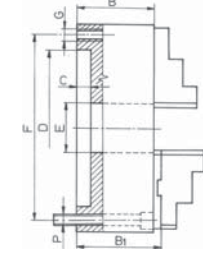
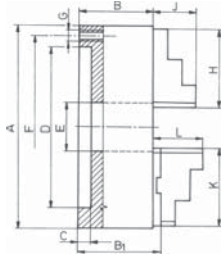


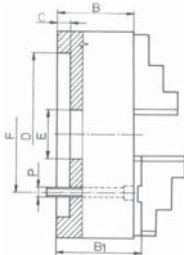
MAIN DIMENSIONS OF CHUCKS TYPE 3100, 3500, 3600, 3700



DIN 6350



3274, 3275, 3574, 3575



3204 3205-800

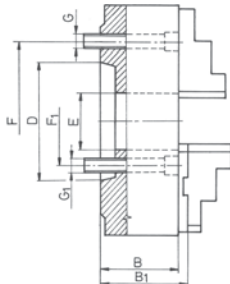
PLAIN BACK MOUNTING

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	97,2	109	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	6xM16	6xM16	6xM24
weight approx. kg		17,5	29	50	85	145,0	250,0	402

¹⁾ for type 3274 chucks, 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 1:4		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 mounting 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 1:4		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		
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 mounting 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		

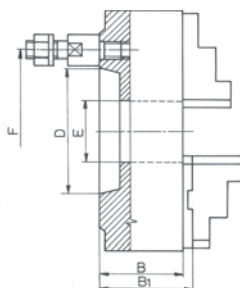
* 252 for chuck type 3500



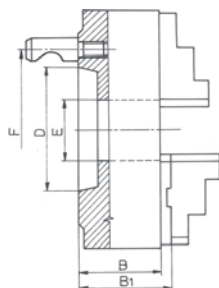
MAIN DIMENSIONS OF CHUCKS TYPE 3100, 3500, 3600, 3700

DIN 55027 | DIN 55029

BAYONET & CAMLOCK TYPES OF MOUNTING



DIN 55027



DIN 55029

Chuck size	100		125		160			
Short taper 1:4	3	3	4	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
	max	53.988	53.988	63.526	53.988	63.526	82.578	106.390
E	20	32		42				
F	75	75	85	75	85	104.8	133.4	
F ¹⁾	70.6	70.6	82.6	70.6	82.6	104.8	133.4	
qty. of mounting screws	bayonet	3	3	3	3	3	4	4
	camlock	3	3	3	3	3	6	6
weight approx. kg	3.0	5.0		9.0				

Chuck size	200				250			315			
Short taper 1:4	3	4	5	6	5	6	8	6	8	11	
B	78				89			96.2		111.7	
	91				103.5			117.7		125	140 ¹⁾
B1	82.8				92.8			101.3		116.8	
	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 screws	bayonet	3	3	4	4	4	4	4	4	6	
	camlock	3	3	6	6	6	6	6	6	6	
weight approx. kg	19.0				32.0			51.0			

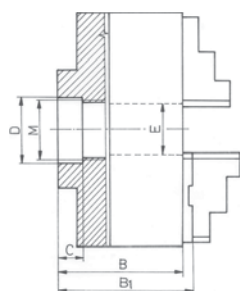
Chuck size	400			500		630			
Short taper 1:4	6	8	11	8	11	8	11	15	
B	108			119		129			
	128.5			146		165			
B1	116.8			129.8		140.3			
	137.3			156.8		176.3			
D	min	106.375	139.719	196.869	139.719	196.869	139.719	196.869	285.775
	max	106.390	139.734	196.887	139.734	196.887	139.734	196.887	285.795
E	103	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 screws	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

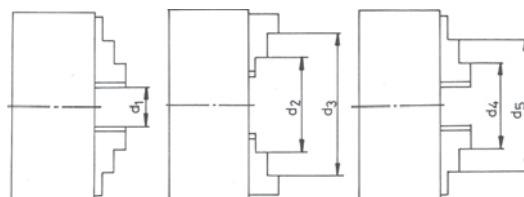
DIN 800

THREADED MOUNTING OF CHUCKS - TYPE 3284



Chuck size A	100
M	M24
B	70
B ₁	-
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



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	62-93	62-93	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 RANGES 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

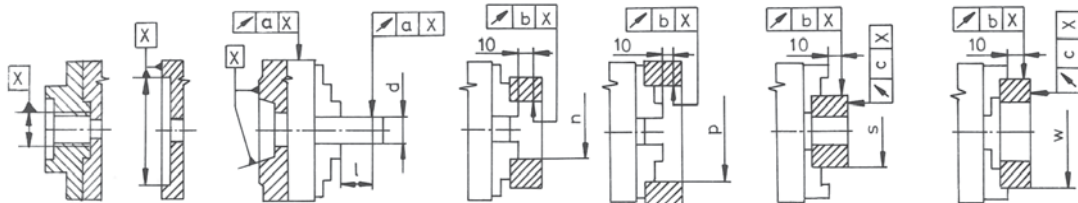
Chuck size	80, 85	100,110	125	140, 160	200	250	315	400	500	630	800
torque on wrench (Nm)	35	50	75	120	160	180	200	280	360	460	500
total gripping force (daN)	1000	1700	2400	3100 2400*	3700 2900*	4600 3600*	5500 4400*	6500 4900*	7200	8000	9000

* 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

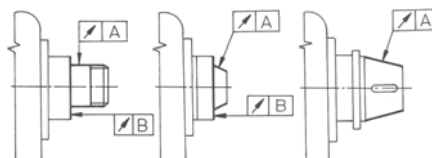
Chuck size	80	100	125	160	200	250	315	400	500	630
gcm	11	16	23	32	45	63	90	140	300	640

CENTRING 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 klasa I	a	0.010	0.015	0.020	0.025	0.030	0.035	0.040	0.045	0.050	0.055	0.060
	b	0.013	0.018	0.023	0.028	0.033	0.038	0.043	0.048	0.053	0.058	0.063
	c	0.008	0.010	0.013	0.015	0.018	0.020	0.023	0.025	0.028	0.030	0.033
3500 3700 3800	a	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.100	0.110	0.120
	b	0.025	0.035	0.045	0.055	0.065	0.075	0.085	0.095	0.105	0.115	0.125
	c	0.015	0.020	0.025	0.030	0.035	0.040	0.045	0.050	0.055	0.060	0.065
3200 3600	a	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.100	0.110	0.120
	b	0.025	0.035	0.045	0.055	0.065	0.075	0.085	0.095	0.105	0.115	0.125
	c	0.015	0.020	0.025	0.030	0.035	0.040	0.045	0.050	0.055	0.060	0.065
3284 3285	a		0.05		0.08							
	b		0.075		0.125							
	c		0.04		0.07							


SPINDLE NOSE CENTERING ACCURACY

3500	A, B	Ø 80 - 400	Ø 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	Ø 80 - 160	Ø 200 - 800	
		0,003 mm	0,005 mm	