

# 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

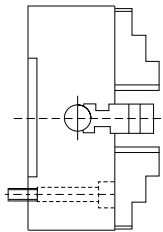
- ☺ Concentric rings for visual rough centering, fine centering using dial gauge

### TECHNICAL FEATURES

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

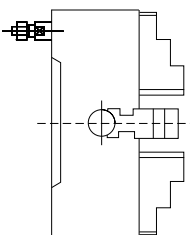
Cast iron independent chucks UGE-UGU

A26  
Cylindrical centre mount



| Size | With one-piece reversible jaws | With base jaws and top jaws | Through-hole mm | Speed max. min <sup>-1</sup> |
|------|--------------------------------|-----------------------------|-----------------|------------------------------|
| 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

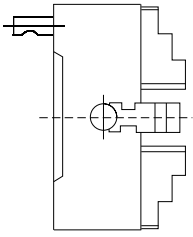


| Size | Mount short taper | With one-piece reversible jaws | With reversible top jaws | Through-hole mm | Speed max. min <sup>-1</sup> |
|------|-------------------|--------------------------------|--------------------------|-----------------|------------------------------|
| 200  | 5                 | 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 <sup>-1</sup> |
|------|-------------------|--------------------------------|--------------------------|-----------------|------------------------------|
| 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

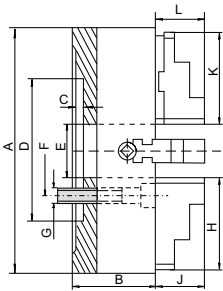
Reversible top jaws UB, hardened



| 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

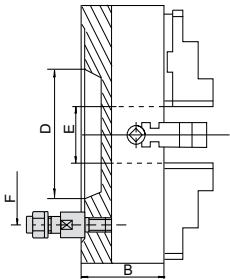
## Cylindrical centre mount



| 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    |
| D <sup>H7</sup> | 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   |

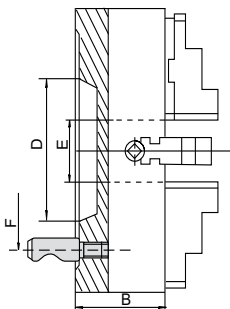
## Short taper mount

DIN 55027 with studs and locknuts



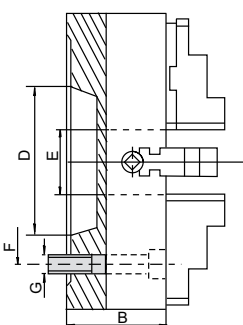
| Size           | 200              |      |       | 250   |      |       |       | 315   |       |       |
|----------------|------------------|------|-------|-------|------|-------|-------|-------|-------|-------|
| Taper size     | 4                | 5    | 6     | 4     | 5    | 6     | 8     | 5     | 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 <sup>1)</sup> | 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

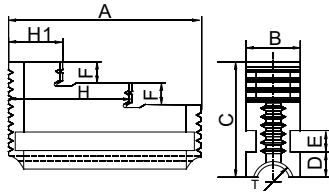


| Size       | 200   |       | 250   |       |       | 315   |       |       | 400   |       |       |
|------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Taper size | 5     | 6     | 5     | 6     | 8     | 5     | 6     | 8     | 6     | 8     | 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   |

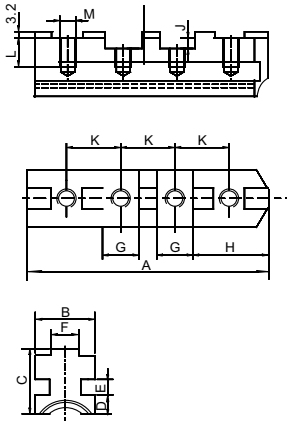
# Jaw dimensions UGE - UGU

## Reversible one-piece jaw EB



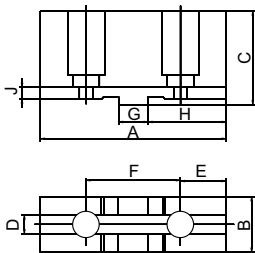
| Size     | 160  | 200  | 250  | 315    | 400    | 500    |
|----------|------|------|------|--------|--------|--------|
| A        | 61,5 | 85   | 92   | 111    | 129    | 152,5  |
| B        | 20   | 27   | 27   | 40     | 40     | 52     |
| C        | 51   | 61,5 | 61,  | 76,5   | 76,5   | 93,5   |
| 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



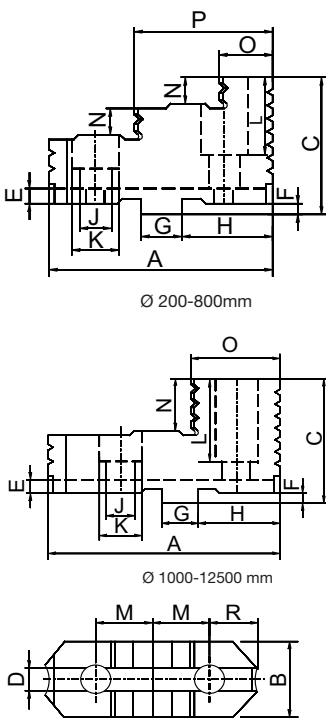
| Size               | 200    | 250    | 315    | 400    | 500    |
|--------------------|--------|--------|--------|--------|--------|
| A                  | 79     | 94     | 110    | 129    | 168    |
| B                  | 27     | 27     | 40     | 40     | 52     |
| C                  | 32     | 38     | 39     | 44     | 59     |
| D                  | 11,5   | 11,5   | 9,7    | 9,7    | 11,7   |
| E                  | 10     | 10     | 12     | 12     | 15     |
| F <sub>-0,03</sub> | 7,94   | 12,7   | 12,7   | 12,7   | 12,7   |
| G <sub>+0,01</sub> | 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 <sub>-0,03</sub> | 3,2    | 3,2    | 3,2    | 6,3    | 6,3    |
| G <sub>+0,01</sub> | 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 |

