

# ITER- FÜR DIE ENERGIE VON MORGEN

## ITER - FOR THE ENERGY OF TOMORROW



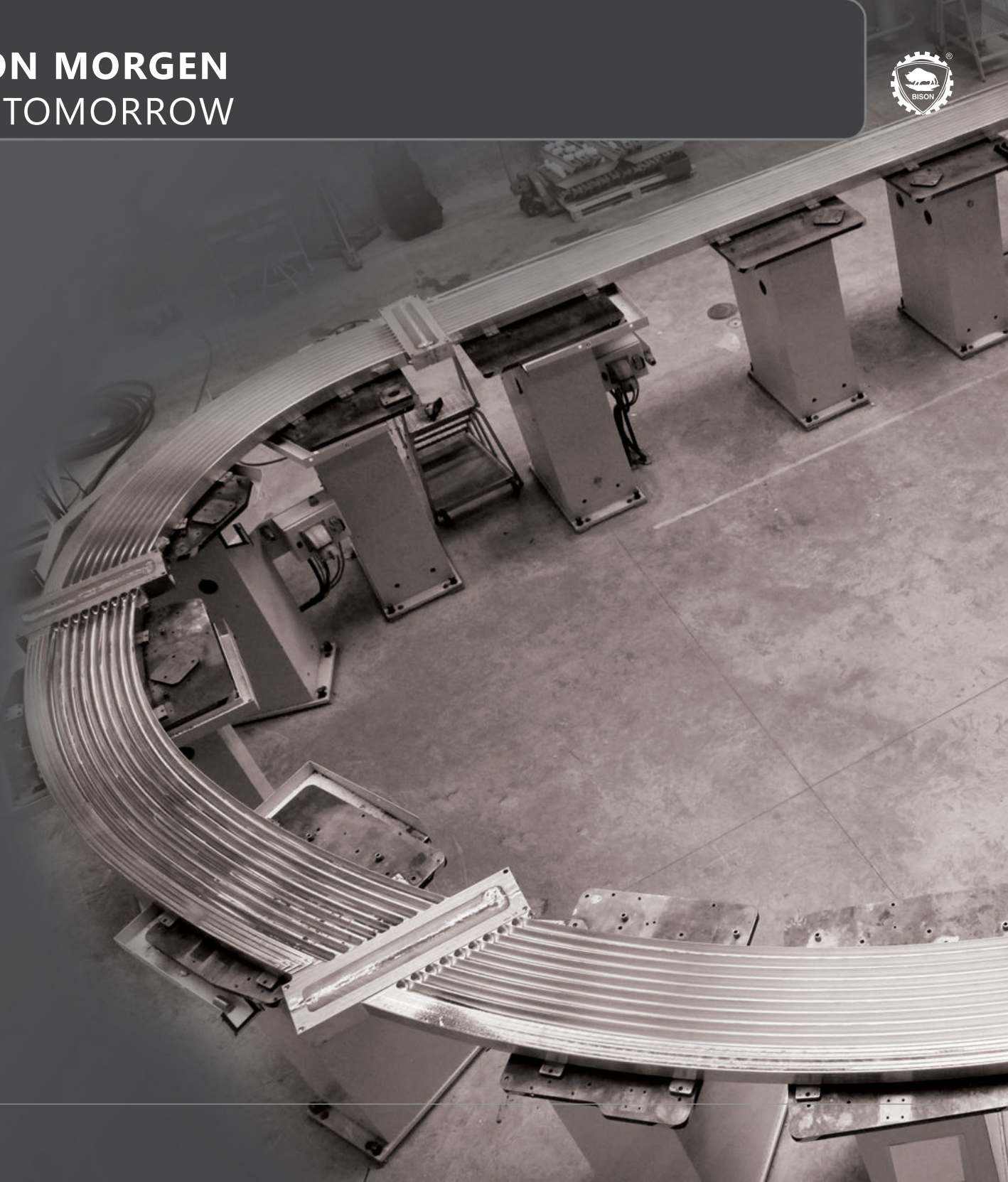
Für das 16 Milliarden Projekt „ITER“ haben sich die Europäische Union, Indien, Japan, Russland, Südkorea, USA und China zusammengeschlossen, um gemeinsam im Forschungszentrum Cadarache, Südfrankreich, einen Experimentalreaktor zu bauen und zu betreiben. „ITER“ (lat. für „Der Weg“) ist das Akronym für **I**nternational **T**hermonuclear **E**xperimental **R**eactor. Das Projekt soll die notwendigen wissenschaftlichen Erkenntnisse über die Wirtschaftlichkeit der Stromerzeugung durch Fusionsenergie liefern.

Durch den Gewinn des Auftrages zur Fertigung von 500 Hochpräzisions-Spannvorrichtungen ist es uns gelungen, Teil dieses innovativen Projektes zu werden.

Unsere speziell mit dem Kunden, einem französisch-italienischen Konsortium, vor Ort entwickelten Hochpräzisions-Schraubstücke werden in Italien und Frankreich bei der Herstellung und Bearbeitung der benötigten siebzig radialen Platten eingesetzt und sorgen im Verbund dafür, dass die D-förmigen, 13,8m x 8,7m x 110 mm großen, aus rostfreiem Stahl gefertigten und je nach Modell 5,5 oder 9,8 Tonnen wiegenden Platten, sicher und präzise gespannt und bearbeitet werden können.

Die bearbeiteten Platten bilden die Grundlage der 18 supraleitenden Magnetspulen, die erforderlich sind, um das erzeugte Plasma in dem ITER Vakuumbehälter zu halten.

Damit leistet BISON schon heute einen wichtigen Beitrag für die Energie der Zukunft.







## ITER- FÜR DIE ENERGIE VON MORGEN ITER - FOR THE ENERGY OF TOMORROW

For the 16 billion comprehensive project "ITER", the European Union, India, Japan, Russia, South Korea, United States and China have joined together to build and operate an experimental reactor in the research center Cadarache, South-France. "ITER" (Latin for "The Way") is the acronym for **I**nternational **T**hermonuclear **E**xperimental **R**eactor. The project aims to provide the necessary scientific evidence on the economics of power generation by fusion energy.

By winning the contract to manufacture 500 high-precision jigs we were able to be part of this innovative project.

Our specially designed solution with the customer, a French-Italian consortium, chose locally-developed high-precision BISON Machine vises that are used in the production and processing of required seventy radial plates in Italy and France and are incorporated for that the D-shaped, 13.8mx 8.7mx 110 mm wide, made of stainless steel and according to the model most 5.5 or 9.8 tons plates, can be precisely and safely clamped and machined. They form the backbone for the 18 toroidal field coils required to confine the plasma in the ITER vacuum vessel.

Thus BISON is already making an important contribution to the energy of the future.

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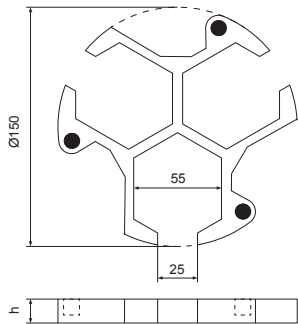
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# 1335

## WERKSTÜCKANSCHLÄGE WORKPIECE STOPS



Artikel Nr.	Typ	Größe	Breite (h)	Max. ø des Werkstücks	Max. Backenbreite
Code No.	Type	Size	Width (h)	Max. ø of the workpiece	Max. jaw width
● 381335300600	1335-150-15	15	15	15 – 130	55
● 381335301900	1335-150-20	20	20	15 – 130	55
● 381335302100	1335-150-25	25	25	15 – 130	55
● 381335303400	1335-150-30	30	30	15 – 130	55
● 381335304700	1335-150-35	35	35	15 – 130	55

- Werkstückanschlag für Drehfutter
  - Der Anschlag wird über drei Haftmagnete, die in den Anschlag eingearbeitet sind, am Drehfutterkörper befestigt
  - Er ist ideal zur Bearbeitung von kurzen Werkstücken und gewährt einen konstanten, einwandfreien Rundlauf der Werkstücke
  - Werkstoff: Aluminium
  - Einzeln oder im Set à 5 Stück erhältlich
- 
- Workpiece stop for all chucks
  - The stop can be fixed on the chuck body with three magnets, which are incorporated in the stop
  - The workpiece stop is for machining short parts and provides a constant, perfectly concentricity of the workpiece
  - Made of treated aluminium
  - Available separately or in a set of 5 pieces

Futtergröße [mm]	Für Typ For Type
Chuck size [mm]	43**
100	○ 398573202900
125	● 398573210500
160	● 398573210500
200	● 398573220700
250	● 398573230900
315	○ 398573240000
400	● 398573250200
500	● 398573260400
630	● 398573270600
800	○ 398573280800
1000	○ 398574080400
1250	○ 398574090600

### VERSTELLSPINDEL OPERATING SCREW



Für Typ • For Type  
43\*\*

Futtergröße [mm]	Für Typ For Type
Chuck size [mm]	4505, 4605, 4705, 4805
200	○ 398575110000
250	○ 398575120200
315	○ 398575130400
400	○ 398575510400
500	○ 398575520600
630	○ 398575530800



Für Typ • For Type  
4505, 4605, 4705, 4805

Futtergröße [mm]	Für Typ For Type
Chuck size [mm]	43**
100	○ 398573302000
125	○ 398573310600
160	○ 398573310600
200	○ 398573320800
250	○ 398573330000
315	○ 398573340100
400	○ 398573350300
500	○ 398573360500
630	○ 398573370700
800	○ 398573380900
1000	○ 398573390000
1250	○ 398573390000

### SPINDELLAGER THRUST BEARING



Für Typ • For Type  
43\*\*

Futtergröße [mm]	Für Typ For Type			
Chuck size [mm]	3105, 32**, 36**, 4505, 4605, 4705, 4805	35**, 37**, 38**	3295	3286
49	-	-	-	-
60	-	-	-	● 398539917000
80	○ 398536100800	○ 398536101000	-	-
100	○ 398536110000	○ 398536111200	-	-
125	○ 398536720700	○ 398536120100	-	-
160	● 398536730900	○ 398536130300	-	-
200	● 398536740000	● 398536140500	-	-
250	○ 398536750200	○ 398536150700	-	-
315	○ 398536760400	○ 398536160900	-	-
400	○ 398536770600	○ 398536170000	○ 398539971500	-
500	○ 398536780800	○ 398536172600	○ 398539972800	-
630*	○ 398536790000	○ 398536174100	○ 398539973000	-
800	○ 398536700300	-	-	-

\* Für Drehfutter 3295-660 • For chucks 3295-660

### PLANSPIRALE SCROLL PLATE



Für Typ • For Type  
3105, 32\*\*, 36\*\*, 35\*\*, 37\*\*, 38\*\*, 3286, 3286, 3295, 4505, 4605, 4705, 4805

Futtergröße [mm]	Für Typ For Type			
Chuck size [mm]	3105, 32**, 36**, 4505, 4605, 4705, 4805	35**, 37**, 38**	3295	3975
80	○ 398533400600	○ 398533400600	-	-
100	● 398533410800	● 398533410800	-	-
125	● 398533420000	○ 398536220200	-	○ 398536220200
140	-	-	-	-
160	● 398533430100	● 398536230400	-	● 398536230400
200	● 398533440300	● 398536240600	-	-
250	● 398533450500	● 398536250800	-	-
315	● 398533460700	● 398536260000	-	-
400	● 398533470900	○ 398536270100	○ 398539961300	-
500	○ 398533480000	○ 398536280300	○ 398539962600	-
630*	● 398533490200	○ 398536290500	○ 398539963900	-
800	○ 398533500700	-	-	-

\* Für Drehfutter 3295-660 • For chucks 3295-660

### RITZEL PINION



Für Typ • For Type  
3105, 3200, 3600, 4500, 4600, 4700, 4800, 35\*\*, 37\*\*, 38\*\*, 3295

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**CAMLOCKBOLZEN  
STUD FOR CAMLOCK  
(DIN 55029)**



Artikel Nr. <sup>1)</sup>	Grösse	Kurzkegel 1:4	Erf. Menge
Code No. <sup>1)</sup>	Size	Taper size 1:4	pcs/set
● 398582510700	M10x1-35	3	3
● 398582520900	M10x1-37	4	3
● 398582530000	M12x1-43	5	6
● 398582540200	M16x1,5-49	6	6
● 398582550400	M20x1,5-55,5	8	6
○ 398582560600	M22x1,5-67	11	6
● 398582570800	M24x1,5-76	15	6
○ 398582580000	M27x2-89	20	6

<sup>1)</sup> Für 1 Stück • For 1 piece

**STEBOLZEN MIT BUNDMUTTER  
STUD AND LOCKNUT  
(DIN 55027)**



Artikel Nr. <sup>1)</sup>	Grösse	Kurzkegel 1:4	Erf. Menge
Code No. <sup>1)</sup>	Size	Taper size 1:4	pcs/set
○ 398582110300	M10x34	3	3
○ 398582120500	M10x39	4	3
● 398582130700	M10x43	5	4
● 398582140900	M12x50	6	4
● 398582150000	M16x60	8	4
● 398582160200	M20x75	11	6
○ 398582170400	M24x90	15	6

<sup>1)</sup> Für 1 Stück • For 1 piece

**HALBSCHEIBE  
LOCKING HALF-RING**



Futtergröße [mm]	Für Typ For Type	
	35**, 37**, 38**	3975
125	○ 398536320300	○ 398536320300
140	-	○ 398536320300
160	○ 398536330500	○ 398536330500
200	○ 398536340700	-
250	○ 398536350900	-
315	○ 398536360000	-
400	○ 398536370200	-
500	○ 398536380400	-
630	○ 398536390600	-
800	○ 398536390600	-

Für Typ • For Type  
35\*\*, 37\*\*, 38\*\*, 3975

**FÜHRUNGSBUCHSE  
SLEEVE BEARING**



Futtergröße [mm]	Für Typ For Type	
	35**, 37**, 38**	3975
125	○ 398536420400	○ 398536420400
140	-	○ 398536420400
160	○ 398536430600	○ 398536430600
200	○ 398536440800	-
250	○ 398536450000	-
315	● 398536460100	-
400	○ 398536470300	-
500	○ 398536480500	-
630	○ 398536490700	-
800	○ 398536490700	-

Für Typ • For Type  
35\*\*, 37\*\*, 38\*\*, 3975

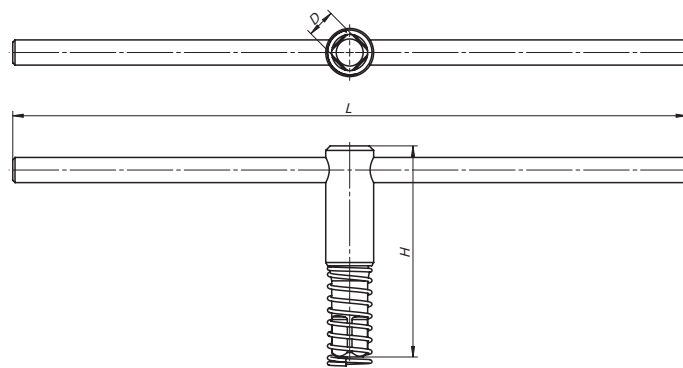
**HALTEBOLZEN  
STUD BOLT**



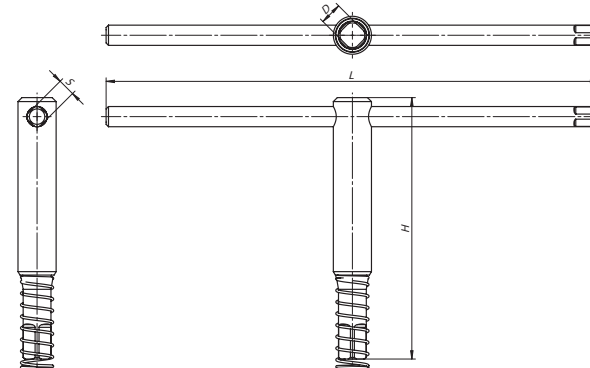
Futtergröße [mm]	Artikel Nr.
Chuck size [mm]	Code No.
80	○ 398533510900
100	○ 398533510900
125	● 398533520000
160	● 398533520000
200	● 398533540400
250	● 398533540400
315	● 398533540400
400	○ 398533570000
500	○ 398533570000
630	○ 398533570000
800	○ 398533570000
1000	○ 398533570000
1250	○ 398533570000

Für Typ • For Type  
3105, 32\*\*, 36\*\*, 38\*\*,  
4505, 4605, 4705, 4805



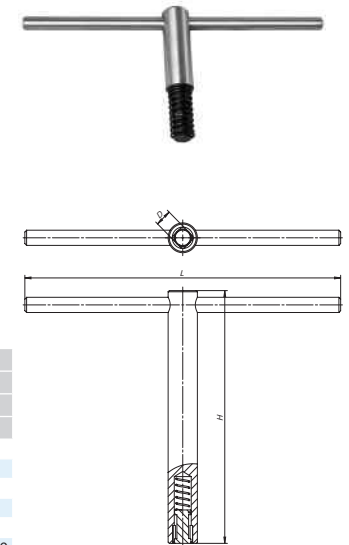


Für Typ • For Type 3105, 32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*, 43\*\*



Für Typ • For Type 45\*\*, 46\*\*, 47\*\*, 48\*\*

**SICHERHEITSSCHLÜSSEL**  
SAFETY WRENCH



Für Typ • For Type 34\*\*

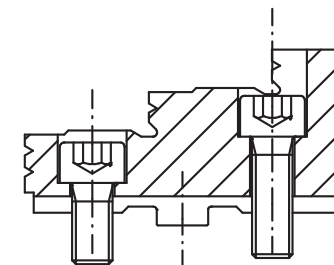
Für Typ • For Type  
3105, 32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*,  
4505, 4605, 4705, 4805,  
43\*\*, 34\*\*, 3975

Futtergröße [mm] Chuck size [mm]	Für Typ • For Type																								
	3105, 32**, 35**, 36**, 37**, 38**					4505, 4605, 4705, 4805					43**					34**			3286	3975					
	Artikel Nr. Code No.	D	H	L	kg	Artikel Nr. Code No.	D	S	H	L	kg	Artikel Nr. Code No.	D	H	L	kg	Artikel Nr. Code No.	D	H	L	kg	Artikel Nr. Code No.	Artikel Nr. Code No.		
49	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	398539910100	-	
60	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	398539910100	-	
80	398534010200	6	60	100	0,06	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
85	398534010200	6	60	100	0,06	-	-	-	-	-	-	398534010200	6	60	100	0,06	-	-	-	-	-	-	-	-	-
100	398534020400	9	80	140	0,15	-	-	-	-	-	-	398534010200	6	60	100	0,06	-	-	-	-	-	-	-	-	-
125	398534020400	9	80	140	0,15	-	-	-	-	-	-	398534410600	7	100	150	0,12	-	-	-	-	-	-	-	-	398534020400
140	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	398534020400	
160	398534030600	11	100	215	0,31	398546052900	7	7	100	215	0,31	398534410600	7	100	150	0,12	-	-	-	-	-	-	-	-	398534020400
200	398534030600	11	100	215	0,31	398575400100	11	7	120	215	0,36	398534420800	11	120	215	0,36	398532930800	14	165	270	0,90	-	-	-	398534020400
250	398534040800	14	120	310	0,62	398575401400	14	7	165	310	0,77	398534420800	11	120	215	0,36	398532940000	16	180	340	1,42	-	-	-	398534030600
315	398534040800	14	120	310	0,62	398575410300	14	11	165	310	0,77	398534430000	14	165	310	0,78	398532950100	18	240	400	2,14	-	-	-	-
400	398534050000	17	140	400	1,18	398575420500	17	11	213	400	1,66	398534430000	14	165	310	0,78	-	-	-	-	-	-	-	-	-
500	398534060100	19	140	450	1,44	398575430700	19	11	260	450	2,28	398534440100	17	230	450	1,76	-	-	-	-	-	-	-	-	-
630	398534060100	19	140	450	1,44	398575430700	19	11	260	450	2,28	398534440100	17	230	450	1,76	-	-	-	-	-	-	-	-	-
800	398534070300	19	140	650	1,97	-	-	-	-	-	-	398534450300	19	260	500	2,40	-	-	-	-	-	-	-	-	-
1000	398534070300	19	140	650	1,97	-	-	-	-	-	-	398534450300	19	260	500	2,40	-	-	-	-	-	-	-	-	-
1250	398534070300	19	140	650	1,97	-	-	-	-	-	-	398534450300	19	260	500	2,40	-	-	-	-	-	-	-	-	-

Futtergröße [mm]	Schraube 1*		Schraube 2*	
Chuck Size [mm]	Bolt 1*		Bolt 2*	
125	M8 x 20	100001484	M8 x 25	100001474
160	M10 x 20	100003252	M10 x 30	100003241
200	M10 x 20	100003252	M10 x 30	100003241
250	M12 x 25	100003301	M12 x 40	100001592
315	M12 x 25	100003301	M12 x 40	100001592
400	M16 x 30	100001587	M16 x 45	100003319
500	M20 x 40	100002416	M20 x 75	100003352
630	M20 x 40	100002416	M20 x 80	100003360
800	M20 x 40	100002416	M20 x 80	100003360

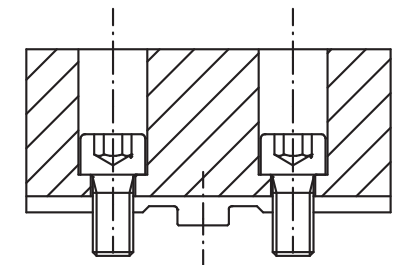
\* 3 Schrauben pro Satz • 3 Bolts per set

FÜR AUFSETZBACKEN • FÜR 3-BACKEN FUTTER  
FOR HARD TOP JAWS • FOR 3-JAW CHUCKS



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BACKENBEFESTIGUNGSSCHRAUBEN  
CLAMPING SCREWS



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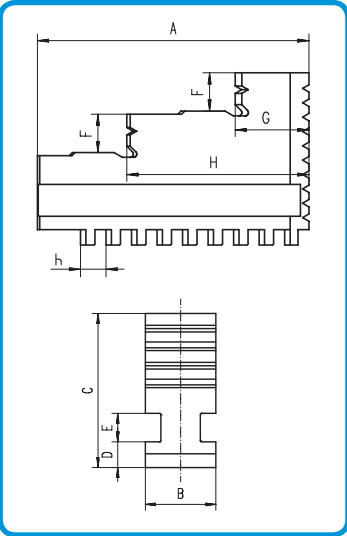
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**HARTE BACKEN • AUSSEN- INNENSPIANNUNG**  
**HARD SOLID JAWS • OUTSIDE-INSIDE CLAMPING**



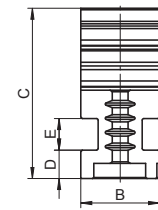
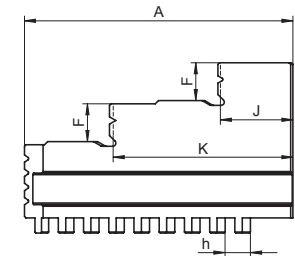
BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	h	kg / Stück
BISON Chuck Type	Chuck Size	Code No.										kg / pc.
32**, 35**	80	● 39853500900	32	11	28	6,0	6	6	9,5	21,0	4,0	0,03
3266	80	○ 398535002400										
32**, 35**	100	● 398535010000	42	15	31	6,0	6	7	11,0	27,0	6,0	0,1
36**, 37**	100	● 398538197000										
3266	100	○ 398535012600										
32**, 35**	125	● 398535020200	51	20	40	8,0	8	8	13,0	33,5	7,0	0,2
36**, 37**	125	● 398539020500										
38**	125	○ 398540020900										
3266	125	○ 398535022800										
32**, 35**	160	● 398535030400	70	20	53	8,0	8	10	19,0	45,0	8,0	0,4
36**, 37**	160	● 398539030700										
38**	160	○ 398540030000										
3266	160	● 398535030400										
32**, 35**	200	● 398535040600	85	25	54	9,0	10	12	23,0	57,0	8,0	0,5
36**, 37**	200	● 398539040900										
38**	200	○ 398540040200										
3266	200	● 398535040600										
32**, 35**	250	● 398535050800	105	28	63	11,0	12	14	28,0	69,5	9,0	0,8
36**, 37**	250	● 398539050000										
38**	250	○ 398540050400										
32**, 35**	315	● 398535060000	125	32	73	12,7	12	18	34,5	83,0	10,0	1,3
36**, 37**	315	● 398539060200										
38**	315	○ 398540060600										
32**, 35**	400	● 398535070100	145	36	92	15,0	14	22	36,0	99,0	12,0	2,4
36**, 37**	400	● 398539070400										
38**	400	○ 398540070800										
32**, 35**	500	● 398535080300	180	40	100	16,0	14	26	50,0	119,5	14,2	3,4
36**, 37**	500	○ 398539080600										
38**	500	○ 398540080000										
32**, 35**	630	● 398535090500	225	50	110	16,0	14	28	66,0	149,0	14,2	5,8
36**, 37**	630	○ 398539081900										
38**	630	○ 398534900900										
32**, 35**	800	● 398535090500	225	50	110	16,0	14	28	66,0	149,0	14,2	5,8
36**, 37**	800	○ 398539081900										
38**	800	○ 398534901100										
32**, 35**	1000	● 398535201300	291	70	140	22,0	20	34	85,0	190,0	18,0	14,3
36**, 37**	1000	● 398539082100										
38**	1000	● 398534902400										

Ø 80 - 1000 mm

SJZW



**HARTE BACKEN • AUSSENSPANNUNG**  
HARD SOLID JAWS • OUTSIDE CLAMPING



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	J	K	h	kg / Stück
BISON Chuck Type	Chuck Size	Code No.										kg / pc.
32**; 35**	80	● 398535100000	32	11	28	6,0	6	6	9,5	21,0	4,0	0,03
3266	80	○ 398535102500										
32**; 35**	100	● 398535110100										
37**	100	○ 398538198200	42	15	31	6,0	6	7	11,0	27,0	6,0	0,1
3266	100	○ 398535112700										
32**; 35**	125	● 398535120300										
36**; 37**	125	○ 398539120600										
38**	125	○ 398540120000	51	20	40	8,0	8	8	13,0	33,5	7,0	0,2
3266	125	○ 398535122900										
32**; 35**	160	● 398535130500										
36**; 37**	160	● 398539130800										
38**	160	○ 398540130100	70	20	53	8,0	8	10	19,0	45,0	8,0	0,4
3266	160	● 398535130500										
32**; 35**	200	● 398535140700										
36**; 37**	200	● 398539140000										
38**	200	○ 398540140300	85	25	54	9,0	10	12	23,0	57,0	8,0	0,5
3266	200	● 398535140700										
32**; 35**	250	● 398535150900										
36**; 37**	250	● 398539150100										
38**	250	○ 398540150500	105	28	63	11,0	12	14	28,0	69,5	9,0	0,8
32**; 35**	315	● 398535160000										
36**; 37**	315	○ 398539160300										
38**	315	○ 398540160700	125	32	73	12,7	12	18	34,5	83,0	10,0	1,3
32**; 35**	400	● 398535170200										
36**; 37**	400	● 398539170500										
38**	400	○ 398540170900	145	36	92	15,0	14	22	36,0	99,0	12,0	2,4
32**; 35**	500	● 398535180400										
36**; 37**	500	○ 398539180700										
38**	500	○ 398540180000	180	40	100	16,0	14	26	50,0	119,5	14,2	3,4
32**; 35**	630	● 398535190600										
36**; 37**	630	○ 398539181000										
38**	630	○ 398535197500	225	50	110	16,0	14	28	66,0	149,0	14,2	5,8
32**; 35**	800	● 398535190600										
36**; 37**	800	○ 398539181000										
38**	800	○ 398535198800	225	50	110	16,0	14	28	66,0	149,0	14,2	5,8
32**; 35**	1000	● 398535211500										
36**; 37**	1000	● 398539182200										
38**	1000	● 398535199000	291	70	140	22,0	20	34	85,0	190,0	18,0	14,3

Ø 80 - 1000 mm

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SJZ



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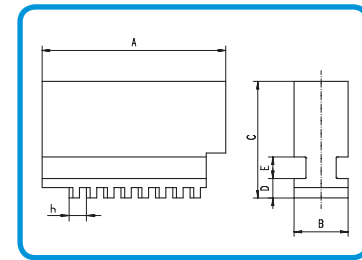
**HARTE EINTEILIGE UMKEHRBACKEN**  
 HARD SOLID JAWS • REVERSIBLE CLAMPING



	BISON Futter Typ	Futtergröße	Artikel Nr.
	BISON Chuck Type	Chuck Size	Code No.
Ø 49 - 160 mm	3286	49	● 398539914200
	3286	60	● 398539915500
	3866	80	● 398541110600
	3867	85	● 398541160500
	3868	85	● 398541210700
	3866	100	● 398541120800
	3867	110	● 398541170700
	3866	125	● 398541130000
	3866	160	● 398541140100
	3867	160	● 398541180900



**WEICHE MONOBLOCKBACKEN**  
SOFT SOLID JAWS



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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	h	kg / Stück
									BISON Chuck Type
32**; 35**	80	● 39853600700	32	11	28	6,0	6	4,0	0,1
32**; 35**	100	● 398536010900	42	15	31	6,0	6	6,0	0,1
37**	100	○ 398539810000							
32**; 35**	125	● 398536020000	51	20	40	8,0	8	7,0	0,3
36**; 37**	125	● 398539820200							
38**	125	○ 398540220000							
32**; 35**	160	● 398536030200	70	20	53	8,0	8	8,0	0,5
36**; 37**	160	● 398539830400							
38**	160	○ 398540230200							
32**; 35**	200	● 398536040400	85	25	54	9,0	10	8,0	0,8
36**; 37**	200	● 398539840600							
38**	200	○ 398540240400							
32**; 35**	250	● 398536050600	105	28	63	11,0	12	9,0	1,4
36**; 37**	250	● 398539850800							
38**	250	● 398540250600							
32**; 35**	315	● 398536060800	125	32	73	12,7	12	10,0	1,9
36**; 37**	315	● 398539860000							
38**	315	● 398540260800							
32**; 35**	400	● 398536070000	145	36	92	15,0	14	12,0	2,5
36**; 37**	400	● 398539870100							
38**	400	○ 398540270000							
32**; 35**	500	● 398536080100	180	40	100	16,0	14	14,2	5,00
36**; 37**	500	○ 398539880300							
38**	500	○ 398540280100							
32**; 35**	630	● 398536090300	225	50	110	16,0	14	14,2	8,4
36**; 37**	630	● 398539890500							
38**	630	○ 398540290300							
32**; 35**	800	● 398536092900	225	50	110	16,0	14	14,2	8,4
36**; 37**	800	● 398539891800							
38**	800	○ 398540291600							
32**; 35**	1000	○ 398536094400	290	70	140	22,0	20	18,0	20,3
36**; 37**	1000	○ 398539892000							
38**	1000	○ 398540292900							

Ø 80 - 1000 mm

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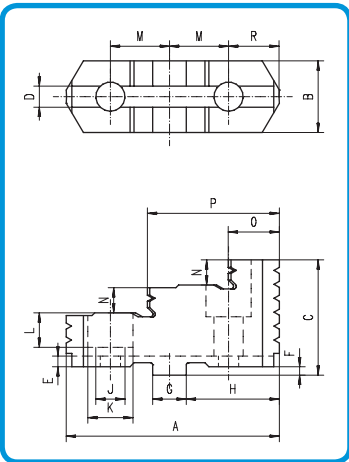
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**HARTE AUFSATZBACKEN**  
**HARD TOP JAWS**



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	kg / Stück
																			kg / pc.
BISON Chuck Type	Chuck Size	Code No.																	
32**, 35**	125	● 398532820500	56	22,0	38,5	7,95	4,0	3,2	12,69	22,6	9	15	10,0	16,00	8,0	14,5	35,0	13,0	0,2
36**, 37**	125	● 398537820600																	
38**	125	● 398540820600	56	22,0	38,5	7,95	4,0	3,2	12,69	22,6	6,6	11	10,0	16,00	8,0	14,5	35,0	13,0	0,2
32**, 35**	160	● 398532830700	67	25,0	41,5	7,95	4,0	3,2	12,69	28,6	11	18	12,0	19,05	8,5	18,0	41,5	16,0	0,3
36**, 37**	160	● 398537830800																	
38**	160	● 398540830800	67	25,0	41,5	7,95	4,0	3,2	12,69	28,6	9	14	12,0	19,05	8,5	18,0	41,5	16,0	0,3
32**, 35**	200	● 398532840900	80	27,0	43,5	7,95	4,0	3,2	12,69	34,9	11	18	12,0	22,25	9,5	21,5	51,0	19,0	0,4
36**, 37**	200	● 398537840000																	
38**	200	● 398540840000	80	27,0	43,5	7,95	4,0	3,2	12,69	34,9	9	14	12,0	22,25	9,5	21,5	51,0	19,0	0,4
32**, 35**	250	● 398532850000																	
36**, 37**	250	● 398537850100	95	32,5	51,5	12,71	4,0	3,2	19,04	39,7	14	20	14,5	27,00	12,0	24,5	59,0	22,0	0,6
38**	250	● 398540850100																	
32**, 35**	315	● 398532860200																	
36**, 37**	315	● 398537860300	110	37,0	55,0	12,71	4,0	3,2	19,04	47,6	14	20	14,5	31,75	13,0	26,5	68,0	35,4	0,9
38**	315	● 398540860300																	
32**, 35**	400	● 398532870400																	
36**, 37**	400	● 398537870500	127	42,0	64,5	12,71	4,0	6,3	19,04	57,1	18	26	18,5	38,10	13,5	27,0	76,5	28,5	1,4
38**	400	● 398540870500																	
32**, 35**	500	● 398532880600																	
36**, 37**	500	● 398537880700	127	42,0	74,5	12,71	4,0	6,3	19,04	57,1	22	33	21,0	38,10	17,0	50,0	88,0	28,5	1,6
38**	500	● 398540880700																	
32**, 35**	630	● 398532890800																	
36**, 37**	630	● 398537890900	127	52,0	82,0	12,71	4,0	6,3	19,04	57,1	22	33	21,0	38,10	21,0	51,0	89,0	28,5	2,4
38**	630	● 398540890900																	
32**, 35**	800	● 398532890800																	
36**, 37**	800	● 398537900300	127	52,0	82,0	12,71	4,0	6,3	19,04	57,1	22	33	21,0	38,10	21,0	51,0	89,0	28,5	2,4
38**	800	● 398540891100																	
32**, 35**	1000	● 398532800100																	
36**, 37**	1000	● 398537901600	175	75,0	97,0	12,71	4,5	6,3	19,04	95,2	24	35	23,0	38,10	28,0	48,0	124,0	67,0	5,5
38**	1000	● 398540892400																	

Ø 125 - 1000 mm

SGT

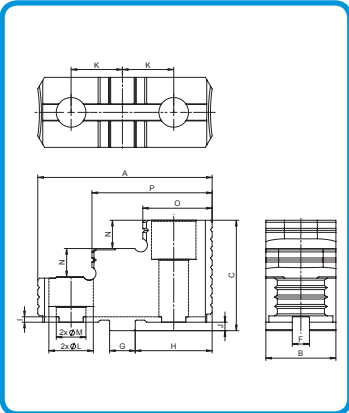


**HARTE AUFSATZBACKEN • 3597**  
 HARD TOP JAWS • 3597



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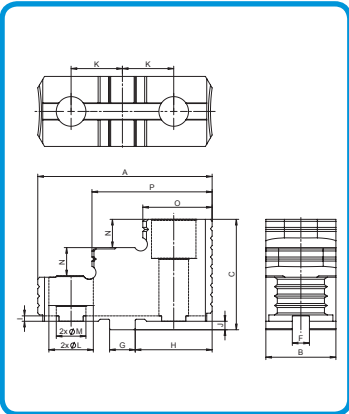
BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	F	G	H	I	J	K	M	L	N	O	P	kg / Stück	
			BISON Chuck Type	Chuck Size	Code No.	kg / pc.												
Ø 315 - 1000 mm	3597	160	● 398532830700	67	25	41,5	7,95	12,69	28,6	4	3,2	19,05	11	17	8,5	18	41,5	0,3
	3597	200	● 398532840900	80	27	43,5	7,95	12,69	34,9	4	3,2	22,25	11	17	9,5	20,5	50	0,4
	3597	250	● 398532850000	95	32,5	51,5	12,71	19,04	39,7	4	3,2	27	14	21	12	33,5	68	0,6
	3597	315	● 398538060400	110	37	55	12,71	19,04	47,6	4	3,2	31,75	14	21	13	26,5	68,0	0,9
	3597	405	● 398538104500	127	42	64,5	12,71	19,04	51,7	4	6,3	38,10	18	26	13,5	26,5	76,5	1,4
	3597	515	● 398538114700	127	42	74,5	12,71	19,04	51,7	4	6,3	38,10	22	33	17	51	89,0	1,6
	3597	660	● 398538127700	127	52	82	12,71	19,04	51,7	4	6,3	38,10	22	33	21	51	86,5	2,4
	3597	800	● 398538137900	127	52	82	12,71	19,04	51,7	4	6,3	38,10	22	33	21	51	89,0	2,3
	3597	1000	● 398532800100	175	75	97	12,71	19,04	95,2	4,5	6,3	38,10	24	35	28	50,5	75,8	5,6



**HARTE AUFSATZBACKEN • HD**  
 HARD TOP JAWS • HD



BISON Futter Typ	Artikel Nr.	A	B	C	F	G	H	I	J	K	M	L	N	O	P	kg / Stück	
		BISON Chuck Type	Code No.	kg / pc.													
Ø 400 - 1000 mm	3515-16" HD	● 398532869700	135	54	82	12,71	19,04	57,1	4	6,3	38,1	22	33	21	54,5	88,0	2,45
	3515-20" HD	● 398532883400	135	54	82	12,71	19,04	57,1	4	6,3	38,1	22	33	21	54,7	87,6	2,45
	3515-25" HD	● 398532888800	135	75	97	12,71	19,04	57,1	4	6,3	38,1	24	35	28	56,6	59,5	4,10
	3515-32" HD	● 398532893600	135	75	97	12,71	19,04	57,1	4	6,3	38,1	24	35	28	56,3	59,1	4,10



- SGT 3597
- SGT HD



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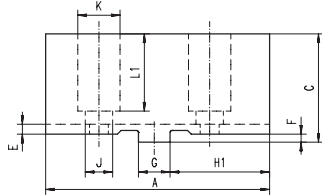
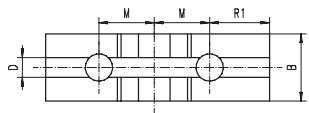
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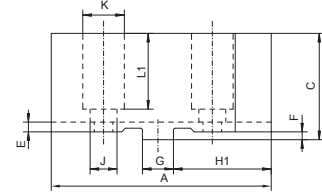
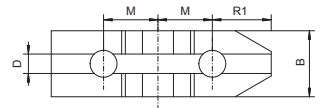
**WEICHE AUFSATZBACKEN**  
 SOFT TOP JAWS



Ausführung 1  
 Version 1



Ausführung 2  
 Version 2



BISON Futter Typ	Futtergröße	Artikel Nr.	Ausführung	A	B	C	D	E	F	G	H1	J	K	L <sub>1</sub>	M	kg / Stück	
BISON Chuck Type	Chuck Size	Code No.	Version														kg / pc.
32**, 35**	125	● 398533020600	1	64	22,0	46,5	7,95	4,0	3,2	12,69	25	9	15	26,0	16,00	0,3	
36**, 37**	125	● 398538220900															
38**	125	○ 398540722000	2	64	22,0	46,5	7,95	4,0	3,2	12,69	25	6,6	11	26,0	16,00	0,3	
3105	160	● 398530530800			40,0												
32**, 35**	160	● 398533030800	1	78	25,0	41,5	7,95	4,0	3,2	12,69	34	11	18	29,0	19,05	0,5	
36**, 37**	160	● 398538230000															
38**	160	○ 398540732200	2	78	25,0	41,5	7,95	4,0	3,2	12,69	34	9	14	29,0	19,05	0,5	
3105	200	● 398530540000	1	90	40,0	41,5	7,95	4,0	3,2	12,69	40	11	14	31,0	22,25	0,7	
32**, 35**	200	● 398533040000	1	90	27,0	43,5	7,95	4,0	3,2	12,69	40	11	18	31,0	22,25	0,7	
36**, 37**	200	● 398538240200															
38**	200	● 398540742400	2	90	27,0	43,5	7,95	4,0	3,2	12,69	40	9	14	31,0	22,25	0,7	
3105	250	○ 398530550100			47												
32**, 35**	250	● 398533050100	1	106	32,5	51,5	12,71	4,0	3,2	19,04	45	14	20	38,0	27,00	1,2	
36**, 37**	250	● 398538250400															
38**	250	○ 398540752600	2														
3105	315	○ 398530560300			52,0												
32**, 35**	315	● 398533060300	1	120	37,0	55,0	12,71	4,0	3,2	19,04	53	14	20	40,0	31,75	1,6	
36**, 37**	315	● 398538260600															
38**	315	○ 398540762800	2														
3105	400	○ 398530570500			52,0												
32**, 35**	400	● 398533070500	1	140	42,0	64,5	12,71	4,0	6,3	19,04	63	18	26	45,5	38,10	2,2	
36**, 37**	400	● 398538270800															
38**	400	● 398540772000	2														
32**, 35**	500	● 398533080700															
36**, 37**	500	● 398538280000	1	140	42,0	74,5	12,71	4,0	6,3	19,04	63	22	33	56,0	38,10	2,4	
38**	500	○ 398540780600															
32**, 35**	630	● 398533090900															
36**, 37**	630	● 398538290100	1	160	52,0	82,0	12,71	4,0	6,3	19,04	63	22	33	64,0	38,10	4,2	
38**	630	○ 398540790800															
32**, 35**	800	● 398533090900															
36**, 37**	800	● 398538290100	1	160	52,0	82,0	12,71	4,0	6,3	19,04	63	22	33	64,0	38,10	4,2	
38**	800	○ 398540790800															
32**, 35**	1000	● 398533093700															
36**, 37**	1000	○ 398538292700	1	191	75,0	97,0	12,71	4,5	6,3	19,04	105	24	35	78,0	38,10	10,0	
38**	1000	○ 398540700100															

Ø 125 - 1000 mm

SGM



**HARTE GRUNDBACKEN  
 HARD MASTER JAWS**



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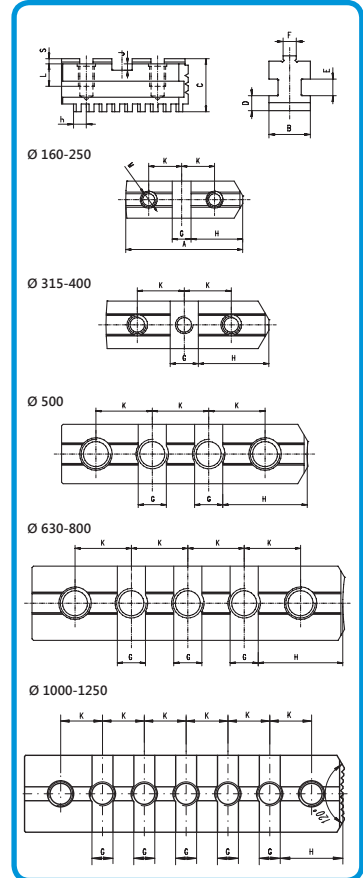
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	S	h	kg / Stück	
BISON Chuck Type	Chuck Size	Code No.																kg / pc.
32**, 35**	125	● 398535720900	54	20	28,0	8,0	8	7,94	12,69	22,6	4,0	16,00	13,5	M8	3,2	7,0	0,1	
36**, 37**	125	● 398539620000																
38**	125	● 398540920700	54	20	28,0	8,0	8	7,94	12,69	22,6	4,0	16,00	13,5	M6	3,2	7,0	0,1	
3105	160	● 398530710600																
32**, 35**	160	● 398535730000	65	20	29,0	8,0	8	7,94	12,69	28,6	4,0	19,05	14,0	M10	3,2	8,0	0,2	
36**, 37**	160	● 398539630200																
38**	160	● 398540930900	65	20	29,0	8,0	8	7,94	12,69	28,6	4,0	19,05	14,0	M8	3,2	8,0	0,2	
3105	200	● 398530720800																
32**, 35**	200	● 398535740200	79	25	33,0	9,0	10	7,94	12,69	34,9	4,0	22,25	14,0	M10	3,2	8,0	0,3	
36**, 37**	200	● 398539640400																
38**	200	● 398540940000	79	25	33,0	9,0	10	7,94	12,69	34,9	4,0	22,25	14,0	M8	3,2	8,0	0,3	
3105	250	● 398530730000																
32**, 35**	250	● 398535750400																
36**, 37**	250	● 398539650600	92	28	36,0	11,0	12	12,7	19,04	39,7	4,0	27,00	16,0	M12	3,2	9,0	0,5	
38**	250	● 398540950200																
3105	315	● 398530740100																
32**, 35**	315	● 398535760600	110	32	40,0	12,7	12	12,7	19,04	47,6	4,0	31,75	16,0	M12	3,2	10,0	0,8	
36**, 37**	315	● 398539660800																
38**	315	● 398540960400																
3105	400	● 398530790000																
32**, 35**	400	● 398535770800	130	36	49,0	15,0	14	12,7	19,04	57,1	7,2	38,10	22,0	M16	3,2	12,0	1,1	
36**, 37**	400	● 398539670000																
38**	400	● 398540970600																
32**, 35**	500	● 398535780000																
36**, 37**	500	● 398539680100	166	40	54,0	16,0	14	12,7	19,04	57,1	7,2	38,10	32,5	M20	3,2	14,2	2,2	
38**	500	● 398540980800																
32**, 35**	630	● 398535790100																
36**, 37**	630	● 398539681400	210	50	54,5	16,0	14	12,7	19,04	57,1	7,2	38,10	32,5	M20	3,2	14,2	3,3	
38**	630	● 398540990000																
32**, 35**	800	● 398535800600																
36**, 37**	800	● 398539682700	225	50	54,5	16,0	14	12,7	19,04	57,1	7,2	38,10	32,5	M20	3,2	14,2	3,4	
38**	800	● 398540991200																
32**, 35**	1000	● 398532801400																
36**, 37**	1000	● 398539683000	328	70	64,0	22,0	20	12,7	19,04	57,1	7,2	38,10	36,0	M22	3,2	18,0	7,8	
38**	1000	● 398540992500																

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery



SP

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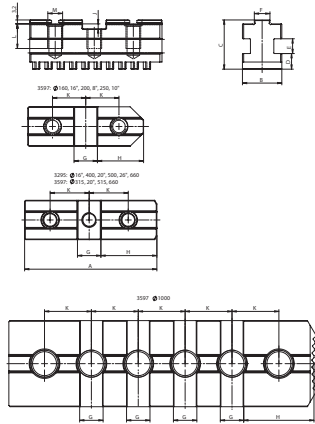
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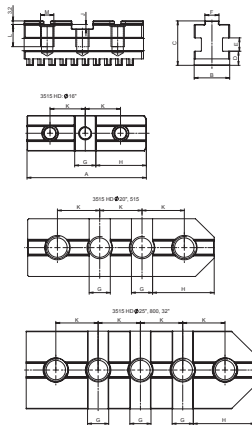
**HARTE GRUNDBACKEN • 3295 UND 3597**  
 HARD MASTER JAWS • 3295 AND 3597



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	kg / Stück	
															kg / pc.	
BISON Chuck Type	Chuck Size	Code No.														
Ø 315 - 1000 mm	3295	400	398539986000	120	36	49	15	14	12,7	19,04	57,1	7,2	38,1	22	M16	1,1
	3295	500	398539987300	120	40	54	16	14	12,7	19,04	57,1	7,2	38,1	32,5	M20	1,3
	3295	660	398539984500	127	50	54,5	16	14	12,7	19,04	54	7,2	38,1	32,5	M20	1,8
	3597	315	398538050200	107,5	32	40	12,7	12	12,7	19,04	45,1	4	31,75	20	M12	0,7
	3597	405	398539986000	120	36	49	15	14	12,7	19,04	57,1	7,2	38,1	22	M16	1,1
	3597	515	398539987300	120	40	54	16	14	12,7	19,04	57,1	7,2	38,1	32,5	M20	1,3
	3597	660	398538126400	127	50	54,5	16	14	12,7	19,04	57,1	7,2	38,1	32,5	M20	1,3
	3597	800	398538136600	160	50	54,5	16	14	12,7	19,04	57,1	7,2	38,1	32,5	M20	2,3
	3597	1000	398538146800	250	70	64	22	20	12,7	19,04	57,1	7,2	38,1	40	M22	6,1

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery

**HARTE GRUNDBACKEN • HD**  
 HARD MASTER JAWS • HD



BISON Futter Typ	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	kg / Stück	
														kg / pc.	
BISON Chuck Type	Code No.														
Ø 400 - 800 mm	3515-16" HD	398535972500	132	50	54,5	16	14	12,7	19,04	57,1	7,2	38,1	32,5	3/4"	1,95
	3515-20" HD	398535982700	169	50	54,5	16	14	12,7	19,04	57,1	7,2	38,1	32,5	3/4"	2,50
	3515-25" HD	398535988300	210	70	62	20	20	12,7	19,04	57,1	7,2	38,1	33	7/8"	5,10
	3515-32" HD	398535995700	225	70	62	20	20	12,7	19,04	57,1	7,2	38,1	33	7/8"	5,50

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery

SP 3597

SP HD



**HARTE GETEILTE UMKEHRBACKEN**  
 HARD 2-PC REVERSIBLE JAWS



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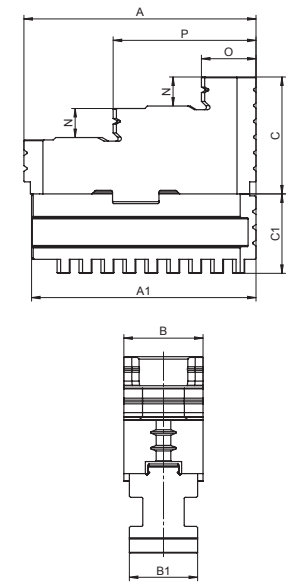
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	A1	B	B1	C	C1	N	O	P	kg / Stück	
BISON Chuck Type	Chuck Size	Code No.										kg / pc.	
Ø 125 - 1000 mm	32**; 35**	125											
	36**; 37**	125	56	54	22,0	20	35,3	24,8	8,0	14,5	35,0	0,3	
	38**	125											
	32**; 35**	160											
	36**; 37**	160	67	65	25,0	20	38,3	25,8	8,5	18,0	41,5	0,4	
	38**	160											
	32**; 35**	200											
	36**; 37**	200	80	79	27,0	25	38,3	29,8	9,5	21,5	51,0	0,7	
	38**	200											
	32**; 35**	250											
	36**; 37**	250	95	92	32,5	28	48,3	32,8	12,0	24,5	59,0	1,1	
	38**	250											
	32**; 35**	315											
	36**; 37**	315	110	110	37,0	32	51,8	36,8	13,0	26,5	68,0	1,7	
	38**	315											
32**; 35**	400												
36**; 37**	400	127	130	42,0	36	58,2	45,8	13,5	27,0	76,5	2,5		
38**	400												
32**; 35**	500												
36**; 37**	500	127	166	42,0	40	68,2	50,8	17,0	50,0	88,0	3,8		
38**	500												
32**; 35**	630												
36**; 37**	630	127	210	52,0	50	75,7	51,3	21,0	51,0	89,0	5,8		
38**	630												
32**; 35**	800												
36**; 37**	800	127	225	52,0	50	75,7	51,3	21,0	51,0	89,0	6,1		
38**	800												
32**; 35**	1000												
36**; 37**	1000	175	328	75,0	70	90,7	60,8	28,0	48,0	124	14,0		
38**	1000												



**SDT**



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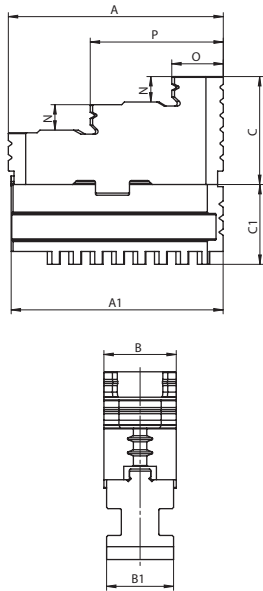
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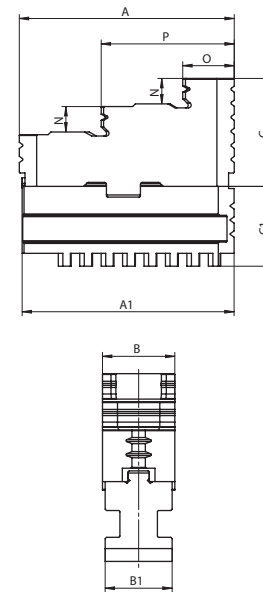
**HARTE GETEILTE UMKEHRBACKEN • 3597**  
 HARD 2-PC REVERSIBLE JAWS • 3597



BISON Futter Typ BISON Chuck Type	Futtergröße Chuck Size	Artikel Nr. Code No.	A	A1	B	B1	C	C1	N	O	P	kg / Stück	
												kg / pc.	
Ø 315 - 1000 mm	3597	315	398538070600	110	107,5	37	32	51,8	36,8	13	26,5	68	1,7
	3597	405	398538102000	127	120	42	36	58,2	45,8	13,5	26,5	76,5	2,7
	3597	515	398538111900	127	120	42	40	68,2	50,8	17	51	89	3,2
	3597	660	398538125100	127	127	52	50	75,8	51,3	21	51	86,5	4,6
	3597	800	398538135300	127	160	52	50	75,8	51,3	21	51	89	5,1
	3597	1000	398538145500	175	250	75	70	90,7	60,8	28	50,5	75,5	12,1

SDT 3597

SDT HD



**HARTE GETEILTE UMKEHRBACKEN • HD**  
 HARD 2-PC REVERSIBLE JAWS • HD



BISON Futter Typ BISON Chuck Type	Artikel Nr. Code No.	A	A1	B	B1	C	C1	N	O	P	kg / Stück	
											kg / pc.	
Ø 400 - 800 mm	3515-16" HD	398535471800	135	132	54	50	75,7	51,3	21	54,5	88	4,76
	3515-20" HD	398535478700	135	169	54	50	75,7	51,3	21	54,7	87,6	5,30
	3515-25" HD	398535489100	135	210	75	70	83,7	58,8	28	56,6	89,5	9,96
	3515-32" HD	398535497800	135	225	75	70	83,7	58,8	28	56,3	89,1	9,96



**WEICHE GETEILTE BACKEN**  
SOFT 2-PC JAWS



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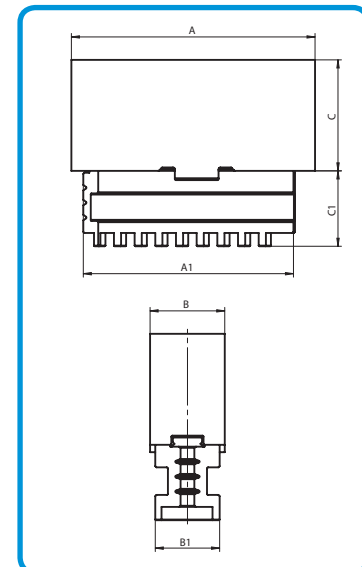
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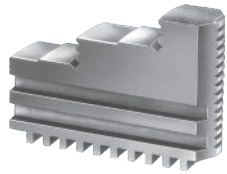
BISON Futter Typ BISON Chuck Type	Futtergröße Chuck Size	Artikel Nr. Code No.	A	A1	B	B1	C	C1	kg / Stück
									kg / pc.
32**; 35**	125	● 398535520700							
36**; 37**	125	○ 398539420900	64	54	22,0	20	35,3	24,8	0,4
38**	125	○ 398540521600							
3105	160	○ 398530010000							
32**; 35**	160	● 398535530900	78	65	25,0	20	38,3	25,8	0,6
36**; 37**	160	○ 398539430000							
38**	160	○ 398540531800							
3105	200	○ 398530020100							
32**; 35**	200	● 398535540000	90	79	27,0	25	38,3	29,8	1,0
36**; 37**	200	○ 398539440200							
38**	200	○ 398540541000							
3105	250	○ 398530030300							
32**; 35**	250	● 398535550200	106	92	32,5	28	48,3	32,8	1,6
36**; 37**	250	○ 398539450400							
38**	250	○ 398540551100							
3105	315	○ 398530040500							
32**; 35**	315	● 398535560400	120	110	37,0	32	51,8	36,8	3,1
36**; 37**	315	○ 398539460600							
38**	315	○ 398540561300							
3105	400	○ 398530110000							
32**; 35**	400	● 398535570600	140	130	42,0	36	58,2	45,8	3,3
36**; 37**	400	○ 398539470800							
38**	400	○ 398540571500							
32**; 35**	500	○ 398535580800							
36**; 37**	500	○ 398539480000	140	166	42,0	40	68,2	50,8	4,6
38**	500	○ 398540580400							
32**; 35**	630	○ 398535590000							
36**; 37**	630	○ 398539490100	160	210	52,0	50	75,7	51,3	7,5
38**	630	○ 398535601700							
32**; 35**	800	○ 398535600400							
36**; 37**	800	○ 398539491400	160	225	52,0	50	75,7	51,3	7,6
38**	800	○ 398535602000							
32**; 35**	1000	○ 398535611900							
36**; 37**	1000	○ 398539492700	191	328	75,0	70	90,7	60,8	17,8
38**	1000	○ 398535603200							

Ø 125 - 1000 mm



SDM

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**HARTE BACKEN • AUSSEN- INNENSPANNUNG**  
 HARD SOLID JAWS • OUTSIDE-INSIDE CLAMPING



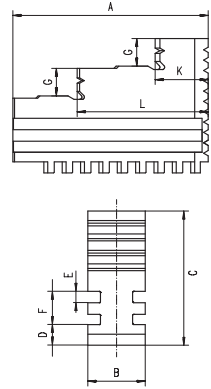
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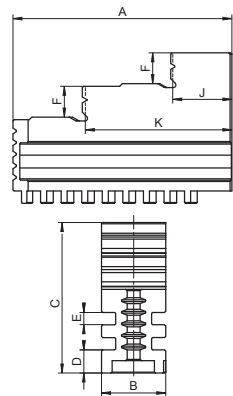
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	K	L	kg / Stück
												kg / pc.
BISON Chuck Type	Chuck Size	Code No.										
Ø 160 - 630 mm	3202; 3203	160	70	20	56	8,0	6	18	12	19	45,0	0,5
	3602; 3603	160										0,5
	3202; 3203	200	85	25	62	9,0	6	18	12	23	57,0	0,6
	3602; 3603	200										0,6
	3202; 3203	250	105	28	74	11,0	8	23	15	28	69,5	1,1
	3602; 3603	250										1,1
	3202; 3203	315	125	32	90	12,7	10	29	19	34	83,0	1,7
	3602; 3603	315										1,7
	3202; 3203	400	145	36	107	15,0	10	29	22	36	99,0	2,7
	3602; 3603	400										2,7
	3202; 3203	500	180	40	120	16,0	12	34	26	50	119,5	4,9
	3602; 3603	500										4,9
	3202; 3203	630	225	50	130	16,0	12	34	28	66	149,0	7,7
	3602; 3603	630										7,7

SJZW

SJZ



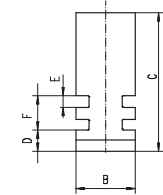
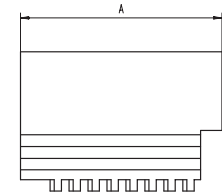
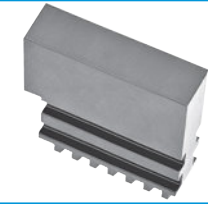
**HARTE BACKEN • AUSSENSPANNUNG**  
 HARD SOLID JAWS • OUTSIDE CLAMPING



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	J	K	kg / Stück
												kg / pc.
BISON Chuck Type	Chuck Size	Code No.										
Ø 160 - 630 mm	3202; 3203	160	70	20	56	8,0	6	18	12	23	45,0	0,5
	3602; 3603	160										0,5
	3202; 3203	200	85	25	62	9,0	6	18	12	23	57,0	0,6
	3602; 3603	200										0,6
	3202; 3203	250	105	28	74	11,0	8	23	15	28	69,5	1,1
	3602; 3603	250										1,1
	3202; 3203	315	125	32	90	12,7	10	29	19	34	83,0	1,7
	3602; 3603	315										1,7
	3202; 3203	400	145	36	107	15,0	10	29	22	36	99,0	2,7
	3602; 3603	400										2,7
	3202; 3203	500	180	40	120	16,0	12	34	26	50	119,5	4,9
	3602; 3603	500										4,9
	3202; 3203	630	180	40	120	16,0	12	34	26	66	119,5	4,9
	3602; 3603	630										4,9



**WEICHE MONOBLOCKBACKEN**  
 SOFT SOLID JAWS



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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	kg / Stück
BISON Chuck Type	Chuck Size	Code No.							kg / pc.
3202; 3203	160	● 398533110500	70	20	56	8,0	6	18	0,5
3602; 3603	160	● 398537110800							
3202; 3203	200	● 398533120700	85	25	62	9,0	6	18	0,6
3602; 3603	200	● 398537120000							
3202; 3203	250	● 398533130900	105	28	74	11,0	8	23	1,1
3602; 3603	250	● 398537130100							
3202; 3203	315	● 398533140000	125	32	90	12,7	10	29	1,7
3602; 3603	315	● 398537140300							
3202; 3203	400	● 398533150200	145	36	107	15,0	10	29	3,8
3602; 3603	400	● 398537150500							
3202; 3203	500	● 398533160400	180	40	120	16,0	12	34	8,8
3602; 3603	500	● 398537160700							
3202; 3203	630	● 398533170600	225	50	130	16,0	12	34	10,2
3602; 3603	630	● 398537170900							

Ø 160 - 630 mm

**SJM**



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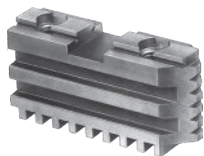
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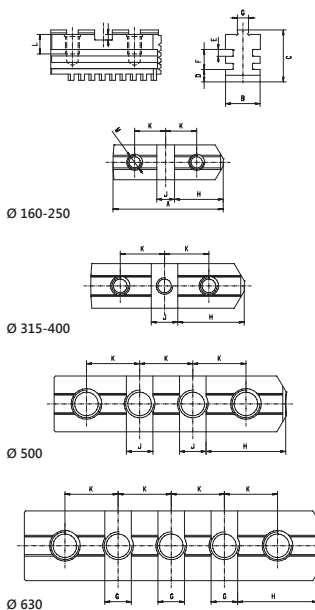
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**HARTE GRUNDBACKEN**  
 HARD MASTER JAWS



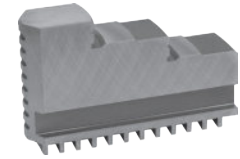
BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	kg / Stück
BISON Chuck Type	Chuck Size	Code No.													kg / pc.
3202; 3203	160	● 398533810100	65	20	39	8,0	6	18	7,94	28,6	12,69	19,05	15,0	2xM10	0,3
3602; 3603	160	○ 398536910700													
3202; 3203	200	● 398533820300	79	25	41	9,0	6	18	7,94	34,9	12,69	22,25	14,0	2xM10	0,4
3602; 3603	200	○ 398536920900													
3202; 3203	250	● 398533830500	92	28	47	11,0	8	23	12,7	39,7	19,04	27,00	16,0	2xM10	0,6
3602; 3603	250	○ 398536930000													
3202; 3203	315	● 398533840700	110	32	57	12,7	10	29	12,7	47,6	19,04	31,75	16,0	3xM12	1,1
3602; 3603	315	○ 398536940200													
3202; 3203	400	○ 398533850900	130	36	64	15,0	10	29	12,7	57,1	19,04	38,10	18,8	3xM16	1,6
3602; 3603	400	○ 398536950400													
3202; 3203	500	○ 398533860000	166	40	74	16,0	12	34	12,7	57,1	19,04	38,10	32,5	4xM20	2,6
3602; 3603	500	○ 398536960600													
3202; 3203	630	○ 398533800000	210	50	74	16,0	12	34	12,7	57,1	19,04	38,10	32,5	5xM20	3,8
3602; 3603	630	○ 398536961900													

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery

SP



**HARTE BACKEN • AUSSEN- INNENSPIANNUNG**  
 HARD SOLID JAWS • OUTSIDE-INSIDE CLAMPING



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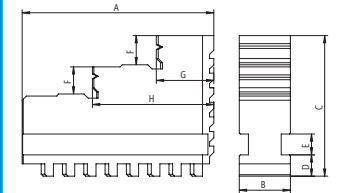
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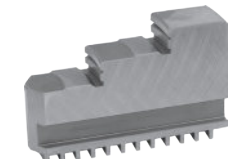
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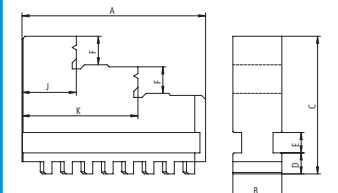
RÖHM Futter Typ	Artikel Nr.	A	B	C	D	E	F	G	H	kg / Stück
										RÖHM Chuck Type
ZG-125/3; ZS-125/3	● 398531730800	52	18	41,5	7,3	7	8	17	35	0,2
ZG-140/3; ZS-140/3	● 398531740000	61	18	41,5	8,2	7	8	18	40	0,2
ZG-160/3; ZS-160/3	● 398531750100	61	18	47,5	8,2	7	10	18	40	0,2
ZG-200/3; ZS-200/3	● 398531760300	69	20	53,5	8,2	8	10	20	44	0,4
ZG-250/3; ZS-250/3	● 398531780700	90	24	67,5	10,3	10	14	27	57	0,7
ZG-315/3; ZS-315/3	● 398531800300	130	34	79,5	11,2	15	15	41,5	86,5	1,8



**HARTE BACKEN • AUSSENSPIANNUNG**  
 HARD SOLID JAWS • OUTSIDE CLAMPING



RÖHM Futter Typ	Artikel Nr.	A	B	C	D	E	F	G	H	kg / Stück
										RÖHM Chuck Type
ZG-125/3; ZS-125/3	● 398531870600	52	18	41,5	7,3	7	8	16	34	0,2
ZG-140/3; ZS-140/3	● 398531880800	61	18	41,5	8,2	7	8	17	39	0,2
ZG-160/3; ZS-160/3	● 398531890000	61	18	47,5	8,2	7	10	17	39	0,2
ZG-200/3; ZS-200/3	● 398531900400	69	20	53,5	8,2	8	10	19	43	0,4
ZG-250/3; ZS-250/3	● 398531920800	90	24	67,5	10,3	10	14	26	56	0,7
ZG-315/3; ZS-315/3	● 398531940100	130	34	79,5	11,2	15	15	40	85	1,8



SJZW RÖHM

SJZ RÖHM

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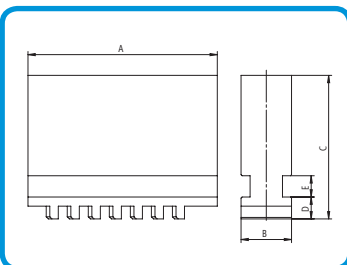
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**WEICHE MONOBLOCKBACKEN**  
 SOFT SOLID JAWS



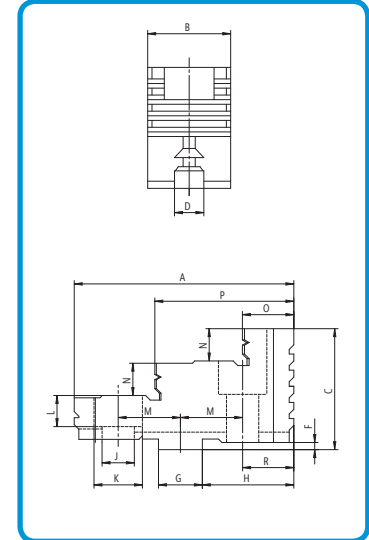
RÖHM Futter Typ RÖHM Chuck Type	Artikel Nr. Code No.	A	B	C	D	E	kg / Stück
							kg / pc.
ZG-80/3; ZS-80/3	398538320000	37	12	26	4,8	4,5	0,1
ZG-100/3; ZS-100/3	398538301900	48	14	33,5	6,3	6	0,2
ZG-110/3; ZS-110/3	398538301900	48	14	33,5	6,3	6	0,2
ZG-125/3; ZS-125/3	398538302100	52	18	41,5	7,3	7	0,3
ZG-140/3; ZS-140/3	398538303400	61	18	41,5	8,2	7	0,3
ZG-160/3; ZS-160/3	398538304700	61	18	47,5	8,2	7	0,4
ZG-200/3; ZS-200/3	398538305000	69	20	53,5	8,2	8	0,5
ZG-250/3; ZS-250/3	398538306200	90	24	67,5	10,3	10	1,0
ZG-315/3; ZS-315/3	398538307500	130	34	79,5	11,2	15	2,4

Ø 80 - 315 mm

SJM RÖHM



**HARTE AUFSATZBACKEN**  
 HARD TOP JAWS

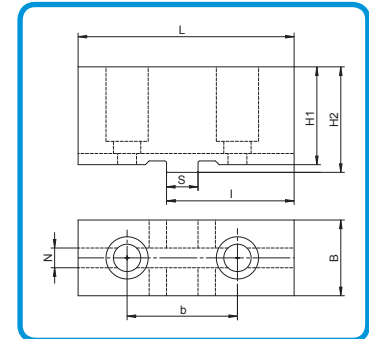


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Ø 125 - 315 mm	RÖHM Futter Typ	Artikel Nr.	A	B	C	D	F	G	H	J	K	L	M	N	O	P	R	kg / Stück
	RÖHM Chuck Type	Code No.	kg / pc.															
	ZG-125/3; ZS-125/3	● 398537710300	56	26	37,5	7,96	3,1	12,68	22,6	9	15	9	16	8	13	35	13	0,2
	ZG-140/160/3; ZS-140/160/3	● 398537720500	66,7	28	41,5	7,96	3,1	12,68	28,5	9	15	10	19,05	10	15,8	42,8	15,8	0,3
	ZG-200/230/3; ZS-200/230/3	● 398537730700	79,5	30	42,5	7,96	3,1	12,68	34,9	9	15	10	22,23	10	19	51,5	19	0,4
	ZG-250/270/3; ZS-250/270/3	● 398537740900	95,3	36	52,5	12,72	3,1	19,03	39,7	14	20	13,5	26,98	14	22,2	60,2	22,2	0,7
	ZG-315/3; ZS-315/3	● 398537750000	109,5	42	57,5	12,72	3,1	19,03	47,6	14	20	13,5	31,75	15	25,4	67,4	25,4	1,0



**WEICHE AUFSATZBACKEN**  
 SOFT TOP JAWS



- SGT RÖHM
- SGM RÖHM

Ø 125 - 800 mm	RÖHM Futter Typ	Artikel Nr.	Backen Typ	N	S	B	H <sub>1</sub>	H <sub>2</sub>	L	b	I	Schrauben	kg / Stück
	RÖHM Chuck Type	Code No.	Jaw Type	Screws									
	ZGU 125; ZSU 125; ZGF 125	● 398525426500	SGM Z4PS 125-01	7,96	12,67	26	38	35,0	62	32,0	25,6	M 8	0,4
	ZGU 160; ZGU 140; ZSU 160; ZSU 140; ZGF 160	● 398525427800	SGM Z4PS 160-01	7,96	12,67	30	45	42,0	74	38,1	32,2	M 8	0,6
	ZGU 200; ZGD 200-230; ZSU 200; UGU 200; ZGF 250; USU 260	● 398525428000	SGM Z4PS 200-01	7,96	12,67	30	50	47,0	87	44,5	38,7	M 8	0,8
	ZGU 250; ZGD 250-270; ZSU 250; UGU 260; ZGF 250; USU 260	● 398525429300	SGM Z4PS 250-01	12,72	19,02	35	60	57,0	103	54,0	43,5	M 12	1,3
		● 398525430000	SGM Z4PS 250-10	12,72	19,02	50	60	57,0	118	54,0	40,5	M 16	2,2
		● 398525431300	SGM Z4PS 315-10	12,72	19,02	50	60	53,7	137	63,5	47,5	M 16	2,5
	ZGU 315; ZGD 315; ZSU 315; UGU 310-350; ZGF 350-400; USU 400-450	● 398525432600	SGM Z4PS 315-01	12,72	19,02	40	60	57,0	120	63,5	53,0	M 12	1,8
	ZGU 350-400; ZGD 400; ZSU 350-400; UGU 400-450; ZGF 350-400; USU 400-450	● 398525433900	SGM Z4PS 350-01	12,72	19,02	50	80	73,7	137	76,2	62,0	M 16	3,4
	ZGU 500-630-700; ZGD 500; ZSU 500-630-700; UGU 500-560-600-630-710; USU 500-560-600-630-710	● 398525434100	SGM Z4PS 500-01	12,72	19,02	50	80	73,7	140	76,2	63,5	M 20	3,2
	HS 630-700-800; ZGU 800; ZSU 800; UGU 800; USU 800; HS 1000-1250; ZGU 1000-1250; ZSU 1000-1250	● 398525435400	SGM Z4PS 800-01	12,72	19,02	60	100	93,7	210	76,2	70,0	M 20	8,0



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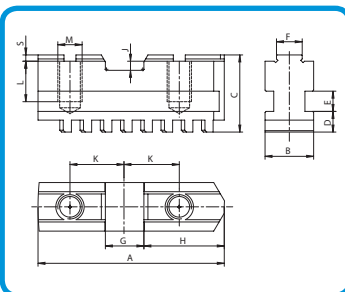
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**HARTE GRUNDBACKEN**  
 HARD MASTER JAWS



	RÖHM Futter Typ	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	S	kg / Stück
	RÖHM Chuck Type	Code No.	kg / pc.													
<b>Ø 125 - 315 mm</b>	ZG-125/3; ZS-125/3	398535711000	55	18	27,1	7,3	7	7,94	12,69	22,6	4,5	16	14,5	M8	3,1	0,1
	ZG-140/3; ZS-140/3	398535712200	65	18	30,1	8,2	7	7,94	12,69	28,5	4,5	19,05	16	M8	3,1	0,2
	ZG-160/3; ZS-160/3	398535713500	65	18	30,1	8,2	7	7,94	12,69	28,5	4,5	19,05	16	M8	3,1	0,2
	ZG-200/3; ZS-200/3	398535714800	78	20	31,1	8,2	8	7,94	12,69	34,9	4,5	22,225	16	M8	3,1	0,2
	ZG-250/3; ZS-250/3	398535715000	92	24	38,1	10,2	10	12,7	19,04	39,7	4,5	27	20	M12	3,1	0,4
	ZG-315/3; ZS-315/3	398535716300	108	34	43,1	11,2	15	12,7	19,04	47,6	4,5	31,75	25	M12	3,1	0,8

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery



**HARTE BACKEN**  
 HARD SOLID JAWS



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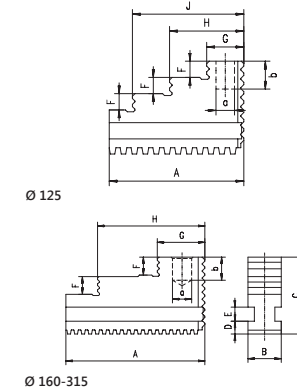
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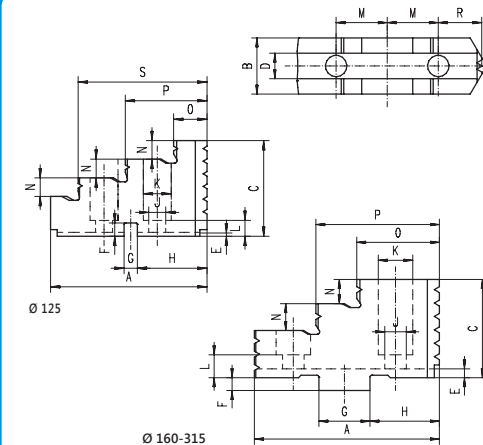
BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	a	b	kg / Stück	
														BISON Chuck Type	Chuck Size
Ø 125 - 315 mm	34**	125	● 398530910800	58,0	14	40	6,5	7	7,0	16,0	32,0	48	8	12	0,4
	34**	160	● 398530920000	69,0	20	45	7,5	9	8,0	26,0	58,0	-	10	12	1,0
	34**	200	● 398530930100	90,0	22	50	8,0	9	11,5	33,0	72,5	-	12	15	1,5
	34**	250	● 398530940300	108,5	26	60	10,0	11	14,0	36,0	83,0	-	15	20	2,6
	34**	315	● 398530950500	132,0	32	70	12,0	14	17,0	41,5	104,5	-	20	20	4,4



**HARTE AUFSATZBACKEN**  
 HARD TOP JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	S	kg / Stück	
																				BISON Chuck Type	Chuck Size
Ø 125 - 315 mm	34**	125	● 398531081300	59	20	36,0	14	1,5	5,0	5	26,0	6,4	10,4	6,0	10	7,0	16,0	31	18,5	47	0,2
	34**	160	● 398531082600	63	20	32,5	8	3,0	4,5	18	23,0	8,4	13,5	9,0	16	7,5	26,0	39	16,0	-	0,2
	34**	200	● 398531083900	72	22	38,5	10	3,5	5,0	20	27,0	8,4	13,5	9,0	20	9,5	32,0	48	17,0	-	0,3
	34**	250	● 398531084100	90	30	50,0	12	3,5	5,0	20	30,0	13,0	19,0	7,0	20	14,0	40,5	81	20,0	-	0,7
	34**	315	● 398531085400	105	35	53,5	12	3,5	6,5	26	35,3	13,0	19,0	15,5	27	15,0	40,0	95	21,3	-	1,1



SJT

SGT

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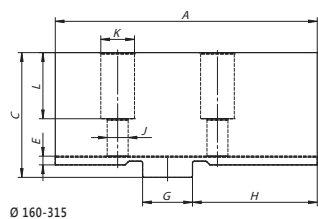
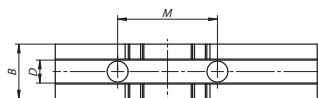
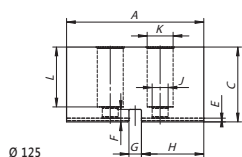
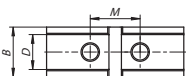
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**WEICHE AUFSATZBACKEN**  
 SOFT TOP JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M	kg / Stück	
															kg / pc.	
BISON Chuck Type	Chuck Size	Code No.														
Ø 125 - 315 mm	34**	125	● 398531030100	55	20	30	14	1,5	5,0	5	25	6,4	10,4	24,0	20	0,2
	34**	160	● 398531040300	85	20	40	8	3,0	4,5	18	42	8,4	13,5	26,5	32	0,4
	34**	200	● 398531050500	105	22	50	10	3,5	5,0	20	50	8,4	13,5	35,0	40	0,7
	34**	250	● 398531060700	125	30	55	12	3,5	5,0	20	70	13,0	19,0	41,0	40	1,2
	34**	315	● 398531070900	145	35	60	12	3,5	6,0	26	74	13,0	19,0	38,0	54	1,8

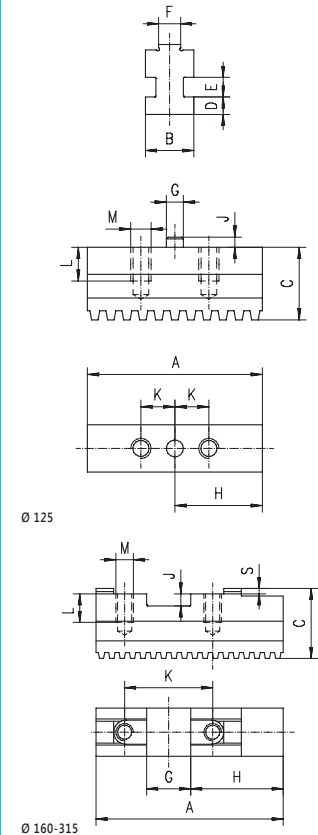


**HARTE GRUNDBACKEN**  
 HARD MASTER JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	S	kg / Stück	
																kg / pc.	
BISON Chuck Type	Chuck Size	Code No.															
Ø 125 - 315 mm	34**	125	● 398530970900	51,5	14	21,5	6,5	7	-	5	25,75	3,0	10	10	M6	-	0,1
	34**	160	● 398530980000	65,0	20	30,0	7,5	9	8	18	28,0	5,0	32	13	M8	2,5	0,2
	34**	200	● 398530990200	85,0	22	32,0	8,0	9	10	20	42,0	5,5	40	13	M8	2,5	0,3
	34**	250	● 398531000600	87,5	26	40,0	10,0	11	12	20	41,5	5,5	40	15	M12	3,0	0,5
	34**	315	● 398531010800	125,0	32	46,0	12,0	14	12	26	69,0	7,0	54	17	M12	3,0	1,0

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery



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SP

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**HARTE GETEILTE UMKEHRBACKEN**  
 HARD 2-PC REVERSIBLE JAWS



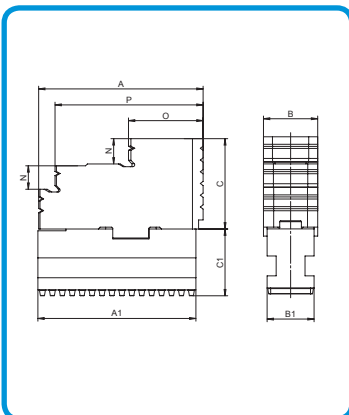
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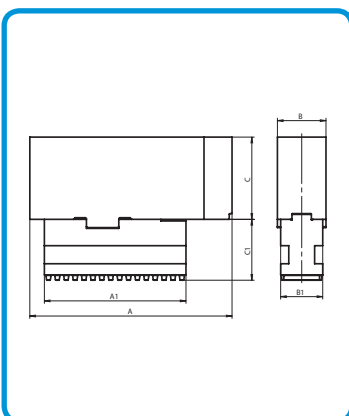
BISON Futter Typ	Futtergröße	Artikel Nr.	A	A1	B	B1	C	C1	N	O	P	kg / Stück	
												kg / pc.	
BISON Chuck Type	Chuck Size	Code No.											
Ø 125 - 315 mm	34**	125	● 398531210000	59	51,5	20	14	36,0	21,5	7,0	16,0	31	0,3
	34**	160	● 398531220100	63	65,0	20	20	32,5	27,5	7,5	26,0	39	0,4
	34**	200	● 398531230300	72	85,0	22	22	38,5	29,5	9,5	32,0	48	0,6
	34**	250	● 398531240500	90	87,5	30	26	50,0	37,0	14,0	40,5	81	1,2
	34**	315	● 398531250700	105	125,0	35	32	53,5	43,0	15,0	40,0	95	2,1

SDT

SDM



**WEICHE GETEILTE BACKEN**  
 SOFT 2-PC JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	A1	B	B1	C	C1	kg / Stück	
									kg / pc.	
BISON Chuck Type	Chuck Size	Code No.								
Ø 125 - 315 mm	34**	125	● 398531270000	55	51,5	20	14	30,0	21,5	0,3
	34**	160	● 398531280200	85	65,0	20	20	35,5	27,5	0,6
	34**	200	● 398531290400	105	85,0	22	22	45,0	29,5	1,0
	34**	250	● 398531292000	125	87,5	30	26	50,0	37,0	1,7
	34**	315	● 398531294500	145	125,0	35	32	54,0	43,0	2,8



**HARTE EINTEILIGE UMKEHRBACKEN**  
 HARD SOLID JAWS • REVERSIBLE CLAMPING



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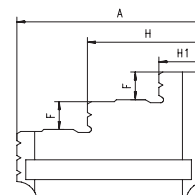
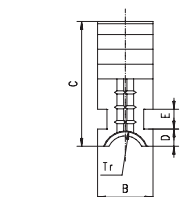
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	LH Gewinde	H <sub>1</sub>	H	kg / Stück
									LH Thread			kg / pc.
Ø 200 - 800 mm	45*5; 47*5	200	85	25	58	11,0	10	12	Tr 18 x 2	25,0	56,0	0,6
	46*5; 48*5	200										
	45*5; 47*5	250	91	28	61	10,0	10	14	Tr 18 x 2	26,5	60,0	0,8
	46*5; 48*5	250										
	45*5; 47*5	315	125	32	73	13,5	12	18	Tr 24 x 3	27,0	76,0	1,6
	46*5; 48*5	315										
	45*5; 47*5	400	145	36	90	12,0	14	22	Tr 24 x 3	35,0	98,2	1,8
	46*5; 48*5	400										
	45*5; 47*5	500	180	40	100	15,0	14	26	Tr 26 x 3	49,7	119,3	3,9
	46*5; 48*5	500										
	45*5; 47*5	630	225	50	108	14,0	14	28	Tr 26 x 3	65,0	148,0	4,5
	46*5; 48*5	630										
	45*5; 47*5	800	230	52	109	13	15	28	Tr 36 x 6	60	145	6,0
	46*5; 48*5	800										



**SJT**



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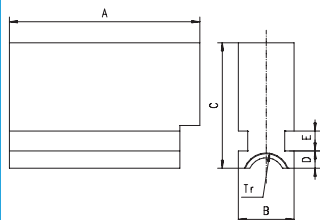
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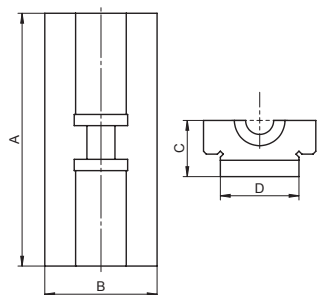
**WEICHE MONOBLOCKBACKEN**  
 SOFT SOLID JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	G	LH Gewinde	H <sub>1</sub>	H	kg / Stück
									LH Thread			kg / pc.
Ø 200 - 630 mm	45*5; 47*5	200	85	25	58	11,0	10	12	Tr 18 x 2	25,0	56,0	0,6
	46*5; 48*5	200										
	45*5; 47*5	250	91	28	61	10,0	10	14	Tr 18 x 2	26,5	60,0	0,8
	46*5; 48*5	250										
	45*5; 47*5	315	125	32	73	13,5	12	18	Tr 24 x 3	27,0	76,0	1,6
	46*5; 48*5	315										
	45*5; 47*5	400	145	36	90	12,0	14	22	Tr 24 x 3	35,0	98,2	1,8
	46*5; 48*5	400										
	45*5; 47*5	500	180	40	100	15,0	14	26	Tr 26 x 3	49,7	119,3	3,9
	46*5; 48*5	500										
	45*5; 47*5	630	225	50	108	14,0	14	28	Tr 26 x 3	65,0	148,0	4,5
	46*5; 48*5	630										



**HARTE GRUNDBACKEN**  
 HARD MASTER JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	kg / Stück
							kg / pc.
Ø 200 - 800 mm	45*5; 47*5	200	79	36	18	25	0,3
	46*5; 48*5	200					
	45*5; 47*5	250	90	40	20	28	0,4
	46*5; 48*5	250					
	45*5; 47*5	315	106	43	22	32	0,5
	46*5; 48*5	315					
	45*5; 47*5	400	129	49	23	36	0,7
	46*5; 48*5	400					
	45*5; 47*5	500	153	55	25	40	1,0
	46*5; 48*5	500					
	45*5; 47*5	630	186	64	26	50	1,6
	46*5; 48*5	630					
	45*5; 47*5	800	186	66	29	50	1,4
	46*5; 48*5	800					

SJM

SP



**HARTE EINTEILIGE UMKEHRBACKEN**  
HARD SOLID JAWS • REVERSIBLE CLAMPING



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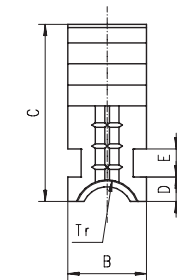
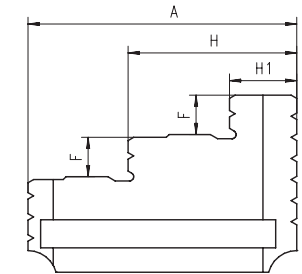
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BISON Futter Typ BISON Chuck Type	Futtergröße Chuck Size	Artikel Nr. Code No.	A	B	C	D	E	F	H <sub>1</sub>	H	LH Gewinde	kg / Stück
											LH Thread	kg / pc.
43**	85	● 398573100200	34,0	13	30,0	4,5	5	7	8,0	17,5	Tr 16x2	0,1
43**	100	● 398574010100	34,0	13	30,0	4,5	5	7	8,0	17,5	Tr 16x2	0,1
43**	125	● 398573110400	51,0	16	34,5	6,0	5	8	12,5	31,5	Tr 18x4	0,1
43**	160	● 398573110400	51,0	16	34,5	6,0	5	8	12,5	31,5	Tr 18x4	0,1
43**	200	● 398573120600	81,0	32	63,0	8,7	10	14	17,5	48,5	Tr 28x5	0,7
43**	250	● 398573130800	96,5	32	63,0	8,7	10	14	23,0	59,0	Tr 28x5	1,3
43**	315	● 398573140000	111,0	40	76,5	9,7	12	18	27,0	67,0	Tr 32x6	1,5
43**	350	● 398573140000	111,0	40	76,5	9,7	12	18	27,0	67,0	Tr 32x6	1,5
43**	400	● 398573150100	129,0	40	76,5	9,7	12	18	32,5	78,5	Tr 32x6	1,8
43**	500	● 398573160300	152,5	52	93,5	11,7	15	22	35,0	93,0	Tr 36x6	3,4
43**	630	● 398573170500	177,0	52	93,5	11,7	15	25	45,0	109,0	Tr 40x6	4,0
43**	800	● 398573180700	202,0	70	114,5	15,7	20	25	44,0	122,0	Tr 44x8	7,8

Ø 85 - 800 mm



SJT

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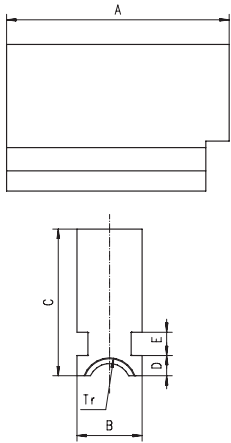
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**WEICHE MONOBLOCKBACKEN**  
 SOFT SOLID JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	H <sub>1</sub>	H	LH Gewinde	kg / Stück
											BISON Chuck Type	Chuck Size
43**	200	● 398573020500	81,0	32	63,0	8,7	10	14	17,5	48,5	Tr 28x5	0,7
43**	250	● 398573030700	96,5	32	63,0	8,7	10	14	23,0	59,0	Tr 28x5	1,3
43**	315	● 398573040900	111,0	40	76,5	9,7	12	18	27,0	67,0	Tr 32x6	1,5
43**	400	● 398573050000	129,0	40	76,5	9,7	12	18	32,5	78,5	Tr 32x6	1,8
43**	500	● 398573060200	152,5	52	93,5	11,7	15	22	35,0	93,0	Tr 36x6	3,4
43**	630	● 398573070400	177,0	52	93,5	11,7	15	25	45,0	109,0	Tr 40x6	4,0
43**	800	● 398573080600	202,0	70	114,5	15,7	20	25	44,0	122,0	Tr 44x8	7,8

Ø 200 - 800 mm



**HARTE AUFSATZBACKEN**  
 HARD TOP JAWS



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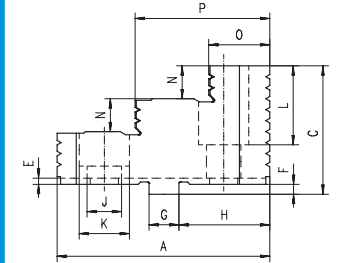
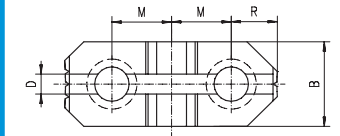
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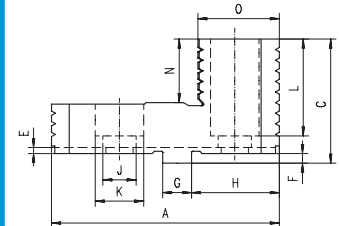
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BISON Futter Typ BISON Chuck Type	Futtergröße Chuck Size	Artikel Nr. Code No.	A	B	C	D	E	F	G	H	J	K	L	M	N	O	P	R	kg / Stück kg / pc.
			<b>Ø 200 - 1250 mm</b>																
43**	200	● 398573620000	82	34	43,5	7,95	4	3,2	12,69	35,2	11	18	21,5	22,25	9,5	22,0	53,0	19,3	0,5
43**	250	● 398573630200	96,5	34	51,5	12,71	4	3,2	19,04	40,0	14	20	26,5	27,00	12,0	25,0	62,0	22,5	0,7
43**	315	● 398573640400	112,5	42	55,0	12,71	4	3,2	19,04	47,9	14	20	27,5	31,75	13,0	27,0	70,5	25,7	1,3
43**	400	● 398573650600	129	42	64,5	12,71	4	6,3	19,04	57,4	18	26	32,0	38,10	13,5	26,5	79,0	28,8	2,1
43**	500; 630	● 398573670000	136	54	82,0	12,71	4	6,3	19,04	58,0	22	33	43,0	38,10	21,0	37,5	87,0	29,4	3,0
43**	800	● 398573680100	136	72	88,0	12,71	4	6,3	19,04	58,0	22	33	46,0	38,10	24,0	40,0	89,0	29,4	4,2
43**	915	● 398574490000	160	72	97,0	12,71	4	6,3	19,04	58,0	22	33	71,0	38,10	50,0	60,0	-	29,4	4,2
43**	1000	● 398574490000	160	72	97,0	12,71	4	6,3	19,04	58,0	22	33	71,0	38,10	50,0	60,0	-	29,4	4,2
43**	1250	● 398574490000	160	72	97,0	12,71	4	6,3	19,04	58,0	22	33	71,0	38,10	50,0	60,0	-	29,4	4,2



Ø 200-800



Ø 1000-1250

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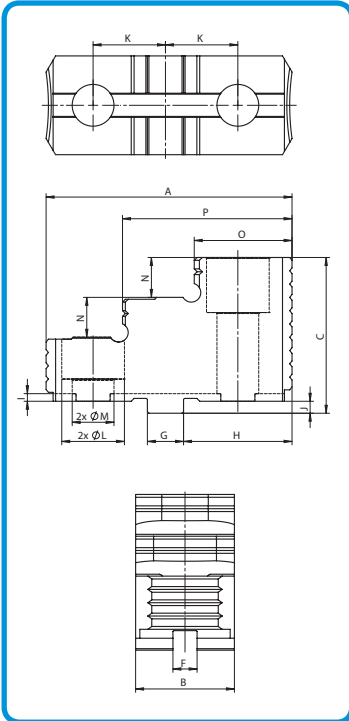
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**HARTE AUFsatzBACKEN • HD**  
 HARD TOP JAWS • HD



BISON Futter Typ	Artikel Nr.	A	B	C	F	G	H	I	J	K	M	L	N	O	P	kg / Stück		
BISON Chuck Type	Code No.																kg / pc.	
Ø 400 - 1250 mm	4317-16"-8A2-5,3" HD																	
	4317-16"-11A2 DIN-6,5" HD																	
	4317-20"-11A2 DIN-6,5" HD																	
	4317-20"-15A2 DIN-10" HD	● 398573667700	135	62	82	12,71	19,04	57,1	4	6,3	38,1	22	33	21	55,9	88,7	2,74	
	4317-20"-15A2 DIN-8" HD																	
	4347-16"-8-5,3" HD																	
	4347-16"-11-6,5" HD																	
	4347-20"-8-5,3" HD																	
	4347-20"-11-6,5" HD																	
	4317-25"-15A2 DIN-10,5" HD																	
	4317-25"-20A2-10,5" HD																	
4317-25"-20A2-12,5" HD																		
4347-28"-11-7,5" HD																		
4317-28"-15A2 DIN-10,5" HD																		
4317-28"-20A2-12,5" HD																		
4317-32"-15A2 DIN-10,5" HD	● 398573677900	135	75	97	12,71	19,04	57,1	4	6,3	38,1	24	35	28	57,3	89,9	4,00		
4317-32"-20A2-12,5" HD																		
4317-32"-20A2-14,5" HD																		
4317-630-20A2-270 HD																		
4317-40"-28A2-20,5" HD																		
4307-1000-520-200 HD																		
4307-1250-520-200 HD																		
4317-49"-15A2 DIN-11" HD																		



**WEICHE AUFSATZBACKEN**  
SOFT TOP JAWS



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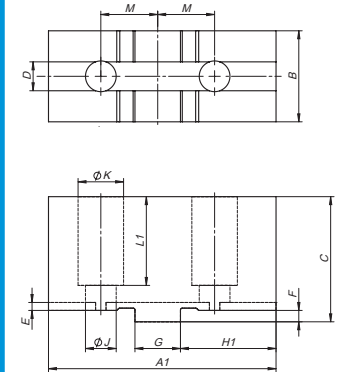
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L1	M	kg / Stück
															kg / pc.
BISON Chuck Type	Chuck Size	Code No.													
43**	200	● 398538240200	90	27	43,5	7,95	4	3,2	12,69	40	11	18	31	22,25	0,7
43**	250	○ 398538250400	106	32,5	51,5	12,71	4	3,2	19,04	45	14	20	38	27	1,2
43**	315	● 398538260600	120	37	55	12,71	4	3,2	19,04	53	14	20	40	31,75	1,6
43**	400	● 398538270800	140	42	64,5	12,71	4	6,3	19,04	63	18	26	45,5	38,1	2,2
43**	500	● 398538280000	140	42	74,5	12,71	4	6,3	19,04	63	22	33	56	38,1	2,4
43**	630	○ 398574370500	140	54	82	12,71	4	6,3	19,04	58	22	33	64	38,1	3,6
43**	800	○ 398574380700	140	72	88	12,71	4	6,3	19,04	58	22	33	70	38,1	5,5
43**	915	○ 398574390900	160	72	97	12,71	4	6,3	19,04	58	22	33	72	38,1	7,2
43**	1000	○ 398574390900	160	72	97	12,71	4	6,3	19,04	58	22	33	72	38,1	7,2
43**	1250	○ 398574390900	160	72	97	12,71	4	6,3	19,04	58	22	33	72	38,1	7,2

Ø 200 - 1250 mm







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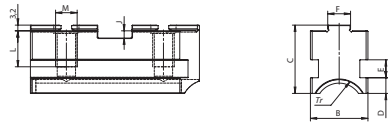
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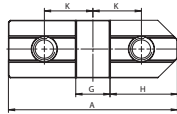
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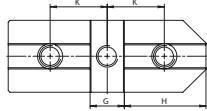
**HARTE GRUNDBACKEN**  
 HARD MASTER JAWS



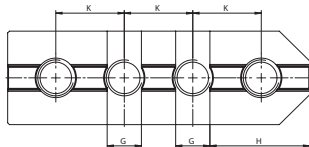
Ø 200-250



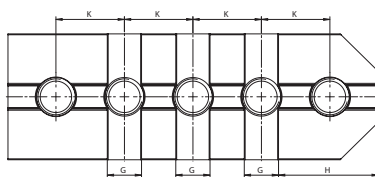
Ø 315-400



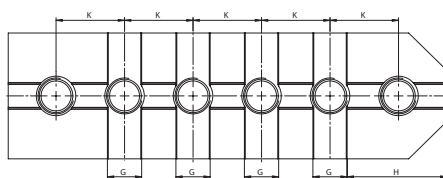
Ø 500



Ø 630-800



Ø 915-1250



Ø 200 - 1250 mm

BISON Futter Typ	Futtergröße	Artikel Nr.	A	B	C	D	E	F	G	H	J	K	L	M*	LH Gewinde	kg / Stück
BISON Chuck Type	Chuck Size	Code No.													LH Thread	kg / pc.
43**	200	● 398573520000	79	32	32	8,7	10	7,94	12,69	33,2	4,0	22,25	14	M10	Tr 28x5	0,3
43**	250	● 398573530100	94	32	38	8,7	10	12,7	19,04	37,5	4,0	27,00	20	M12	Tr 28x5	0,6
43**	315	● 398573540300	110	40	39	9,7	12	12,7	19,04	45,4	4,0	31,75	17,5	M12	Tr 32x6	0,9
43**	400	● 398573550500	129	40	44	9,7	12	12,7	19,04	54,9	7,2	38,10	22	M16	Tr 32x6	0,9
43**	500	● 398573560700	168	52	59	11,7	15	12,7	19,04	55,5	7,2	38,10	35	M20	Tr 36x6	2,4
43**	630	● 398573570900	206	52	59	11,7	15	12,7	19,04	55,5	7,2	38,10	35	M20	Tr 40x6	2,7
43**	800	● 398573580000	206	70	59	15,7	20	12,7	19,04	55,5	7,2	38,10	33,5	M20	Tr 44x8	3,8
43**	915	● 398573590200	244	70	59	15,7	20	12,7	19,04	55,5	7,2	38,10	35	M20	Tr 44x6	5,4
43**	1000	● 398573590200	244	70	59	15,7	20	12,7	19,04	55,5	7,2	38,10	35	M20	Tr 44x6	5,4
43**	1250	● 398573590200	244	70	59	15,7	20	12,7	19,04	55,5	7,2	38,10	35	M20	Tr 44x6	5,4

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery

SP

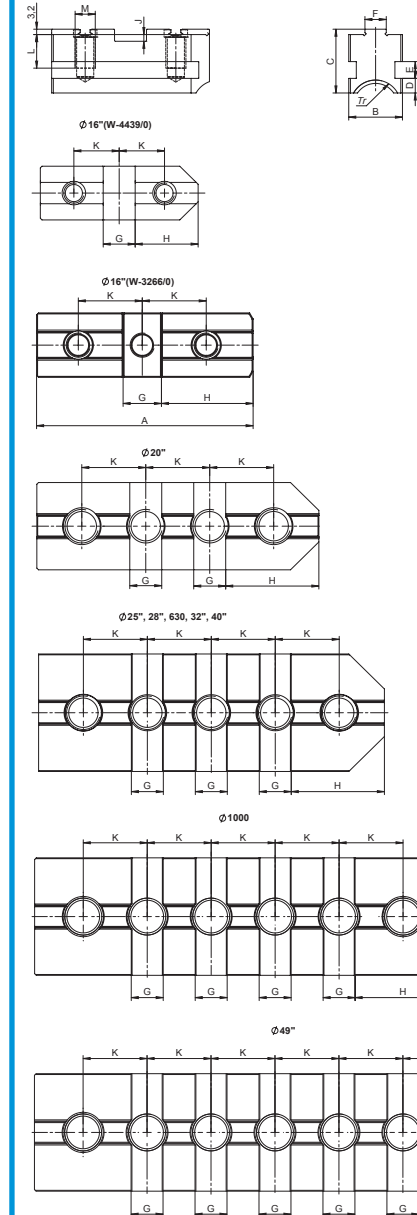


**HARTE GRUNDBACKEN • HD**  
HARD MASTER JAWS • HD

BISON Futter Typ BISON Chuck Type	Artikel Nr. Code No.	A	B	C	D	E	F	G	H	J	K	L	M*	LH Gewinde LH Thread	kg / Stück kg / pc.
		4317-16"-8A2-5,3" HD 4347-16"-8-5,3" HD 4347-16"-11-6,5" HD 4317-16"-11A2 DIN-6,5" HD 4317-20"-15A2 DIN-10" HD	● 398572041300	132	60	58	15,7	20	12,7	19,04	57,1	7,2	38,1	33,5	3/4"
4347-20"-8-5,3" HD 4347-20"-11-6,5" HD 4317-20"-11A2 DIN-6,5" HD 4317-20"-15A2 DIN-8" HD	● 398572046700	170	60	58	15,7	20	12,7	19,04	57,1	7,2	38,1	33,5	3/4"	Tr 44x8	3,2
4317-25"-15A2 DIN-10,5" HD 4317-25"-20A2-10,5" HD 4317-25"-20A2-12,5" HD 4317-28"-20A2-12,5" HD 4347-28"-11-7,5" HD 4317-28"-15A2 DIN-10,5" HD 4317-32"-15A2 DIN-10,5" HD 4317-32"-20A2-12,5" HD 4317-32"-20A2-14,5" HD 4317-40"-28A2-20,5" HD	● 398573772600	208	70	61	15,7	20	12,7	19,04	57,1	7,2	38,1	33,5	7/8"	Tr 50x8	4,65

Ø 400 - 1250 mm

\* Schrauben sind im Lieferumfang enthalten • Screws are included in delivery



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SP HD

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**HARTE GETEILTE UMKEHRBACKEN**  
 HARD 2-PC REVERSIBLE JAWS



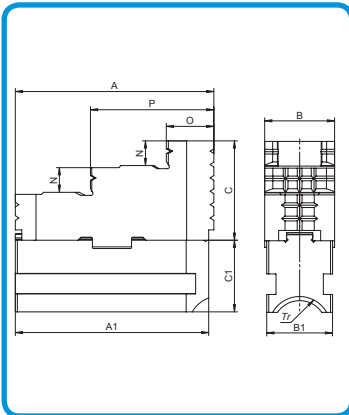
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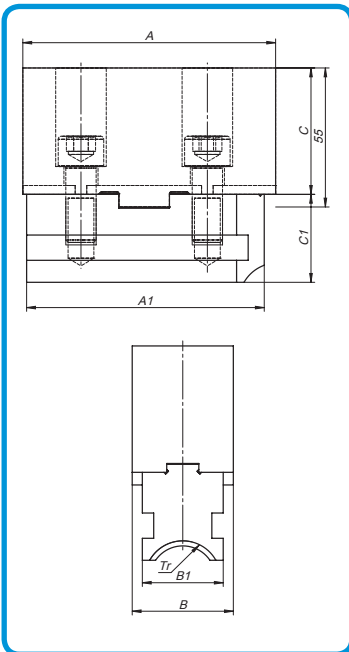
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BISON Futter Typ	Futtergröße	Artikel Nr.	A	A1	B	B1	C	C1	N	O	P	LH Gewinde	kg / Stück	
												LH Thread	kg / pc.	
Ø 200 - 1250 mm	43**	200	● 398573820200	82	79	34	32	40,3	28,8	9,5	22,0	53,0	Tr 28x5	0,9
	43**	250	● 398573830400	96,5	94	34	32	48,3	34,8	12,0	25,0	62,0	Tr 28x5	1,2
	43**	315	● 398573840600	112,5	110	42	40	51,8	35,8	13,0	27,0	70,5	Tr 32x6	2,0
	43**	400	● 398573850800	129	129	42	40	58,2	40,8	14,0	26,5	79,0	Tr 32x6	2,9
	43**	500	● 398573960000	136	168	54	52	75,7	55,8	21,0	37,5	87,0	Tr 36x6	5,6
	43**	630	● 398573870100	136	206	54	52	75,7	55,8	21,0	37,5	87,0	Tr 40x6	5,7
	43**	800	● 398573880300	136	206	72	70	81,7	55,8	24,0	56,0	88,0	Tr 44x8	8,7
	43**	915	● 398574290800	160	244	72	70	90,7	55,8	50,0	60,0	-	Tr 44x6	10,1
	43**	1000	● 398574290800	160	244	72	70	90,7	55,8	50,0	60,0	-	Tr 44x6	10,1
	43**	1250	● 398574290800	160	244	72	70	90,7	55,8	50,0	60,0	-	Tr 44x6	10,1

**WEICHE GETEILTE BACKEN**  
 SOFT 2-PC JAWS



BISON Futter Typ	Futtergröße	Artikel Nr.	A	A1	B	B1	C	C1	LH Gewinde	kg / Stück	
										LH Thread	kg / pc.
Ø 200 - 1250 mm	43**	200	● 398574122100	90	79	27	32	40,3	28,8	Tr 28x5	1,0
	43**	250	● 398574132100	106	94	32,5	32	48,3	34,8	Tr 28x5	1,9
	43**	315	● 398574142300	120	110	37	40	51,8	35,8	Tr 32x6	2,6
	43**	400	● 398574152500	140	129	42	40	58,2	40,8	Tr 32x6	3,3
	43**	500	● 398574162700	140	168	42	52	68,2	55,8	Tr 36x6	5,1
	43**	630	● 398574172900	140	206	54	52	75,7	55,8	Tr 40x6	6,6
	43**	800	● 398574182000	140	206	72	70	81,7	55,8	Tr 44x8	9,7
	43**	915	● 398574196300	160	244	72	70	90,7	55,8	Tr 44x6	12,9
	43**	1000	● 398574196300	160	244	72	70	90,7	55,8	Tr 44x6	12,9
	43**	1250	● 398574196300	160	244	72	70	90,7	55,8	Tr 44x6	12,9

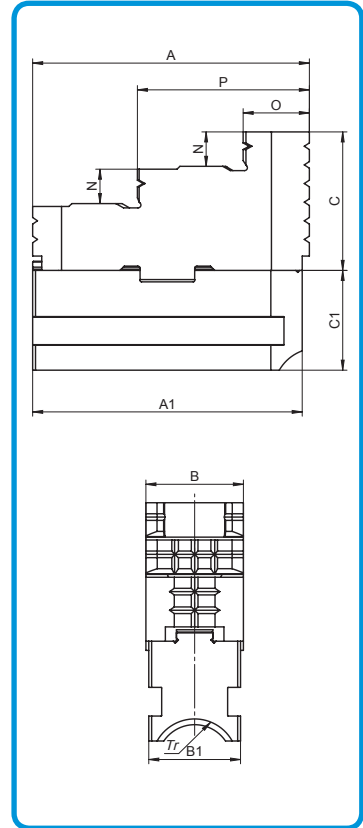
SDT

SDM



**HARTE GETEILTE UMKEHRBACKEN • HD**  
 HARD 2-PC REVERSIBLE JAWS • HD

BISON Futter Typ BISON Chuck Type	Artikel Nr. Code No.	A	A1	B	B1	C	C1	N	O	P	LH Gewinde	kg / Stück																									
											LH Thread	kg / pc.																									
Ø 400 - 1250 mm	4347-16"-8-5,3" HD 4317-16"-8A2-5,3" HD 4317-16"-11A2 DIN-6,5" HD 4347-16"-11-6,5" HD	● 398573865300	135	132	62	60	75,7	54,8	21	55,9	88,7	Tr 44x8	5,61																								
	4347-20"-8-5,3" HD 4347-20"-11-6,5" HD 4317-20"-11A2 DIN-6,5" HD 4317-20"-15A2 DIN-10" HD 4317-20"-15A2 DIN-8" HD													○ 398573866600	135	170	62	60	75,7	54,8	21	55,9	88,7	Tr 44x8	6,30												
	4317-25"-15A2 DIN-10,5" HD 4317-25"-20A2-10,5" HD 4317-25"-20A2-12,5" HD 4347-28"-11-7,5" HD																									○ 398573855100	135	208	75	70	90,7	57,8	28	57,3	89,9	Tr 50x8	9,17
	4317-28"-15A2 DIN-10,5" HD 4317-28"-20A2-12,5" HD 4317-32"-15A2 DIN-10,5" HD 4317-32"-20A2-12,5" HD 4317-32"-20A2-14,5" HD 4317-40"-28A2-20,5" HD																																				



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**SDT HD**

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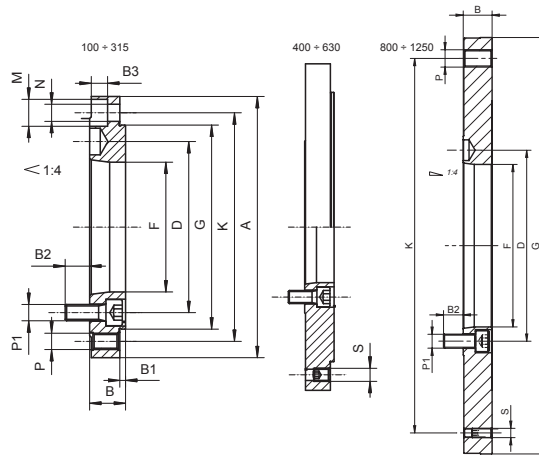
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**FLANSCH FERTIGBEARBEITET**  
FULLY-FINISHED ADAPTER PLATES

**8210-X**  
DIN 55026

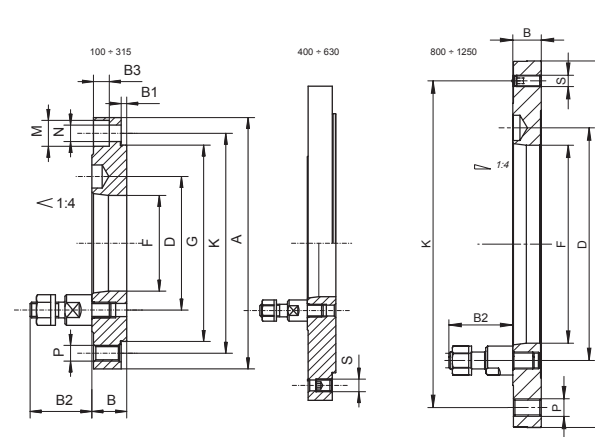


Artikel Nr.	W	KK 1:4		A	B	B1	B2	B3	D	F	G (h6)	K	M	N	P	P1	S	kg
		ST 1:4																
● 358210540800	125	3	125	22	3,5	14,0	10	70,6	51,4	95	108,0	3x13,5	3x8,4	3xM8	3xM10	-	1,4	
● 358210570300	160	4	160	22	3,5	15,0	10	82,6	60,9	125	140,0	6x16,5	6x10,5	3xM10	6xM10	-	2,2	
● 358210580500	160	5	160	22	3,5	15,0	10	104,8	79,5	125	140,0	6x16,5	6x10,5	3xM10	6xM10	-	1,9	
● 358210650000	200	5	200	22	3,5	15,0	10	104,8	79,5	160	176,0	6x16,5	6x10,5	3xM10	6xM10	-	3,6	
● 358210660200	200	6	200	22	3,5	21,0	10	133,4	103,0	160	176,0	6x16,5	6x10,5	3xM10	6xM12	-	3,1	
● 358210710400	250	5	250	28	4,5	12,0	12	104,8	79,5	200	224,0	6x19,0	6x13,0	3xM12	6xM10	-	7,7	
● 358210720600	250	6	250	28	4,5	19,0	12	133,4	103,0	200	224,0	6x19,0	6x13,0	3xM12	6xM12	-	7,1	
● 358210730800	250	8	250	28	4,5	24,0	12	171,4	136,1	200	224,0	6x19,0	6x13,0	3xM12	6xM16	-	5,9	
● 358210770500	315	6	315	33	4,5	19,0	16	133,4	103,0	260	286,0	6x25,0	6x17,0	3xM16	6xM12	-	14,6	
● 358210780700	315	8	315	33	4,5	22,0	16	171,4	136,1	260	286,0	6x25,0	6x17,0	3xM16	6xM16	-	13,2	
● 358210791100	315	11	315	38	4,5	32,0	-	235,0	192,8	260	286,0	-	-	6xM16	6xM20	-	12,0	
● 358210810500	400	8	400	36	4,5	20,0	16	171,4	136,1	330	362,0	6x25,0	6x17,0	6xM16	6xM16	3xM16	26,0	
● 358210821000	400	11	400	36	4,5	30,0	17	235,0	192,8	330	362,0	6x25,0	6x17,0	6xM16	6xM20	3xM16	22,5	
● 358210830900	500	8	500	36	4,5	20,0	16	171,4	136,1	420	458,0	6x25,0	6x17,0	6xM16	6xM16	3xM16	43,4	
● 358210841300	500	11	500	36	4,5	30,0	16	235,0	192,8	420	458,0	6x25,0	6x17,0	6xM16	6xM20	3xM16	39,9	
● 358210851500	500	15	500	36	4,5	32,0	16	330,2	281,4	420	458,0	6x25,0	6x17,0	6xM16	6xM24	3xM16	31,6	
● 358210871900	630	11	630	42	6,0	24,0	19	235,0	192,8	545	586,0	6x25,0	6x17,0	6xM16	6xM20	3xM16	79,7	
● 358210881000	630	15	630	42	6,0	36,0	19	330,2	281,4	545	586,0	6x25,0	6x17,0	6xM16	6xM24	3xM16	79,1	
● 358210907300	800	15	-	40	-	36	-	330,2	281,4	380	330,2	-	-	11xM24	6xM24	-	13,7	
● 358210903200	800	15	-	48	-	34	-	330,2	281,4	450	368,3	-	-	8xM24	8xM24	3xM24	31,3	
● 358210911900	1000	15	-	45	-	35	-	330,2	281,4	520	463,6	-	-	6xM24	8xM24	3xM16	44,6	

W - Futterdurchmesser • Chuck diameter

**FLANSCH FERTIGBEARBEITET**  
FULLY-FINISHED ADAPTER PLATES

**8230-X**  
DIN 55027



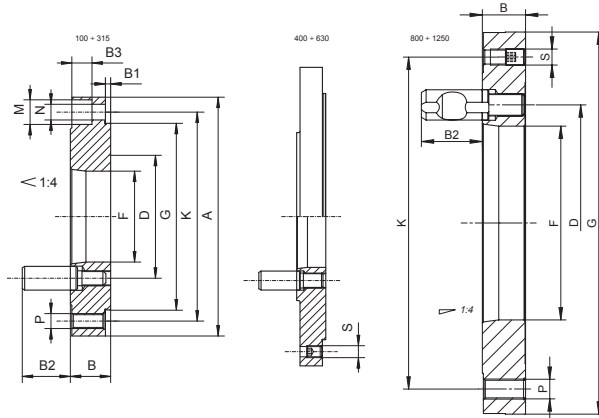
Artikel Nr.	W	KK 1:4		A	B	B1	B2	D	F	G (h6)	K	M	N	P	S	kg
		ST 1:4														
● 358230071600	160	4	160	22	3,5	39	85,0	60,9	125	140,0	6x16,5	6x10,5	6xM10	-	2,5	
● 358230082000	160	5	160	22	3,5	43	104,8	79,5	125	140,0	6x16,5	6x10,5	6xM10	-	2,2	
● 358230083300	160	6	160	22	3,5	50	133,4	103,0	125	140,0	6x16,5	6x10,5	6xM10	-	1,9	
● 358230111600	200	5	200	22	3,5	43	104,8	79,5	160	176,0	6x16,5	6x10,5	6xM10	-	3,9	
● 358230121800	200	6	200	22	3,5	50	133,4	103,0	160	176,0	6x16,5	6x10,5	6xM10	-	3,6	
● 358230161500	250	6	250	28	4,5	50	133,4	103,0	200	224,0	6x19,0	6x13,0	6xM12	-	7,6	
● 358230171700	250	8	250	28	4,5	60	171,4	136,1	200	224,0	6x19,0	6x13,0	6xM12	-	6,7	
● 358230201500	315	6	315	33	4,5	50	133,4	103,0	260	286,0	6x25,0	6x17,0	6xM16	-	15,1	
● 358230211700	315	8	315	33	4,5	60	171,4	136,1	260	286,0	6x25,0	6x17,0	6xM16	-	14,0	
● 358230221900	315	11	315	33	4,5	75	235,0	192,8	260	286,0	6x25,0	6x17,0	6xM16	-	12,2	
● 358230251400	400	8	400	36	4,5	60	171,4	136,1	330	362,0	6x25,0	6x17,0	6xM16	3xM16	26,9	
● 358230261600	400	11	400	36	4,5	75	235,0	192,8	330	362,0	6x25,0	6x17,0	6xM16	3xM16	24,7	
● 358230311800	500	11	500	36	4,5	75	235,0	192,8	420	458,0	6x25,0	6x17,0	6xM16	3xM16	42,1	
● 358230321000	500	15	500	36	4,5	90	330,2	281,4	420	458,0	6x25,0	6x17,0	6xM16	3xM16	35,7	
● 358230351500	630	11	630	42	6,0	75	235,0	192,8	545	586,0	6x25,0	6x17,0	6xM16	3xM16	81,9	
● 358230382300	800	11	-	45	-	75	235,0	192,8	450	368,3	-	-	12xM24	3xM16	43,0	
● 358230384900	800	15	-	45	-	90	330,2	281,4	380	330,2	-	-	6xM24	3xM16	23,3	

W - Futterdurchmesser • Chuck diameter

**8240-X**  
DIN 55029



**FLANSCH FERTIGBEARBEITET**  
FULLY-FINISHED ADAPTER PLATES



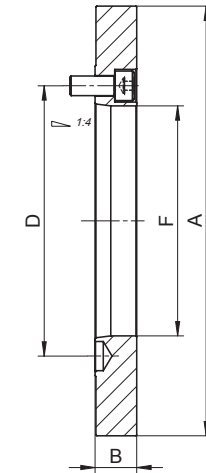
Artikel Nr.	W	KK 1:4 ST 1:4	A	B	B1	B2	D	F	G (h6)	K	M	N	P	S	kg
● 358245122900	125	4	125	26,0	3,5	32,2	82,6	60,0	95	108,0	3x13,5	3x8,4	6xM8	-	1,6
○ 358245032000	160	3	160	27,0	3,5	30,8	70,6	51,4	125	140,0	3x16,5	3x8,4	6xM10	-	3,1
● 358245132000	160	4	160	27,0	3,5	32,2	82,6	60,0	125	140,0	3x16,5	3x8,4	6xM10	-	2,9
○ 358245232100	160	5	160	30,0	3,5	38,2	104,8	79,5	125	140,0	3x16,5	3x8,4	6xM10	-	3,0
● 358245142200	200	4	200	27,0	3,5	32,8	82,6	60,0	160	176,0	6x16,5	6x10,5	6xM10	-	4,9
○ 358245242300	200	5	200	30,0	3,5	38,2	104,8	79,5	160	176,0	6x16,5	6x10,5	6xM10	-	4,8
● 358245342400	200	6	200	36,5	3,5	44,2	133,4	103,0	160	176,0	6x16,5	6x10,5	6xM10	-	5,9
● 358245352600	250	6	250	36,5	4,5	44,2	133,4	103,0	200	224,0	6x19,0	6x13	6xM12	-	8,7
● 358245452700	250	8	250	39,0	4,5	50,7	171,4	136,1	200	224,0	6x19,0	6x13	6xM12	-	9,4
○ 358245362800	315	6	315	39,0	4,5	44,2	133,4	103,0	260	286,0	6x25,0	6x17	6xM16	-	17,4
● 358245462900	315	8	315	39,0	4,5	50,7	171,4	136,1	260	286,0	6x25,0	6x17	6xM16	-	15,9
● 358245562000	315	11	315	47,0	4,5	60,6	235,0	192,8	260	286,0	6x25,0	6x17	6xM16	-	16,3
● 358245472000	400	8	400	39,0	4,5	50,7	171,4	136,1	330	362,0	6x25,0	6x17	6xM16	3xM16	27,4
● 358245572100	400	11	400	47,0	4,5	60,6	235,0	192,8	330	362,0	6x25,0	6x17	6xM16	3xM16	27,4
○ 358245582300	500	11	500	47,0	4,5	60,6	235,0	192,8	420	458,0	6x25,0	6x17	6xM16	3xM16	44,5
○ 358245602000	630	11	630	47,0	6,0	60,6	235,0	192,8	545	586,0	6x25,0	6x17	6xM16	3xM16	74,5

W - Futterdurchmesser • Chuck diameter

**8212**  
DIN 55026



**FLANSCH VORGEARBEITET**  
SEMI-MACHINED ADAPTER PLATES



- Flansch für Drehfutter und Planscheiben
- Futterseitig plan, maschinenseitig fertig
- Adapters for plain back self-centering and independent chuck
- Rough on the chuck side

Artikel Nr.	W	KK 1:4 ST 1:4	A	B	D	F	kg
○ 358212080700	160	5	162	24,0	104,8	79,5	4,2
○ 358212110500	200	5	203	38,0	104,8	55,0	12,0
○ 358212120700	200	6	203	33,0	133,4	54,0	12,0
○ 358212160400	250	6	253	50,0	133,4	80,5	16,0
○ 358212170600	250	8	253	46,0	171,4	80,5	16,0
○ 358212200400	315	6	318	33,0	133,4	103,0	22,0
○ 358212210600	315	8	318	55,0	171,4	103,0	22,0

W - Futterdurchmesser • Chuck diameter

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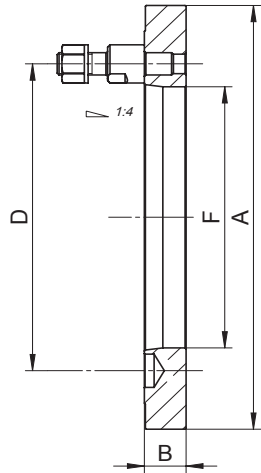
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**FLANSCH VORGEARBEITET**  
SEMI-MACHINED ADAPTER PLATES

8232  
DIN 55027



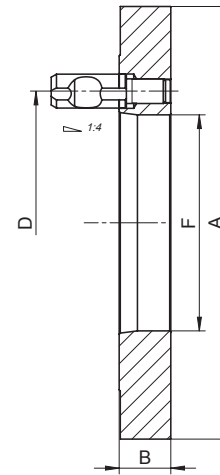
- Flansch für Drehfutter und Planscheiben
- Futterseitig plan, maschinenseitig fertig
- Adapters for plain back self-centering and independent chuck
- Rough on the chuck side

Artikel Nr. Code No.	W	KK 1:4		A	B	F	D	kg
		ST 1:4						
358232030200	125	3		127	19,5	51,4	70,6	2,4
358232040400	125	4		127	19,5	60,9	85,0	2,4
358232070000	160	4		162	24	60,9	85,0	3,2
358232080100	160	5		162	24	79,5	104,8	2,8
358232090300	160	6		162	33	42,5	133,4	4,6
358232110000	200	5		203	38	55,0	104,8	12,0
358232120100	200	6		203	33	55,0	133,4	12,0
358232160900	250	6		253	50	80,0	133,4	16,0
358232170000	250	8		253	46	80,0	171,4	16,0
358232200900	315	6		318	33	103,0	133,4	17,2
358232210000	315	8		318	55	103,0	171,4	27,0
358232220200	315	11		318	47	103,0	235,0	24,0
358232260000	400	11		405	47	136,1	235,0	38,5
358232380400	800	11		385	45	192,8	235,0	28,0

W - Futterdurchmesser • Chuck diameter

**FLANSCH VORGEARBEITET**  
SEMI-MACHINED ADAPTER PLATES

8242  
DIN 55029



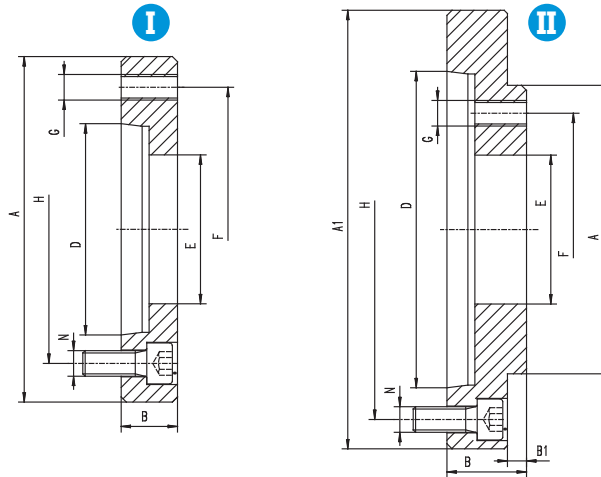
- Flansch für Drehfutter und Planscheiben
- Futterseitig plan, maschinenseitig fertig
- Adapters for plain back self-centering and independent chuck
- Rough on the chuck side

Artikel Nr. Code No.	W	KK 1:4		A	B	F	D	kg
		ST 1:4						
358242030000	125	3		127	50	26,0	70,6	2,4
358242040100	125	4		127	30	26,0	82,6	2,4
358242060500	160	4		162	55	26,0	82,6	4,2
358242070700	160	5		162	35	26,0	104,8	4,2
358242080900	160	6		162	49	26,0	133,4	4,5
358242130000	200	5		203	50	55,0	104,8	10,8
358242140200	200	6		203	40	55,0	133,4	9,5
358242180000	250	6		253	49	80,0	133,4	16,0
358242190100	250	8		253	49	80,0	171,4	16,0
358242230100	315	8		318	55	103,0	171,4	28,0
358242240300	315	11		318	55	103,0	235,0	24,0
358242290200	400	11		405	50	136,1	235,0	42,0
358242410000	800	11		385	50	192,8	235,0	31,0
358242420100	800	15		408	55	281,4	330,2	26,5,0

W - Futterdurchmesser • Chuck diameter

8217-0  
DIN 55026

FLANSCH FERTIGBEARBEITET FÜR  
4304, 4305, 4306, 4307  
FULLY-FINISHED ADAPTER PLATES FOR  
4304, 4305, 4306, 4307

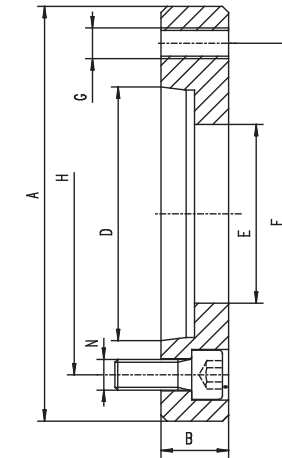


Artikel Nr. Code No.	W	KK 1:4 ST 1:4	Z	A h6	A1	B	B1	D	E	F	G	H	N	kg
358217012000	200	6	II	110	165	32	5,5	106,375	50	82,6	M10	133,4	6xM12	3,5
358217021000	250	6	II	150	165	40	7,5	106,375	65	104,8	M12	133,4	6xM12	4,4
358217022200	250	8	II	150	210	38	7,5	139,719	65	104,8	M12	171,4	6xM16	6,5
358217031100	315	6	I	175	-	35	-	106,375	80	133,4	M16	133,4	8xM12	4,5
358217032400	315	8	II	175	210	52	7,5	139,719	80	133,4	M16	171,4	6xM16	9,5
358217033700	315	11	II	175	280	49	7,5	196,869	80	133,4	M16	235,0	6xM20	14

W - Futterdurchmesser • Chuck diameter    Z - Form der Flansche • Adapter form

8217-1  
DIN 55026

FLANSCH FERTIGBEARBEITET FÜR  
4306, 4307  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*  
FULLY-FINISHED ADAPTER PLATES FOR  
4306, 4307  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*



Artikel Nr. Code No.	W	KK 1:4 ST 1:4	A h6	B	D	E	F	G	H	N	kg
358217071900	800	11	380	40	196,869	192,9	330,2	12xM24	235,0	6xM20	24,0
358217072100	800	15	380	48	285,775	281,5	330,2	12xM24	330,2	6xM24	17,4
358217090000	1000;1250	11	520	40	196,869	192,9	463,6	12xM24	235,0	8xM20	57,0
358217091200	1000;1250	15	520	40	285,775	281,5	463,6	12xM24	330,2	8xM24	53,0
358217110600	1250	11	720	50	196,869	192,9	647,6	12xM30	235,0	8xM20	132,0
358217111900	1250	15	720	50	285,775	281,5	647,6	12xM30	330,2	8xM24	128,0
358217112100	1250	20	720	50	412,775	408,0	647,6	12xM30	463,6	8xM24	102,0

W - Futterdurchmesser • Chuck diameter

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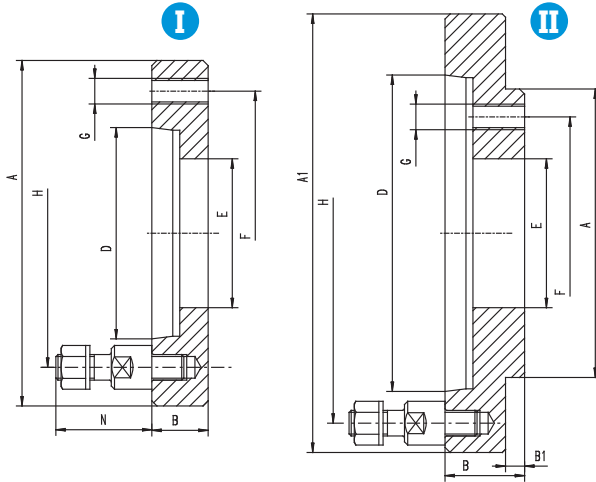
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**FLANSCH FERTIGBEARBEITET FÜR  
4304, 4305, 4306, 4307**  
FULLY-FINISHED ADAPTER PLATES FOR  
4304, 4305, 4306, 4307

8237-0  
DIN 55027

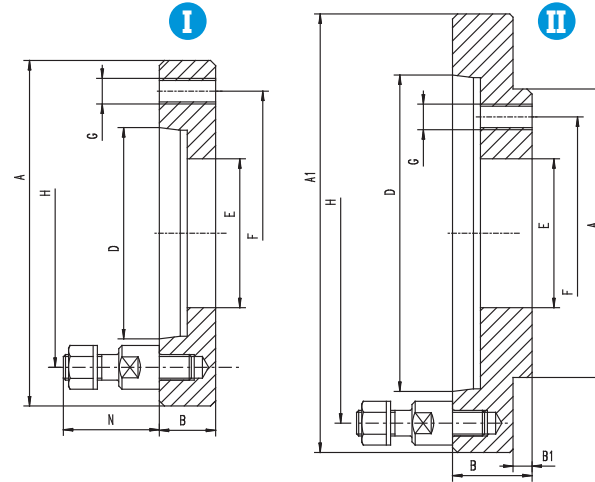


Artikel Nr. Code No.	W	KK 1:4 ST 1:4	Z	A h6	A1	B	B1	D	E	F	G	H	N	Q	kg
358237012500	200	6	II	110	170	34	5,5	106,375	50	82,6	M10	133,4	50	4	4,4
358237021400	250	6	II	150	170	45	7,5	106,375	65	104,8	M12	133,4	50	4	6,2
358237022700	250	8	II	150	220	38	7,5	139,719	65	104,8	M12	171,4	60	4	8,2
358237031600	315	6	I	175	-	33	-	106,375	80	133,4	M16	133,4	50	4	4,6
358237032900	315	8	II	175	220	52	7,5	139,719	80	133,4	M16	171,4	60	4	11,7
358237033100	315	11	II	175	290	49	7,5	196,869	80	133,4	M16	235	75	6	16,2
358237041800	400	8	II	200	220	28	11	139,719	100	171,4	M16	171,4	60	4	5,1
358237042000	400	11	II	200	290	45	11	196,869	100	171,4	M16	235	75	6	16,4
358237051000	500	8	I	270	-	30	-	139,719	125	235	M20	171,4	60	4	10,2
358237052200	500	11	II	270	290	45,5	12,5	196,869	125	235	M20	235	75	6	14,0
358237061100	630	11	II	270	290	38	-	196,869	160	235	M20	235	75	6	12,0

W - Futterdurchmesser • Chuck diameter Z - Form der Flansche • Adapter form

**FLANSCH FERTIGBEARBEITET FÜR  
4306, 4307**  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*  
FULLY-FINISHED ADAPTER PLATES FOR  
4306, 4307  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*

8237-1  
DIN 55027

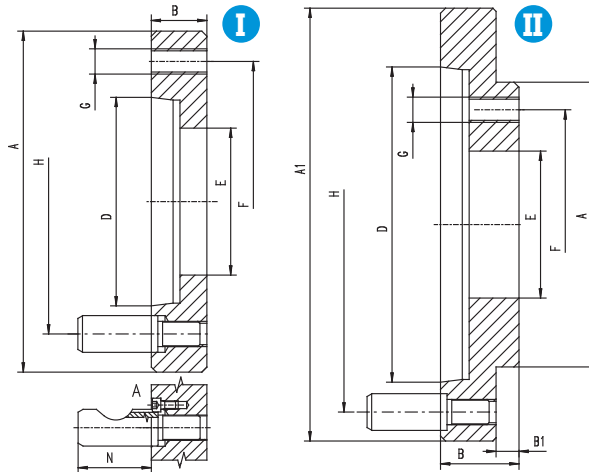


Artikel Nr. Code No.	W	KK 1:4 ST 1:4	Z	A h6	A1	B	B1	D	E	F	G	H	N	Q	kg
358237071300	800	11	I	380	-	40	-	196,869	192,9	330,2	12xM24	235	75	6	25,3
358237072600	800	15	II	380	400	40	13	285,775	281,5	330,2	12xM24	330,2	90	6	20,4
358237090400	1000; 1250	11	I	520	-	40	-	196,869	192,9	463,6	12xM24	235	75	6	54,5
358237091700	1000; 1250	15	I	520	-	40	-	285,775	281,5	463,6	12xM24	330,2	90	6	48,3
358237092000	1000; 1250	20	II	520	540	14	-	412,775	408,0	463,6	12xM24	463,6	100	6	32,2
358237100900	1250	11	I	720	-	50	-	196,869	192,9	647,6	12xM30	235	75	6	138,0
358237110000	1250	15	I	720	-	50	-	285,775	281,5	647,6	12xM30	330,2	90	6	132,0

W - Futterdurchmesser • Chuck diameter Z - Form der Flansche • Adapter form

8247-0  
DIN 55029

FLANSCH FERTIGBEARBEITET FÜR  
4304, 4305, 4306, 4307  
FULLY-FINISHED ADAPTER PLATES FOR  
4304, 4305, 4306, 4307

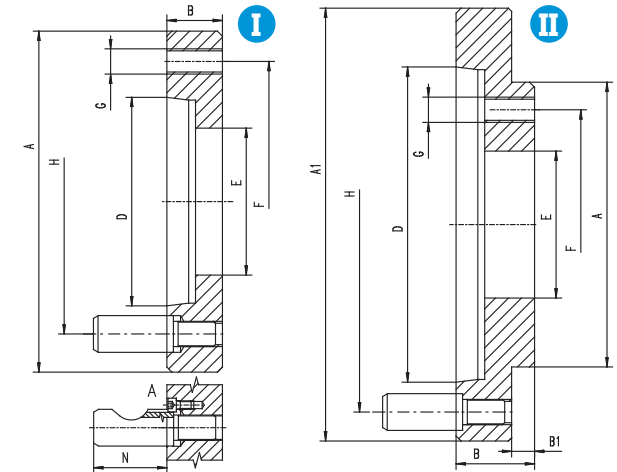


Artikel Nr. Code No.	W	KK 1:4 ST 1:4	Z	A h6	A1	B	B1	D	E	F	G	H	N	Q	kg
358247012200	200	6	II	110	181	40,0	5,5	106,375	50,0	82,6	M10	133,4	44,2	6	6,5
358247021100	250	6	II	150	181	50,0	7,5	106,375	65,0	104,8	M12	133,4	44,2	6	8,0
358247022400	250	8	II	150	225	46,0	7,5	139,719	65,0	104,8	M12	171,4	50,7	6	11,0
358247031300	315	6	II	175	181	70,0	7,5	106,375	80,0	133,4	M16	133,4	44,2	6	11,2
358247032600	315	8	II	175	225	60,0	7,5	139,719	80,0	133,4	M16	171,4	50,7	6	14,7
358247033900	315	11	II	175	298	50,0	7,5	196,869	80,0	133,4	M16	235,0	60,6	6	19,4
358247041500	400	8	II	200	225	70,0	10,5	139,719	100,0	171,4	M16	171,4	50,7	6	16,5
358247042800	400	11	II	200	298	60,0	10,5	196,869	100,0	171,4	M16	235,0	60,6	6	23,8
358247051700	500	8	I	270	-	38,0	-	139,719	136,2	235,0	M20	171,4	50,7	6	13,0
358247052000	500	11	II	270	298	45,0	12,5	196,869	192,9	235,0	M20	235,0	60,6	6	14,3
358247061900	630	11	II	270	298	50,0	12,5	196,869	160,0	235,0	M20	235,0	60,6	6	39,5

W - Futterdurchmesser • Chuck diameter Z - Form der Flansche • Adapter form

8247-1  
DIN 55029

FLANSCH FERTIGBEARBEITET FÜR  
4306, 4307  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*  
FULLY-FINISHED ADAPTER PLATES FOR  
4306, 4307  
32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*



Artikel Nr. Code No.	W	KK 1:4 ST 1:4	Z	A h6	A1	B	B1	D	E	F	G	H	N	Q	kg
358247072300	800	15	II	380	403	48,0	13	285,775	281,5	330,2	12xM24	330,2	69,6	6	22,2
358247090100	1000; 1250	11	I	520	-	45,0	-	196,869	192,9	463,6	12xM24	235,0	60,6	6	59,1
358247091400	1000; 1250	15	I	520	-	50,0	-	285,775	281,5	463,6	12xM24	330,2	69,6	6	56,6
358247092700	1000; 1250	20	II	520	546	55,0	-	412,775	408,0	463,6	12xM24	463,6	82,6	6	42,1
358247110800	1250	11	I	720	-	50,0	-	196,869	192,9	647,6	12xM30	235,0	60,6	6	142,0
358247111000	1250	15	I	720	-	50,0	-	285,775	281,5	647,6	12xM30	330,2	69,6	6	130,8
358247112300	1250	20	I	720	-	51,5	-	412,775	408,0	647,6	12xM30	463,6	82,6	6	111,3

W - Futterdurchmesser • Chuck diameter Z - Form der Flansche • Adapter form

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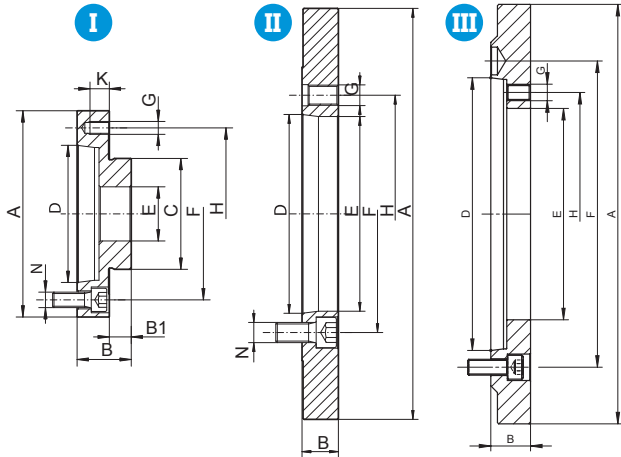
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**FLANSCH FERTIGBEARBEITET  
FÜR FUTTER MIT FEINEINSTELLUNG**  
FULLY MACHINED ADAPTER PLATES  
FOR CHUCKS WITH FINE ADJUSTMENT

8215  
DIN 55026

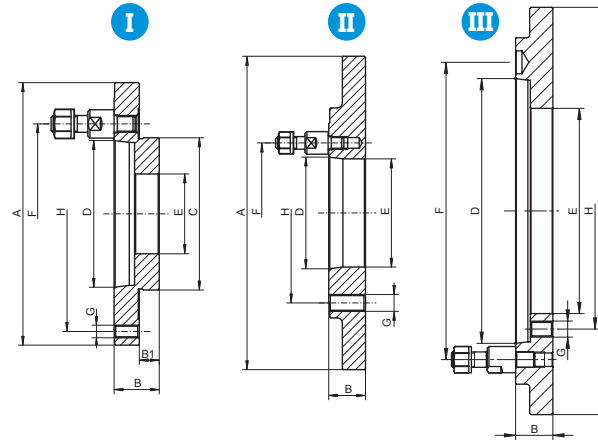


Artikel Nr.	W	KK 1:4 ST 1:4	Z	A	B	B1	C	D	E	F	G	H	K	kg
358215064900	125	4	I	125,00	36	14	55,00	63,513	35,0	82,6	M8	108,0	22	2,2
358215070000	125	5	I	125,00	36	14	55,00	82,563	35,0	104,8	M8	108,0	22	1,9
358215080100	160	5	I	160,00	37	16	86,00	82,563	42,0	104,8	M10	140,0	21	3,1
358215110000	200	5	I	200,00	33	17	110,00	82,563	55,0	104,8	M10	176,0	16	4,2
358215120100	200	6	I	200,00	45	17	110,00	106,375	55,0	133,4	M10	176,0	28	6,2
358215150700	250	5	I	250,00	38	19	145,00	82,563	76,0	104,8	M12	224,0	19	7,8
358215160900	250	6	I	250,00	38	19	145,00	106,375	76,0	133,4	M12	224,0	19	7,9
358215210000	315	8	I	315,00	46	19	180,00	139,719	103,0	171,4	M16	286,0	27	16,0
358215230400	400	6	II	298,45	35	-	298,45	106,375	136,0	133,4	M16	171,4	35	14,3
358215240600	400	8	II	298,45	37	-	298,45	139,719	136,0	171,4	M16	171,4	29	12,8
358215251000	400	11	II	298,45	48	-	298,45	196,869	136,0	235,0	M16	171,4	27	16,2
358215290500	500	15	II	407,00	52	-	407,00	285,775	190,0	330,2	M20	235,0	52	34,6
358215360000	630	11	II	407,00	36	-	407,00	196,869	192,8	235,0	M20	330,2	36	27,6
358215370200	630	15	II	407,00	52	-	407,00	285,775	252,0	330,2	M20	330,2	52	29,6
358215380400	800	11	II	635,00	40	-	635,00	196,869	192,8	235,0	M24	368,3	40	86,5

W - Futterdurchmesser • Chuck diameter Z - Form der Flansche • Adapter form

**FLANSCH FERTIGBEARBEITET  
FÜR FUTTER MIT FEINEINSTELLUNG**  
FULLY MACHINED ADAPTER PLATES  
FOR CHUCKS WITH FINE ADJUSTMENT

8235  
DIN 55027

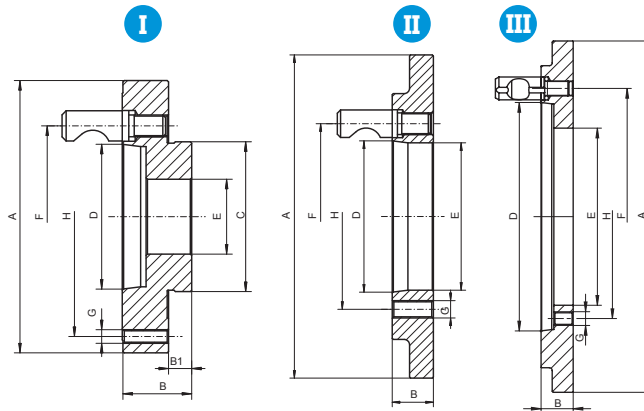


Artikel Nr.	W	KK 1:4 ST 1:4	Z	A	B	B1	C	D	E	F	G	H	kg
358235021800	125	4	I	125,00	33	14	55,00	63,513	35,0	85,0	M8	108,0	1,7
358235022000	125	5	I	130,00	35	14	55,00	82,563	35,0	104,8	M8	108,0	1,8
358235050000	160	5	I	160,00	37	16	86,00	82,563	42,0	104,8	M10	140,0	3,0
358235080600	200	5	I	200,00	33	17	110,00	82,563	55,0	104,8	M10	176,0	4,4
358235090800	200	6	I	200,00	40	17	110,00	106,375	55,0	133,4	M10	176,0	5,3
358235110400	250	6	I	250,00	38	19	145,00	106,375	76,0	133,4	M12	224,0	7,9
358235120600	250	8	I	250,00	43	19	145,00	139,719	76,0	171,4	M12	224,0	10,3
358235140000	315	8	I	315,00	43	19	180,00	139,719	103,0	171,4	M16	286,0	15,0
358235150100	315	11	I	315,00	50	19	180,00	196,869	103,0	235,0	M16	286,0	17,9
358235240000	400	8	II	298,45	37	-	298,45	139,719	135,8	171,4	M16	171,4	15,0
358235252800	400	11	II	298,45	37	-	298,45	196,869	120,0	235,0	M16	171,4	17,0
358235280800	500	11	II	407,00	36	-	407,00	196,869	192,8	235,0	M20	235,0	29,6
358235360500	630	11	II	407,00	36	-	407,00	196,869	192,8	330,2	M20	330,2	29,6

W - Drehfutterdurchmesser • Diameter Z - Form der Flansche • Adapter form

8245  
DIN 55029

**FLANSCH FERTIGBEARBEITET  
FÜR FUTTER MIT FEINEINSTELLUNG**  
FULLY MACHINED ADAPTER PLATES  
FOR CHUCKS WITH FINE ADJUSTMENT



Artikel Nr. Code No.	W	KK 1:4		Z	A	B	B1	C	D	E	F	G	H	kg
		ST 1:4												
● 358245820000	125	4	I	125,00	39,0	14	55	63,513	35,0	82,6	M8	108,0	2,6	
○ 358245822500	125	5	I	135,00	44,0	14	55	82,563	35,0	104,8	M8	108,0	3,1	
○ 358245840300	160	4	I	160,00	46,0	16	86	63,513	42,0	82,6	M10	140,0	4,5	
○ 358245850500	160	5	I	160,00	46,0	16	86	82,563	42,0	104,8	M10	140,0	4,5	
○ 358245870900	200	4	I	200,00	33,0	17	110	63,513	55,0	82,6	M10	176,0	4,7	
○ 358245880000	200	5	I	200,00	47,0	17	110	82,563	55,0	104,8	M10	176,0	7,2	
○ 358245890200	200	6	I	200,00	51,0	17	110	106,375	55,0	133,4	M10	176,0	8,0	
○ 358245910900	250	6	I	250,00	53,0	19	145	106,375	76,0	133,4	M12	224,0	12,9	
○ 358245920000	250	8	I	250,00	60,0	19	145	139,719	76,0	171,4	M12	224,0	14,7	
○ 358245930200	315	6	I	315,00	38,0	19	180	106,375	103,0	133,4	M16	286,0	12,9	
○ 358245940400	315	8	I	315,00	57,0	19	180	139,719	103,0	171,4	M16	286,0	21,7	
○ 358245950600	315	11	I	315,00	64,0	19	180	196,869	103,0	235,0	M16	286,0	24,0	
○ 358245971200	400	8	II	298,45	38,0	-	227	139,719	136,1	171,4	M16	171,4	11,9	
○ 358245981400	400	11	II	298,45	48,0	-	297	196,869	136,0	235,0	M16	171,4	17,5	
○ 358245994400	500	11	II	407,00	44,0	-	407	196,869	192,8	235,0	M20	235,0	35,3	
○ 358245995700	500	15	II	407,00	52,0	-	407	285,775	190,0	330,2	M20	235,0	37,8	

W - Futterdurchmesser • Chuck diameter    Z - Form der Flansche • Adapter form

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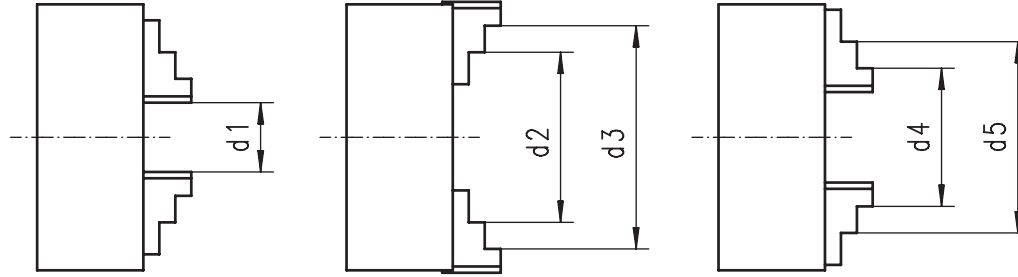
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**SPANNBEREICHE**  
CLAMPING RANGES

- Beachten Sie die maximal zulässigen Spannbereiche!
- Do not exceed the maximum allowable clamping ranges!



32\*\*, 35\*\*, 36\*\*, 37\*\*

Futtergröße [mm] Chuck size [mm]	Harte, einteilige Backen Hard solid jaws					Harte, geteilte Backen Hard 2-piece jaws					Max. Umlaufdurchmesser [mm] Max. swing diameter [mm]
	d1	d2	d3	d4	d5	d1	d2	d3	d4	d5	
80	2-27	25-50	48-71	22-46	45-69	-	-	-	-	-	90
100	3-33	32-62	62-93	25-56	56-87	-	-	-	-	-	117
125	3-50	39-83	80-125	34-74	72-115	3-50	52-96	95-125	34-76	75-118	151
160	3-64	50-107	98-160	42-100	94-154	3-64	62-121	115-160	42-97	88-146	204
200	4-90	60-145	130-200	52-135	120-202	4-90	72-156	133-200	50-130	105-190	246
250	5-118	77-188	160-250	62-174	145-256	5-118	86-197	160-250	58-165	125-235	306
315	10-131	90-215	190-315	78-200	172-299	10-131	103-226	190-315	65-182	145-265	384
400	10-180	103-272	230-400	85-252	210-380	10-180	127-294	230-400	72-228	165-329	472
500	20-235	140-357	276-500	120-335	245-476	20-235	110-400	190-500	120-410	200-485	600
630	30-335	180-487	345-630	160-465	325-630	30-335	120-570	200-630	140-590	210-630	770
800	150-482	302-634	468-800	282-614	448-780	150-482	240-724	316-800	252-736	328-800	940
1000	-	-	-	-	-	100-600	350-880	430-1000	425-900	500-1000	1140
1250	-	-	-	-	-	480-1000	585-1090	740-1250	580-1070	750-1250	1390
1400	-	-	-	-	-	480-1150	585-1240	750-1400	580-1220	750-1400	1540
1600	-	-	-	-	-	480-1330	585-1420	750-1600	580-1400	750-1600	1740
1800	-	-	-	-	-	480-1530	585-1620	750-1800	580-1600	750-1800	1950
2000	-	-	-	-	-	480-1725	585-1815	750-2000	580-1800	750-2000	2150

43\*\*

Futtergröße [mm] Chuck size [mm]	d1 min.	d3 max.	Max. Umlaufdurchmesser [mm] Max. swing diameter [mm]
85	3	85	101
100	3	10	116
125	8	125	150
160	8	160	185
200	10	200	235
250	10	250	296
315	15	315	369
350	15	350	404
400	20	400	465
500	45	500	570
630	50	630	720
800	50	800	900
1000	170	1000	1090
1250	170	1250	1340
1400	470	1400	1515
1600	470	1600	1715
1800	470	1800	1920
2000	470	2000	2120

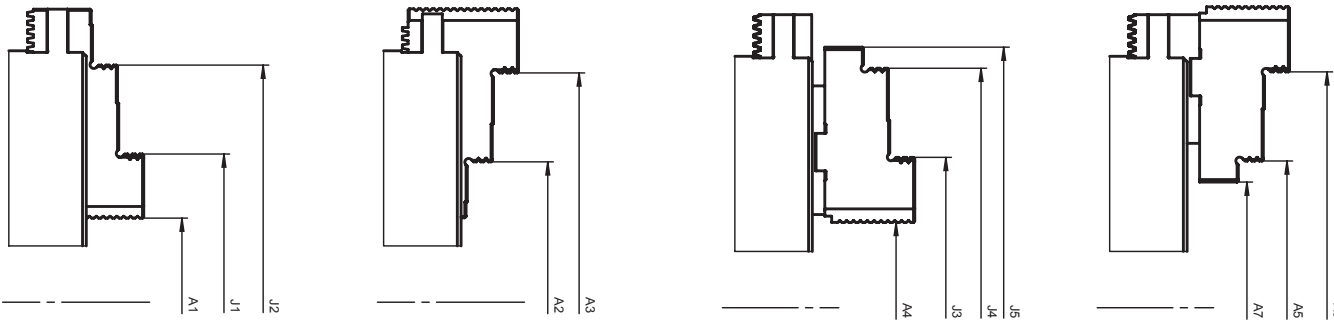
3864, 3865

Futtergröße [mm] Chuck size [mm]	Harte, einteilige Backen Hard solid jaws					Harte, geteilte Backen Hard 2-piece jaws					Max. Umlaufdurchmesser [mm] Max. swing diameter [mm]
	d1	d2	d3	d4	d5	d1	d2	d3	d4	d5	
125	6-43	42-78	83-120	34-68	74-110	6-43	50-87	94-125	33-70	76-119	151
160	8-64	52-107	102-160	47-100	98-154	8-64	67-121	118-160	45-97	92-146	204
200	8-90	64-145	132-200	55-135	121-202	8-90	74-156	134-200	52-130	109-190	246
250	12-118	82-188	165-250	68-174	150-256	12-118	82-188	164-250	68-174	150-256	306
315	12-131	95-215	192-315	82-200	178-299	12-131	108-226	153-315	68-182	150-265	384
400	15-202	140-308	232-400	95-280	213-400	15-202	132-296	236-400	73-252	169-352	472
500	30-235	152-361	291-500	132-335	270-474	30-235	121-402	197-478	135-413	210-489	600
630	40-335	192-487	358-630	175-467	340-630	40-335	132-555	210-630	150-585	220-630	770
800	-	-	-	-	-	180-482	290-644	420-800	285-635	440-800	940
1000	-	-	-	-	-	310-600	410-950	580-1000	415-840	530-1000	1140
1250	-	-	-	-	-	480-1000	585-1090	740-1250	580-1070	770-1250	1390
1400	-	-	-	-	-	480-1150	585-1240	750-1400	580-1220	770-1400	1540
1600	-	-	-	-	-	480-1330	585-1420	750-1600	580-1400	770-1600	1740
1800	-	-	-	-	-	480-1530	585-1620	750-1800	580-1600	770-1800	1950
2000	-	-	-	-	-	480-1725	585-1815	750-2000	580-1800	770-2000	2150

4505, 4605, 4705, 4805

Futtergröße [mm] Chuck size [mm]	d1 min.	d3 max.	Max. Umlaufdurchmesser [mm] Max. swing diameter [mm]
200	4	200	240
250	5	250	300
315	10	315	370
400	15	400	470
500	20	500	575
630	30	630	725
800	50	800	900
1000	175	1000	1100
1250	350	1250	1345
1400	350	1400	1520
1600	350	1600	1725
1800	350	1800	1925
2000	350	2000	2130

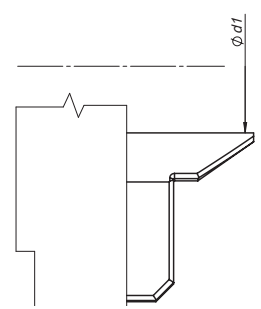




**SPANNBEREICHE**  
CLAMPING RANGES

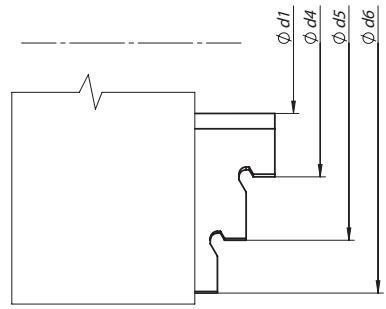
34\*\*

Futtergröße [mm] Chuck size [mm]	Harte, einteilige Backen Hard solid jaws					Harte, geteilte Backen Hard 2-piece jaws						
	A1	J1	J2	A2	A3	A4	J3	J4	A5	A6	J5	A7
125	4-29	28-53	100-125	38-63	100-125	10-25	38-80	107-125	27-62	90-125	72-110	60-95
160	4-90	34-120	90-160	61-150	90-160	10-39	60-134	86-160	100-147	120-160	132-160	35-88
200	5-105	49-149	100-200	70-170	100-200	10-50	70-184	103-200	100-174	120-200	152-200	45-124
250	8-130	66-188	128-250	81-170	120-250	10-64	94-170	174-250	80-154	160-235	195-250	60-185
315	10-155	74-200	142-315	95-189	152-315	24-88	108-210	214-315	100-215	145-315	236-315	80-195
400	10-174	120-276	258-400	118-278	260-413	15-168	124-272	263-412	115-268	260-410	-	-
500	52-254	158-358	290-500	165-360	306-500	64-256	166-360	306-502	165-360	305-500	-	-
630	-	-	-	-	-	25-326	165-490	335-630	210-512	352-654	-	-
800	-	-	-	-	-	170-410	335-573	475-715	368-660	510-800	-	-
1000	-	-	-	-	-	300-630	480-860	620-1000	570-860	715-1000	-	-
1200	-	-	-	-	-	480-895	645-1060	785-1200	770-1060	910-1200	-	-



**3868**

Futtergröße [mm] Chuck size [mm]	Ø d1
3868-85	1,5-25



**3286**

Futtergröße [mm] Chuck size [mm]	Ø d1	Ø d2	Ø d3	Ø d4	Ø d5	Ø d6	Ø d7
3286-49-M12x1	0,5-32	17-39	35-57	20-27	37-63	50-75	5-14
3286-60-M16x1	0,5-35	20-42	38-60	20-52	37-70	61-85	5-20

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**MAXIMAL ZULÄSSIGE DREHZAHLEN (MAX. U/MIN)**  
MAXIMUM PERMISSIBLE ROTATION SPEEDS (RPM)

Die zulässige Drehzahl des Futterers ist von vielen Faktoren abhängig, wie z.B. Drehparameter, Werkstückgewicht und dessen Unwucht, Typ der Bearbeitung (Dauer- oder Aussetzbetrieb) usw.

Die maximalen zulässigen Drehzahlen, die in den nachfolgenden Tabellen angegeben sind, dürfen keine Spannkraftminderung auf die Hälfte des Anfangswertes verursachen. Bei Arbeiten unter normalen/stabilen Bedingungen (Werkstück, Werkzeuge, Arbeitsbedingungen) ist eine Spannkraftminderung auf bis zu 67% des Anfangswertes zulässig.

Dies bezieht sich auf Futter mit Standardbacken, die nicht über den äußeren Durchmesser des Futterers hinausgehen und gleichzeitiger Beibehaltung der Wuchtgüte des „bearbeiteten Werkstück“ (nicht mehr als 20gmm/kg). Futter und Backen müssen einen guten technischen Zustand aufweisen. In anderen Fällen siehe den in der PN-M-60650 angegebenen Berechnungen.

Admissible revolutions of the chuck depend on many factors, such as cutting parameters, weight of the workpiece and its balance or type of machining (interrupted or continuous turning) etc.

The max. speeds as indicated in the table below should not cause a decrease of the clamping force to the half of its initial value. When machining in the stable conditions (machining material, tools, working conditions), the clamping force may be reduced by up to 67% of its initial value.

This relates to the chuck equipped with standard jaws, that do not protrude beyond the outer diameter of the chuck and the unbalance condition of the 'chuck-machining workpiece' is maintained (not exceeding 20gmm/kg). The chuck and jaws must be in good condition. Otherwise, refer to the calculations as indicated in the PN-M-60650.

3105, 32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*

Futtergröße [mm]	Max. U/min			
	Max. rpm			
	Stahlkörper		Gusskörper	
Chuck size [mm]	Steel body		Cast iron body	
	35**, 356*, 37**	38**, 386*	3105, 32**, 36**	38**
80	7.000	-	5.000	-
100	6.300	-	4.500	-
125	5.500	3.800	4.000	-
160	4.600	3.200	3.600	-
200	4.000	2.800	3.000	2.000
250	3.500	2.400	2.500	1.500
315	2.800	1.900	2.000	1.200
400	2.000	1.400	1.600	800
500	1.300	900	1.000	600
630	1.000	700	800	500
800	800	560	600	400
1000	600	400	400	-
1250	500	350	300	-
1400	440	-	250	-
1600	380	-	220	-
1800	340	-	190	-
2000	300	-	170	-

43\*\*

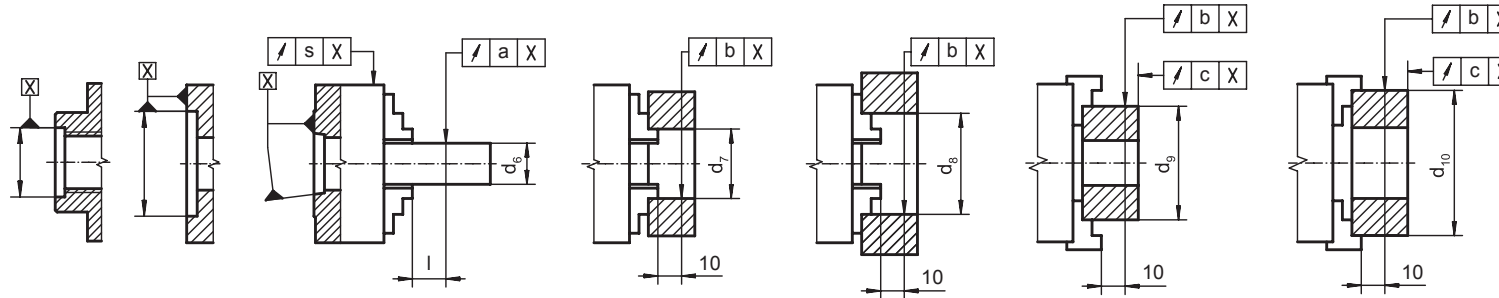
Futtergröße [mm]	Max. U/min	
	Max. rpm	
	Stahlkörper	Gusskörper
Chuck size [mm]	Steel body	Cast iron body
	80	7.640
85	7.190	-
100	6.120	-
125	4.890	-
140	4.370	-
160	3.820	-
200	3.060	1.800
250	2.450	1.500
315	1.940	1.200
400	1.530	860
500	1.220	690
630	970	550
800	760	430
1000	610	340
1250	490	280
1400	440	250
1600	380	220
1800	340	190
2000	300	170

4505, 4605, 4705, 4805

Futtergröße [mm]	Max. U/min			
	Max. rpm			
	4505	4605	4705	4805
Chuck size [mm]				
200	2.500	2.000	3.000	2.500
250	2.000	1.800	2.500	2.000
315	1.500	1.200	2.000	1.700
400	1.000	800	1.500	1.300
500	700	600	1.000	800
630	540	480	750	660
800	420	360	600	520
1000	280	240	380	330
1250	210	170	-	-

34\*\*

Futtergröße [mm]	Max. U/min
	Max. rpm
Chuck size [mm]	
125	6.000
160	5.400
200	4.600
250	4.200
315	3.300
400	2.400
500	1.500
630	1.200
800	960
915	840
1000	720
1250	600



**RUNDLAUFGENAUIGKEIT**  
CENTERING ACCURACY

32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*

Futtergröße [mm] Chuck size [mm]	I	d <sub>6</sub>	d <sub>7</sub>	d <sub>8</sub>	d <sub>9</sub>	d <sub>10</sub>		Rundlaufgenauigkeit [mm] Centering accuracy [mm]																	
						Harte, einteilige Backen Hard solid jaws	Harte, geteilte Backen Hard 2-piece jaws	35** PREMIUM				35**, 37**, 38**				32**, 36**				3284, 3285					
						a	b	c	s	a	b	c	s	a	b	c	s	a	b	c	s				
80	40	10	-	14	40	60	35	63	-	0,010	0,013	0,008	0,010	0,020	0,025	0,015	0,020	0,030	0,025	0,015	0,020	0,050	0,075	0,040	0,050
100	40	10	14	18	40	75	50	80	-	0,010	0,013	0,008	0,010	0,020	0,025	0,015	0,020	0,030	0,025	0,015	0,020	0,050	0,075	0,040	0,050
125	60	18	25	30	50	100	62	100	120	0,015	0,018	0,010	0,015	0,030	0,035	0,020	0,030	0,030	0,035	0,020	0,030	0,050	0,075	0,040	0,050
160	60	18	30	40	50	135	88	100	150	0,015	0,018	0,010	0,015	0,030	0,035	0,020	0,030	0,030	0,035	0,020	0,030	0,050	0,075	0,040	0,050
200	80	30	40	53	80	162	96	160	185	0,020	0,023	0,013	0,020	0,040	0,045	0,025	0,040	0,040	0,045	0,025	0,040	0,050	0,075	0,040	0,050
250	80	30	53	75	80	200	150	160	225	0,020	0,023	0,013	0,020	0,040	0,045	0,025	0,040	0,040	0,045	0,025	0,040	0,080	0,075	0,070	0,080
315	120	53	75	100	125	252	210	250	300	0,025	0,028	0,015	0,025	0,050	0,055	0,030	0,050	0,050	0,055	0,030	0,050	0,080	0,075	0,070	0,080
400	120	53	100	125	125	282	250	250	350	0,030	0,033	0,015	0,030	0,060	0,065	0,030	0,060	0,060	0,065	0,030	0,060	-	-	-	-
500	160	75	100	125	200	282	300	400	400	0,050	0,055	0,030	0,050	0,100	0,075	0,050	0,100	0,100	0,100	0,050	0,100	-	-	-	-
630	160	75	125	160	200	325	400	400	400	0,070	0,075	0,050	0,070	0,100	0,100	0,050	0,100	0,100	0,100	0,050	0,100	-	-	-	-
800	160	160	200	250	325	500	400	500	500	0,100	0,100	0,050	0,100	0,150	0,150	0,060	0,150	0,150	0,150	0,060	0,150	-	-	-	-
1000	160	250	315	400	500	630	500	-	630	0,120	0,120	0,060	0,120	0,150	0,150	0,080	0,150	0,150	0,150	0,080	0,150	-	-	-	-
1250	200	-	-	500	800	800	1000	-	1000	0,120	0,120	0,060	0,120	0,150	0,150	0,080	0,150	0,150	0,150	0,080	0,150	-	-	-	-
1400	200	-	-	500	800	800	1000	-	1000	0,120	0,120	0,060	0,120	0,150	0,150	0,100	0,150	0,180	0,180	0,120	0,180	-	-	-	-
1600	200	-	-	500	800	800	1000	-	1000	0,150	0,150	0,080	0,150	0,180	0,180	0,120	0,180	0,200	0,200	0,160	0,200	-	-	-	-
1800	200	-	-	500	800	800	1000	-	1000	0,200	0,200	0,120	0,200	0,220	0,220	0,160	0,220	0,250	0,250	0,200	0,250	-	-	-	-
2000	200	-	-	500	800	800	1000	-	1000	0,200	0,200	0,120	0,200	0,220	0,220	0,160	0,220	0,250	0,250	0,200	0,250	-	-	-	-

34\*\*

Futtergröße [mm] Chuck size [mm]	I	d <sub>6</sub>	d <sub>7</sub>	d <sub>8</sub>	d <sub>9</sub>	d <sub>10</sub>	Rundlaufgenauigkeit [mm] Centering accuracy [mm]					
							a	b	c	s		
125	60	14	20	29	50	100	95	125	0,015	0,015	0,010	0,020
160	60	14	20	38	50	135	100	160	0,020	0,015	0,010	0,020
200	80	14	22	50	80	162	150	200	0,020	0,020	0,010	0,020
250	80	15	32	64	80	200	180	250	0,020	0,020	0,010	0,020
315	120	20	64	89	125	252	225	290	0,025	0,025	0,010	0,025
400	120	53	100	125	125	282	250	300	0,030	0,030	0,015	0,030
500	160	75	100	125	200	325	300	400	0,050	0,050	0,030	0,050
630	160	75	125	160	200	400	400	400	0,070	0,070	0,050	0,070
800	160	200	250	282	400	500	400	630	0,100	0,10	0,050	0,100
1000	160	325	400	500	500	630	630	800	0,120	0,120	0,060	0,120
1200	160	500	630	-	700	800	800	1000	0,160	0,160	0,080	0,160

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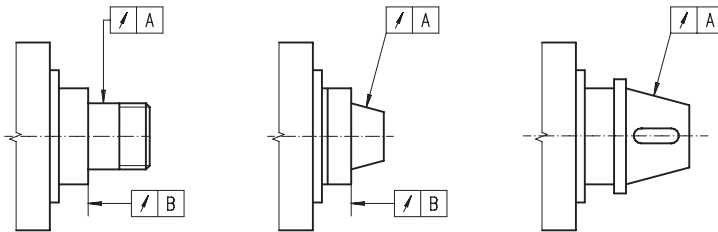
**RUNDLAUFGENAUIGKEIT DER SPINDELNASE**  
SPINDLE NOSE CENTERING ACCURACY

Für die Messung der Rundlaufgenauigkeit eines Futterers ist zu beachten, dass

- 1) der Rundlauffehler der Maschinenspindel den unten angegebenen Angaben entspricht
- 2) das Futter ordnungsgemäß auf der Spindel Nase montiert wurde.

To obtain the specified centering accuracy of a chuck mounted on a machine tool it is necessary:

- 1) to ensure the machine spindle nose run-out does not exceed the values specified,
- 2) to meet the basic requirements for correct mounting of the chuck on the spindle nose, according to the operations manual.



A · B			
35**		32**, 36**, 37**	
Ø 80 - 400	0,003mm	Ø 80 - 160	0,003mm
Ø 500 - 630	0,005mm	Ø 200 - 800	0,005mm

**UNWUCHTWERTE FÜR DREHFUTTER**  
BALANCE VALUE

35\*\*, 37\*\*

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

34\*\*

Futtergröße [mm] Chuck size [mm]	gcm
125	16
160	32
200	63
250	125
315	250

**MAX. SPANNKRAFT**  
TOTAL GRIPPING FORCE

- Die max. Spannkraft ist die Summe aller Kräfte der Backen, die radial auf das stationäre Werkstück wirken. Die angegebenen Spannkraften sind Näherungswerte.
- Voraussetzung hierfür ist ein einwandfreier Zustand des Futterers sowie eine ausreichende Schmierung gemäß der Bedienungsanleitung.

- The gripping force is the total sum of all jaws acting radially on the stationary, nonrotating workpiece.
- The data refer to a chuck in good condition lubricated with grease as recommended in the chuck manual.

3105, 32\*\*, 35\*\*, 36\*\*, 37\*\*, 38\*\*,  
45\*\*, 46\*\*, 47\*\*, 48\*\*

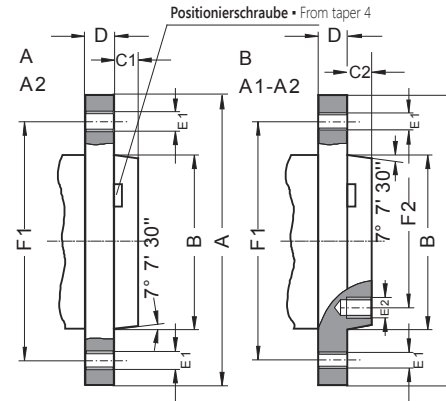
Futtergröße [mm] Chuck size [mm]	Anzugsmoment [Nm] Torque on wrench [Nm]	Spannkraft [daN] Total gripping force [daN]
80	35	1.000
100	50	1.700
125	75	2.400
160	120	3.100 (2.400*)
200	160	3.700 (2.900*)
250	180	4.600 (3.600*)
315	200	5.500 (4.400*)
400	280	6.500 (4.900*)
500	360	7.200
630	460	8.000
800	500	9.000
1000	500	11.500
1250	500	12.500
1400	500	12.500
1600	500	12.500
1800	500	12.500
2000	500	12.500

\* Für Typ 3105 • For Type 3105

34\*\*

Futtergröße [mm] Chuck size [mm]	Anzugsmoment [Nm] Torque on wrench [Nm]	Spannkraft [daN] Total gripping force [daN]
125	40	3.000
160	100	6.000
200	160	8.500
250	200	11.000
315	250	13.000
400	280	20.000
500	320	23.000
630	350	25.000
800	350	25.000
1000	350	25.000
1200	350	25.000

Spindelgröße Spindle nose size	A	B max.	C1	C2	D	E1 (DIN)	E1 (ISO)	F1	E2 (DIN)	E2 (ISO)	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	19,050	35	11xM20	11xM18	235,0	8xM20	8xM18	165,1
15	380	285,791	19	20,638	42	12xM24	12xM22	330,2	11xM24	11xM22	247,6
20	520	412,795	21	22,225	48	12xM24	-	463,6	11xM24	-	368,3
28	725	584,248	24	25,400	56	12xM30	-	647,6	11xM30	-	530,2



**DIN 55026 - TYP A, TYP B / TYPE A2, TYPE B**  
**ISO 702/I - TYP A2, TYP A1-A2 / TYPE A2, TYPE A1-A2**

- Typ A: Gewindelöcher im Flansch (äußerer Lochkreis) ohne inneren Lochkreis
- Typ B: Gewindelöcher im Flansch (äußerer Lochkreis) und im inneren Lochkreis
- Maße in Klammern entsprechen ISO 702/I
- 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



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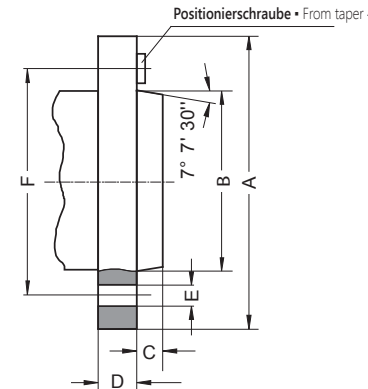
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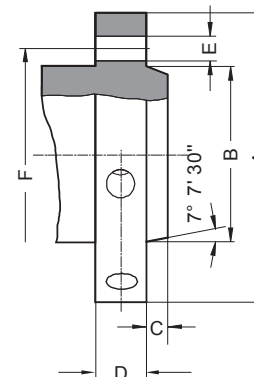
Spindelgröße Spindle nose size	A	B max.	C	D	E	F
3	102	53,983	11	16	3x21	75,0
4	112	63,521	11	20	3x21	85,0
5	135	82,573	13	22	4x21	104,8
6	170	106,385	14	25	4x23	133,4
8	220	139,731	16	28	4x29	171,4
11	290	196,883	18	35	6x36	235,0
15	400	285,791	19	42	6x43	330,2
20	540	412,795	21	48	6x43	463,6



**DIN 55027, ISO 702/III - TYP C / TYPE C**  
**MIT BAYONETT-SCHEIBE**  
**WITH BAYONET MOUNT RING**



Spindelgröße 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	6x23,0	133,4
8	225	139,731	16	50	6x26,2	171,4
11	298	196,883	18	60	6x31,0	235,0
15	403	285,791	19	70	6x35,7	330,2
20	546	412,795	21	82	6x42,1	463,6



**DIN 55029, ISO 702/II - TYP D / TYPE D**  
**CAMLOCK**



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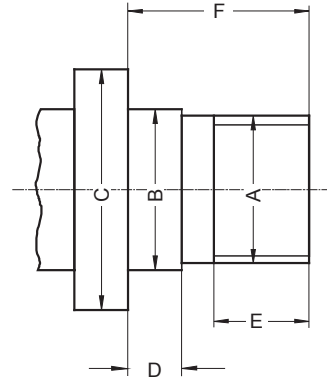
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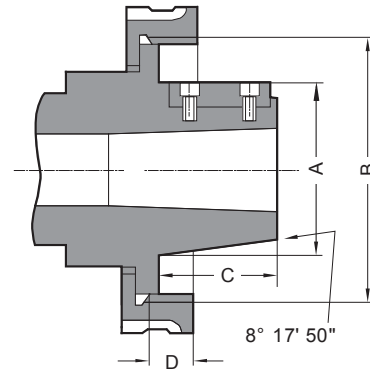
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**DIN 800 MIT GEWINDE**  
DIN 800 WITH THREAD



A	B g5	C min.	D	E	F
M 20	21	30	6,3	10	20
M 24	25	36	8,0	12	24
M 33	34	50	9,0	14	30
M 39	40	56	10,0	16	35
M 45	46	67	11,0	18	40
M 52	55	80	12,0	20	45
M 60	62	90	14,0	22	50
M 76x6	78	112	16,0	30	63
M 105x6	106	150	20,0	40	80

**TYP L - LANGKEGEL 7:24**  
TYPE L - LONG TAPER 7:24



Spindelgröße Spindle nose size	A +0.051	B	C	D	Mitnehmer Driving block
L00	69.850	3 3/4-6 UNS	50.800	14.288	9.525x38.10
L0	82.550	4 1/2-6 UNS	60.325	15.875	9.525x44.45
L1	104.775	6-6 UNS	73.025	19.050	15.875x60.32
L2	133.350	7 3/4-5 UNS	85.725	25.400	19.050x73.02
L3	165.100	10 3/8-4 UNS	94.425	28.575	25.400x82.55