

ZS Hi-Tru



Lathe and grinding chucks ZS Hi-Tru

APPLICATION

Optimized for machining workpieces which must be produced with **maximum concentricity**. Can be universally used, but is especially advantageous on turning and grinding machines as well as dividing units.

TYPE

Face spiral chuck in steel design, with which the workpiece can be adjusted very sensitively to the desired concentricity via 3 tangentially arranged adjusting spindles.

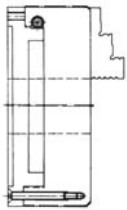
CUSTOMER BENEFITS

- ⊕ Radial fine adjustment for maximum concentricity
- ⊕ Repeatability 0.015 mm
- ⊕ Adjusting accuracy within 0.005 mm
- ⊕ Precision adjustment without opening the mounting screws
- ⊕ Jaws in chuck ground out for concentricity

TECHNICAL FEATURES

- With one set each of turning and drilling jaws
- Hardened adjusting spindles, as well as their support surfaces
- Hardened spiral ring
- Steel take-up flange

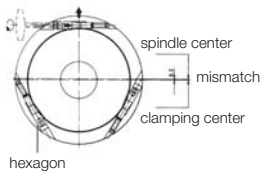
A09
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws DIN 6350, cylindrical centre mount, Form A



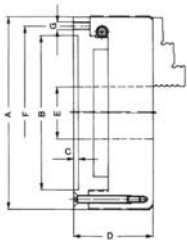
Item no.	Size	Cylindrical centre mount	Through-hole mm	Speed max. min ⁻¹	Torque Nm	Total clamping force kN
180259	80	56	19	7000	30	13
180261	100	70	20	6300	60	27
180263	125	95	32	5500	80	31
180265	160	125	42	4600	110	47
180267	200	160	55	4000	140	55
180269	250	200	76	3000	150	63
180271	315	260	103	2300	180	69

On request from size 125 with 6 jaws or with short-taper mount to ISO 702-3 (DIN 55027) or ISO 702-2 (DIN 55029) Camlock
Further sizes and mountings available on request

DIN 6350
Dimensions ZS Hi-Tru
Cylindrical centre mount,
Form A



Size A	Zoll	B ^{+0,02}	C	D	F	G	Hexagon	Weight
ZS Hi-Tru, with one set outward stepped jaws and one set inward stepped jaws								
80	3 ^{1/4}	56	3	50,5	67	3xM6	4	1,7
100	4	70	3	63	83	3xM8	5	3,6
125	5	95	4	72	108	3xM8	5	5,6
160	6 ^{1/4}	125	4	81	140	3xM10	6	10
200	8	160	4	89,5	176	3xM10	6	17,2
250	10	200	5	102	224	3xM12	8	34,5
315	12 ^{1/2}	260	5	122	286	3xM16	8	57,5



Jaws ZS Hi-Tru

A09

Inside jaw BB DIN 6350, outward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110155	80	set	37	26	12
110156	100	set	48	33,5	14
110157	125	set	52	41,5	18
110159	160	set	61	47,5	18
110160	200	set	69	53,5	20
110161	250	set	90	67,5	24
110162	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09

Outside jaw DB DIN 6350, inward stepped jaw, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
110165	80	set	37	26	12
110166	100	set	48	33,5	14
110167	125	set	52	41,5	18
110169	160	set	61	47,5	18
110170	200	set	69	53,5	20
110171	250	set	90	67,5	24
110016	315	set	130	79,5	34

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

A09

Unstepped jaw BL DIN 6350, unstepped, soft, 16MnCr5



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
107588	80	set	37	26	12
107589	100	set	48	33,5	14
107590	125	set	52	41,5	18
107592	160	set	61	47,5	18
107593	200	set	69	53,5	20
107594	250	set	90	67,5	24
107595	315	set	130	79,5	34

A09

Base jaw GB DIN 6350, with fixing screw



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw width
107500	100	set	46	14
107501	125	set	55	18
107503	160	set	65	18
107504	200	set	78	20
107505	250	set	92	24
107506	315	set	108	34

A09

Reversible top jaws UB DIN 6350, hardened



Item no.	Chuck Size	Contents of delivery	Jaw length	Jaw height	Jaw width
108045	100	set	47	29,5	22
108046	125	set	56	37,5	26
107936	160	set	66,7	41,5	28
107937	200	set	79,5	42,5	30
108049	250	set	95,3	52,5	36
108050	315	set	109,5	57,5	42

Additionally or later purchased, hardened jaws must be ground out in the chuck.
For jaws which are applied later, send in the chuck.

Configure your individual clamping jaws online! www.web2product.biz

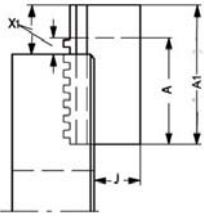
Jaws ZS Hi-Tru

A09
Unstepped top jaw AB DIN 6350, soft, material 16MnCr5



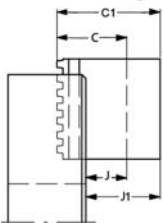
Item no.	Chuck size	Contents of delivery	Jaw length	Jaw height	Jaw width
107633	100	Satz	53	30	22,5
107634	125	Satz	62	38	26,5
108581	160	Satz	74	42	28,5
108582	200	Satz	87	43	30,5
107637	250	Satz	103	53	36,5
107638	315	Satz	120	58	42,5

A09
Unstepped jaw BL, special length, soft, 16MnCr5, DIN 6350



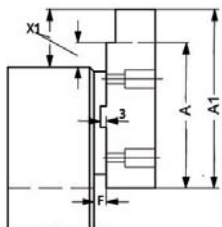
Item no.	Chuck size	A1 mm	X1 max. mm	A	J	X max.
130031	200	100	50	69	32,5	19
132658	250	120	56	90	41	26
132184	315	160	70	130	46	40
130033	200	120	70	69	32,5	19
128880	250	140	76	90	41	26
118908	315	200	110	130	46	40
121367	315	250	160	130	46	40

A09
Unstepped jaw BL, special height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	C1	J1 mm	C	J
125710	200	80	58,5	54	32,5
122188	250	100	73	68	41
132186	315	110	76	80	46
125712	200	120	98,5	54	32,5
122189	250	130	103	68	41
137096	315	140	106	80	46
125714	200	150	128,5	54	32,5
137102	250	150	123	68	41
137104	315	160	126	80	46

A09
Top jaw AB, special length, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	A1 mm	X1 max. mm	F	A	X max.
110086	200	100	43	6,8	87	30
112122	250	130	63	8	103	36
110624	315	160	76	5,5	120	36
112120	200	120	63	6,8	87	30
125428	250	150	83	8	103	36
112091	315	200	116	5,5	120	36
104710	250	180	113	8	103	36
112089	315	250	166	5,5	120	36

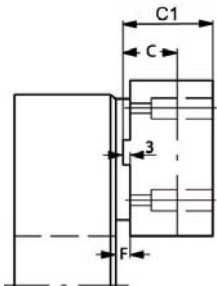
Jaws ZS Hi-Tru

A09

Top jaw AB, special height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	C1	C	F
132155	200	60	43	6,8
119645	250	70	53	8
110435	315	80	58	5,5
128564	200	80	43	6,8
128571	250	100	53	8
110437	315	110	58	5,5
128573	250	150	53	8
128569	315	150	58	5,5

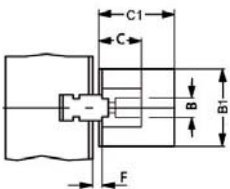


A09

Top jaw AB, special width and height, soft, 16MnCr5, DIN 6350



Item no.	Chuck size	B1	C1	B	C
105057	200	40	70	30.5	43
137090	250	50	80	36.5	53
143053	315	60	90	42	58
133259	200	50	80	30.5	43
133653	250	60	90	36.5	53
143057	315	80	110	42	58



C15

Mounting bolt for top jaws, bolt 1



Item no.	Chuck size	Thread	Contents of delivery
249299	100	M6x20	Stück
236949	125	M8x25	Stück
334571	160/200	M8x30	Stück
233025	250	M12x40	Stück
233026	315	M12x45	Stück

C15

Mounting bolt for top jaws, bolt 2



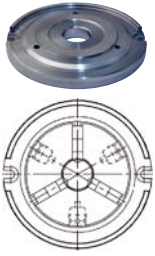
Id.-Nr.	Chuck size	Thread	Contents of delivery
216528	100	M6x16	Stück
233058	125/160/200	M8x20	Stück
227692	250	M12x25	Stück
233030	315	M12x30	Stück

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Accessories ZS Hi-Tru

Accessories ZS Hi-Tru

A09 Base plates for lathe chucks with **cylindrical centre mount**
DIN 6350



Item no.	Size
162793	160
162401	200
163036	250
133705	315

A09 Chip guard, piece



Item no.	Size	Contents of delivery
108500	80/85	piece
108501	100/110	piece
108502	125	piece
108503	140/160	piece
108504	200	piece
108505	250	piece
108506	315/350/400	piece

A09 Scroll



Item no.	Size
102183	80/85
101754	100
101721	125
100303	160
100003	200
100203	250
101552	315

A09 Pinion holder screw



Item no.	Size
102185	85
100305	160
100006	270
101554	315

A09 Safety key with ejector



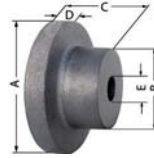
Item no.	Size	Square	Length mm
154370	80/85	6	110
154371	100/110	8	130
154372	125/140	9	130
154373	160	10	160
154374	200/230	11	160
154375	250/270	12	160
154376	315	14	200

A09 Safety adapter with ejector
for actuating the chuck with torque (defined torque introduction)



Item no.	Size	Square	Inch
178566	80/85	6	3/8
178567	100/110	8	1/2
178568	125/140	9	1/2
178569	160	10	1/2
178570	200/230	11	1/2
178571	250/270	12	1/2
178572	315/350	14	1/2

A09 Unfinished adapter plates for cylindrical mount
The unfinished back plate must be machined and fitted on both machine and chuck side



Item no.	Chuck Size	Inch	A mm	B mm	C mm	D mm	E mm
017113	80	3 1/4	92	56	47	15	20
017114	100	4	120	80	58	20	25
017115	125	5	135	80	58	20	25
017116	160	6 1/4	170	80	58	20	30
017117	200	8	210	92	66	22	40
017118	250	10	260	105	92	25	50

A09 Special grease F80 for lathe chucks
for lubrication and conservation of chucking power



Item no.	Design	Contents
308555	Cartridge	0,5 kg
028975	Tin	1 kg

A09 Driving pinion



Item no.	Size	Hexagon
178473	100	9
178474	110	9
178475	125	10
178476	140	10
178477	160	11
178478	200	12
178480	250	14
178482	315	17

A09 Standard key



Item no.	Size	Square	Length mm
107426	80/85	6	62
107427	100/110	8	75
107428	125/140	9	80
107429	160	10	90
107430	200/230	11	100
107431	250/270	12	100
107432	315	14	110

A09 Elongated safety key with ejector



Item no.	Size	Square	Length mm
154683	125/140	9	170
154685	160	10	180
154687	200/230	11	200
154689	250/270	12	200
154695	315	14	250

A09 Mounting screws
with **cylindrical centre rim**



Item no.	Size	Thread	Contents of delivery
249299	74-85	M6x20	piece
334571	100-140	M8x30	piece
249301	160-230	M10x35	piece
233025	250-270	M12x40	piece
220565	315-350	M16x50	piece