

JAWS INDIVIDUALLY ADJUSTABLE

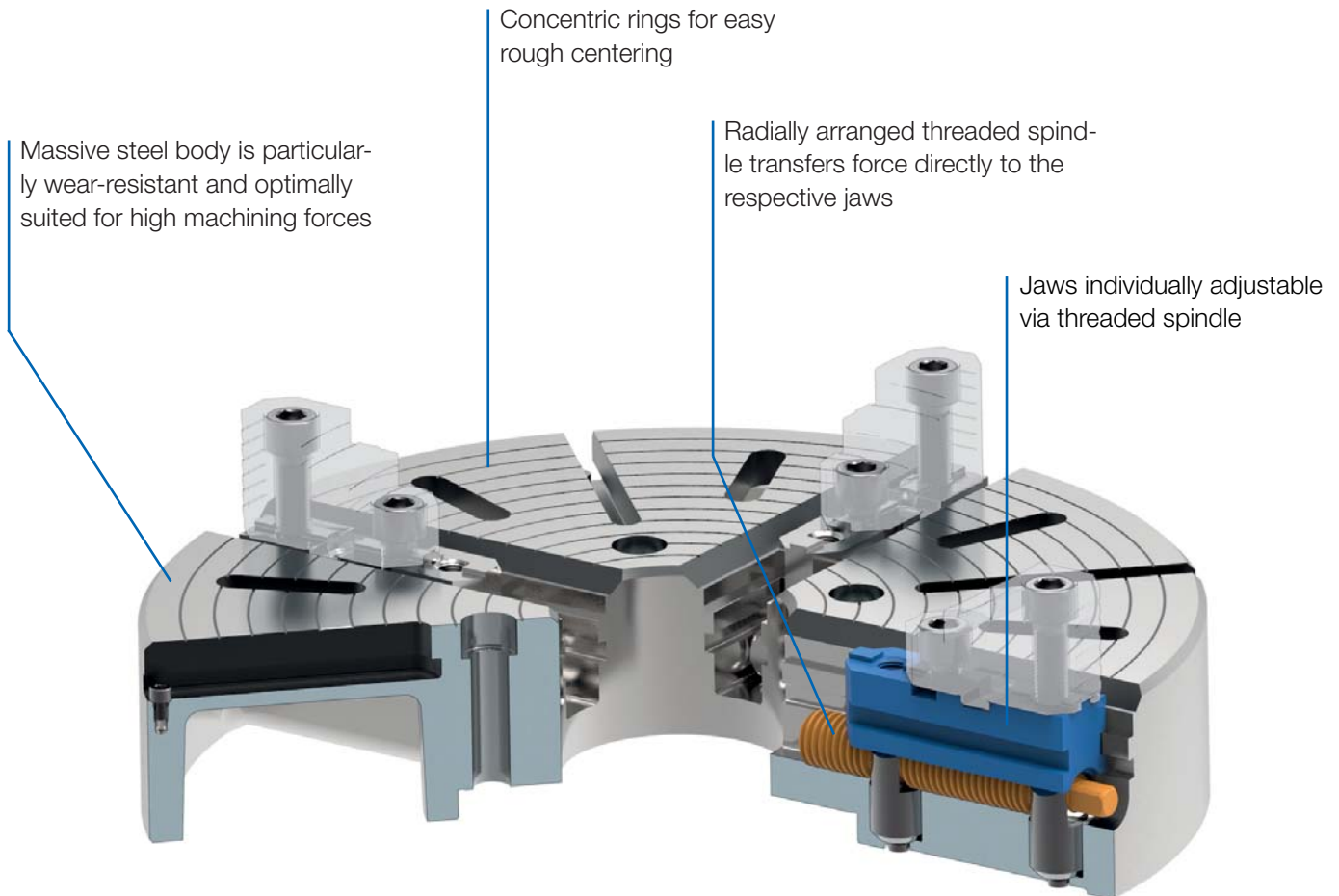
The four jaws can be independently adjusted via the threaded spindle, thereby allowing the safe and secure clamping of irregular, regular, as well as round workpieces.

INDEPENDENT CHUCKS

Independent chucks from RÖHM are particularly successful and effective when force has top priority. Due to the increased rigidity and optimal wear behavior, they are especially suitable for the initial machining of irregular, regular and round workpieces and make high machining forces and a longer machine service life possible.

ADVANTAGES AT A GLANCE

- ⊕ Safe and easy clamping of irregular, regular, as well as round workpieces by four independently adjustable jaws
- ⊕ Easy rough centering by means of concentric rings on the chuck body
- ⊕ Direct force transfer through radially arranged threaded spindles



USE - USU



APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped.

TYPE

Independent four-jaw chuck in steel design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 315 with T-slots. Starting from size 1100 with T-slots and set-up slots.

CUSTOMER BENEFITS

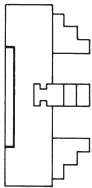
- ☺ Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

- Steel design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

Steel independent chucks USE-USU

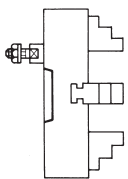
A26
Cylindrical centre mount (without mounting bolts)



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

Further sizes and mountings available on request

A26
ISO 702-3 (DIN 55027), DIN 55022



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	139782 ▲	137163 ▲	61	2350	120	17
260	5	139783 ▲	137164 ▲	70	2350	120	17
260	6	139784 ▲	137165 ▲	70	2350	120	17
310	5	139797 ▲	139724 ▲	75	1970	120	17
310	6	139798 ▲	139725 ▲	75	1970	120	17
310	8	139799 ▲	139726 ▲	75	1970	120	17
400	6	139828 ▲	135371 ▲	95	1530	170	23
400	8	139829 ▲	135372 ▲	95	1530	170	23
400	11	139830 ▲	135358 ▲	95	1530	170	23
450	6	139843 ▲	136947 ▲	95	1360	170	23
450	8	139844 ▲	136948 ▲	95	1360	170	23
450	11	139845 ▲	136957 ▲	95	1360	170	23
500	6	139858 ▲	135632 ▲	95	1220	170	23
500	8	139859 ▲	135633 ▲	95	1220	170	23
500	11	139860 ▲	135696 ▲	95	1220	170	23
630	8	139888 ▲	139767 ▲	136	970	240	37
630	11	139889 ▲	139768 ▲	136	970	240	37
630	15	139890 ▲	139769 ▲	136	970	240	37
710	8	141088 ▲	141098 ▲	136	860	240	37
710	11	141089 ▲	141099 ▲	136	860	240	37
800	8	141092 ▲	600638 ▲	200	765	300	45
800	11	141093 ▲	141107 ▲	192	765	300	45
800	15	141094 ▲	141108 ▲	192	765	300	45
900	11	-	600639 ▲	190	680	300	45
900	15	-	600641 ▲	190	680	300	45

Further sizes and mountings available on request

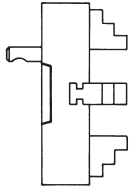
USE - USU

Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
1000	11	-	141115 ▲	190	610	320	47
1000	15	-	141116 ▲	190	610	320	47
1000	20	-	600645 ▲	190	610	320	47
1100	11	-	150500 ▲	190	555	320	47
1100	15	-	600642 ▲	190	555	320	47
1100	20	-	600646 ▲	190	555	320	47
1200	11	-	150501 ▲	190	510	450	64
1200	15	-	600643 ▲	190	510	450	64
1200	20	-	600647 ▲	190	510	450	64

Further sizes and mountings available on request

A26

ISO 702-2 (DIN 55029), ASA B 5.9, type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Clamping force/jaw kN
260	4	139791 ▲	137166 ▲	60	2350	120	17
260	5	139792 ▲	137254 ▲	70	2350	120	17
260	6	139793 ▲	137255 ▲	70	2350	120	17
310	5	139806 ▲	139733 ▲	75	1970	120	17
310	6	139807 ▲	139734 ▲	75	1970	120	17
310	8	139808 ▲	139735 ▲	75	1970	120	17
400	6	139837 ▲	135375 ▲	95	1530	170	23
400	8	139838 ▲	135376 ▲	95	1530	170	23
400	11	139839 ▲	135359 ▲	95	1530	170	23
450	6	139852 ▲	136951 ▲	95	1360	170	23
450	8	139853 ▲	136952 ▲	95	1360	170	23
450	11	139854 ▲	136955 ▲	95	1360	170	23
500	6	139867 ▲	135703 ▲	95	1220	170	23
500	8	139868 ▲	135704 ▲	95	1220	170	23
500	11	139869 ▲	135705 ▲	95	1220	170	23
630	8	139897 ▲	139776 ▲	136	970	240	37
630	11	139898 ▲	139777 ▲	136	970	240	37
630	15	139899 ▲	139778 ▲	136	970	240	37
710	8	140804 ▲	141102 ▲	136	860	240	37
710	11	140805 ▲	141103 ▲	136	860	240	37
710	15	-	141418 ▲	136	860	240	37
800	11	140810 ▲	141111 ▲	192	765	300	45
800	15	140811 ▲	141112 ▲	192	765	300	45
900	11	-	600660 ▲	190	680	300	45
900	15	-	600661 ▲	190	680	300	45
1000	11	-	141119 ▲	190	610	320	47
1000	15	-	141120 ▲	190	610	320	47
1000	20	-	600665 ▲	190	610	320	47
1100	11	-	150504 ▲	190	555	320	47
1100	15	-	600662 ▲	190	555	320	47
1100	20	-	600666 ▲	190	555	320	47
1200	11	-	150505 ▲	190	510	450	64
1200	15	-	600663 ▲	190	510	450	64
1200	20	-	600667 ▲	190	510	450	64

Further sizes and mountings available on request

Jaws USE - USU

A09

Reversible jaw EB, hardened


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

A09

Base jaw GB with fixing screw


Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
304656 ▲	260	set	91	40,1	35
304657 ▲	310	set	107	40,1	35
304658 ▲	400/450	set	126	47,1	40
304659 ▲	500	set	164,4	47,1	40
304660 ▲	630	set	165	51,1	45
304661 ▲	710	set	202	51,1	45
304662 ▲	800/900/1000/1100	set	240	61,1	60
150543 ▲	1200	set	350	92,2	70

A09

Reversible top jaws UB DIN 6350, hardened


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

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

A09

Unstepped top jaw AB DIN 6350, soft, material 16MnCr5


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

Accessories USE - USU

A26

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

A26

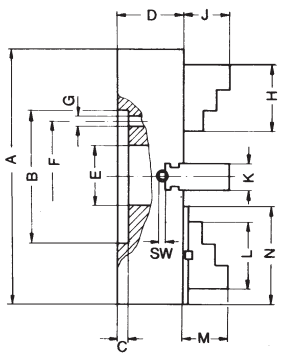
Safety key



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 USE - USU

Cylindrical centre mount



Size A	260	310	400	450	500	630	710	800
B ^{H8}	130	130	210	210	210	260	260	370
C	8	8	18	18	18	18	18	18
D	USE - USU	85	95	112,5	112,5	122,5	132,5	145
E	USE - USU	70	75	95	95	135	135	180
F		105	105	175	175	220	220	330
G		4x13,5	4x13,5	4x17	4x17	4x17	4x20,5	8x22
H		85	94	112	112	136	172	172
J		34	35	41,5	42	50	55,5	80
K		35	35	40	40	40	45	60
L		80	87	105	114	126	140	165
M		56,5	60,5	54	54	69	69	91
N		100	105	125	135	145	165	240
SW		10	10	13	13	13	16	18
approx. kg		23	32	52	76	91	150	270

1) Outer hexagon

Chuck dimensions USE - USU

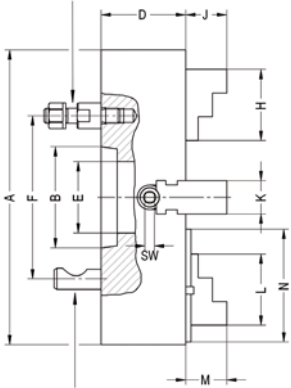
Short taper mount

DIN 55021 with setscrews and locknuts



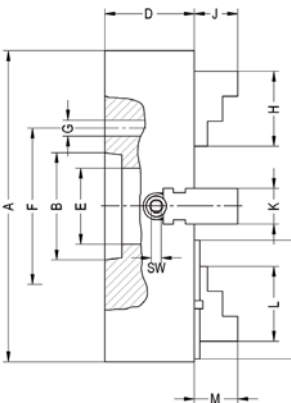
Size A	260			310			400			450			500			630			
Taper size	4 ¹⁾	5 ²⁾	6	5	6	8	6	8	11	6	8	11	6	8	11	8	11	15	
B	63,5	82,5	106,4	82,5	106,4	139,7	106,4	139,7	196,9	106,4	139,7	196,9	106,4	139,7	196,9	139,7	196,9	285,8	
D	75			82			112,5			112,5			122,5						
E	61	70	70	75			95			95			135						
F	DIN	85	104,8	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
	Camlock	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			45					
	USU	36			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



Size A	710			800			
Taper size	8	11	15	8	11	15	
B	139,7	196,9	285,8	139,7	196,9	285,8	
D	132,5			145			
E	135			180			
F	171,4	235	330,2	171,4	235	330,2	
G	18	22	26	18	22	16	
H	172			185			
J	55,5			80			
K	USE	45			60		
	USU	68			68		
L	210			210			
M	69			91			
N	202			240			
SW	16			18			
approx. kg	190			270			

DIN 55029 with studs for camlock

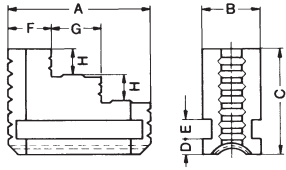


DIN 55026 mounting from front

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

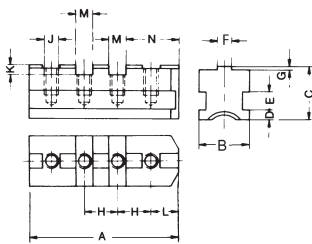
Jaw dimensions USE - USU

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

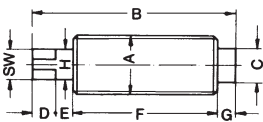
Base jaw GB



Size	260	310	400	450	630	710	800
A	91	107		126	165	202	240
B	35	35		40	45	45	60
C	40,1	40,1		47,1	51,1	51,1	61,1
D	10	10		10	12	12	14
E	12	12		14	14	14	18
F	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
H	54	63,5		76,2	88,1	88,1	88,1
J	M12	M12		M16	M20	M20	M20
K	7,6	7,6		10,8	10,8	10,8	10,8
L	21,2	24,4		27,5	27,5	27,5	27,5
M	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
Grooves	1	1		1	2	3	4
Tapped holes	2	2		2	4	5	6
approx. kg	0,8	0,9		1,1	1,4	2,2	2,8

Reversible top jaw UB and unstepped top jaw

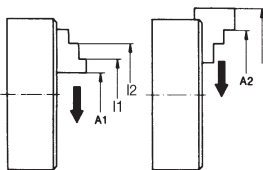
Adjusting spindle



Size	260	310	400	450	500	630	710	800
A	26	26	30		30	34	34	40
B	83,5	99	129		167	200	200	240
C	14	14	16		16	28	28	33
D	13	15	16		16	20,5	20,5	24
E	13,5	15	18,5		18,5	21,5	21,5	24
F	45	55	78		116	143	143	172
G	12	14	16,5		16,5	13,5	13,5	20
H	14	14	16		16	20	20	22
SW	10	10	13		13	16	16	18

1) with outer hexagon

Chucking capacities of jaw steps (standard values)



Size mm	260	310	400	450	500	630	710	800
A1 min.	20	20	35	40	40	60	130	190
A2 max.	260	295	400	450	500	585	690	800
I1 min.	75	80	90	100	145	145	145	170
I2 max.	260	310	400	450	520	650	730	820
max. swing. dia.	305	355	465	510	570	675	785	870

UGE - UGU



APPLICATION

Clamping chucks for lathes on which large, heavy or irregularly shaped workpieces are clamped.

TYPE

Independent four-jaw chuck in cast iron design. Jaws individually adjustable via threaded spindle (no central drive). Starting from size 400 with T-slots and set-up slots.

CUSTOMER BENEFITS

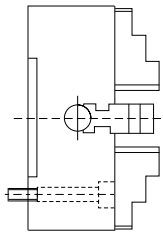
- ☺ Concentric rings for visual rough centering, fine centering using dial gauge

TECHNICAL FEATURES

- Cast iron design incl. clamping wrench and fastening screws, as well as 1 set of reversible or base and top jaws

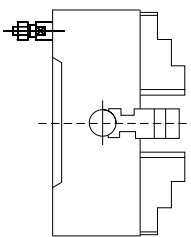
Cast iron independent chucks UGE-UGU

A26
Cylindrical centre mount



Size	With one-piece reversible jaws	With base jaws and top jaws	Through-hole mm	Speed max. min ⁻¹
160	1189704 ▲	-	45	2000
200	1189705 ▲	1189780 ▲	56	1800
250	1189706 ▲	1189781 ▲	65	1500
315	1189707 ▲	1189782 ▲	80	1200
400	1189708 ▲	1189783 ▲	100	800
500	1189709 ▲	1189784 ▲	125	500

A26
ISO 702-3 (DIN 55027), DIN 55022, with studs and locknuts, optional DIN 55021 with set screw and nut

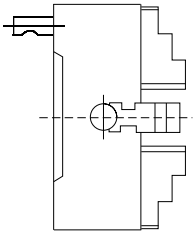


Size	Mount short taper	With one-piece reversible jaws	With reversible top jaws	Through-hole mm	Speed max. min ⁻¹
200	5	1189714 ▲	1189789 ▲	56	1800
200	6	1189715 ▲	1189790 ▲	56	1800
250	5	1189716 ▲	1189791 ▲	65	1500
250	6	1189717 ▲	1189792 ▲	65	1500
250	8	1189718 ▲	1189793 ▲	65	1500
315	5	1189719 ▲	1189794 ▲	80	1200
315	6	1189720 ▲	1189795 ▲	80	1200
315	8	1189721 ▲	1189796 ▲	80	1200
400	6	1189722 ▲	1189797 ▲	100	800
400	8	1189723 ▲	1189798 ▲	100	800
400	11	1189724 ▲	1189799 ▲	100	800
500	6	1189725 ▲	1189800 ▲	100	500
500	8	1189726 ▲	1189801 ▲	125	500
500	11	1189727 ▲	1189802 ▲	125	500

UGE - UGU

A26

ISO 702-2 (DIN 55029), ASA B 5.9, Type D, with studs for Camlock



Size	Mount short taper	with one-piece reversible jaws	with reversible top jaws	Through-hole mm	Speed max. min ⁻¹
200	4	1189733 ▲	1189812 ▲	56	1800
200	5	1189734 ▲	1189813 ▲	56	1800
200	6	1189735 ▲	1189943 ▲	56	1800
250	4	1189736 ▲	1189814 ▲	60	1500
250	5	1189737 ▲	1189815 ▲	65	1500
250	6	1189738 ▲	1189816 ▲	65	1500
250	8	1189739 ▲	1189817 ▲	65	1500
315	5	1189740 ▲	1189818 ▲	80	1200
315	6	1189741 ▲	1189819 ▲	80	1200
315	8	1189742 ▲	1189820 ▲	80	1200
400	6	1189743 ▲	1189821 ▲	100	800
400	8	1189744 ▲	1189822 ▲	100	800
400	11	1189745 ▲	1189823 ▲	100	800
500	8	1189746 ▲	1189824 ▲	125	500
500	11	1189747 ▲	1189825 ▲	125	500

Jaws UGE - UGU

A09

Reversible jaw EB, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189865 ▲	160	set	61,5	51	20
1189866 ▲	200	set	85	61,5	27
1189867 ▲	250	set	92	61,5	27
1189868 ▲	315	set	111	76,5	40
1189871 ▲	400	set	129	76,5	40
1189872 ▲	500	set	152,5	93,5	52

A09

Base jaw GB with mounting bolts



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189895 ▲	200	set	79	32	27
1189896 ▲	250	set	94	38	27
1189897 ▲	315	set	110	39	40
1189898 ▲	400	set	129	44	40
1189899 ▲	500	set	168	59	52

A09

Unstepped top jaw AB, soft



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189877 ▲	200	set	90	43,5	40
1189878 ▲	250	set	106	51,5	47
1189879 ▲	315	set	120	55	52
1189880 ▲	400	set	140	64,5	52
1189881 ▲	500	set	145	82	60

A09

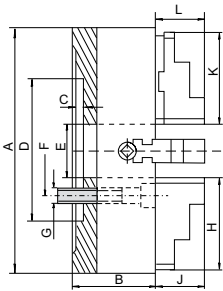
Reversible top jaws UB, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
1189886 ▲	200	set	82	43,5	34
1189887 ▲	250	set	96,5	51,5	34
1189888 ▲	315	set	112,5	55	42
1189889 ▲	400	set	129	64,5	42
1189890 ▲	500	set	136	74,5	54

Chuck dimensions UGE - UGU

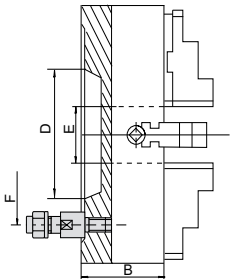
Cylindrical centre mount



Size	160	200	250	315	400	500
A	160	200	250	315	400	500
B	65	75	85	95	105	120
C	5	6	7	7	10	12
DH7	65	75	150	175	200	270
E	45	56	65	80	100	125
F	95	95	104,8	133,4	171,4	235
G	4xM10	4xM10	4xM12	4xM16	4xM16	4xM20
H	61,5	85	96,5	111	129	152,5
J	31,5	35	40,3	49,8	49,8	59,8
L	-	46,4	60,4	60,9	72,3	90,3
K	-	82	96,5	112,5	129	136
approx. kg	7,5	10	25	39	61	105

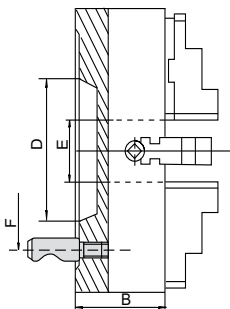
Short taper mount

DIN 55027 with studs and locknuts



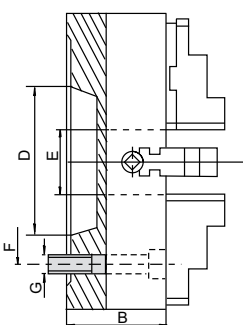
Size	200			250				315		
Taper size	4	5	6	4	5	6	8	5	6	8
B	75	75	75	85	85	85	85	95	95	95
D	63,5	82,5	106,3	63,5	82,5	106,3	139,7	82,5	106,3	139,7
E	56	56	56	60	65	65	65	80	80	80
F	85 ¹⁾	82,6	104,8	133,4	82,6	104,8	133,4	171,4	104,8	133,4
Mounting holes	DIN	3	4	4	-	4	4	4	4	4
	Camlock	3	6	6	3	6	6	6	6	6
approx. kg	10	10	10	27,5	27,5	27,5	27,5	39,5	39,5	39,5

DIN 55029 with studs for camlock



Size	400			500		
Taper size	6	8	11	6	8	11
B	105	105	105	120	120	120
D	106,3	139,7	196,8	106,3	139,7	196,8
E	100	100	100	100	125	125
F	133,4	171,4	235	133,4	171,4	235
Mounting holes	DIN	4	4	6	4	6
	Camlock	6	6	6	6	6
approx. kg	60	60	60	95,5	95,5	95,5

DIN 55026 mounting from front

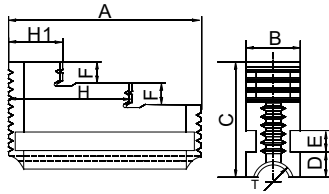


Size	200		250			315			400		
Taper size	5	6	5	6	8	5	6	8	6	8	11
B	75	75	85	85	85	95	95	95	105	105	105
D	82,5	106,3	82,5	106,3	139,7	82,5	106,3	139,7	106,3	139,7	196,8
E	50	50	65	65	65	80	80	80	100	100	100
F	104,8	133,4	104,8	133,4	171,4	104,8	133,4	171,4	133,4	171,4	235
G	4xM10	4xM12	8xM10	4xM12	4xM16	4xM10	8xM12	4xM16	8xM12	4xM16	4xM20
approx. kg	17	17	25,5	25,5	25,5	40	40	40	65	65	65

Size	500		
Taper size	6	8	11
B	120	120	120
D	106,3	139,7	196,8
E	100	125	125
F	133,4	171,4	235
G	4xM12	8xM16	8xM20
approx. kg	114	114	114

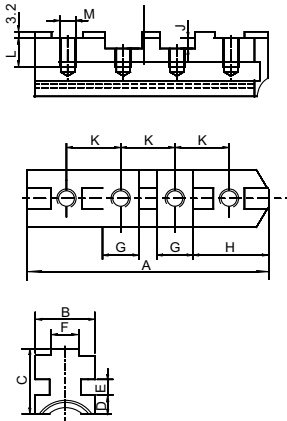
Jaw dimensions UGE - UGU

Reversible one-piece jaw EB



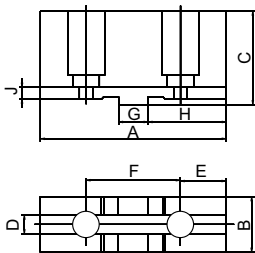
Size	160	200	250	315	400	500
A	61,5	85	92	111	129	152,5
B	20	27	27	40	40	52
C	51	61,5	61,	76,5	76,5	93,5
D	9	11,5	11,5	9,7	9,7	11,7
E	10	10	10	12	12	15
F	10	12	12	18	18	22
H1	20	30,5	30,5	27	32,5	35
H	41	58	65,5	67	78,5	93
Thread T	22x4	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Base jaw GB



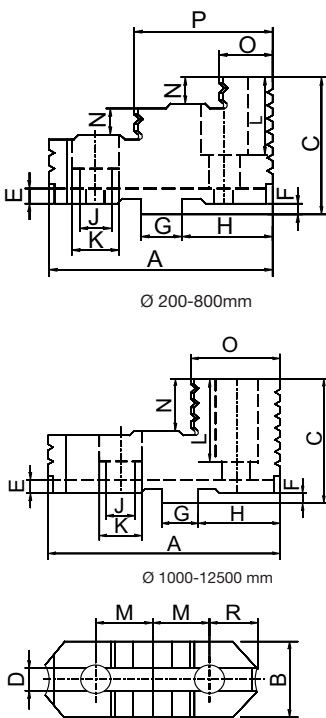
Size	200	250	315	400	500
A	79	94	110	129	168
B	27	27	40	40	52
C	32	38	39	44	59
D	11,5	11,5	9,7	9,7	11,7
E	10	10	12	12	15
F _{-0,03}	7,94	12,7	12,7	12,7	12,7
G _{+0,01}	12,69	19,04	19,04	19,04	19,04
H	33,2	37,5	45,4	54,9	55,5
J	4	4	4	7,2	7,2
K	22,25	27	31,75	38,1	38,1
L	14	20	17,5	22	33,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
Thread T	24x4	24x4	Tr32x6	Tr32x6	Tr36x6

Unstepped soft top jaw AB



Size	200	250	315	400	500
A	90	106	120	140	145
B	40	47	52	52	60
C	43,5	51,5	55	64,5	82
D	7,95	12,71	12,71	12,71	12,71
E	24	27,5	30,7	34,4	34,4
F	44,5	54	63,5	76,2	76,2
G	12,69	19,04	19,04	19,04	19,04
H	40	45	53	63	63
J	4	4	4	4	4

Reversible top jaw UB



Size	200	250	315	400	500
A	82	96,5	112,5	129	136
B	34	34	42	42	54
C	43,5	51,5	55	64,5	74,5
D	7,95	12,71	12,71	12,71	12,71
E	4	4	4	4	4
F _{-0,03}	3,2	3,2	3,2	6,3	6,3
G _{+0,01}	12,69	19,04	19,04	19,04	19,04
H	35,2	40	47,9	57,4	58
J	11	14	14	18	22
K	18	20	20	26	33
L	21,5	26,5	27,5	32	39,5
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10
N	9,5	12	13	13,5	18
O	22	25	27	26,5	37,5
P	53	62	70,5	79	87
R	19,3	22,5	25,7	28,8	29,4

Chucking capacities of jaw steps (standard values)

Size mm	160	200	250	315	400	500
A1 min.	8	10	10	15	20	45
A2 max.	160	200	250	315	400	500
max. swing. dia.	185	235	296	369	465	570

