

# Stainless hand-operated chucks

for EDM, metrology, ...

## Benefits at a glance

Only 3 different components  
simple assembly,  
easy to clean

repetitive clamping accuracy  $\leq 0,01\text{mm}$   
radial runout  $\leq 0,02\text{mm}$

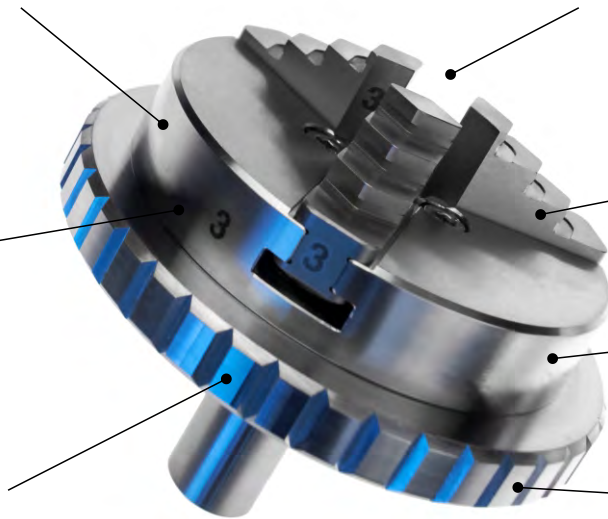
stainless  
steel

hardened, ground,  
reversible jaws

60% flatter than  
standard chucks

easily demagnetisable

clamping without the need  
for additional tools by  
turning the clamping ring



## Applications



### metrology

measurement of gearbox shafts  
measurement of spindles  
testing of needles and cannulas



### electrical discharge machining

wire erosion with rotating spindle  
usage as work piece holder in  
dividing machines



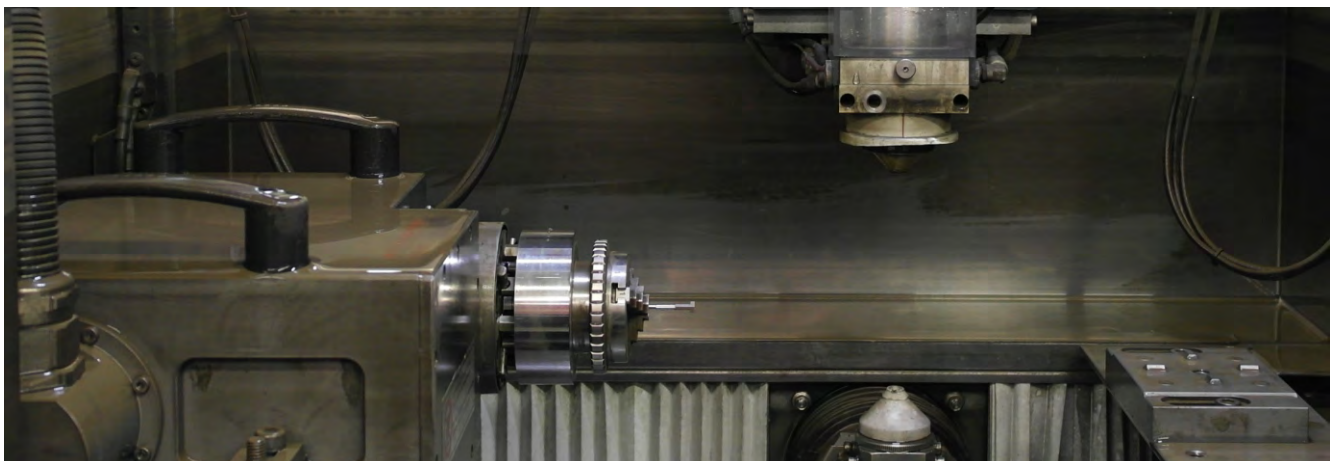
### underwater applications

ultrasonic testing  
ultrasound cleaning



### laser / electron beam

laser marking  
laser welding



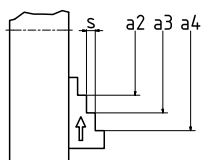
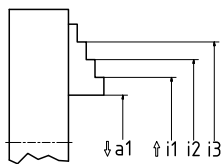
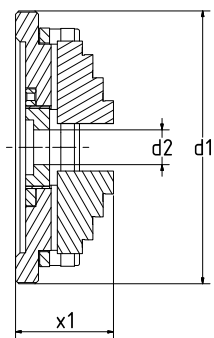
Application example: DBF63 in a wire EDM system with rotating spindle

# Stainless hand-operated chucks

for EDM, metrology, ..

All chucks of this type are made of stainless steel. The chucks are built to be flat and light. The adjustment of the chuck is done by turning the clamping ring. Thus a fast clamping can be done by hand - without the need for any additional tools.

## Dimensions



### outer dimensions<sup>1</sup>

	DBF63	DBF100	DBF140x58	DBF160
d <sub>1</sub>	69,5	119	138	159
d <sub>2</sub>	8,2	15,2	58	23
x <sub>1</sub>	29,25	42,7	43,6	108,8

### clamping range<sup>1</sup>

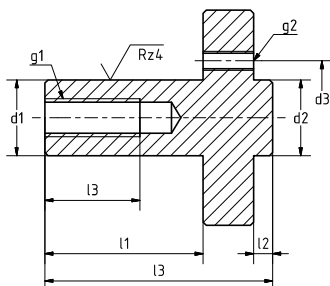
i <sub>1</sub>	12-32	20-60	24-68	24-82
i <sub>2</sub>	24-44	40-80	54-98	52-110
i <sub>3</sub>	36-56	60-100	84-128	80-138
a <sub>1</sub>	0-20	0-40	0-44	0-56
a <sub>2</sub>	15,4-32	30-74	30-74	30-80
a <sub>3</sub>	27,4-44	60-104	60-104	58-108
a <sub>4</sub>	39,4-56	90-134	90-134	86-136
s	3	4,5	4,5	7

### additional information

weight <sup>2</sup>	0,38kg	1,6kg	2,2kg	5,0kg
jaws	hardened, ground, reversible			

### standard fixture<sup>3</sup>

d <sub>1</sub> / l <sub>1</sub>	12h6 / 25	18h6 / 37,5	<sup>-4</sup>	25h6 / 45
d <sub>2</sub> / l <sub>2</sub>	12h6 / 3	24h6 / 3	<sup>-4</sup>	28h6 / 3
g <sub>1</sub> / l <sub>3</sub>	M5 / 12	M6 / 15	<sup>-4</sup>	M8 / 15
g <sub>2</sub> / d <sub>3</sub>	3xM3 / Ø18	3xM4 / Ø30	<sup>-4</sup>	3xM6 / Ø36
l <sub>3</sub>	36	52,5	<sup>-4</sup>	60



<sup>1</sup> drawings and CAD-data can be found on our website [www.kochmaschinenbau.de](http://www.kochmaschinenbau.de)

<sup>2</sup> weight without fixture

<sup>3</sup> special fixtures available on demand

<sup>4</sup> chuck is delivered without fixture by default

# Watchmaker lever scroll chucks

## for jewelry and watchmaking

The chucks are especially suited for light and precise work with low clamping forces in individual construction. Tensioning the work pieces is performed by turning the geared scroll without a key.

## Applications

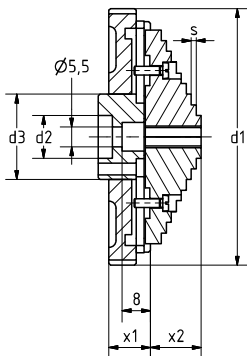


**watches**  
polishing housing parts  
precision turning of individual parts



**jewelry**  
turning of rings  
engraving of rings

## Dimensions



outer dimensions	DF56/3	DF56/4	RF 75	StF75	6-BF75	U6-BF75
d <sub>1</sub>	55,5	55,5	75	75	75	75
d <sub>2</sub> / d <sub>3</sub>	8H6 / 35	8H6 / 35	12H6 / 24	12H6 / 24	12H6 / 24	12H6 / 24
x <sub>1</sub>	15	15	12	12	12	12
<b>clamping range</b>						
rings inner Ø	12-50	12-50	10-65	-	-	-
discs outer Ø	8-49	8-49	-	8-65	-	36-50
biggest twist-out Ø	-	-	-	-	66	50
s	1,6	1,6	1,4	1,4	-	1-2
x <sub>2</sub>	8	8	14	13	13	8

### additional information

jaws	hardened	hardened	twist-out	twist-out	twist-out	twist-out
fixture	All types can be delivered with mounting shank for watchmaker lathes: <ul style="list-style-type: none"> <li>• Ø8 mm thread 6,85x40 Gg., e.g. Boley &amp; Leinen</li> <li>• Ø8 mm thread 7x40 Gg., e.g. Andrä&amp;Zwingenberger, Präzima, Saupe&amp;Sohn</li> </ul>					

