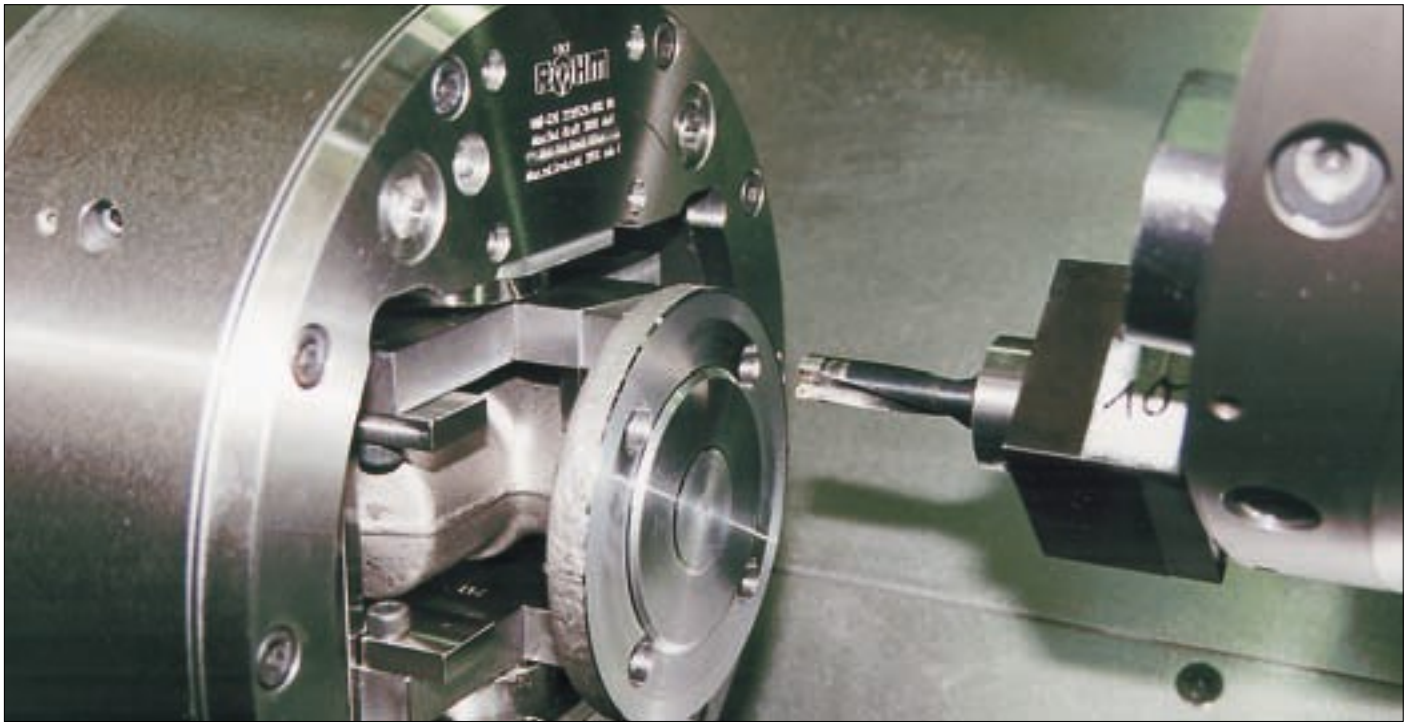
Indexing chucks

for machining workpieces with intersecting axes

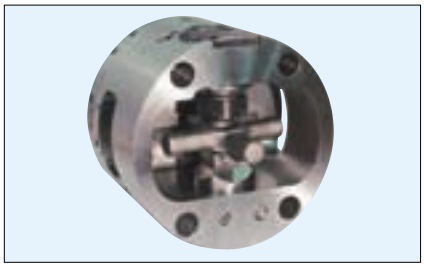


RÖHM indexing chucks have an indexing axis aligned at 90° to their axis of rotation and can be used for machining workpieces with intersecting axes in one chucking operation (classic example: yoke journal assemblies).
The fully automatic operating sequence through the indexing positions with the machine spindle running means that these chucks are very successful in rationalizing processes on relatively simple CNC lathes.
The degree of rationalization can be boosted still further by fitting an automatic workpiece handling system. An oil distributor or a chucking cylinder is required for operating the indexing chuck.

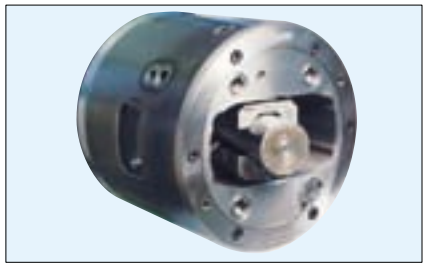
A control block integrated in the machine's hydraulic system is used for activating the chuck. Alternatively, a separate hydraulic power unit can be linked up to the machine electronically for use with existing machines.

RÖHM radial indexing chucks with an indexing axis parallel to their axis of rotation can be used for machining workpieces on which the centers of rotation of the areas to be machined are separated from one another but are still parallel to the center of the lathe spindle (classic example: crankshafts).

Overview of indexing chucks



Hydraulically operated indexing chuck HSF
with one movable jaw

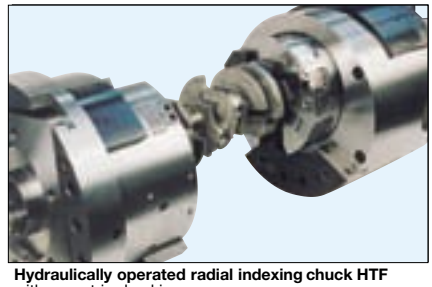


Power operated indexing chuck KSFZ
with central chucking

Power operated indexing chuck KSFZ
with eccentric chucking

Hydraulically operated indexing chuck HSFK
with correction piston

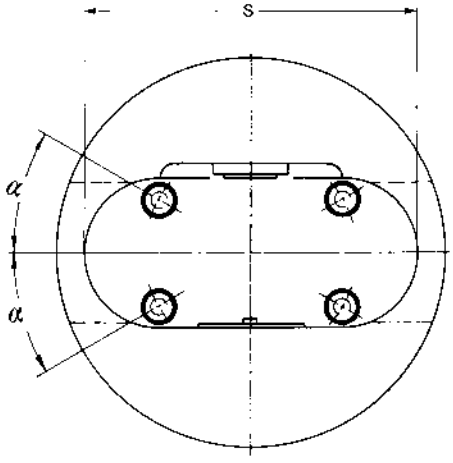
Hydraulically operated indexing chuck HSFZ
with indexable internal body

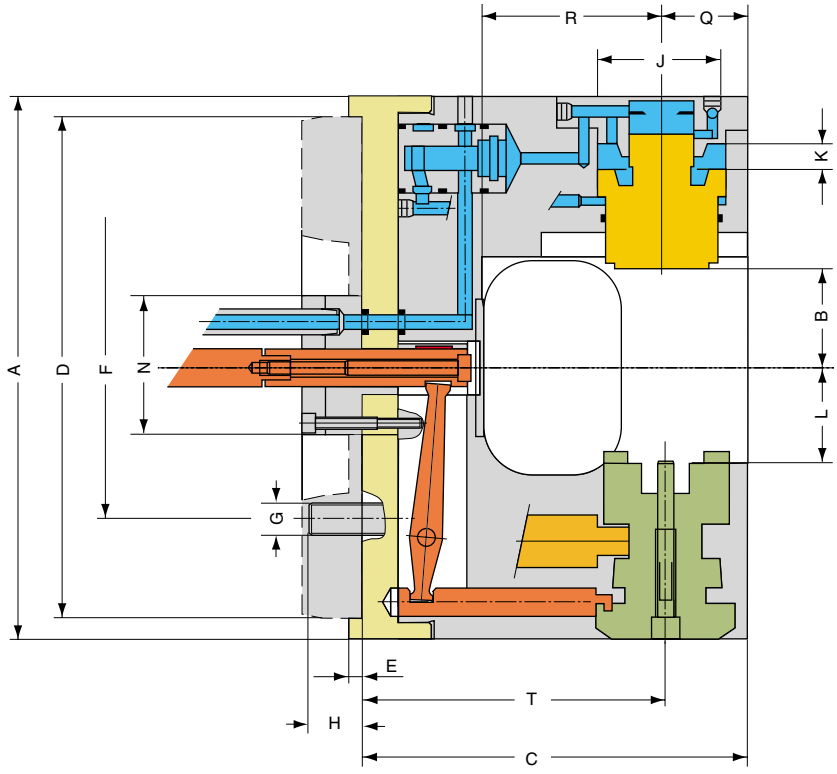


Hydraulically operated radial indexing chuck HTF
with eccentric chucking

Ask for our special leaflet Id.-No. 790732

HSF Hydraulically operated indexing chuck





Type 519-00

Size			200	230	250	315	400	500	630	800
Id.-No.			413172	413173	413174	413175	413176	413177	413178	413179
	A		200	230	250	315	400	500	630	800
	B	min.	30	40	32	57	92,5	120	160	220
		max.	44	54	49	80	119,5	154	205	275
	C		157	175	195	245	280	328	405	460
	D H6		185	185	210	220	300	380	380	380
	E		5	6	6	6	6	6	8	8
	F ±0,2		104,8	133,4	133,4	171,4	235	330,2	330,2	330,2
	G		M 10	M 12	M 12	M 16	M 20	M 24	M 24	M 24
	H		16	20	22	25	30	35	35	40
	J		50	55	70	85	100	115	125	145
Stroke	K		14	14	17	23	27	34	45	55
	L		32	45	41	62	104	135	192	260
	M		4	4	4	5	5	6	6	6
	N		58	58	58	72	92	92	92	110
	Q		32	35	40	50	60	68	75	90
	R		80	90	105	135	160	200	260	300
	S		170	195	210	260	340	410	530	620
	T		125	140	155	195	220	260	330	375
	α		30°	30°	30°	30°	30°	30°	60°	60°
Max. operating pressure/max. clamping pressure	bar		45/60	45/60	45/60	45/60	45/60	45/60	45/60	45/60
Max. total clamping force approx. at 60 bar	kN		23	28	46	68	94	122	147	197
Maximum admissible speed**	min^{-1}		4200	3700	3600	2600	2000	1500	1100	550
Moment of inertia J	kgm^2		0,15	0,31	0,45	1,36	3,80	10	30,5	66
Weight without jaw inserts approx.	kg		27	42	52	95	150	250	450	580

* Matching chuck adaptor plate, oil distributors, hydraulic control units and power units on request
** Depending on mass and center of gravity of the clamping inserts