

ISO 9001

LATHE CHUCKS

1



BISON-BIAL
METAEXPORT GROUP





Fabryka Przyrządów i Uchwytów BISON-BIAL S.A. Factory of Tooling and Chucks BISON-BIAL S.A.



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- Lathe chucks with manual clamping
 - self centering, standard and precision
 - independent
- Power chucks
- Hydraulic cylinders
- VDI holders
- Precision vices
- Milling tables
- Indexing fixtures
- Spindle toolings for standard and CNC machines
- Tapping heads
- Milling arbors
- Other equipment



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- Machine vices manual and power operated
- Bench vices manual and power operated
- Black smith's vices



Plant in Kolno

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- Milling arbors for standard and CNC machines
- Spindle toolings for standard and CNC machines
- Dead and live centres
- Toolposts
- Other spindle toolings

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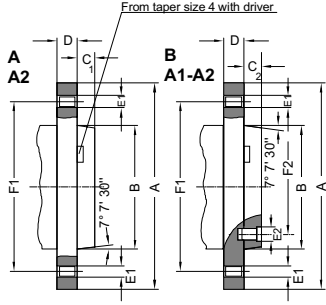
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Balance for self-centering lathe chucks


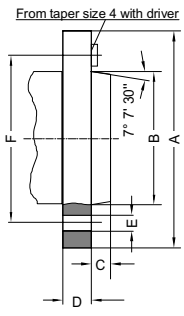
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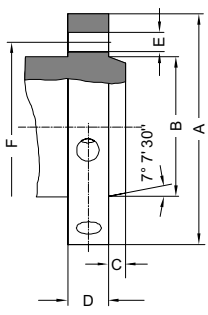
Centering accuracy of self-centering lathe chucks

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DIN 55026 Type A Type B ISO 702/I Type A2 Type A1-A2		spindle nose size	A	B max	C1	C2	D	E1	F1	E2	F2
 	3	92	53.983	11	-	16	3xM10	70.6	-	-	-
	4	108	63.521	11	-	20	11xM10	82.6	-	-	-
	5	133	82.573	13	14.288	22	11xM10	104.8	8xM10	61.9	-
	6	165	106.385	14	15.875	25	11xM12	133.4	8xM12	82.6	-
	8	210	139.731	16	17.462	28	11xM16	171.4	8xM16	111.1	-
	11	280	196.883	18	19.05	35	11xM20 (11xM18)	235	8xM20 (8xM18)	165.1	-
	15	380	285.791	19	20.638	42	12xM24 (12xM22)	330.2	11xM24 (11 xM22)	247.6	-
	20	520	412.795	21	22.225	48	12xM24	463.6	11xM24	368.3	-

Type A: Tapped holes in flange (outer bolt circle) without inner bolt circle.
Type B: Tapped holes in flange (outer bolt circle) and in inner bolt circle.
 Dimensions in brackets according to ISO 702/I.

DIN 55027 and ISO 702/III		WITH BAYONET RING FIXING					
spindle nose size	A	B max	C	D	E	F	
 	3	102	53.983	11	16	3x21	75
	4	112	63.521	11	20	3x21	85
	5	135	82.573	13	22	4x21	104.8
	6	170	106.385	14	25	4x23	133.4
	8	220	139.731	16	28	4x29	171.4
	11	290	196.883	18	35	6x36	235
	15	400	285.791	19	42	6x43	330.2
	20	540	412.795	21	48	6x43	463.6

DIN 55029, ANSI B 5.9 and ISO 702/II		CAMLOCK FIXING					
spindle nose size	A	B max	C	D	E	F	
 	3	92	53.983	11	32	3x15.1	70.6
	4	117	63.521	11	34	3x16.7	82.6
	5	146	82.573	13	38	6x19.8	104.8
	6	181	106.385	14	45	6x23	133.4
	8	225	139.731	16	50	6x26.2	171.4
	11	298	196.883	18	60	6x31	235
	15	403	285.791	19	70	6x35.7	330.2

DIN 800		WITH THREAD					
A	Bg5	C min	D	E	F		
M 20	21	30	6.3	10	20		
M 24	25	36	8	12	24		
M 33	34	50	9	14	30		
M 39	40	56	10	16	35		
M 45	46	67	11	18	40		
M 52	55	80	12	20	45		
M 60	62	90	14	22	50		
M 76x6	78	112	16	30	63		
M 105x6	106	150	20	40	80		

Last edition of relevant DIN standard applies in each case



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TYPE A1 - A2

A1

spindle nose size	A	B max	C -0.025	D	E1	F1	E2	F2
5	133.4	82.575	14.288	22.2	11x7/16-14 UNC	104.8	8x7/16-14 UNC	61.9
6	165.1	106.390	15.875	25.4	11x1/2-13 UNC	133.4	8x1/2-13 UNC	82.6
8	209.5	139.735	17.462	28.6	11x5/8-11 UNC	171.4	8x5/8-11 UNC	111.1
11	279.4	196.885	19.05	34.9	11x3/4-10 UNC	235	8x3/4-10 UNC	165.1
15	381	285.8	20.638	41.3	12x7/8-9 UNC	330.2	11x7/8-9 UNC	247.6
20	520	412.8	22.225	47.6	12x1-8 UNC	463.6	11x1-8 UNC	368.3

Tapped holes in flange (outer bolt circle) and inner bolt circle.
From taper size 4 with driver.

A2

spindle nose size	A	B max	C	D	E1	F1
3	92.1	53.985	11.1	15.9	3x7/16-14 UNC	70.66
4	108	63.525	11.1	19	11x7/16-14 UNC	82.55
5	133.4	82.575	12.7	22.2	11x7/16-14 UNC	104.8
6	165.1	106.390	14.3	25.4	11x1/2-13 UNC	133.4
8	209.5	139.735	15.9	28.6	11x5/8-11 UNC	171.4
11	279.4	196.885	17.5	34.9	11x3/4-10 UNC	235
15	381	285.8	19	41.3	12x7/8-9 UNC	330.2
20	520	412.8	20.6	47.6	12x1-8 UNC	463.6

Type A1-A2 correspond ISO 702/L.
Tapped holes in flange (outer bolt circle) without inner bolt circle.

TYPE B1 - B2

B1

spindle nose size	A	B	C -0.025	D	G	F1	E2	F2
5	133.4	82.575	14.288	22.2	11x11.9	104.8	8x7/16-14 UNC	61.9
6	165.1	106.390	15.875	25.4	11x3.5	133.4	8x1/2-13 UNC	82.6
8	209.5	139.735	17.462	28.6	11x16.7	171.4	8x5/8-11 UNC	111.1
11	279.4	196.885	19.05	34.9	11x20.2	235	8x3/4-10 UNC	165.1
15	381	285.8	20.638	41.3	12x23.4	330.2	11x7/8-9 UNC	247.6
20	520	412.8	22.225	47.6	12x26.6	463.6	11x1-8 UNC	368.3

Through-holes in flange (outer bolt circle) tapped holes in inner bolt circle.
From taper size 4 with driver.

B2

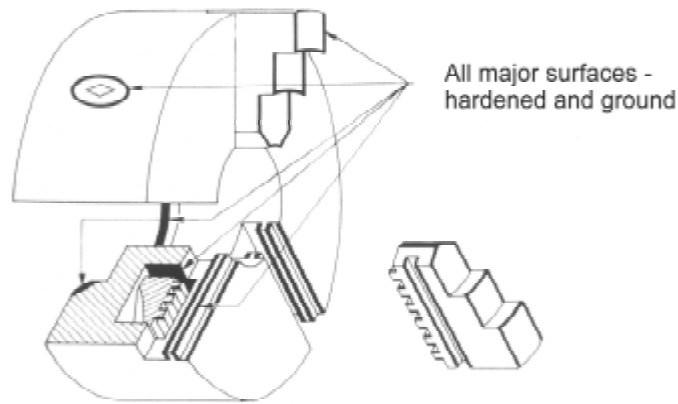
spindle nose size	A	B	C	D	G	F1
3	92.1	53.985	11.1	15.9	3x11.9	70.66
4	108	63.525	11.1	19	11x11.9	82.55
5	133.4	82.575	12.7	22.2	11x11.9	104.8
6	165.1	106.390	14.3	25.4	11x13.5	133.4
8	209.5	139.735	15.9	28.6	11x16.7	171.4
11	279.4	196.885	17.5	34.9	11x20.2	235
15	381	285.8	19	41.3	12x23.4	330.2
20	520	412.8	20.6	47.6	12x26.6	463.6

Through-holes in flange (outer bolt circle) without inner bolt circle.

TYPE L

LONG TAPER

spindle nose size	A+0.051	B	C	D	driving key
L00	69.850	3 3/4-6 UNS	50.800	14.288	9.525x9.525x38.1
L0	82.550	4 1/2-6 UNS	60.325	15.875	9.525x9.525x44.45
L1	104.775	6-6 UNS	73.025	19.050	15.875x15.875x60.32
L2	133.350	7 3/4-5 UNS	85.725	25.400	19.05x19.05x73.02
L3	165.100	10 3/8-4 UNS	94.425	28.575	25.4x25.4x82.55



Type 3500, 3700 chuck

**A PROVEN DESIGN (THE CUSHMAN TYPE) FOR UNIVERSAL USE
BUILT IN THREE MAIN LINES:**

- standard chucks - with cast iron body for normal use
- precision chucks - with steel body for precision and high precision machining; extended period of life - expectancy
- super precision chucks - with adjustment

All components which are important for transmitting the chucking force are of modern and compact design.

BODY

- type 3500, 3700 chucks - drop-forged of highest grade steel, hardened and ground
- type 3200, 3600 chucks - high quality cast-iron

SCROLL PLATE

- drop-forged of fine alloy steel, carburized and hardened
- thread flanks ground on both sides

JAWS

- of fine alloy steel, teeth, guides and other working surfaces carburized, hardened and ground

PINIONS

- of alloy steel, carburized, hardened and ground
- pinions are recessed into the chuck body and special safety spring is mounted on the operating wrench preventing against the risk of accidents

Each scroll plate and assembled precision chuck are statically balanced within fine limits.

Lathe chucks must be lubricated regularly to maintain their gripping force.

Appropriate directions are included in the operating instructions supplied with each chuck.


All chucks are equipped with grease nipples for convenient maintenance.



**GUIDE FOR USE OF HAND-OPERATED BISON CHUCKS,
SELF-CENTERING AND INDEPENDENT CHUCKS**

range of application, special features	3500 1st class accuracy	3200 3600	3500 3700	3105	3264, 3265 3564, 3565 3864, 3865	3266, 3868 3866, 3867	4505, 4605 4705, 4805	4300
machining of flange-type workpieces	●	●	●	●	●		●	●
bar or tubework	●	●	●	●	●		●	▲
machining of parts requiring a very high concentricity accuracy	■	●	●		■			
twist drill grinding	■					■		
clamping of parts on grinding machines	●	▲	●		■		▲	
machining of eccentrical parts, of assymetrical and irregularly shaped workpieces							■	■
machining of workpieces requiring especially high gripping force	●	●	●				●	●
machining of workpieces requiring a very high speed	■		■					
measuring and inspection works	■				■			
<p>● normal application ■ particularly suitable ▲ possible, with reservations</p>								

- Chucks form A mounting to ISO 702/I on request.

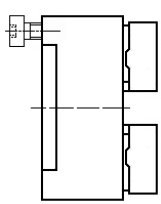


Used for machining all types of workpieces of irregular shapes.

Standard accessories:

- * 1 set of soft top jaws
- * 1 wrench
- * 1 set of mounting screws

Chuck and jaw weight in dimension tables
Spare parts see page 26
Engineering data see page 18, 19

SELF-CENTERING 2-JAWS CHUCKS, 2-PIECE SOFT TOP JAWS, CAST IRON BODY					
	chuck size	through hole	code No 0642 531	PKWiU 29 407 250	
	DIN 6350		type 3105		
		mm			
		160	42	050 403	313 105 290
		200	55	050 505	313 105 410
		250	76	050 607	313 105 510
		315	103	050 709	313 105 610
	400	136	050 800	313 105 730	
Example of order : 3105-400 or 0642 531 050 800					



Used when high accuracy of machining is needed.



Standard accessories:

- * 1 set of outside hard-solid jaws
- * 1 set of inside hard-solid jaws
- * 1 wrench
- * 1 set of mounting screws

Optional accessories:

- * 1 set of hard masters jaws
- * 1 set of soft solid jaws
- * 1 set of soft 2-piece jaws (hard master + top soft)

Size 500, 630 with T-slots

Chuck and jaw weight in dimension tables

Spare parts see page 26. Engineering data see page 18, 19.

PRECISION SELF-CENTERING 3-JAW CHUCKS, SOLID JAWS, 1st CLASS ACCURACY, STEEL BODY

	chuck size	short taper	through hole	code No 0642 535	PKWiU 29 407 250		chuck size	short taper	through hole	code No 0642 535	PKWiU 29 407 250
	DIN 6350						DIN 55026				
	type 3504						type 3514				
	80		16	040 105	343 504 010		160	*5	42	142 603	343 514 182
	100		20	040 207	343 504 030		200	*5	42	143 003	343 514 322
	125		35,5	040 309	343 504 080		200	*6	55	143 105	343 514 323
	160		42	040 400	343 504 180		250	5	76	143 309	343 514 472
	200		55	040 502	343 504 320		250	*6	55	143 400	343 514 473
	250		76	040 604	343 504 470		250	*8	76	143 502	343 514 474
	315		103	040 706	343 504 600		315	6	103	143 706	343 514 603
	400		136	040 808	343 504 740		315	*8	103	143 808	343 514 604
500		190	040 900	343 504 870	400	8	136	144 106	343 514 744		
630		252	041 106	343 504 920	400	*11	130	144 208	343 514 752		
						500	8	136	144 707	343 514 874	
						500	11	190	144 809	343 514 875	
						630	11	190	145 504	343 514 922	
						630	15	252	145 606	343 514 923	
	DIN 55027						DIN 55029				
	type 3534						type 3544				
	125	3	35,5	342 007	343 534 080		100	3	20	442 004	343 544 030
	125	4	35,5	342 200	343 534 081		125	3	35,5	442 106	343 544 080
	160	4	42	342 404	343 534 181		125	4	35,5	442 208	343 544 081
	160	5	42	342 506	343 534 182		160	3	42	442 300	343 544 180
	200	5	55	342 903	343 534 322		160	4	42	442 401	343 544 181
	200	6	55	343 008	343 534 323		160	5	42	442 503	343 544 182
	250	6	76	343 303	343 534 473		200	4	55	442 809	343 544 321
	250	8	76	343 405	343 534 474		200	5	55	442 900	343 544 322
	315	6	103	343 609	343 534 604		200	6	55	443 005	343 544 323
	315	8	103	343 700	343 534 605		250	6	76	443 300	343 544 473
	315	11	103	343 802	343 534 606		250	8	76	443 402	343 544 474
	400	8	136	344 009	343 534 744		315	6	103	443 606	343 544 603
	400	11	136	344 100	343 534 745		315	8	103	443 708	343 544 604
500	8	136	344 508	343 534 874	315	11	103	443 800	343 544 605		
500	11	190	344 600	343 534 875	400	8	136	444 006	343 544 744		
630	11	190	344 701	343 534 925	400	11	136	444 108	343 544 745		
630	15	252	344 803	343 534 933	500	8	136	444 301	343 544 873		
					500	11	190	444 403	343 544 874		
					630	8	136	445 200	343 544 923		
					630	11	190	445 302	343 544 924		
					630	15	252	445 404	343 544 928		
	type 3574										
	80		16	740 106	343 574 010						
	100		20	740 208	343 574 030						
	125		35,5	740 300	343 574 080						
	160		42	740 401	343 574 180						
	200		55	740 503	343 574 320						
	250		76	740 605	343 574 470						
	315		103	740 707	343 574 600						
400		136	740 809	343 574 740							

* mounting from front in the inner bolt circle

Example of order : 3514-200/5-l or 0642 535 143 003

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For use on lathes, rotary tables, indexing heads, etc.

Standard accessories:

- * 1 set of outside hard-solid jaws
- * 1 set of inside hard-solid jaws
- * 1 wrench
- * 1 set of mounting screws

Optional accessories:

- * 1 set of hard masters jaws
 - * 1 set of soft solid jaws
 - * 1 set of soft 2-piece jaws (hard master + top soft)
- Size 500, 630 with T-slots
 Chuck and jaw weight in dimension tables
 Spare parts see page 26
 Engineering data see page 18, 19

SELF-CENTERING 3 & 4 - JAWS CHUCKS, HARD SOLID JAWS

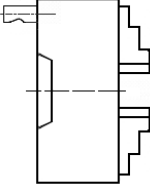
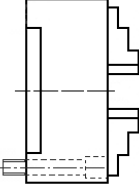
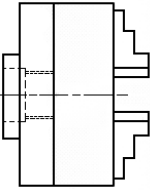
	chuck size	short taper	through hole	3 - jaw chucks				4 - jaw chucks			
				standard cast iron body		precision steel body		standard cast iron body		precision steel body	
				code No 0642 532	PKWiU 29 407 250	code No 0642 535	PKWiU 29 407 250	code No 0642 536	PKWiU 29 407 250	code No 0642 537	PKWiU 29 407 250
DIN 6350	mm		mm	type 3204		type 3504		type 3604		type 3704	
	80	-	16	040 106	323 204 010	045 100	343 504 011	-	-	-	-
	100	-	20	040 208	323 204 040	045 201	343 504 031	040 203	353 604 030	040 200	363 704 021
	110	-	27	041 504	323 204 080	-	-	041 500	353 604 050	-	-
	125	-	32**	040 300	323 204 090	045 303	343 504 081	040 305	353 604 070	040 301	363 704 060
	140	-	40	041 606	323 204 160	-	-	041 601	353 604 140	-	-
	160	-	42	040 401	323 204 180	045 405	343 504 181	040 407	353 604 170	040 403	363 704 130
	200	-	55	040 503	323 204 310	045 507	343 504 321	040 509	353 604 280	040 505	363 704 250
	250	-	76	040 605	323 204 440	045 609	343 504 471	040 600	353 604 380	040 607	363 704 450
	315	-	103	040 707	323 204 590	045 700	343 504 601	040 702	353 604 480	040 709	363 704 650
	400	-	136	040 809	323 204 700	045 802	343 504 741	040 804	353 604 590	040 800	363 704 770
	500	-	190	040 900	323 204 800	-	-	040 906	353 604 690	040 902	363 704 880
630	-	252	041 005	323 204 870	-	-	041 102	353 604 790	040 956	363 704 900	
800	-	320	041 107	323 204 940	-	-	-	-	-	-	
DIN 55026				type 3214		type 3514		type 3614		type 3714	
	160	*5	42	142 502	323 214 183	146 108	343 514 188	-	-	-	-
	200	*5	42	142 900	323 214 313	146 403	343 514 328	-	-	142 901	363 714 252
	200	*6	55	143 004	323 214 314	146 505	343 514 329	143 000	353 614 282	143 006	363 714 253
	250	5	76	143 208	323 214 443	146 709	343 514 478	143 203	353 614381	143 200	363 714 452
	250	*6	55	143 300	323 214 444	146 800	343 514 479	143 305	353 614 382	143 301	363 714 453
	250	*8	76	143 401	323 214 445	146 902	343 514 480	143 407	353 614 383	143 403	363 714 454
	315	6	103	143 605	323 214 594	147 109	343 514 609	143 600	353 614 482	143 607	363 714 653
	315	*8	80	143 707	323 214 595	147 200	343 514 610	143 702	353 614 483	143 709	363 714 654
	400	6	103	143 900	323 214 704	-	-	143 906	353 614 592	143 902	363 714 773
	400	8	136	144 005	323 214 705	147 506	343 514 750	144 000	353 614 593	144 007	363 714 774
	400	*11	130	144 110	323 214 707	147 608	343 514 753	144 115	353 614 595	144 111	363 714 775
	500	8	136	144 209	323 214 805	-	-	144 204	353 614 693	-	-
	500	11	190	144 313	323 214 807	-	-	144 319	353 614 695	-	-
	630	11	190	144 619	323 214 879	-	-	-	-	144 180	363 714 905
	630	*15	190	144 710	323 214 880	-	-	-	-	-	-
800	11	190	144 812	323 214 949	-	-	-	-	-	-	
800	*15	190	145 019	323 214 950	-	-	-	-	-	-	
800	20	320	144 901	323 214 948	-	-	-	-	-	-	
DIN 55027				type 3234		type 3534		type 3634		type 3734	
	100	3	20	342 008	323 234 040	-	-	-	-	-	-
	125	3	32**	342 100	323 234 090	345 702	343 534 086	342 105	353 634 070	342 101	363 734 060
	125	4	32**	342 201	323 234 091	345 804	343 534 087	342 207	353 634 071	342 203	363 734 061
	160	3	42	342 303	323 234 180	-	-	342 309	353 634 170	-	-
	160	4	42	342 405	323 234 181	346 000	343 534 187	342 400	353 634 171	342 407	363 734 131
	160	5	42	342 507	323 234 182	342 102	343 534 188	342 502	353 634 172	342 509	363 734 132
	160	6	42	342 609	323 234 183	-	-	342 604	353 634 173	-	-
	200	3	51.4	342 700	323 234 310	-	-	342 706	353 634 280	-	-
	200	4	55	342 802	323 234 311	-	-	342 808	353 634 281	-	-
	200	5	55	342 904	323 234 312	346 306	343 534 328	342 900	353 634 282	342 906	363 734 252
	200	6	55	343 009	323 234 313	346 408	343 534 329	343 004	353 634 283	343 000	363 734 253
	250	6	76	343 304	323 234 443	346 703	343 534 479	343 300	353 634 383	343 306	363 734 453
	250	8	76	343 406	323 234 444	346 805	343 534 480	343 401	353 634 384	343 408	363 734 454
	315	6	103	343 600	323 234 593	347 001	343 534 610	343 605	353 634 483	343 601	363 734 653
	315	8	103	343 701	323 234 594	347 103	343 534 611	343 707	353 634 484	343 703	363 734 654
	315	11	103	343 803	323 234 595	347 205	343 534 612	-	-	-	-
	400	6	103	343 905	323 234 703	-	-	343 900	353 634 593	-	-
	400	8	136	344 000	323 234 704	347 409	343 534 750	344 005	353 634 594	344 001	363 734 774
	400	11	136	344 101	323 234 705	347 500	343 534 751	344 107	353 634 595	344 103	363 734 775
	500	8	136	344 203	323 234 804	-	-	344 209	353 634 694	344 908	363 734 880
	500	11	190	344 305	323 234 805	-	-	344 300	353 634 695	345 002	363 734 881
	630	11	190	344 600	323 234 875	-	-	-	-	345 705	363 734 903
	630	15	252	344 702	323 234 876	-	-	-	-	345 807	363 734 905

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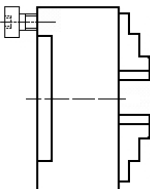
SELF-CENTERING 3 & 4 - JAWS CHUCKS, HARD SOLID JAWS

	chuck size	short taper	through hole	3 - jaw chucks				4 - jaw chucks			
				standard cast iron body		precision steel body		standard cast iron body		precision steel body	
				code No 0642 532 ...	PKWIU 29 407 250 ...	code No 0642 535 ...	PKWIU 29 407 250 ...	code No 0642 536 ...	PKWIU 29 407 250 ...	code No 0642 537 ...	PKWIU 29 407 250 ...
DIN 55029	mm		mm	type 3244		type 3544		type 3644		type 3744	
	100	3	20	442 005	323 244 040	445 608	343 544 000	-	-	-	-
	125	3	32**	442 107	323 244 090	445 700	343 544 086	442 102	353 644 070	442 109	363 744 060
	125	4	32**	442 209	323 244 091	445 801	343 544 087	442 204	353 644 071	442 200	363 744 061
	160	3	42	442 300	323 244 180	445 903	343 544 186	442 306	353 644 170	442 302	363 744 130
	160	4	42	442 402	323 244 181	446 008	343 544 187	442 408	353 644 171	442 404	363 744 131
	160	5	42	442 504	323 244 182	446 100	353 644 188	442 500	353 644 172	442 506	363 744 133
	200	3	51.4	442 708	323 244 310	-	-	442 703	353 644 280	-	-
	200	4	55	442 800	323 244 311	446 201	343 544 327	442 805	353 644 281	442 801	363 744 251
	200	5	55	442 901	323 244 312	446 303	343 544 328	442 907	353 644 282	442 903	363 744 252
	200	6	55	443 006	323 244 313	446 405	343 544 329	443 001	353 644 283	443 008	363 744 253
	250	5	76	443 200	323 244 442	-	-	443 205	353 644 382	-	-
	250	6	76	443 301	323 244 443	446 700	343 544 479	443 307	353 644 383	443 303	363 744 453
	250	8	76	443 403	323 244 444	446 802	343 544 480	443 409	353 644 384	443 405	363 744 454
	315	6	103	443 607	323 244 593	447 009	343 544 609	443 602	353 644 483	443 609	363 744 653
	315	8	103	443 709	323 244 594	447 100	343 544 610	443 704	353 644 484	443 700	363 744 654
	315	11	103	443 800	323 244 595	447 202	343 544 611	-	-	-	-
	400	6	103	443 902	323 244 703	-	-	443 908	353 644 593	-	-
	400	8	136	444 007	323 244 704	447 406	343 544 750	444 002	353 644 594	444 009	363 744 774
	400	11	136	444 109	323 244 705	447 508	343 544 751	444 104	353 644 595	444 100	363 744 775
	500	8	136	444 200	323 244 804	-	-	444 206	353 644 694	444 600	363 744 880
	500	11	190	444 302	323 244 805	-	-	444 308	353 644 695	444 701	363 744 881
	630	11	190	444 608	323 244 875	-	-	-	-	445 702	363 744 903
	630	15	252	444 700	323 244 876	-	-	-	-	445 804	363 744 905
				type 3274		type 3574		type 3674		type 3774	
	80		16	743 100	323 274 010	743 109	343 574 011	-	-	-	-
	85		18	744 202	323 274 011	-	-	-	-	-	-
	100		20	743 201	323 274 040	743 200	343 574 031	-	-	-	-
	125		32**	743 303	323 274 090	743 302	343 574 081	740 115	353 674 072	-	-
	160		42	743 405	323 274 180	743 404	343 574 181	740 217	353 674 172	740 302	363 774 130
	200		55	743 507	323 274 310	743 506	343 574 321	740 306	353 674 280	740 404	363 774 250
	250		76	743 609	323 274 440	743 608	343 574 471	740 408	353 674 380	740 506	363 774 450
	315		103	743 700	323 274 590	743 700	343 574 601	740 500	353 674 480	740 608	363 774 650
	400		136	743 802	323 274 700	743 801	343 574 741	-	-	740 700	363 774 770
	500		190	740 900	323 274 800	-	-	-	-	-	-
	630		252	740 941	323 274 870	-	-	-	-	-	-
		threaded mounting		type 3284							
	100	M24x3	20	840 002	323 284 040						

* mounting from front in the inner bolt circle ** 35,5 for 3500, 3700

Example of order : 3244-200/6 or 0642 532 443 006

SELF-CENTERING 6 - JAW CHUCKS, HARD SOLID JAWS

	chuck size	through hole	standard cast iron body		precision steel body	
			code No 0642 538 ...	PKWIU 29 407 250 ...	code No 0642 538 ...	PKWIU 29 407 250 ...
DIN 6350	mm	mm	type 3804		type 3806	
	200	55	040 308	373 804 460	060 304	373 806 460
	250	76	040 400	373 804 550	060 406	373 806 550
	315	103	040 501	373 804 630	060 508	373 806 630
	400	136	040 603	373 804 730	060 600	373 806 730
	500	190	040 705	373 804 810	060 701	373 806 810
	630	252	040 807	373 804 890	060 803	373 806 890

Example of order: 3804-200 or 0642 538 040 308



Used when high accuracy of machining is needed.



Standard accessories:

- * 1 set of hard sectional jaws (master+hard top reversible)
- * 1 wrench
- * 1 set of mounting screws

Optional accessories:

- * 1 set of soft top jaws
- * 1 set of outside hard solid jaws
- * 1 set of inside hard solid jaws

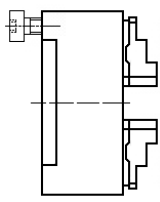
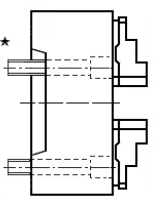
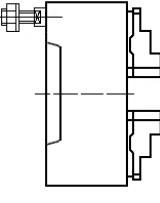
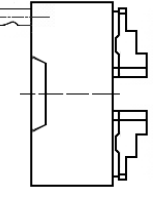
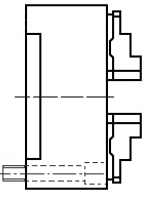
Size 500, 630 with T-slots
 Chuck and jaw weight in dimension tables
 Spare parts see page 26
 Engineering data see page 18, 19

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PRECISION SELF-CENTERING 3-JAW CHUCKS, HARD REVERSIBLE JAWS, 1st CLASS ACCURACY, STEEL BODY											
	chuck size	short taper	through hole	code No 0642 535 ...	PKWiU 29 407 250 ...		chuck size	short taper	through hole	code No 0642 535 ...	PKWiU 29 407 250 ...
	DIN 6350			type 3505			DIN 55026			type 3515	
	125		35,5	050 307	343 505 080		160	*5	42	152 500	343 515 182
	160		42	050 409	343 505 180		200	*5	42	152 907	343 515 322
	200		55	050 500	343 505 320		200	*6	55	153 001	343 515 323
	250		76	050 602	343 505 470		250	5	76	153 205	343 515 472
	315		103	050 704	343 505 600		250	*6	55	153 307	343 515 473
	400		136	050 806	343 505 740		250	*8	76	153 409	343 515 474
	500		190	050 908	343 505 870		315	6	103	153 602	343 515 603
630		252	051 104	343 505 920	315	*8	80	153 704	343 515 604		
	DIN 55027			type 3535			DIN 55029			type 3545	
	125	3	35,5	352 107	343 535 080		125	3	35,5	452 104	343 545 080
	125	4	35,5	352 209	343 535 081		125	4	35,5	452 206	343 545 081
	160	4	42	352 402	343 535 181		160	3	42	452 308	343 545 180
	160	5	42	352 504	343 535 182		160	4	42	452 400	343 545 181
	200	5	55	352 901	343 535 322		160	5	42	452 501	343 545 182
	200	6	55	353 006	343 535 323		200	4	55	452 807	343 545 321
	250	6	76	353 301	343 535 473		200	5	55	452 909	343 545 322
	250	8	76	353 403	343 535 474		200	6	55	453 003	343 545 323
	315	6	103	353 607	343 535 603		250	6	76	453 309	343 545 473
	315	8	103	353 709	343 535 604		250	8	76	453 400	343 545 474
	315	11	103	353 800	343 535 605		315	6	103	453 604	343 545 603
	400	8	136	354 007	343 535 744		315	8	103	453 706	343 545 604
	400	11	136	354 109	343 535 745		315	11	103	453 808	343 545 605
	500	8	136	354 506	343 535 874		400	8	136	454 004	343 545 744
500	11	190	354 608	343 535 875	400	11	136	454 106	343 545 745		
630	11	190	354 700	343 535 925	500	8	136	454 300	343 545 874		
630	15	252	354 801	343 535 926	500	11	190	454 401	343 545 875		
				type 3575							
	125		35,5	750 308	343 575 080						
	160		42	750 400	343 575 180						
	200		55	750 501	343 575 320						
	250		76	750 603	343 575 470						
	315		103	750 705	343 575 600						
400		136	750 807	343 575 740							

* mounting from front in the inner bolt circle

Example of order : 3515-250/5 I or 0642 535 153 205



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For use on lathes, rotary tables, indexing heads, etc.

Standard accessories:

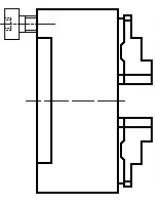
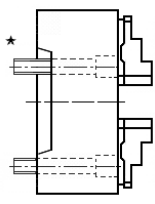
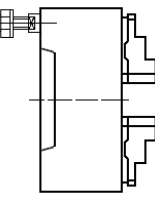
- * 1 set of hard sectional jaws (master+hard top reversible)
- * 1 wrench
- * 1 set of mounting screws

Optional accessories:

- * 1 set of soft top jaws
- * 1 set of outside hard solid jaws
- * 1 set of inside hard solid jaws

Chuck and jaw weight in dimension tables
Spare parts see page 26
Engineering data see page 18, 19

SELF-CENTERING 3 & 4 - JAWS CHUCKS, HARD REVERSIBLE JAWS

	chuck size	short taper	through hole	3 - jaw chucks				4 - jaw chucks			
				standard cast iron body		precision steel body		standard cast iron body		precision steel body	
				code No 0642 532	PKWiU 29 407 250	code No 0642 535	PKWiU 29 407 250	code No 0642 536	PKWiU 29 407 250	code No 0642 537	PKWiU 29 407 250
DIN 6350	mm		mm	type 3205		type 3505		type 3605		type 3705	
	125	-	32**	050 308	323 205 090	055 301	343 505 081	050 303	353 605 070	050 300	363 705 060
	160	-	42	050 400	323 205 180	055 403	343 505 181	050 405	353 605 170	050 401	363 705 130
	200	-	55	050 501	323 205 310	055 505	343 505 321	050 507	353 605 280	050 503	363 705 250
	250	-	76	050 603	323 205 440	055 607	343 505 471	050 609	353 605 380	050 605	363 705 450
	315	-	103	050 705	323 205 590	055 709	343 505 601	050 700	353 605 480	050 707	363 705 650
	400	-	136	050 807	232 205 700	055 800	343 505 741	050 802	353 605 590	050 809	363 705 770
	500	-	190	050 909	323 205 800	-	-	050 904	353 605 690	050 900	363 705 880
	630	-	252	051 003	323 205 870	-	-	051 100	353 605 790	050 954	363 705 900
	800	-	320	051 105	323 205 940	-	-	-	-	-	-
DIN 55026				type 3215		type 3515		type 3615		type 3715	
	160	*5	42	152 500	323 215 181	156 004	343 515 188	-	-	-	-
	200	*5	42	152 908	323 215 312	156 300	343 515 328	-	-	152 900	363 715 252
	200	*6	55	153 002	323 215 313	156 401	343 515 329	153 008	353 615 283	153 004	363 715 253
	250	5	76	153 206	323 215 442	156 605	343 515 478	153 201	353 615 382	153 208	363 715 452
	250	*6	55	153 308	323 215 443	156 707	343 515 479	153 303	353 615 383	153 300	363 715 453
	250	*8	76	153 400	323 215 444	156 809	343 515 480	153 405	353 615 384	153 401	363 715 454
	315	6	103	153 603	323 215 593	157 005	343 515 609	153 609	353 615 483	153 605	363 715 653
	315	*8	80	153 705	323 215 594	157 107	343 515 610	153 700	353 615 484	153 707	363 715 654
	400	6	103	153 909	323 215 703	-	-	153 904	353 615 593	153 900	363 715 773
	400	8	136	154 003	323 215 704	157 209	343 515 751	154 009	353 615 594	154 005	363 715 774
	400	*11	130	154 118	323 215 706	157 313	343 515 768	154 113	353 615 596	154 110	363 715 775
	500	8	136	154 207	323 215 804	-	-	154 202	353 615 694	-	-
	500	11	190	154 311	323 215 806	-	-	154 317	353 615 696	-	-
	630	11	190	154 617	323 215 877	-	-	-	-	-	-
	630	*15	190	154 719	323 215 878	-	-	-	-	-	-
	800	11	190	154 810	323 215 948	-	-	-	-	-	-
	800	*15	190	155 017	323 215 949	-	-	-	-	-	-
	800	20	320	154 900	323 215 947	-	-	-	-	-	-
DIN 55027				type 3235		type 3535		type 3635		type 3735	
	125	3	32**	352 108	323 235 090	355 700	343 535 086	352 103	353 635 070	352 100	363 735 060
	125	4	32**	352 200	323 235 091	355 802	343 535 087	352 205	353 635 071	352 201	363 735 061
	160	3	42	352 301	323 235 180	-	-	352 307	353 635 160	-	-
	160	4	42	352 403	323 235 181	356 009	353 535 187	353 409	353 635 161	352 405	363 735 131
	160	5	42	352 505	323 235 182	356 100	343 535 188	353 500	353 635 162	353 507	363 735 133
	160	6	42	352 607	323 235 183	-	-	352 602	353 635 163	-	-
	200	3	51.4	352 709	323 235 310	-	-	352 704	353 635 280	-	-
	200	4	55	352 800	323 235 311	-	-	352 806	353 635 281	-	-
	200	5	55	352 902	323 235 312	356 304	343 535 328	352 908	353 635 282	352 904	363 735 252
	200	6	55	353 007	323 235 313	356 406	343 535 329	353 002	353 635 283	353 009	363 735 253
	250	6	76	353 302	323 235 443	356 701	343 535 479	353 308	353 635 383	353 304	363 735 453
	250	8	76	353 404	323 235 444	356 803	343 535 480	353 400	353 635 384	353 406	363 735 454
	315	6	103	353 608	323 235 593	357 000	343 535 609	353 603	353 635 483	353 600	363 735 653
	315	8	103	353 700	323 235 594	357 101	343 535 610	353 705	353 635 484	353 701	363 735 654
	315	11	103	353 801	323 235 595	357 114	353 535 611	-	-	-	-
	400	6	103	353 903	323 235 703	-	-	353 909	353 635 593	-	-
	400	8	136	354 008	323 235 704	357 203	343 535 750	354 003	353 635 594	354 000	363 735 774
	400	11	136	354 100	323 235 705	357 305	343 535 751	354 105	353 635 595	354 101	363 735 775
	500	8	136	354 201	323 235 804	-	-	354 207	353 635 694	354 804	363 735 880
	500	11	190	354 303	323 235 805	-	-	354 309	353 635 695	354 906	363 735 881
	630	11	190	354 609	323 235 875	-	-	-	-	355 500	363 735 903
	630	15	252	354 700	323 235 876	-	-	-	-	355 601	363 735 905



SELF-CENTERING 3 & 4 - JAW CHUCKS, HARD REVERSIBLE JAWS

	chuck size	short taper	through hole	3 - jaw chucks				4 - jaw chucks			
				standard cast iron body		precision steel body		standard cast iron body		precision steel body	
				code No 0642 532	PKWiU 29 407 250	code No 0642 535	PKWiU 29 407 250	code No 0642 536	PKWiU 29 407 250	code No 0642 537	PKWiU 29 407 250
DIN 55029	mm		mm	type 3245		type 3545		type 3645		type 3745	
	125	3	32**	452 105	323 245 090	455 708	343 545 086	452 100	353 645 070	452 107	363 745 060
	125	4	32**	452 207	323 245 091	455 800	343 545 087	452 202	353 645 071	452 209	363 745 061
	160	3	42	452 309	323 245 180	455 901	343 545 186	452 304	353 645 170	452 300	363 745 130
	160	4	42	452 400	323 245 181	456 006	343 545 187	452 406	353 645 171	452 402	363 745 131
	160	5	42	452 502	323 245 182	456 108	343 545 188	452 508	353 645 172	452 504	363 745 132
	200	3	51.4	452 706	323 245 310	-	-	452 701	353 645 280	-	-
	200	4	55	452 808	323 245 311	456 200	343 545 327	452 803	353 645 281	452 800	363 745 251
	200	5	55	452 900	323 245 312	456 301	343 545 328	452 905	353 645 282	452 901	363 745 252
	200	6	55	453 004	323 245 313	456 403	343 545 329	453 000	353 645 283	453 006	363 745 253
	250	5	76	453 208	323 245 442	-	-	453 203	353 645 382	-	-
	250	6	76	453 300	323 245 443	456 709	343 545 477	453 305	353 645 383	453 301	363 745 453
	250	8	76	453 401	323 245 444	456 800	343 545 478	453 407	353 645 384	453 403	363 745 454
	315	6	103	453 605	323 245 593	457 007	343 545 609	453 600	353 645 483	453 607	363 745 653
	315	8	103	453 707	323 245 594	457 109	343 545 610	453 702	353 645 484	453 709	363 745 654
	315	11	103	453 809	323 245 595	457 404	343 545 611	-	-	-	-
	400	6	103	453 900	323 245 703	-	-	453 906	353 645 593	-	-
	400	8	136	454 005	323 245 704	457 200	343 545 750	454 000	353 645 594	454 007	363 745 774
	400	11	136	454 107	323 245 705	457 302	343 545 751	454 102	353 645 595	454 109	363 745 775
	500	8	136	454 209	323 245 804	-	-	454 204	353 645 694	454 608	363 745 880
	500	11	190	454 300	323 245 805	-	-	454 306	353 645 695	454 700	363 745 881
630	11	190	454 606	323 245 875	-	-	-	-	455 700	363 745 902	
630	15	252	454 708	323 245 876	-	-	-	-	455 802	363 745 906	
				type 3275		type 3575		type 3675		type 3775	
	125		32**	753 301	323 275 090	753 300	343 575 081	-	-	-	-
	160		42	753 403	323 275 180	753 402	343 575 181	742 206	353 675 170	750 300	363 775 130
	200		55	753 505	323 275 310	753 504	343 575 321	742 308	353 675 280	750 402	363 775 250
	250		76	753 607	323 275 440	753 606	343 575 471	742 400	353 675 380	750 504	363 775 450
	315		103	753 709	323 275 590	753 708	343 575 601	742 501	353 675 480	750 606	363 775 650
	400		136	753 800	323 275 700	753 800	343 575 741	-	-	750 708	363 775 770
	500		190	750 909	323 275 800	-	-	-	-	-	-
	630		252	750 940	323 275 870	-	-	-	-	-	-

* mounting from front in the inner bolt circle ** 35,5 for 3500, 3700

Example of order : 3245-160/4 or 0642 532 452 400

SELF-CENTERING 6 - JAW CHUCKS, HARD REVERSIBLE JAWS

	chuck size	through hole	standard cast iron body		precision steel body	
			code No 0642 538	PKWiU 29 407 250	code No 0642 538	PKWiU 29 407 250
			DIN 6350	mm	mm	type 3805
	200	55	050 306	373 805 460	070 302	373 807 460
	250	76	050 408	373 805 550	070 404	373 807 550
	315	103	050 500	373 805 630	070 506	373 807 630
	400	136	050 601	373 805 730	070 608	373 807 730
	500	190	050 703	373 805 810	070 700	373 807 810
	630	252	050 805	373 805 890	070 801	373 807 890

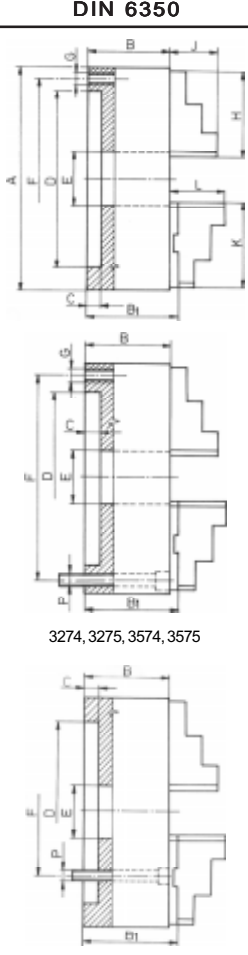
Example of order: 3805-200 or 0642 538 050 306

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DIN 6350		PLAIN BACK MOUNTING							
chuck size A		80	85 ¹⁾	100	110	125	140	160	
B	type 3500, 3700	44	-	50	-	59,5	-	68	
	the others	44	44	50	50	56	60	64,5	
B1	type 3500, 3700	-	-	-	-	64,3	-	72,8	
	the others	-	-	-	-	60,8	64,8	69,3	
C		3	3	3	4	4	4	4	
D H7		56	62	70	80	95	105	125	
E		16	18	20	27	32 35,5 ³⁾	40	42	
F		67	72	83	95	108	120	140	
G ²⁾		3xM6	-	3xM8	3xM8	3xM8	3xM8	6xM10	
H		32	43	42	42	51	51	70	
J		13	13	17	17	20	20	32	
K		-	-	-	-	56	56	67	
L		-	-	-	-	40	40	43	
P		3xM6	3xM6	3xM8	-	3xM8	-	3xM10	
weight approx. kg		1,5	1,9	2,8	3,4	5,0	6,0	10,0	
chuck size A		200	250	315	400	500	630	800	
B	type 3500 3700	78	89	96,2	108	119	129	-	
	the others	75	85	94	105	120	135	159	
B1	type 3500 3700	82,8	92,8	101,3	116,8	129,8	140,3	-	
	the others	79,8	88,8	99,1	113,8	130,8	146,3	170,3	
C		4	5	5	5	5	7	20	
D H7		160	200	260	330	420	545	450	
E		55	76	103	136	190	252	320	
F		176	224	286	362	458	586	368,3	
G ²⁾		6xM10	6xM12	6xM16	6xM16	6xM16	6xM16	-	
H		85	105	125	145	180	225	225	
J		29	34	43	55	60	70	70	
K		80	95	110	127	127	127	127	
L		45	53	57	67	79	87	87	
P		3xM10	3xM12	3xM16	3xM16	-	-	6xM24	
weight approx. kg		17,5	29	50	85	145,0	250,0	402	



3274, 3275, 3574, 3575

3204, 3205-800

¹⁾ for type 3274 chuck, ²⁾ 3 holes for types 3274, 3275, 3574, 3575, ³⁾ for type 3500, 3700

DIN 55026		FORM A MOUNTING									
chuck size A		160	200		250			315			
short taper		5	4	5	6	5	6	8	6	8	
B	type 3500,3700	68	78			89			96,2		
	the others	81,5	91			103,5			117,7		
B1	type 3500,3700	72,8	82,8			92,8			101,3		
	the others	86,3	95,8			107,3			122,8		
D	min	82,563	63,513	82,563	106,375	82,563	106,375	139,719	106,375	139,719	
	max	82,578	63,526	82,578	106,390	82,578	106,390	139,734	106,390	139,734	
E		42	42	42	55	76	55	76	103	80	
F1		61,9	-	61,9	82,6	-	82,6	111,1	-	111,1	
G1		M10	-	M10	M12	-	M12	M16	-	M16	
F		-	82,6	-	-	104,8	-	-	133,4	-	
G		-	M10	-	-	M10	-	-	M12	-	
qty. of moun- tin screws	3-jaw	3	3			3	6		6		
	4-jaw	4	4			4			8	4	
weight approx. kg		10,0	19,0			32,0			55,0		
chuck size A		400		500		630		800			
short taper		6	8	11	8	11	11	15	11	15	20
B	type 3500,3700	108			119		129		-		
	the others	128,5			146		165		159	180	
B1	type 3500,3700	116,8			129,8		140,3		-		
	the others	137,3			157,3		175,8		191,3		
D	min	106,375	139,719	196,869	139,719	196,869	196,869	285,775	196,869	285,775	412,775
	max	106,390	139,734	196,887	139,734	196,887	196,887	285,795	196,887	285,795	412,802
E		103	136	130	136	190	190	190*	190	320	
F1		-	-	165,1	-	-	-	-	-	247,6	-
G1		-	-	M 20	-	-	-	-	-	M 24	-
F		133,4	171,4	-	171,4	235	235	330,2	235	-	368,3
G		M12	M16	-	M16	M20	M20	M24	M20	-	M24
qty. of moun- ting screws	3-jaw	6			6		6		6		
	4-jaw	8	8	4	4	8	-		-		
weight approx. kg		92,0			160,0		285,0		384,0		

* 252 for chuck type 3500



MAIN DIMENSIONS OF CHUCKS TYPE 3100, 3200, 3500, 3600, 3700

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DIN 55027 & DIN 55029		BAYONET & CAMLOCK TYPES OF MOUNTING													
 DIN 55027	chuck size	100			125			160							
	short taper	3	3	4	3	4	5	6	3	4	5	6			
	B	type 3500, 3700	76			59.5			68						
		the others	80			70			81.5						
	B1	type 3500, 3700	-			64.8			72.8						
		the others	-			74.8			86.3						
	D	min	53.975	53.975	63.513	53.975	63.513	82.563	106.375	53.975	63.513	82.563	106.375		
		max	53.988	53.988	63.526	53.988	63.526	82.578	106.390	53.988	63.526	82.578	106.390		
	E	20	32			42									
	F	75	75	85	75	85	104.8	133.4	75	85	104.8	133.4			
	F ¹⁾	70.6	70.6	82.6	70.6	82.6	104.8	133.4	70.6	82.6	104.8	133.4			
	qty. of mounting studs	bayonet	3	3	3	3	3	4	4	3	3	4	4		
		camlock	3	3	3	3	3	6	6	3	3	6	6		
	weight approx. kg	3.0	5.0			9.0									
	 DIN 55029	chuck size	200				250			315					
short taper		3	4	5	6	5	6	8	6	8	11				
B		type 3500, 3700	78				89			96.2		111.7			
		the others	91				103.5			117.7		125	140 ¹⁾		
B1		type 3500, 3700	82.8				92.8			101.3		116.8			
		the others	95.8				107.3			122.8		130	145 ¹⁾		
D		min	53.975	63.513	82.563	106.375	82.563	106.375	139.719	106.375	139.719	196.869			
		max	53.988	63.526	82.578	106.390	82.578	106.390	139.734	106.390	139.734	196.887			
E		51.5	55			76			103						
F		75	85	104.8	133.4	104.8	133.4	171.4	133.4	171.4	235				
F ¹⁾		70.6	82.6	104.8	133.4	104.8	133.4	171.4	133.4	171.4	235				
qty. of mounting studs		bayonet	3	3	4	4	4	4	4	4	4	4	6		
		camlock	3	3	6	6	6	6	6	6	6	6	6		
weight approx. kg		19.0				32.0			51.0						
 DIN 55029		chuck size	400			500		630							
	short taper	6	8	11	8	11	8	11	15						
	B	type 3500, 3700	108			119		129							
		the others	128.5			146		165							
	B1	type 3500, 3700	116.8			129.8		140.3							
		the others	137.3			156.8		176.3							
	D	min	106.375	139.719	196.869	139.719	196.869	139.719	196.869	285.775					
		max	106.390	139.734	196.887	139.734	196.887	139.734	196.887	285.795					
	E	103	136		136	190	136	190	252						
	F	133.4	171.4	235	171.4	235	-	235	330.2						
	F ¹⁾	133.4	171.4	235	171.4	235	171.4	235	330.2						
	qty. of mounting studs	bayonet	4	4	6	4	6	-	6	6					
		camlock	6	6	6	6	6	6	6	6					
	weight approx. kg	101.0			150.0		274.0								

¹⁾ for form Camlock

All other dimensions should be taken from the table about chucks with plain back mounting

THREADED MOUNTING OF CHUCKS - TYPE 3284	
chuck size A	100
M	M24
B	70
B1	-
C	14
D	24
E	20
weight approx. kg	3.6

All other dimensions should be taken from the table about chucks with plain back mounting

MAIN DIMENSIONS OF HARD SOLID JAWS AND SOFT SOLID JAWS FOR CHUCKS TYPE 3200, 3500, 3600, 3700, 3864



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Hard solid inside and outside jaws		chuck size	80	85	100	110	125	140	160
A			32	43	42	42	51	51	70
B			11	11	15	15	20	20	20
C			28	28	32	32	40	40	53
D			6	6	6	6	8	8	8
E			6	6	6	6	8	8	8
F			6	6	7	7	8	8	10
G			9.5	10	11	11	13	13	19
H			21	26	27	27	33.5	33.5	45
J			9.5	12	12	12	13	13	22
K			21	26	27.5	27.5	33.5	33.5	47.5
weight approx. kg	hard jaws		0.03	0.07	0.09	0.09	0.18	0.18	0.36
	soft jaws		0.07	-	0.13	0.13	0.26	0.26	0.50

Soft solid jaws		chuck size	200	250	315	400	500	630	800
A			85	105	125	145	180	225	225
B			25	28	32	36	40	50	50
C			54	63	73	92	100	110	110
D			9	11	12.7	15	16	16	16
E			10	12	12	14	14	14	14
F			12	14	18	22	26	28	28
G			23	28	34.5	36	50	66	66
H			57	69.5	83	99	119.5	149	149
J			23	28	34.5	36	50	66	66
K			57	69.5	83	99	119.5	149	149
weight approx. kg	hard jaws		0.50	0.80	1.32	2.35	3.36	5.80	5.80
	soft jaws		0.80	1.36	1.90	2.46	5.00	8.36	8.36

Dimensions G and H apply to outside jaws
Dimensions J and K apply to inside jaws

MOUNTING DIMENSIONS OF HARD MASTER JAWS FOR CHUCKS TYPE 3100, 3200, 3500, 3600, 3700, 3865

Hard master jaws		chuck size	125	140	160	200	250	
A			54	54	65	79	92	
B			20	20	20	25	28	
C			28	28	29	33	36	
D			8	8	8	9	11	
E			8	8	8	10	12	
F - 0.03			7.94	7.94	7.94	7.94	12.7	
G + 0.01			12.69	12.69	12.69	12.69	19.04	
H			22.6	22.6	28.6	34.9	39.7	
J			4	4	4	4	4	
K			16	16	19.05	22.25	27	
L			13.5	13.5	14	14	16	
M			M8	M6*	M8	M10	M8*	M12
S			3.2	3.2	3.2	3.2	3.2	
weight approx. kg			0.14	0.14	0.18	0.30	0.48	

Hard master jaws		chuck size	315	400	500	630	800
A			110	130	166	210	225
B			32	36	40	50	50
C			40	49	54	54.5	54.5
D			12.7	15	16	16	16
E			12	14	14	14	14
F - 0.03			12.7	12.7	12.7	12.7	12.7
G + 0.01			19.4	19.04	19.04	19.04	19.04
H			47.6	57.1	57.1	57.1	57.1
J			4	7.2	7.2	7.2	7.2
K			31.75	38.1	38.1	38.1	38.1
L			16	22	32.5	32.5	32.5
M			M12	M16	M20	M20	M20
S			3.2	3.2	3.2	3.2	3.2
weight approx. kg			0.77	1.10	2.18	3.34	3.4

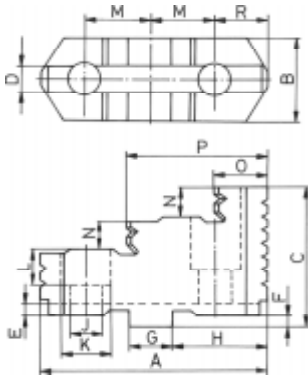
* for 3865



MOUNTING DIMENSIONS OF TOP JAWS FOR CHUCKS TYPE 3100, 3200, 3500, 3600, 3700, 3865

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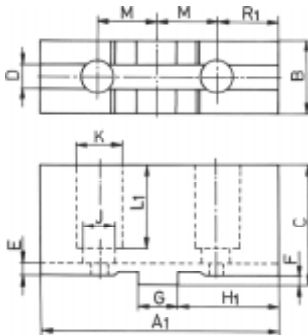
Hard reversible top jaws



chuck size		125	140	160	200		250
A		56	56	67	80		95
A1		64	64	78	90		106
B		22	22	25	27		32.5
B for 3100		-	-	40	40		47
C		38.5	38.5	41.5	41.5*	43.5	51.5
D		7.95	7.95	7.95	7.95		12.71
E		4	4	4	4		4
F		3.2	3.2	3.2	3.2		3.2
G		12.69	12.69	12.69	12.69		19.04
H		22.6	22.6	28.6	34.9		39.7
H1		25	25	34	40		45
J		9	6,6**	9	11	9**	14
K		15	11**	15	18	14**	20
L		10	10	12	12		14.5
L1		26	26	29	31		38
M		16	16	19.05	22.25		27
N		8	8	8.5	9.5		12
O		14.5	14.5	18	21.5		24.5
P		35	35	41.5	51		59
R		13	13	16	19		22
R1		15	15	21	24		27.5
weight approx. kg	hard jaws	0.17	0.17	0.26	0.36		0.62
	soft jaws	0.30	0.30	0.46	0.65		1.15

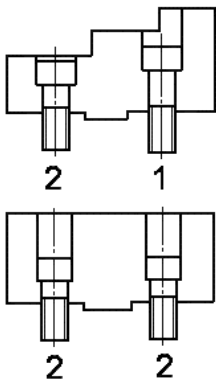
* for 3100 ** for 3865

Soft top jaws



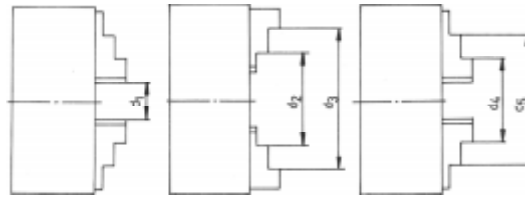
chuck size		315	400	500	630	800
A		110	127	127	127	127
A1		120	140	140	160	160
B		37	42	42	52	52
B for 3100		52	52	-	-	-
C		55	64.5	74.5	82	82
D		12.71	12.71	12.71	12.71	12.71
E		4	4	4	4	4
F		3.2	6.3	6.3	6.3	6.3
G		19.04	19.04	19.04	19.04	19.04
H		47.6	57.1	57.1	57.1	57.1
H1		53	63	63	63	63
J		14	18	22	22	22
K		20	26	33	33	33
L		14.5	18.5	21	21	21
L1		40	45.5	56	64	64
M		31.75	38.1	38.1	38.1	38.1
N		13	13.5	17	21	21
O		26.5	27	50	51	51
P		68	76.5	88	89	89
R		35.4	28.5	28.5	28.5	28.5
R1		30.7	34.4	34.4	34.4	34.4
weight approx. kg	hard jaws	0.90	1.35	1.55	2.42	2.42
	soft jaws	1.60	2.20	2.40	4.20	4.20

MOUNTING BOLTS FOR TOP JAWS



chuck size	bolt 1		bolt 2	
mm				
125	M8x25	M6x30*	M8x20	M6x20*
140	M8x25	-	M8x20	-
160	M10x30	M8x30*	M10x20	M8x20*
200	M10x30	M8x30*	M10x20	M8x20*
250	M12x40		M12x25	
315	M12x40		M12x25	
400	M16x45		M16x30	
500	M20x75		M20x40	
630	M20x80		M20x40	
800	M20x80		M20x40	

* for 3865



GRIPPING RANGES FOR CHUCKS TYPE 3200, 3500, 3600, 3700

chuck size		80	85	100	110	125	140	160
Solid jaws	d1	2-27	2-40	3-33	3-33	3-50	3-50	3-64
	d2	25-50	32-70	32-62	32-62	39-83	39-83	50-107
	d3	48-71	64-102	62-83	62-83	80-125	80-125	98-160
	d4	22-46	22-60	25-56	25-56	34-74	34-74	42-100
	d5	45-69	54-92	56-87	56-87	72-115	72-115	94-154
Reversible top jaws	d1	-	-	-	-	3-50	-	3-64
	d2	-	-	-	-	52-96	-	62-121
	d3	-	-	-	-	95-125	-	115-160
	d4	-	-	-	-	34-76	-	42-97
	d5	-	-	-	-	75-118	-	88-146
max swing dia		90	121	117	117	151	151	204

chuck size		200	250	315	400	500	630	800
Solid jaws	d1	4-90	5-118	10-131	10-180	20-235	30-335	150-482
	d2	60-145	77-188	90-215	103-272	140-357	180-487	302-634
	d3	130-200	160-250	190-315	230-400	276-500	345-630	468-800
	d4	52-135	62-174	78-200	85-252	120-335	160-465	282-614
	d5	120-202	145-256	172-299	210-380	245-476	325-630	448-780
Reversible top jaws	d1	4-90	5-118	10-131	10-180	20-235	30-335	150-482
	d2	72-156	86-197	103-226	127-294	110-400	120-570	240-724
	d3	133-200	160-250	190-315	230-400	190-500	200-630	316-800
	d4	50-130	58-165	65-182	72-228	120-410	140-590	252-736
	d5	105-190	125-235	145-265	165-329	200-485	210-665	328-812
max swing dia		246	306	384	472	600	770	940

GRIPPING RANGE FOR CHUCKS TYPE 3864, 3865

chuck size		125	160	200	250	315	400	500	630
Solid jaws	d1	6-43	8-64	8-90	12-118	12-131	15-202	30-235	40-335
	d2	42-78	52-107	64-145	82-188	95-215	140-308	152-361	192-487
	d3	83-120	102-160	132-200	165-250	192-315	232-400	291-500	358-630
	d4	34-68	47-100	55-135	68-174	82-200	95-280	132-335	175-467
	d5	74-110	98-154	121-202	150-256	178-299	213-400	270-474	340-630
Reversible top jaws	d1	6-43	8-64	8-90	12-118	12-131	15-202	30-235	40-335
	d2	50-87	67-121	74-156	82-188	108-226	132-296	121-402	132-555
	d3	94-125	118-160	134-200	164-250	153-315	236-400	197-478	210-630
	d4	33-70	45-97	52-130	68-174	68-182	73-252	135-413	150-585
	d5	76-119	92-146	109-190	150-256	150-265	169-352	210-489	220-661
max swing dia		151	204	246	306	384	472	600	770

Do not exceed maximum chucking ranges.

MAXIMUM PERMISSIBLE SPEEDS (rpm)

chuck size	80, 85	100, 110	125	140, 160	200	250	315	400	500	630	800
3100*, 3200, 3600	4000	3500	3200	3000	2500	2000	1500	1000	700	500	300
3500, 3700	6000	5200	4800	4500	4000	3500	2800	2000	1200	1000	
3564, 3565		4200	3800	3500	3100	2700	2200	1800	1200	1000	
3864, 3865			3000	2500	2200	1900	1500	1300	800	700	
4505					2500	2000	1500	1000	500	350	
4605					2000	1800	1500	1000	500	350	
4705					3000	2500	2000	1500	1000	750	
4805					2500	2000	1700	1500	1000	750	

* valid for symmetrical gripping of the workpiece

The maximum permissible speed has been fixed so that 1/3 of the gripping force is still available as residual gripping force if the maximum gripping force is applied and the chuck is fitted with its heaviest jaws. The jaws may not project beyond the outside diameter of the chuck. The chuck must be in a perfect condition. The speed limit for chucks with cast iron bodies is based on the permissible peripheral speed for cast iron.



TOTAL GRIPPING FORCE FOR CHUCKS TYPE 3100, 3200, 3500, 3600, 3700, 3800

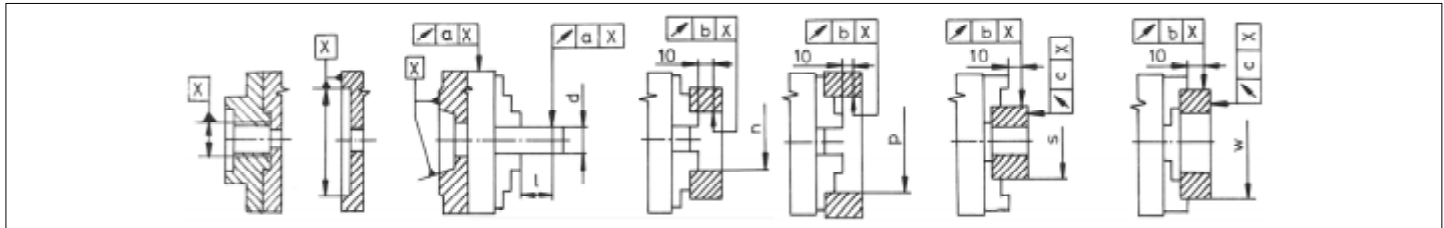
chuck size	80, 85	100, 110	125, 140	160	200	250	315	400	500	630	800
torque on wrench (Nm)	35	50	75	120	160	180	200	280	360	460	500
total gripping force (daN)	1000	1700	2400	3100 2400*	3700 2900*	4600 3600*	5500 4400*	6500 4900*	7200	8000	9000

* for 3100
The total gripping force is the sum of all jaw forces acting radially on the stationary workpiece. The specified gripping forces are approximate values. They apply to chucks in a perfect condition which have been lubricated with greases recommended in operating instructions.

VALUE OF BALANCING FOR SELF-CENTERING CHUCKS TYPE 3500, 3700

chuck size	80	100	125	160	200	250	315	400	500	630
gcm	11	16	23	32	45	63	90	140	300	640

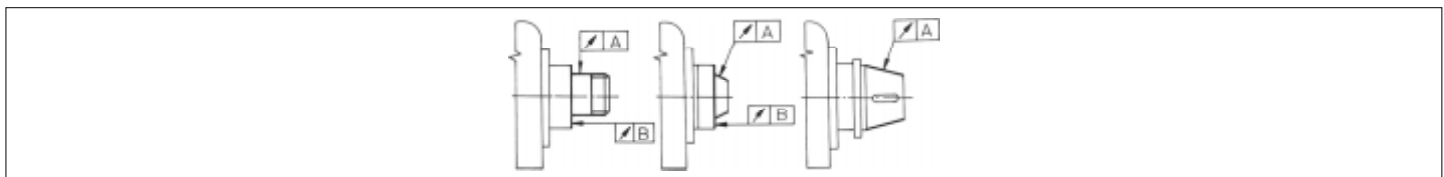
CENTERING ACCURACY FOR CHUCKS TYPE 3200, 3500, 3600, 3700



chuck size	mm	80, 85	100, 110	125, 140	160	200	250	315	400	500	630	800
	inch	3 1/4	4	5	6 1/4	8	10	12 1/2	15 3/4	20	25	31 1/2
d	10	10	18	18	30	30	53	53	75	75	160	
	-	14	25	30	40	53	75	100	100	125	200	
	14	18	30	40	53	75	100	125	125	160	250	
l	40	40	60	60	80	80	120	120	160	160	160	
n	40	40	50	50	80	80	125	125	200	200	325	
p	60	75	100	135	162	200	252	282	282	325	500	
s	35	50	62	88	96	150	210	250	300	400	400	
w	solid jaws	63	80	100	100	160	160	250	250	400	400	500
	two-piece jaws	-	-	120	150	185	225	300	350	400	400	500

centering accuracy (mm)

3500 class I	a	0.010	0.015	0.020	0.025	0.030	0.050	0.070	
	b	0.013	0.018	0.023	0.028	0.033	0.055	0.075	
	c	0.008	0.010	0.013	0.015	0.015	0.030	0.050	
3500 3700 3800	a	0.020	0.030	0.040	0.050	0.060			
	b	0.025	0.035	0.045	0.055	0.065			
	c	0.015	0.020	0.025	0.030	0.030			
3200 3600	a	0.020	0.030	0.040	0.050	0.060	0.10	0.10	0.15
	b	0.025	0.035	0.045	0.055	0.065	0.10	0.10	0.15
	c	0.015	0.020	0.025	0.030	0.030	0.05	0.05	0.06
3284 3285	a		0.05		0.08				
	b		0.075		0.075				
	c		0.04		0.07				



SPINDLE NOSE CENTERING ACCURACY

3500	A, B	φ 80-400	φ 500-630	To obtain the specified centering accuracy of a chuck mounted on a machine tool it is necessary: * to ensure the machine spindle nose runout not to exceed the values specified, * to meet the basic requirements for correct mounting of chuck on the spindle nose, according to the chuck installation instructions.
		0.003 mm	0.005 mm	
3200, 3600, 3700	A, B	φ 80-160	φ 200-800	
		0.003 mm	0.005 mm	

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Mostly suitable for the machining of parts with top concentricity.
It is for universal use, however particularly advantageous for grinding machines, indexing heads and lathes :

- * adjusting accuracy within **0,005 mm**
- * repeatability **0,015 mm**

Standard accessories :

- Chucks with hard solid jaws :
- * 1 set of inside solid jaws
 - * 1 set of outside solid jaws
 - * 1 wrench
 - * 1 hexagonal key
 - * 1 set of mounting screws

- Chucks with hard reversible top jaws :
- * 1 set of hard reversible top jaws
 - * 1 wrench
 - * 1 hexagonal key
 - * 1 set of mounting screws

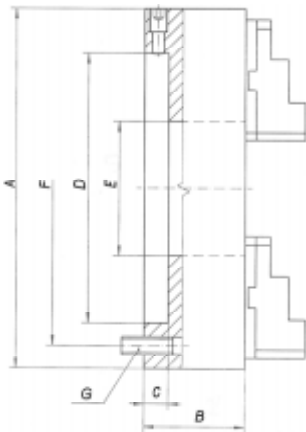
Optional accessories :

- Chucks with hard solid jaws :
- * 1 set of hard master jaws
 - * 1 set of hard top jaws

- Chucks with hard reversible top jaws :
- * 1 set of hard inside solid jaws
 - * 1 set of hard outside solid jaws

The clamped workpiece is adjusted to the required concentricity by means of 4 (8 for size 400, 500, 630) radially arranged adjusting screws.

Chucks 3564, 3565-500, 630 with T-slots
Chuck and jaw weight in dimension tables
Spare parts see page 26
Engineering data see page 18, 19
Adapters see page 42



chuck size	3-jaws hard solid jaws chuck		3-jaws hard reversible top jaws chuck		6-jaws hard solid jaws chuck		6-jaws hard reversible top jaws chuck	
	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU
	0642 535 ...	29 407 250 ...	0642 535 ...	29 407 250 ...	0642 538 ...	29 407 250 ...	0642 538 ...	29 407 250 ...
mm	type 3564		type 3565		type 3864		type 3865	
100	640 200	343 564 030	-	-	-	-	-	-
125	640 302	343 564 080	650 300	343 565 080	640 301	373 864 220	650 300	373 865 220
160	640 404	343 564 180	650 402	343 565 180	640 403	373 864 350	650 401	373 865 350
200	640 506	343 564 320	650 504	343 565 320	640 505	373 864 460	650 503	373 865 460
250	640 608	343 564 470	650 606	343 565 470	640 607	373 864 550	650 605	373 865 550
315	640 700	343 564 600	650 708	343 565 600	640 709	373 864 630	650 707	373 865 630
400	640 801	343 564 740	650 800	343 565 740	640 800	373 864 730	650 809	373 865 730
500	640 903	343 564 870	650 901	343 565 870	640 902	373 864 810	650 900	373 865 810
630	641 008	343 564 920	651 006	343 565 920	641 007	373 864 890	651 005	373 865 890
chuck size A	B	C	D	E	F	G	weight approx. kg	
	mm						3-jaw	6-jaw
100	68	13	45	20	83	3xM8	3.3	4.5
125	71.5	15	55	35	108	3xM8	5.0	6.2
160	68	18	86	42	140	3xM10	9.1	10.5
200	78	20	110	55	176	3xM10	15.5	17.5
250	89	20	145	76	224	3xM12	26.2	33.0
315	96.2	20	180	103	286	3xM16	46.5	56.0
400	123	22	299, 237	136	171.5	6xM16	90.0	99.0
500	144	30	407.16	190	235	6xM20x120	171	180
630	150	30	407.16	252	330.2	6xM20x130	302	326

Example of order: 3864-160 or 0642 538 640 403



**Mostly suitable for the production of parts with top concentricity.
It is for universal use, however particularly advantageous for grinding machines,
indexing heads and lathes :**

- * adjusting accuracy within **0,005 mm**
- * repeatability **0,015 mm**
- * hardened adjusting spindles
- * steel adapter plate



Standard accessories :

- Chucks with hard solid jaws :
- * 1 set of inside solid jaws
 - * 1 set of outside solid jaws
 - * 1 wrench
 - * 1 hexagonal key
 - * 1 set of mounting screws

- Chucks with hard reversible top jaws :
- * 1 set of hard reversible top jaws
 - * 1 wrench
 - * 1 hexagonal key
 - * 1 set of mounting screws

Optional accessories :

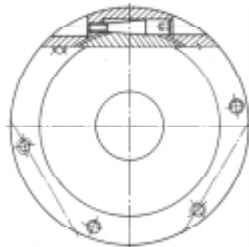
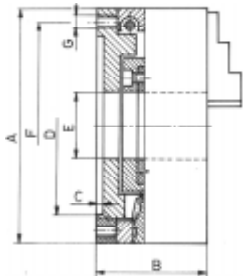
- Chucks with hard solid jaws :
- * 1 set of hard master jaws
 - * 1 set of hard top jaws

- Chucks with hard reversible top jaws :
- * 1 set of hard inside solid jaws
 - * 1 set of hard outside solid jaws

The clamped workpiece is adjusted to the required concentricity by means of 3 tangentially arranged adjusting spindles.

Jaw weight in dimension tables
Spare parts see page 26
Engineering data see page 18, 19

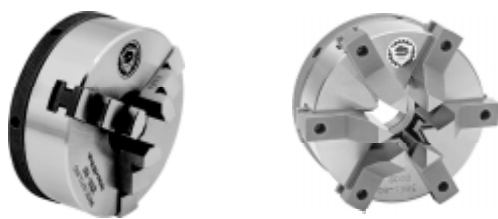
	chuck size	3-jaws hard solid jaws chuck			3-jaws hard reversible top jaws chuck		
		code No 0642 532 ...	PKWiU 29 407 250 ...	weight approx. kg	code No 0642 532 ...	PKWiU 29 407 250 ...	weight approx. kg
DIN 6350	mm	type 3264			type 3265		
	80	640 023	323 264 010	2,8	-	-	-
	100	640 008	323 264 040	3,5	-	-	-
	125	640 100	323 264 090	5,6	650 108	323 265 090	6,0
	160	640 201	323 264 180	10,0	650 200	323 265 180	10,5
	200	640 303	323 264 310	17,2	650 301	323 265 310	18,0
	250	640 405	323 264 440	34,5	650 403	323 265 440	36,0
	315	640 507	323 264 590	57,5	650 505	323 265 590	59,0
	chuck size A	B	C min	D	E min	F	G
	mm						
	80	59	3	56	16	67	3xM6
	100	69	4	70	20	83	3xM8
	125	70	5	95	32	108	3xM8
	160	80,5	5	125	42	140	3xM10
	200	91	5	160	55	176	3xM10
	250	103	6	200	76	224	3xM12
	315	120	6	260	103	286	3xM16
Example of order: 3264-160 or 0642 532 640 201							



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Lever scroll chuck is specially designed for grinding twist drills and other cutting tools.
 Type 3266 and 3866 with fine adjustment,
 type 3868 with additional tool support.

- Standard accessories:**
- * 1 set of hard solid jaws
 - * 1 operating lever
 - * 1 set of mounting screws

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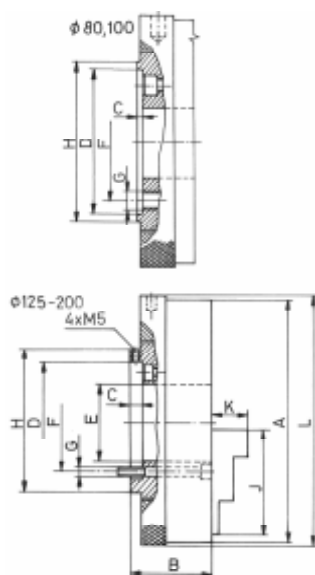
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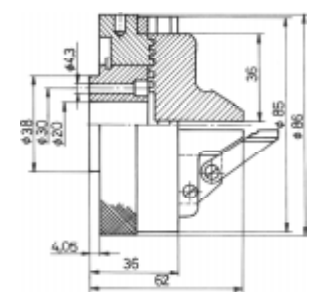
3 - JAWS

Spare parts see page 26.

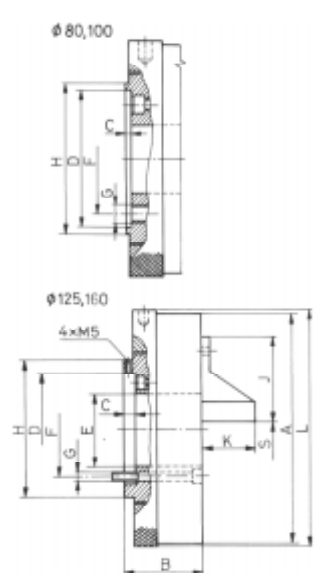


chuck size		code No 0642 532 ...		PKWiU 29 407 250 ...			
mm		type 3266					
80		660 106		323 260 010			
100		660 208		323 260 040			
125		660 300		323 260 090			
160		660 401		323 260 180			
200		660 503		323 260 310			
A	B	C	D	E	F	G	
80	35	1.5	48	24	39	3xM6	
100	40	2	75	32	62	3xM8	
125	48	8	70	38	56	3xM6	
160	52	8	78.5	52	65	3xM6	
200	66	13	115	64	84	3xM8	
A	H	J	K	L	clamping pin	weight approx. kg	
80	52	35	13	82	6x100	1.1	
100	85	42	17	102	6x125	3.2	
125	83	51	20	129	8x160	4.0	
160	96	70	33	164	8x200	7.3	
200	147	85	30	205	8x200	13.3	

6 - JAWS



chuck size	code No 0642 538 ...	PKWiU 29 407 250 ...	clamping pin	weight approx. kg
mm	type 3868			
85	680 202	373 868 020	6 x 100	2,5



chuck size		code No 0642 538 ...		PKWiU 29 407 250 ...			
mm		type 3866					
80		660 206		373 866 020			
100		660 308		373 866 110			
125		660 400		373 866 220			
160		660 501		373 866 350			
A	B	C	D	E	F	G	
80	35	1.5	48	24	39	3xM6	
100	40	2	75	32	62	3xM8	
125	48	8	70	38	56	3xM6	
160	52	8	78.5	52	65	3xM6	
A	H	J	K	L	S	clamping pin	weight ap. kg
80	52	35	22	82	1-23	6x100	2.0
100	85	42	25	102	1.5-31	6x125	2.8
125	83	50	36	128	2-37	8x160	4.0
160	96	58	36	164	3-51	8x200	7.0

Example of order: 3866-80 or 0642 538 660 206



Wrench operated scroll chuck is specially designed for grinding twist drills and other cutting tools. Plain back (front mounting). Metric and imperial execution of screws is available.

Standard accessories:

- * 1 set of hard solid jaws
- * 1 wrench
- * 1 set of mounting screws

6 - JAWS

	chuck size	code No 0642 538 ...	PKWiU 29 407 250 ...	A	B	C	D	
	mm	type 3867						
	85	670 204	373 867 020	85	44	3.9	62	
	110	670 408	373 867 200	110	50	4	86	
160	670 601	373 867 350	160	79	4	125		
chuck size mm	E	F	G	J	K	S	weight approx. kg	
85	25.5	70	3xM6	32	37	1-25	1.9	
110	32.1	95	3xM6	38	33	2.3-32	3.5	
160	51	140	3xM10	51	51	2.5-50	4.5	

SPARE PARTS - HARD OUTSIDE JAWS-SETS



chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
	for chuck type 3866		for chuck type 3868		for chuck type 3867	
	mm	6-jaw set				
80	411 106	443 866 001	-	-	-	-
85	-	-	412 107	443 868 001	411 605	443 867 001
100	411 208	443 866 050	-	-	-	-
110	-	-	-	-	411 707	443 867 130
125	411 300	443 866 150	-	-	-	-
160	411 401	443 866 290	-	-	411 809	443 867 290

5C COLLET CHUCKS

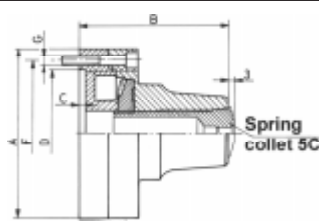


The type 3911 collet chuck designed for use with 5C collets can be used for turning, facing, boring, grinding and milling operations. The simple wrench operated scroll provides a uniform, distortion free clamping of workpieces and low collet exchange times. Type 3960 allows for fine adjustment to the required concentricity by means of 4 radially arranged adjusting screws.

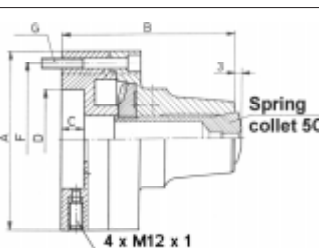
Standard accessories:

- * 1 wrench
- * 1 set of mounting screws

Collets on request



chuck size	code No 0642 539 ...	PKWiU 29 407 250 ...	A	B	C	D	F	G	weight approx.
mm	type 3911								kg
125	110 307	393 911 200	126	107.5	4	95	108	3xM8x45	4.5



chuck size	code No 0642 539 ...	PKWiU 29 407 250 ...	A	B	C	D	F	G	weight approx.
mm	type 3960								kg
125	600 305	393 960 200	126	117	15	55	108	3xM8x55	5.4

Example of order: 3960-125-5C or 0642 539 600 305



Large diameter through-hole chucks are designed for pipe machining or pipe welding/cut off operations. Also they can be used on lathes, rotary tables, welding devices.

Standard accessories :

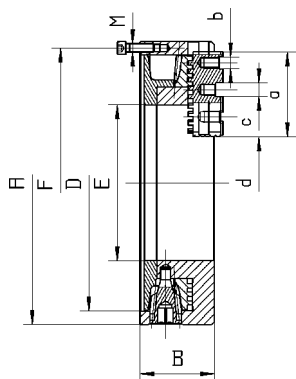
- * 1 set of master jaws
- * 1 wrench
- * 1 set of mounting screws

Optional accessories :

- * hard top jaws
- * soft top jaws

Jaw weight in dimension tables
Spare parts see page 26

3 - JAWS CHUCKS, CAST IRON BODY



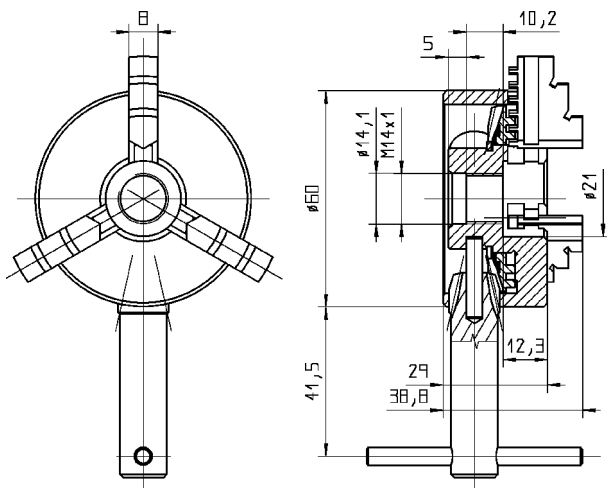
chuck size	code No 0642 532 ...	PKWiU 29 407 250 ...	weight approx. kg
mm	type 3295		
400	950 405	323 295 700	57,7
500	950 507	323 295 801	75,8
660	950 609	323 295 871	128,9
800	950 700	323 295 941	212,0

chuck size mm	A	B	D	E	F	M	a	b	c	d		Rpm max
										min	max	
400	400	105	362	220	381	M12x40	120	M16	19.04	168	288	500
500	508	120	462	320	481.5	M16x40	120	M20		250.8	380	350
660	660	135	580	406	620	M16x40	127			376	497	250
800	800	151	700	410	460	M24x160	225			188	566	200



Special compact design to achieve very small turned diameter. These chucks are suitable for lathes with threaded spindle.

3 - JAWS CHUKS, HARD REVERSIBLE JAWS, STEEL BODY



chuck size	mounting	code No 0642 532 ...	PKWiU 29 407 250 ...	weight approx. kg
type 3286				
60	M14x1	860 100	323 286 001	0.68

Example of order: 3286-60 or 0642 532 860 100

SPARE PARTS

	code No 0642 985 ...	PKWiU 29 407 231 ...
<p>Reversible jaws</p>	399 155	443 286 002
<p>Scroll plate</p>	399 170	443 286 003
<p>Wrench</p>	399 101	443 286 001

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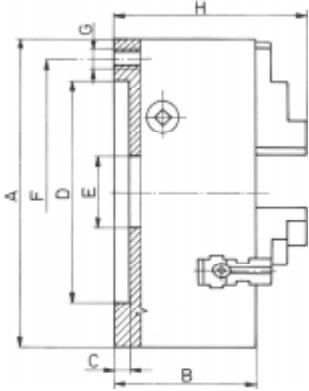


Particularly suitable for lining up and chucking workpieces of irregular shape.

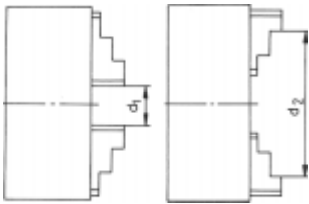
Standard accessories :

- * 1 set of hard solid jaws
- * 1 wrench
- * 1 set of mounting screws

Spare parts see page 26
Engineering data see page 18, 19

DIN 6351 	chuck size	3-jaw chucks				4-jaw chucks			
		cast iron body		steel body		cast iron body		steel body	
		code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 545 ...	29 407 250 ...	0642 547 ...	29 407 250 ...	0642 546 ...	29 407 250 ...	0642 548 ...	29 407 250 ...
mm		type 4505		type 4705		type 4605		type 4805	
200		050 200	434 505 510	055 208	434 705 510	050 207	444 605 510	055 204	444 805 510
250		050 302	434 505 590	055 300	434 705 590	050 309	444 605 590	055 306	444 805 590
315		050 404	434 505 670	055 401	434 705 670	050 400	444 605 670	055 408	444 805 670
400		050 506	434 505 800	055 503	434 705 800	050 502	444 605 800	055 500	444 805 800
500		050 608	434 505 850	055 605	434 705 850	050 604	444 605 850	055 601	444 805 850
630		050 700	434 505 900	055 707	434 705 900	050 706	444 605 900	055 703	444 805 900

Example of order: 4505-200 or 0642 545 050 200

	chuck size A	B	C	D H6	E	F	G	H	gripping ranges		weight approx. kg
									d1 min	d2 max	
									200	96	
250	102	6	200	76	224	6xM12	135	5	250	31	
315	117	6	260	103	286	6xM16	158.5	10	315	54.5	
400	123	6.3	330	136	362	6xM16	182	15	400	88	
500	145	8	420	190	458	6xM16	206	20	500	150	
630	160	10	545	252	586	6xM16	232	30	630	245	

MAIN DIMENSIONS OF HARD SOLID AND SOFT SOLID JAWS

chuck size	200	250	315	400	500	630
A	85	91	125	145	180	225
B	25	28	32	36	40	50
C	58	61	73	90	100	108
D	11	10	13.5	12	15	14
E	10	10	12	14	14	14
F	12	14	18	22	26	28
Tr left-hand	Tr 18 x 2	Tr 18 x 2	Tr 24 x 3	Tr 24 x 3	Tr 26 x 3	Tr 26 x 3
H1	25	26.5	27	35	49.7	65
H	56	60	76	98.2	119.3	148
weight approx. kg	0.55	0.76	1.60	1.80	3.85	4.50

Hard solid jaws

Soft solid jaws

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HARD OUTSIDE SOLID JAWS - SETS 1)									
chuck size		code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3864		for chuck type 3266	
mm	inch	3-jaw set		4-jaw set		6-jaw set		3-jaw set	
80	3 1/4	350 009	443 500 001	-	-	-	-	350 024	443 266 001
100	4	350 100	443 500 053	381 970*	443 704 051	-	-	350 126	443 266 050
110	4 1/4	352 306	443 204 133	389 704	443 604 130	-	-	-	-
125	5	350 202	443 204 151	390 205	443 600 152	400 209	443 860 150	350 228	443 266 150
140	5 1/2	352 601	443 204 273	389 806	443 604 270	-	-	-	-
160	6 1/4	350 304	443 204 292	390 307	443 600 292	400 300	443 860 290	350 304	443 266 292
200	8	350 406	443 204 413	390 409	443 600 412	400 402	443 860 410	350 406	443 266 413
250	10	350 508	443 204 515	390 500	443 600 512	400 504	443 860 510	-	-
315	12 1/2	350 600	443 204 611	390 602	443 600 612	400 606	443 860 610	-	-
400	15 3/4	350 701	443 204 712	390 704	443 600 712	400 708	443 860 710	-	-
500	20	350 803	443 204 765	390 806	443 600 762	400 800	443 800 760	-	-
630	25	350 905	443 204 811	390 819	443 600 812	349 009	443 834 810	-	-
800	31 1/2	352 000	443 200 853	-	-	-	-	-	-

* for 3700



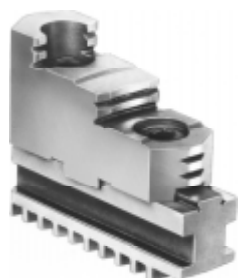
HARD INSIDE SOLID JAWS - SETS 1)									
chuck size		code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3864		for chuck type 3266	
mm	inch	3-jaw set		4-jaw set		6-jaw set		3-jaw set	
80	3 1/4	351 000	443 500 002	-	-	-	-	351 025	443 266 002
100	4	351 101	443 500 054	381 982*	443 704 052	-	-	351 127	443 266 051
110	4 1/4	352 408	443 204 134	391 909	443 604 131	-	-	-	-
125	5	351 203	443 204 152	391 206	443 600 153	401 200	443 860 151	351 229	443 266 151
140	5 1/2	352 703	443 204 274	392 003	443 604 271	-	-	-	-
160	6 1/4	351 305	443 204 293	391 308	443 600 293	401 301	443 860 291	351 305	443 500 293
200	8	351 407	443 204 414	391 400	443 600 413	401 403	443 860 411	351 407	443 500 414
250	10	351 509	443 204 516	391 501	443 600 513	401 505	443 860 511	-	-
315	12 1/2	351 600	443 204 612	391 603	443 600 613	401 607	443 860 611	-	-
400	15 3/4	351 702	443 204 713	391 705	443 600 713	401 709	443 860 711	-	-
500	20	351 804	443 204 766	391 807	443 600 763	401 800	443 800 761	-	-
630	25	351 906	443 204 814	391 810	443 600 813	351 975	443 834 811	-	-
800	31 1/2	352 102	443 200 854	-	-	-	-	-	-

* for 3700



SOFT SOLID JAWS - SETS							
chuck size		code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck typ 3864	
mm	inch	3-jaw set		4-jaw set		6-jaw set	
80	3 1/4	360 007	443 500 003	-	-	-	-
100	4	360 109	443 500 055	381 995*	443 704 053	-	-
110	4 1/4	352 500	443 204 135	398 009	443 604 132	-	-
125	5	360 200	443 204 160	398 202	443 600 160	402 200	443 800 152
140	5 1/2	352 805	443 204 275	397 904	443 604 272	-	-
160	6 1/4	360 302	443 204 302	398 304	443 604 300	402 302	443 800 292
200	8	360 404	443 204 422	398 406	443 604 420	402 404	443 800 412
250	10	360 506	443 204 525	398 508	443 604 520	402 506	443 800 512
315	12 1/2	360 608	443 204 620	398 600	443 604 620	402 608	443 800 612
400	15 3/4	360 700	443 204 721	398 701	443 604 720	402 700	443 800 712
500	20	360 801	443 200 773	398 803	443 604 770	402 801	443 800 762
630	25	360 903	443 200 821	398 905	443 604 820	402 903	443 800 810
800	31 1/2	360 929	443 200 861	-	-	-	-

* for 3700



HARD 2-PIECE REVERSIBLE JAWS - SETS 1)							
chuck size		code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3865	
mm		3-jaw set		4-jaw set		6-jaw set	
125		353 205	443 500 153	392 207	443 600 154	403 201	443 860 153
160		353 307	443 500 294	392 309	443 600 294	403 303	443 860 293
200		353 409	443 500 415	392 400	443 600 414	403 405	443 860 413
250		353 500	443 500 518	392 502	443 600 514	403 507	443 860 513
315		353 602	443 500 613	392 604	443 600 614	403 609	443 860 613
400		353 704	443 500 714	392 706	443 600 714	403 700	443 860 713
500		353 806	443 200 767	392 808	443 600 764	403 802	443 800 763
630		353 908	443 200 815	392 900	443 600 814	403 904	443 860 811
800		354 002	443 200 855	-	-	-	-

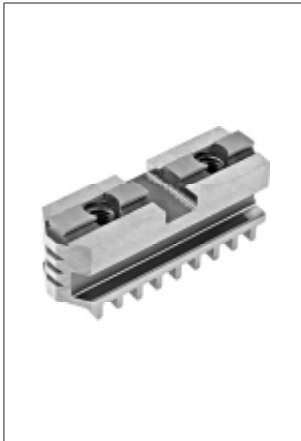


SPARE PARTS FOR SELF-CENTERING LATHE CHUCKS

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HARD TOP JAWS - SETS ¹⁾							
chuck size		code No	PKWiU	code No	PKWiU	code No	PKWiU
		0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3865	
mm	inch	3-jaw set		4-jaw set		6-jaw set	
125	5	328 205	443 500 150	378 206	443 600 150	408 206	443 860 159
160	6 1/4	328 307	443 500 290	378 308	443 600 290	408 308	443 860 299
200	8	328 409	443 500 410	378 400	443 600 410	408 400	443 860 419
250	10	328 500	443 500 510	378 501	443 600 510	408 501	443 860 518
315	12 1/2	328 602	443 500 610	378 603	443 600 610	408 603	443 860 619
400	15 3/4	328 704	443 500 710	378 705	443 600 710	408 705	443 860 719
500	20	328 806	443 200 760	378 807	443 600 760	408 807	443 800 768
630	25	328 908	443 200 810	378 909	443 600 810	408 909	443 800 815
800	31 1/2	328 908	443 200 810	-	-	-	-

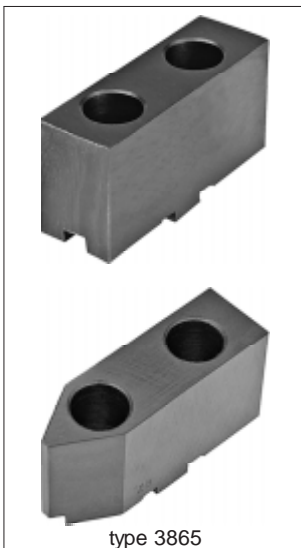


HARD MASTER JAWS - SETS ¹⁾											
chuck size	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU	
	0642 985	29 407 231	0642 985	29 407 231	0642 985	29 407 231	0642 985	29 407 231	0642 985	29 407 231	
		for chuck type 3100		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3865		for chuck type 3295	
mm	2-jaw set		3-jaw set		4-jaw set		6-jaw set		3-jaw set		
125	-	-	357 209	443 500 157	396 200	443 500 158	409 207	443 860 160	-	-	
160	307 106	443 105 293	357 300	443 500 299	396 302	443 600 298	409 309	443 860 300	-	-	
200	307 208	443 105 413	357 402	443 500 419	396 404	443 600 418	409 400	443 860 420	-	-	
250	307 300	443 105 513	357 504	443 500 522	396 506	443 600 518	409 502	443 860 519	-	-	
315	307 401	443 105 613	357 606	443 500 617	396 608	443 600 618	409 604	443 860 620	-	-	
400	307 900	443 105 713	357 708	443 500 718	396 700	443 600 718	409 706	443 860 720	399 860	443 295 713	
500	-	-	357 800	443 200 771	396 801	443 600 768	409 808	443 800 769	399 873	443 295 763	
630*	-	-	357 901	443 200 819	396 814	443 600 818	409 900	443 800 816	399 886	443 295 813	
800	-	-	358 006	443 200 859	-	-	-	-	-	-	

* for 3295 - 660



SOFT 2-PIECE JAWS - SETS									
chuck size	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU	
	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	
		for chuck type 3100		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3865	
mm	2-jaw set		3-jaw set		4-jaw set		6-jaw set		
125	-	-	355 207	443 500 155	394 209	443 600 156	405 216	443 800 150	
160	300 100	443 105 290	355 309	443 500 296	394 300	443 600 296	405 318	443 800 290	
200	300 201	443 105 410	355 400	443 500 417	394 402	443 600 416	405 410	443 800 410	
250	300 303	443 105 510	355 502	443 500 520	394 504	443 600 516	405 511	443 800 510	
315	300 405	443 105 610	355 604	443 500 615	394 606	443 600 616	405 613	443 800 610	
400	301 100	443 105 710	355 706	443 500 716	394 708	443 600 716	405 715	443 800 710	
500	-	-	355 808	443 200 769	394 800	443 600 766	405 804	443 800 765	
630	-	-	355 900	443 200 817	394 901	443 600 816	356 017	443 834 812	
800	-	-	356 004	443 200 857	-	-	-	-	



SOFT TOP JAWS - SETS										
chuck size	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU	code No	PKWiU
	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...	0642 985 ...	29 407 231 ...
		for chuck type 3100		for chuck type 3200, 3500		for chuck type 3600, 3700		for chuck type 3865		
mm	inch	2-jaw set		3-jaw set		4-jaw set		6-jaw set		
125	5	-	-	330 206	443 200 150	382 209	443 600 151	407 220	443 800 152	
160	6 1/4	305 308	443 105 292	330 308	443 200 290	382 300	443 600 291	407 322	443 800 293	
200	8	305 400	443 105 412	330 400	443 200 410	382 402	443 600 411	407 424	443 800 413	
250	10	305 501	443 105 512	330 501	443 200 510	382 504	443 600 511	407 526	443 800 513	
315	12 1/2	305 603	443 105 612	330 603	443 200 610	382 606	443 600 611	407 628	443 800 612	
400	15 3/4	305 705	443 105 712	330 705	443 200 710	382 708	443 600 711	407 720	443 800 712	
500	20	-	-	330 807	443 200 761	382 800	443 600 761	* 407 806	443 800 767	
630	25	-	-	330 909	443 200 812	382 901	443 600 811	* 407 908	443 800 814	
800	31 1/2	-	-	330 909	443 200 812	-	-	-	-	

* not bevelled

¹⁾ Hard jaws, supplied as supplement or as spares, must be ground on the chuck, otherwise centering accuracy does not conform the limmits. This job can be done in BISON plant at extra charge. In case of a subsequent jaw delivery please return the chuck.



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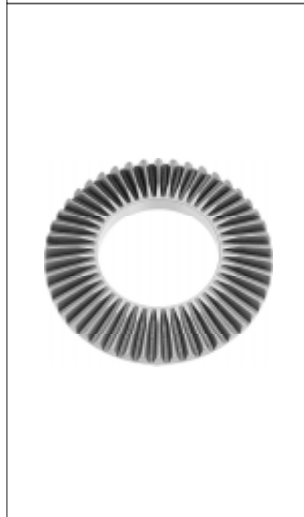


STUD BOLT							
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...
mm	inch	for chuck type 3100, 3200, 3500, 3600, 3700, 4500, 4600, 4700, 4800		mm	inch	for chuck type 3100, 3200, 3500, 3600, 3700, 4500, 4600, 4700, 4800	
80	3 1/4	335 109	443 200 002	315	12 1/2	335 404	443 200 412
100	4	335 109	443 200 002	400	15 3/4	335 700	443 200 712
125	5	335 200	443 200 152	500	20	335 700	443 200 712
160	6 1/4	335 200	443 200 152	630	25	335 700	443 200 712
200	8	335 404	443 200 412	800	31 1/2	335 700	443 200 712
250	10	335 404	443 200 412				



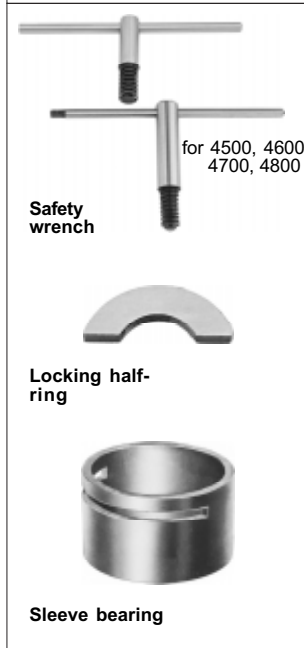
PINION							
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	inch	for chuck type 3100, 3200, 3600, 4500, 4600, 4700, 4800		for chuck type 3500, 3700, 3800		for chuck type 3295	
80	3 1/4	334 006	443 200 001	334 006	443 200 001	-	-
100	4	334 108	443 200 050	334 108	443 200 050	-	-
110	4 1/4	333 800	443 204 132	-	-	-	-
125	5	334 200	443 204 151	362 202	443 500 162	-	-
140	5 1/2	333 901	443 204 272	-	-	-	-
160	6 1/4	334 301	443 204 291	362 304	443 500 304	-	-
200	8	334 403	443 204 411	362 406	443 500 424	-	-
250	10	334 505	443 204 511	362 508	443 500 528	-	-
315	12 1/2	334 607	443 204 611	362 600	443 500 622	-	-
400	15 3/4	334 709	443 204 711	362 701	443 500 723	399 613	443 295 710
500	20	334 800	443 204 762	362 803	443 560 761	399 626	443 295 760
630*	25*	334 902	443 204 813	362 905	443 560 811	399 639	443 295 810
800	31 1/2	335 007	443 204 850	-	-	-	-

* for 3295 - 660 (26")



SCROLL PLATE							
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	inch	for chuck type 3100, 3200, 3600, 4500, 4600, 4700, 4800		for chuck type 3500, 3700, 3800		for chuck type 3295	
80	3 1/4	361 008	443 200 005	361 010	443 500 004	-	-
100	4	361 100	443 200 053	361 112	443 500 056	-	-
110	4 1/4	366 705	443 200 130	-	-	-	-
125	5	367 207	443 200 153	361 201	443 500 161	-	-
140	5 1/2	366 807	443 200 270	-	-	-	-
160	6 1/4	367 309	443 200 295	361 303	443 500 303	-	-
200	8	367 400	443 200 413	361 405	443 500 423	-	-
250	10	367 502	443 200 518	361 507	443 500 526	-	-
315	12 1/2	367 604	443 200 613	361 609	443 500 621	-	-
400	15 3/4	367 706	443 200 715	361 700	443 500 722	399 715	443 295 711
500	20	367 808	443 200 774	361 726	443 560 760	399 728	443 295 761
630*	25*	367 900	443 200 822	361 741	443 560 810	399 730	443 295 811
800	31 1/2	367 003	443 200 862	-	-	-	-

* for 3295 - 660 (26")



chuck size		SAFETY WRENCH				LOCKING HALF-RING		SLEEVE BEARING	
		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	inch	for chuck type 3100, 3200, 3500, 3600, 3700, 3800		for chuck type 4500, 4600, 4700, 4800		for chuck type 3500, 3700, 3800		for chuck type 3500, 3700, 3800	
80	3 1/4	340 102	443 200 003	-	-	-	-	-	-
85	3 3/8	340 102	443 200 003	-	-	-	-	-	-
100	4	340 204	443 200 051	-	-	-	-	-	-
110	4 1/4	340 204	443 200 051	-	-	-	-	-	-
125	5	340 204	443 200 051	-	-	363 203	443 500 163	364 204	443 500 164
140	5 1/2	340 306	443 200 292	-	-	-	-	-	-
160	6 1/4	340 306	443 200 292	-	-	363 305	443 500 305	364 306	443 500 306
200	8	340 306	443 200 292	754 001	443 505 414	363 407	443 500 425	364 408	443 500 426
250	10	340 408	443 200 513	754 014	443 505 514	363 509	443 500 529	364 500	443 500 530
315	12 1/2	340 408	443 200 513	754 103	443 505 614	363 600	443 500 623	364 601	443 500 624
400	15 3/4	340 500	443 200 713	754 205	443 505 714	363 702	443 500 724	364 703	443 500 725
500	20	340 601	443 200 763	754 307	443 505 764	363 804	443 560 762	364 805	443 560 763
630	25	340 601	443 200 763	754 307	443 505 764	363 906	443 560 812	364 907	443 560 813
800	31 1/2	340 703	443 200 851	-	-	-	-	-	-



SPARE PARTS FOR SELF-CENTERING LATHE CHUCKS

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ADJUSTING SPINDLE					
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...		
mm	inch	for chuck type 4500, 4600, 4700, 4800			
200	8	751 100	444 505 410		
250	10	751 202	444 505 510		
315	12 1/2	751 304	444 505 610		
400	15 3/4	755 104	444 505 710		
500	20	755 206	444 505 760		
630	25	755 308	444 505 810		

HARD MASTER JAW - SETS					
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
		for chuck type 4500, 4700		for chuck type 4600, 4800	
mm	inch	3-jaw set		4-jaw set	
200	8	752 305	444 505 413	753 408	444 605 412
250	10	752 407	444 505 513	753 500	444 605 512
315	12 1/2	752 509	444 505 613	753 601	444 605 612
400	15 3/4	756 502	444 505 713	758 107	444 605 712
500	20	756 604	444 505 763	758 209	444 605 762
630	25	756 706	444 505 813	758 300	444 605 812

HARD SOLID REVERSIBLE JAW - SETS					
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
		for chuck type 4500, 4700		for chuck type 4600, 4800	
mm	inch	3-jaw set		4-jaw set	
200	8	751 508	444 505 411	752 600	444 605 410
250	10	751 600	444 505 511	752 702	444 605 510
315	12 1/2	751 701	444 505 611	752 804	444 605 610
400	15 3/4	755 501	444 505 711	757 106	444 605 710
500	20	755 603	444 505 761	757 208	444 605 760
630	25	755 705	444 505 811	757 300	444 605 810

SOFT SOLID JAW - SETS					
chuck size		code No 0642 985 ...	PKWiU 29 407 231 ...	code No 0642 985 ...	PKWiU 29 407 231 ...
		for chuck type 4500, 4700		for chuck type 4600, 4800	
mm	inch	3-jaw set		4-jaw set	
200	8	751 905	444 505 412	753 000	444 605 411
250	10	752 000	444 505 512	753 102	444 605 511
315	12 1/2	752 101	444 505 612	753 204	444 605 611
400	15 3/4	756 105	444 505 712	757 503	444 605 711
500	20	756 207	444 505 762	757 605	444 605 761
630	25	756 309	444 505 812	757 707	444 605 811

Example of order: Hard top jaw 3200-315 or 0642 985 328 602

MOUNTING BOLTS FOR LATHE CHUCKS TYPES 3100, 3200, 3500, 3600, 4300 AND FOR ADPTERS PLATE TYPES 8200

STUD AND LOCKNUT - DIN 55027				
thread of stud	taper size	pcs/set	code No 0642 985 ... ¹⁾	PKWiU 29 407 231 ...
M10x34	3	3	821 103	443 200 154
M10x39	4	3	821 205	443 200 155
M10x43	5	4	821 307	443 200 297
M12x50	6	4	821 409	443 200 415
M16x60	8	4	821 500	443 200 520
M20x75	11	6	821 602	443 200 615
M24x90	15	6	821 704	443 200 823

STUD FOR CAMLOCK - DIN 55029				
thread of stud for camlock	taper size	pcs/set	code No 0642 985 ... ¹⁾	PKWiU 29 407 231 ...
M10x1-35	3	3	825 107	443 200 300
M10x1-37	4	3	825 209	443 200 301
M12x1-43	5	6	825 300	443 200 419
M16x1.5-49	6	6	825 402	443 200 523
M20x1.5-55.5	8	6	825 504	443 200 718
M22x1.5-67	11	6	825 606	443 200 719
M24x1.5-76	15	6	825 708	443 200 828
M27x2-89	20	6	825 800	443 200 864

¹⁾ for one piece

Example of order: Stud for DIN 55027 M12x50 or 0642 985 821 409



Jaw locking system, steel body, jaw guides hardened and ground¹⁾.
For turning work demanding high concentricity reliable repeatability with large gripping forces.

Standard accessories:
* 1 set of hard solid jaws
* 1 wrench
* 1 set of mounting screws

Optional accessories:
* 1 set of hard sectional jaws

Jaw weight in dimensions tables
Spare parts see page 33
Engineering data see page 32

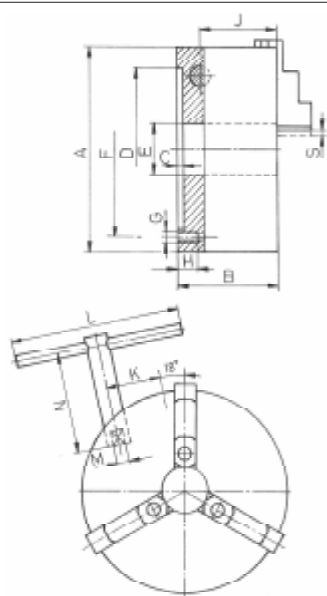
SELF-CENTERING 3-JAW WEDGE BAR CHUCKS, HARD SOLID JAWS

	chuck size	short taper	B	weight approx. kg	code No 0642 534	PKWiU 29 407 250		chuck size	short taper	B	weight approx. kg	code No 0642 534	PKWiU 29 407 250	
	mm	type 3404						DIN 55026	mm	type 3414				
	125	-	67	5,6	040 302	333 404 200		160	4	84,5	11	140 300	333 414 380	
	160	-	84	11,8	040 404	333 404 380		160	5	92	13	140 401	333 414 381	
	200	-	97	20	040 506	333 404 510		200	5	99	21	140 503	333 414 511	
	250	-	112	36	040 608	333 404 590		200	6	105	22	140 605	333 414 512	
	315	-	127	60	040 700	333 404 670		250	6	117	35,5	140 809	333 414 592	
								250	8	122	36,7	140 900	333 414 593	
								315	8	136	64	141 107	333 414 673	
								315	11	139	65,5	141 209	333 414 674	
DIN 55027	mm	type 3434						DIN 55029	mm	type 3444				
	125	3	70	5,9	340 100	333 434 200		125	3	70	5,9	440 108	333 444 200	
	125	4	74	6,3	340 202	333 434 201		125	4	74	6,3	440 200	333 444 201	
	160	4	84,5	11,4	340 304	333 434 381		160	4	84,5	11,4	440 301	333 444 381	
	160	5	92	13	340 406	333 434 382		160	5	92	13	440 403	333 444 382	
	200	5	99	21,4	340 508	333 434 512		200	5	99,5	21,4	440 505	333 444 512	
	200	6	105	22,8	340 600	333 434 513		200	6	105	22,8	440 607	333 444 513	
	250	6	117	35,5	340 803	333 434 593		250	6	126	39	440 800	333 444 593	
	250	8	122	36,7	340 905	333 434 594		250	8	129	40,3	440 902	333 444 594	
	315	8	136	64	341 101	333 434 674		315	8	142	66	441 109	333 444 674	
315	11	139	66,5	341 203	333 434 675	315	11	144	68	441 200	333 444 675			

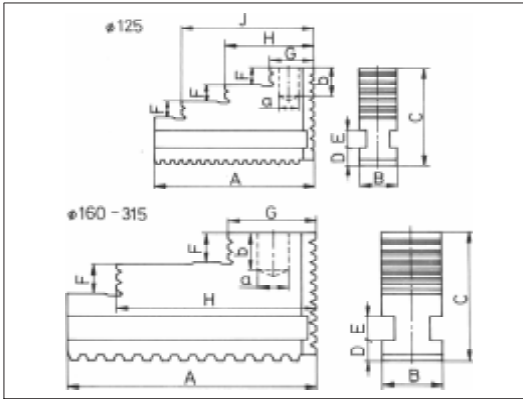
¹⁾ with size 125 jaw guides ground only

Example of order: 3444-315/11 or 0642 534 441 200

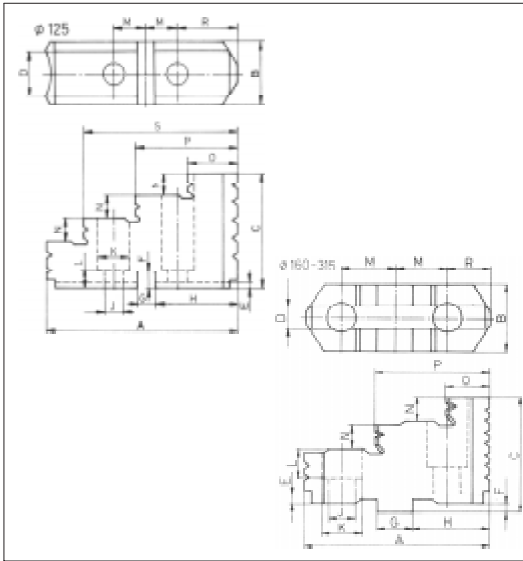
MAIN DIMENSIONS OF WEDGE BAR CHUCKS



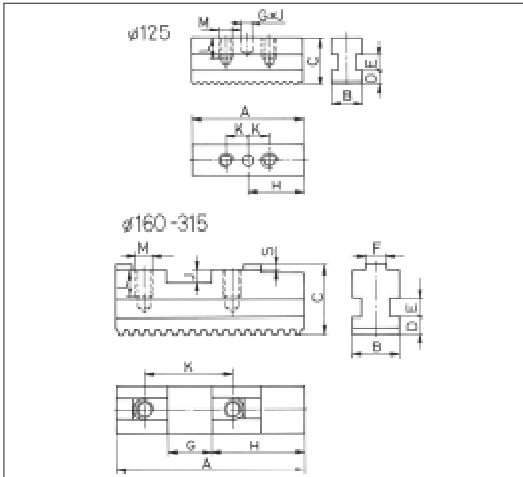
chuck size	125	160	200	250	315
A	130	165	205	252	315
B	67	84	97	112	127
C	4	5	5	6	6
D	95	125	160	200	260
E	30	40	51	66	90
F	108	140	176	224	286
G	3xM8	3xM10	3xM12	3xM16	3xM18
H	16	17	20	24	30
J	51,5	65	73,5	84,5	95,5
K	35,5	45,5	56,5	72	88
L	150	200	290	440	500
M	9	11	14	16	18
N	125	130	149	173	219
S	5,2	5,2	5,6	6,2	9,1



HARD SOLID REVERSIBLE JAWS					
chuck size	125	160	200	250	315
A	58	69	90	108.5	132
B	14	20	22	26	32
C	40	45	50	60	70
D	6.5	7.5	8	10	12
E	7	9	9	11	14
F	7	8	11.5	14	17
G	16	26	33	36	41.5
H	32	58	72.5	83	104.5
J	48	-	-	-	-
a	8	10	12	15	20
b	12	12	15	20	20
weight approx. kg	0.4	1.0	1.5	2.6	4.4

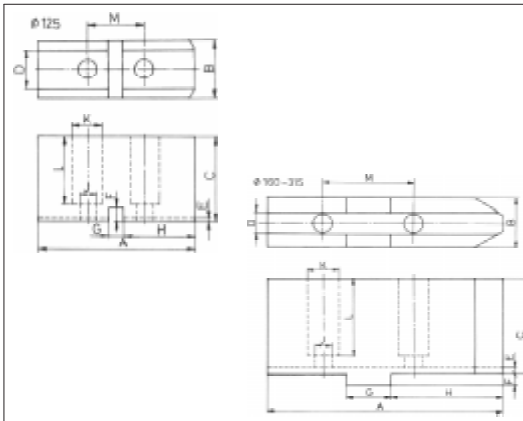


HARD TOP JAWS					
chuck size	125	160	200	250	315
A	59	63	72.5	91	105
B h11	20	20	22	30	35
C	36	37	43.5	55	60
D H9	14	8	10	12	12
E	1.5	3	3.5	3.5	6.5
F	5	4.5	5	5	5
G h7	5	18	20	20	26
H	26	23	27	30	35.3
J	6.4	8.4	8.4	13	13
K	10.4	13.5	13.5	19	19
L	6	8.5	9.5	26	23.5
M	10	16	20	20	27
N	7	7.5	9.5	14	15
O	16	27	33	40.5	40
P	31	40	58	81	95
R	18.5	16	17	20	21
S	47	-	-	-	-
weight approx. kg	0.18	0.25	0.35	0.50	0.80

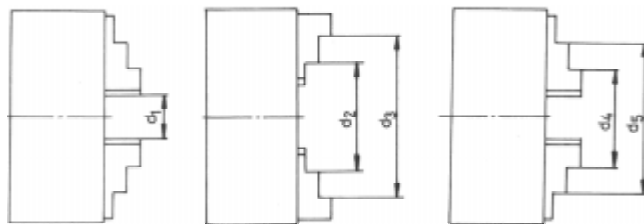


HARD MASTER JAWS					
chuck size	125	160	200	250	315
A	51.5	65	85	87.5	125
B	14	20	22	26	32
C	21.5	26.5	28.5	36	42
D	6.5	7.5	8	10	12
E	7	9	9	11	14
F	-	8	10	12	12
G H7 ¹⁾	5	18	20	20	26
H	25.75	28	42	41.5	69
J	7	5	5.5	5.5	7
K	10	32	40	40	54
L	10	12	12	17	17
M	M6	M8	M8	M12	M12
S	-	2.5	2.5	3	3
weight approx. kg	0.3	0.6	0.9	1.8	3.0

¹⁾ H7 without chuck size 125



SOFT TOP JAWS					
chuck size	125	160	200	250	315
A	55	85	105	125	145
B	20	20	22	30	35
C	30	40	50	55	60
D H9	14	8	10	12	12
E	1.5	4.5	5	5	6
F	5	3	3	3.5	3.5
G h7	5	18	20	20	26
H	25	35	40	60	60
J	6.4	8.4	8.4	13	13
K	10.4	13.5	13.5	19	19
L	24	26.5	35	41	38
M	20	32	40	40	54
weight approx. kg	0.6	1.2	2.1	4.2	6.2



GRIPPING RANGES

chuck size	125	160	200	250	315
d1	4-29	4-90	5-105	8-130	10-155
d2	38-63	61-150	70-170	81-170	95-189
d3	100-125	90-160	100-200	120-250	152-315
d4	28-53	34-120	49-149	66-188	74-200
d5	100-125	90-160	100-200	128-250	142-315
max. swing dia	151	212	264	322	393

MAXIMUM PERMISSIBLE ROTATIONAL SPEEDS (rpm)

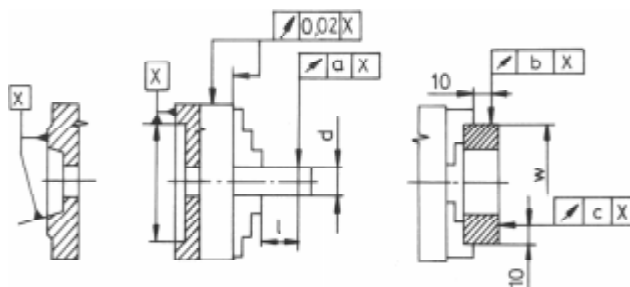
chuck size	125	160	200	250	315
max. rpm	4500	4000	3500	3000	2300

TOTAL GRIPPING FORCE

chuck size	125	160	200	250	315
torque on wrench (Nm)	40	100	160	200	250
total gripping force (daN)	3000	6000	8500	11000	13000

VALUE OF BALANCING

chuck size	125	160	200	250	315
gcm	16	32	63	125	250



CENTERING ACCURACY

chuck size	125	160	200	250	315
d	14	14	14	15	20
	20	20	22	32	64
	29	39	50	64	89
l	60	60	80	80	120
w	95	95	125	180	189
	125	160	200	245	290
centering accuracy (mm)					
a	0.015	0.015	0.015	0.015	0.020
b	0.010	0.010	0.010	0.010	0.010
c	0.015	0.015	0.015	0.015	0.020



HARD SOLID JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	309 108	443 404 150
160	309 200	443 404 290
200	309 301	443 404 410
250	309 403	443 404 510
315	309 505	443 404 610

HARD MASTER JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	309 709	443 405 150
160	309 800	443 405 290
200	309 902	443 405 410
250	310 006	443 405 510
315	310 108	443 405 610

SOFT TOP JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	310 301	443 405 151
160	310 403	443 405 291
200	310 505	443 405 411
250	310 607	443 405 511
315	310 709	443 405 611

HARD TOP JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	310 902	443 405 154
160	311 007	443 405 294
200	311 109	443 405 414
250	311 200	443 405 514
315	311 302	443 405 614

SOFT 2-PIECE JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	312 700	443 405 156
160	312 802	443 405 296
200	312 904	443 405 416
250	312 920	443 405 516
315	312 945	443 405 616

HARD 2-PIECE REVERSIBLE JAWS - set		
chuck size	code No	PKWiU
	0642 985	29 407 231
mm	3 pcs/set	
125	312 100	443 405 155
160	312 201	443 405 295
200	312 303	443 405 415
250	312 405	443 405 515
315	312 507	443 405 615



These chucks feature jaws that are individually adjustable, allow firm gripping of odd shaped work-pieces, and the four jaws allow a square component to be perfectly centered to the chuck while achieving maximum gripping force. The chuck bodies are made of cast iron or steel. The jaws are made of high quality carbon steel and hardened. Thrust bearings and operating screws are made of case hardened steel. From size 250, with T-slots.
Chucks with high accuracy with grounded grip surface of jaws can be made on special request.

Standard accessories :

- Chucks with one-piece reversible jaws:
 - * 1 set of solid reversible jaws
 - * 1 wrench
 - * 1 set of mounting screws
- Chucks with one-piece reversible jaws:
 - * 1 set of two-piece reversible jaws
 - * 1 wrench
 - * 1 set of mounting screws

Optional accessories :

- Chucks with one-piece reversible jaws:
 - * 1 set of two-piece reversible jaws
- Chucks with one-piece reversible jaws:
 - * 1 set of solid reversible jaws

Chuck and jaw weight in dimension tables
Spare parts see page 40
Engineering data see page 39

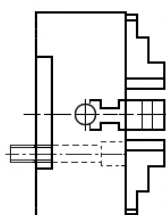


tel. +48 85 7416420

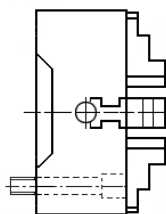
e-mail: bison-bial@bison-bial.pl

http://www.bison-bial.pl

chuck size	through hole	SOLID REVERSIBLE JAWS						TWO-PIECE REVERSIBLE JAWS			
		cast iron body		steel body		cast steel body		cast iron body		cast steel body	
		code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250
mm		type 4304		type 4304		type 4302		type 4305		type 4303	
85	25	-	-	040 006	424 304 010	-	-	-	-	-	-
100	25	-	-	040 108	424 304 020	-	-	-	-	-	-
125	26	-	-	040 200	424 304 040	-	-	-	-	-	-
160	42	-	-	040 403	424 304 070	-	-	-	-	-	-
200	50	040 505	424 304 091	-	-	020 407	424 302 090	050 503	424 305 091	030 405	424 303 090
250	65	040 607	424 304 191	-	-	020 509	424 302 190	050 605	424 305 191	030 507	424 303 190
315	80	040 709	424 304 291	-	-	020 600	424 302 290	050 707	424 305 291	030 609	424 303 290
350	80	006 304	424 304 390	-	-	-	-	-	-	-	-
400	100	040 800	424 304 411	-	-	020 702	424 302 410	050 809	424 305 411	030 700	424 303 410
500	125	040 902	424 304 511	-	-	020 804	424 302 510	050 900	424 305 511	030 802	424 303 510
630	160	041 007	424 304 611	-	-	020 906	424 302 610	051 005	424 305 611	030 904	424 303 610
800	200	041 109	424 304 691	-	-	021 000	424 302 690	051 107	424 305 691	031 009	424 303 690
915	190	-	-	-	-	-	-	051 402	424 305 791	031 100	424 303 790
1000	190	-	-	-	-	-	-	051 209	424 305 851	031 202	424 303 850
1250	190	-	-	-	-	-	-	051 300	424 305 931	031 304	424 303 930



chuck size	short taper	through hole	SOLID REVERSIBLE JAWS				TWO-PIECE REVERSIBLE JAWS			
			cast iron body		cast steel body		cast iron body		cast steel body	
			code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250
DIN 55026	mm	mm	type 4314		type 4312		type 4315		type 4313	
200	4	50	140 207	424 314 090	120 200	424 312 091	152 808	424 315 091	130 209	424 313 091
200	5	50	140 309	424 314 091	120 302	424 312 092	152 900	424 315 092	130 300	424 313 092
200	6	50	140 400	424 314 092	120 404	424 312 093	153 004	424 315 093	130 402	424 313 093
250	4	65	140 502	424 314 190	120 506	424 312 191	153 106	424 315 192	130 504	424 313 191
250	5	65	140 604	424 314 191	120 608	424 312 192	153 208	424 315 193	130 606	424 313 192
250	6	65	140 706	424 314 192	120 700	424 312 193	153 300	424 315 194	130 708	424 313 193
250	8	65	140 808	424 314 193	120 801	424 312 194	153 401	424 315 195	130 800	424 313 194
315	5	80	140 900	424 314 290	120 903	424 312 292	153 503	424 315 292	130 901	424 313 292
315	6	80	141 004	424 314 291	121 008	424 312 293	153 605	424 315 293	131 006	424 313 293
315	8	80	141 106	424 314 292	121 100	424 312 294	153 707	424 315 294	131 108	424 313 294
400	6	100	141 208	424 314 410	121 201	424 312 413	153 900	424 315 413	131 200	424 313 413
400	8	100	141 300	424 314 411	121 303	424 312 414	154 005	424 315 414	131 301	424 313 414
400	11	100	141 414	424 314 413	121 418	424 312 415	154 110	424 315 415	131 416	424 313 415
500	6	125	141 503	424 314 512	121 507	424 312 513	154 402	424 315 513	131 505	424 313 513
500	8	125	141 605	424 314 513	121 609	424 312 514	154 209	424 315 514	131 607	424 313 514
500	11	125	141 710	424 314 515	121 713	424 312 516	154 313	424 315 516	131 711	424 313 516
500	15	125	141 811	424 314 517	121 815	424 312 518	154 710	424 315 518	131 813	424 313 518
630	8	125	141 900	424 314 613	121 904	424 312 614	154 504	424 315 614	131 902	424 313 614
630	11	160	142 018	424 314 615	122 011	424 312 616	154 619	424 315 615	132 010	424 313 616
630	15	160	142 110	424 314 617	122 113	424 312 618	150 014	424 315 618	132 111	424 313 618
800	8	125	142 209	424 314 693	122 202	424 312 694	154 800	424 315 694	132 200	424 313 694
800	11	180	142 313	424 314 695	122 317	424 312 696	154 914	424 315 696	132 315	424 313 696
800	15	200	142 415	424 314 697	122 419	424 312 698	150 116	424 315 698	132 417	424 313 698
800	20	200	142 504	424 314 698	122 508	424 312 699	150 205	424 315 699	132 506	424 313 699
915	11	190	-	-	-	-	-	-	132 610	424 313 796
915	15	190	-	-	-	-	-	-	132 712	424 313 797
1000	11	190	-	-	-	-	159 114	424 315 856	132 842	424 313 856
1000	15	190	-	-	-	-	159 216	424 315 858	132 855	424 313 858
1000	20	190	-	-	-	-	-	-	132 827	424 313 859
1250	11	190	-	-	-	-	159 511	424 315 937	133 010	424 313 936
1250	15	190	-	-	-	-	159 613	424 315 939	133 100	424 313 938
1250	20	190	-	-	-	-	-	-	133 201	424 313 939





4-JAW INDEPENDENT CHUCKS

	chuck size	short taper	through hole	SOLID REVERSIBLE JAWS				TWO-PIECE REVERSIBLE JAWS			
				cast iron body		cast steel body		cast iron body		cast steel body	
				code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250	code No 0642 543	PKWiU 29 407 250
DIN 55027	mm		mm	type 4334		type 4332		type 4335		type 4333	
	200	4	50	340 507	424 334 095	-	-	352 802	424 335 091	-	-
	200	5	50	340 609	424 334 096	320 409	424 332 092	352 904	424 335 092	330 407	424 333 092
	200	6	50	340 700	424 334 097	320 500	424 332 093	353 009	424 335 093	330 509	424 333 093
	250	5	65	340 802	424 334 196	320 704	424 332 192	353 202	424 335 192	330 600	424 333 192
	250	6	65	340 904	424 334 197	320 806	424 332 193	353 304	424 335 193	330 704	424 333 193
	250	8	65	341 009	424 334 198	320 908	424 332 194	353 406	424 335 194	330 906	424 333 194
	315	5	80	341 100	424 334 296	321 104	424 332 292	353 508	424 335 292	330 908	424 333 292
	315	6	80	341 202	424 334 297	321 206	424 332 293	353 600	424 335 293	331 000	424 333 293
	315	8	80	341 304	424 334 298	321 308	424 332 294	353 701	424 335 294	331 102	424 333 294
	315	11	80	341 317	424 334 299	321 400	424 332 299	353 803	424 335 295	331 204	424 333 295
	400	5	100	342 804	424 334 416	322 105	424 332 412	353 829	424 335 412	331 703	424 333 412
	400	6	100	341 406	424 334 417	322 207	424 332 413	353 905	424 335 413	331 805	424 333 413
	400	8	100	341 508	424 334 418	322 309	424 332 414	354 000	424 335 414	331 907	424 333 414
	400	11	100	341 600	424 334 419	322 400	424 332 415	354 101	424 335 415	332 001	424 333 415
	500	6	125	341 701	424 334 511	322 604	424 332 513	354 407	424 335 513	332 103	424 333 513
	500	8	125	341 803	424 334 512	322 706	424 332 514	354 203	424 335 514	332 205	424 333 514
	500	11	125	341 905	424 334 513	322 808	424 335 515	354 305	424 335 515	332 307	424 333 515
	500	15	125	342 000	424 334 514	322 900	424 332 516	351 007	424 335 516	332 409	424 333 516
	630	8	125	342 101	424 334 612	323 106	424 332 614	354 509	424 335 614	332 500	424 333 614
	630	11	160	342 203	424 334 613	323 208	424 332 615	354 600	424 335 615	332 602	424 333 615
	630	15	160	342 305	424 334 614	323 300	424 332 616	351 109	424 335 616	332 704	424 333 616
800	8	125	342 407	424 334 692	323 401	424 332 694	354 804	424 335 694	332 806	424 333 694	
800	11	180	342 509	424 334 693	323 503	424 332 695	354 906	424 335 695	332 908	424 333 695	
800	15	200	342 600	424 334 694	323 605	424 332 696	351 200	424 335 696	333 002	424 333 696	
915	11	190	-	-	-	-	-	-	333 308	424 333 795	
915	15	190	-	-	-	-	-	-	333 400	424 333 796	
1000	11	190	-	-	-	-	-	-	333 603	424 333 855	
1000	15	190	-	-	-	-	-	-	333 705	424 333 856	
1000	20	190	-	-	-	-	-	-	333 807	424 333 857	
1250	11	190	-	-	-	-	-	-	333 909	424 333 935	
1250	15	190	-	-	-	-	-	-	334 003	424 333 936	
1250	20	190	-	-	-	-	-	-	334 105	424 333 937	
DIN 55029	mm		mm	type 4344		type 4342		type 4345		type 4343	
	160	3	43	445 101*	424 344 070	-	-	-	-	-	-
	200	3	50	440 606	424 344 090	420 009	424 342 090	452 708	424 345 090	430 007	424 343 090
	200	4	50	440 708	424 344 091	420 100	424 342 091	452 800	424 345 091	430 109	424 343 091
	200	5	50	440 800	424 344 092	420 202	424 342 092	452 901	424 345 092	430 200	424 343 092
	200	6	50	440 812	424 344 093	420 304	424 342 093	452 006	424 345 093	430 302	424 343 093
	250	3	50	440 901	424 344 190	420 406	424 342 190	453 108	424 345 190	430 404	424 343 190
	250	4	60	441 006	424 344 191	420 508	424 342 191	453 200	424 345 191	430 506	424 343 191
	250	5	65	441 108	424 344 193	420 600	424 342 192	453 301	424 345 192	430 608	424 343 192
	250	6	65	441 200	424 344 194	420 701	424 342 193	453 403	424 345 193	430 700	424 343 193
	250	8	65	441 225	424 344 195	420 803	424 342 194	453 429	424 345 194	430 801	424 343 194
	315	5	80	441 301	424 344 292	420 905	424 342 292	453 505	424 345 292	430 903	424 343 292
	315	6	80	441 403	424 344 293	421 000	424 342 293	453 607	424 345 293	431 008	424 343 293
	315	8	80	441 505	424 344 295	421 101	424 342 294	453 709	424 345 294	431 100	424 343 294
	315	11	80	441 518	424 344 296	-	-	-	-	-	-
	400	6	100	441 607	424 344 413	421 203	424 342 413	453 902	424 345 413	431 201	424 343 413
	400	8	100	441 709	424 344 414	421 305	424 342 414	454 007	424 345 414	431 303	424 343 414
	400	11	100	441 800	424 344 416	421 407	424 342 415	454 109	424 345 415	431 405	424 343 415
	500	8	125	442 007	424 344 514	421 600	424 342 514	454 200	424 345 514	431 609	424 343 514
	500	11	125	442 109	424 344 515	421 702	424 342 515	454 302	424 345 515	431 700	424 343 515
	500	15	125	442 200	424 344 517	421 804	424 342 516	454 404	424 345 516	431 802	424 343 516
	630	8	125	442 302	424 344 614	421 906	424 342 614	454 506	424 345 614	432 904	424 343 614
	630	11	160	442 404	424 344 615	422 000	424 342 615	454 608	424 345 615	432 009	424 343 615
	630	15	160	442 506	424 344 616	421 102	424 342 616	454 700	424 345 616	432 100	424 343 616
	800	8	125	442 608	424 344 694	421 204	424 342 694	454 801	424 345 694	432 202	424 343 694
	800	11	180	442 700	424 344 695	421 306	424 342 695	454 903	424 345 695	432 304	424 343 695
	800	15	200	442 801	424 344 696	421 408	424 342 696	455 008	424 345 696	432 406	424 343 696
	800	20	200	442 903	424 344 697	421 500	424 342 697	455 100	424 345 697	432 508	424 343 697
	915	11	190	-	-	-	-	-	-	432 600	424 343 794
	915	15	190	-	-	-	-	-	-	432 701	424 343 796
1000	11	190	-	-	-	-	-	-	432 905	424 343 855	
1000	15	190	-	-	-	-	-	-	433 000	424 343 856	
1000	20	190	-	-	-	-	-	-	433 101	424 343 857	
1250	11	190	-	-	-	-	-	-	433 203	424 343 935	
1250	15	190	-	-	-	-	-	-	433 305	424 343 936	
1250	20	190	-	-	-	-	-	-	433 407	424 343 937	
* steel body											
Example of order: 4334 - 200/5 or 0642 543 340 609											

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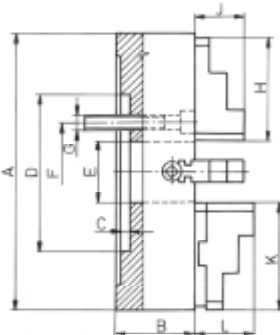
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PLAIN BACK MOUNTING

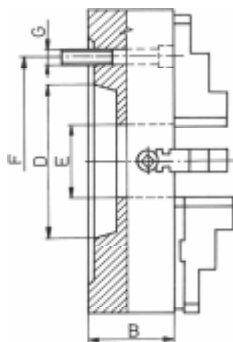


chuck size	85	100	125	160	200	250	315
A	86	100	130	156	200	250	315
B	40	40	43	43	80	85	95
C	5	2.5	2.5	2.5	5	7	7
D H7	62	79.38	69.85	82.55	110	150	175
E	25	25	26	42	50	65	80
F	72	54	54	69.85	82.6	104.8	133.4
G	4xM6	4xM8	4xM8	4xM10	4xM10	4xM12	4xM16
H	34	34	51	51	81	96.5	111
J	17	17	20	20	40.3	40.3	49.8
L	-	-	-	-	46.4	60.4	60.9
K	-	-	-	-	82	96.5	112.5
weight approx. kg	1.9	2.4	3.8	4.3	14.0	25.0	39.0

chuck size	350	400	500	630	800	915	1000	1250
A	350	400	500	630	800	915	1000	1250
B	95	105	120	140	160	170	170	190
C	7	10	12	12	12	18	18	18
D H7	175	200	270	270	380	370	370	550
E	80	100	125	160	200	190	190	190
F	133.4	171.4	235	235	330	330	330	500
G	4xM16	4xM16	4xM20	4xM20	4xM24	8xM24	8xM24	8xM24
H	111	129	152.5	177	202	-	-	-
J	49.8	49.8	59.8	59.8	70.8	-	-	-
L	-	72.3	90.3	97.8	93.8	102.8	102.8	102.8
K	-	129	136	136	136	160	160	160
weight approx. kg	47.5	61.0	105	163	319	350	410	750

DIN 55026

FORM A MOUNTING



chuck size	200			250				315		
short taper	4	5	6	4	5	6	8	5	6	8
B	80			85				95		
D min	63.513	82.563	106.375	63.513	82.563	106.375	139.719	82.563	106.375	139.719
D max	63.526	82.578	106.390	63.526	82.578	106.390	139.734	82.578	106.390	139.734
E	50			65				80		
F	82.6	104.8	133.4	82.6	104.8	133.4	171.4	104.8	133.4	171.4
G	4xM10	4xM10	4xM12	8xM10	8xM10	4xM12	4xM16	4xM10	8xM12	4xM16
weight approx. kg	17.0			25.5				40.0		

chuck size	400			500				630		
short taper	6	8	11	6	8	11	15	8	11	15
B	105			120				140		
D min	106.375	139.719	196.869	106.375	139.719	196.869	285.775	139.719	196.869	285.775
D max	106.390	139.734	196.887	106.390	139.734	196.887	285.795	139.734	196.887	285.795
E	100			125				160		
F	133.4	171.7	235	133.4	171.4	235	330.2	171.4	235	330.2
G	8xM12	4xM16	4xM20	4xM12	8xM16	8xM20	4xM24	8xM16	8xM20	4xM24
weight approx. kg	65			114.0				165.0		

chuck size	800				915		1000		
short taper	8	11	15	20	11	15	11	15	20
B	160				170		170		
D min	139.719	196.869	285.775	412.775	196.869	285.775	196.869	285.775	412.775
D max	139.734	196.887	285.795	412.802	196.887	285.795	196.887	285.795	412.802
E	125	180	200	200*	190		190		
F	171.4	235	330.2	463.6	235	330.2	235	330.2	463.6
G	4xM16	8xM20	8xM24	4xM24	8xM20	8xM24	8xM20	8xM24	8xM24
weight approx. kg	305				315.0		395.0		

chuck size	1250		
short taper	11	15	20
B	190		
D min	196.869	285.775	412.775
D max	196.887	285.795	412.802
E	190		
F	235	330.2	463.6
G	8xM20	8xM24	8xM24
weight approx. kg	732.0		

* 320 mm on request

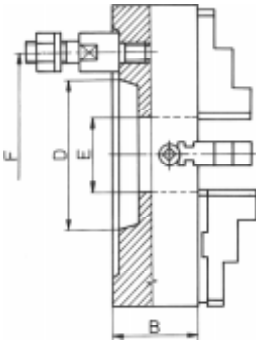


MAIN DIMENSIONS OF 4-JAW INDEPENDENT CHUCKS

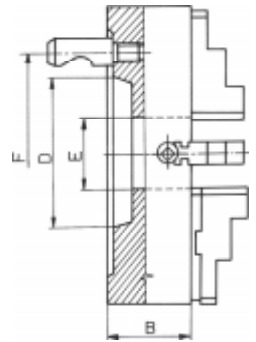
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DIN 55027 AND DIN 55029

BAYONET & CAMLOCK TYPES OF MOUNTING



DIN 55027



DIN 55029

chuck size		160	200				250				
short taper		3	3	4	5	6	3	4	5	6	8
B		54	80				85				
D max		53.988	53.988	63.526	82.578	106.390	53.988	63.526	82.578	106.390	139.734
D min		53.975	53.975	63.513	82.563	106.375	53.975	63.513	82.563	106.375	139.719
E		42	50				50	60	65		
F		70.6	70.6	85 ¹⁾	82.6	104.8	133.4	70.6	82.6	104.8	171.4
qty. of mounting studs	bayonet	-	-	3	4	4	-	-	4	4	4
	camlock	3	3	3	6	6	3	3	6	6	6
weight approx. kg		6.0	16.5				27.5				

chuck size		315				400			
short taper		5	6	8	11	5	6	8	11
B		95				105			
D max		82.578	106.390	139.734	196.887	82.578	106.390	139.734	196.887
D min		82.563	106.375	139.719	196.869	82.563	106.375	139.719	196.869
E		80				79.5	100		
F		104.8	133.4	171.4	235	104.8	133.4	171.4	235
qty. of mounting studs	bayonet	4	4	4	6	4	4	4	6
	camlock	6	6	6	6	6	6	6	6
weight approx. kg		39.5				60.0			

chuck size		500				630			800			
short taper		6	8	11	15	8	11	15	8	11	15	20
B		120				140			160			
D max		106.390	139.734	196.887	285.795	139.734	196.887	285.795	139.734	196.887	285.795	412.802
D min		106.375	139.719	196.869	285.775	139.719	196.869	285.775	139.719	196.869	285.775	412.775
E		100	125			125	160		125	180	200	
F		133.4	171.4	235	330.2	171.4	235	330.2	171.4	235	330.2	463.6
qty. of mounting studs	bayonet	4	4	6	6	4	6	6	4	6	6	6
	camlock	6	6	6	6	6	6	6	6	6	6	6
weight approx. kg		95.5				165.0			298.0			

chuck size		915			1000			1250	
short taper		11	15	11	15	20	11	15	
B		170			170			190	
D max		196.887	285.795	196.887	285.795	412.802	196.887	285.795	
D min		196.869	285.775	196.869	285.775	412.775	196.869	285.775	
E		190			190			190	
F		235	330.2	235	330.2	463.6	235	330.2	
qty. of mounting studs	bayonet	6	6	6	6	6	6	6	
	camlock	6	6	6	6	6	6	6	
weight approx. kg		326.0			386.0			722.0	

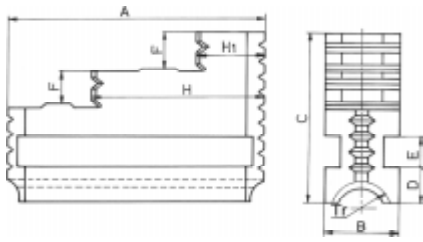
¹⁾ for bayonet type

All other dimensions should be taken from the table about chuck with plain back mounting.

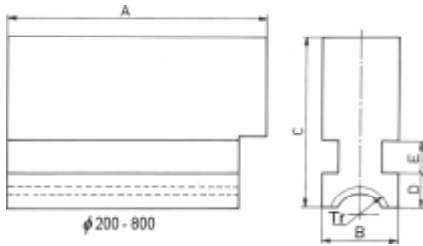


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ONE-PIECE SOLID REVERSIBLE JAWS



One-piece solid reversible jaws

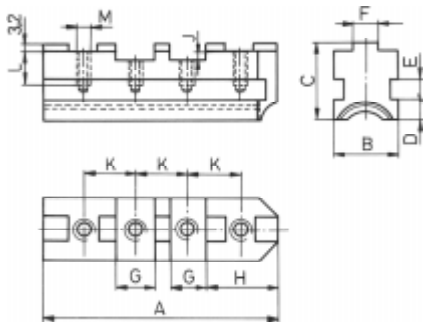


Soft solid jaws

chuck size	85	100	125	160	200	250
A	34	34	51	51	81	96.5
B	13	13	16	16	32	32
C	30	30	34.5	34.5	63	63
D	4.5	4.5	6	6	8.7	8.7
E	5	5	5	5	10	10
F	7	7	8	8	14	14
H1	8	8	12.5	12.5	17.5	23
H	17.5	17.5	31.5	31.5	48.5	59
Tr-left-hand	Tr 16x2	Tr 16x2	Tr 18x4	Tr 18x4	Tr 28x5	Tr 28x5
weight approx. kg	0.1	0.1	0.12	0.12	0.72	1.3

chuck size	315	350	400	500	630	800
A	111	111	129	152.5	177	202
B	40	40	40	52	52	70
C	76.5	76.5	76.5	93.5	93.5	114.5
D	9.7	9.7	9.7	11.7	11.7	15.7
E	12	12	12	15	15	20
F	18	18	18	22	25	25
H1	27	27	32.5	35	45	44
H	67	67	78.5	93	109	122
Tr-left-hand	Tr 32x6	Tr 32x6	Tr 32x6	Tr 36x6	Tr 40x6	Tr 44x8
weight approx. kg	1.5	1.5	1.8	3.4	4.0	7.8

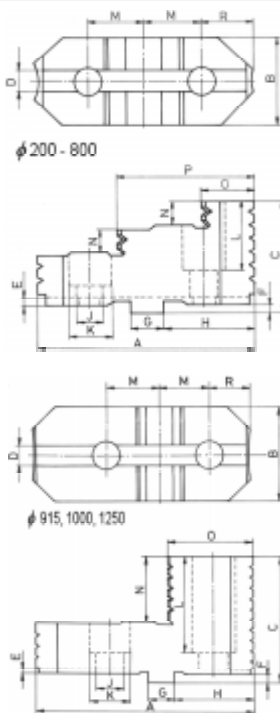
HARD MASTER JAWS



Hard master jaws

chuck size	200	250	315	400	500	630	800	915	1000	1250
A	79	94	110	129	168	206	206	244	244	244
B	32	32	40	40	52	52	70	70	70	70
C	32	38	39	44	59	59	59	59	59	59
D	8.7	8.7	9.7	9.7	11.7	11.7	15.7	15.7	15.7	15.7
E	10	10	12	12	15	15	20	20	20	20
F-0.03	7.94	12.7	12.7	12.7	12.7	12.7	12.7	12.7	12.7	12.7
G+0.01	12.69	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04
H	33.2	37.5	45.4	54.9	55.5	55.5	55.5	55.5	55.5	55.5
J	4	4	4	7.2	7.2	7.2	7.2	7.2	7.2	7.2
K	22.25	27	31.75	38.1	38.1	38.1	38.1	38.1	38.1	38.1
L	14	20	17.5	22	33.5	33.5	33.5	33.5	33.5	33.5
M	M10	M12	M12	M16	M20	M20	M20	M20	M20	M20
	3/8"-16	1/2"-13	1/2"-13	5/8"-11	3/4"-10	3/4"-10	3/4"-10	3/4"-10	3/4"-10	3/4"-10
Tr-left-hand	Tr 28x5	Tr 28x5	Tr 32x6	Tr 32x6	Tr 36x6	Tr 40x6	Tr 44x8	Tr 44x8	Tr 44x8	Tr 44x8
weight approx. kg	0.6	0.9	1.1	1.2	1.5	2.4	2.4	5.4	5.4	5.4

HARD TOP JAWS



Hard top jaws

chuck size	200	250	315	400	500	630	800	915	1000	1250
A	82	96.5	112.5	129	136	136	136	160	160	160
B	34	34	42	42	54	54	72	72	72	72
C	43.5	51.5	55	64.5	74.5	82	88	97	97	97
D	7.95	12.71	12.71	12.71	12.71	12.71	12.71	12.71	12.71	12.71
E	4	4	4	4	4	4	4	4	4	4
F-0.03	3.2	3.2	3.2	6.3	6.3	6.3	6.3	6.3	6.3	6.3
G + 0.01	12.69	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04	19.04
H	35.2	40	47.9	57.4	58	58	58	58	58	58
J	11	14	14	18	22	22	22	22	22	22
K	18	20	20	26	33	33	33	33	33	33
L	21.5	26.5	27.5	32	39.5	43	46	71	71	71
M	22.25	27	31.75	38.1	38.1	38.1	38.1	38.1	38.1	38.1
N	9.5	12	13	13.5	18	21	24	50	50	50
O	22	25	27	26.5	37.5	37.5	40	60	60	60
P	53	62	70.5	79	87	87	89	-	-	-
R	19.3	22.5	25.7	28.8	29.4	29.4	29.4	29.4	29.4	29.4
weight approx. kg	0.5	0.7	1.3	2.1	3.0	3.0	4.2	4.2	4.2	4.2

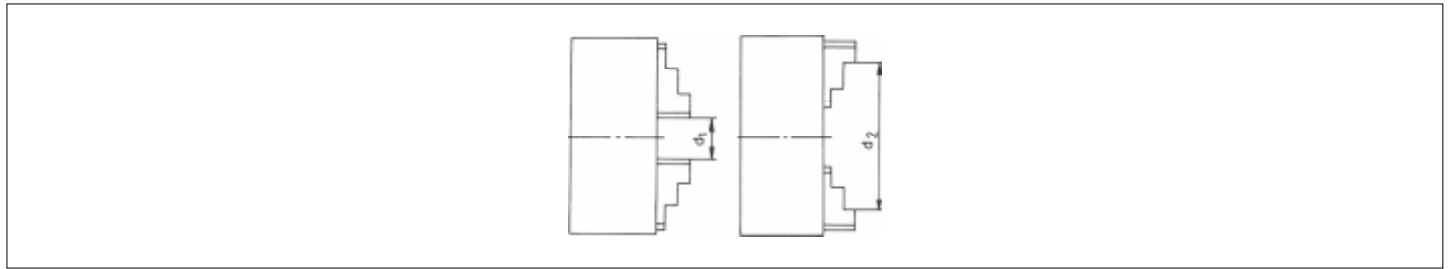


	chuck size	bolt 1	bolt 2
	200	M10x30	M10x20
	250	M12x40	M12x25
	315	M12x40	M12x25
	400	M16x45	M16x30
	500	M20x55	M20x40
	630	M20x60	M20x40
	800	M20x65	M20x40
	915	M20x45	M20x45
	1000	M20x45	M20x45
	1250	M20x45	M20x45

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ENGINEERING DATA FOR 4-JAW INDEPENDENT CHUCKS

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GRIPPING RANGES

chuck size	85	100	125	160	200	250	315	350
d1 min	3	3	8	8	10	10	15	15
d2 max	85	100	125	160	200	250	315	350
max swing dia.	101	116	150	185	235	296	369	404

chuck size	400	500	630	800	915	1000	1250
d1 min	20	45	50	50	120	170	170
d2 max	400	500	630	800	915	1000	1250
max swing dia.	465	570	720	888	1003	1088	1338

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Gripping ranges are valid for lathe chucks with reversible jaws. Do not exceed maximum chucking ranges.

MAXIMUM PERMISSIBLE ROTATIONAL SPEEDS * (rpm)

chuck size	85	100	125	160	200	250	315	350
cast steel or steel body	4000	3800	3500	3200	2500	2000	1500	1500
cast iron body	-	-	-	-	1800	1500	1200	1200

chuck size	400	500	630	800	915	1000	1250
cast steel or steel body	1100	700	550	450	200	200	150
cast iron body	800	500	400	300	150	150	100

* Valid for symmetrical gripping of the workpiece

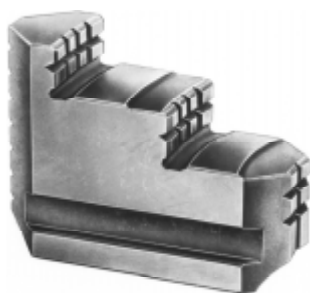
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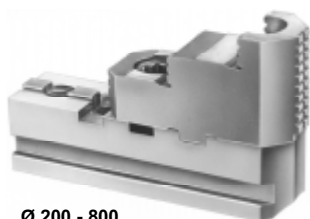
HARD SOLID REVERSIBLE JAWS - SETS

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	4-jaw set	
85	731 002	444 304 001
100	740 101	444 300 050
125	731 104	444 304 152
160	731 104	444 304 152
200	731 206	444 304 413
250	731 308	444 304 511
315	731 400	444 304 613
350	731 400	444 304 613
400	731 501	444 304 711
500	731 603	444 304 763
630	731 705	444 304 811
800	731 807	444 304 853



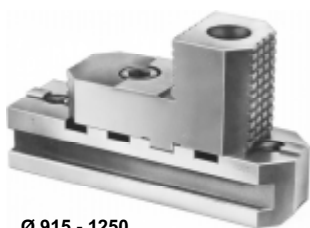
HARD MASTER JAWS - SETS

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	4-jaw set	
200	735 200	444 305 410
250	735 301	444 305 510
315	735 403	444 305 610
400	735 505	444 305 710
500	735 607	444 305 760
630	735 709	444 305 810
800	735 800	444 305 850
915	735 902	444 305 911
1000	735 902	444 305 911
1250	735 902	444 305 911



HARD 2-PIECE REVERSIBLE JAWS - SETS

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	4-jaw set	
200	738 202	444 305 413
250	738 304	444 305 513
315	738 406	444 305 613
400	738 508	444 305 713
500	738 600	444 305 763
630	738 701	444 305 813
800	738 803	444 305 853
915	742 908	444 303 890
1000	742 908	444 303 890
1250	742 908	444 303 890



THRUST BEARING

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm		
85	733 004	444 304 003
100	733 020	444 300 052
125	733 106	444 300 154
160	733 106	444 300 154
200	733 208	444 300 415
250	733 300	444 300 513
315	733 401	444 300 615
350	733 401	444 300 615
400	733 503	444 300 713
500	733 605	444 300 765
630	733 707	444 300 813
800	733 809	444 300 856
915	733 900	444 300 890
1000	733 900	444 300 890
1250	733 900	444 300 890



SOFT SOLID JAWS - SETS

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	4-jaw set	
85	-	-
100	-	-
125	-	-
160	-	-
200	730 205	444 300 412
250	730 307	444 300 510
315	730 409	444 300 612
350	-	-
400	730 500	444 300 710
500	730 602	444 300 762
630	730 704	444 300 810
800	730 806	444 300 852



HARD TOP JAWS - SETS

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm	4-jaw set	
200	736 200	444 305 411
250	736 302	444 305 511
315	736 404	444 305 611
400	736 506	444 305 711
500	736 608	444 305 763
630	736 700	444 305 811
800	736 801	444 305 851
915	744 900	444 303 892
1000	744 900	444 303 892
1250	744 900	444 303 892

OPERATING SCREW

chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm		
85	732 003	444 304 001
100	732 029	444 300 051
125	732 105	444 300 153
160	732 105	444 300 153
200	732 207	444 300 414
250	732 309	444 300 512
315	732 400	444 300 614
350	740 509	444 304 610
400	732 502	444 300 712
500	732 604	444 300 764
630	732 706	444 300 812
800	732 808	444 300 854
915	740 702	444 305 890
1000	740 804	444 305 910
1250	740 906	444 305 930



SAFETY WRENCH

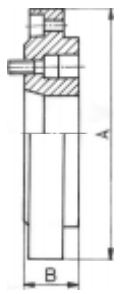
chuck size	code No 0642 985 ...	PKWiU 29 407 231 ...
mm		
85	340 102	443 200 003
100	340 102	443 200 003
125	344 106	444 300 150
160	344 106	444 300 150
200	344 208	444 300 410
250	344 208	444 300 410
315	344 300	444 300 610
350	344 300	444 300 610
400	344 300	444 300 610
500	344 401	444 300 760
630	344 401	444 300 760
800	344 503	444 300 850
915	344 503	444 300 850
1000	344 503	444 300 850
1250	344 503	444 300 850

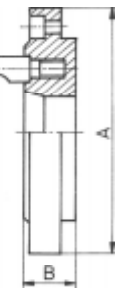


Example of order: Operating screw 4300-250 or 0642 985 732 309



Fully machined cast-iron adapters for plain back self-centering chucks.
Allowance for turning on the chuck side. Mounting instructions see in chuck service manual.

	size mm	short taper	A mm	code No 0642 582 ...	PKWiU 29 407 250 ...	B mm	code No 0642 582 ...	PKWiU 29 407 250 ...	B mm	weight approx. kg
DIN 55026 AND DIN 55027	type 8210				type 8230					
 DIN 55026 - type 8210	100	3	100.5	100 301	728 210 050	18.5	300 102	728 230 050	16.5	1.6
	125	3	125.5	100 403	728 210 120	18.5	300 306	728 230 120	18.5	2.4
	125	4	125.5	100 505	728 210 121	18.5	300 408	728 230 121	18.5	2.4
	160	3	160.5	100 607	728 210 260	18.5	300 601	728 230 260	21	4.3
	160	4	160.5	100 709	728 210 261	21	300 703	728 230 261	21	4.3
	160	5	160.5	100 800	728 210 262	21	300 805	728 230 262	21	4.3
	200	3	201	100 902	728 210 380	21	300 825	728 230 380	21	7.0
	200	4	201	101 007	728 210 381	21	300 907	728 230 381	21	7.0
	200	5	201	101 109	728 210 382	21	301 103	728 230 382	21	7.0
	200	6	201	101 200	728 210 384	21	301 205	728 230 383	21	7.0
	250	5	251	101 506	728 210 482	21	301 500	728 230 482	21	11.0
	250	6	251	101 608	728 210 483	26	301 602	728 230 483	21	11.0
	250	8	251	101 700	728 210 484	26	301 704	728 230 484	26	18.0
	315	6	316	102 008	728 210 583	33	302 002	728 230 583	33	18.0
	315	8	316	102 100	728 210 584	33	302 104	728 230 584	33	18.0
	315	11	316	102 214	728 210 585	33	302 206	728 230 585	33	18.0
	400	6	402	102 405	728 210 703	33	302 400	728 230 703	33	36.0
	400	8	402	102 507	728 210 704	33	302 501	728 230 704	33	36.0
	400	11	402	102 611	728 210 706	33	302 603	728 230 705	33	36.0
	500	8	502	103 009	728 210 804	34	303 003	728 230 804	34	60.0
500	11	502	103 113	728 210 806	34	303 105	728 230 805	34	60.0	
500	15	502	103 215	728 210 808	34	303 207	728 230 806	34	60.0	
630	8	633	103 406	728 210 904	42	303 400	728 230 904	42	105.0	
630	11	633	103 510	728 210 906	42	303 502	728 230 905	42	105.0	
630	15	633	103 612	728 210 908	42	303 604	728 230 906	42	105.0	

	size mm	short taper	A mm	code No 0642 582 ...	PKWiU 29 407 250 ...	B mm	weight approx. kg
DIN 55029	type 8240						
	100	3	100.5	450 113	728 240 050	26	1.6
	125	3	125.5	450 215	728 240 120	26	2.4
	125	4	125.5	451 216	728 240 121	26	2.4
	160	3	160.5	450 317	728 240 260	27	4.3
	160	4	160.5	451 318	728 240 261	27	4.3
	160	5	160.5	452 319	728 240 262	30	4.3
	160	6	160.5	453 310	728 240 263	36.5	4.3
	200	3	201	450 419	728 240 380	27	7.0
	200	4	201	451 410	728 240 381	27	7.0
	200	5	201	452 410	728 240 382	30	7.0
	200	6	201	453 411	728 240 383	36.5	7.0
	200	8	201	454 412	728 240 384	40	7.0
	250	4	251	451 511	728 240 481	28	11.0
	250	5	251	452 512	728 240 482	30	11.0
	250	6	251	453 513	728 240 483	36.5	18.0
	250	8	251	454 514	728 240 484	39	18.0
	315	6	316	453 615	728 240 583	39.5	18.0
	315	8	316	454 616	728 240 584	42	18.0
	315	11	316	455 617	728 240 585	47	18.0
	400	6	402	453 717	728 240 703	36.5	36.0
400	8	402	454 718	728 240 704	39	36.0	
400	11	402	455 719	728 240 705	47	36.0	
500	8	502	454 810	728 240 804	39	60.0	
500	11	502	455 810	728 240 805	47	60.0	
500	15	502	456 312	728 240 806	50	60.0	
630	8	633	455 912	728 240 904	39	105.0	
630	11	633	456 017	728 240 905	47	105.0	
630	15	633	456 414	728 240 906	50	105.0	



Cast-iron adapters for plain back self-centering and independent chuck, rough on the chuck side.
Mounting instructions see in chuck service manual.

	size mm	short taper	A mm	code No 0642 582	PKWiU 29 407 250	B mm	code No 0642 582	PKWiU 29 407 231	B mm	code No 0642 582	PKWiU 29 407 231	B mm	weight approx. kg	
DIN 55026, DIN 55027, DIN 55029				type 8212			type 8232			type 8242				
	DIN 55026 type 8212	100	3	102	120 308	728 212 050	18	320 109	728 232 050	18	420 106	728 242 050	28	1,8
		125	3	127	120 400	728 212 120	19,5	320 302	728 232 120	19,5	420 300	728 242 120	26	2,4
125		4	127	120 501	728 212 121	19,5	320 404	728 232 121	19,5	420 401	728 242 121	26	2,4	
160		3	162	-	-	-	-	-	-	420 503	728 242 260	26	4,2	
160		4	162	120 705	728 212 262	24	320 700	728 232 261	24	420 605	728 242 261	29	4,2	
160		5	162	120 807	728 212 263	24	320 801	728 232 262	24	420 707	728 242 262	29	4,2	
200		4	203	-	-	-	-	-	-	421 209	728 242 381	44	12,0	
200		5	203	121 105	728 212 382	38	321 100	728 232 382	38	421 300	728 242 382	50	12,0	
200		6	203	121 207	728 212 383	33	321 201	728 232 383	33	421 402	728 242 383	35	12,0	
250		5	253	121 502	728 212 482	33	321 507	728 232 482	33	421 708	728 242 482	49	16,0	
DIN 55027 type 8232	250	6	253	121 604	728 212 483	50	321 609	728 232 483	50	421 800	728 242 483	49	16,0	
	250	8	253	121 706	728 212 484	46	321 700	728 232 485	46	421 901	728 242 484	49	16,0	
	315	6	318	122 004	728 212 583	33	322 009	728 232 583	33	422 200	728 242 583	70	22,0	
	315	8	318	122 106	728 212 584	55	322 100	728 232 584	55	422 301	728 242 584	55	22,0	
	315	11	318	122 210	728 212 586	55	322 202	728 232 586	47	422 403	728 242 585	55	22,0	
	400	8	405	122 503	728 212 704	43	322 508	728 232 704	43	422 800	728 242 704	70	42,0	
	400	11	405	122 618	728 212 706	75	322 600	728 232 705	47	422 902	728 242 705	50	42,0	
	500	8	505	123 005	728 212 804	45	323 000	728 232 804	45	423 302	728 242 804	46	72,0	
	500	11	505	123 110	728 212 806	45	323 101	728 232 805	45	423 404	728 242 805	72	72,0	
	630	11	635	123 517	728 212 906	45	323 509	728 232 905	45	423 700	728 242 905	72	105,0	
DIN 55029 type 8242	630	15	635	123 619	728 212 907	56	323 600	728 232 906	56	423 801	728 242 906	60	105,0	
	800 ¹⁾	11	385	123 812	728 212 956	45	323 804	728 232 955	45	424 100	728 242 955	50	130,0	
	800 ¹⁾	15	408	123 914	728 212 958	45	323 906	728 232 956	45	424 201	728 242 956	55	130,0	

¹⁾ for independent chucks (type 4300)

Steel adapters, fully machined, for self-centering with fine adjustment chucks type 3564, 3565, and 3864, 3865.

DIN 55026	FORM A MOUNTING														weight approx. kg
	size	A	short taper	code No 0642 582	PKWiU 29 407 250	B	B1	C	D	E	F	G	H	K	
type 8215															
	100	100	3	150 506	728 215 050	40	12	45	53.975	20	70.6	M8	83	14	1.6
		105	4	150 519	728 215 051	40	12	45	63.513	20	82.6	M8	83	14	1.5
	125	125	4	150 649	728 215 121	36	14	55	63.513	35	82.6	M8	108	29	2.2
			5	150 700	728 215 122	36	14	55	82.563	35	104.8	M8	108	22	1.9
			3	150 738	728 215 260	45	16	86	53.975	42	70.6	M10	140	20	4.4
	160	160	4	150 740	728 215 261	45	16	86	63.513	42	82.6	M10	140	29	4.4
			5	150 801	728 215 262	37	16	86	82.563	42	104.8	M10	140	21	3.1
			6	150 903	728 215 263	42	16	86	106.375	42	133.4	M10	140	26	3.3
			4	151 049	728 215 381	33	17	110	63.513	55	82.6	M10	176	16	4.4
	200	200	5	151 100	728 215 382	33	17	110	82.563	55	104.8	M10	176	16	4.2
			6	151 201	728 215 383	45	17	110	106.375	55	133.4	M10	176	28	6.2
	250	250	5	151 507	728 215 482	38	19	145	82.563	76	104.8	M12	224	19	7.8
			6	151 609	728 215 483	38	19	145	106.375	76	133.4	M12	224	19	7.9
			8	151 700	728 215 484	46	19	145	139.719	76	171.4	M12	224	26	9.2
	315	315	6	152 009	728 215 583	38	19	180	106.375	103	133.4	M16	286	19	12.3
			8	152 100	728 215 584	46	19	180	139.719	103	171.4	M16	286	27	16.0
			11	152 215	728 215 586	55	19	180	196.869	103	235	M16	286	36	18.7
	400	298.45	6	152 304	728 215 703	35	25	298.45	106.375	136	133.4	M16	171.4	35	14.3
			8	152 406	728 215 704	37	25	298.45	139.719	136	171.4	M16	171.4	29	12.8
			11	152 510	728 215 706	48	22	298.45	196.869	136	235	M16	171.4	27	16.2
500	407	8	152 701	728 215 804	36	-	407	139.719	136	171.4	M20	235	36	31.5	
		11	152 803	728 215 805	36	-	407	196.869	192.8	235	M20	235	36	27.6	
		15	152 905	728 215 807	52	-	407	285.775	190	330.2	M20	235	52	34.6	
630	407	8	152 509	728 215 904	36	-	407	139.719	136	171.4	M20	330.2	36	31.5	
		11	153 600	728 215 905	36	-	407	196.869	192.8	235	M20	330.2	36	27.6	
		15	153 702	728 215 906	52	-	407	285.775	252	330.2	M20	330.2	52	29.6	



ADAPTERS FOR BISON LATHE CHUCKS

		BAYONET MOUNTING													
		size	A	short taper	code No 0642 582	PKWiu 29 407 250	B	B1	C	D	E	F	G	H	weight approx. kg
DIN 55027		type 8235													
	100	100	3	350 103	728 235 050	31	12	45	53.975	20	75	M8	83	1.3	
		105	4	350 116	728 235 051	31	12	45	63.513	20	85	M8	83	1.2	
	125	125	3	350 205	728 235 120	33	14	55	53.975	35	75	M8	108	1.8	
		125	4	350 218	728 235 121	33	14	55	63.513	35	85	M8	108	1.7	
		130	5	350 220	728 235 122	35	14	55	82.563	35	104.8	M8	108	1.8	
	160	160	3	350 307	728 235 260	32	16	86	53.975	42	75	M10	140	2.8	
			4	350 409	728 235 261	32	16	86	63.513	42	85	M10	140	2.8	
			5	350 500	728 235 262	37	16	86	82.563	42	104.8	M10	140	3.0	
	200	200	4	350 704	728 235 381	33	17	110	63.513	55	85	M10	176	4.0	
			5	350 806	728 235 382	33	17	110	82.563	55	104.8	M10	176	4.4	
	250	250	6	352 908	728 235 383	40	17	110	106.375	55	133.4	M10	176	5.3	
			5	351 002	728 235 482	38	19	145	82.563	76	104.8	M12	224	8.4	
			6	351 104	728 235 483	38	19	145	106.375	76	133.4	M12	224	7.9	
	315	315	8	351 206	728 235 484	43	19	145	139.719	76	171.4	M12	224	10.3	
			6	351 308	728 235 583	43	19	180	106.375	103	133.4	M16	286	12.9	
			8	351 400	728 235 584	43	19	180	139.719	103	171.4	M16	286	15.0	
	400	298.45	11	351 501	728 235 585	50	19	180	196.869	103	235	M16	286	17.9	
			6	352 309	728 235 703	35	22	298.45	106.375	103	133.4	M16	171.4	12.8	
			8	352 400	728 235 705	37	-	298.45	139.719	135.8	171.4	M16	171.4	15.0	
	500	407	11	352 502	728 235 706	37	-	298.45	196.869	120	235	M16	171.4	17.0	
8			352 706	728 235 812	36	-	407	139.719	136	171.4	M20	235	31.5		
11			352 808	728 235 813	36	-	407	196.869	192.8	235	M20	235	29.6		
630	407	15	352 900	728 235 814	52	-	407	285.775	190	235	M20	235	39		
		8	353 503	728 235 904	36	-	407	139.719	136	171.4	M20	330.2	31.5		
		11	353 605	728 235 905	36	-	407	196.869	192.8	330.2	M20	330.2	29.6		
		15	353 707	728 235 906	52	-	407	285.775	252	330.2	M20	330.2	34		

		CAMLOCK MOUNTING													
		size	A	short taper	code No 0642 582	PKWiu 29 407 250	B	B1	C	D	E	F	G	H	weight approx. kg
DIN 55029		type 8245													
	100	100	3	458 006	728 245 050	38	12	45	53.975	20	70.6	M8	83	1.5	
		108	4	458 019	728 245 051	40	12	45	63.513	20	82.6	M8	83	1.8	
	125	125	3	458 108	728 245 120	40	14	55	53.975	35	70.6	M8	108	2.7	
			4	458 200	728 245 121	39	14	55	63.513	35	82.6	M8	108	2.6	
			5	458 225	728 245 122	44	14	55	82.563	35	104.8	M8	108	3.1	
	160	160	6	458 255	728 245 123	44	14	55	104.8	35	133.4	M8	108	3.1	
			3	458 301	728 245 260	46	16	86	53.975	42	70.6	M10	140	4.9	
			4	458 403	728 245 261	46	16	86	63.513	42	82.6	M10	140	4.5	
	200	200	5	458 505	728 245 262	46	16	86	82.563	42	104.8	M10	140	4.5	
			6	458 518	728 245 263	51	16	86	106.375	42	133.4	M10	140	5.9	
			3	458 607	728 245 380	33	17	110	53.975	51.4	70.6	M10	176	4.7	
	250	250	4	458 709	728 245 381	33	17	110	63.513	55	82.6	M10	176	4.7	
			5	458 800	728 245 382	47	17	110	82.563	55	104.8	M10	176	7.2	
			6	458 902	728 245 383	51	17	110	106.375	55	133.4	M10	176	8.0	
	315	315	4	458 943	728 245 481	38	19	145	63.513	60.5	82.6	M12	224	8.6	
			5	459 007	728 245 482	38	19	145	82.563	76	104.8	M12	224	8.0	
			6	459 109	728 245 483	53	19	145	106.375	76	133.4	M12	224	12.9	
	400	298.45	8	459 200	728 245 484	60	19	145	139.719	76	171.4	M12	224	14.7	
			6	459 302	728 245 583	38	19	180	106.375	103	133.4	M16	286	12.9	
			8	459 404	728 245 584	57	19	180	139.719	103	171.4	M16	286	21.7	
500	407	11	459 506	728 245 585	64	19	180	196.869	103	235	M16	286	24.0		
		6	459 636	728 245 703	35	22	183	106.375	103	133.4	M16	171.4	11.7		
		8	459 712	728 245 704	38	22	227	139.719	136.1	171.4	M16	171.4	11.9		
630	407	11	459 814	728 245 705	48	22	297	196.869	136	235	M16	171.4	17.5		
		8	459 931	728 245 804	36	-	407	139.719	136	171.4	M20	235	33.5		
		11	459 944	728 245 805	36	-	407	196.869	192.8	235	M20	235	35.3		
		15	459 957	728 245 806	52	-	407	285.775	190	330.2	M20	235	37.8		
		8	459 972	728 245 904	36	-	407	139.719	136	171.4	M20	330.2	33.5		
		11	459 985	728 245 905	36	-	407	196.869	192.8	235	M20	330.2	35.3		
		15	459 998	728 245 906	52	-	407	285.775	252	330.2	M20	330.2	32.8		

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BISON-BIAL SA



Designed for turning, milling and grinding operations for simultaneously supporting and clamping long objects (tubes, shaft etc.).
May work in horizontal and vertical position.

ROTATING - type 9154, 9155											
D	SM	A	B	min ⁻¹	weight kg	code No 0642 591	PKWiU 29 407 250	code No 0642 591	PKWiU 29 407 250	code No 0642 591	PKWiU 29 407 250
						type 9154-AE		type 9154- BE		type 9155- BE	
80	2	102.5	-	4000	3.5	542 009	889 154 060	540 007	889 154 020	-	-
80	3	102.5	-		3.8	542 100	889 154 061	540 109	889 154 021	-	-
100	3	111.5	-	3500	5.5	-	-	540 506	889 154 121	-	-
100	4	113,0	-		5.9	-	-	540 608	889 154 123	-	-
125	4	127,0	-	3200	7.9	541 700	889 154 270	541 008	889 154 242	-	-
125	5	127,0	-		8.6	541 507	889 154 271	541 100	889 154 243	-	-
160	5	149.5	110	3000	14.3	541 405	889 154 420	541 609	889 154 383	551 403	889 155 383

DEAD - type 9156						
D	SM	A	min ⁻¹	weight approx. kg	code No 0642 591	PKWiU 29 407 250
type 9156						
80	2	65.5	4000	2.2	560 003	889 156 020
80	3	62.5		2.3	560 105	889 156 021
100	3	68.5	3500	3.7	560 502	889 156 121
125	4	85,0	3200	6.7	561 004	889 156 242
125	5	105,0		7,0	561 106	889 156 243
160	4	93.5	3000	14.9	561 300	889 156 382
160	5	93.5		15.2	561 401	889 156 383

Standard accessories :

- Type 9154, 9156 - chuck 3274, hard solid outside and inside solid jaws, wrench.
- Type 9155 - chuck 3275, hard 2-piece reversible jaws, wrench.

D	B	E	C		d ₁ min	d ₂ max
			solid jaws	2-piece reversible jaws		
80	44	16	13	-	2	71
100	50	20	17	-	3	83
125	56	32	20	40	3	125
160	64.5	42	32	43	3	160

ROTATING WITH FINE ADJUSTMENT- type 9164, 9165								
D	SM	A	min ⁻¹	weight kg	code No 0642 591	PKWiU 29 407 250	code No 0642 591	PKWiU 29 407 250
						type 9164		type 9165
100	3	151	2500	6.8	640 529	889 164 192	-	-
100	4	154.5	2500	7.1	640 620	889 164 193	-	-
125	4	155.5	2000	9.2	641 020	889 164 301	652 208	889 165 316
125	5	160.5	2000	10.3	641 122	889 164 302	652 300	889 165 317
160	5	156.5	1800	32.4	641 402	889 164 432	652 605	889 165 383

Example of order: 9164-100/3 AE or 0642 591 640 529

Standard accessories :

- Type 9164 - chuck 3564, hard solid outside jaws, wrench, hex key.
- Type 9165 - chuck 3565, hard 2-piece reversible jaws, wrench, hex key.

D	B	E	C		d ₁ min	d ₂ max
			solid jaws	2-piece reversible jaws		
100	68	20	17	-	3	83
125	71,5	35	20	40	3	125
160	68	42	32	43	3	160



3-JAW CHUCKS WITH MORSE TAPER

ROTATING DIVIDING WITH BLOCKING - type 9184, 9185										
D	SM	A	B	min ⁻¹	weight approx. kg	code No 0642 591	PKWiU 29 407 250	code No 0642 591	PKWiU 29 407 250	
type 9184							type 9185			
80	2	113,9	-	3000	3,9	840 100	889 184 020	-	-	
80	3	113,9	-		4,1	840 113	889 184 021	-	-	
100	3	123,4	-		6,2	840 202	889 184 121	-	-	
100	4	124,9	-	2500	6,5	840 215	889 184 122	-	-	
125	4	139,5	-		11,0	840 317	889 184 242	850 315	889 185 242	
125	5	139,5	-	2000	12,0	840 320	889 184 243	850 328	889 185 243	
160	4	148	125		18,0	840 419	889 184 382	850 417	889 185 382	
160	5	148	125	1800	19,0	840 412	889 184 383	850 420	889 185 383	

Basic indexing :
2, 3, 4, 6, 8, 12, 24

ROTATING WITH BLOCKING - type 9186, 9187										
D	SM	A	B	min ⁻¹	weight app. kg	code No 0642 591	PKWiU 29 407 250	code No 0642 591	PKWiU 29 407 250	
type 9186							type 9187			
80	2	109	-	3200	3,6	860 107	889 186 020	-	-	
80	3	109	-	3200	3,8	860 110	889 186 021	-	-	
100	3	118,5	-	2800	6,0	860 209	889 186 121	-	-	
100	4	120	-	2800	6,0	860 211	889 186 122	-	-	
125	4	138,5	-	2500	11,0	860 313	889 186 242	870 311	889 187 242	
125	5	138,5	-	2500	12,0	860 326	889 186 243	870 324	889 187 243	
160	4	147	125	2200	18,0	860 402	889 186 382	870 400	889 187 382	
160	5	147	125	2200	18,9	860 415	889 186 383	870 413	889 187 383	

Example of order: 9186-80/2 AE or 0642 591 860 107

Standard accessories :

- Type 9184, 9186 - chuck 3274, hard outside and inside solid jaws, wrench.
- Type 9185, 9187 - chuck 3275, hard 2-piece reversible jaws, wrench.

D	B	E	C		d ₁ min	d ₂ max
			solid jaws	2-piece reversible jaws		
80	44	16	13	-	2	71
100	50	20	17	-	3	83
125	56	32	20	40	3	125
160	64,5	42	32	43	3	160

4-JAW INDEPENDENT CHUCKS WITH MORSE TAPER

ROTATING - type 4954								
D	SM	A	B	min ⁻¹	weight approx. kg	code No 0642 549	PKWiU 29 407 250	
type 4954								
100	4 AE	115	98	3500	6,0	543 016	494 954 103	
125	4 BE	135,5	115	3200	8,0	540 102	494 954 203	
160	4 AE	135,5	115	2800	11,0	543 207	494 954 384	
160	5 AE	135,5	115	2800	12,0	543 309	494 954 385	

DEAD - type 4956							
D	SM	A	min ⁻¹	weight approx. kg	code No 0642 549	PKWiU 29 407 250	
type 4956							
125	4 AE	72	3200	6,0	560 109	494 956 203	

Example of order: 4956-125/4AE or 0642 549 560 109

Standard accessories : chuck 4304, hard solid jaws, wrench.

D	B	C	E	d ₁ min	d ₂ max
100	40	17	25	3	100
125	43	20	26	8	125
160	43	20	42	8	160



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Because of the constant product development we reserve the right to make changes in specifications and design without notice.



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Metalexport Co. Ltd. is dealing with export - import business for over 50 years. In our line of business, trading and investment goods, we are one of the oldest and the biggest companies in Poland. Since 2000 Metalexport is a private company among Metalexport Group production and trade companies. From the beginning our company has been present on world markets. Over the past years Metalexport has created one of the most efficient sales networks for machine tools and tooling, setting up subsidiaries in the USA, Canada, the UK, Germany and Italy. We have our branch offices in Russia and Turkey. We are working together with local distributors in other countries of Europe, Asia, Americas and Africa. Export department of Metalexport is serving our customers all over the world successfully offering Polish industrial products: holding-tools, cutting tools, measuring tools, hand tools and others.

We make special tooling accordingly to customers' demands.

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