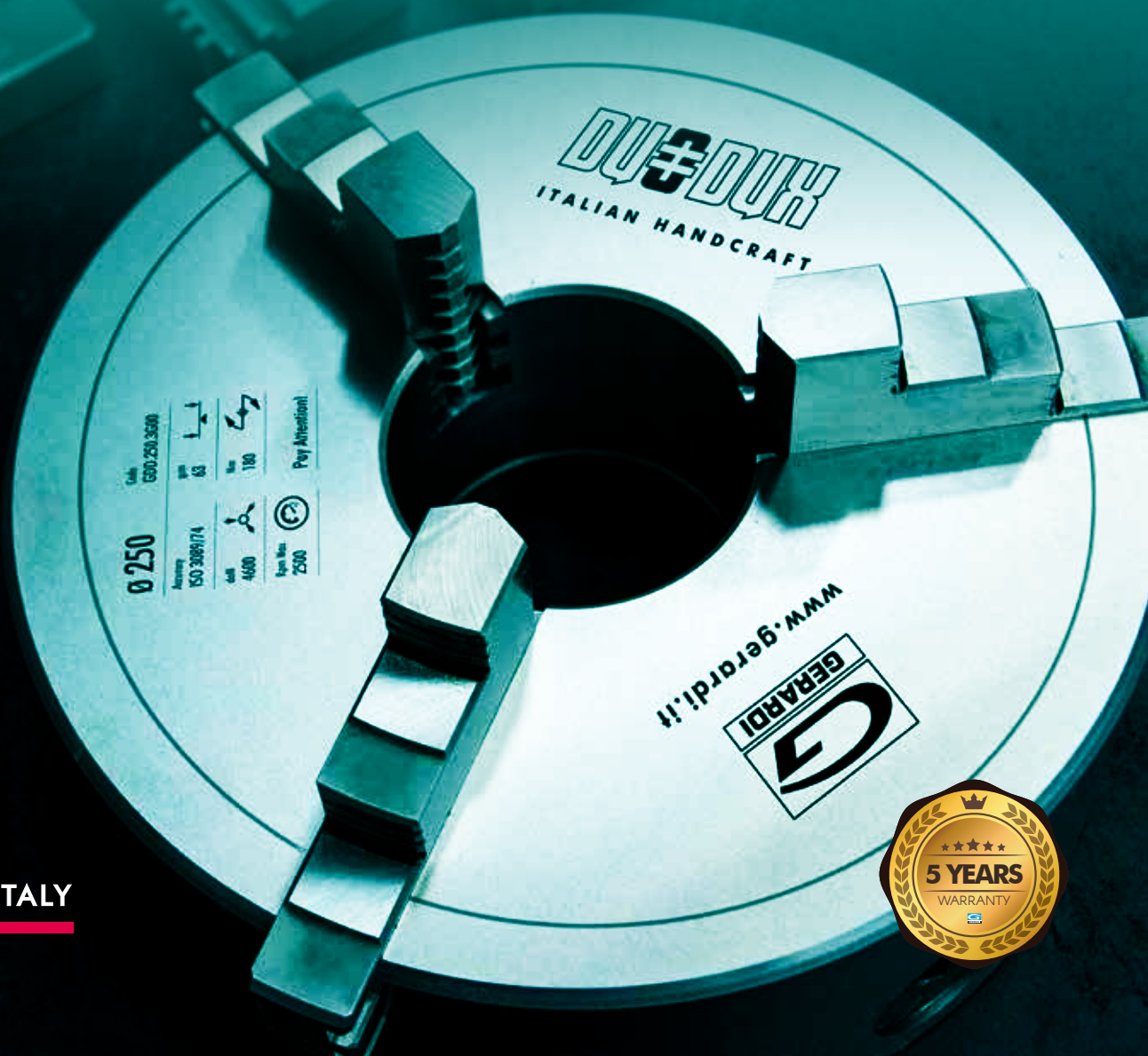




DUODUX

IL DOPPIA GUIDA ITALIANO - THE ITALIAN DOUBLE GUIDE

AUTOCENTRANTI DOPPIA GUIDA & SINGOLA
DOUBLE & SINGLE GUIDE SELF CENTERING CHUCKS



100%
MADE IN ITALY



Mandrini autocentranti / Self-centering chucks

DUODUX



Precisione / Accuracy

 $\pm 0,02\text{mm}$


Durezza / Hardened

EN GJL 250

Mandrini autocentranti a doppia e singola guida

Single and double guide self-centering chucks

COLLAUDO / INSPECTION

Ogni autocentrante DUO-DUX viene equilibrato secondo la norma ISO3089/74, testato singolarmente e fornito di apposito certificato di collaudo e garanzia. Gli autocentranti di diametro 365 e 430mm, indicati per lavorazioni pesanti, conservano al contempo le stesse doti tecniche di precisione dei mandrini di minor diametro.

Every DUO-DUX chuck is balanced following the ISO3089/74 rules and supplied with the warranty and testing certificates. The chucks with diameter 365 and 430mm, suitable for heavy-duty machinings, keep the same technical features and precision of the chucks with lower diameters.

GARANZIA / WARRANTY

Sicuri dell'affidabilità e dell'elevata qualità dei componenti impiegati per la realizzazione degli autocentranti DuoDux riconosciamo 5 anni di garanzia sull'intera gamma.

Sure of the reliability and high quality of all self-centering vises DuoDux components, we recognize 5 years warranty on the whole range.



Versione Speciale Ø270-105

Special Model Ø270-105

Oltre ai diametri della gamma standard è disponibile una versione speciale con Ø270 e passaggio barra maggiorato Ø105. Codice: GDD-270-3G20-105

Not only standard dimensions: a special Ø270mm version with increased bar holder Ø105 is available too. Code: GDD-270-3G20-105



Griffe integrali

Integral jaws

Le griffe integrali per il serraggio sono realizzate in acciaio al nichel-cromo cementato, temprato e rettificato a garantire elevata precisione e ripetibilità.

Integral clamping jaws are made of hardened nickel-chrome steel for the highest accuracy and repeatability.

MODELLI DISPONIBILI A RICHIESTA

AVAILABLE MODELS ON REQUEST

Disponibili altre versioni (A RICHIESTA):

- Mandrini autocentranti manuali a **3 GRIFFE** Ø130 a **guida singola** 2 SET (3+3) e 3SET (3+3+3)
- Mandrini autocentranti manuali a **4 GRIFFE** Ø130-Ø160 a **guida singola** 2SET (4+4) e 3SET (4+4+4)
- Mandrini autocentranti manuali a **4 GRIFFE** Ø200-Ø230-Ø250-Ø270-Ø310 a **doppia guida** 2SET (4+4) e 3SET (4+4+4)

Other versions available (ON REQUEST):

- Manual self-centering chucks with **3 JAWS** Ø130 with **single guide** 2 SET (3+3) and 3SET (3+3+3)
- Manual self-centering chucks with **4 JAWS** Ø130-Ø160 with **single guide** 2SET (4+4) and 3SET (4+4+4)
- Manual self-centering chucks with **4 JAWS** Ø200-Ø230-Ø250-Ø270-Ø310 with **double guide** 2SET (4+4) and 3SET (4+4+4)

CORONA, GRIFFE E PIGNONE:

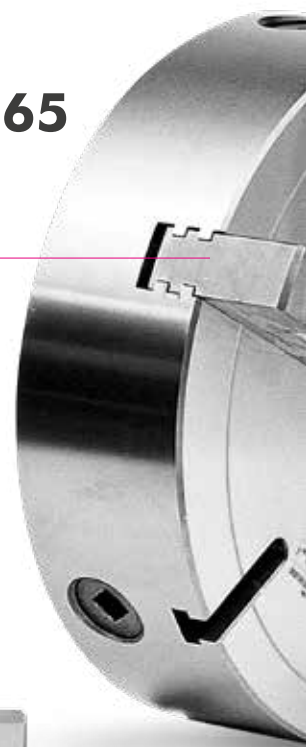
SCROLL, JAWS AND PINIONS:

Corona griffe e pignone sono fabbricati in acciaio al nichel-cromo cementato temprato ed interamente rettificati.

Scroll, jaws and pinions in fully ground, casehardened and heat treated chrome-nickel steel.

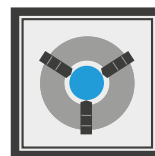


Ø365



DUO-DUX, il mandrino autocentrante manuale a doppia guida 100% Made in Italy. Composto da griffe integrali a guida doppia in grado di sopportare maggiori carichi di lavoro e garantire una maggior stabilità. La corona è rettificata con uno speciale metodo da noi sviluppato atto a garantire elevata precisione e ripetibilità.

DUO-DUX, the double guide self-centering manual chuck 100% Made in Italy. It is made with double guided integral jaws, which can stand heavier charges and grant a better stability. The crown is ground with a special way studied by Gerardi to grant highest precision and repeatability.



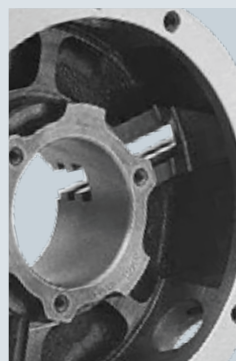
Precisione, rigidità e stabilità!
Accuracy, rigidity & stability!



Doppia Guida *Double guide*

Il sistema a doppia guida degli autocentranti DuoDux è in grado di sopportare maggiori carichi di lavoro e garantire maggior stabilità.

Double guide system of our Duo Dux self-centering vises can bear higher workload and grant a higher stability.



Durezza corpo *Solid body*

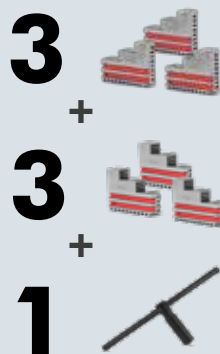
Corpo in fusione monoblocco di ghisa ad Alta Resistenza. Corona con spirale completamente rettificata!

Solid high-resistance cast iron body. Ground spiral crown!



Ø250

100%
MADE IN ITALY



Dotazione Standard *Standard Equipment*

- Set da **3** Griffe con presa INTERNA
- Set da **3** Griffe con presa ESTERNA
- **1** Chiave mandrino per apertura Griffe
- Set made by **3** INTERNAL clamp jaws
- Set made by **3** EXTERNAL clamp jaws
- **1** Chiave mandrino per apertura Griffe

1

GUIDA SINGOLA SINGLE GUIDE



GRIFFE / JAWS
3



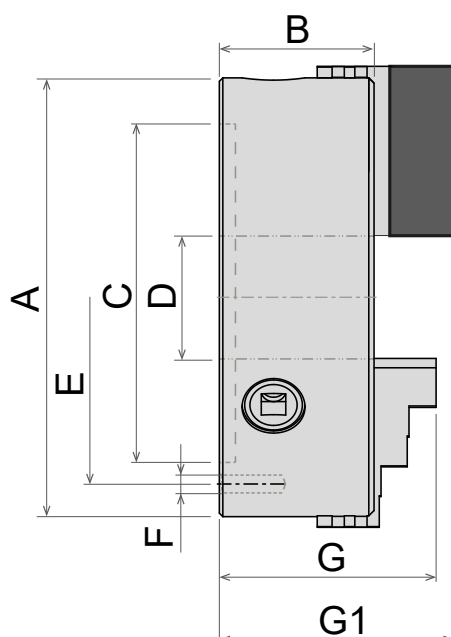
GUIDE / GUIDES
1



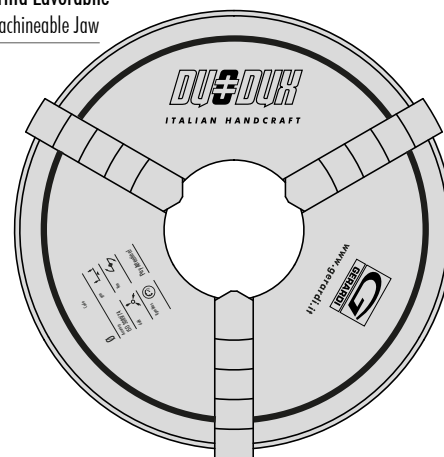
DIN
6350



GARANZIA / WARRANTY
5 anni - 5 Years



Griffa Lavorabile
Machineable Jaw



A	Ø161
B	68,5
C h6	130
D	42
E	144,5
F	N°3 M8
G	89,5
G1	106,1
daN	3.100
Rpm	Max 3500
kg	8
Code	GMD-160-3G20

Dotazione Standard - Standard Equipment



**1 set da 3 griffe
con presa esterna**
1 set made by 3 external
clamp jaws



**1 set da 3 griffe
con presa interna**
1 set made by 3 interna
clamp jaws



**1 chiave per
apertura griffe**
1 key for
opening jaws

Vedi pagina 6 - See page 6

Vedi pagina 6 - See page 6

Vedi pagina 13 - See page 13

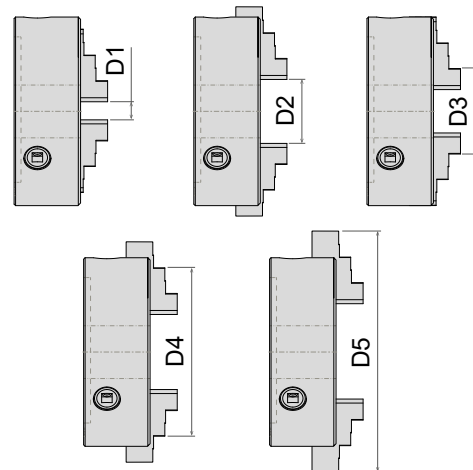
DATI TECNICI SINGOLA GUIDA

Single guide TECHNICAL DATA

Apertura griffe Presa Interna Jaws opening Internal Clamp

Ø	Ø160
D1 min	3
D2 max	68
D3 min	43
D4 max	152
*D5 max	200

*D5: Non rettificato - Not Ground



Apertura griffe Presa Esterna Jaws opening External Clamp

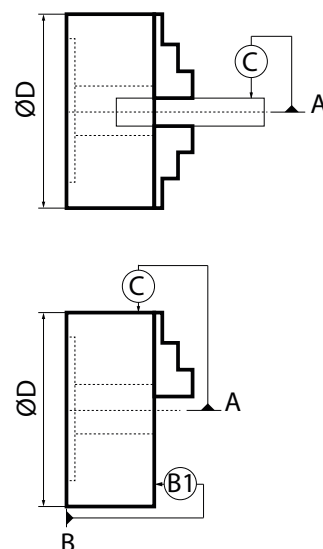
Ø	Ø160
D6 min	3
D7 max	51
D8 min	160
*D9 max	200
D10 max	240

*D9: Non rettificato - Not Ground



Concentricità di presa su spine Gripping concentricity on pins

ØD	Ø160
SERRAGGIO - CLAMPING	15
Ø Spina di collaudo Ø Testing Pin	30
	43
CORPO MANDRINO - BODY CHUCK	
Eccentricità ammessa C - A Eccentricity allowed C - A	0,03 mm
Concentricità ammessa C - A Concentricity allowed C - A	0,010 mm
Planarità ammesse B - B1 Flatness allowed B - B1	0,02 mm

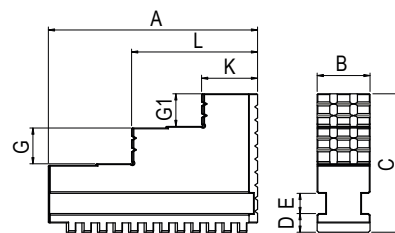


GRIFFE SINGOLA GUIDA

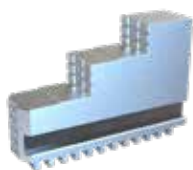
Single Guide Jaws



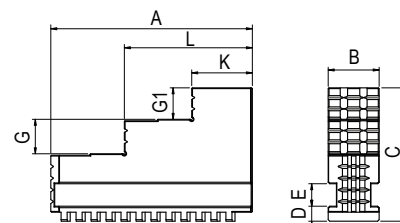
Griffe temprate integrali - Serraggio ESTERNO-INTERNO
Integral temprate jaws guide - EXTERNAL-INTERNAL clamping



Size	Ø160
A	66
B	18
C	42
D	8
E	8
G	10
G1	9
K	20
L	42
Code	GGI-160-3S00



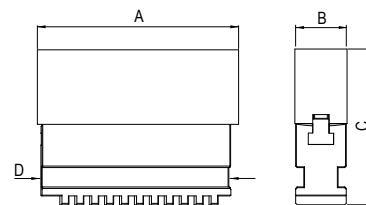
Griffe temprate integrali - Serraggio ESTERNO
Integral temprate jaws guide - EXTERNAL clamping



Size	Ø160
A	66
B	18
C	43
D	8
E	8
G	10
G1	9
K	20
L	42
Code	GGE-160-3S00



Griffe riportate, lavorabili
Machineable jaws



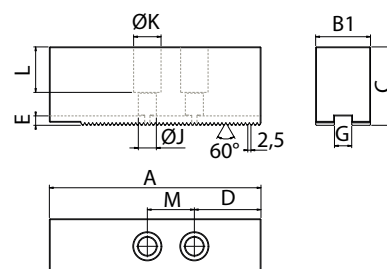
Size	Ø160
A	80
B	20
C	60
D	65,5
Code	GGs-160-3S00

GRIFFE SINGOLA GUIDA

Single Guide Jaws



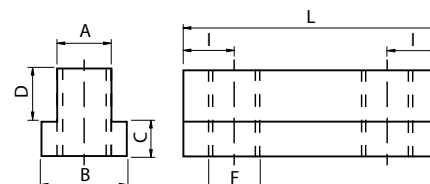
Blochetto Lavorabile
MACHINEABLE jaw



Size	Ø160
A	80
B	20
C	30
D	30
E	3,5
G	7,5
ØJ	7
ØK	11
L	20
M	18
Code	GGs-160-3S0C



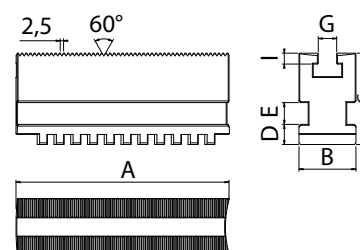
Tassello
Nut



Size	Ø160
A	7,3
B	10,8
C	5,5
D	5,5
F	M6
I	8,5
L	35
Code	GGs-160-3S0B



Griffa BASE
BASE jaws



Size	Ø160
A	65
B	18
C	31
D	8
E	8
G	7,5
I	4,5
Code	GGs-160-3S0A

2 DOPPIA GUIDA DOUBLE GUIDE



GRIFFE / JAWS
3



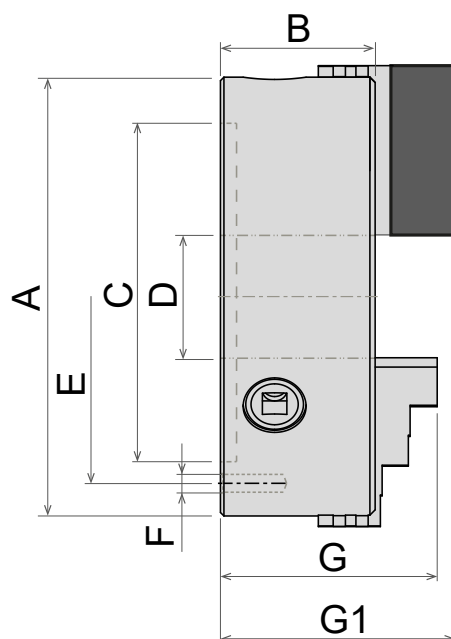
GUIDE / GUIDES
2



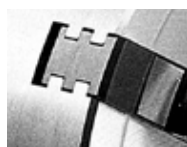
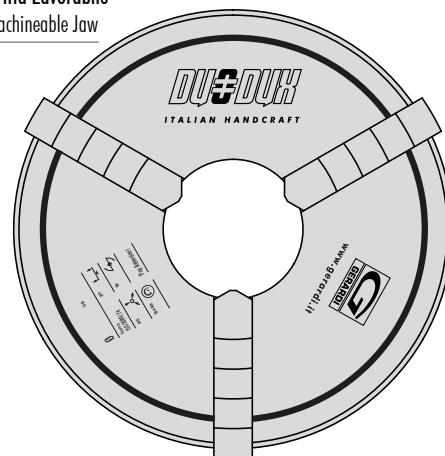
DIN
6350



GARANZIA / WARRANTY
5 anni - 5 Years



Griffa Lavorabile
Machineable Jaw



A	Ø200	Ø250	Ø310	Ø365	Ø430
B	81,5	88,5	100,5	105,5	114
Ché	160	200	260	310	382
D	53	80	108	126,5	170
E	176	224	286	336,5	405
F	N°3 M10	N°6 M12	N°6 M12	N°6 M14	N°6 M14
G	113	124	143,5	155	170
G1	132,5	149,5	162,5	168	176,5
daN	3.700	4.600	5.500	5.900	6.900
Rpm	Max 3.000	Max 2.500	Max 2.000	Max 1.800	Max 1.400
kg	15	23	38	61	92
code	GDD-200-3620	GDD-250-3620	GDD-310-3620	GDD-365-3620	GDD-430-3620

Dotazione Standard - Standard Equipment



**1 set da 3 griffe
con presa esterna**
1 set made by 3
external clamp jaw



**1 set da 3 griffe
con presa interna**
1 set made by 3 interna
clamp jaws



**1 chiave per
apertura griffe**
1 key for opening
jaws

Vedi pagina 10 - See page 10

Vedi pagina 10 - See page 10

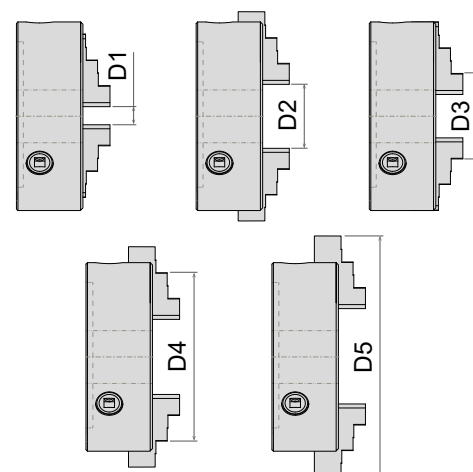
Vedi pagina 13 - See page 13

DATI TECNICI DOPPIA GUIDA

Double guide TECHNICAL DATA

Apertura griffe Presa Interna Jaws opening Internal Clamp					
Ø	Ø200	Ø250	Ø310	Ø365	Ø430
D1 min	4	4	5	12	12
D2 max	85	115	145	170	220
D3 min	50	60	69	77	110
D4 max	185	239	289	332	430
*D5 max	247	311	375	430	550

*D5: Non rettificato - Not Ground

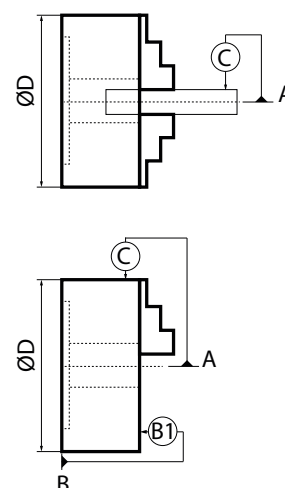


Apertura griffe Presa Esterna Jaws opening External Clamp					
Ø	Ø200	Ø250	Ø310	Ø365	Ø430
D6 min	4	4	5	12	12
D7 max	66	82	91	103	135
D8 min	201	255	311	358	450
*D9 max	247	311	375	430	550
D10 max	300	360	450	510	630

*D9: Non rettificato - Not Ground



Concentricità di presa su spine Gripping concentricity on pins					
ØD	Ø200	Ø250	Ø310	Ø365	Ø430
Ø Spina di collaudo Ø Testing Pin	15	15	20	20	25
	30	35	55	55	55
	43	55	82	82	100
SUL SERRAGGIO Eccentricità ammessa C - A Eccentricity allowed C - A	0,04mm	0,04mm	0,05mm	0,05mm	0,075mm
SUL CORPO Concentricità ammessa C - A Concentricity allowed C - A	0,015mm	0,015mm	0,020mm	0,020mm	0,030mm
Planarità ammesse B - B1 Flatness allowed B - B1	0,02mm	0,025mm	0,025mm	0,025mm	0,03mm



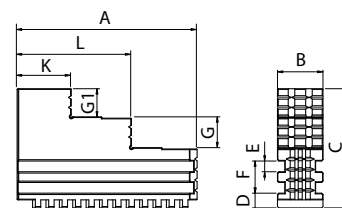
GRIFFE DOPPIA GUIDA

Double Guide Jaws

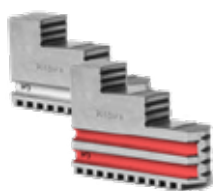


Griffe temprate integrali - Serraggio ESTERNO-INTERNO

Integral temprate jaws guide - EXTERNAL-INTERNAL clamping

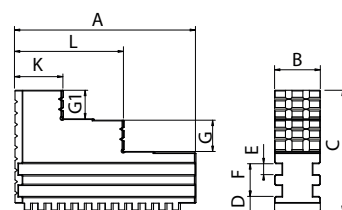


Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	81	98	113,5	134,1	170
B	22	22	26	34	34
C	64,5	68	81,5	89	96
D	8,5	8,5	9,5	11	11
E	7	7	8	8	8
F	20	20	23	24	24
G	14	16,5	20	21	26
G1	14,5	15,5	19	24	24
K	23	28	32	35,5	50
L	50	61,5	72	80,5	110
Code	GGI-200-3S00	GGI-250-3S00	GGI-310-3S00	GGI-365-3S00	GGI-430-3S00



Griffe temprate integrali - Serraggio ESTERNO

Integral temprate jaws guide - EXTERNAL clamping

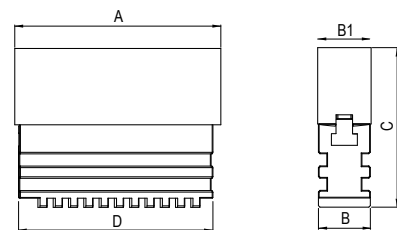


Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	81	98	115	134,52	170,5
B	22	22	26	34	34
C	64	68	81,5	89	96
D	8,5	8,5	9,5	11	11
E	7	7	8	8	8
F	20	20	23	24	24
G	14	15,5	20	21	26
G1	14,5	16	19	23	24
K	23	28	32	36	50
L	50	62	72	81	110
Code	GGE-200-3S00	GGE-250-3S00	GGE-310-3S00	GGE-365-3S00	GGE-430-3S00



Griffe riportate, lavorabili

Machineable jaws



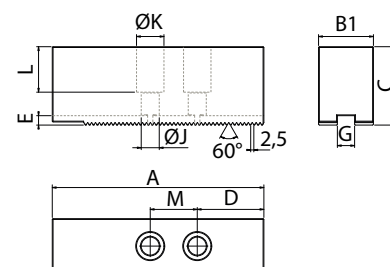
Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	90	102	126	136	175
B1	22	22	26	34	34
C	83,8	95	102	104,5	104,5
D	77,33	91,41	113,59	127,32	167,32
Code	GGs-200-3S00	GGs-250-3S00	GGs-310-3S00	GGs-365-3S00	GGs-430-3S00

GRIFFE DOPPIA GUIDA

Double Guide Jaws



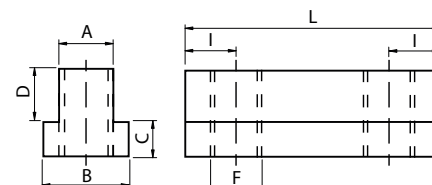
Blochetto Lavorabile
MACHINEABLE jaw



Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	90	102	126	136	175
B1	25	25	30	35	35
C	40	50	50	50	50
D	38	44	56	62,5	62,5
E	5	5	6	6	6
G±0.05	9,5	9,5	11	11	11
ØJ	9,5	9,5	11,5	11,5	11,5
ØK	14,5	14,5	17,5	17,5	17,5
L	22	32	29	29	29
M	25	25	30	30	30
Code	GG-200-3S0C	GG-250-3S0C	GG-310-3S0C	GG-365-3S0C	GG-430-3S0C



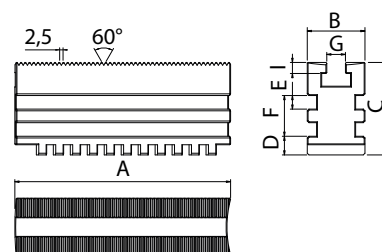
Tassello
Nut



Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	9,3	9,3	10,7	10,7	10,7
B	13,8	13,8	16,8	16,8	16,8
C	5,5	5,5	7	7	7
D	8,5	8,5	10	10	10
F	M8	M8	M10	M10	M10
I	10	10	10	10	10
L	45	45	50	50	50
Code	GG-200-3S0B	GG-250-3S0B	GG-310-3S0B	GG-365-3S0B	GG-430-3S0B



Griffa BASE
BASE jaws

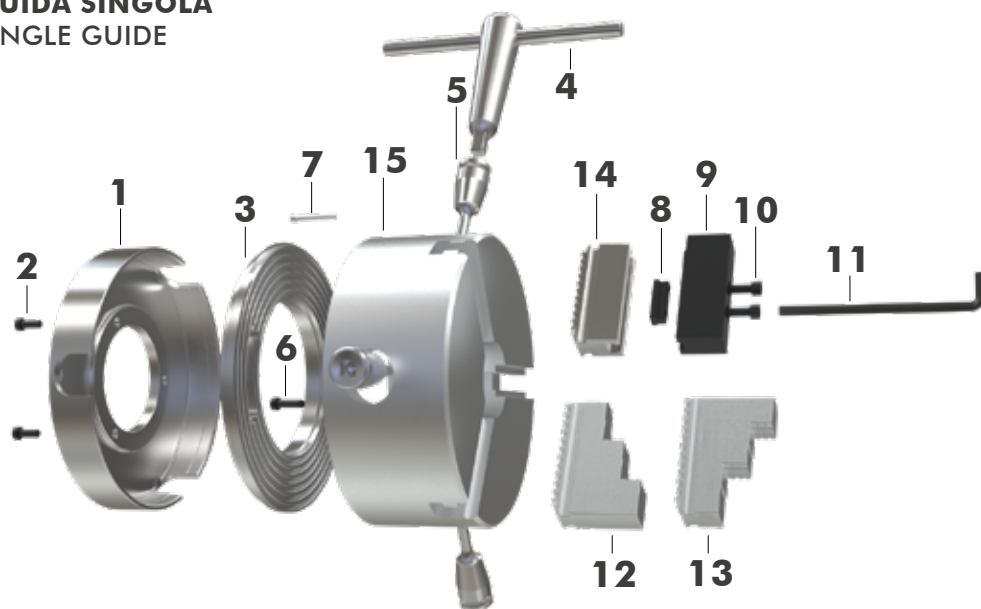


Size	Ø200	Ø250	Ø310	Ø365	Ø430
A	77,33	91,41	113,59	127,32	167,32
B	22	22	26	34	34
C	44,5	45	52	54,5	54,5
D	8,5	8,5	9,5	11	11
E	7	7	8	8	8
F	20	20	23	24	24
G	9,5 H8	9,5	11	11	11
I	6	6	6,5	6,5	6,5
Code	GG-200-3S0A	GG-250-3S0A	GG-310-3S0A	GG-365-3S0A	GG-430-3S0A

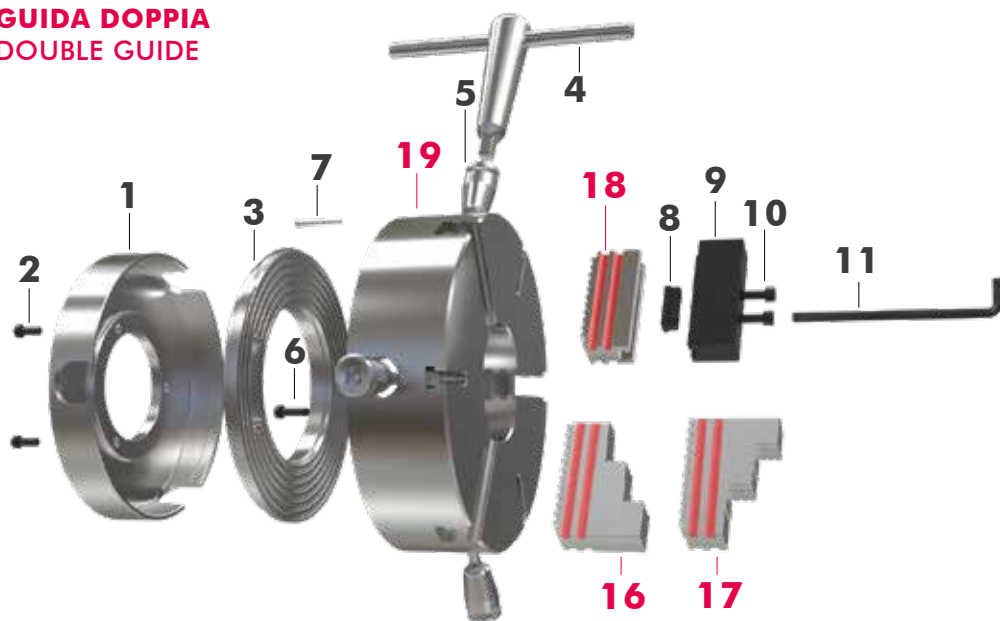
ACCESSORI

DUODUX accessories

GUIDA SINGOLA SINGLE GUIDE



GUIDA DOPPIA DOUBLE GUIDE



1
Coperchio
Cover

2
Vite T.C.
Screw

3
Corona GMD
GMD Crown

4
Chiave di comando
Operating wrench

5
Pignone
Pinion

6
Vite T.E.
Screw

7
Spinetta pignone
Pinion pin (optional)

8
Tassello
Nut

9
Blocchetto tenero
Soft blank top jaw

10
Vite T.C.E.I
Screw

11
Chiave esagonale
Hexagonal wrench

12
Morsetto presa interna
Inward grip jaw

13
Morsetto presa esterna
Outward grip jaw

14
Falsa griffa
Guide jaw

15
Corpo
Body

16
Morsetto presa interna doppia guida
Inward double guide grip jaw

17
Morsetto presa esterna doppia guida
Outward double guide grip jaw

18
Falsa griffa doppia guida
Double guide jaw

19
Corpo doppia guida
Double guide Body

Esempio di ordinazione - Ordering example

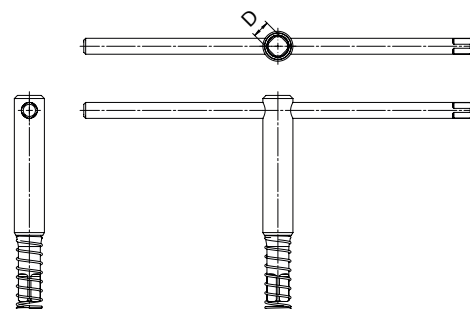
Corona (3) per mandrino Ø310
Scroll (3) for Ø310 chucks



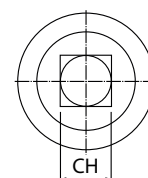
COD: GDD-310-3

ACCESSORI E RICAMBI

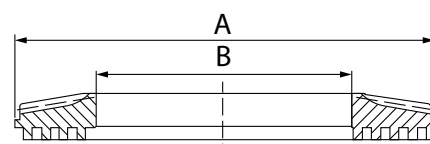
Spare parts and accessories


4
Chiave di sicurezza
 Security key


Size	Ø160	Ø200	Ø250	Ø310	Ø365	Ø430
D	10	12	14	14	16	16
Code	GDD-160-4	GDD-200-4	GDD-250-4	GDD-310-4	GDD-365-4	GDD-430-4


5
Pignone
 Pinion


Size	Ø160	Ø200	Ø250	Ø310	Ø365	Ø430
CH	10	12	14	14	16	16
Code	GDD-160-5	GDD-200-5	GDD-250-5	GDD-310-5	GDD-365-5	GDD-430-5


3
Corona
 Scroll


Size	Ø160	Ø200	Ø250	Ø310	Ø365	Ø430
A	Ø128,5	Ø153,5	Ø199,5	Ø259	Ø308,5	Ø381
B	Ø66	Ø85	Ø124	Ø156	Ø181	Ø238
Code	GDD-160-3	GDD-200-3	GDD-250-3	GDD-310-3	GDD-365-3	GDD-430-3

LAVORAZIONI AGGIUNTIVE

ADDITIONAL PROCESSING

Size	Ø160	Ø200	Ø250	Ø310	Ø365	Ø430
Fori di fissaggio passanti con incassatura Fixing through holes	-	-	-	-	-	-
Adattamento flangia a mandrino autocentrante Flange / Self-centering chuck fitting	-	-	-	-	-	-

FLANGE SEMIFINITE

Semi-finished adapter plates

**Finite lato macchina,
lavorabili lato autocentranti**

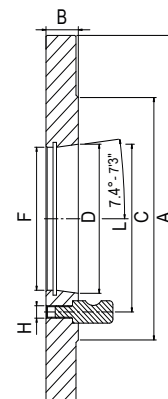
Fully finished machine side,
machinable chucks side



Camlock

(DIN55029) - ASA B 5.9 tipo D1

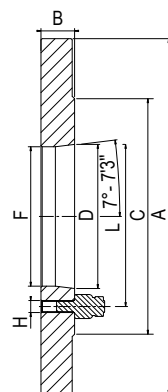
Shank size	4"		5"		6"				8"				11"		
A	Ø160	Ø200	Ø160	Ø200	Ø200	Ø250	Ø315	Ø380	Ø250	Ø315	Ø380	Ø450	Ø315	Ø380	Ø430
B	39		39		42				45				52		
C	120		140		180				220				290		
D	63,513		82,563		106,375				139,719				196,869		
F	60,7		79,4		103,0				135,7				192,5		
G	13		16		17				19				21		
H	7/16 - 20		1/2 - 20		5/8 - 18				3/4 - 16				7/8 - 14		
L	82,55		104,80		133,40				171,40				235,00		
N. Fori passanti Through holes nr.	3 Ø15,87		6 Ø19,05		6 Ø22,22				6 Ø25,40				6 Ø30,16		
Code	GFD-160-040A	GFD-200-040A	GFD-160-050A	GFD-200-050A	GFD-200-060A	GFD-250-060A	GFD-315-060A	GFD-380-060A	GFD-250-080A	GFD-315-080A	GFD-380-080A	GFD-450-080A	GFD-315-011A	GFD-380-011A	GFD-450-011A



Con vite prigioniera e dado

Stud bolt and nut DIN55022 (55027)

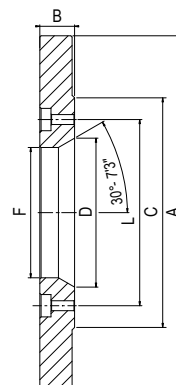
Shank size	4"		5"		6"				8"				11"		
A	Ø160	Ø200	Ø160	Ø200	Ø200	Ø250	Ø315	Ø380	Ø250	Ø315	Ø380	Ø450	Ø315	Ø380	Ø430
B	39		39		42				45				52		
C	120		140		180				220				290		
D	63,525		82,575		106,390				139,735				196,885		
F	60,7		79,4		103,0				135,7				192,5		
H	M10		M10		M12				M16				M20		
L	85 (82,55)		104,80		133,40				171,40				235,00		
N. Fori passanti Through holes nr.	3		4		4				4				6		
Code	GFD-160-040B	GFD-200-040B	GFD-160-050B	GFD-200-050B	GFD-200-060B	GFD-250-060B	GFD-315-060B	GFD-380-060B	GFD-250-080B	GFD-315-080B	GFD-380-080B	GFD-450-080B	GFD-315-011B	GFD-380-011B	GFD-450-011B



Con fori passanti

With through holes DIN55026 ASA B 5.9 tipo A2

Shank size	4"		5"		6"				8"				11"		
A	Ø160	Ø200	Ø160	Ø200	Ø200	Ø250	Ø315	Ø380	Ø250	Ø315	Ø380	Ø430	Ø315	Ø380	Ø430
B	39		39		42				45				52		
C	120		140		180				220				290		
D	63,525		82,575		106,390				139,735				196,885		
F	60,7		79,4		133,40				171,40				235,40		
L	85 (82,55)		104,80		133,40				171,40				235,00		
N. Fori passanti Through holes nr.	4		4		4/8				8				8		
Code	GFD-160-040C	GFD-200-040C	GFD-160-050C	GFD-200-050C	GFD-200-060C	GFD-250-060C	GFD-315-060C	GFD-380-060C	GFD-250-080C	GFD-315-080C	GFD-380-080C	GFD-430-080C	GFD-315-011C	GFD-380-011C	GFD-450-011C



DIMENSIONI NASO MACCHINA

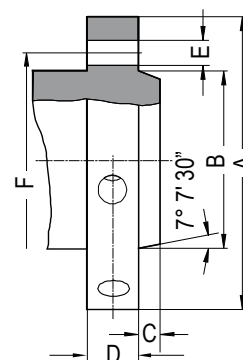
Spindle noses dimensions



Con serraggio anello a camlock
 With camlock ring tightening

Spindle noses	4"	5"	6"	8"	11"	15"
A	117	146	181	225	298	403
B (Max)	63,521	82,573	106,385	139,731	196,883	285,791
C	11	13	14	16	18	19
D	34	38	45	50	60	70
E	3x16,7	6x19,8	6x23,0	6x26,2	6x31,0	6x35,7
F	82,6	104,8	133,4	171,4	235,0	330,2

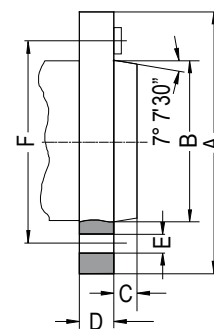
DIN 55029 - ISO702/II - TYPE D



Con serraggio anello a baionetta
 With bayonet ring tightening

Spindle noses	4"	5"	6"	8"	11"	15"
A	112	135	170	220	290	400
B (Max)	63,521	82,573	106,385	139,731	196,883	285,791
C	11	13	14	16	18	19
D	20	22	25	28	35	42
E	3x21	4x21	4x23	4x29	6x36	6x43
F	85,0	104,8	133,4	171,4	235,0	330,2

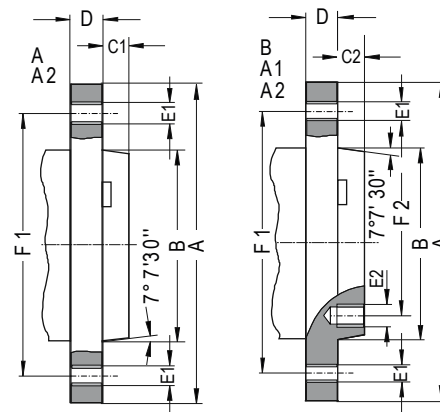
DIN 55027 - ISO702/III - TYPE C



Tipo A: Fori filettati (esterni dal cono) senza fori interni
Tipo B: Fori filettati esterni e interni
 Type A: Threaded holes (external from the cone) without internal holes
 Type B: External and internal threaded holes

Spindle noses	4"	5"	6"	8"	11"	15"
A	108	133	165	210	280	380
B (Max)	63,521	82,573	106,385	139,731	196,883	285,791
C1	11	13	14	16	18	19
C2	-	14-228	15,875	17,462	19,050	20,638
D	20	22	25	28	35	42
E1 (DIN)	11xM10	11xM10	11xM12	11xM16	11xM20	12xM24
E1 (ISO)	-	-	-	-	11xM18	12xM22
F1	82,6	104,8	133,4	171,4	235,0	330,2
E2 (DIN)	-	8xM10	8xM12	8xM16	8xM20	11xM24
E2 (ISO)	-	-	-	-	8xM18	11xM22
F2	-	61,9	82,6	111,1	165,1	247,6

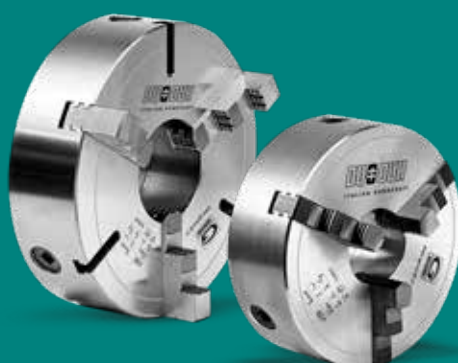
DIN 55026 - TYPE A, TYPE B
 ISO702/1 - TYPE A2, TYPE A1-A2





DUODUX

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