	111	133,4	3300	80	67
235058	315	8	87	111	171,4	3300	80	67
235059	315	11	87	111	235	3300	80	67
235060	400	6	102	118	133,4	2200	90	85
235061	400	8	102	118	171,4	2200	90	85
235062	400	11	102	118	235	2200	90	85
236475	400	15	102	118	330,2	2200	90	85
241772	500	8	162	118	171,4	1900	100	93
241773	500	11	162	118	235	1900	100	93
242777	500	15	162	118	330,2	1900	100	93
361199	630	11	252	143	235	1100	100	93
361204	630	15	252	143	330,2	1100	100	93

at size 125 jaw guides only ground from diameter 630 mm on request

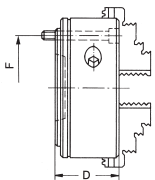
Tool group A08  
Type 011  
**with reversible one-piece jaws**  
**DIN 55026**; DIN 55021, ASA B 5.9, A1/A2 metr.; mounting from front



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
361228 <sup>1)</sup>	160	4	42	63	82,62	5400	40	25
361229	160	5	42	63	104,8	5400	40	25
361230	200	5	52	81	104,8	4600	60	40
361231	200	6	52	81	133,4	4600	60	40
361232	250	6	62	92	133,4	4200	70	55
361233	315	6	87	111	133,4	3300	80	67
361234	315	8	87	111	171,4	3300	80	67
361235	400	8	102	118	171,4	2200	90	85
361236	500	11	162	118	235	1900	100	93

<sup>1)</sup> DIN 55021 Ø 85 from diameter 630 mm on request

Tool group A08  
Type 014  
**with reversible top jaws**  
**DIN 55026**; DIN 55021, ASA B 5.9, A1/A2 metr.; mounting from front

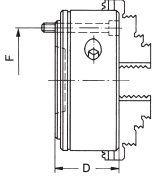


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
361217 <sup>1)</sup>	160	4	42	63	82,62	5400	40	25
353691	160	5	42	63	104,8	5400	40	25
353714	200	5	52	81	104,8	4600	60	40
353822	200	6	52	81	133,4	4600	60	40
361211	250	6	62	92	133,4	4200	70	55
361212	315	6	87	111	133,4	3300	80	67
361213	315	8	87	111	171,4	3300	80	67
361214	400	8	102	118	171,4	2200	90	85
361215	500	11	162	118	235	1900	100	93
361216	630	15	252	143	330,2	1100	100	93

<sup>1)</sup> DIN 55021 Ø 85 from diameter 630 mm on request

# DURO

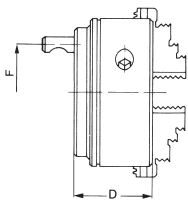
Tool group A08  
Type 012  
**with base jaws only**  
**DIN 55026**; DIN 55021, ASA B 5.9,  
A1/A2 metr.; mounting from front



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
361218 <sup>1)</sup>	160	4	42	63	82,62	5400	40	25
361219	160	5	42	63	104,8	5400	40	25
361220	200	5	52	81	104,8	4600	60	40
361221	200	6	52	81	133,4	4600	60	40
361222	250	6	62	92	133,4	4200	70	55
361223	315	6	87	111	133,4	3300	80	67
361224	315	8	87	111	171,4	3300	80	67
361225	400	8	102	118	171,4	2200	90	85
361226	500	11	162	118	235	1900	100	93
361227	630	15	252	143	330,2	1100	100	93

<sup>1)</sup> DIN 55021 Ø 85  
from diameter 630 mm on request

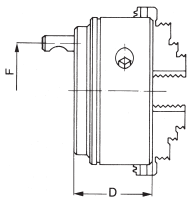
Tool group A08  
Type 030  
**with reversible one-piece jaws**  
**DIN 55029**; ASA B 5.9, Type D,  
with studs for Camlock



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
212104	125	3	32	46,5	70,66	6000	20	8
212106	125	4	32	46,5	82,6	6000	20	8
229058	160	4	42	63	82,6	5400	40	25
229059	160	5	42	63	104,8	5400	40	25
229060	160	6	42	63	133,4	5400	40	25
229061	200	4	52	81	82,6	4600	60	40
229062	200	5	52	81	104,8	4600	60	40
229063	200	6	52	81	133,4	4600	60	40
229064	200	8	52	81	171,4	4600	60	40
229065	250	4	62	92	82,6	4200	70	55
229066	250	5	62	92	104,8	4200	70	55
229067	250	6	62	92	133,4	4200	70	55
229068	250	8	62	92	171,4	4200	70	55
229069	315	6	87	111	133,4	3300	80	67
229070	315	8	87	111	171,4	3300	80	67
229071	315	11	87	111	235	3300	80	67
229072	400	6	102	118	133,4	2200	90	85
229073	400	8	102	118	171,4	2200	90	85
229074	400	11	102	118	235	2200	90	85
236469	400	15	102	118	330,2	2200	90	85
241765	500	8	162	118	171,4	1900	100	93
241766	500	11	162	118	235	1900	100	93
242775	500	15	162	118	330,2	1900	100	93

at size 125 jaw guides only ground  
from diameter 630 mm on request

Tool group A08  
Type 033 **with reversible top jaws**  
**DIN 55029**; ASA B 5.9, Type D,  
with studs for Camlock

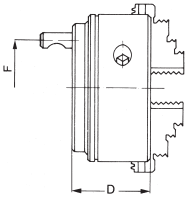


Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
094083	160	4	42	63	82,6	5400	40	25
094084	160	5	42	63	104,8	5400	40	25
094085	160	6	42	63	133,4	5400	40	25
094086	200	4	52	81	82,6	4600	60	40
094087	200	5	52	81	104,8	4600	60	40
094088	200	6	52	81	133,4	4600	60	40
094089	200	8	52	81	171,4	4600	60	40
094090	250	4	62	92	82,6	4200	70	55
094091	250	5	62	92	104,8	4200	70	55
094092	250	6	62	92	133,4	4200	70	55
094093	250	8	62	92	171,4	4200	70	55
094094	315	6	87	111	133,4	3300	80	67
094095	315	8	87	111	171,4	3300	80	67
094096	315	11	87	111	235	3300	80	67
094097	400	6	102	118	133,4	2200	90	85
094098	400	8	102	118	171,4	2200	90	85
094099	400	11	102	118	235	2200	90	85
236473	400	15	102	118	330,2	2200	90	85
241789	500	8	162	118	171,4	1900	100	93
241790	500	11	162	118	235	1900	100	93
242783	500	15	162	118	330,2	1900	100	93
361209	630	11	252	143	235	1100	100	93
361210	630	15	252	143	330,2	1100	100	93

from diameter 630 mm on request

## DURO

Tool group A08  
Type 031  
**with base jaws only**  
**DIN 55029; ASA B 5.9, Type D,**  
with studs for Camlock



Item no.	Size	Mount short taper	Through-hole	D	F	Speed max. min-1	Torque Nm	Total Clamping force kN
236488	125	3	32	46,5	70,66	6000	20	8
236490	125	4	32	46,5	82,6	6000	20	8
235063	160	4	42	63	82,6	5400	40	25
235064	160	5	42	63	104,8	5400	40	25
235065	160	6	42	63	133,4	5400	40	25
235066	200	4	52	81	82,6	4600	60	40
235067	200	5	52	81	104,8	4600	60	40
235068	200	6	52	81	133,4	4600	60	40
235069	200	8	52	81	171,4	4600	60	40
235070	250	4	62	92	82,6	4200	70	55
235071	250	5	62	92	104,8	4200	70	55
235072	250	6	62	92	133,4	4200	70	55
235073	250	8	62	92	171,4	4200	70	55
235074	315	6	87	111	133,4	3300	80	67
235075	315	8	87	111	171,4	3300	80	67
235076	315	11	87	111	235	3300	80	67
235077	400	6	102	118	133,4	2200	90	85
235078	400	8	102	118	171,4	2200	90	85
235079	400	11	102	118	235	2200	90	85
236477	400	15	102	118	330,2	2200	90	85
241776	500	8	162	118	171,4	1900	100	93
241777	500	11	162	118	235	1900	100	93
242779	500	15	162	118	330,2	1900	100	93
361205	630	11	252	143	235	1100	100	93
361206	630	15	252	143	330,2	1100	100	93

at size 125 jaw guides only ground  
from diameter 630 mm on request