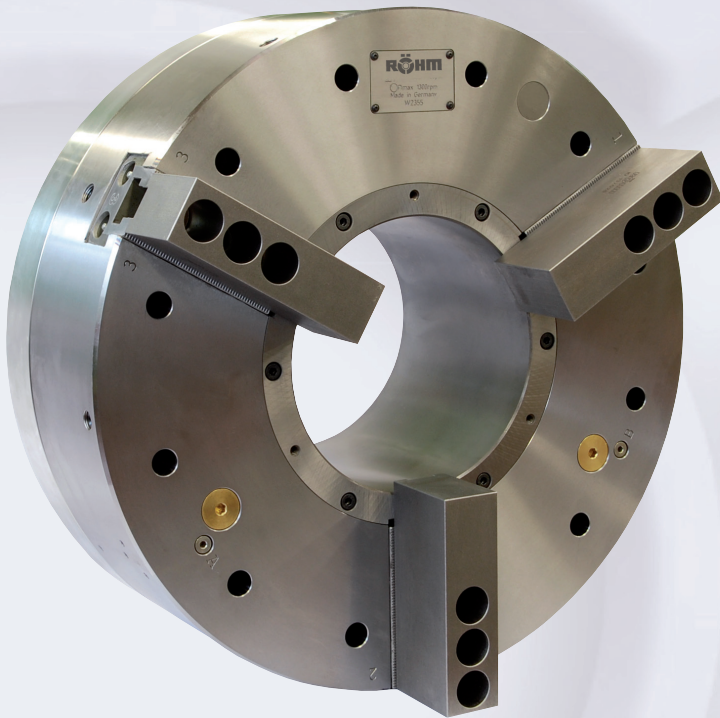


LVE - with large through-hole



Sizes 400-1000

For the machining of large and long pipes as frequently used in the oil and gas industry.

Flange-type workpieces can of course, be chucked as well. A very reliable chucking tool thanks to high safety and modern production.

- Self-contained unit
- Unobstructed bore throughout spindle thanks to the elimination of the draw tube
- Quick interchangeability with manually operated chucks
- No retooling necessary when changing from bar work to normal chucking
- Specially for tube finishing as self-contained chuck

Application (example)

Two chucks are mounted at the front and rear of the machine spindle. A selector switch on our combined pneumatic and electrical control unit, LSV Type 525-91, enables the two chucks to be used together or separately and even with different chucking pressures. These combinations permit the ends of large pipes to be machined with high stock removal rates and high turning accuracy.

Air-Operated Self-Contained Chucks Sizes 400-1000

A special feature of this chuck is a pneumatic piston built into the chuck body and which supplies the chucking power. The workpiece is clamped or released by compressed air supplied, with chuck stopped, via the distributor ring and a non-return valve to the pneumatic piston.

The pneumatic piston is screwed on to the clamping piston, which is itself connected to the base jaws via a wedgesystem.

An axial movement of the pneumatic piston thus produces a radial movement of the base jaws.

Distributor ring

The distributor ring has the function of transmitting the compressed air from outside into the chuck. This means that the ring is always stationary whilst the chuck rotates when the workpiece is being machined. It is therefore supported on the chuck and is prevented from turning with the chuck by means of a fork.

Special seals seal the gap between ring and chuck during the clamping movement to ensure smooth pressure transmission.

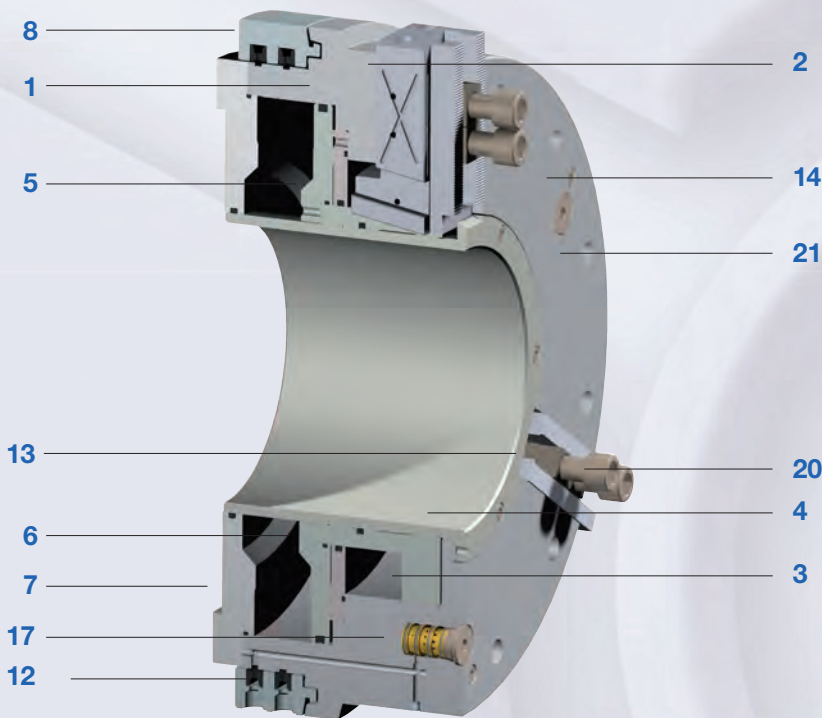
Important: To prevent destruction of the sealing ring pressure transmission must only be carried out with chuck stopped.

Control unit

The control unit has the function of keeping the compressed air required for clamping within a closed system throughout the whole machining operation.

It automatically seals the piston side under pressure, whereby the compressed air is automatically released from the opposite side of the piston. The valve can be dismounted as a complete unit and replaced.

LVE - with large through-hole



Components LVE

1. Body
2. Base jaw
3. Piston
4. Protective bush
5. Intermediate washer
6. Piston plate
7. Flange
8. Distributor ring
12. Seal
13. T-Nut
14. Air-vent screw
17. Control valve
20. Jaw fixing screws
21. Chuck fixing screws

Control system

Clamping efficiency depends very much on the tightness of the sealed air chamber. A pressure drop during machining means a drop in clamping force. With the "RÖHM control" the pressure in the sealed air chamber is monitored. If the pressure drops below a set minimum value, a spring-loaded pin mounted on the outside diameter of the chuck moves out.

A proximity sensor is mounted on the same level as the pin at a set radial distance. When the extended pin passes through the magnetic field of the switch, an electric pulse is triggered which can be used to stop the machine.

Wedge system

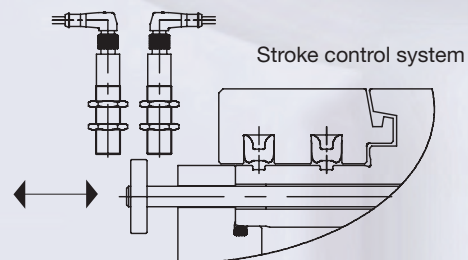
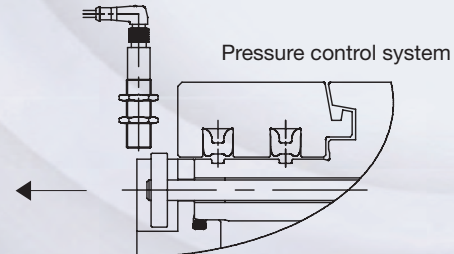
The transmission and conversion of axial piston force into radial jaw force is effected via the proven wedge system. The large power transmission surfaces guarantees long service life and permanent high precision of clamping. These features apply to both chucks with normal jaw stroke and chucks with rapid and clamping strokes.

Further versions on request

including, for example, compensating self-contained chucks and chucks that can be converted from self-centering to compensating action and vice versa.

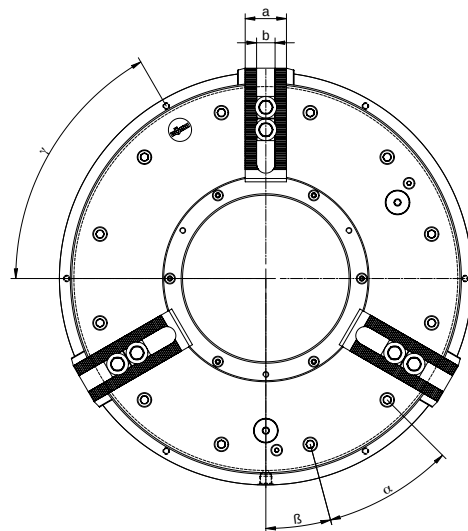
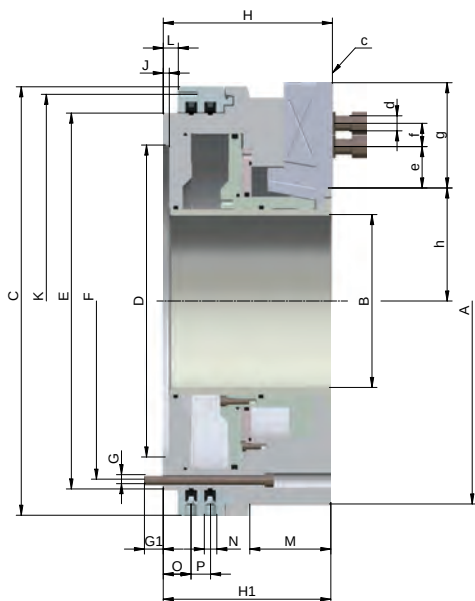
www.roehm.biz

RÖHM-Control system



The control unit is designed for LVE chucks with rapid and clamping strokes only for external clamping. For LVE chucks with a normal stroke only pressure control device for the external clamping is provided (on customer demand for internal clamping).

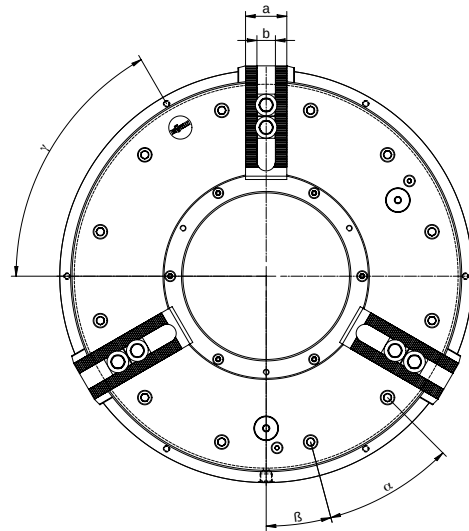
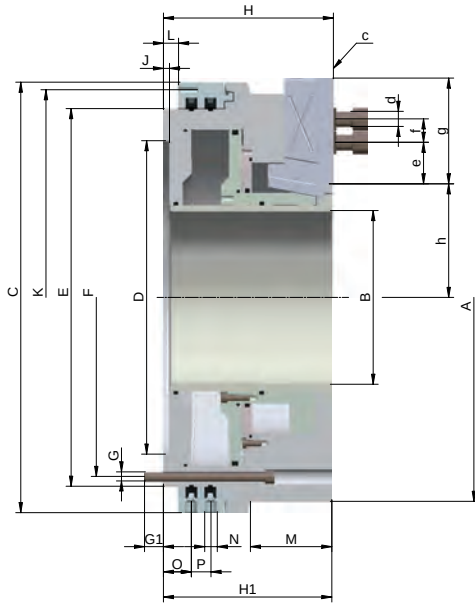
LVE - large through-hole, standard design



Tool group C 15
Type 525-00 3-jaw
self-contained chucks **LVE**,
with **large through-hole**,
max. operating pressure 8 bar,
with **serration**
adaptor recess
(standard design)

Item no.	169400 ▲	169401 ●	169402 ▲	169403 ●	169404 ▲	169405 ▲	169406 ▲	169407 ▲	169408 ▲	169409 ▲	169410 ▲
Size	400	400	500	500	600	600	600	700	800	800	1000
LVE	LVE 420-140	LVE 480-185	LVE 540-205	LVE 570-230	LVE 600-275	LVE 640-275	LVE 680-325	LVE 730-375	LVE 800-375	LVE 830-410	LVE 1000-570
Jaw travel	7	8,5	8,5	8,5	8,5	10	10	10	12	12	12
A	425	480	540	570	605	640	685	735	800	835	1000
B	140	185	205	230	280	275	325	375	375	410	570
C	470	530	570	570	605	685	685	735	850	850	925
DH6	310	365	415	415	450	510	510	560	700	700	700
E	400	460	500	500	535	610	610	660	775	775	850
F	374	434	474	474	508	580	580	630	745	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16	M16	M16
G ₁	25	25	25	25	25	30	30	30	30	30	30
H	196	225	225	225	225	263	263	263	305	305	315
H ₁	194	223	223	223	223	261	261	261	303	303	313
J	8	8	8	8	8	8	8	8	8	8	10
K	448	510	550	550	585	666	666	716	830	830	910
L	20	20	20	20	20	20	20	20	25	25	33
M	70	90	100	-	-	110	-	-	155	155	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O	37	37	37	37	37	39,5	39,5	39,5	44,5	44,5	52,5
P	26	26	26	26	26	33	33	33	33	33	33
a	57	57	57	57	57	75	75	75	75	75	75
bH7	25,5	25,5	25,5	25,5	25,5	30	30	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65	M24x65	M24x65
e	20	20	20	20	20	28	28	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42	42	42
f max.	85	85	105	105	105	100	100	100	125	125	125
g	120	120	140	140	135	145	145	145	173	173	173
h min.	94	118,5	131,5	141,5	164	175	195	220	225	242,5	323
h max.	101	127	140	150	172,5	185	205	230	237	254,5	345
α	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	30°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	140	155	210	190	200	240	155	175	405	360	180
Cylinder surface area cm ²	710	899	1045	940	1010	1414	1181	1307	2382	2121	1075
Air consumption (total stroke) l	20	31	36	32	35	58	49	55	117	104	85
Max. admissible speed min ⁻¹	1700	1500	1300	1300	1200	1000	900	800	750	750	450
Moment of inertia kgm ²	3,50	7,50	10,65	8,00	15,50	24,25	29,10	45,80	67,80	71,25	157,5
Weight kg	150	215	225	200	275	413	418	560	712	650	950

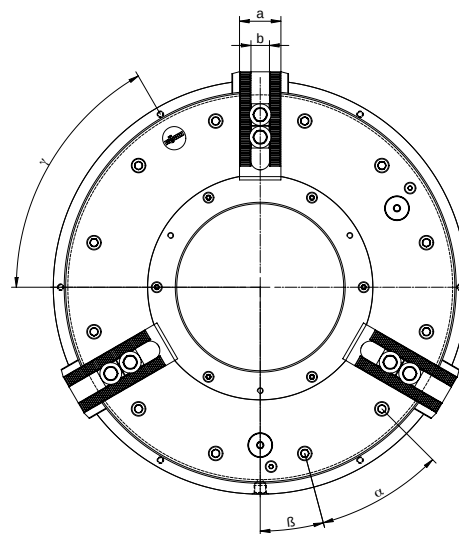
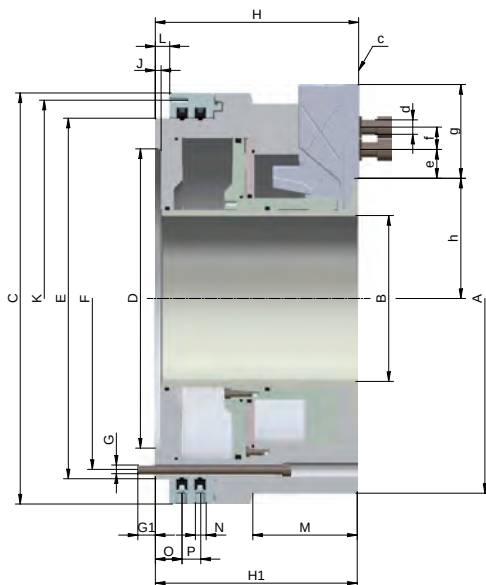
LVE - large through-hole, with pressure control device



Tool group C 15
Type 525-10 3-jaw
self-contained chucks **LVE**,
with **large through-hole**,
max. operating pressure 8 bar,
with **serration**
adaptor recess
with pressure control device for
external clamping

Item no.	169411 ▲	169412 ▲	169413 ▲	169414 ▲	169415 ▲	169416 ▲	169417 ▲	169418 ▲	169419 ▲	169420 ▲	169421 ▲
Size	400	400	500	500	600	600	600	700	800	800	1000
LVE	LVE 420-140	LVE 480-185	LVE 540-205	LVE 570-230	LVE 600-275	LVE 640-275	LVE 680-325	LVE 730-375	LVE 800-375	LVE 830-410	LVE 1000-570
Jaw travel	7	8,5	8,5	8,5	8,5	10	10	10	12	12	12
A	425	480	540	570	605	640	685	735	800	835	1000
B	140	185	205	230	280	275	325	375	375	410	570
C	470	530	570	570	605	685	685	735	850	850	925
DH6	310	365	415	415	450	510	510	560	700	700	700
E	400	460	500	500	535	610	610	660	775	775	850
F	374	434	474	474	500	580	580	630	745	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16	M16	M16
G ₁	25	25	25	25	25	30	30	30	30	30	30
H	196	225	225	225	225	263	263	263	305	305	315
H ₁	194	223	223	223	223	261	261	261	303	303	313
J	8	8	8	8	8	8	8	8	8	8	10
K	448	510	550	550	585	666	666	666	830	830	910
L	20	20	20	20	20	20	20	20	25	25	33
M	70	90	100	-	-	110	-	-	-	155	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O	37	37	37	37	37	39,5	39,5	39,5	39,5	44,5	52,5
P	26	26	26	26	26	33	33	33	33	33	33
a	57	57	57	57	57	75	75	75	75	75	75
bH7	25,5	25,5	25,5	25,5	25,5	30	30	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65	M24x65	M24x65
e	20	20	20	20	20	28	28	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42	42	42
f max.	85	85	105	105	105	100	100	100	125	125	125
g	120	120	140	140	135	145	145	145	173	173	173
h min.	94	118,5	131,5	141,5	164	175	195	220	225	242,5	323
h max.	101	127	140	150	172,5	185	205	230	237	254,5	345
α	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	140	155	210	190	200	240	155	175	405	360	180
Cylinder surface area cm²	710	899	1045	939	1010	1414	1181	1307	2382	2121	1075
Air consumption (total stroke) l	20	31	36	32	35	58	49	55	117	104	85
Max. admissible speed min ⁻¹	1700	1500	1300	1300	1200	1000	900	800	750	750	450
Moment of inertia kgm²	3,50	7,50	10,65	8,00	15,5	24,25	29,10	45,80	67,80	71,25	157,5
Weight kg	150	215	255	200	275	413	418	560	712	650	950

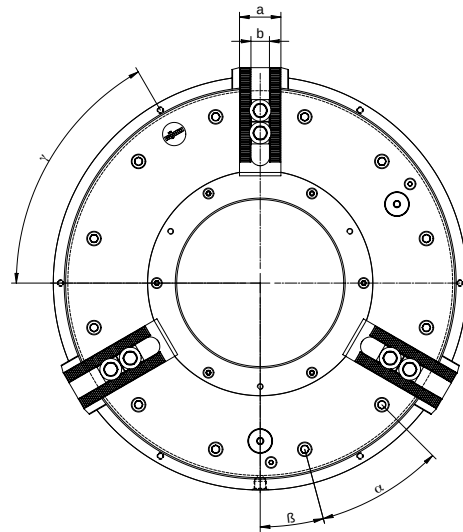
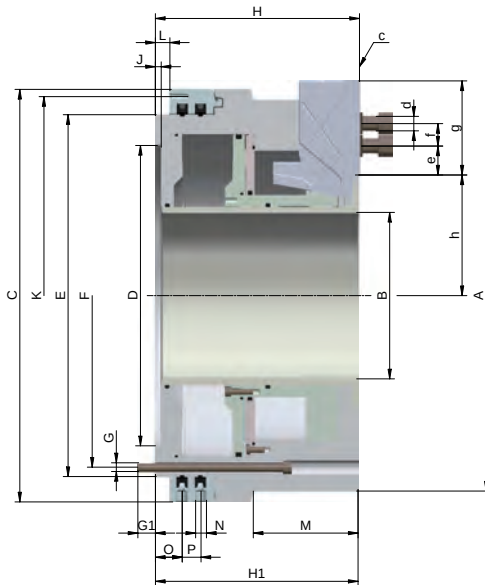
LVE - large through-hole, standard design, with rapid and gripping jaw movements



Tool group C 15
Type 525-20
3-jaw self-contained chucks LVE, with rapid and gripping jaw movements, with large through-hole, external chucking, max. operating pressure 8 bar, with serration 90° adaptor recess (standard design)

Item no.	169422 ▲	169423 ●	169424 ▲	169425 ●	169426 ▲	169427 ▲	169428 ▲	169429 ▲	169430 ▲	169431 ▲	169432 ▲
Size	400	400	500	500	600	600	600	700	800	800	1000
LVE	LVE 470-140 ES	LVE 490-185 ES	LVE 570-205 ES	LVE 570-230 ES	LVE 610-275 ES	LVE 680-275 ES	LVE 680-325 ES	LVE 730-375 ES	LVE 850-375 ES	LVE 850-410 ES	LVE 1000-570 ES
Jaw travel	19	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4
Rapid movement	12	16,9	16,9	16,9	16,9	16,9	16,9	16,9	14,9	14,9	14,9
Gripping movement	7	8,5	8,5	8,5	8,5	8,5	8,5	8,5	10,5	10,5	10,5
A	470	490	570	570	605	685	685	735	850	850	1000
B	140	185	205	230	275	275	325	375	375	410	570
C	470	530	570	570	605	685	685	735	850	850	925
DH6	310	365	415	415	450	510	510	560	700	700	700
E	400	460	500	500	535	610	610	660	775	775	850
F	374	434	474	474	508	580	580	630	745	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16	M16	M16
G ₁	25	25	25	25	25	30	30	30	30	30	30
H	240	282	282	282	282	308	308	308	322	322	332
H ₁	238	280	280	280	280	306	306	306	320	320	330
J	8	8	8	8	8	8	8	8	8	8	10
K	448	510	550	550	585	666	666	716	830	830	910
L	20	20	20	20	20	20	20	20	25	25	33
M	-	140	100	-	-	110	-	-	-	-	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O	37	37	37	37	37	39,5	39,5	39,5	44,5	44,5	52,5
P	26	26	26	26	26	33	33	33	33	33	33
a	57	57	57	57	57	75	75	75	75	75	75
bH7	25,5	25,5	25,5	25,5	25,5	30	30	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65	M24x65	M24x65
e	20	20	20	20	20	28	28	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42	42	42
f max.	80	80	95	95	95	95	95	95	120	120	120
g	112	112	130	130	125	140	140	140	170	170	170
h min.	126	132,6	142,1	154,6	177,1	182,6	202,6	227,6	234,6	252,1	329,6
h max.	145	158	167,5	180	202,5	208	228	253	260	277,5	355
α	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°
γ	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	120	150	190	170	180	240	200	175	200	185	180
Cylinder surface area cm ²	700	862	1003	895	958	1414	1181	1307	1345	1130	1075
Air consumption (total stroke) l	32	42	48	45	46	68	57	63	80	67	65
Max. admissible speed min ⁻¹	1500	1300	1200	1200	1100	900	800	750	750	750	450
Moment of inertia kgm ²	6,50	8,25	14,65	12,75	19,10	32,80	34,25	47,50	103,0	91,85	158,2
Weight kg	200	260	320	270	350	500	490	580	970	825	955

LVE - large through-hole, with pressure control device, with rapid and gripping jaw movements

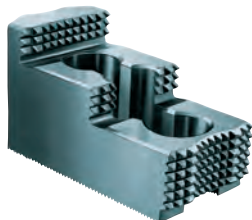


Tool group C 15
Type 525-30 3-jaw
self-contained chucks **LVE**,
with **rapid and gripping jaw**
movements,
with **large through-hole**,
external chucking,
max. operating pressure 8 bar,
with **serration**
adaptor recess
with pressure control device for
external clamping

Item no.	169433 ▲	169434 ▲	169435 ▲	169436 ▲	169437 ▲	169438 ▲	169439 ▲	169440 ▲	169441 ▲	169442 ▲	169443 ▲
Size	400	400	500	500	600	600	600	700	800	800	1000
LVE	LVE 470-140 ES	LVE 490-185 ES	LVE 570-205 ES	LVE 570-230 ES	LVE 610-275 ES	LVE 680-275 ES	LVE 680-325 ES	LVE 730-375 ES	LVE 850-375 ES	LVE 850-410 ES	LVE 1000-570 ES
Jaw travel	19	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4	25,4
Rapid movement	12	16,9	16,9	16,9	16,9	16,9	16,9	16,9	14,9	14,9	14,9
Gripping movement	7	8,5	8,5	8,5	8,5	8,5	8,5	8,5	10,5	10,5	10,5
A	470	490	570	570	605	685	685	735	850	850	1000
B	140	185	205	230	275	275	325	375	375	410	570
C	470	530	570	570	605	685	685	735	850	850	925
DH6	310	365	415	415	450	510	510	560	700	700	700
E	400	460	500	500	535	610	610	660	775	775	850
F	374	434	474	474	509	580	580	630	745	745	815
G	M12	M12	M12	M12	M12	M16	M16	M16	M16	M16	M16
G ₁	25	25	25	25	25	30	30	30	30	30	30
H	240	282	282	282	282	308	308	308	322	322	332
H ₁	238	280	280	280	280	306	306	306	320	320	330
J	8	8	8	8	8	8	8	8	8	8	10
K	448	510	550	550	585	666	666	716	830	830	910
L	20	20	20	20	20	20	20	20	25	25	33
M	-	140	100	-	-	110	-	-	-	-	225
N	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8	G 3/8
O	37	37	37	37	37	39,5	39,5	39,5	44,5	44,5	52,5
P	26	26	26	26	26	33	33	33	33	33	33
a	57	57	57	57	57	75	75	75	75	75	75
bH7	25,5	25,5	25,5	25,5	25,5	30	30	30	30	30	30
c	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°	3/32"x90°
d	M20x50	M20x50	M20x50	M20x50	M20x50	M24x65	M24x65	M24x65	M24x65	M24x65	M24x65
e	20	20	20	20	20	28	28	28	28	28	28
f min.	32	32	32	32	32	42	42	42	42	42	42
f max.	80	80	95	95	95	95	95	95	120	120	120
g	112	112	130	130	125	140	140	140	170	170	170
h min.	126	132,6	142,1	154,6	177,1	182,6	202,6	227,6	234,6	252,1	329,6
h max.	145	158	167,5	180	202,5	208	228	253	260	277,5	355
α	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°	30°
β	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°	15°
	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°
Min. operating pressure bar	2	2	2	2	2	2	2	2	3	3	3
Max. operating pressure bar	8	8	8	8	8	8	8	8	8	8	8
Total clamping force at 6 bar kN	120	150	210	170	180	240	200	175	200	185	180
Cylinder surface area cm ²	700	862	1024	895	958	1414	1181	1307	1345	1130	1075
Air consumption (total stroke) l	32	42	50	45	46	68	57	63	80	67	65
Max. admissible speed min ⁻¹	1500	1300	1200	1200	1100	900	800	750	750	750	450
Moment of inertia kgm ²	6,50	8,25	14,65	12,75	19,10	32,80	34,25	47,50	103,0	91,85	158,2
Weight kg	200	260	320	270	350	500	490	580	970	825	955

Jaws LVE

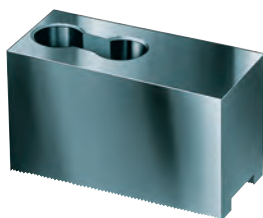
Tool group C 21
Type 543/538
Reversible top jaws, 3-jaw set, hardened
Serration 90°
material: 16 MnCr 5



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width	Serration
037531 ●	400	135	65	68	3/32"x 90°
169464 ▲	600/700	170	75	80	3/32"x90°
169466 ●	800/1000	195	85	80	3/32"x90°

Hardened jaws, supplied as supplement or as spares, must be ground on the chuck.

Tool group C 21
Type 543/538
Soft top jaws, 3-jaw set, can be hardened
Serration 90°
material: 16 MnCr 5



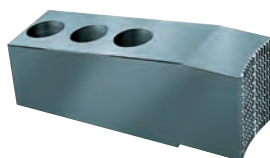
Item no.	Chuck Size	Jaw length	Jaw height	Jaw width	Serration
118004 ■	400/500/600	130	80	50	3/32"x90°
137028 ●	400/500/600	180	80	50	3/32"x 90°
169450 ●	600/700	215	89	68	3/32"x90°
169452 ●	600/700/800/1000	245	89	68	3/32"x90°

Tool group C 21
Type 543
extented soft top jaws, 3-jaw set
Serration 90°
material: 16 MnCr 5



Item no.	Chuck Size	Jaw length	Jaw height	Jaw width	Serration
137028 ●	400/500/600	180	80	50	3/32"x 90°
169449 ●	500/600	205	80	50	3/32"x90°
169452 ●	600/700/800/1000	245	89	68	3/32"x90°
169456 ●	800/1000	285	89	68	3/32"x90°

Tool group C 21
Type 543
extented hardened top jaws, 3-jaw set **Serration 90°**
material: 16 MnCr 5

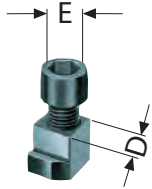


Item no.	Chuck Size	Jaw length	Jaw height	Jaw width	Serration
284627 ●	400	170	80	50	3/32"x 90°
321209 ●	500/600	210	80	50	3/32"x 90°
169458 ●	600/700	225	89	68	3/32"x90°
169460 ●	800	285	89	68	3/32"x90°
169462 ■	1000	325	89	68	3/32"x90°

Accessories LVE

Tool group C 15

Type 525-00 T-nuts without screw



Item no.	Chuck Size	Contents of delivery	D	E
588960 ▲	400/500/600	piece	25,5	M20
169447 ▲	400/500/600	piece	25,5	3/4-10 UNC
588770 ●	600/700/800/1000	piece	30	M24
169448 ▲	600/700/800/1000	piece	30	7/8-9 UNC

Tool group C 15

Type 0040-Y Mounting screws

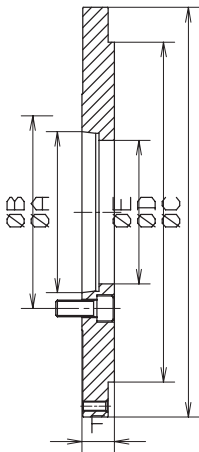


Item no.	Size	Contents of delivery	Thread
249388 ●	630	piece	M20x50
243854 ●	400/500/600	piece	3/4-10 UNCx2
236514 ●	600/700/800/1000	piece	M24x60
680392 ●	600/700/800/1000	piece	7/8-9 UNCx2-1/4

Socket head cap screw to DIN 912, 12.9

Tool group C 15

Type 518-10 Short-taper intermediate flanges ISO 702-1 (DIN 55026) for LVE-chucks with centering rim



Item no.	LVE	Spindle nose size	A	B	C	D	E	F
169475 ■	400-140	A8	139,719	171,4	400	310	136	40
169477 ■	400-140	A11	196,869	235	400	310	140	40
169479 ■	480-185	A8	139,719	171,4	460	365	136	40
169481 ■	480-185	A11	196,869	235	460	365	185	40
169483 ■	480-185	A15	285,775	330,2	460	365	185	40
169485 ■	540-205 / 570-230	A11	196,869	235	500	415	192	40
169487 ■	540-205 / 570-230	A15	285,775	330,2	500	415	230	40
169489 ■	540-205 / 570-230	A20	412,775	463,6	500	415	230	40
169491 ■	600-275	A11	196,869	235	545	415	192	40
169493 ■	600-275	A15	285,775	330,2	545	415	275	40
169495 ■	600-275	A20	412,775	463,6	545	415	275	40
169497 ■	630-275 / 680-325	A11	196,869	235	610	510	192	50
169499 ■	630-275 / 680-325	A15	285,775	330,2	610	510	281	50
169501 ■	630-275 / 680-325	A20	412,775	463,6	610	510	325	50
169503 ■	730-375	A15	285,775	330,2	660	560	281	50
169505 ■	730-375	A20	412,775	463,6	660	560	375	50
169507 ■	800-375 / 830-410	A15	285,775	330,2	775	700	281	50
169509 ■	800-375 / 830-410	A20	412,775	463,6	775	700	407,5	50
169511 ■	1000-570	A20	412,775	463,6	775	700	407,5	50
169513 ■	1000-570	A28	584,225	647,6	775	700	578,5	50

ISO 702-3 (DIN 55027) / ISO 702-2 (DIN 55029) on request

Accessories LVE

Tool group C 15
Type 525-91
Pneumatic control unit
for LVE 400-1000



Item no.	Width	Height	Depth	Control voltage	Connection	Weight approx. kg
426560 ●	280	250	100	24 V	R ½ " inside thread	3

Two pneumatic control units are required for dual chucks

Tool group C 15
Type 3515-Y **Two Connecting hoses with screw couplings**



Item no.	Contents of delivery
302138 ¹⁾ ●	set

¹⁾ Please indicate the hose length

Tool group C 15
Typ 525-60/70
Control units for single chucks
with dual foot switch, wired, 6 m
cable, for LVE 400-1000



Item no.	Design	Width	Width with plug	Height	Depth	Control voltage	Cable length
426481 ●	without pressure monitoring	300	340	300	120	24 V	6 m
426263 ●	with pressure monitoring	300	340	300	120	24 V	6 m

Supply on request: primary 35-264 V ~, 47-63 HZ - secondary 24V/1,5 A

Tool group C 15
Typ 525-80/90
Control units for dual chucks
with dual foot switch, wired,
6 m cable, for LVE 400-1000



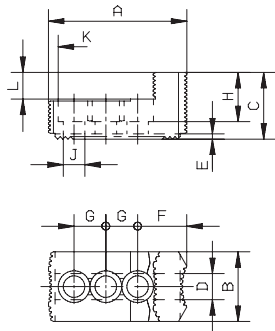
Item no.	Design	Width	Width with plug	Height	Depth	Control voltage	Cable length
426482 ▲	without pressure monitoring	300	340	300	120	24 V	6 m
426264 ▲	with pressure monitoring	300	340	300	120	24 V	6 m

Supply on request: primary 35-264 V ~, 47-63 HZ - secondary 24V/1,5 A

Chucking capacities und Jaw dimensions LVE

Reversible top jaws UB

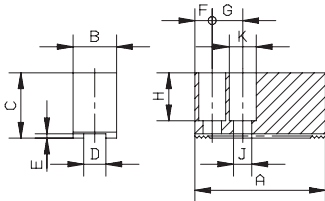
serration 90°,
material 16MnCr5



Chuck size	400		500		600		700		800		1000
LVE	400-140	480-185	540-205	570-230	600-275	630-275	680-325	730-375	800-375	830-410	1000-570
Typ	538-07		538-07		538-07	543-21		543-21	543-21		543-21
Item no. 3-jaw	037531		037531		037531	169464		169464	169466		169466
A	135	135	135	135	135	170	170	170	195	195	195
B	68	68	68	68	68	80	80	80	80	80	80
C	65	65	65	65	65	75	75	75	85	85	85
D ^{+0,05}	25,5	25,5	25,5	25,5	25,5	30,0	30,0	30,0	30,0	30,0	30,0
E	5	5	5	5	5	6	6	6	6	6	6
F	48	48	48	48	48	56	56	56	78	78	78
G	31+31	31+31	31+31	31+31	31+31	42+42	42+42	42+42	42+42	42+42	42+42
H	48	48	48	48	48	58	58	58	62	62	62
J	21	21	21	21	21	26	26	26	26	26	26
K	31	31	31	31	31	40	40	40	40	40	40
L	26	26	26	26	26	32	32	32	35	35	35
M	--	--	--	--	--	--	--	--	--	--	--
Toothing	3/32"x90°		3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°
Weight/jaw kg	2,4		2,4		2,4	3,6		3,6	4,5		4,5
External chucking	A1	85 - 255	135 - 305	160 - 370	180 - 390	220 - 430	225 - 420	265 - 460	315 - 510	280 - 530	315 - 565
	A2	125 - 295	175 - 345	200 - 410	220 - 430	260 - 470	275 - 470	315 - 510	365 - 560	370 - 620	405 - 655
	A3	330 - 500	380 - 550	405 - 615	425 - 635	465 - 675	540 - 735	580 - 775	630 - 825	640 - 890	675 - 925
Internal chucking	J1	155 - 325	205 - 375	230 - 440	250 - 460	290 - 500	305 - 500	345 - 540	395 - 590	405 - 655	440 - 690
	J2	350 - 520	405 - 570	430 - 640	450 - 660	490 - 700	565 - 770	605 - 800	655 - 850	670 - 920	705 - 955
max. -Ø	S	570	625	690	710	750	800	840	890	1000	1030
										1030	1215

Soft top jaws AB

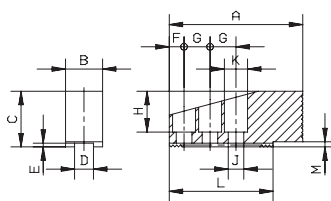
serration 90°,
material 16MnCr5



Chuck size	400		500		600		700		800		1000
LVE	400-140	480-185	540-205	570-230	600-275	630-275	680-325	730-375	800-375	830-410	1000-570
Typ	538-73		518-07		518-07	543-22		543-22	543-22		543-22
Item no. 3-jaw	118004		137028		137028	169450		169450	169452		169452
A	130	130	180	180	180	215	215	215	245	245	245
B	50	50	50	50	50	68	68	68	68	68	68
C	80	80	80	80	80	89	89	89	89	89	89
D ^{+0,05}	25,5	25,5	25,5	25,5	25,5	30,0	30,0	30,0	30,0	30,0	30,0
E	5	5	5	5	5	6	6	6	6	6	6
F	20	20	20	20	20	25	25	25	25	25	25
G	35	35	35+35	35+35	35+35	45+45	45+45	45+45	45+45	45+45	45+45
H	60	60	60	60	60	69	69	69	69	69	69
J	21	21	21	21	21	25	25	25	25	25	25
K	31	31	31	31	31	37	37	37	37	37	37
L	130	130	180	180	180	140	140	140	140	140	140
M	-	-	-	-	-	7	7	7	7	7	7
Toothing	3/32"x90°		3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°
Weight/jaw kg	3,1		4,2		4,2	7,8		7,8	9,1		9,1
A1 Ø External chucking	85 - 190	130 - 235	60 - 270	80 - 290	125 - 335	120 - 315	160 - 355	210 - 415	165 - 415	200 - 450	360 - 610
S Ø max.	460	505	640	660	710	760	800	850	920	955	1150

Extended top jaws AB hardened

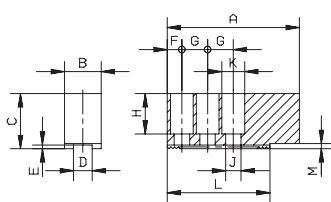
serration 90°,
material 16MnCr5



Chuck size	400		500		600		700		800		1000
LVE	400-140	480-185	540-205	570-230	600-275	630-275	680-325	730-375	800-375	830-410	1000-570
Typ	543-27		543-27		543-27	543-27		543-27	543-27		543-27
Item no. 3-jaw	284627		321209		321209	169458		169458	169460		169462
A	170	170	210	210	210	225	225	225	285	285	325
B	50	50	50	50	50	68	68	68	68	68	68
C	80	80	80	80	80	89	89	89	89	89	89
D ^{+0,05}	25,5	25,5	25,5	25,5	25,5	30,0	30,0	30,0	30,0	30,0	30,0
E	5	5	5	5	5	6	6	6	6	6	6
F	22	22	20	20	20	25	25	25	30	30	30
G	35+35	35+35	45+45	45+45	45+45	45+45	45+45	45+45	50+50	50+50	60+60
H	60	60	60	60	60	69	69	69	69	69	69
J	22	22	22	22	22	26	26	26	26	26	26
K	33	33	33	33	33	40	40	40	40	40	40
L	121	121	135	135	135	140	140	140	160	160	180
M	6	6	6	6	6	7	7	7	7	7	7
Toothing	3/32"x90°		3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°
Weight/jaw kg	3,1		4,1		4,1	7,1		7,1	9,4		11,0
A1 Ø External chucking	20 - 190	60 - 230	30 - 240	50 - 260	90 - 300	100 - 295	140 - 335	190 - 385	105 - 355	140 - 390	230 - 520
S Ø max.	540	580	660	680	720	760	800	850	940	975	1200

Extended soft top jaws AB

serration 90°,
material 16MnCr5



Chuck size	400		500		600		700		800		1000
LVE	400-140	480-185	540-205	570-230	600-275	630-275	680-325	730-375	800-375	830-410	1000-570
Typ	518-07		543-22		543-22	543-22		543-22	543-22		543-22
Item no. 3-jaw	137028		169449		169449	169452		169452	169456		169456
A	180	180	205	205	205	245	245	245	285	285	285
B	50	50	50	50	50	68	68	68	68	68	68
C	80	80	80	80	80	89	89	89	89	89	89
D ^{+0,05}	25,5	25,5	25,5	25,5	25,5	30,0	30,0	30,0	30,0	30,0	30,0
E	5	5	5	5	5	6	6	6	6	6	6
F	20	20	20	20	20	25	25	25	25	25	25
G	35+35	35+35	35+35	35+35	35+35	45+45	45+45	45+45	55+55	55+55	55+55
H	60	60	60	60	60	69	69	69	69	69	69
J	21	21	21	21	21	25	25	25	25	25	25
K	31	31	31	31	31	37	37	37	37	37	37
L	180	180	190	190	190	140	140	140	160	160	160
M	--	--	6	6	6	7	7	7	7	7	7
Toothing	3/32"x90°		3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°	3/32"x90°		3/32"x90°
Weight/jaw kg	4,2		5,0		5,0	9,1		9,1	10,9		10,9
A1 Ø External chucking	20 - 155	30 - 200	10 - 220	30 - 240	75 - 285	60 - 255	100 - 295	150 - 345	105 - 355	140 - 390	300 - 550
S Ø max.	330	575	640	660	710	760	800	850	945	980	1100