

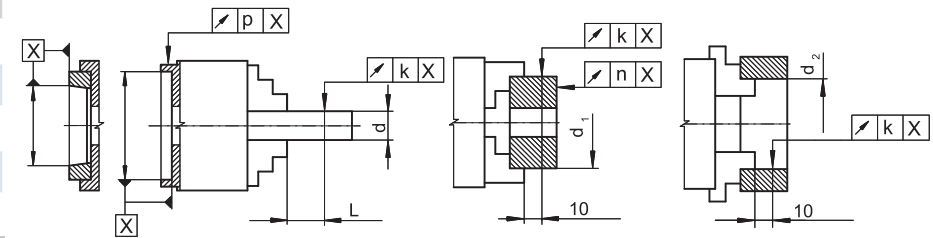
Für Typ • For Type 2405; 2405-K

| Ø   | d  | d1  | d2  | L   | k   | n   | p               |
|-----|----|-----|-----|-----|-----|-----|-----------------|
| 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  |

Für Typ • For Type 2409

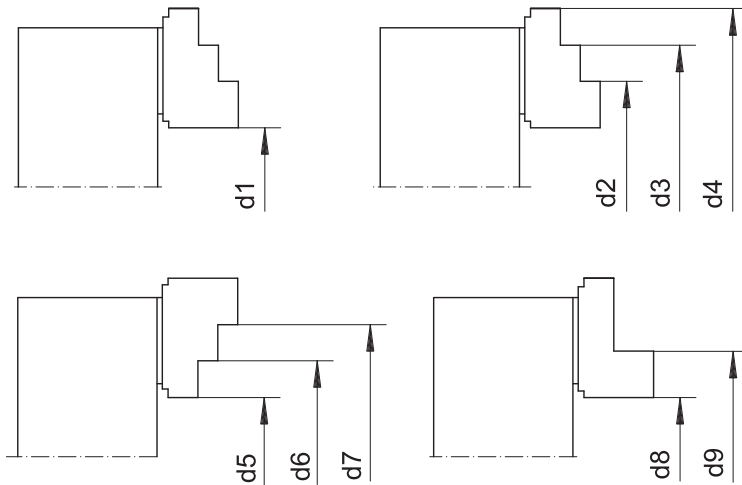
| Ø   | d  | L  | d1  | d2 | k   | n   | p               |
|-----|----|----|-----|----|-----|-----|-----------------|
| 130 | 18 | 32 | 40  | 40 | 100 | 75  | 0,04 0,035 0,01 |
| 160 | 32 | 40 | 50  | 40 | 125 | 100 | 0,05 0,04 0,01  |
| 200 | 32 | 40 | 50  | 40 | 125 | 125 | 0,06 0,05 0,01  |
| 250 | 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  |

**RUNDLAUFGENAUIGKEITEN**  
CENTERING ACCURACY



**SPANNBEREICHE**  
CLAMPING RANGE

Für Typ • For Type 2405; 2405-K



| Ø    | d1      | d2      | d3      | d4       | d5      | d6      | d7      |
|------|---------|---------|---------|----------|---------|---------|---------|
| 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 | -       | 582-826  | 308-550 | -       | 476-719 |
| 1000 | 310-680 | 435-804 | -       | 695-1064 | 264-624 | -       | 624-884 |

Für Typ • For Type 2500

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

Für Typ • For Type 2502

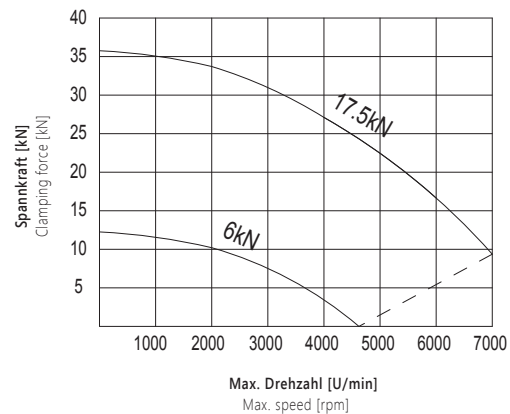
| Ø        | d1      | d2      | d3      | d4       | d5      | d6      | d7       |
|----------|---------|---------|---------|----------|---------|---------|----------|
| 160-38   | 7-74    | 67-130  | 115-180 | 163-180  | 18-67   | 66-115  | 114-160  |
| 200-52   | 20-104  | 83-178  | 130-216 | 180-216  | 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 |

Für Typ • For Type 2409

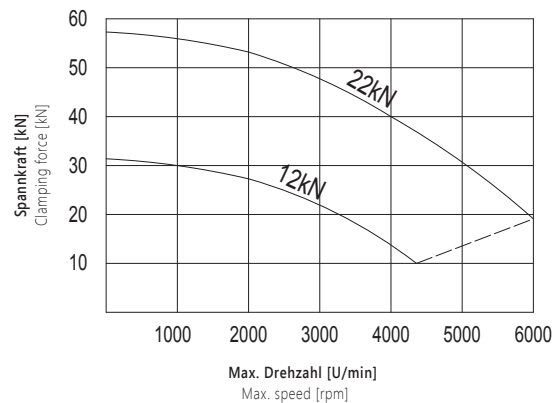
| Ø       | d1       | d2        | d3        | d4        | d5       | d6        | d7        | d8       | d9       |
|---------|----------|-----------|-----------|-----------|----------|-----------|-----------|----------|----------|
| 160     | 22 - 90  | 68 -140   | 104 -175  | 142 -210  | 24 - 94  | 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 |

**SPANNKRAFT IN ABHÄNGIGKEIT ZUR DREHZAHL 2405; 2405-K; 2405-A**  
GRIPPING FORCE LOSS DURING CHUCK ROTATION 2405; 2405-K; 2405-A

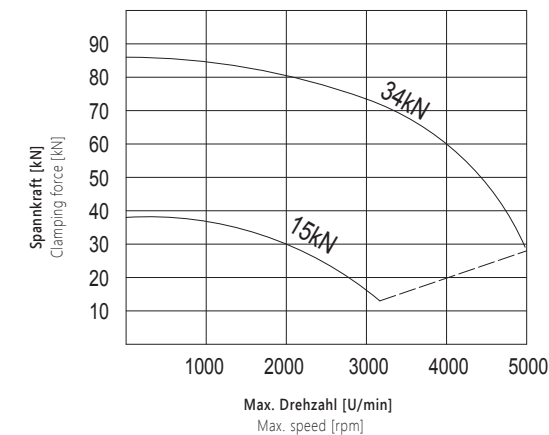
Futter Größe 135 mm  
Chuck size 135 mm



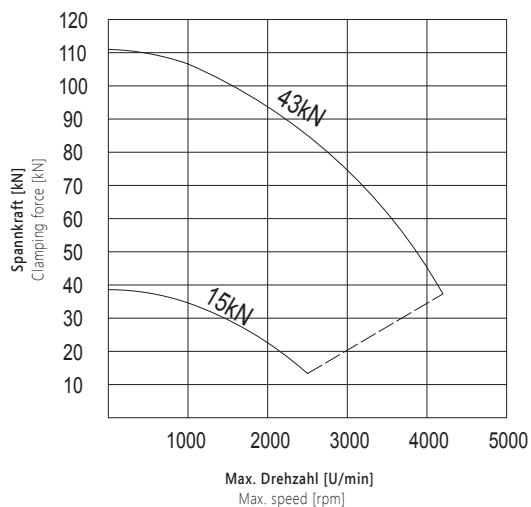
Futter Größe 160 mm  
Chuck size 160 mm



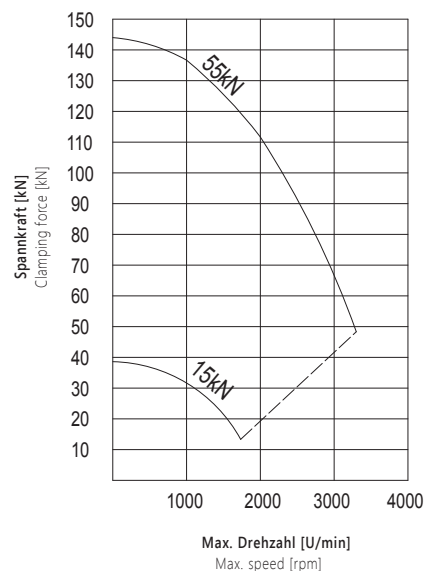
Futter Größe 200 mm  
Chuck size 200 mm



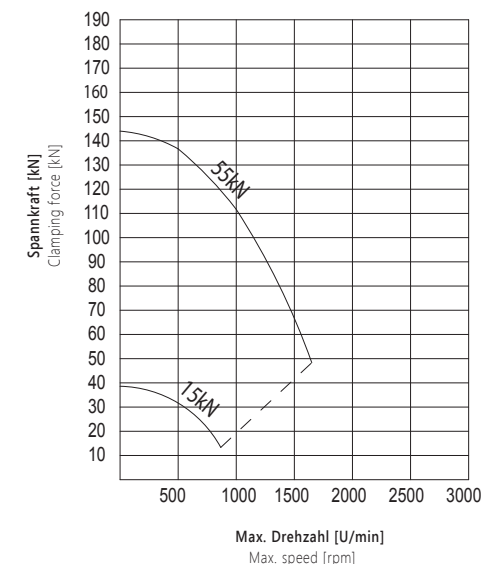
Futter Größe 250 mm  
Chuck size 250 mm



Futter Größe 315 mm  
Chuck size 315 mm

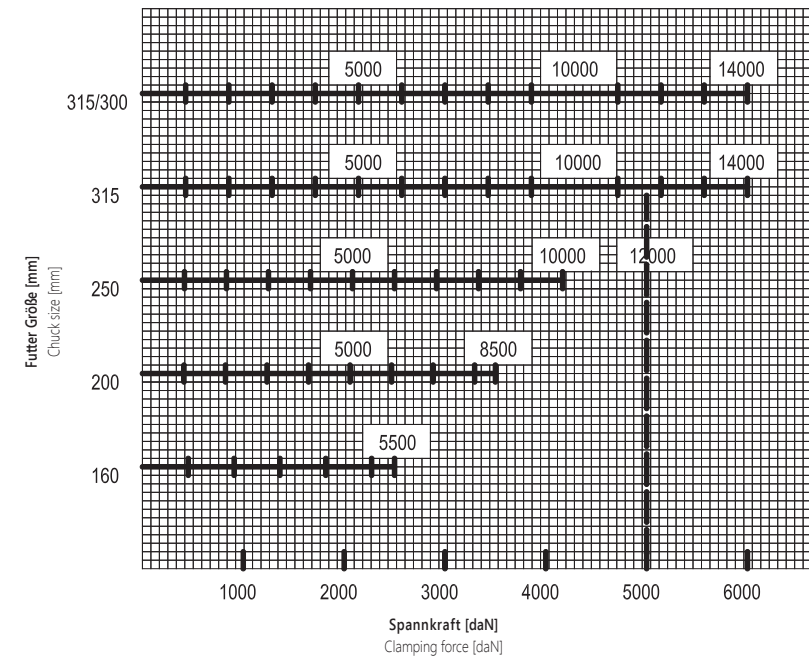
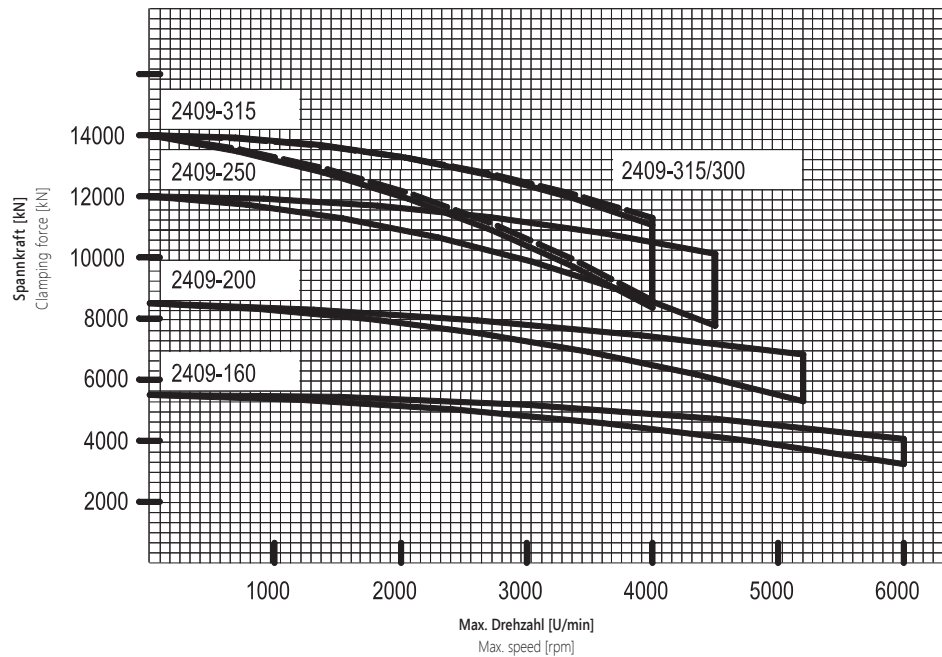


Futter Größe 400 mm  
Chuck size 400 mm



- 1
- 2
- 3
- 4
- 5
- 6

**SPANNKRAFT FÜR FUTTER 2409**  
CLAMPING FORCE FOR CHUCK 2409



**SPANNKRAFT EIGENSCHAFTEN**

CLAMPING FORCE LOSS

Die Spannkraft-Eigenschaften wurden mit einem Futter mit harten Aufsatzbacken ermittelt. Bei Stillstand des Futters haben die Backen und die Art des Aufbaus größtenteils keinen Einfluss auf die Spannkraft.

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.

Obere Kurve: min. Zentrifugalkräfte der Backen  
Untere Kurve: max. Zentrifugalkräfte der Backen

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

**TOTALE SPANNKRÄFT**

TOTAL CLAMPING FORCE

Um die spezifische totale Spannkraft des Futters zu erreichen, muss sich das Futter in einem technisch einwandfreien Zustand befinden. (z.B. Schmierung)

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

Beispiel: Für Futtertyp 2409 Größe 315 mm und einer Betätigungskraft von 5 kN beträgt die totale Spannkraft ca. 11.7 kN (alle am Werkstück anliegenden Kräfte)

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