

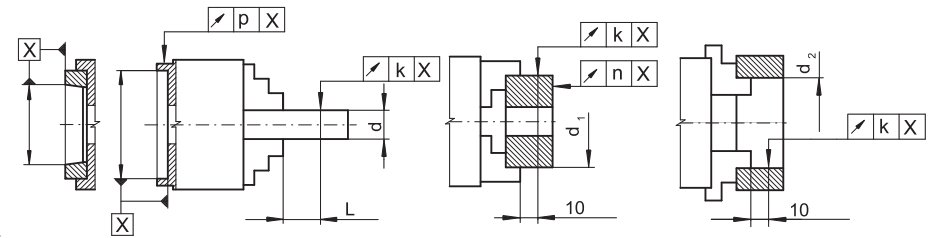
For Type 2405; 2405-K

Ø	d		d1	d2	L	k	n	p	
	[mm]								
135	18	32	40	100	75	40	0.02	0.02	0.01
160	20	32	50	125	100	40	0.025	0.02	0.01
200	32	50	80	200	125	40	0.025	0.02	0.01
250	32	50	80	200	162	60	0.03	0.03	0.01
315	50	80	125	250	162	80	0.04	0.03	0.01
400	75	100	125	250	252	80	0.05	0.04	0.01
500	-	125	160	275	300	120	0.06	0.05	0.01
630	-	200	400	520	400	120	0.08	0.05	0.01
800	-	250	520	-	600	120	0.15	0.06	0.01

For Type 2409

Ø	d		L	d1	d2	k	n	p	
	[mm]								
130	18	32	40	40	100	75	0.04	0.035	0.01
160	32	40	50	40	125	100	0.05	0.04	0.01
200	32	40	50	40	125	125	0.06	0.05	0.01
250	55	80	125	40	200	125	0.06	0.05	0.01
315	60	80	125	60	200	162	0.08	0.06	0.01

CENTERING ACCURACY



CLAMPING RANGE

For Type 2500

Ø	d1
	[mm]
400-140	20 - 140
500-230	65 - 280
630-325	138 - 335
1000-560	340 - 565

For Type 2409

Ø	d1	d2	d3	d4	d5	d6	d7	d8	d9
	[mm]								
160	22 - 90	68 - 140	104 - 175	142 - 210	24 - 94	62 - 132	98 - 168	6 - 42	36 - 72
200	28 - 126	86 - 182	134 - 232	182 - 280	29 - 126	76 - 174	124 - 220	10 - 60	50 - 100
250	60 - 156	120 - 216	168 - 264	218 - 315	60 - 156	108 - 204	158 - 254	27 - 76	82 - 130
315	58 - 214	118 - 274	166 - 320	215 - 372	58 - 214	108 - 264	156 - 315	26 - 134	80 - 190
315/300	74 - 200	153 - 280	216 - 342	280 - 408	74 - 200	138 - 264	202 - 328	33 - 98	88 - 152

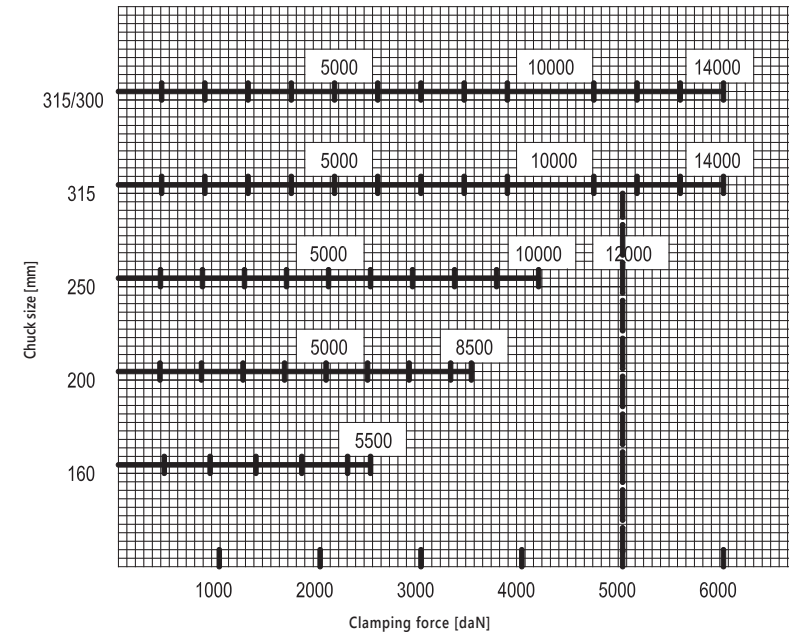
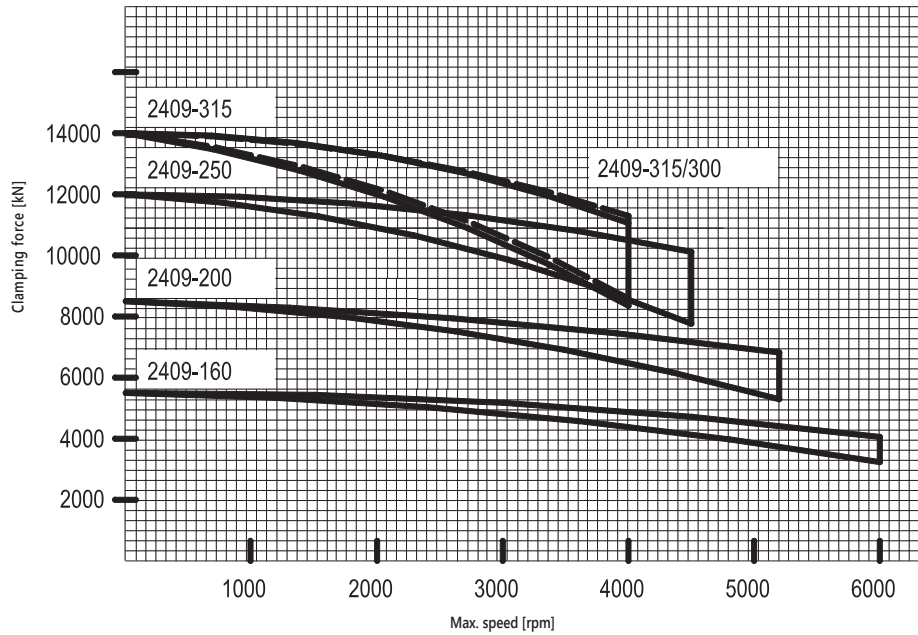
For Type 2405; 2405-K

Ø	d1	d2	d3	d4	d5	d6	d7
	[mm]						
135	10-72	52-112	83-144	118-180	14-73	50-109	82-141
160	15-95	66-144	104-184	145-226	20-97	62-139	102-179
200	14-118	77-179	125-229	175-279	25-118	89-168	153-218
250	18-134	100-214	162-277	226-342	25-140	89-204	153-268
315	38-197	118-274	177-334	246-403	38-197	107-266	167-326
400	46-234	157-343	240-429	328-517	46-234	134-322	220-408
500	84-338	193-447	278-533	366-621	100-338	187-426	273-512
630	174-475	281-582	-	448-749	183-475	-	351-643
800	255-550	414-657	-	308-550	582-826	-	476-719

For Type 2502

Ø	d1	d2	d3	d4	d5	d6	d7
	[mm]						
160-38	7-74	67-130	115-180	163-180	18-67	66-115	114-160
200-52	20-104	83-178	130-216	180-216	22-104	70-153	119-202
250-65	24-130	106-208	168-266	232-266	26-130	89-194	153-258
250-68	24-130	106-208	168-266	232-266	26-130	89-194	153-258
315-105	64-184	142-262	206-326	270-326	64-184	128-252	192-316
400-140	90-300	200-404	286-480	373-480	90-280	178-368	264-454
500-230	176-402	286-510	370-596	460-600	176-402	264-490	350-576
630-330	272-500	407-625	-	605-724	272-500	-	472-704
800-365	326-674	434-780	-	600-862	326-674	-	494-842
800-410	330-600	453-768	-	691-866	435-600	-	675-840
1000-560	530-766	636-951	-	804-1026	530-845	-	698-1006

SPANNKRAFT FÜR FUTTER 2409
CLAMPING FORCE FOR CHUCK 2409



CLAMPING FORCE LOSS

The clamping force loss during chuck rotation has been determined experimentally for chucks equipped with a hard top jaws. There are very low reductions in clamping force when the chuck is rotating compared to zero rotation speed.

Upper curve: The min. centrifugal force acting on the jaws
 Lower curve: The max. centrifugal force acting on the jaws

TOTAL CLAMPING FORCE

To obtain the specified total clamping force, the chuck has to be in a proper technical condition and should be lubricated with the GLEITMO-805 grease from FUCHS, as recommended by BISON

Example: For chuck 2409 size 315 mm and the clamping force of 5 kN, the total clamping force is approx. 11.7 kN