



TOROK

Clamps gently or forcefully





The TOROK manual chuck is primarily used in tool prototyping on machines without a clamping cylinder. For example, thanks to its easy manual actuation, when used on grinding machines you can safely and delicately clamp. In combination with our clamping device adaptations, such as the MANDO Adapt mandrel-in-chuck or the jaw module, many more clamping options are possible.

And most recent: Thanks to the optional lightweight CFRP design, with the TOROK CFK you save one-third the weight. This is particularly set-up friendly and it off-loads the machine spindle bearings.

Key advantages

- Also available in a CFRP lightweight design
- Manual actuation – a clamping cylinder is not required
- Sensitive clamping possible
- Workpiece stabilization through axial draw force applied against the workpiece end-stop
- Mandrels, jaw modules, face drivers, and morse taper adaptable



TOROK in use



TOROK manually actuated chuck types

	TOROK CFK	TOROK
		
Description	Manually actuated lightweight chuck	Manually actuated chuck
Sizes	52, 65	52, 65, 80, 100
Clamping range of all sizes [mm]	3 – 65	3 – 100
Variant	SE [hexagonal] / RD [round]	SE [hexagonal] / RD [round]
Advantages	■ Made of carbon fiber ■ 1/3 lighter than the standard model	
Clamping elements	 Clamping head SE  Clamping head RD	 Clamping head SE  Clamping head RD
Adaptations	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Face driver / Morse taper adapter SE / RD [Adaptation for clamping between centers]  Magnet module SE / RD [Adaptation for magnetic clamping]	 MANDO Adapt T211 SE / RD [Mandrel-in-clamping-device, with draw bolt]  MANDO Adapt T212 SE / RD [Mandrel-in-clamping-device, without draw bolt]  Jaw module SE / RD [Adaptation for jaw clamping]  Face driver SE / Morse taper adapter SE / RD [Adaptation for clamping between centers]  Magnet module SE / RD [Adaptation for magnetic clamping]



TOROK CFK SE in detail

Designation	
1 Manual actuation via socket wrench 2 Chuck body made of carbon fiber 3 Clamping head with pull-back and hexagon geometry for optimum chuck sealing and improved clamping force 4 Mounting threads for front end-stop 5 Grease nipple, optimal holding power due to efficient lubrication 6 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 7 Clamping screw for base end-stop, easy mounting through external actuation	

TOROK RD in detail

Designation	
1 Manual actuation via socket wrench 2 Vulcanized clamping head with hardened steel segments and pull-back 3 Mounting threads for front end-stop 4 Fixed base end-stop for clamping with pull-back effect, central mounting thread for workpiece specific end-stop 5 Clamping screw for base end-stop, easy mounting through external actuation	



Order overview. TOROK CFK SE / RD

				Clamping elements and adaptations					
Product line	Size	Material no.	In stock						
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SE	52	10000486	-	✓	✓	✓		✓	✓
	65	10000487	-	✓	✓	✓	✓	✓	✓
Product line	Size	Material no.	In stock	Clamping head RD	MANDO Adapt T211 RD	MANDO Adapt T212 RD	Jaw module RD	Face driver / morse taper adapter RD	Magnet module RD
				Page 430	Page 290	Page 296	Page 316	Page 324	Page 332
RD	52	10000488	-	✓	✓	✓		✓	✓
	65	10000489	-	✓	✓	✓	✓	✓	✓

Detailed technical data follows.

Order overview. TOROK SE / RD

				Clamping elements and adaptations					
Product line	Size	Material no.	In stock						
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SE	52	10000174	✓	✓	✓	✓		✓	✓
	65	10000175	✓	✓	✓	✓	✓	✓	✓
	100	10015275	✓	✓	✓	✓	✓	✓	✓
Product line	Size	Material no.	In stock	Clamping head RD	MANDO Adapt T211 RD	MANDO Adapt T212 RD	Jaw module RD	Face driver / morse taper adapter RD	Magnet module RD
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RD	52	10000172	✓	✓	✓	✓		✓	✓
	65	10000173	✓	✓	✓	✓	✓	✓	✓
	80	10015262	✓	✓	✓	✓	✓	✓	✓
	100	10015263	✓	✓	✓	✓	✓	✓	✓

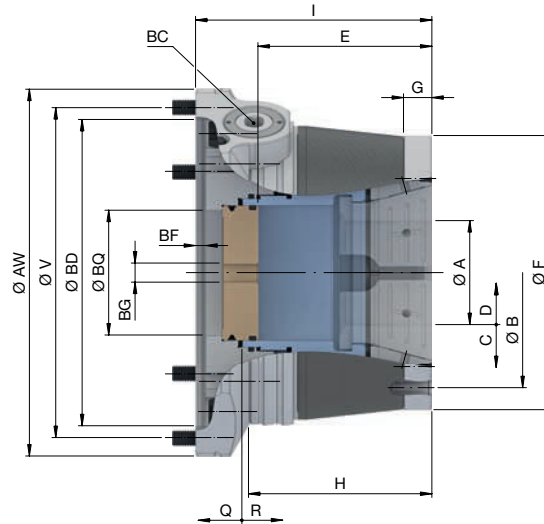
Detailed technical data follows.

Scope of delivery

- Chuck without spindle flange
- Base end-stop
- Actuation tool



TOROK CFK SE. Technical data



Product line		SE	
Size		52	65
Run-out ≤ [mm]		0,015	
Max. radial clamping force [kN]		108	120
Max. axial drawtube force [pull / push] [kN]		40	45
Flange location	BD	Ø 145 H7	Ø 162 H7
Flange fit length [mm]	BF	5,1	
Max. actuating torque [Nm]	BC	75	90
RPM n max. [1/min.]		7000	
Clamping range [mm]	A	3 – 52	3 – 65
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,5	
End-stop depth [mm]	E	90	92
Ø Capacity [mm]	BQ	53	66
End-stop thread size [M]	BG	10	12
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Length [mm]	H	92	97
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
Total length [mm]	I	120	125
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]
Outer Ø [mm]	AW	174	194
Weight [kg]		7	10,3
In stock		-	-
Material no.		10000486	10000487



Clamping heads	Adaptations I.D. clamping	Adaptations jaw clamping	Face driver / morse taper	Magnet module	Flanges	Accessory overview
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Technical drawing of a mechanical component, likely a pump or motor housing, showing dimensions and labels. The drawing includes a cross-section view of the internal assembly.

Dimensions:

- $\varnothing AW$: Overall outer diameter.
- $\varnothing V$: Diameter of the central bore.
- $\varnothing BD$: Diameter of the inner bore.
- $\varnothing BQ$: Diameter of the inner bore.
- BG : Distance from the centerline to the inner bore.
- BF : Distance from the centerline to the inner bore.
- $\varnothing A$: Diameter of the outer bore.
- D : Distance from the centerline to the outer bore.
- $\varnothing B$: Diameter of the outer bore.
- $\varnothing F$: Diameter of the outer bore.
- C : Distance from the centerline to the outer bore.
- H : Height of the component.
- I : Total length of the component.
- E : Distance from the front face to the centerline.
- G : Distance from the centerline to the rear face.
- Q : Distance from the front face to the centerline.
- R : Distance from the centerline to the rear face.

Labels:

- BC**: Label pointing to the rear face of the component.
- BF**: Label pointing to the inner bore.

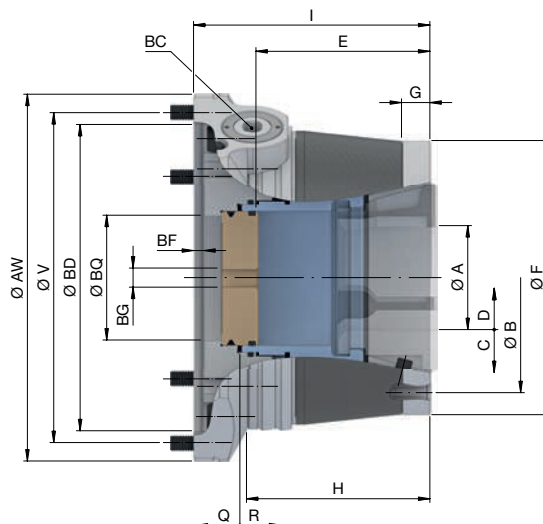
The bolt hole circle does not have equal division.



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TOROK CFK RD. Technical data



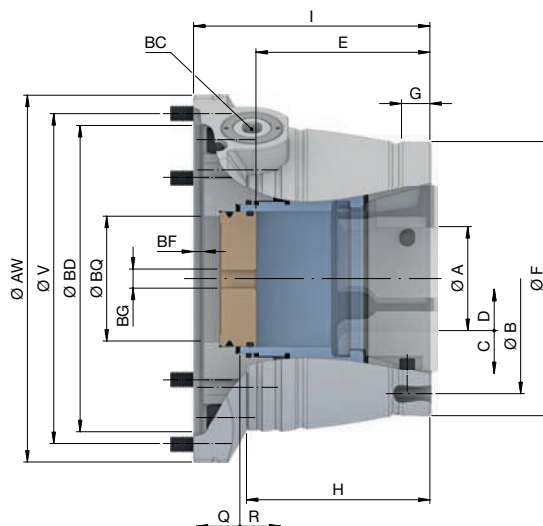
Product line		RD	
Size		52	65
Run-out ≤ [mm]		0,010	
Max. radial clamping force [kN]		94	105
Max. axial drawtube force [pull / push] [kN]		40	45
Flange location	BD	Ø 145 H7	Ø 162 H7
Flange fit length [mm]	BF	5,1	
Max. actuating torque [Nm]	BC	75	90
RPM n max. [1/min.]		7000	
Clamping range [mm]	A	3 – 52	3 – 65
Release stroke in Ø [mm]	C	0,6	
Reserve stroke in Ø [mm]	D	1	
Range / recommended workpiece tolerance [mm]		± 0,5	
End-stop depth [mm]	E	90	92
Ø Capacity [mm]	BQ	53	66
End-stop thread size [M]	BG	10	12
Location front end-stop	F	Ø 125 f7	Ø 145 f7
Length [mm]	H	92	97
Centering length [mm]	G	15	
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]
Total length [mm]	I	120	125
Reserve stroke axial [mm]	Q	2	
Release stroke axial [mm]	R	2,5	
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]
Outer Ø [mm]	AW	174	194
Weight [kg]		7,3	10,4
In stock		-	-
Material no.		10000488	10000489



Clamping heads	Adaptations I.D. clamping	Adaptations jaw clamping	Face driver / morse taper	Magnet module	Flanges	Accessory overview
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TOROK RD. Technical data



Product line	RD			
Size	52	65	80	100
Run-out ≤ [mm]	0,010		0,015	
Max. radial clamping force [kN]	94	105	115	150
Max. axial drawtube force [pull / push] [kN]	40	45	50	65
Flange location	BD	Ø 145 H7	Ø 162 H7	Ø 240 H6
Flange fit length [mm]	BF	5,1	5	5
Max. actuating torque [Nm]	BC	75	90	70
RPM n max. [1/min.]		7000	6000	5500
Clamping range [mm]	A	3 – 52	3 – 65	4 – 80
Release stroke in Ø [mm]	C	0,6	0,6	2
Reserve stroke in Ø [mm]	D	1	1	1,5
Range / recommended workpiece tolerance [mm]		± 0,5	± 0,5	± 1,0
End-stop depth [mm]	E	90	92	90
Ø Capacity [mm]	BQ	53	66	80
End-stop thread size [M]	BG	10	12	12
Location front end-stop	F	Ø 125 f7	Ø 145 f7	Ø 160 f7
Length [mm]	H	92	97	57
Centering length [mm]	G	17	14	15
Bolt hole circle end-stop	B	LK Ø 107 [3 x M6]	LK Ø 126 [3 x M6]	LK Ø 139 [3 x M6]
Total length [mm]	I	120	125	130
Reserve stroke axial [mm]	Q	2	2,1	3,1
Release stroke axial [mm]	R	2,5	2,5	5
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]	LK Ø 235 [6 x M10]
Outer Ø [mm]	AW	174	194	260
Weight [kg]		12,6	15,2	32
In stock		✓	✓	✓
Material no.		10000172	10000173	10015262

The bolt hole circle does not have equal division.

Clamping heads	Adaptations I.D. clamping	Adaptations jaw clamping	Face driver / morse taper	Magnet module	Flanges	Clamping head adapter	Accessory overview
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Flanges. For TOROK and TOROK CFK

Size	Figure	Spindle nose	Length 2 [mm]	Interface	Interface hole circle Y	Outer Ø [mm]	Bolt hole circle	Variant	In stock	Material no.
		DU	BS	X		AW	V			
52		A2-5	20	Ø 145 g5	LK Ø 156 [6 x M8]	195	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✓	10000220
		A2-6					LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✓	10000221
		A2-8				210	LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✓	10000222
65		A2-5	20	Ø 162 g5	LK Ø 176 [6 x M8]	195	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✓	10000223
		A2-6					LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✓	10000224
		A2-8				210	LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✓	10000225
80/100		A2-5	26,5	Ø 240 g5	LK Ø 235 [6 x M10]	260	LK Ø 104,8 [4 x M10]	Adjustable bolt DIN ISO 702-3 M10x43	✓	10015276
		A2-6	20				LK Ø 133,4 [4 x M12]	Adjustable bolt DIN ISO 702-3 M12x50	✓	10015277
		A2-8	26,5				LK Ø 171,4 [4 x M16]	Adjustable bolt DIN ISO 702-3 M16x60	✓	10015278

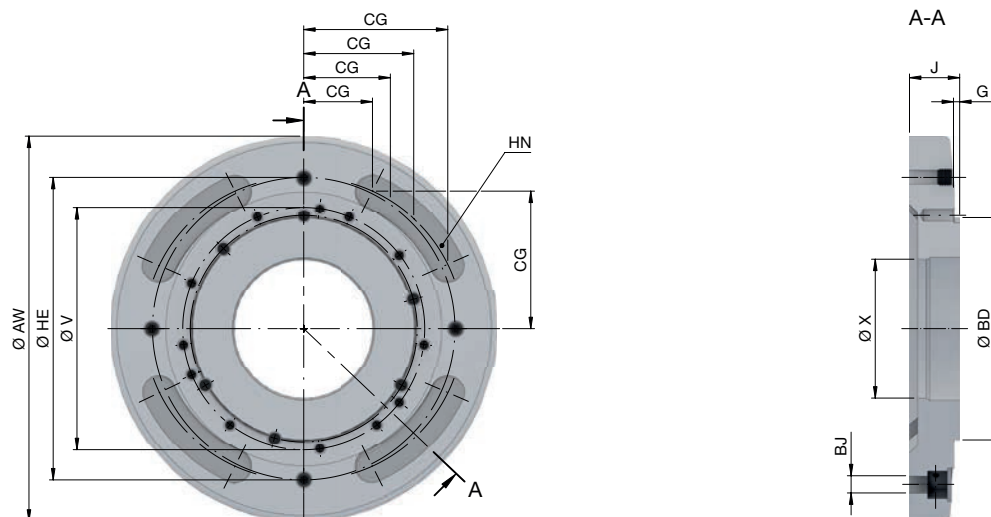
Camlock flange [DIN 55029] on request.

CHUCKS

Manual chuck TOROK



TOROK base plate for stationary use e.g. on a machining center. Technical data



Size		52 SE / RD	65 SE / RD	80/100 SE / RD
Bolt hole circle	V	LK Ø 156 [6 x M8]	LK Ø 176 [6 x M8]	LK Ø 234 [6 x M10]
Flange location	BD	Ø 145 g5	Ø 162 g5	Ø 240 f7
Interface	X	Ø 101 H7		Ø 140 H7
Outer Ø [mm]	AW	280		350
Height [mm]	J	36	36,5	35
Centering length [mm]	G	4	4,5	3,5
Mounting slots for T-groove table with groove spacing [mm]	CG	50, 63, 80, 100		
Groove width [mm]	BJ	12,5		13,5
Protective cover	HN	4x		
Torsional safety	HE	220 [4 x M10]		300 [4 x M10]
Weight [kg]		10,5	10,7	17
In stock		✓	✓	✓
Material no.		10001437	10001436	10001434