

For use on modern lathes. With large through-hole, suitable for both bar work and chucking of flange-type parts.

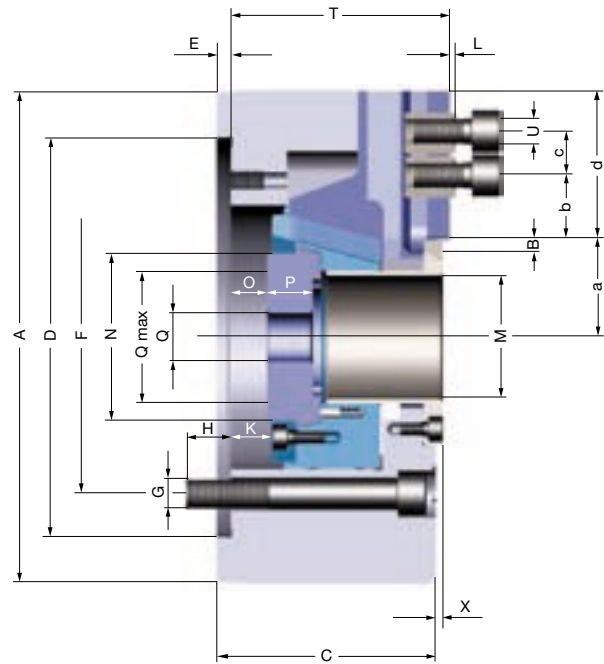
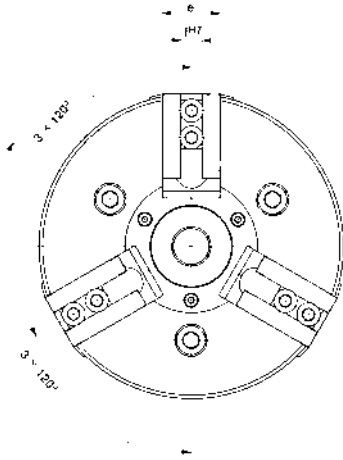
The chucking power is transmitted by means of the proven wedge system.

#### Technical features

- Rugged construction
- Large through-hole
- High radial and axial true-running accuracy
- Direct lubrication of all wearing surfaces
- Short taper mounting to DIN 55026/55021 or straight recess mounting to DIN 6353
- Used in conjunction with RÖHM SZS-E, SZS, OVS safety cylinders, KFD-HE power chucks meet the requirements of the German Employers' Liability Insurance Association.

#### Components KFD-HE

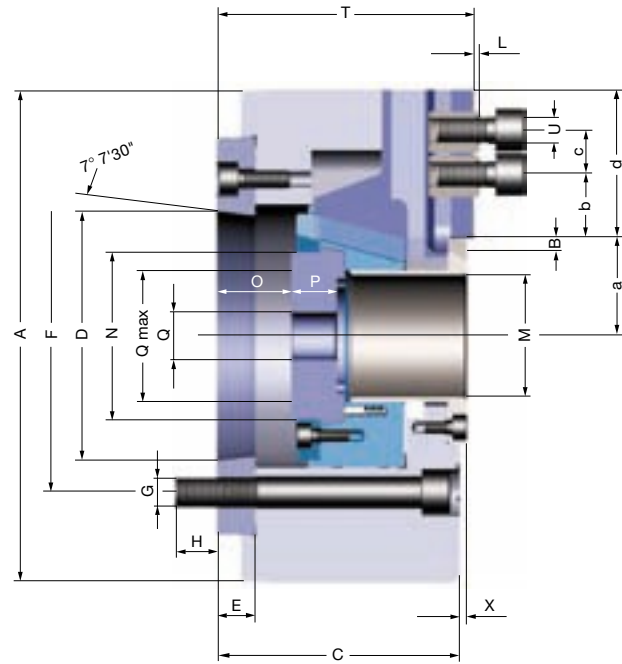
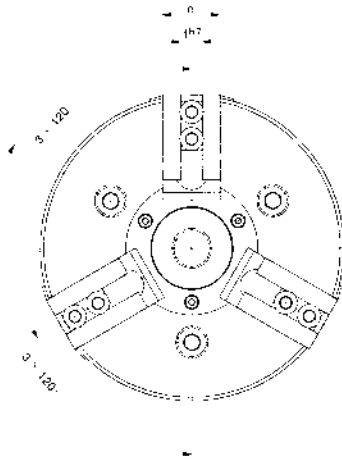
1. Body
2. Base jaw
3. Piston
4. Adaptor plate
5. Protective bushing
6. Ring nut
7. Sliding block



Interchangeable with Kitagawa models B-200A

## Type 440-90 adaptor recess DIN 6353

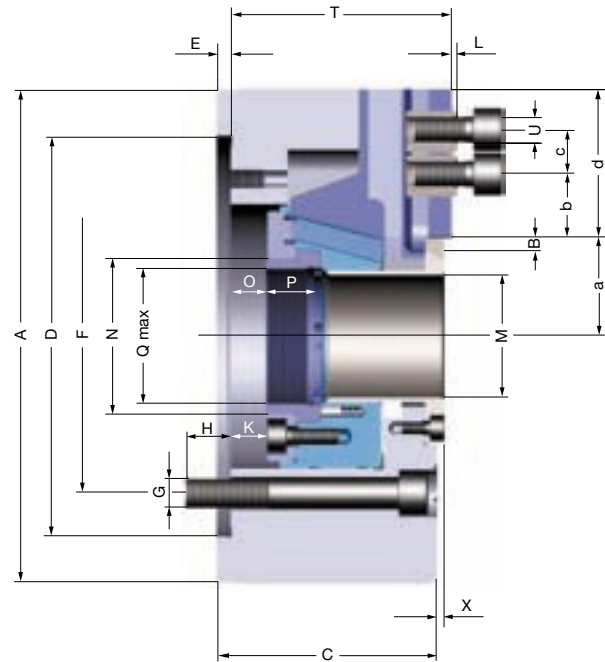
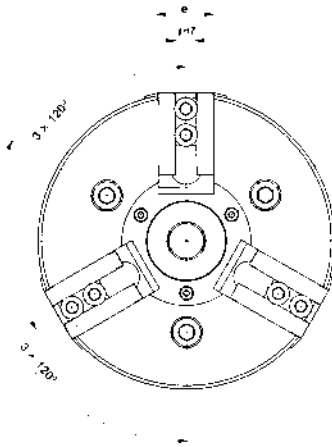
Size	inches	5	6	8	10	12	12
	mm	130	170	210	254	315	315
Id.-No.		154808	154390	154391	154392	154812	154830
Jaw travel	A	130	170	210	254	315	315
	B	2,7	3,4	4,3	5,1	5,3	5,3
	C	60	82	93	101	104	114
	D <sup>H6</sup>	110	140	170	220	220	300
	E	4	6	6	6	6	6
	F	82,6	104,8	133,4	171,4	171,4	235
	G	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 16	3 x M 20
	H	15	15	19	23	24	28
Wedge stroke	K	10	14	16	19	23	23
	L	2,9	3,2	3,2	3,2	3,2	3,2
Large bore	M	33	43	52	75	91	121
	N	45	57	66	94	108	143
min./max.	O	-9/1	-2,6/11,4	-0,7/15,3	-10,3/8,7	-14,8/8,2	-9,4/13,6
	P	20	19	20,5	28	32	26
	Q/Q max.	∅ 12/M 40 x 1,5	∅ 20/M 53 x 2	∅ 30/M 60 x 2	∅ 45/M 85 x 2	∅ 50/M 100 x 2	∅ 60/M 130 x 2
	T	61	82	93	101	110	114
	U	M 8	M 10	M 12	M 12	M 16	M 16
	V <sup>H7</sup> <sub>-0,05</sub>	57	74	92	125	135	170
	X	3	3	3	3	3	3
	a	23,8 / 26,5	34,8 / 38	37,7 / 42	50,9 / 56	56 / 61,3	72,2 / 77,5
	b	7	4,5	9	8	12	12
	c	14	20	25	30	30	30
min./max.	d	38,5	47	63	71	96	80
	e	25	32	40	50	50	50
	f <sup>H7</sup> <sub>-0,025</sub>	10	12	14	16	21	21
Max. swing of top jaws	mm	170	230	290	345	410	410
Maximum draw bar pull	kN	16	25	40	60	60	60
Max. total clamping force approx.	kN	36	66	90	135	150	150
Maximum admissible speed	min <sup>-1</sup>	7000	6000	5000	4200	3300	3300
Moment of inertia J	kgm <sup>2</sup>	0,011	0,038	0,9	0,22	0,8	0,8
Weight without top jaws approx.	kg	5,5	12	18	29	53	50



Interchangeable with Kitagawa models B-200A

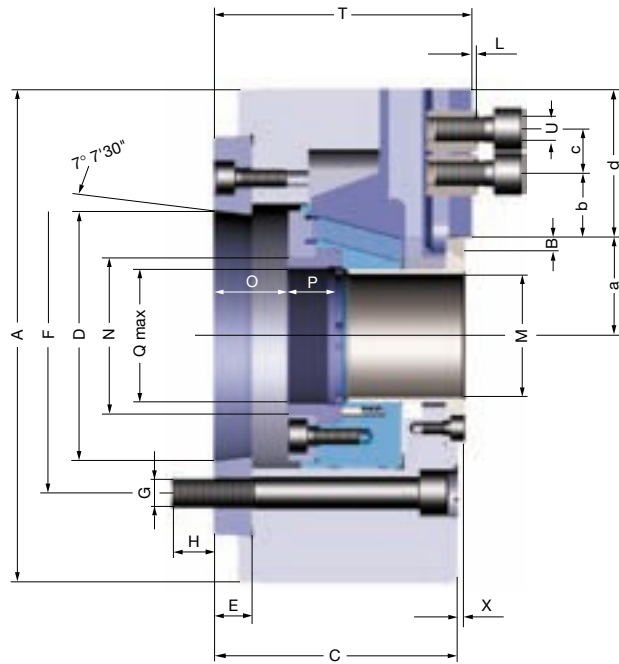
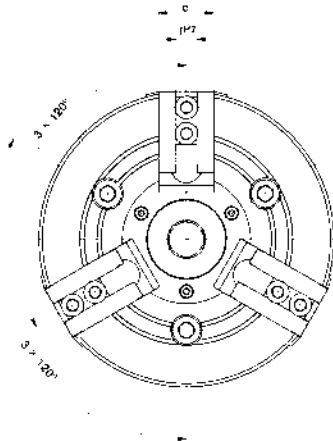
## Type 440-92 short taper mount DIN 55026/55021

Size	inches	5	6	8	10	12	12
	mm	130	170	210	254	315	315
Id.-No.		154809	154393	154394	154395	154813	154832
	A	130	170	210	254	315	315
Jaw travel	B	2,7	3,4	4,3	5,1	5,3	5,3
	C	67,5	90,6	103,2	112,8	121,8	127,4
Short taper	D	4 (nur 55026)	5	6	8	8	11
	E	11,5	15	16	17,8	17,8	19,4
	F	82,6	104,8	133,4	171,4	171,4	235
	G	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 16	3 x M 20
	H	13	15	18	23	24	29
Wedge stroke	K	10	14	16	19	23	23
	L	2,9	3,2	3,2	3,2	3,2	3,2
Large bore	M	33	43	52	75	91	121
	N	45	57	66	94	108	143
	min./max. O	2,5 / 12,5	12 / 26	15,5 / 31,5	7,5 / 26,5	3 / 26	10 / 33
	P	20	19	20,5	28	32	26
	Q/Q max.	$\varnothing 12/M 40 \times 1,5$	$\varnothing 20/M 53 \times 2$	$\varnothing 30/M 60 \times 2$	$\varnothing 45/M 85 \times 2$	$\varnothing 50/M 100 \times 2$	$\varnothing 60/M 130 \times 2$
	T	72,5	96,6	109,2	118,8	127,8	133,4
	U	M 8	M 10	M 12	M 12	M 16	M 16
	V <sup>H7</sup> <sub>-0,05</sub>	57	74	92	125	135	170
	X	3	3	3	3	3	3
	min./max. a	23,8 / 26,5	34,8 / 38	37,7 / 42	50,9 / 56	56 / 61,3	72,2 / 77,5
	min. b	7	4,5	9	8	12	12
	c	14	20	25	30	30	30
	d	38,5	47	63	71	96	80
	e	25	32	40	50	50	50
	f <sup>H7</sup> <sub>-0,025</sub>	10	12	14	16	21	21
Max. swing of top jaws	mm	170	230	290	345	410	410
Maximum draw bar pull	kN	16	25	40	60	60	60
Max. total clamping force approx.	kN	36	66	90	135	150	150
Maximum admissible speed	min <sup>-1</sup>	7000	6000	5000	4200	3300	3300
Moment of inertia J	kgm <sup>2</sup>	0,011	0,038	0,9	0,22	0,8	0,8
Weight without top jaws approx.	kg	5,5	12	18	29	53	50



### Type 440-50 adaptor recess DIN 6353

Size		130	170	210	254	315	315	400
Id.-No.		154806	154384	154031	154032	154810	154829	151554
	A	130	170	210	254	315	315	400
Jaw travel	B	2,7	3,2	4,3	5,1	5,3	5,3	8
	C	60	82	93	101	104	114	128
	D <sup>H6</sup>	110	140	170	220	220	300	300
	E	4	6	6	6	6	6	6
	F	82,6	104,8	133,4	171,4	171,4	235	235
	G	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 16	3 x M 20	3 x M 20
	H	15	15	19	23	24	28	29
Wedge stroke	K	10	14	16	19	23	23	30
	L	2,75	2,5	2,5	2,5	2,5	2,5	3,5
Large bore	M	33	43	52	75	91	121	121
	N	45	57	66	94	108	143	136
	O	-9/1	-2,6/11,4	-0,7/15,3	-10,3/8,7	-14,8/8,2	-9,4/13,6	-21/9
	P	20	19	20,5	28	32	26	28
	Q	M 40 x 1,5	M 52 x 1,5	M 58 x 1,5	M 82 x 1,5	M 98 x 1,5	M 126 x 1,5	M 126 x 1,5
	T	61	82	93	101	110	114	129
	U	M 8	M 8	M 12	M 16	M 16	M 16	M 20
	V <sup>H7</sup> <sub>-0,05</sub>	57	74	92	125	135	170	170
	X	3	3	3	3	3	3	4
	a	23,8/26,5	34,8/38	37,7/42	50,9/56	56/61,3	72,2/77,5	79/87
	b	7	7,5	9	10	12	12	19
	c	14	2 x 15	19/47	25/59	25/84	25/69	31/80
	d	38,5	47	63	71	96	80	113
	e	25	32	40	50	50	50	60
	f <sup>H7</sup> <sub>-0,025</sub>	10	12	17	21	21	21	25,5
Max. swing of top jaws	mm	170	230	290	345	410	410	560
Maximum draw bar pull	kN	16	25	40	60	60	60	95
Max. total clamping force approx.	kN	36	66	90	135	150	150	220
Maximum admissible speed	min <sup>-1</sup>	7000	6000	5000	4200	3300	3300	2000
Moment of inertia J	kgm <sup>2</sup>	0,011	0,038	0,09	0,22	0,8	0,8	1,88
Weight without top jaws approx.	kg	5,5	12	18	29	53	50	100



**Type 440-52 short taper mount DIN 55026/55021**

Size		130	170	210	254	315	315	400
Id.-No.		154807	154385	154034	154037	154811	154831	151553
	A	130	170	210	254	315	315	400
Jaw travel	B	2,7	3,2	4,3	5,1	5,3	5,3	8
	C	67,5	90,6	103,2	112,8	121,8	127,4	141,4
Short taper	D	4 (only 55026)	5	6	8	8	11	11
	E	11,5	15	16	17,8	17,8	19,4	19,4
	F	82,6	104,8	133,4	171,4	171,4	235	235
	G	3 x M 10	3 x M 10	3 x M 12	3 x M 16	3 x M 16	3 x M 20	3 x M 20
	H	13	15	18	23	24	29	30
Wedge stroke	K	10	14	16	19	23	23	30
	L	2,75	2,5	2,5	2,5	2,5	2,5	3,5
Large bore	M	33	43	52	75	91	121	121
	N	45	57	66	94	108	143	136
	min./max. O	2,5/12,5	12/26	15,5/31,5	7,5/26,5	3/26	10/33	-1,6/28,4
	P	20	19	20,5	28	32	26	28
	Q	M 40 x 1,5	M 52 x 1,5	M 58 x 1,5	M 82 x 1,5	M 98 x 1,5	M 126 x 1,5	M 126 x 1,5
	T	72,5	96,6	109,2	118,8	127,8	133,4	128,4
	U	M 8	M 8	M 12	M 16	M 16	M 16	M 20
	V <sup>H7</sup> <sub>-0,05</sub>	57	74	92	125	135	170	170
	X	3	3	3	3	3	3	4
	min./max. a	23,8/26,5	34,8/38	37,7/42	50,9/56	56/61,3	72,2/77,5	79/87
	min. b	7	7,5	9	10	12	12	19
	min./max. c	14	2 x 15	19/47	25/59	25/84	25/69	31/80
	d	38,5	47	63	71	96	80	113
	e	25	32	40	50	50	50	60
	f <sup>H7</sup> <sub>-0,025</sub>	10	12	17	21	21	21	25,5
Max. swing of top jaws	mm	170	230	290	345	410	410	560
Maximum draw bar pull	kN	16	25	40	60	60	60	95
Max. total clamping force approx.	kN	36	66	90	135	150	150	220
Maximum admissible speed	min <sup>-1</sup>	7000	6000	5000	4200	3300	3300	2000
Moment of inertia J	kgm <sup>2</sup>	0,011	0,038	0,09	0,22	0,8	0,8	1,88
Weight without top jaws approx.	kg	5,5	12	18	29	53	50	100

	Size	Type UB 1/16" x 90°	3-jaw set		Size	Type UB 1,5 x 60°	3-jaw set		
			Id.-No.				Id.-No.		
	130	543-21	<b>156446</b>		130	543-31	<b>154814</b>		
	170	538-02	<b>046404</b>		170	543-31	<b>154674*</b>		
	210	538-04	<b>118522</b>		210	543-31	<b>154676</b>		
	254	538-05	<b>046414</b>		254	543-31	<b>154678</b>		
	315	538-05	<b>046414</b>		315	543-31	<b>154816</b>		

\* one step only

Type UB ground to finished size on the corresponding chuck at surcharge

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	Size	Type AB 1/16" x 90°	3-jaw set		Size	Type AB 1,5 x 60°	3-jaw set		Type KB Claw type jaws
			Id.-No.				Id.-No.		
	130	543-22	<b>156452</b>		130	543-32	<b>154863</b>		
	170	538-02	<b>046403</b>		170	543-32	<b>154865</b>		
	210	538-04	<b>133153</b>		210	543-32	<b>154867</b>		
	254	538-05	<b>133154</b>		254	543-32	<b>154869</b>		
	315	538-05	<b>133154</b>		315	543-32	<b>154871</b>		

Assign and dimensions on page 222

## Extended T-nuts – for high clamping forces and cutting capacities

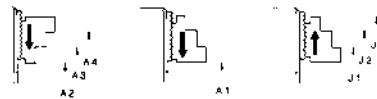
	Chuck size		130	170	210	254/315	400
	for SV 1/16" x 90°	DxExG	10xM8x14	12xM8x15	17xM12	21xM16	25,5xM20
	Id.-No.	piece	<b>154033</b>	<b>343234*</b>	<b>157569</b>	<b>157533</b>	<b>241676</b>
	suitable screw size		M8x16	M8x20	M12x25	M16x30	M20x40
	Id.-No.	piece	<b>248149*</b>	<b>233058**</b>	<b>227692</b>	<b>229157</b>	<b>233047</b>
	for SV 1,5 x 60°	DxExG	10xM8x14	12xM10x20	14xM12x25	16xM12x30	21xM16x30
	Id.-No.	piece	<b>154033</b>	<b>154651</b>	<b>154659</b>	<b>154672</b>	<b>155219</b>
	suitable screw size		M8x16	M10x25	M12x30	M12x30	M16x40
	Id.-No.	piece	<b>248149*</b>	<b>216588*</b>	<b>233030*</b>	<b>233030*</b>	<b>216569*</b>

Socket head cap screw to DIN 912, 12.9

\* 2 pieces required

\*\* 3 pieces required

## Chucking capacities with reversible top jaws UB



Chuck size		130	170	210	254	315
with reversible jaws 1/16" x 90°		Type UB	543-21	538-02	538-04	538-05
External clamping	jaw position	A 1	5-73	24-83	19-108	25-134
		A 2	–	–	36-128	48-162
		A 3	71-130	80-150	94-182	130-226
		A 4	–	120-192	145-234	210-272
Internal clamping	jaw position	J 1	54-119	63-130	78-156	80-190
		J 2	–	102-173	128-209	156-261
		J 3	–	154-210	181-263	246-338

Size		130	170	210	254	315
with reversible jaws 1,5 x 60°		Type UB	543-31	543-31	543-31	543-31
External clamping	jaw position	A 1	5-73	17-100	19-111	25-130
		A 2	–	–	–	–
		A 3	71-130	97-174	82-170	124-219
		A 4	–	–	133-224	170-265
Internal clamping	jaw position	J 1	54-119	74-154	63-160	84-197
		J 2	–	–	112-213	129-244
		J 3	–	–	170-273	211-328

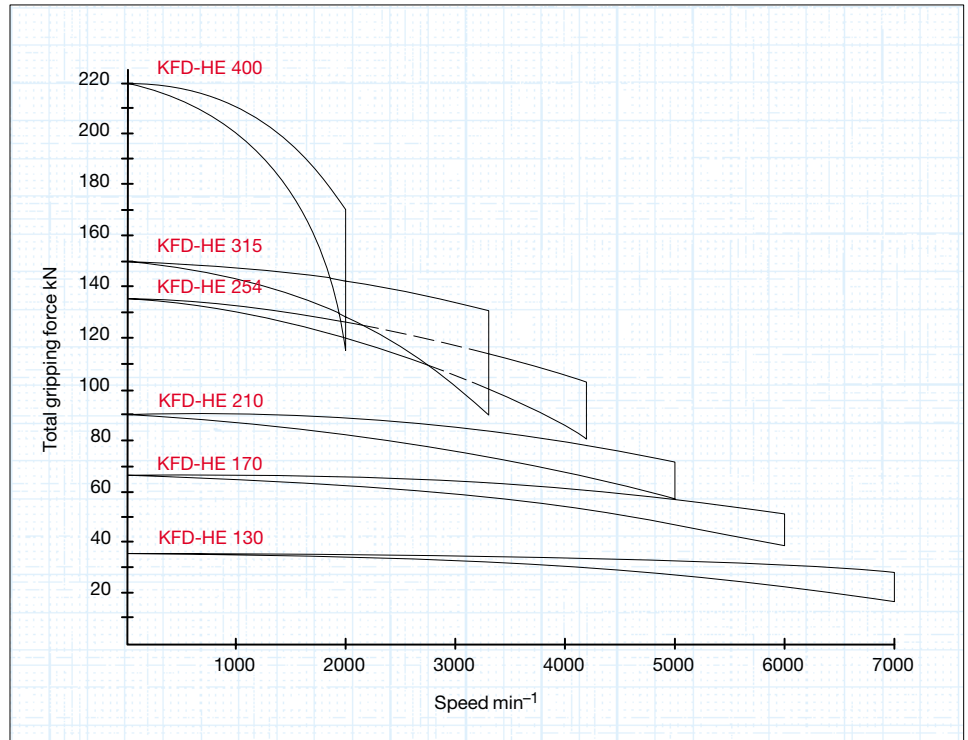
### Gripping force/speed diagram

The loss of gripping force was determined experimentally on a chuck with matched UB top jaws. It is largely independent of the initial gripping force at zero speed.

Upper curve  
= min. centrifugal force of top jaw



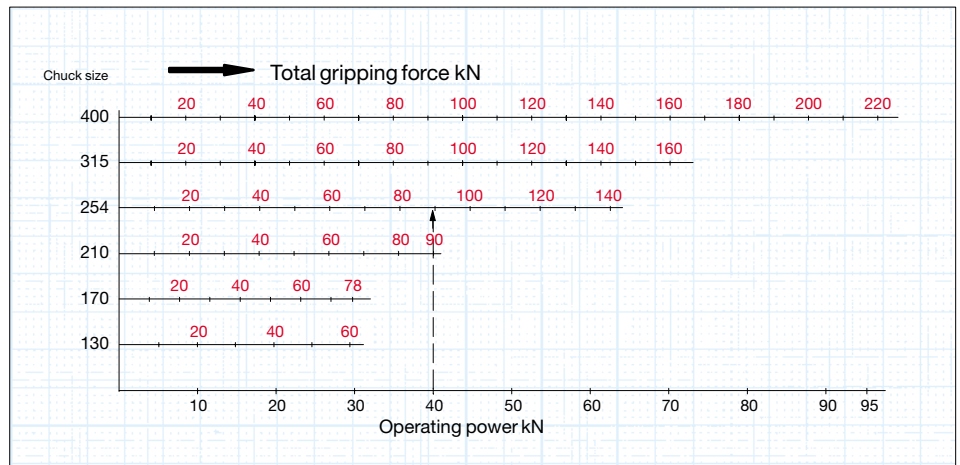
Lower curve  
= max. centrifugal force of top jaw



### Gripping force/operating power diagram

To obtain the specified gripping forces, the chuck must be in a perfect condition and lubricated with F 80 lubricant recommended by RöhM. Measuring point near chuck face.

**Example:** For a chuck size 254 and an applied operating power of 40 kN, the total gripping force is approx. 90 kN.



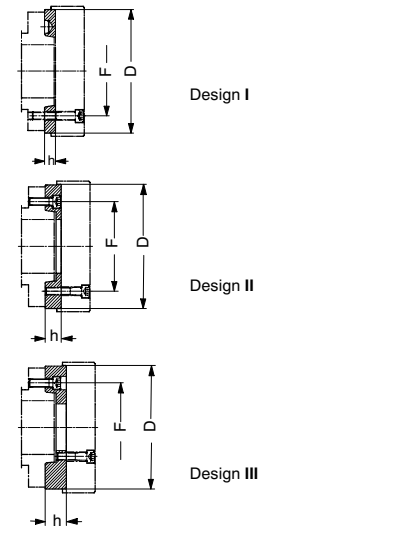
Spindle nose size	4 <sup>1)</sup>	5	6	8	11	15
F	82,6	104,8	133,4	171,4	235	330,2

**Type 594-32** Mounting from front to DIN 55026/55021 and ASA B 5.9 A1/A2 with metric mounting bolts

size	D	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.			
170	140	II	18	145125	I	15	145153	III	35	145129									
210	170				II	21	145127	I	16	145155	III	39	145135						
254	220							II	27	145131	I	18	145157	III	48	145143			
315	220							II	27	145131	I	18	145157	III	48	145143			
315	300										II	38	145139	I	19	145159			
400	300										II	38	145139	I	19	145159	III	58	145149

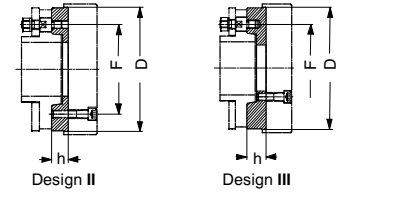
**Type 594-35** Mounting from front to ASA B 5.9 A1/A2 with inch threaded mounting bolts

size	D	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.			
170	140	II	18	145191				III	35	145193									
210	170				II	21	145192				III	39	145196						
254	220							II	27	145194				III	48	145200			
315	220							II	27	145194				III	48	145200			
315	300										II	38	145198						
400	300										II	38	145198				III	58	145203



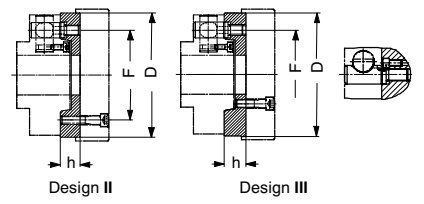
**Type 594-33** Bayonet fixing to DIN 55027/55022

size	D	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.			
170	140	II	18	145208	II	21	145236	III	35	145212									
210	170				II	21	145210	II	22	145240	III	39	145218						
254	220							II	27	145214	II	30	145242	III	48	145226			
315	220							II	27	145214	II	30	145242	III	48	145226			
315	300										II	38	145222	II	36	145246			
400	300										II	38	145222	II	36	145230	III	58	145232



**Type 594-36** Camlock fixing to DIN 55029/ASA B 5.9 D1

size	D	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.	*	h	Id.-No.			
170	140	II	28	145252	II	30	145280	III	43	145256									
210	170				II	30	145254	II	35	145284	III	46	145262						
254	220							II	35	145258	II	38	145286	III	53	145270			
315	220							II	35	145258	II	38	145286	III	53	145270			
315	300										II	38	145264	II	45	145290			
400	300										II	38	145264	II	45	145290	III	58	145276



### Suitable actuating cylinders

Chuck size	130	170	210	254	315		
SZS hydraulic	37/70	46/103	52/130	77/170	86/200		
OVS hydraulic	85	105-130	130	150	200		

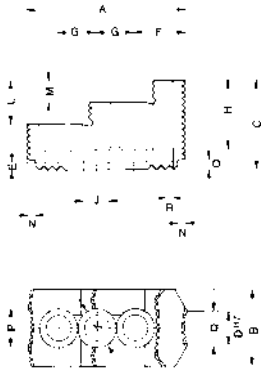


### Special grease F 80 for lubrication and conservation of chucking power

contents	Id.-No.				
1 kg	028975				

### Reversible top jaws, hardened, serration 90°, material 16MnCr5

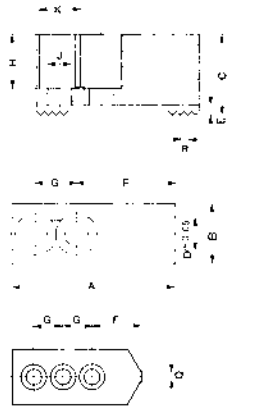
Type UB hardened reversible top jaws are employed to clamp blank or rough-machined workpieces.



Size KFD-HS	110	130	130/140	160/175	160	200	-	200/250	315	400/500	
Size KFD-HE		130	170				210	250/315	400		
reversible jaws-set UB	543-21	543-21	537-02	538-02	543*	543-09**	538-03	538-04	538-05	538-07	
2-jaws	Id.-No. 149490	-	046545	045796	-	-	046429	118521	046435	046447	
3-jaws	Id.-No. 149352	156446	046544	046404	351320	609592	046408	118522	046414	037531	
4-jaws	Id.-No. 155395	-	046546	046452	-	-	046456	118523	046462	046474	
A	45	54	56	56	51,5	80	68	75	103,5	135	
B	26	23	26	26	26	36	34,7	36	50	68	
C	32	27,5	37,5	37,5	26	37	45	49	58	65	
D <sup>H7</sup>	10	10	10	12	12	17	17	17	21	25,5	
E	3,5	4	3,5	3,5	3,5	5	5	5	5	5	
F	15	13	10	14	23	41	17	21,5	33,5	48	
G	15	14	12 <sup>1)</sup>	15	15 <sup>2)</sup>	19 <sup>2)</sup>	19	19	25	31	
H	23	19	29	29	17	25,5	33,5	37,5	45	48	
J	8,4	8,4	6,4	8,4	9	13	13	13	17	21	
K	13,5	13,5	10,4	13,5	14	19	19	19	25	31	
L	14	-	20	20	-	-	20	24	28	-	
M	7	10	10	10	8	12	10	12	14	26	
N	4	3	4	4	3	6	5	6	6	6,5	
O	4	3	4	4	4	7,5	7	7,5	6,5	5,5	
P	8	-	5	5	20	-	10	18	24,5	34	
Q	5	6	5	5	3	7	5	7	22,5	40	
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°	
weight/jaw	kg	0,155	0,110	0,130	0,170	0,150	0,235	0,350	0,460	1,130	2,000

1) 4 mounting holes  
2) 2 mounting holes  
\* one step only, for 8000 rpm  
\*\* one step only, extended

### Soft top jaws, serration 90°, material 16MnCr5

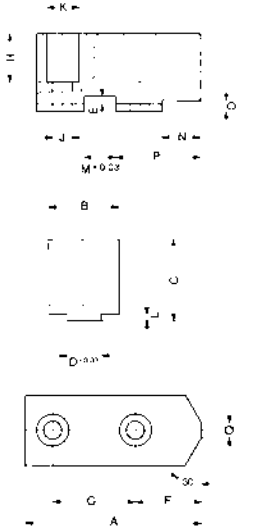


Type 537-02  
Type 543-22

grand. KFD-HS	110	-	130/140	160/175	200	250	315	-	400/500	
grand. KFD-HE	-	130	-	170		210	250/315	-	400	
Top jaws-set AB	543-22	537-02	537-02	538-02	538-03	538-04	538-05	538-06	538-07	
2-jaws	Id.-No. 149690	-	045794	045795	133147	133148	133149	133150	133151	
3-jaws	Id.-No. 149353	156452	046402	046403	133152	133153	133154	133155	133156	
4-jaws	Id.-No. -	-	046450	046451	133157	133158	133159	133160	133161	
A	45	54	53	55	66,7	75	95	103	130	
B	26,5	23	22,5	26,5	36,5	36,5	45	50	50	
C	38	29	30	38	53	53	54,5	80	80	
D	10	10	10	12	17	17	21	21	25,5	
E	3,5	4	3,5	3,5	5	5	5	5	5	
F	15	28	20	31	36	44	55	62	79	
G	15	14	12 <sup>1)</sup>	15	19	19	25	25	31	
H	23	20	20	28	43	43	42,5	67	60	
J	8,4	8,4	6,4	8,4	13	13	17	17	21	
K	13,5	13,5	10,4	13,5	19	19	25	25	31	
Q	5	-	3	-	-	-	-	-	-	
R	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	1/16"x90°	3/32"x90°	
Weight/Jaw	kg	0,210	0,220	0,223	0,320	0,700	0,880	1,400	2,580	3,1

1) 3 fori di fissaggio  
3 mounting holes

### Soft top jaws, tongue and groove, material 16MnCr5



Size KFD and KFD-HS	110	160	200	250	
Top jaws-set AB	549-10	538-13	538-14	538-15	
2-jaws	Id.-No. -	123359	123431	123434	
3-jaws	Id.-No. 144082	123358	123430	123433	
4-jaws	Id.-No. 144115	123359	123431	123434	
A	53	72,7	90,3	115,3	
B	22,5	36,5	36,5	45	
C	30	53	53	54,5	
D-0,03	10	16	16	20	
E	3,5	5,5	5,5	5,5	
F	26,5	32,2	45,3	58,3	
G	17	25	30	40	
H	20	38	38	38	
J	9	13	13	17	
K	15	19	19	25	
L	2,5	4,5	4,5	4,5	
M+0,03	10	10	12	16	
N	20	24,7	35,3	45,3	
O	4	5	5	5	
P	30	39,7	54,3	70,3	
Q	3	3	6	6	
Weight/Jaw	kg	0,21	0,720	1,0	1,55

Soft blank top jaws are ideal for high-accuracy chucking. When turning these top jaws for a specific chucking diameter, be sure to have the jaws under pressure. Top jaws which are to be hardened must be ground on the chuck after hardening.  
**Note:** At high speeds, heavy jaw weights must be avoided because of their own centrifugal force, resulting in a reduction of gripping force.

Soft top jaws **AB**, serration 60°, material 16MnCr5

	KFD-HE size	130	170	210	254	315
	Soft top jaws <b>AB</b> set	543-32	543-32	543-32	543-32	543-32
	3-jaws <b>Id.-No.</b>	<b>154863</b>	<b>154865</b>	<b>154867</b>	<b>154869</b>	<b>154871</b>
	A	54	72	95	110	120
	B	23	32,5	35	50	50
	C	29	40	45,5	45	55,5
	D	10	12	14	16	21
	F	28	37	46	50	52
	G	14	20	25	30	30
	H	20,5	27	33	29	34
J	8,4	11	13	13	17	
K	13,5	17	19	19	25	
Serration	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°	
Jaw weight kg	0,25	0,5	0,9	1,7	1,9	

Reversible top jaws **UB**, serration 60°, material 16MnCr5

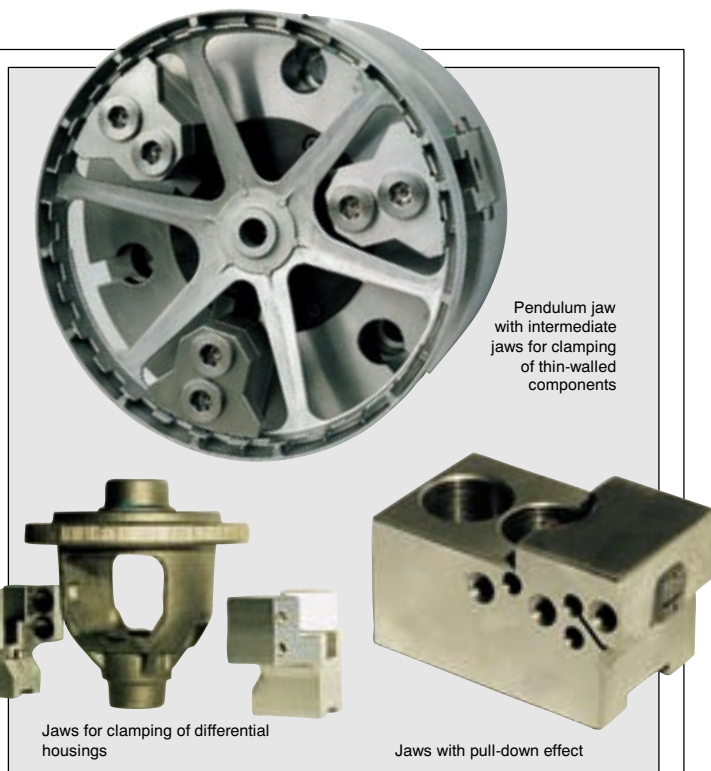
	KFD-HE size	130	170	210	254	315
	Reversible top jaws <b>UB</b> set	543-31	543-31	543-31	543-31	543-31
	3-jaws <b>Id.-No.</b>	<b>154814<sup>1)</sup></b>	<b>154674</b>	<b>154676</b>	<b>154678</b>	<b>154816<sup>1)</sup></b>
	A	54	66	81	99,5	103
	B	23	34,7	36	44,5	50
	C	27,5	36	49	54	55,5
	D	10	12	14	16	21
	F	13	12,5	17,5	25,5	22,5
	G	14	20	25	30	30
	H	19	23	36,5	38,5	34
J	8,4	11	13	13	17	
K	13,5	17	19	19	25	
Serration	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°	1,5 x 60°	
Jaw weight kg	0,16	0,3	0,6	1,2	1,5	

1) one step only

Clamping jaws

**RÖHM - Special design jaws**

With our own design department and production line, we are the perfect partner for solutions to clamping problems. Our experienced design team can create various styles and forms. This will ensure the prototypes can be finished in a time frame acceptable for the producer and customer.

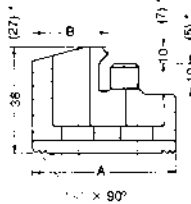


Pendulum jaw with intermediate jaws for clamping of thin-walled components

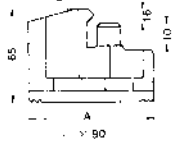
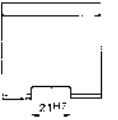
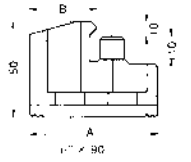
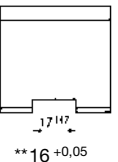
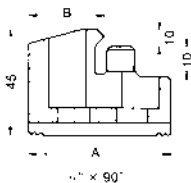
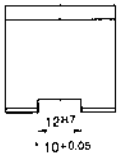
Jaws for clamping of differential housings

Jaws with pull-down effect

### Type 544-50 Claw type jaws KB, serration 90°



\* KFD-HS 110+130+140



Piece Id.-No.	A	B	H	KFD-HS 110 External chucking	Piece Id.-No.	A	B	KFD-HS 130 / 140 External chucking
149920	42	37,1	27	20-49	147259	50	41	27-67 / 35-72
149921	42	23,4	27	47-70	147261	44	22	58-108 / 61-114
149922	47	17,7	27	68-100				
				Internal chucking				
149922	47	17,7	27	45-75	147261	44	22	58-108 / 61-114
149921	42	23,4	27	56-102	147259	50	41	100-130 / 106-140
149920	42	37,1	27	84-130				

Piece Id.-No.	A	B	KFD 130	KFD-HS 160	KFD-HS 175	Piece Id.-No.	A	B	KFD-HE 170 1,5x60°	
				External chucking						
144320	66	52	38-82	38-84	48-100	156025	67	53	39-83	
144321	56	34	78-122	78-122	88-140	156027	65	46	52-98	
144322	66	25	120-144	120-146	130-160	156029	55	40	78-124	
						161189	55	24	110-155	
				Internal chucking						
144322	66	25	70-98	70-100	70-115	156027	65	46	92-135	
144321	56	34	92-138	92-140	102-155	156029	55	40	125-168	
144320	66	52	122-178	122-180	132-195	161189	55	24	150-190	

Piece Id.-No.	A	B	KFD-HE 160 KFD 160	KFD-HE 200 KFD 200	KFD-HS 200	KFD-HS 250			
Capacities external chucking									
137031	67	53	38-56	60-96	55-110	68-162			
137032	65	46	51-71	73-111	68-124	80-173			
137039	55	40	66-87	88-127	95-150	108-200			
137034	50	31	83-102	105-142	102-158	115-206			
137035	55	27	97-117	119-157	110-168	125-220			
Capacities internal chucking									
137036	65	19	50-70	72-110	65-125	80-172			
137037	65	26	68-85	90-125	86-142	100-192			
137038	55	24	82-104	104-144	100-156	112-206			
137035	55	27	102-116	124-156	120-178	135-228			
137034	50	31	114-123	136-163	132-188	145-236			
137039	55	40	120-135	144-175	136-195	150-245			
137033	55	39	132-165	154-205	150-207	165-257			
137032	65	46	146-178	168-218	164-222	179-270			

Piece Id.-No.	A	B	** KFD-HE 254 1,5x60°						
Capacities external chucking									
156099	95	80	60-102						
156101	75	60	99-140						
156103	60	43	132-174						
156105	70	37	163-205						
Capacities internal chucking									
156101	75	60	222-275						
156103	60	43	188-250						
156105	70	37	158-198						

Piece Id.-No.	A	B	KFD-HE 254	KFD 315▲	KFD-HE 315	KFD-HS 315 (86) <sup>1)</sup>	KFD-HS 315 (108) <sup>1)</sup>		
Capacities external chucking									
137041	95	80	53-95	53-160	66-160	46-175	65-175		
137042	75	60	92-133	92-198	105-198	92-220	104-220		
137043	60	43	125-167	125-232	138-232	114-250	135-250		
137044	70	37	156-198	156-263	169-263	142-275	166-275		
Capacities internal chucking									
137045	95	25	68-112	68-117	81-177	65-200	82-200		
137046	80	30	108-154	108-219	121-219	108-242	130-242		
137044	70	37	146-186	146-240	159-240	142-275	164-275		
137043	60	43	178-240	178-305	191-305	170-305	195-305		
137042	75	60	212-265	212-330	225-330	202-340	224-340		

Piece Id.-No.	A	B	KFD-HE 400	KFD-HS	KFD-HS 400 (165) <sup>1)</sup>	KFD-HS 500			
Capacities external chucking									
137051	130	113	80-180	70-270	94-270	94-370			
137052	90	67	170-270	150-304	183-304	183-404			
137053	100	45	256-390	175-390	210-390	210-490			
Capacities internal chucking									
137054	130	33	100-215	96-290	110-290	110-390			
137053	100	45	260-395	160-305	195-305	195-405			
137051	130	113	300-460	280-490	302-490	302-590			

▲) shallow design chuck

1) Chuck bore M