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Manual Chucks  
with Mounting Plates

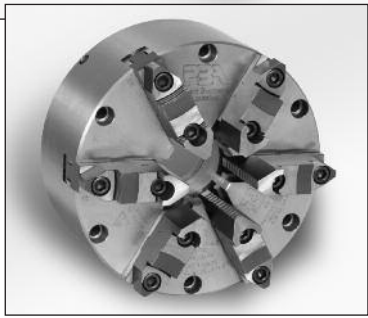
Power Chucks

Cylinders

Top Tooling

Collet Chucks

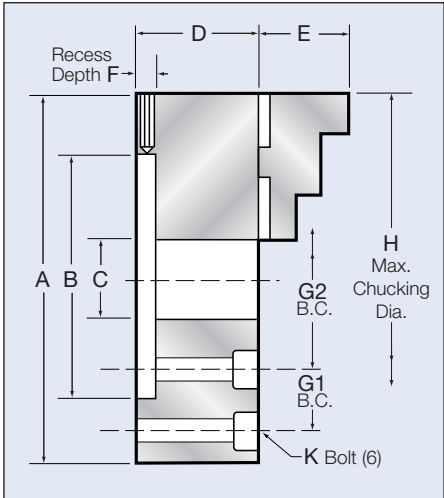
Collets



# Self-Centering Universal Steel Body SETRITE® Chuck

## 253 Series - 3 Jaw • 263 Series - 6 Jaw Direct Replacement for the Buck Ajust-Tru® Early Design

- ⚙️ Two-year warranty ⚙️ Precision manufactured for adapter mounting
- ⚙️ .0005 TIR repeatability on duplicate parts ⚙️ Steel body on sizes 6" thru 24"
- ⚙️ Semi-steel body on the 5" chucks ⚙️ 4 adjusting screws - 5", 6", 8", 10", 12"
- ⚙️ 8 adjusting screws - 15" ⚙️ Sizes 5" to 24", larger sizes available on request
- ⚙️ Nitride hardened scroll ⚙️ Hardened pinion
- ⚙️ Two-piece American standard tongue and groove jaws on chuck sizes 6" thru 24"
- ⚙️ 5" chucks equipped with one set of solid I.D jaws and one set of solid O.D. jaws
- ⚙️ One pinion - 5", 6", 8", 10", 12"; 3 pinions - 15", 18", 24" - **Larger Models Available**
- ⚙️ Durability - double the contact surface of the master jaw and body versus our competitor's chucks



Jaws shown in O.D. position

Chuck Size (in)	Model Number	Approx. Weight (lbs)	Maximum RPM*
<b>253 Series - 3 Jaw</b>			
5	0515400	14	5000
6	0625300	26	4900
8	0825300	46	4200
10	1025300	71	3300
12	1225300	112	2300
15	1525300	146	2000
18	1825300	270	1300
24	2425300	550	850
<b>263 Series - 6 Jaw</b>			
5	0516400	15	3600
6	0626300	27	3500
8	0826300	49	3000
10	1026300	76	2400
12	1226300	116	2000
15	1526300	205	1500
18	1826300	290	880
24	2426300	570	740

\*Eccentric adjustment of chuck on mounting plate to obtain required TIR on the workpiece may result in unacceptable vibration at these speeds. Reduce RPMs accordingly. Jaws must be fully engaged in the chuck body.

### Dimensional Data for Series 253 & 263 Adapter Mounting Self-Centering Chucks

Chuck Size	A	B*	C	D	E	F	G1	G2	H	K	Gripping Capacity	
											Min.**	Max.
5"	5.00"	2.375"	1.30"	2.84"		.66"	4.44"	-	5.00"	1/4"	1/16"	4"
6"	6.31"	3.125"	1.81"	2.88"	1.59"	0.69"	5.34"	-	7.31"	1/4"	3/16"	5"
8"	8.25"	4.750"	2.25"	3.25"	1.75"	0.75"	7.50"	-	9.25"	3/8"	3/16"	6 1/2"
10"	9.85"	6.375"	3.00"	3.63"	2.13"	0.81"	-	4.38"	11.00"	7/16"	3/16"	8"
12"	12.20"	7.906"	4.06"	4.00"	2.28"	0.84"	-	5.25"	14.00"	1/2"	3/4"	10"
15"	15.74"	11.7812"	4.56"	5.13"	3.16"	1.13"	-	6.75"	17.00"	5/8"	1 1/2"	13"
18"	18.00"	11.781"	5.04"	5.781"	3.27"	1.125"	-	6.75"	19.00"	5/8"	1 1/2"	16"
24"	24.00"	16.030"	7.025"	6.530"	3.27"	1.188"	-	9.25"	25.00"	3/4"	2	22"

\* Tolerance - .000/+ .001 \*\*6-Jaw Chuck minimum grip, consult factory Ⓜ️ Recess can be opened up to 2.745" - 2.755"

Soft top jaws shown on page 75. Ⓜ️ Ajust-Tru is a registered trade mark of Illinois Tool Works.

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

## Mounting Plates For "SETRITE"™ 3 Jaw and 6 Jaw - 253 & 263 Series Chucks

PBA offers a full line of Mounting Plates type "D", "A", "L" and threaded plates for the "SETRITE" Chucks. PBA Mounting Plates are interchangeable with other popular adjustable universal style Chucks.

Mounting plates are precision machined to suit the spindle nose of your machine. For maximum accuracy of "SETRITE" mounting plates, mount plate on machine spindle nose, place a dial indicator on the chuck side face of the adapter close to the mounting holes, rotate the adapter and if the total indicator reading (TIR) exceeds .0005" take a light truing cut across the face of the mounting plate.

### Type D Mounting Plates "Camlock"

Spindle	6"	8"	10"	12"	15"	18"	24"
D-3	0605020	0805020	-	-	-	-	-
D-4	0605021	0805021	1005021	-	-	-	-
D-5	0605022	0805022	1005022	-	-	-	-
D-6	-	0805023	1005023	1205023	1505023	-	-
D-8	-	-	1005024	1205024	1505024	1805024	2405024
D-11	-	-	-	1205025	1505025	1805025	2405025

### Type A American Standard Short Taper A-1 & A-2, Spindles

Spindle	6"	8"	10"	12"	15"	18"	24"
A-4	0605009	-	-	-	-	-	-
A-5	0605010	0805010	1005010	-	-	-	-
A-6	-	0805011	1005011	1205011	-	-	-
A-8	-	-	1005012	1205012	1505012	1805012	-
A-11	-	-	-	-	1505013	1805013	2405013
A-15	-	-	-	-	-	-	2405014

### Type L American Standard Long Taper Key Drive Spindle

Spindle	6"	8"	10"	12"	15"	18"	24"
L-00	0605031	0805031	1005031	-	-	-	-
L-0	0605032	0805032	1005032	1205032	-	-	-
L-1	-	0805033	1005033	1205033	1505033	1805033	2405033
L-2	-	-	1005034	1205034	1505034	1805034	2405034
L-3	-	-	-	-	1505035	1805035	2405035

### For Hardinge® and Elgin Lathe Threaded & Blank Mountings for SETRITE™ Chucks

Spindle	5"	6"
4° Taper	0505044	0605044
2 <sup>3</sup> / <sub>16</sub> "-10 Threaded	0505045	0605045

Spindle	5"	6"	8"	10"	12"
Blank	0505040	0605040	0805040	1005040	1205040
1 <sup>1</sup> / <sub>2</sub> "-8	0505041	0605041	0805041	-	-
1 <sup>3</sup> / <sub>4</sub> "-8	0505042	0605042	0805042	-	-
2 <sup>1</sup> / <sub>4</sub> "-8	0505043	0605043	0805043	-	-
2 <sup>3</sup> / <sub>8</sub> "-6	-	0605046	0805046	-	-

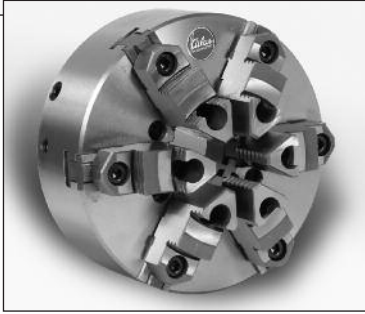
Also available plates for rotary tables

\*Threaded adapter plates and special plates are available upon request.

"SETRITE" chucks and adapters are shipped unassembled unless ordered assembled at extra charge.

When ordering special adapters give make, model number, size, and spindle dimensions of machine.

For standard spindle dimensions, see page 103.

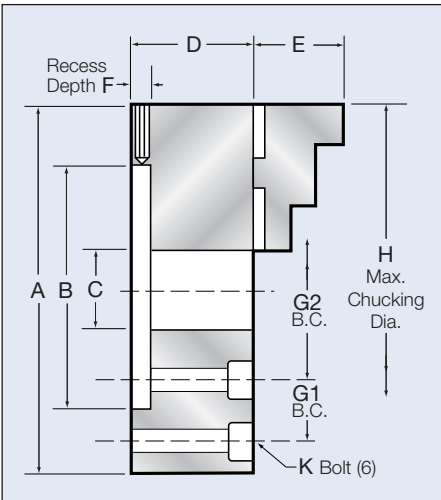


# Easy-Set™ Self-Centering Universal Chuck

## Low Cost 3 & 6 Jaw Chucks

Direct Replacement for the Buck Adjust-Tru® Early Design

- ⚙ High value, Lower cost
- ⚙ One-year warranty
- ⚙ Precision manufactured for adapter plate mounting - UTILIZES the same mounting plate as the PBA SETRITE™ and other popular adjustable universal chucks
- ⚙ .0005 repeatability on duplicate parts
- ⚙ 4 adjusting screws
- ⚙ Chuck Sizes 6", 8", 10", 12" and 15"
- ⚙ Hardened scroll
- ⚙ Hardened pinion
- ⚙ Two-piece tongue and groove jaws
- ⚙ Semi-steel body



Chuck Size (in)	Model Number	Approx. Weight (lbs)	Maximum RPM*
<b>Easy-set - 3 Jaw</b>			
6	EZ63	20	3400
8	EZ83	43	3100
10	EZ103	67	2700
12	EZ123	104	2200
15	EZ153	141	1800
<b>Easy-set - 6 Jaw</b>			
6	EZ66	18	2500
8	EZ86	47	2200
10	EZ106	70	2000
12	EZ126	108	1500

\*Eccentric adjustment of chuck on adapter to obtain required TIR on the workpiece may result in unacceptable vibration at maximum RPM's. Reduce RPMs accordingly.

## Dimensional Data for Series Adapter Mounting Self-Centering Chucks

Chuck Size	A	B*	C	D	E	F	G1	G2	H	K	Gripping Capacity	
											Min.**	Max.
6"	6.0"	3.125"	1.540"	2.35"	1.53"	0.69"	5.34"	-	6.5"	1/4"	1/8"	5"
8"	8.25"	4.750"	2.346"	3.15"	2.10"	0.75"	7.50"	-	8.5"	3/8"	3/16"	6 1/2"
10"	10.0"	6.375"	2.860"	3.40"	2.58"	0.81"	-	4.38"	11.0"	7/16"	15/32"	8"
12"	12.0"	7.906"	3.285"	4.00"	2.58"	0.84"	-	5.25"	12.5"	1/2"	27/64"	10"
15"	15.0"	11.781"	4.250"	5.78"	3.55"	1.13"	-	6.75"	16.0"	3/4"	9/16"	15"

\* Tolerance - .003/+.002 \*\*6-Jaw Chuck minimum grip, consult factory

1. Bolt circle on 6" and 8" chucks are outside the pilot recess "B" as shown.

Bolt circle on 10", 12" and 15" Dia. chucks are inside "B" dimension.

® Adjust-Tru is a registered trade mark of Illinois Tool Works.

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

## Mounting Plates For Easy-Set™ 3-Jaw and 6-Jaw Chucks

Atlas Workholding offers a full line of Mounting Plates type "D", "A", "L" and threaded plates for the Easy-Set™ Chucks. Our Mounting Plates are interchangeable with other popular adjustable universal style Chucks.

Mounting plates are precision machined to suit the spindle nose of your machine. For maximum accuracy of mounting plates, mount plate on machine spindle nose, place a dial indicator on the chuck side face of the adapter close to the mounting holes, rotate the adapter and if the total indicator reading (TIR) exceeds .0005" take a light truing cut across the face of the mounting plate.

### Type D Mounting Plates "Camlock"

Spindle	6"	8"	10"	12"	15"
D-3	0605020	0805020	-	-	-
D-4	0605021	0805021	-	-	-
D-5	0605022	0805022	1005022	-	-
D-6	-	0805023	1005023	1205023	-
D-8	-	-	1005024	1205024	1505024
D-11	-	-	-	1205025	1505025

### Type A American Standard A-1 & A-2, Spindles

Spindle	6"	8"	10"	12"
A-4	0605009	-	-	-
A-5	0605010	0805010	1005010	-
A-6	-	0805011	1005011	1205011
A-8	-	-	1005012	1205012

### Type L American Standard Long Taper Key Drive Spindle

Spindle	6"	8"	10"	12"
L-00	0605031	0805031	1005031	-
L-0	0605032	0805032	1005032	1205032
L-1	-	0805033	1005033	1205033
L-2	-	-	1005034	1205034

### For Hardinge® and Elgin Lathe

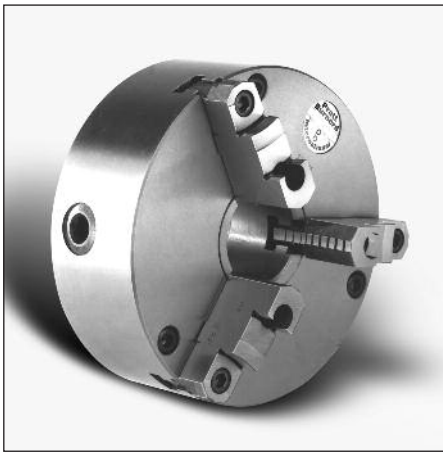
Spindle	6"
4° Taper	0605044
2 <sup>3</sup> / <sub>16</sub> "-10 TH'D	0605045

Also available plates for rotary tables

### Threaded & Blank Mountings\* for Easy-Set™ Chucks

Spindle	6"	8"
Blank	0605040	0805040
1 <sup>1</sup> / <sub>2</sub> "-8	0605041	0805041
1 <sup>3</sup> / <sub>4</sub> "-8	0605042	0805042
2 <sup>1</sup> / <sub>4</sub> "-8	0605043	0805043
2 <sup>3</sup> / <sub>8</sub> "-6	0605046	0805046

\*Blank Mountings are finished on the chuck side of the mounting plate, and blank on the machine side  
Hardinge is a registered trademark of Hardinge Inc.  
For standard spindle dimensions, see page 103.

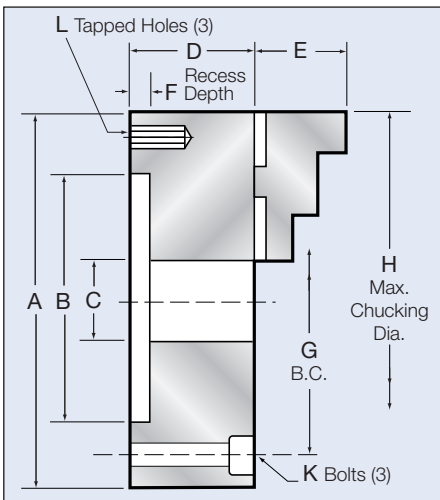


## Self-Centering High Quality 3 Jaw Universal Chucks

### Super-Precision, 3 Pinion Non-Adjustable Self-Centering Type: 234 and 235 Series 5" thru 15"

- ⌚ Two-year warranty
- ⌚ Precision manufactured to fit types A, D and L spindles and adapter mounting
- ⌚ .0015" T.I.R. 6-12" sizes, 15" size .003" T.I.R. using nominated pinion.
- ⌚ Repeatability .0005" on all sizes
- ⌚ Sizes 5" thru 15"
- ⌚ Three hardened pinions
- ⌚ Two-piece American standard tongue and groove jaws
- ⌚ High tensile ductile iron bodies

Chuck Size	Adapter Mounting Model No.	Type A Spindle Short Taper		Type D Spindle Camlock		Type L Spindle Long Taper	
		Size	Model No.	Size	Model No.	Size	Model No.
5	0523500	-	-	D-3	0523520	-	-
5	-	-	-	D-4	0523521	-	-
6	0623500	A-5	0623510	D-3	0623520	L-00	0623531
6	-	-	-	D-4	0623521	L-0	0623532
8	0823500	A-5	0823510	D-3	0823520	L-00	0823531
8	-	A-6	0823511	D-4	0823521	L-0	0823532
8	-	-	-	D-5	0823522	-	-
8	-	-	-	D-6	0823523	L-1	0823533
10	1023500	A-5	1023510	D-4	1023521	L-00	1023531
10	-	A-6	1023511	D-6	1023523	L-0	1023532
10	-	A-8	1023512	D-8	1023524	L-1	1023533
12	1223500	A-6	1223511	D-6	1223523	L-0	1223532
12	-	A-8	1223512	D-8	1223524	L-1	1223533
12	-	-	-	D-11	1223525	L-2	1223534
15	1523400	A-8	1523412	D-6	1523423	L-1	1523433
15	-	A-11	1523413	D-8	1523424	L-2	1523434
15	-	-	-	D-11	1523425	-	-



Larger diameter chucks available, contact PBA for price and delivery.

### Dimensional Data for 235 Series Adapter Mounting Self-Centering Chucks

Chuck Size	A	B	C	D	E	F	G	H	K	Lbs Wt.	Gripping Capacity		Max. RPM
											Min.	Max.	
5"	4.92"	3.740"	1.38"	2.31"	1.375"	.15"	4.25"	6.75"	M8	10.5	3/16"	4"	3600
6"	6.30"	4.921"	1.81"	2.53"	1.59"	.15"	5.51"	7.75"	M10	18	3/16"	5"	3400
8"	7.87"	6.299"	2.16"	2.87"	1.75"	.15"	6.93"	9.75"	M10	31.5	3/16"	6½"	3100
10"	9.84"	7.875"	2.99"	3.31"	2.13"	.19"	8.82"	12.25"	M12	59	1/2"	8"	2700
12"	12.20"	10.236"	4.05"	3.56"	2.28"	.19"	11.26"	14.25"	M12	89	3/4"	10"	2200
15"	15.74"	12.990"	5.35"	3.96"	2.75"	.19"	14.25"	16.25"	M16	150	1½"	13"	1800

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

## Mounting Plates For 234 and 235, Series Chucks

Mounting plates are precision machined to suit the spindle nose of your machine. Plates are stocked semi-finished. If ordering plate separately, specify the model number of your chuck so that PBA can finish machine the adapter to suit your Pratt Burnerd chuck.

### Type D Camlock Mountings

Spindle	5"	6"	8"	10"	12"	15"
D-3	0503020	0603020	0803020	1003020	-	-
D-4	0503021	0603021	0803021	1003021	-	-
D-5	-	-	0803022	1003022	-	-
D-6	-	-	0803023	1003023	1203023	1503023
D-8	-	-	-	1003024	1203024	1503024
D-11	-	-	-	-	1203025	1503025

### Type A American Standard Short Taper A-1 & A-2 Spindles

Spindle	5"	6"	8"	10"	12"	15"
A-5	0503010	0603010	0803010	1003010	-	-
A-6	-	-	0803011	1003011	1203011	1503011
A-8	-	-	-	1003012	1203012	1503012
A-11	-	-	-	-	1203013	1503013

### Type L American Standard Long Taper Key Drive Spindles

Spindle	5"	6"	8"	10"	12"	15"
L-00	0503031	0603031	0803031	1003031	-	-
L-0	-	0603032	0803032	1003032	1203032	-
L-1	-	-	0803033	1003033	1203033	1503033
L-2	-	-	-	1003034	1203034	1503034
L-3	-	-	-	-	-	1503035

### Threaded Spindles

Spindle	5"	6"	8"	10"
1½"-8	0503041	0603041	0803041	-
1¾"-8	0503042	0603042	0803042	-
2¼"-8	0503043	0603043	0803043	1003043

Special adapter plates available upon request. Specify chuck number and spindle nose specifications. For spindle nose specifications, see page 103.





3-Jaw Universal Chucks

## Special Manual Large Thru-Hole Rotary Table Chucks and Lathe Chucks

- 🔧 3-Jaw Universal Chucks and 4-Jaw Independent Chucks
- 🔧 Special Large Thru-Hole
- 🔧 Straight Mounting Recess
- 🔧 Custom Chuck Sizes and Thru-Hole Available
- 🔧 Custom Rotary Table Chuck Adapters Available
- 🔧 Lathe Mounting Adapters A, D and L Available
- 🔧 One Year Warranty
- 🔧 Also Available 3 and 6 Jaw Setrite (page 4) & Easy-Set Chucks (page 6) for Rotary Tables

### 3-Jaw Universal Chucks

Part Number	Chuck Size	Thru Hole	Jaw Type	Body Thickness	Mounting Recess Dia	Bolt Circle	Thru Bolts	Bolt Size
1433-2000-6.1	14"	6.1"	2pc. Am. Std.	3.937" (100mm)	11.614" (295mm)	12.598" (320mm)	3-120°	M14
1634-2000-6.5	16"	6.5"	2pc. Am. Std.	4.33" (110mm)	13.78" (350mm)	14.763" (375mm)	3-120°	M12
1833-2000-8.3	18"	8.3"	2pc. Am. Std.	4.25" (108mm)	15.039" (382mm)	16.535" (420mm)	3-120°	M16
2033-2000-10.3	20"	10.3"	2pc. Am. Std.	4.449" (113mm)	15.039" (382mm)	18.11" (460mm)	6-60°	M20
2033-2000-10.65	20"	10.65"	2pc. Am. Std.	4.449" (113mm)	15.039" (382mm)	18.11" (460mm)	6-60°	M20

Other Chuck Diameters and Thru-Hole combinations available, contact factory



4-Jaw Independent Chucks

### 4-Jaw Independent Chucks

Part Number	Chuck Size	Thru Hole	Jaw Type	Body Thickness	Mounting Recess Dia	Bolt Circle	Thru Bolts	Bolt Size
1643-2000-6.1	16"	6.1"	2pc. Am. Std.	4.693" (119.30mm)	11.811" (300mm)	12.598" (320mm)	4	M16
2143-2000-320	21"	12.6"	2pc. Am. Std.	4.5" (114.30mm)	15.748" (400mm)	17.323" (440mm)	4	M16

Other Chuck Diameters and Thru-Hole combinations available, contact factory

# Chuck Semi-Finished Mounting Plates

- ⊕ Semi-finished suitable for all adapter mount chucks.
- ⊕ Sizes available 6"-24", larger diameter mounting plates available upon request
- ⊕ Mounting types available "D" camlock, "A" Am. Std., "L" long tapered nose and threaded type.
- ⊕ Supplied with finish turning instructions.

## "D" camlock

Part No.	Spindle Type	Diameter	Plate Thickness
0603020	D1-3	6.25"	1.125"
0603021	D1-4	6.25"	1.125"
0603022	D1-5	6.25"	1.125"
0803020	D1-3	8.25"	1.125"
0803021	D1-4	8.25"	1.125"
0803022	D1-5	8.25"	1.125"
0803023	D1-6	8.25"	1.125"
1003020	D1-3	10.25"	1.125"
1003021	D1-4	10.25"	1.125"
1003022	D1-5	10.25"	1.125"
1003023	D1-6	10.25"	1.250"
1003024	D1-8	10.25"	1.375"
1203022	D1-5	12.50"	1.250"
1203023	D1-6	12.50"	1.250"
1203024	D1-8	12.50"	1.375"
1203025	D1-11	12.50"	1.625"
1503023	D1-6	15.75"	1.375"
1503024	D1-8	15.75"	1.5"
1503025	D1-11	15.75"	1.625"
2003024	D1-8	20.375"	1.875"
2003025	D1-11	20.375"	1.875"

## "A" short taper

Part No.	Spindle Type	Diameter	Plate Thickness
0603009	A-4	6.250"	1.250"
0603010	A-5	6.250"	1.250"
0603011	A-6	6.250"	1.375"
0803010	A-5	8.250"	1.375"
0803011	A-6	8.250"	1.500"
1003010	A-5	10.50"	1.375"
1003011	A-6	10.50"	1.500"
1003012	A-8	10.50"	1.750"
1203011	A-6	12.75"	1.625"
1203012	A-8	12.75"	1.787"
1203013	A-11	12.75"	2.125"
1503011	A-6	15.75"	1.625"
1503012	A-8	15.75"	1.787"
1503013	A-11	15.75"	2.125"
2003012	A-8	20.375"	2.125"
2003013	A-11	20.375"	2.375"
2403012	A-8	25.0"	2.375"
2403013	A-11	25.0"	2.625"

## "L" long tapered nose

Part No.	Spindle Type	Diameter	Plate Thickness
0603031	L-00	6.25"	1.25"
0603032	L-0	6.25"	1.50"
0803031	L-00	8.25"	1.25"
0803032	L-0	8.25"	1.50"
0803033	L-1	8.25"	1.75"
1003031	L-00	10.5"	1.25"
1003032	L-0	10.5"	1.50"
1003033	L-1	10.5"	1.75"
1003034	L-2	10.5"	2.0"
1203032	L-0	12.5"	1.5"
1203033	L-1	12.5"	1.75"
1203034	L-2	12.5"	2.0"
1503033	L-1	15.75"	1.75"
1503034	L-2	15.75"	2.0"
2003034	L-2	20.375"	2.0"
2403034	L-2	25.0"	2.0"

## Threaded Mounts

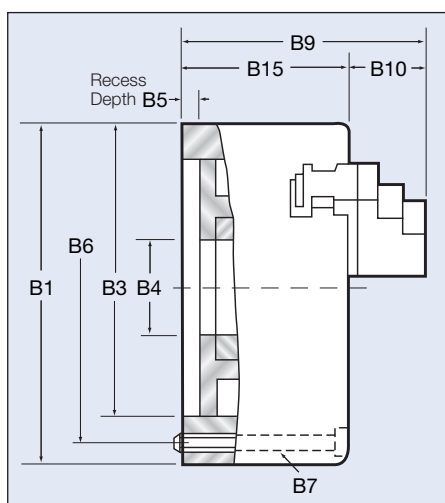
Part No.	Spindle Type	Diameter	Plate Thickness
0503039	1-10	5.0"	.750"
0503041	1-1/2-8	5.0"	.750"
0603041	1-1/2-8	6.312"	.687"
0603042	1-3/4-8	6.312"	.687"
0603043	2-1/4-8	6.312"	.687"
0803043	2-1/4-8	7.875"	.781"
0803046	2-3/8-6	7.875"	.781"
1003043	2-1/4-8	9.875"	.906"
1203046	2-3/8-8	12.42"	1.10"



# Self-Centering 3-Jaw Universal Iron Body Chucks

## Series 342 Medium-Duty Value Line Flatback, D and A Type Mounting: Sizes 5" thru 25"

- ⚙ High value and lower cost
- ⚙ One year warranty
- ⚙ Standard chuck sizes 5" Thru 25"
- ⚙ Maximum .003" TIR using nominating pinion - thru 12"
- ⚙ .001" Repeatability using nominating pinion - thru 12"
- ⚙ Two-piece American Standard tongue and groove jaws
- ⚙ Hardened scroll
- ⚙ Three hardened pinions
- ⚙ Semi steel bodies



Chuck Size	Flatback Chuck No.	Type D Spindle Size	Chuck No.	Type A Spindle Size	Chuck No.
5"	0534-2000		-----		-----
6"	0634-2000	D-4	0634-20D4	A-4	0634-20A4
6"	-----		-----	A-5	0634-20A5
8"	0834-2000	D-4	0834-20D4		-----
8"	-----	D-5	0834-20D5	A-5	0834-20A5
8"	-----	D-6	0834-20D6	A-6	0834-20A6
10"	1034-2000	D-5	1034-20D5	A-5	1034-20A5
10"	-----	D-6	1034-20D6	A-6	1034-20A6
10"	-----	D-8	1034-20D8	A-8	1034-20A8
12"	1234-2000	D-6	1234-20D6	A-6	1234-20A6
12"	-----	D-8	1234-20D8	A-8	1234-20A8
16"	1634-2000	D-8	1634-20D8	A-8	1634-20A8
16"	-----	D-11	1634-2D11	A-11	1634-2A11
20"	2034-2000	D-8	2034-20D8	A-8	2034-20A8
20"	-----	D-11	2034-2D11	A-11	2034-2A11
25"	2534-2000	D-8	2534-20D8	A-8	2534-20A8
25"	-----	D-11	2534-2D11	A-11	2534-2A11
25"	-----		-----	A-15	2534-2A15

Consult factory for chucks sizes larger than 25".

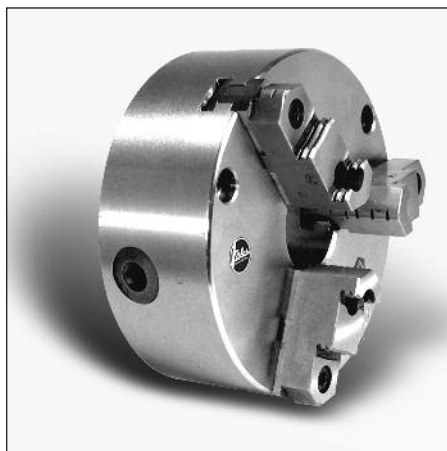
### Dimensions for Universal Flatback Mounting Chucks with Two-piece Jaws (in/mm)

Chuck Size	B1	B3	B4	B5	B6	B7	B9	B10	B15	Max RPM
5"/125	4.92"/125	3.74"/95	1.18"/30	.157"/4	4.25"/108	(3) M-8	3.94"/100	1.65"/42	2.28"/58	3000
6"/160	6.30"/160	4.92"/125	1.77"/45	.197"/5	5.51"/140	(6) M-10	4.53"/115	1.97"/50	2.56"/65	2500
8"/200	7.87"/200	6.30"/160	2.56"/65	.197"/5	6.93"/176	(6) M-10	5.00"/127	2.05"/52	2.95"/75	2000
10"/250	9.84"/250	7.87"/200	3.15"/80	.197"/5	8.81"/224	(6) M-12	5.59"/142	2.44"/62	3.15"/80	1600
12"/315	12.40"/315	10.23"/260	3.94"/100	.236"/6	11.26"/286	(6) M-16	6.53"/166	3.15"/76	3.54"/90	1200
16"/400	15.75"/400	12.99"/330	5.12"/130	.236"/6	14.25"/362	(6) M-16	7.32"/186	3.38"/86	3.94"/100	1000
20"/500	19.68"/500	16.53"/420	8.26"/210	.236"/6	18.03"/458	(6) M-16	8.07"/205	3.54"/90	4.53"/115	800
25"/630	24.80"/630	21.45"/545	9.92"/252	.275"/7	23.07"/586	(6) M-16	8.68"/220.5	3.36"/85.5	5.31"/135	800

Note: Dimensions are for flatback chucks; for D or A mounted chucks dimension B15 will vary.

(1) Model No. 2034-2A11 and 2534-2A11 have a 6.5" thru-hole

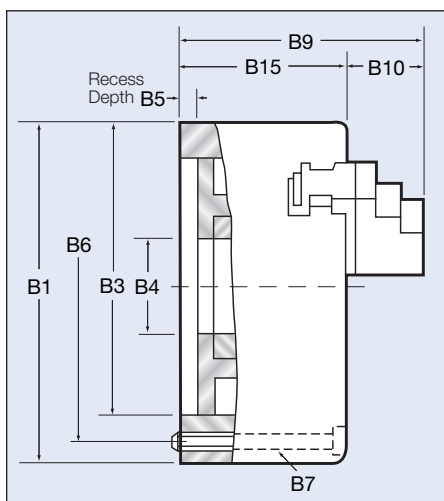
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



## Self-Centering 3-Jaw Universal Steel Body Value Line Chucks

### Series 333 Value Line Flatback, D and A Type Mounting: Sizes 6" thru 25"

- ⚙ High value and lower cost
- ⚙ One year warranty
- ⚙ Standard chuck sizes 6" thru 25"
- ⚙ Maximum .003" TIR using nominating pinion - thru 12"
- ⚙ .001" Repeatability using nominating pinion - thru 12"
- ⚙ Two-piece American Standard tongue and groove jaws
- ⚙ Hardened scroll
- ⚙ Three hardened pinions
- ⚙ Steel bodies



Chuck Size	Flatback Chuck No.	Type D Spindle Size	Chuck No.	Type A Spindle Size	Chuck No.
6"	0633-3000	D-4	0633-30D4	A-4	0633-30A4
6"	-----		-----	A-5	0633-30A5
8"	0833-3000	D-4	0833-30D4		-----
8"	-----	D-5	0833-30D5	A-5	0833-30A5
8"	-----	D-6	0833-30D6	A-6	0833-30A6
10"	1033-3000	D-5	1033-30D5	A-5	1033-30A5
10"	-----	D-6	1033-30D6	A-6	1033-30A6
10"	-----		-----	A-8	1033-30A8
12"	1233-3000	D-6	1233-30D6	A-6	1233-30A6
12"	-----	D-8	1233-30D8	A-8	1233-30A8
16"	1633-3000	D-8	1633-30D8	A-8	1633-30A8
16"	-----	D-11	1633-3D11	A-11	1633-3A11
20"	2033-3000	D-8	2033-30D8	A-8	2033-30A8
20"	-----	D-11	2033-3D11	A-11	2033-3A11
25"	2533-3000	D-8	2533-30D8	A-8	2533-30A8
25"	-----	D-11	2533-3D11	A-11	2533-3A11

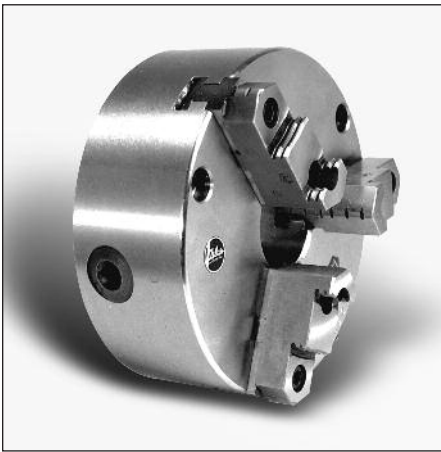
Consult factory for chucks sizes larger than 25".

### Dimensions for Universal Flatback Mounting Chucks with Two-piece Jaws (in/mm)

Chuck Size	B1	B3	B4	B5	B6	B7	B9	B10	B15	Max RPM
6"/160	6.30"/160	4.92"/125	1.77"/45	.197"/5	5.51"/140	(6) M-10	4.53"/115	2.57"/50	2.56"/65	4500
8"/200	7.87"/200	6.30"/160	2.56"/65	.197"/5	6.93"/176	(6) M-10	5.00"/127	2.05"/52	2.95"/75	4000
10"/250	9.84"/250	7.87"/200	3.15"/80	.197"/5	8.81"/224	(6) M-12	5.59"/142	2.44"/62	3.15"/80	3000
12"/315	12.40"/315	10.23"/260	3.94"/100	.236"/6	11.26"/286	(6) M-16	6.53"/166	3.15"/76	3.54"/90	2300
16"/400	15.75"/400	12.99"/330	5.12"/130	.236"/6	14.25"/362	(6) M-16	7.32"/186	3.38"/86	3.94"/100	2000
20"/500	19.68"/500	16.53"/420	8.26"/210	.236"/6	18.03"/458	(6) M-16	8.07"/205	3.54"/90	4.52"/115	1200
25"/630	24.80"/630	21.45"/545	9.92"/252	.275"/7	23.07"/586	(6) M-16	8.68"/220.5	3.36"/85.5	4.52"/135	1200

Note: Dimensions are for flatback chucks; for D or A mounted chucks dimension B15 will vary.

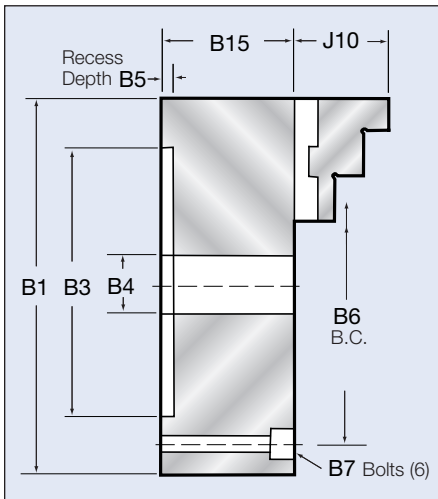
HOW TO ORDER: State quantity, chuck number and shipping instructions.



## Self-Centering 3-Jaw Universal Steel Body Chucks

### Series 332 Heavy-Duty Flatback, A, L, and D Type Mountings, Sizes 20" thru 32"

- ⌚ One year warranty
- ⌚ Steel body
- ⌚ Sizes 20" thru 32"
- ⌚ Maximum .003" TIR using nominating pinion
- ⌚ .001" Repeatability using nominating pinion
- ⌚ Two-piece American Standard tongue and groove jaws
- ⌚ Nitride hardened and ground scroll
- ⌚ Three hardened pinions
- ⌚ **Larger chuck sizes available upon request.**



Chuck Size	Flatback Chuck No.	Type A Spindle		Type L Spindle		Fits Camlock Spindle Type D	
		Size	Chuck No.	Size	Chuck No.	Size	Chuck No.
20"	2033-2000	A-8	2033-20A8	L-1	2033-20L1	D-8	2033-20D8
20"	---	A-11	2033-2A11	L-2	2033-20L2	D-11	2033-2D11
24"	2433-2000	A-8	2433-20A8	L-2	2433-20L2	D-8	2433-20D8
24"	---	A-11	2433-2A11	---	---	D-11	2433-2D11
28"	2833-2000	A-15	2833-2A15	L-2	2833-20L2	D-11	2833-2D11
28"	---	A-20	2833-2A20	---	---	---	---
32"	3233-2000	A-15	3233-2A15	L-3	3233-20L3	D-11	3233-2D11
32"	---	A-20	3233-2A20	---	---	---	---

Consult factory for chucks sizes larger than 32".

### Dimensional Data for Universal Flatback Mounting Chucks

Chuck Dia.	B1	B3	B4	B5	B6	B7	B15	J10	RPM
20"	19.6"	15.748"	5.51" <sup>(1)</sup>	.236"	18.03"	M-16	4.17"	3.26"	1100
24"	23.6"	21.456"	9.094" <sup>(1)</sup>	.236"	23.07"	M-16	4.25"	3.26"	850
28"	27.5"	23.818"	10.23"	.236"	25.98"	M-16	5.25"	3.96"	750
32"	31.5"	27.755"	10.23"	.236"	29.99"	M-16	5.25"	3.66"	600

Note: Dimensions are for flatback chucks; for A, D or L mounted chucks dimension B15 will vary, add approx. 1" to B15 dimension.

(1) Model No. 2033-2A11 and 2433-2A11 have a 6.5" thru-hole.

HOW TO ORDER: State quantity, chuck number, and shipping instructions.

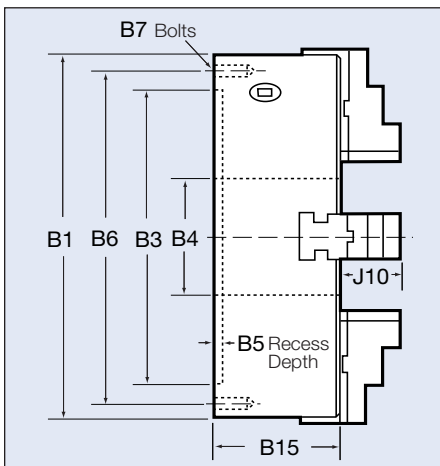


# Self-Centering 4-Jaw Universal Steel Body Chucks

## Series 743 Sizes 6" thru 24"

- ⌚ One year warranty
- ⌚ Sizes 6" thru 24"
- ⌚ Chucks can be supplied with thru holes from front of chuck for mounting on rotary tables or centers
- ⌚ Maximum .003" TIR using nominating pinion
- ⌚ .001" Repeatability using nominating pinion
- ⌚ Two-piece American Standard tongue and groove jaws
- ⌚ Nitride hardened and ground scroll
- ⌚ Hardened pinions
- ⌚ Steel body
- ⌚ Can be used for either two jaw or four jaw concentric, self-centering chucking
- ⌚ Larger sizes available on request
- ⌚ Sizes 20" and 24" chucks also available in iron body on request

Chuck Size	Flatback Chuck No.	Camlock type D Spindle		Type L Spindle		Type A Spindle		Threaded Type Spindle	
		Size	Chuck No.	Size	Chuck No.	Size	Chuck No.	Size	Chuck No.
6"	0673-2000	D-3	0673-20D3	L-00	0673-2L00	A-4	0673-20A4	1-1/2-8	0673-2041
6"		D-4	0673-20D4	L-0	0673-20L0	A-5	0673-20A5	1-3/4-8	0673-2042
6"								2-1/4-8	0673-2043
6"								2-3/8-6	0673-2046
8"	0873-2000	D-4	0873-20D4	L-00	0873-2L00	A-5	0873-20A5	2-1/4-8	0873-2043
8"		D-5	0873-20D5	L-0	0873-20L0	A-6	0873-20A6	2-3/8-6	0873-2046
8"		D-6	0873-20D6						
10"	1073-2000	D-5	1073-20D5	L-0	1073-20L0	A-5	1073-20A5	2-1/4-8	1073-2043
10"		D-6	1073-20D6	L-1	1073-20L1	A-6	1073-20A6	2-3/8-6	1073-2046
10"		D-8	1073-20D8			A-8	1073-20A8		
12"	1273-2000	D-6	1273-20D6	L-0	1273-20L0	A-6	1273-20A6		
12"		D-8	1273-20D8	L-1	1273-20L1	A-8	1273-20A8		
12"		D-11	1273-2D11	L-2	1273-20L2				
16"	1673-2000	D-6	1673-20D6	L-1	1673-20L1	A-8	1673-20A8		
16"		D-8	1673-20D8	L-2	1673-20L2	A-11	1673-2A11		
16"		D-11	1673-2D11						
20"	2073-2000	D-8	2073-20D8	L-1	2073-20L1	A-8	2073-20A8		
20"		D-11	2073-2D11	L-2	2073-20L2	A-11	2073-2A11		
24"	2473-2000	D-8	2473-20D8	L-2	2473-20L2	A-8	2473-20A8		
24"		D-11	2473-2D11			A-11	2473-2A11		

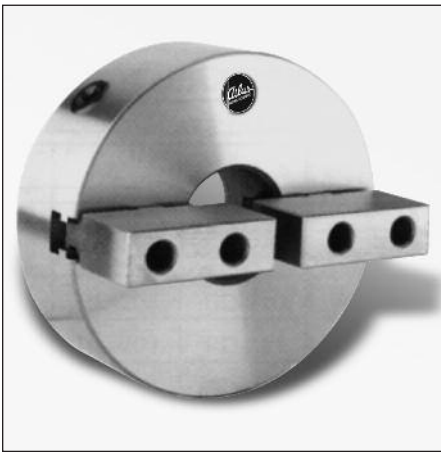


### Dimensional Data For Universal Flatback Mounting Chucks with Two-piece Jaws

Chuck Dia.	B1	B3	B4	B5	B6	B7	B15	J10
6-1/4"	6.3"	4.921"	1.65"	.157"	5.51"	3xM10	2.56"	1.64"
8"	7.9"	6.299"	2.16"	.157"	6.92"	3xM10	2.95"	1.69"
10"	9.8"	7.875"	3.15"	.165"	8.74"	3xM12	3.26"	2.11"
12"	12.4"	10.157"	3.74"	.196"	11.18"	3xM14	4.13"	2.12"
16"	15.8"	12.598"	5.11"	.196"	14.25"	3xM16	5.55"	2.44"
20"	19.6"	15.748"	6.49"	.236"	18.03"	3xM16	4.17"	2.93"
24"	23.6"	21.456"	8.07"	.275"	23.07"	3xM16	5.51"	2.93"

Note: Dimensions are for flatback chucks; on A, L and D mounted chucks dimension B15 will vary.

HOW TO ORDER: State quantity, chuck number, and shipping instructions.

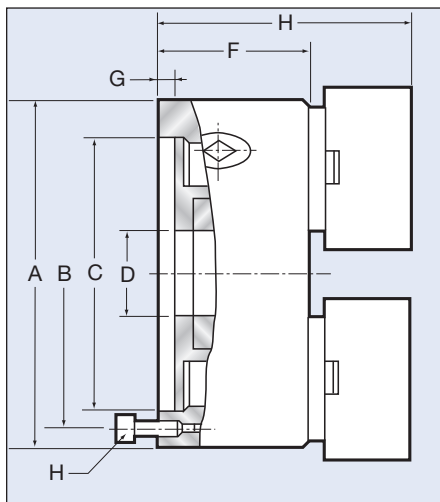


# Self-Centering 2-Jaw Scroll Chucks

## Sizes 6-25 inches

- ⊕ American standard two-piece tongue and groove jaws
- ⊕ Scroll and jaws hardened and ground
- ⊕ Sizes 6", 8", 10", 12" 15" 20" and 25",
- ⊕ Top reversible jaws
- ⊕ Semi-steel body
- ⊕ Comes with master jaws and top jaws, T-wrench and mounting screws
- ⊕ One year warranty

Chuck Size	Flatback Chuck No.	Camlock type D Spindle		Type L Spindle		Type A Spindle		Threaded Type Spindle	
		Size	Chuck No.	Size	Chuck No.	Size	Chuck No.	Size	Chuck No.
6"	0624-2000	D-3	0624-20D3	L-00	0624-2L00	A-4	0624-20A4	1-1/2-8	0624-2041
6"		D-4	0624-20D4	L-0	0624-20L0	A-5	0624-20A5	1-3/4-8	0624-2042
6"								2-1/4-8	0624-2043
6"								2-3/8-6	0624-2046
8"	0824-2000	D-4	0824-20D4	L-00	0824-2L00	A-5	0824-20A5	2-1/4-8	0824-2043
8"		D-5	0824-20D5	L-0	0824-20L0	A-6	0824-20A6	2-3/8-6	0824-2046
8"		D-6	0824-20D6						
10"	1024-2000	D-5	1024-20D5	L-0	1024-20L0	A-5	1024-20A5	2-1/4-8	1024-2043
10"		D-6	1024-20D6	L-1	1024-20L1	A-6	1024-20A6	2-3/8-6	1024-2046
10"		D-8	1024-20D8			A-8	1024-20A8		
10"									
12"	1224-2000	D-6	1224-20D6	L-0	1224-20L0	A-6	1224-20A6		
12"		D-8	1224-20D8	L-1	1224-20L1	A-8	1224-20A8		
12"		D-11	1224-2D11	L-2	1224-20L2				
15"	1624-2000	D-6	1624-20D6	L-1	1624-20L1	A-8	1624-20A8		
15"		D-8	1624-20D8	L-2	1624-20L2	A-11	1624-2A11		
15"		D-11	1624-2D11						
20"	2024-2000	D-8	2024-20D8	L-1	2024-20L1	A-8	2024-20A8		
20"		D-11	2024-2D11	L-2	2024-20L2	A-11	2024-2A11		
25"	2424-2000	D-8	2424-20D8	L-2	2424-20L2	A-8	2424-20A8		
25"		D-11	2424-2D11			A-11	2424-2A11		



### Dimensional Data 2-Jaw Self Centering Scroll Chucks

Chuck Dia.	A	B	C	D	E	F	G	H	Weight
6"	6.299"	5.591"	5.118"	1.575"	4.291"	2.559"	0.197"	3-M8	22 lbs.
8"	7.874"	7.087"	6.496"	2.559"	4.803"	2.953"	0.197"	3-M10	35 lbs.
10"	9.843"	8.898"	8.110"	3.150"	5.276"	3.150"	0.197"	3-M12	51 lbs.
12"	12.795"	11.654"	10.709"	3.937"	6.102"	3.780"	0.472"	3-M16	99 lbs.
15"	14.961"	13.780"	12.795"	5.315"	6.181"	3.858"	0.236"	3-M16	155 lbs
20"	19.685"	18.307"	17.323"	8.268"	8.268"	4.528"	0.236"	6-M16	262 lbs
25"	24.803"	23.425"	22.047"	10.630"	8.582"	5.256"	0.276"	6-M16	460 lbs

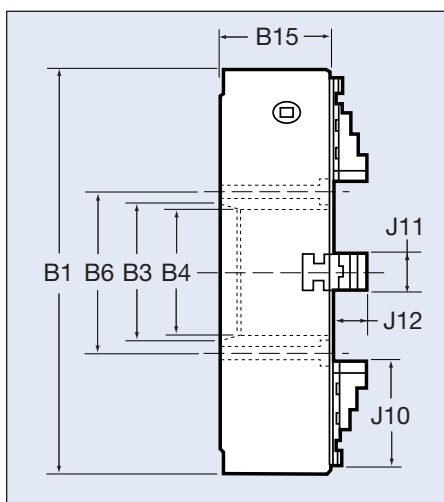
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



# King Bore Oil Country 3-Jaw Universal Chucks

## Series 332EX Extra Heavy-Duty Sizes 20" thru 48"

- ⚙️ Sizes 20" to 48"
- ⚙️ Forged Steel Body
- ⚙️ Hardened Jaw Ways
- ⚙️ Extra Heavy Duty American Standard, Hard Top and Master Jaws.
- ⚙️ Gripping surfaces serrated for more holding power
- ⚙️ Large Thru-Holes Standard
- ⚙️ Hardened Scroll Gear for long life
- ⚙️ A Type Mount standard also available with D1 Camlock Mounting
- ⚙️ T-slots optional



Chuck Size	Model No.	Mount	Thru Hole	Max rpm's	Approx. Weight
20	2033-2A11EX	A2-11	6.75	1100	475 lbs
20	2033-2A15EX	A2-15	7.30	1100	450 lbs
24	2433-2A15EX	A2-15	11.06	850	695 lbs
24	2433-2A20EX	A2-20	12.60 <sup>①</sup>	850	670 lbs
28	2833-2A15EX	A2-15	11.06	750	890 lbs
28	2833-2A20EX	A2-20	12.60 <sup>①</sup>	750	870 lbs
32	3233-2A15EX	A2-15	11.06	600	1290 lbs
32	3233-2A20EX	A2-20	12.60 <sup>①</sup>	600	1270 lbs
36	3633-2A20EX	A2-20	12.60 <sup>①</sup>	550	1610 lbs
40	4033-2A20EX	A2-20	14.56 <sup>①</sup>	500	1975 lbs
40	4033-2A28EX	A2-28	18.50	500	1910 lbs

<sup>①</sup>Optional 14.7" & 16.06" thru-hole  
Consult factory for 48" and larger chucks

### Dimensional Data 3-Jaw Universal King Bore Oil Country Chuck

Model No.	B1 O. D.	Mount Type	B3 Mount Recess	B4 Thru Hole	B6 Mounting Bolt Radius	B15 Body Width	J10 Master Jaw Length	J11 Top Jaw Width	J12 Top Jaw Height
2033-2A11EX	19.68"	A2-11	7.75"	6.75"	4.625"	6.34"	6.50"	2.36"	3.27"
2033-2A15EX	19.68"	A1-15	11.25"	7.30"	4.875"	6.34"	6.50"	2.36"	3.27"
2433-2A15EX	24.80"	A2-15	11.25"	11.06"	6.50"	6.61"	7.08"	2.36"	3.27"
2433-2A20EX	24.80"	A1-20	16.25"	12.60" <sup>①</sup>	7.25"	6.69"	7.08"	2.36"	3.27"
2833-2A15EX	27.56"	A2-15	11.25"	11.06"	6.50"	6.81"	8.26"	2.95"	3.62"
2833-2A20EX	27.56"	A1-20	16.25"	12.60" <sup>①</sup>	7.25"	6.89"	8.26"	2.95"	3.62"
3233-2A15EX	31.49"	A2-15	11.25"	11.06"	6.50"	7.01"	9.84"	2.95"	3.62"
3233-2A20EX	31.49"	A2-20	16.25"	12.60" <sup>①</sup>	9.175"	7.09"	8.50"	2.95"	3.62"
3633-2A20EX	35.43"	A2-20	16.25"	12.60" <sup>①</sup>	9.175"	7.48"	9.84"	2.95"	3.62"
4033-2A20EX	39.37"	A2-20	16.25"	14.56" <sup>①</sup>	9.175"	7.48"	9.84"	2.95"	3.62"
4033-2A28EX	39.37"	A2-28	23.00"	18.50"	12.750"	7.48"	9.84"	2.95"	3.62"

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

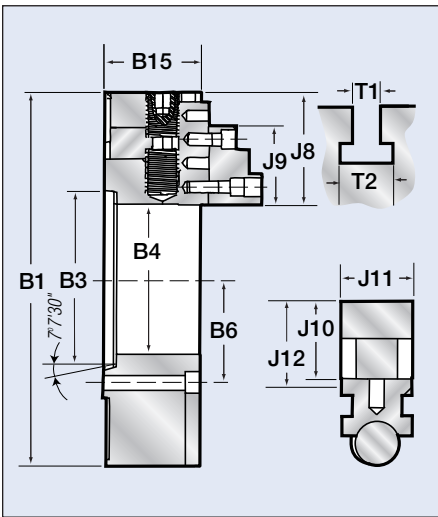




# King Bore Oil Country 4-Jaw Independent Chucks

## Series 432EX Extra Heavy-Duty Sizes 18" thru 48"

- ⚙ Forged Steel Body
- ⚙ Extra Heavy Duty American Standard, Hard Top and Master Jaws.
- ⚙ Gripping surfaces serrated for more holding power
- ⚙ Large Thru-Holes Standard
- ⚙ T-Slots Standard
- ⚙ Direct A Type Mounting
- ⚙ One Year Warranty
- ⚙ Available in smaller and larger sizes on request



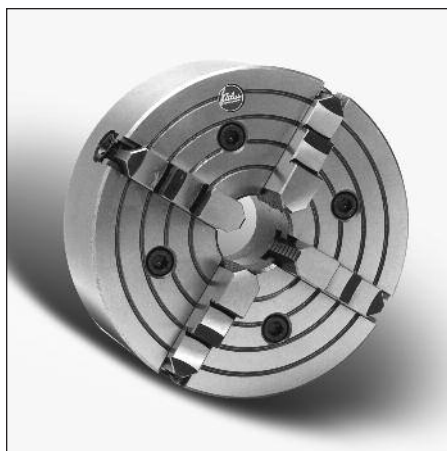
Chuck Size	Model No.	Mount	Thru Hole	Max rpm's <sup>①</sup>	Approx. Weight
18	1843-2A11EX	A2-11	6.70"	1100	350 lbs
21	2143-2A11EX	A2-11	6.70"	1000	540 lbs
21	2143-2A15EX	A2-15	7.30"	1000	533 lbs
24	2443-2A11EX	A2-11	6.70"	850	720 lbs
24	2443-2A15EX	A2-15	11.00"	850	700 lbs
24	2443-2A20EX	A2-20	12.60"	850	685 lbs
28	2843-2A15EX	A2-15	11.00"	750	905 lbs
28	2843-2A20EX	A2-20	12.60"	750	920 lbs
32	3243-2A15EX	A2-15	11.00"	600	1265 lbs
32	3243-2A20EX	A2-20	12.60"*	600	1255 lbs
36	3643-2A20EX	A2-20	12.60"*	550	1930 lbs
40	4043-2A20EX	A2-20	12.60"*	500	2350 lbs
40	4043-2A28EX	A2-28	18.50"	500	2275 lbs

\*Optional 14.7" thru hole. ① To achieve maximum RPM read instruction manual. Consult factory for 48" and larger sizes.

### Dimensional Data 4-Jaw Independent King Bore Oil Country Chuck

Model No.	B1 O. D.	B3 Mount Type	B4 Mount Recess	B6 Thru Hole	B15 Mounting Bolt Radius	J8 Body Width	J9 Master Jaw Length	J10 Top Jaw Length	J11 Top Jaw Height	J12 Top Jaw Width	T1 Top Jaw Height From Face	T2 T-Slot	T2 T-Slot
1843-2A11EX	18"	A2-11	7.75"	6.50"	4.625"	5.75"	6.50"	5.00"	2.87"	2.40"	3.26"	.708"	1.557"
2143-2A11EX	21"	A2-11	7.75"	6.57"	4.625"	5.75"	6.50"	5.00"	2.87"	2.40"	3.26"	.866"	1.557"
2143-2A15EX	21"	A2-15	11.25"	7.30"	6.50"	5.75"	6.50"	5.00"	2.87"	2.40"	3.26"	.866"	1.557"
2443-2A11EX	23.62"	A2-11	7.75"	6.57"	4.625"	6.10"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2443-2A15EX	23.62"	A2-15	11.25"	10.51"	6.50"	6.10"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2443-2A20EX	23.62"	A2-20	16.25"	12.59"	9.125"	6.10"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2843-2A15EX	27.55"	A2-15	11.25"	10.51"	6.50"	6.10"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2843-2A20EX	27.55"	A2-20	16.25"	12.59"	9.125"	6.10"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3243-2A15EX	31.49"	A2-15	11.25"	10.51"	6.50"	6.50"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3243-2A20EX	31.49"	A2-20	16.25"	12.59"	9.125"	6.50"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3643-2A20EX	35.43"	A2-20	16.25"	12.59"	9.125"	6.50"	7.75"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
4043-2A20EX	39.37"	A2-20	16.25"	12.59"	9.125"	6.50"	7.75"	5.00"	3.26"	3.00"	3.62"	1.100"	1.565"
4043-2A28EX	39.37"	A2-28	23.00"	18.50"	12.75"	6.50"	7.75"	5.00"	3.26"	3.00"	3.62"	1.100"	1.565"

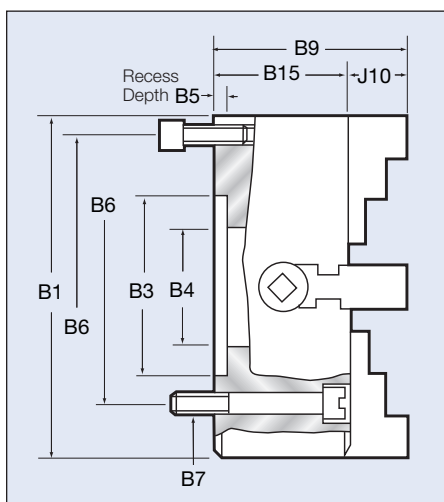
HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.



## 4-Jaw Independent Iron Body Chucks

### Series 441 Medium-Duty Value Line Sizes 5" thru 32"

- ⚙ High value and lower cost
- ⚙ One year warranty
- ⚙ 1 set Solid Reversible Jaws
- ⚙ Hardened and ground operating screws
- ⚙ High tensile iron bodies
- ⚙ Straight recess for adapter mounting
- ⚙ Available with A, D, L and straight recess mounting



Chuck Size	Flatback Chuck No.	Type D Spindle		Type A Spindle	
		Size	Chuck No.	Size	Chuck No.
5"	0544-1000				
6"	0644-1000	D-3	0644-10D3		
6"		D-4	0644-10D4		
8"	0844-1000	D-3	0844-10D3		
8"		D-4	0844-10D4		
8"		D-5	0844-10D5	A-5	0844-10A5
10"	1044-1000	D-5	1044-10D5	A-5	1044-10A5
10"		D-6	1044-10D6	A-6	1044-10A6
12"	1244-1000	D-6	1244-10D6	A-6	1244-10A6
12"		D-8	1244-10D8	A-8	1244-10A8
16"	1644-1000	D-8	1644-10D8	A-8	1644-10A8
16"		D-11	1644-1D11	A-11	1644-1A11
18"	1844-1000	D-8	1844-10D8	A-8	1844-10A8
18"		D-11	1844-1D11	A-11	1844-1A11
20"	2044-1000	D-8	2044-10D8	A-8	2044-10A8
20"		D-11	2044-1D11	A-11	2044-1A11
24"	2444-1000	D-8	2444-10D8	A-8	2444-10A8
24"		D-8	2444-1D11	A-11	2444-1A11
32"	3244-1000	D-11	3244-1D11	A-11	3244-1A11
32"		D-15	3244-1D15	A-15	3244-1A15

Contact PBA for price and availability for "L" type mounted chucks

### Dimensional Data 4-Jaw Independent Iron Body Chucks (in/mm)

Chuck Dia.	B1	B3	B4	B5	B6	B7	B9	B15	J10
6"/160	6.30"/160	2.56"/65	1.77"/45	.197"/5	3.74"/95	(4) M-10	2.36"/96.5	2.56"/65	1.24"/31.5
8"/200	7.87"/200	4.92"/125	1.97"/50	.236"/6	4.11"/104.5	(4) M-10	4.33"/110	2.95"/75	1.37"/35
10"/250	9.84"/250	4.33"/110	2.56"/65	.236"/6	4.72"/120	(4) M-12	4.62"/117.5	3.29"/82	1.39"/35.5
12"/315	12.40"/315	5.51"/140	3.74"/95	.236"/6	6.49"/165	(4) M-16	5.27"/134	3.54"/90	1.73"/44
16"/400	15.75"/400	6.30"/160	4.92"/125	.315"/8	7.28"/185	(4) M-16	5.63"/143	3.74"/95	1.89"/48
18"/450	17.71"/450	7.08"/180	5.51"/140	.315"/8	8.07"/205	(4) M-16	5.79"/147	3.94"/100	1.85"/47
20"/500	19.68"/500	7.87"/200	6.30"/160	.315"/8	9.29"/236	(4) M-20	6.39"/161	4.17"/106	2.16"/55
24"/630	24.80"/630	8.66"/220	7.08"/180	.394"/10	10.26"/258	(4) M-20	7.06"/180	4.64"/118	2.56"/65
32"/800	31.49"/800	9.84"/250	8.26"/210	.472"/12	10.26"/258	(8) M-20	7.95"/202	5.19"/132	2.76"/65

Note: Dimensions are for flatback-mounted chucks; on A, L and D mounted chucks dimension B15 will vary. All A & D-11 mount chucks have 6.5" thru-hole as standard.

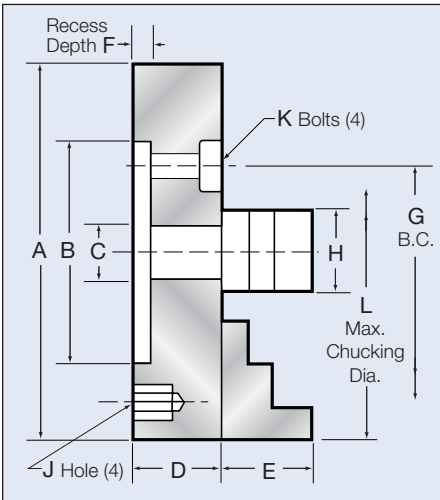
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



# 4-Jaw High Quality Independent Chucks

## Medium Duty-144 Series Heavy Duty-145 Series

- ⌚ Two-year warranty
- ⌚ Precision manufactured to fit types A, D, L, and threaded spindles or adapter mounting
- ⌚ Ductile iron body
- ⌚ Sizes 6" - 16"
- ⌚ Hardened operating screws
- ⌚ Solid reversible hard jaws
- ⌚ Special jaw and jaw way design adding extra bearing surfaces, increases chuck life and rigidity



Chuck Size	Adapter Mounting Model No.	Type A Spindle Short Taper		Type D Spindle Camlock		Type L Spindle Long Taper	
		Size	Model No.	Size	Model No.	Size	Model No.
6	0614400	-	-	D-3	0614420	L-00	0614431
6	-	-	-	D-4	0614421	L-0	0614433
8	0814400	A-5	0814410	D-3	0814420	L-00	0814431
8	-	-	-	D-4	0814421	L-0	0814432
8	-	-	-	-	-	L-1	0814433
10	1014400	A-5	1014410	D-4	1014421	L-00	1014431
10	-	-	-	D-5	1014422	-	-
10	-	A-6	1014411	D-6	1014423	L-0	1014432
10	-	A-8	1014412	D-8	1014424	L-1	1014433
12	1214400	A-6	1214411	D-6	1214423	L-0	1214432
12	-	A-8	1214412	D-8	1214424	L-1	1214433
14	1414500	A-6	1414511	D-6	1414523	L-1	1414533
14	-	A-8	1414512	D-8	1414524	L-2	1414534
16	1614500	A-8	1614512	D-8	1614524	L-1	1614533
16	-	A-11	1614513	D-11	1614525	L-2	1614534

Larger diameter chucks available, contact us for price and delivery.

### Dimensional Data for Adapter Mounting Chucks

Chuck Size	A	B	C	D	E	F	G	H	J	K	L	Gripping Capacity		Wt. lbs
												Min.	Max.	
6"	6.30"	4.921"	1.77"	2.12"	.87"	.16"	5.512"	.94"	M10	M10	7 1/8"	5/16"	5"	16
8"	7.87"	4.921"	1.97"	2.83"	1.22"	.16"	5.512"	1.26"	M10	M10	9 1/4"	5/16"	7"	31
10"	9.84"	7.874"	2.36"	2.83"	1.22"	.19"	8.819"	1.26"	M12	M12	12"	1/2"	8"	43
12"	12.40"	7.874"	2.95"	3.15"	1.42"	.19"	8.819"	1.42"	M12	M12	14"	1/2"	10"	72
14"	13.80"	10.236"	2.95"	3.58"	1.47"	.19"	11.26"	1.42"	-	M12	16"	3/4"	12"	126
16"	15.75"	10.236"	4.05"	3.58"	1.47"	.19"	11.26"	1.42"	-	M12	18"	3/4"	14"	180

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

## Mounting Plates for 144 and 145 Series Independent Chucks

Mounting plates are precision machined to suit the spindle nose of your machine. Plates are stocked semi-finished. If ordering plate separately, specify the model number of your chuck so that PBA can finish machine the adapter to suit your Pratt Burnerd chuck.

### Type D Camlock Mountings

Spindle	6"	8"	10"	12"	14"	16"
D-3	0603020	0603020	1003020	1003020	-	-
D-4	0603021	0603021	1003021	1003021	-	-
D-5	0603022	0603022	1003022	1003022	1203022	-
D-6	-	0603023	1003023	1003023	1203023	1203023
D-8	-	-	1003024	1003024	1203024	1203024
D-11	-	-	-	-	1203025	1203025

### Type A American Standard Short Taper A1 & A2 Spindles

Spindle	6"	8"	10"	12"	14"	16"
A-5	0603010	0603010	1003010	-	-	-
A-6	0603011	0603011	1003011	1003011	-	-
A-8	-	-	1003012	1003012	1203012	1203012
A-11	-	-	-	-	1203013	1203013

### Type L American Standard Long Taper Spindles

Spindle	6"	8"	10"	12"	14"	16"
L-00	0603031	0603031	1003031	-	-	-
L-0	0603032	0603032	1003032	1003032	1203032	-
L-1	-	-	1003033	1003033	1203033	1203033
L-2	-	-	1003034	1003034	1203034	1203034

### Threaded Spindles

Spindle	6"	8"	10"
1½"-8	0603041	0603041	-
1¾"-8	0603042	0603042	-
2¼"-8	0603043	0603043	1003043

### Hardinge 4° Taper Plate

Spindle	6"	8"
4° Taper	0604044	0604044

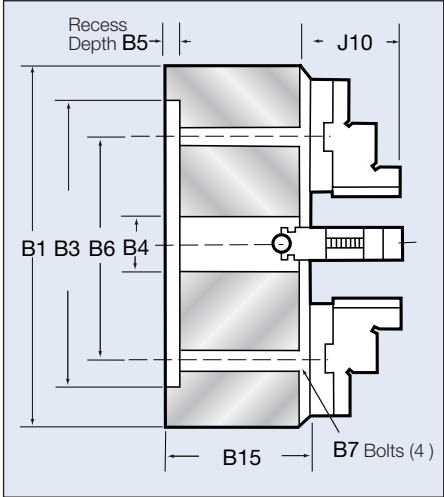
Special adapter plates available upon request. Specify chuck number and spindle nose specifications. 6", 8", 10" and 12" adapters are the same as 3 Jaw adapters on page 9. For standard spindle dimensions, see page 103.



# 4-Jaw Standard Independent Steel Body Chucks

## Series 432 Heavy-Duty Sizes 12" thru 80"

- 🌀 One year warranty   🌀 Sizes 12" thru 80"
- 🌀 Two-piece reversible American Standard tongue and groove jaws
- 🌀 Hardened and ground operating screws
- 🌀 Steel body   🌀 T-slots standard   🌀 Straight recess for adapter mounting
- 🌀 **Larger chucks available up to 80" on request**



Chuck Size	Flatback Chuck No.	Type A Spindle		Type D Spindle	
		Size	Chuck No.	Size	Chuck No.
12"	1243-2000	A-6	1243-20A6	D-6	1243-20D6
12"		A-8	1243-20A8	D-8	1243-20D8
12"		A-11	1243-2A11	D-11	1243-2D11
14"	1443-2000	A-6	1443-20A6	D-6	1443-20D6
14"		A-8	1443-20A8	D-8	1443-20D8
14"		A-11	1443-2A11	D-11	1443-2D11
16"	1643-2000	A-8	1643-20A8	D-8	1643-20D8
16"		A-11	1643-2A11	D-11	1643-2D11
18"	1843-2000	A-8	1843-20A8	D-8	1843-20D8
18"		A-11	1843-2A11	D-11	1843-2D11
20"	2043-2000	A-8	2043-20A8	D-8	2043-20D8
20"		A-11	2043-2A11	D-11	2043-2D11
24"	2443-2000	A-8	2443-20A8	D-8	2443-20D8
24"		A-11	2443-2A11	D-11	2443-2D11
28"	2843-2000	A-11	2843-2A11	D-11	2843-2D11
28"		A-15	2843-2A15		
32"	3243-2000	A-11	3243-2A11	D-11	3243-2D11
32"		A-15	3243-2A15		
32"		A-20	3243-2A20		
36"	3643-2000	A-11	3643-2A11	D-11	3643-2D11
36"		A-15	3643-2A15		
36"		A-20	3643-2A20		

Larger sizes available, up to 80" dia., contact PBA for price quotation.  
Consult factory for 40" and larger sizes.

### Dimensional Data 4-Jaw Independent Steel Body Chucks

Chuck Dia.	B1	B3	B4	B5	B6	B7	B15	J10	Weight
12"	12.4"	7.874"	3.07"	.295"	8.819"	M-12	4.055"	2.34"	126 lbs.
14"	13.78"	10.236"	3.07"	.216"	11.26"	M-12	4.08"	2.34"	165 lbs.
16"	15.74"	10.236"	4.13"	.295"	11.26"	M-12	3.86"	2.34"	210 lbs.
18"	17.7"	7.874"	4.055"	.196"	6.61"	M-20	4.33"	3.22"	320 lbs.
20"	19.6"	9.842"	4.055"	.196"	8.66"	M-20	4.33"	3.22"	415 lbs.
24"	23.6"	9.842"	4.055"	.196"	8.66"	M-20	4.92"	3.22"	720 lbs.
28"	27.5"	9.842"	4.72"	.196"	8.66"	M-20	4.92"	3.39"	1050 lbs.
32"	31.5"	9.842"	5.31"	.196"	8.66"	M-20	4.92"	3.39"	1230 lbs.
36"	35.43"	*	*	*	*	M-20	*	3.39"	1475 lbs.

Dimensions are for flatback-mount chucks; on A, L and D mounted chucks dimension B15 will vary. \*Specify when ordering.  
"L" type mounts available upon request.

(1) B4 are standard thru-holes. Thru-holes can be larger upon request. All A-11 mount chucks have 6.5" thru-hole as standard.

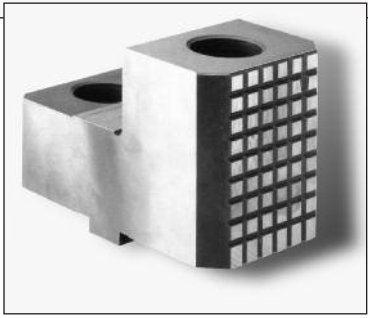
HOW TO ORDER: State quantity, chuck number, and shipping instructions.

# Heavy Duty 4 Jaw Independent Chucks

## 32" to 79" Steel Body chucks



- ⌚ One-year warranty
- ⌚ Heavy duty steel body
- ⌚ Two-piece reversible jaws
- ⌚ Long master jaws
- ⌚ One step top jaws
- ⌚ Hardened and ground jaws, operating screws and thrust bearings
- ⌚ Chuck Sizes 32", 36", 40", 48", 56", 60", 63", 71" and 79"
- ⌚ Direct mount
- ⌚ Thru-hole can be altered to suit customers requirements
- ⌚ Special larger sizes available upon request



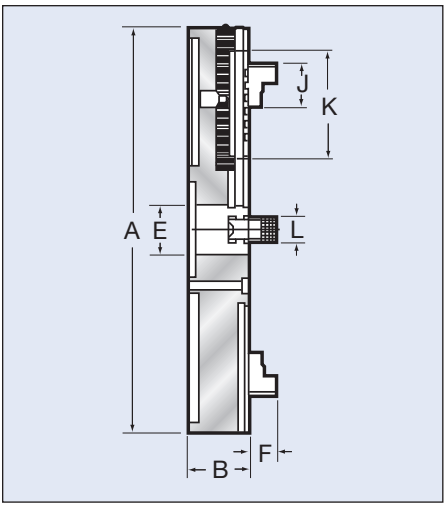
One Step Top Jaw



Optional Long Base Jaw

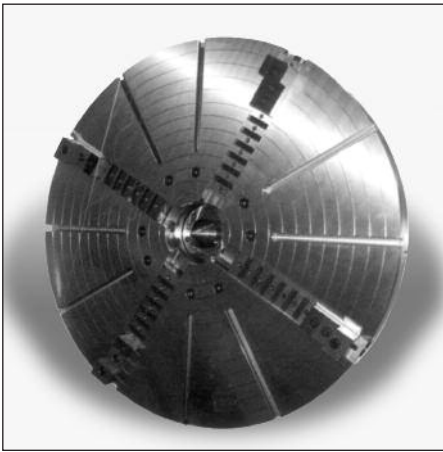
Chuck Size	Recess Mount Cast Steel	Size	Type A Spindle Cast Steel
32"	3224500	A-8	3224512
32"		A-11	3224513
32"		A-15	3224514
36"	3624500	A-11	3624513
36"		A-15	3624514
40"	4024500	A-11	4024513
40"		A-15	4024514
40"		A-20	4024515
48"	4824500	A-11	4824513
48"		A-15	4824514
48"		A-20	4824515
55"	5524500	A-11	5524513
55"		A-15	5524514
55"		A-20	5524515
60"	6024500	A-15	6024514
60"		A-20	6024515
63"	6324500	A-15	6324514
63"		A-20	6324515
71"	7124500	A-15	7124514
71"		A-20	7124515
71"		A-28	7124516
79"	7924500	A-15	7924514
79"		A-20	7924515
79"		A-28	7924516

### Dimensional Data



Chuck Size	A	B	E	F	J	L	K	Optional K
32"	31.50"	5.31"	5.31"	2.87"	5"	2.36"	7.99"	11.18"
36"	35.43"	5.31"	5.51"	2.87"	5"	2.36"	7.99"	12.68"
40"	39.37"	5.51"	5.91"	3.07"	5"	2.95"	7.99"	12.68"
48"	47.24"	6.30"	6.30"	3.07"	5"	2.95"	7.99"	15.75"
55"	55.12"	6.69"	6.30"	3.07"	5"	2.95"	7.99"	17.72"
60"	59.06"	7.28"	6.30"	3.07"	5"	2.95"	7.99"	19.69"
63"	62.99"	7.68"	6.69"	3.62"	5"	3.54"	21.65"	21.65"
71"	70.87"	8.07"	7.09"	3.62"	5"	3.54"	23.62"	23.62"
79"	78.74"	8.46"	7.09"	3.62"	5"	3.54"	25.59"	25.59"

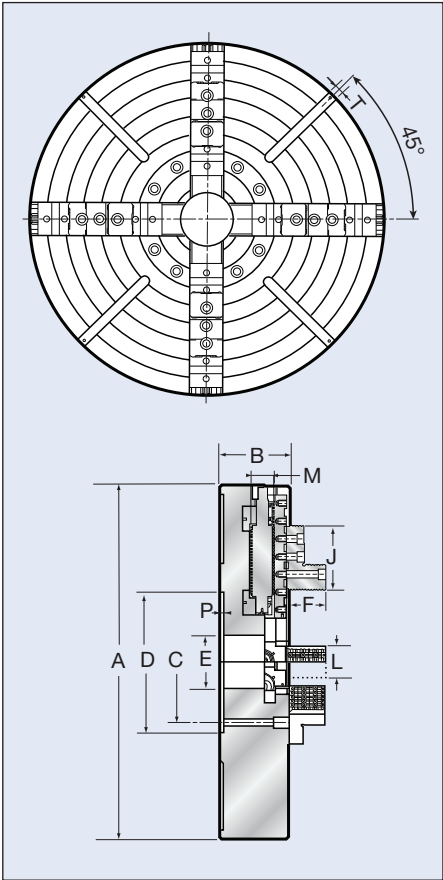
HOW TO ORDER: State quantity, Chuck Number, and shipping instructions.



# Heavy Duty 4-Jaw Independent XL Chucks

## Sizes 24" to 79 "

- ⚙ Super Heavy-Duty for Heavy Parts
- ⚙ Steel Body
- ⚙ Hardened and Ground Master and Top Jaws
- ⚙ Extra Long Master Jaws for more rigidity and adjustability
- ⚙ Hardened and Ground Operating Screws and Thrust Bearing



Consult factory for larger sizes

(mm/inch)

Chuck Size	Recess Mount	Mount	Type D Spindle	Mount	Type A Spindle
600/23.6	2443-2000XL	D-8	2443-20D8XL	A-8	2443-20A8XL
600/23.6		D-11	2443-2D11XL	A-11	2443-2A11XL
700/27.5	2843-2000XL	D-8	2843-20D8XL	A-8	2843-20A8XL
700/27.5		D-11	2843-2A11XL	A-11	2843-2A11XL
800/31.5	3243-2000XL	D-11	3243-2D11XL	A-11	3243-2A11XL
800/31.5		D-15	3243-2D15XL	A-15	3243-2A15XL
900/35.5	3643-2000XL	D-11	3643-2D11XL	A-11	3643-2A11XL
900/35.5		D-15	3643-2D15XL	A-15	3643-2A15XL
1000/39.4	4043-2000XL	D-11	4043-2D11XL	A-11	4043-2A11XL
1000/39.4		D-15	4043-2D15XL	A-15	4043-2A15XL
1000/39.4		D-20	4043-2D20XL	A-20	4043-2A20XL
1200/47.2	4843-2000XL	D-11	4843-2D11XL	A-11	4843-2A11XL
1200/47.2		D-15	4843-2D15XL	A-15	4843-2A15XL
1200/47.2		D-20	4843-2D20XL	A-20	4843-2A20XL
1400/55	5543-2000XL	D-11	5543-2D11XL	A-11	5543-2A11XL
1400/55		D-15	5543-2D15XL	A-15	5543-2A15XL
1400/55		D-20	5543-2D20XL	A-20	5543-2A20XL
1500/59	5943-2000XL	D-15	5943-2D15XL	A-15	5943-2A15XL
1500/59		D-20	5943-2D20XL	A-20	5943-2A20XL
1600/63	6343-2000XL	D-15	6343-2D15XL	A-15	6343-2A15XL
1600/63		D-20	6343-2D20XL	A-20	6343-2A20XL
1800/71	7143-2000XL	D-15	7143-2D15XL	A-15	7143-2A15XL
1800/71		D-20	7143-2D20XL	A-20	7143-2A20XL
1800/71		D-28	7143-2D28XL	A-28	7143-2A28XL
2000/79	7943-2000XL	D-15	7943-2D15XL	A-15	7943-2A15XL
2000/79		D-20	7943-2D20XL	A-20	7943-2A20XL
2000/79		D-28	7943-2D28XL	A-28	7943-2A28XL

(mm/inch)

Size A	B	C	D	H	E	F	J	L	K	T-Slot	M	rpm	Weight
600/23.6	150/5.90	235/9.25	300/11.81	8xM20	120/4.72	78/3.07	130/5.12	75/2.95	203/7.99	4x22/.866	50/1.968	970	573 lbs
700/27.5	150/5.90	235/9.25	300/11.81	8xM20	140/5.51	78/3.07	130/5.12	75/2.95	203/7.99	4x22/.866	50/1.968	875	838 lbs
800/31.5	150/5.90	330.2/13.0	380/14.96	8xM24	155/2.91	78/3.07	130/5.12	75/2.95	280/11.02	4x22/.866	50/1.968	764	1124 lbs
900/35.4	150/5.90	330.2/13.0	380/14.96	8xM24	160/6.10	78/3.07	130/5.12	75/2.95	315/12.04	4x22/.866	50/1.968	679	1378 lbs
1000/39.4	180/7.08	330.2/13.0	380/14.96	8xM24	170/6.69	102/4.01	180/7.08	90/3.54	350/13.78	4x22/.866	64/2.519	611	2160 lbs
1200/47	180/7.08	463.6/18.25	520/20.47	8xM24	180/7.08	102/4.01	180/7.08	90/3.54	450/17.71	4x22/.866	64/2.519	509	3086 lbs
1400/55	185/7.28	463.6/18.25	520/20.47	8xM24	180/7.08	102/4.01	180/7.08	90/3.54	550/21.65	4x22/.866	64/2.519	437	4233 lbs
1500/59	185/7.28	647.6/25.50	720/28.35	8xM30	180/7.08	102/4.01	180/7.08	90/3.54	550/21.65	4x22/.866	64/2.519	407	5048 lbs
1600/63	195/7.68	647.6/25.50	720/28.35	8xM30	190/7.48	102/4.01	180/7.08	100/3.94	650/25.59	4x28/1.10	64/2.519	382	6063 lbs
1800/71	205/8.08	647.6/25.50	720/28.35	8xM30	200/7.87	102/4.01	180/7.08	100/3.94	650/25.59	4x28/1.10	64/2.519	340	7783 lbs
2000/79	230/9.05	647.6/25.50	720/28.35	8xM30	240/9.45	142/5.59	245/9.64	120/4.72	800/31.50	4x28/1.10	80/3.149	306	11022 lbs

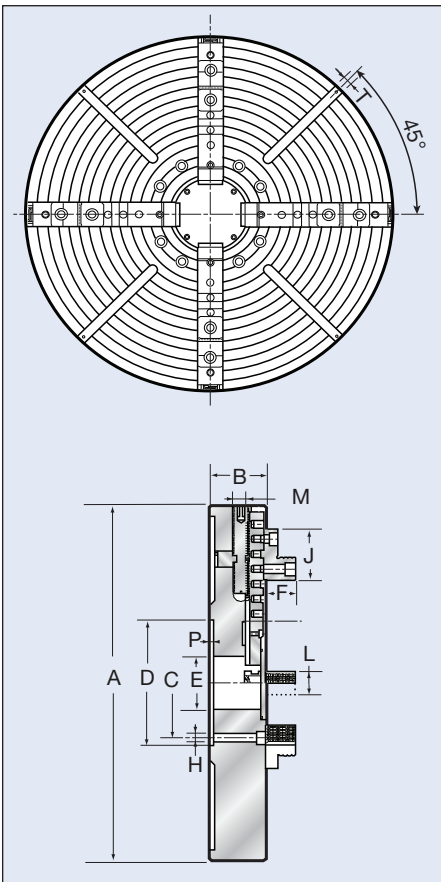
HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

# 4-Jaw Independent Manual VTL Chucks

## Sizes 24" to 120"



- ⚙ Forged Steel Body ⚙ 2 Piece American Standard Master & Hard Top Jaws
- ⚙ Hardened Operating Screws and Thrust Bearings
- ⚙ Reduced Maintenance ⚙ Master Jaw Wiper Blade
- ⚙ Extra Length Master Jaws for internal Chuck component protection
- ⚙ Thru-Hole Cover Plate ⚙ Custom T-Slots available
- ⚙ Available for straight recess, A Type Spindles or Custom Mounting
- ⚙ Larger sizes are available consult the factory for special quotations



(mm/inch)

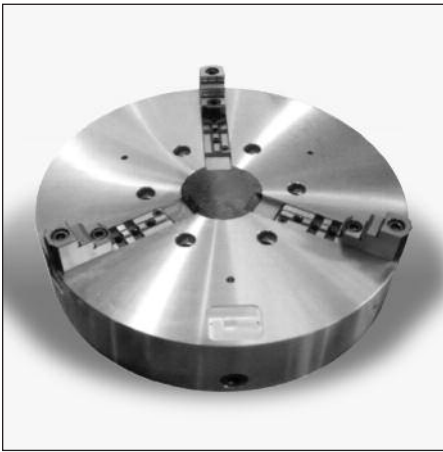
Chuck Size	Recess Mount	Mount	Type A Spindle	Max. rpm	Min. Clamping	Approx. Weight
600/23.6	2443-2000VTL	A-8	2443-2A8VTL	970	180/7.08	530 lbs
600/23.6		A-11	2443-2A11VTL	970	180/7.08	530 lbs
700/27.5	2843-2000VTL	A-8	2843-2A8VTL	873	180/7.08	838 lbs
700/27.5		A-11	2843-2A11VTL	873	180/7.08	838 lbs
800/31.5	3243-2000VTL	A-11	3243-2A11VTL	764	180/7.08	1125 lbs
800/31.5		A-15	3243-2A15VTL	764	180/7.08	1125 lbs
900/35.5	3643-2000VTL	A-11	3643-2A11VTL	679	180/7.08	1380 lbs
900/35.5		A-15	3643-2A15VTL	679	180/7.08	1380 lbs
1000/39.4	4043-2000VTL	A-11	4043-2A11VTL	611	200/7.87	1874 lbs
1000/39.4		A-15	4043-2A15VTL	611	200/7.87	1874 lbs
1000/39.4		A-20	4043-2A20VTL	611	200/7.87	1874 lbs
1200/47.2	4843-2000VTL	A-11	4843-2A11VTL	509	240/11.0	2646 lbs
1200/47.2		A-15	4843-2A15VTL	509	240/11.0	2646 lbs
1200/47.2		A-20	4843-2A20VTL	509	240/11.0	2646 lbs
1400/55	5543-2000VTL	A-11	5543-2A11VTL	437	240/11.0	3748 lbs
1400/55		A-15	5543-2A15VTL	437	240/11.0	3748 lbs
1400/55		A-20	5543-2A20VTL	437	240/11.0	3748 lbs
1500/59	5943-2000VTL	A-15	5943-2A15VTL	407	240/11.0	4718 lbs
1500/59		A-20	5943-2A20VTL	407	240/11.0	4718 lbs
1600/63	6343-2000VTL	A-15	6343-2A15VTL	382	240/11.0	5732 lbs
1600/63		A-20	6343-2A20VTL	382	240/11.0	5732 lbs
1800/71	7143-2000VTL	A-15	7143-2A15VTL	340	240/11.0	6900 lbs
1800/71		A-20	7143-2A20VTL	340	240/11.0	6900 lbs
1800/71		A-28	7143-2A28VTL	340	240/11.0	6900 lbs
2000/79	7943-2000VTL	A-15	7943-2A15VTL	306	240/11.0	9260 lbs
2000/79		A-20	7943-2A20VTL	306	240/11.0	9260 lbs
2000/79		A-28	7943-2A28VTL	306	240/11.0	9260 lbs

(mm/inch)

Size A	B	C	D	H	F	J	L	T-Slot	M
600/23.6	135/5.31	235/9.25	300/11.81	8xM20	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
700/27.5	135/5.31	235/9.25	300/11.81	8xM20	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
800/31.5	135/5.31	330/12.99	380/14.96	8xM24	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
900/35.4	135/5.31	330/12.99	380/14.96	8xM24	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
1000/39.4	150/5.90	330/12.99	380/14.96	8xM24	78/3.07	130/5.12	75/2.95	4x22/.866	50/1.968
1200/47	160/6.30	463.6/18.25	520/20.47	8xM24	78/3.07	130/5.12	75/2.95	4x22/.866	50/1.968
1400/55	170/6.69	463.6/18.25	520/20.47	8xM24	78/3.07	130/5.12	75/2.95	4x22/.866	50/1.968
1500/59	175/6.89	647.6/25.50	720/28.35	8xM30	78/3.07	130/5.12	75/2.95	4x22/.866	50/1.968
1600/63	185/7.28	647.6/25.50	720/28.35	8xM30	102/4.01	180/7.09	90/3.54	4x28/1.10	64/2.519
1800/71	185/7.28	647.6/25.50	720/28.35	8xM30	102/4.01	180/7.09	90/3.54	4x28/1.10	64/2.519
2000/79	200/7.87	647.6/25.50	720/28.35	8xM30	102/4.01	180/7.09	100/3.94	4x28/1.10	64/2.519

HOW TO ORDER: State quantity, Model Number of Chuck, Part Number of Adapter, and shipping instructions.

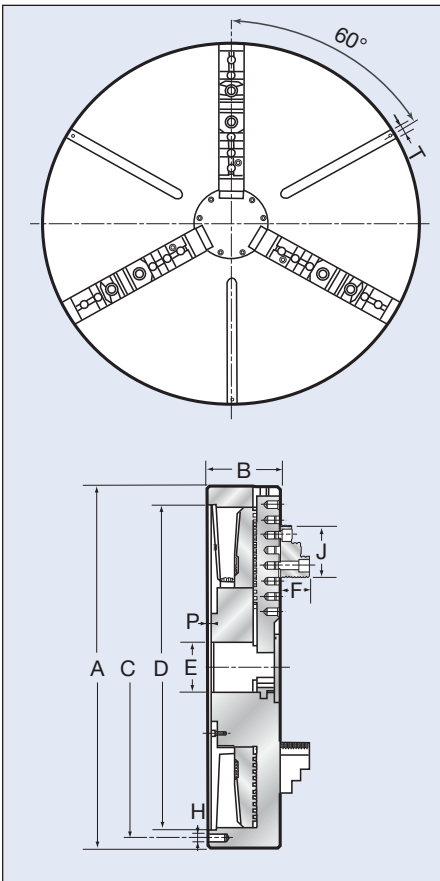




# Self Centering VTL Manual 3-Jaw Universal Chucks

## Sizes 630mm/27.5" to 2500mm/71"

- ⚙ Forged Steel Body
- ⚙ 2 Piece American Standard Master & Hard Top Jaws
- ⚙ Hardened Jaw Ways
- ⚙ Hardened Scroll and Pinion Gears
- ⚙ Reduced Maintenance
- ⚙ Master Jaw Wiper Blade
- ⚙ Extra Length Master Jaws for internal Chuck component protection
- ⚙ Thru-Hole Cover Plate
- ⚙ Custom T-Slots optional
- ⚙ Available for straight recess, A Type Spindles or Custom Mounting
- ⚙ Larger sizes are available consult the factory for special quotations



(mm/inch)

Chuck Size	Model No.	Mount	Max rpm's	Min Clamping	Approx. Weight
700/27.5	2833-2000VTL	Recess	825	180/7	739 lbs
800/31.5	3233-2000VTL	Recess	740	180/7	904 lbs
900/35.4	3633-2000VTL	Recess	650	180/7	1246 lbs
1000/39.4	4033-2000VTL	Recess	600	200/7.8	1590 lbs
1200/47	4833-2000VTL	Recess	450	240/9.5	2646 lbs
1400/55	5033-2000VTL	Recess	400	240/9.5	4078 lbs
1600/63	6333-2000VTL	Recess	335	240/9.5	6173 lbs
1800/71	7233-2000VTL	Recess	300	240/9.5	9479 lbs

(mm/inch)

Model	A	B	C	D	F	H	L	P	T-Slot	J
2833-2000VTL	700/27.5	162/6.38	660/25.98	630/24.80	71/2.74	6XM20	60/2.36	8/.315	4x18/.708	127/5.000
3233-2000VTL	800/31.5	167/6.57	760/29.92	730/28.24	71/2.74	6XM20	60/2.36	8/.315	4x18/.708	127/5.000
3633-2000VTL	900/35.4	172/6.77	850/33.46	810/31.89	71/2.74	6XM22	60/2.36	8/.315	4x18/.708	127/5.000
4033-2000VTL	1000/39.4	200/7.87	950/37.40	910/35.82	71/2.74	6XM24	75/2.95	10/.394	4x18/.708	130/5.118
4833-2000VTL	1200/47	200/7.87	950/37.40	910/35.82	80/3.15	6XM24	75/2.95	10/.394	4x22/.866	130/5.118
5033-2000VTL	1400/55	200/7.87	950/37.40	910/35.82	80/3.15	6XM24	75/2.95	10/.394	4x22/.866	130/5.118
6333-2000VTL	1600/63	200/7.87	1050/41.33	910/35.82	80/3.15	6XM30	75/2.95	10/.394	4x22/.866	130/5.118
7233-2000VTL	1800/71	200/7.87	1050/41.33	910/35.82	80/3.15	6XM30	75/2.95	10/.394	4x22/.866	130/5.118

HOW TO ORDER: State quantity, Model Number of Chuck, Part Number of Adapter, and shipping instructions.



# 4 Jaw Large Diameter Combination Chuck for Large Swing Lathes and VTL

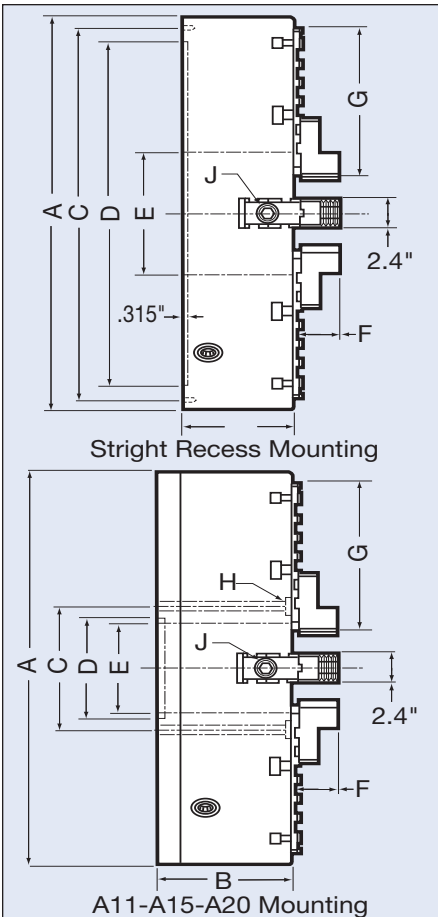
## 24" - 120" Chucks

- ⚙ Forged steel body
- ⚙ Induction hardened in areas of friction
- ⚙ Chuck bodies fully ground, including guideways
- ⚙ Two piece jaws according to ASA norms
- ⚙ Steel jaws cement hardened, treated and ground on all surfaces
- ⚙ Scroll induction hardened and ground on spiral and internal diameter
- ⚙ Operating screws hardened and ground
- ⚙ Larger sizes available upon request
- ⚙ Also available in 3-Jaw and 6-Jaw

Chuck Size	Recessed Mount Steel	Straight D Mount Type Steel		A Spindle Mount Steel	
24"	2427300	D-11	2427325	A2-11	2427313
		D-15	2427326	A2-15	2427314
28"	2827300	D-11	2827325	A2-11	2827313
		D-15	2827326	A2-15	2827314
32"	3227300	D-11	3227325	A2-11	3227313
		D-15	3227326	A2-15	3227314
				A2-20	3227315
36"	3627300	D-11	3627325	A2-11	3627313
		D-15	3627326	A2-15	3627314
				A2-20	3627315
40"	4027300	D-15	4027326	A2-15	4027314
				A2-20	4027315

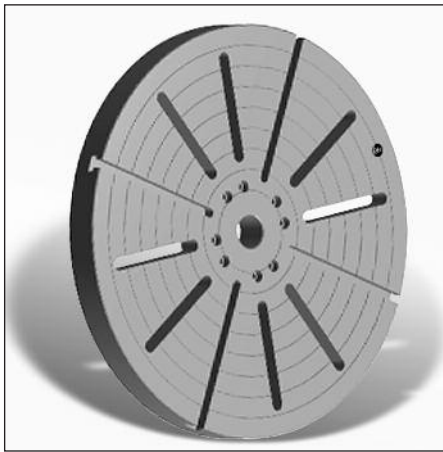
For sizes larger than 40" consult factory

### Dimensional Data (in inches)



SIZE	A	Mount	B	C	D	E	F	G	H	J
24"		Recess	7.68"	23.07"	21.45"	7.09/10.55"	3.39"	8.35/7.09"	6xM16	1.57"
		A11	8.66"	9.25"	7.75	7.09"	3.39"	8.35"	-	1.57"
		A15	9.65"	13.00"	11.25	10.51"	3.39"	7.09"	-	1.57"
27.5"		Recess	7.87"	25.98"	23.82	7.56/10.55"	3.39"	9.72/8.35"	6xM20	1.57"
		A11	8.86"	9.25"	7.75	7.56"	3.39"	9.72"	-	1.57"
		A15	8.86"	13.00"	11.25	10.51"	3.39"	8.35"	-	1.57"
31.5"		Recess	8.07"	29.92"	27.76	10.55/15.00"	3.39"	9.72/7.24"	6xM20	1.57"
		A11	9.06"	9.25"	7.75	7.56"	3.39"	10.71"	-	1.57"
		A15	9.06"	13.00"	11.25	10.51"	3.39"	9.72"	-	1.57"
35.43"		A20	9.06"	18.25"	16.25	15.00"	3.39"	7.24"	-	1.57"
		Recess	8.46"	33.46"	31.69	11.02/15.00"	3.39"	10.71/9.72"	6xM24	1.57"
		A11	9.45"	9.25"	7.75	7.56"	3.39"	10.71"	-	1.57"
39.37"		A15	9.45"	13.00"	11.25	11.02"	3.39"	10.71"	-	1.57"
		A20	9.45"	18.25"	16.25	15.00"	3.39"	9.72"	-	1.57"
		Recess	8.86"	37.40"	35.63	11.02/16.06"	3.39"	12.87/10.71"	6xM24	1.57"
		A15	9.84"	13.00"	11.25	11.02"	3.39"	12.87"	-	1.57"
		A20	9.84"	18.25"	16.25	16.06"	3.39"	10.71"	-	1.57"

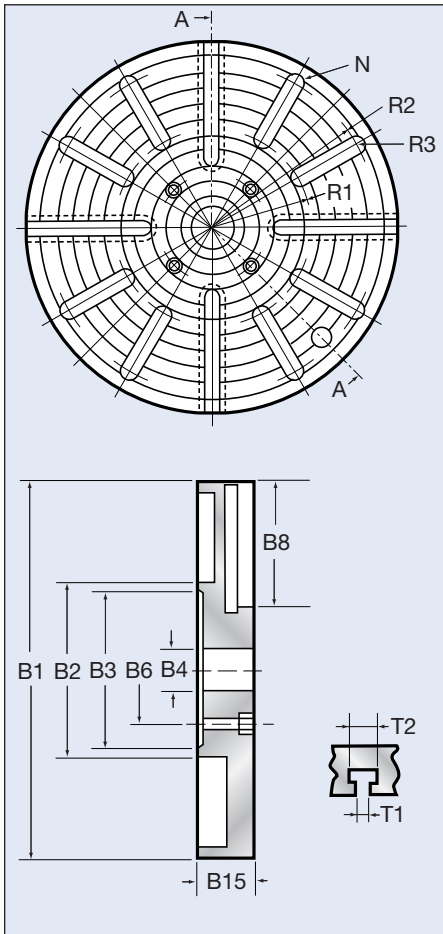
HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



Sample only

# Chucks Face Plates up to 275"

- 🌀 Steel or Cast Face Plate for special Fixturing needs
- 🌀 All Face Plates are custom made
- 🌀 Available as direct mount or flatback
- 🌀 Smaller sizes and specials available on request
- 🌀 Available in forged steel up to 275" dia. on special request
- 🌀 Photo, Drawing and Dimensions shown have Windows and T-slots. This is only a Sample, each Plate is custom made and can be designed with the number of Windows and or T-slots required. Consult Factory



Sample only

Part No.	Diameter	Type
1602000	16"	Flatback
2002000	20"	Flatback
2402000	24"	Flatback
2802000	28"	Flatback
3202000	32"	Flatback
3602000	36"	Flatback
4002000	40"	Flatback
4802000	48"	Flatback
5502000	55"	Flatback
6002000	60"	Flatback
6302000	63"	Flatback
7102000	71"	Flatback
7902000	79"	Flatback

Part No.	Diameter	Spindle Type
1602022	16"	D-5
1602023	16"	D-6
1602024	16"	D-8
2002023	20"	D-6
2002024	20"	D-8
2002025	20"	D-11
2402023	24"	D-6
2402024	24"	D-8
2402025	24"	D-11
2802024	28"	D-8
2802025	28"	D-11
2802026	28"	D-15
3202024	32"	D-8
3202025	32"	D-11
3202026	32"	D-15
3602024	36"	D-8
3602025	36"	D-11
3602026	36"	D-15
4002025	40"	D-11
4002026	40"	D-15
4802025	48"	D-11
4802026	48"	D-15
5502025	55"	D-11
5502026	55"	D-15
5502027	55"	D-20
6002025	60"	D-11
6002026	60"	D-15
6002027	60"	D-20
6302025	63"	D-11
6302026	63"	D-15
6302027	63"	D-20

Part No.	Diameter	Spindle Type
1602010	16"	A-5
1602011	16"	A-6
1602012	16"	A-8
2002011	20"	A-6
2002012	20"	A-8
2002013	20"	A-11
2402011	24"	A-6
2402012	24"	A-8
2402013	24"	A-11
2802012	28"	A-8
2802013	28"	A-11
2802014	28"	A-15
3202012	32"	A-8
3202013	32"	A-11
3202014	32"	A-15
3602012	36"	A-8
3602013	36"	A-11
3602014	36"	A-15
4002013	40"	A-11
4002014	40"	A-15
4802013	48"	A-11
4802014	48"	A-15
5502013	55"	A-11
5502014	55"	A-15
5502015	55"	A-20
6002013	60"	A-11
6002014	60"	A-15
6002015	60"	A-20

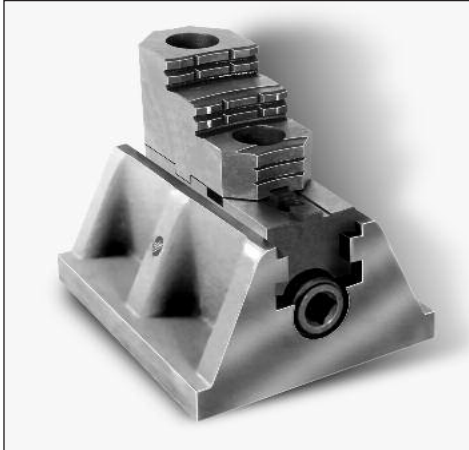
## Dimensional Data (in inch)

Dia.	B1	B2	B3	B4	B6	B7	B8	B15	T1	T2	R1	R2	R3	Windows N
15.75	8.27	6.89	2.44	5.91	4xM18	-	3.07	-	-	-	4.69	6.73	0.39	12
19.66	8.27	6.89	2.56	5.91	4xM18	-	2.95	-	-	-	4.92	6.73	0.39	12
23.62	11.02	9.84	2.68	6.89	4xM18	7.87	3.15	0.87	1.57	6.30	10.43	0.59	8	8
27.56	11.02	9.84	2.76	8.66	4xM18	9.84	3.35	0.87	1.57	6.61	11.97	0.59	8	8
31.50	11.02	9.84	2.95	8.66	8xM18	11.81	3.35	0.87	1.57	7.28	12.99	0.59	8	8
35.43	11.81	10.83	2.95	9.84	8xM18	12.80	3.35	0.87	1.57	7.28	14.96	0.59	8	8
39.37	11.81	10.83	3.15	9.84	8xM18	14.76	4.724	0.87	1.57	7.28	16.73	0.59	8	8
47.24	11.81	10.83	3.35	9.84	8xM18	18.31	4.724	1.10	1.97	7.28	20.67	0.59	8	8
55.12	11.81	10.83	3.35	9.84	8xM20	21.65	5.51	1.10	1.97	7.28/13.78	23.62/21.65	0.59	8/12	8/12
59.06	14.96	11.81	3.94	10.63	8xM24	23.62	5.90	1.10	1.97	10.24/17.72	26.57/18.11	0.59	8/12	8/12

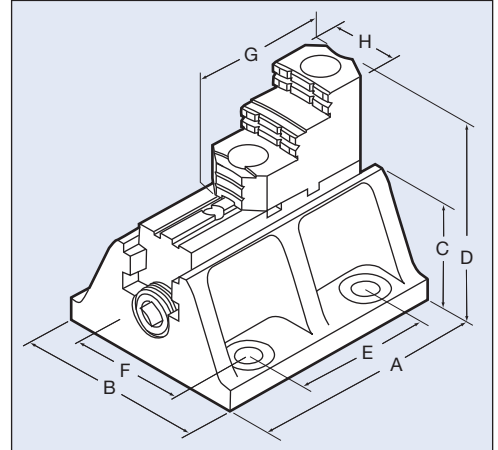
# Boring Mill Jaws for Parallel Tee-slot and Face Plate Jaws for Radial Tee-slot

- 🔧 One year warranty
- 🔧 Heavy Duty

## Boring Mill Jaw Set with 2 piece Jaw for Parallel Tee Slots

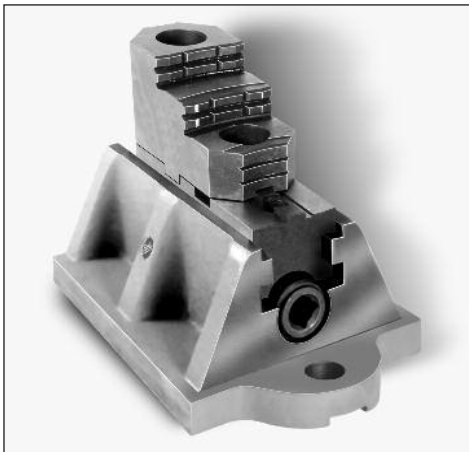


Model	1BL0100300	1BL0100400
A	8.26"	12.00"
B	6.77"	8.66"
C	3.86"	4.66"
D	7.10"	8.40"
E	4.92"	7.00"
F	4.92"	6.00"
G	5.00"	5.00"
H	2.36"	2.95"

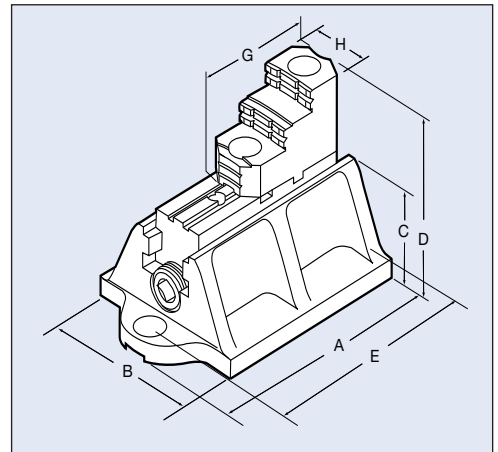


Manual Chucks  
with Mounting Plates

## Face Plate Jaw Set with 2 piece Jaw for Radial Tee Slots



Model	1BL0000600
A	14.17"
B	6.69"
C	3.65"
D	8.40"
E	12.40"
G	5.00"
H	2.95"



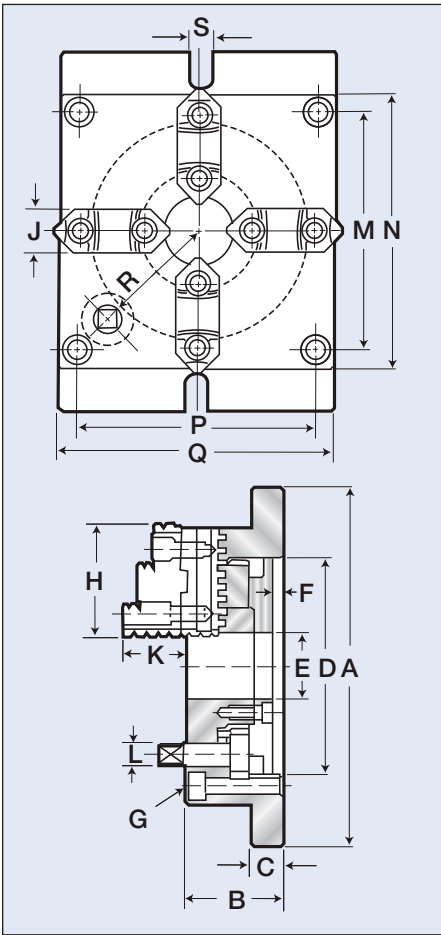
HOW TO ORDER: State quantity, model number and shipping instructions.



# Super Thin Low Profile Square Chucks

## Series MCA

- ⚙ Universal scroll chuck design
- ⚙ End-surface clamping design enables fast efficient mounting of several chucks to a worktable
- ⚙ Super thin design allows greater Z-axis machining
- ⚙ Elongated slots allows fast and easy positioning on worktable, simply use standard T-bolts, versus mounting connecting plates required by conventional chucks
- ⚙ Milled key-slots on the base plate allows accurate quick changing of the chucks
- ⚙ Ideal for pallet applications, Standard Mills, Vertical Machining Centers, Angle Plates, Tombstones, and Grinding Machines.
- ⚙ American standard, hard top and master jaws
- ⚙ One year warranty



Model	Approx Weight	Gripping capacity			
		External Min.	External Max.	Internal Min.	Internal Max.
MCA6	25 lbs	.16"	5.04"	2.17"	5.04"
MCA8	41 lbs	.20"	6.38"	2.44"	6.34"
MCA10	70 lbs	.24"	7.78"	2.83"	7.78"
MCA12	125 lbs	.39 "	10.43"	3.54 "	10.43"

### Dimensional Data (in inch)

Model	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R	S
MCA6	8.46	2.24	.71	5.12	1.57	.22	4-M10x1.5P	2.68	1.02	1.54	.551*	5.67	6.50	5.67	6.50	2.60	.71
MCA8	9.84	2.56	.79	6.30	2.17	.24	4-M12x1.7P	3.23	1.10	1.69	.669*	6.85	7.87	6.85	7.87	3.27	.71
MCA10	12.20	2.83	.87	7.87	2.76	.24	4-M14x2P	3.66	1.26	1.97	.827*	8.58	9.84	8.58	9.84	4.09	.71
MCA12	14.96	3.35	.98	10.24	3.94	.27	4-M16x2P	4.64	1.57	2.20	.905*	10.79	12.20	10.79	12.20	5.31	.87

\*square drive

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

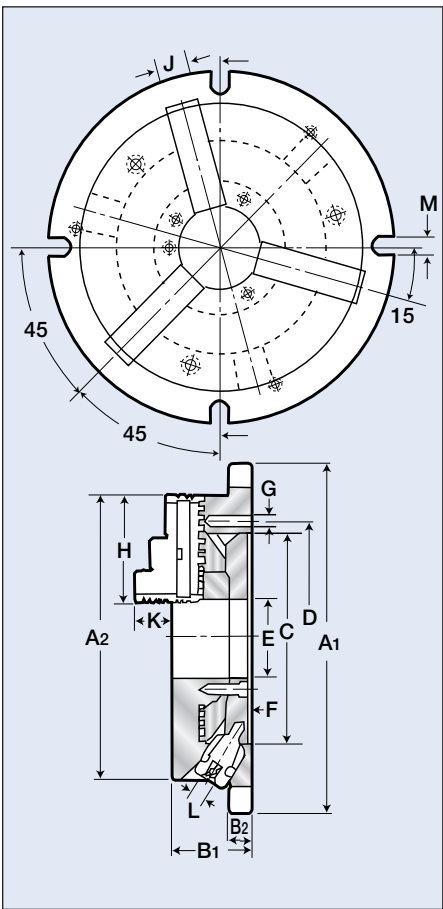


# Super Thin Low Profile Round Chucks

## Series NBK

### The Ultimate Low Profile 3-Jaw Universal Chuck

- ⚙ Three operating pinions positioned at a 45 degree angle for easier operation.
- ⚙ Sizes available 6, 8, 10 and 12 inch diameter.
- ⚙ Easy Installation with flange type mounting.
- ⚙ One Year Warranty
- ⚙ Accurate- .001" repeatability on duplicate parts using the nominated pinion.
- ⚙ Ideal for Drill Presses, Standard Mills, Vertical Machining Centers, Angle Plates, Tombstones, and Grinding Machines.
- ⚙ American standard hard top and master jaws



Model	Approx. Weight	Gripping capacity			
		External		Internal	
		Min.	Max.	Min.	Max.
NBK6	24 lbs.	.31"	6.30"	1.89"	5.91"
NBK8	40 lbs.	.43"	7.87"	2.44"	7.48"
NBK10	62 lbs.	.47"	9.84"	2.83"	9.41"
NBK12	95 lbs.	.59"	11.81"	3.38"	11.41"

### Dimensional Data (in inch)

Model	A1	A2	B1	B2	C	D	E	F	G	H	J	K	L	M
NBK6	8.66	6.69	2.28	.71	5.12	5.79	1.77	.24	3-M10x1.5P	2.68	1.02	1.57	.394*	.512
NBK8	10.63	8.27	2.56	.78	6.10	6.77	2.36	.24	3-M10x1.5P	3.23	1.10	1.69	.433*	.512
NBK10	12.40	10.04	2.87	.78	7.48	8.27	3.15	.24	3-M12x1.75P	3.66	1.26	2.04	.472*	.630
NBK12	14.57	12.00	3.15	.87	9.84	11.22	4.13	.21	3-M12x1.75P	4.64	1.57	2.32	.551*	.708

\*square drive

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



Shown with optional jaw setting fixture and hard reversible top jaws.

Jaw Presetting Fixture Order number 1009-07090

for use with 6", 8", 10", 12", 15", 18", and 20" sizes Standard Bore and King Bore Models Quick Change Jaw Power Chucks.

## Quick-Change Jaw Grip Fast Power Chucks, Standard and King Bore

### Constant Grip High Speed Thru-Hole Power Chucks Sizes 6" Thru 24"

- Ⓜ One Year Warranty Ⓜ ±.0005" Repeatability
- Ⓜ 3-Point Adjusting Feature in the chuck body permits indicating in to zero. Increase Soft Jaw Life by using adjustment feature. Reduce or eliminate re-boring of Soft Jaws.
- Ⓜ High RPM ... up to 6,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design.
- Ⓜ Quick Change Master Jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job reducing traditional setup time by 95%.
- Ⓜ SAFE Visual Indicator shows when Master Jaws are in the unlocked mode.
- Ⓜ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16 x 90, Am. Std. Acme, Am. Std Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- Ⓜ Doubles as collet chuck as master jaws have keyed radius in front that accept standard W & S collet pads. Eliminate time wasted on switching over to collet chuck.
- Ⓜ Large Thru-Hole Capacity
- Ⓜ Utilize the machine's existing actuating cylinder - does not require long stroke cylinder.
- Ⓜ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube or drawbar. PBA can supply chuck sleeve prethreaded on request, at a nominal charge.
- Ⓜ Optional Jaw Setting Fixture (as shown) for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- Ⓜ Sizes 6", 8", 10", 12", 15", 18", 20", and 24" diameters.

Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9131-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-5(D)	6000	9131-317__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-6(I)	6000	9131-417__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
8.25"	A2-5(I)	5500	9131-321__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
8.25"	A2-6(D)	5500	9131-421__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
8.25"	A2-8(I)	5500	9131-521__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
10.0"	A2-6(I)	5000	9131-426__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9131-526__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9131-531__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9131-631__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9131-538__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9131-638__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9131-546__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9131-646__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9131-650__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	2000	9131-661__	.315"	.984"	6.299"	6.0"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(D)	2000	9131-761__	.315"	.984"	6.299"	6.0"	1/2" UNC	20,700	38,250	760
<b>King Bore Quick-Change Chucks</b>											
7.0"	A2-5(D)	7000	9171-317__	.140"	.630"	2.20"	2.0"	5/16" UNC	4,500	13,000	37
8.25"	A2-6(D)	5500	9171-421__	.140"	.630"	2.59"	2.5"	5/16" UNC	5,400	15,000	53
8.25"	A2-8(D)	5500	9171-521__	.140"	.630"	2.59"	2.5"	5/16" UNC	5,400	15,000	53
10.43"	A2-6(I)	5000	9171-426__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82
10.43"	A2-8(D)	5000	9171-526__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82
12.40"	A2-8(I)	4200	9171-531__	.160"	.730"	4.05"	4.0"	3/8" UNC	9,900	27,000	183
12.40"	A2-11(D)	4200	9171-631__	.160"	.730"	4.05"	4.0"	3/8" UNC	9,900	27,000	183

① Insert last two digits for Master Jaw type...Example 9131-21723...Indicates 1.5mm x 60°: Master Jaw Required  
 Use 23 for 1.5mm x 60° Japanese type.\*\* Use 07 for Am. Std Tongue & Groove. Use 10 for 1/16 X 90° Serrations.\*  
 Use 26 for Acme Serration. Use 27 for Square Serration.

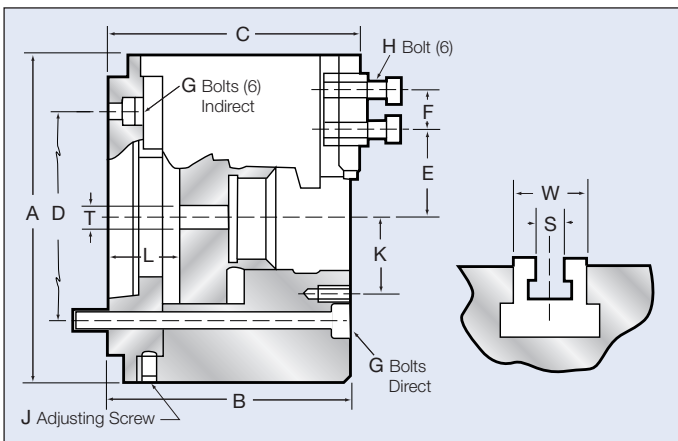
**NOTE:** 18, 20" & 24" dia. chucks require separate collet pad master jaws: 18"-#8130-46696, 20"-#8130-50696 & 24"-#8130-61696.

**HOW TO ORDER:** State quantity, Model Number of chuck, Machine Make & Model, and shipping instructions.

## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
6-A4	6.496	4.685	4.803	3.250	.787	2.126	1.339	M10x25(6)	M10x25	5/16 UNFx1/2	2.99	.94	1.57	.475	1.22
6-A5	6.496	4.842	4.960	4.125	.787	2.126	1.339	M10x130(3)	M10x25	5/16 UNFx1/2	2.99	1.10	1.73	.475	1.22
6-A6	6.496	5.078	5.196	5.250	.787	2.126	1.339	M12x30(6)	M10x25	5/16 UNFx1/2	2.99	1.50	2.13	.475	1.22
8-A5	8.26	5.119	5.275	4.125	1.000	2.637	1.733	M10x30(6)	M12x35	3/8 UNFx3/4	3.94	.98	1.61	.551	1.57
8-A6	8.26	5.354	5.510	5.250	1.000	2.637	1.733	M12x130(3)	M12x35	3/8 UNFx3/4	3.94	1.19	1.81	.551	1.57
8-A8	8.26	5.705	5.862	6.750	1.000	2.637	1.733	M16x30(6)	M12x35	3/8 UNFx3/4	3.94	2.02	1.75	.551	1.57
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	1/2 UNFx3/4	4.53	1.02	2.15	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	1/2 UNFx3/4	4.53	1.41	2.03	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M20x160(3)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
15-A8	15	6.929	7.086	6.750	1.693	5.000	3.228	M16x35(6)	M20x55	1/2 UNFx3/4	7.08/11.81	1.38	2.16	.866	2.36
15-A11	15	6.929	7.086	9.250	1.693	5.000	3.228	M20x180(6)	M20x55	1/2 UNFx3/4	7.08/11.81	1.38	2.36	.866	2.36
18-A8	18	7.720	7.780	6.750	1.693	6.772	4.527	M16x40(6)	M20x55	1/2 UNFx3/4	8.66/12.6	1.38	2.36	.984	2.36
18-A11	18	7.720	7.780	9.250	1.693	6.772	4.527	M20x35(6)	M20x55	1/2 UNFx3/4	8.66/12.6	1.38	2.36	.984	2.36
20-A11	19.68	7.362	7.499	9.250	2.362	8.090	5.059	M20x45(6)	M20x35	1/2 UNFx3/4	8.66/12.21	1.38	2-.36	.984	2.36
24-A11	24.02	7.560	7.720	9.250	2.362	10.09	5.770	M20x45(6)	M20x35	1/2 UNFx3/4	***	1.57	2.56	.984	2.36
24-A15	24.02	7.560	7.720	13.000	2.362	10.09	5.770	7/8-9x8(6)	M20x35	1/2 UNFx3/4	***	1.57	2.56	.984	2.36

\*\*\*9.45"/13"/16.53"/20.08"



### (T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service **Mono Block Jaws** are made from a nitride hardening material to allow hardening after forming without major distortion.

**Mono Block Jaws**  
See page 67 for Dimensions.

## Extra Sets of Master Jaws for Quick Change Jaw Power Chucks

	6"	8"	10"	12"	15"	18"	20"	24"
Master Jaw Type - 1.5mm x 60° Fine Serration (Japanese Type)	8130-17623	8130-21623	8130-26623	8130-31623	8130-40623	8130-46623	8130-50623**	8130-61623**
1/16 x 90° Fine serration (European Type)	8130-17610	8130-21610	8130-26610	8130-31610	8130-38610*	8130-46610*	8130-50610*	8130-61610*
Acme Serration	N/A	8130-21626	8130-26626	8130-31626	8130-40626	8130-46626	8130-50626	8130-61626
American Std. Tongue & Groove	8130-17607	8130-21607	8130-26607	8130-31607	8130-38607	8130-46607	8130-50607	8130-61607
Square Serration	N/A	8130-21627	8130-26627	8130-31627	8130-38627	8130-46627	8130-50627	8130-61627
Mono Block Jaw***	8130-17601P	8130-21601	8130-26601	8130-31601	8130-38601	8130-46601	8130-50601	8130-61601

\*\*20" & 24" diameter chucks supplied with 3mm x 60° serrations \* 15", 18" 20" and 24" diameter chucks supplied with 3/32" x 90° serrations

\*\*\* Also available in longer pointed design





## 3-Jaw Constant Grip Power Chucks

### Constant Grip High Speed Standard and King Bore Thru-Hole Power Chucks Sizes 6" Thru 24"

- ⌚ One Year Warranty ⌚ High RPM - up to 6000
- ⌚ Constant Grip, internally counter-balanced design that reduces grip loss from centrifugal force of the jaws at high RPM.
- ⌚ Easy Retrofit on most all existing NC and CNC lathes utilizing the same drawtube and actuating cylinder including Japanese types.
- ⌚ Accurate - repeatability of  $\pm .0005"$
- ⌚ 3-Point Adjusting Feature in the chuck body permits indicating in to zero. Increase Soft Jaw Life by using adjustment feature. Reduce or eliminate re-boring of Soft Jaws.
- ⌚ Doubles as collet chuck as master jaws have keyed radius in front that accept standard W & S collet pads. Eliminate time wasted on switching over to collet chuck.
- ⌚ Large Thru-Hole Capacity
- ⌚ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16" x 90, Am. Std. Acme, Am. Std. Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- ⌚ Also available in 2-jaw style.
- ⌚ Chuck sizes available 6", 8", 10", 12", 15", 18", 20" and 24" diameters.

Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9151-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-5(D)	6000	9151-317__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-6(I)	6000	9151-417__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
8.25"	A2-5(I)	5500	9151-321__	.140"	.630"	2.05"	2.0"	5/16" UNC	6,200	15,000	53
8.25"	A2-6(D)	5500	9151-421__	.140"	.630"	2.05"	2.0"	5/16" UNC	6,200	15,000	53
8.25"	A2-8(I)	5500	9151-521__	.140"	.630"	2.05"	2.0"	5/16" UNC	6,200	15,000	53
10.0"	A2-6(I)	5000	9151-426__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9151-526__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9151-531__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9151-631__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9151-538__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9151-638__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9151-546__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9151-646__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9151-650__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	1800	9151-660__	.315"	.984"	6.299"	6.25"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(D)	1800	9151-760__	.315"	.984"	6.299"	6.25"	1/2" UNC	20,700	38,250	760
<b>King Bore Chucks</b>											
7.0"	A2-5(D)	7000	9161-318__	.140"	.630"	2.20"	2.0"	5/16" UNC	4,500	13,000	37
8.25"	A2-6(D)	5500	9161-421__	.140"	.630"	2.59"	2.5"	5/16" UNC	5,400	15,000	53
10.43"	A2-6(I)	5000	9161-426__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82
10.43"	A2-8(D)	5000	9161-526__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82
12.40"	A2-8(I)	4200	9161-531__	.160"	.730"	4.05"	4.0"	3/8" UNC	9,900	27,000	183
12.40"	A2-11(D)	4200	9161-531__	.160"	.730"	4.05"	4.0"	3/8" UNC	9,900	27,000	183

① Insert last two digits for Master Jaw type...Example 9151-21723...Indicates 1.5mm x 60°: Master Jaw Required  
 Use 23 for 1.5mm x 60° Japanese type.\*\* Use 07 for Am. Std. Tongue & Groove. Use 10 for 1/16 X 90° Serrations.\*\*\*  
 Use 26 for Acme Serration. Use 27 for Square Serration.

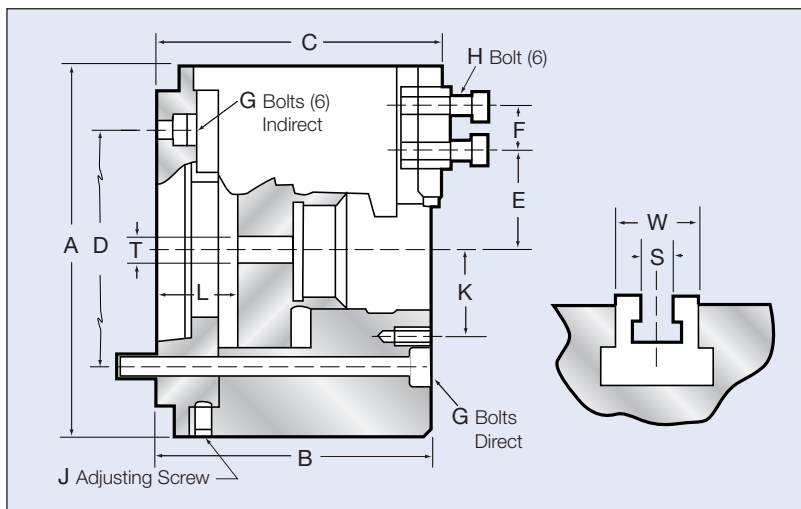
**NOTE:** 18, 20" & 24" dia. chucks require separate collet pad master jaws: 18"-#8130-46696, 20"-#8130-50696 & 24"-#8130-61696.  
 \*\*3mm on 20" and 24" dia. chucks \*\*\*3/32 x 90° on 20" and 24" chucks

HOW TO ORDER: State quantity, Model Number of chuck, Machine make & Model, and shipping instructions.

## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
6-A4	6.5	4.685	4.803	3.250	.787	2.126	1.339	M10x25(6)	M10x25	5/16 UNFx1/2	2.99	.94	1.57	.475	1.22
6-A5	6.5	4.842	4.960	4.125	.787	2.126	1.339	M10x130(3)	M10x25	5/16 UNFx1/2	2.99	1.10	1.73	.475	1.22
6-A6	6.5	5.078	5.196	5.250	.787	2.126	1.339	M12x30(6)	M10x25	5/16 UNFx1/2	2.99	1.50	2.13	.475	1.22
8-A5	8.25	5.119	5.275	4.125	1.000	2.637	1.733	M10x30(6)	M12x35	3/8 UNFx3/4	3.94	.98	1.61	.551	1.57
8-A6	8.25	5.354	5.510	5.250	1.000	2.637	1.733	M12x130(3)	M12x35	3/8 UNFx3/4	3.94	1.19	1.81	.551	1.57
8-A8	8.25	5.705	5.862	6.750	1.000	2.637	1.733	M16x30(6)	M12x35	3/8 UNFx3/4	3.94	2.02	2.65	.551	1.57
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	1/2 UNFx3/4	4.53	1.02	1.75	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	1/2 UNFx3/4	4.53	1.41	2.15	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M20x160(3)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
15-A8	15	6.929	7.086	6.750	1.693	5.000	3.228	M16x35(6)	M20x55	1/2 UNFx3/4	7.08/11.81	1.38	2.16	.866	2.36
15-A11	15	6.929	7.086	9.250	1.693	5.000	3.228	M20x180(6)	M20x55	1/2 UNFx3/4	7.08/11.81	1.38	2.36	.866	2.36
18-A8	18	7.720	7.780	6.750	1.693	6.772	4.527	M16x40(6)	M20x55	1/2 UNFx3/4	8.66/12.6	1.38	2.36	.984	2.36
18-A11	18	7.720	7.780	9.250	1.693	6.772	4.527	M20x35(6)	M20x55	1/2 UNFx3/4	8.66/12.6	1.38	2.36	.984	2.36
20-A11	19.7	7.362	7.499	9.250	2.362	8.090	5.059	M20x45(6)	M20x35	1/2 UNFx3/4	8.66/12.21	1.38	2.36	.984	2.36
24-A11	24	7.560	7.720	9.250	2.362	10.090	5.770	M20x45(6)	M20x35	1/2 UNFx3/4	***	1.57	2.56	.984	2.36
24-A15	24	7.560	7.720	13.000	2.362	10.090	5.770	7/8-9x8(6)	M20x35	1/2 UNFx3/4	***	1.57	2.56	.984	2.36

\*\*\*9.45"/13"/16.53"/20.08"



### (T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.
4. Standard master jaw serration for 20 and 24 inch chucks are 3mm x 60°.



## Quick-Change 2-Jaw Power Chucks

### Constant Grip High Speed Thru-Hole Power Chucks

Jaw Presetting Fixture Order number  
1009-07090

for use with 6", 8", 10", 12", 15", 18",  
and 20" sizes Standard Bore and King  
Bore Models Quick Change Jaw  
Power Chucks.

- Ⓐ One Year Warranty
- Ⓐ ±.0005" Repeatability
- Ⓐ 4-Point Adjusting Feature in the chuck body allows you to true up to virtually zero. Increase Soft Jaw Life by using the adjustment feature instead of skim cutting soft jaws as often. 6 points on 15" chucks and larger
- Ⓐ High RPM ... up to 6,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design.
- Ⓐ Quick Change Master Jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job reducing traditional setup time by 95%.
- Ⓐ SAFE Visual Indicator shows when Master Jaws are in the unlocked mode.
- Ⓐ Master jaws available in 1.5mm x 60° (Japanese type), 1/16" x 90°, Acme serration and square serration, American Standard tongue and groove.
- Ⓐ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16" x 90, Am. Std. Acme, Am. Std. Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- Ⓐ Large Thru-Hole Capacity
- Ⓐ Utilize the machine's existing actuating cylinder - including Japanese types.
- Ⓐ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube of drawbar PBA can supply chuck sleeve pre-threaded on request, at a nominal charge.
- Ⓐ Optional Jaw Setting Fixture for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- Ⓐ Sizes 6", 8", 10", and 12", diameters...other sizes available on request.

Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9141-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
6.5"	A2-5(D)	6000	9141-317__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
6.5"	A2-6(I)	6000	9141-417__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
8.25"	A2-5(I)	5500	9141-321__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
8.25"	A2-6(D)	5500	9141-421__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
8.25"	A2-8(I)	5500	9141-521__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
10.0"	A2-6(I)	5000	9141-426__	.160"	.730"	2.56"	2.5"	3/8" UNC	4,800	13,200	82
10.0"	A2-8(D)	5000	9141-526__	.160"	.730"	2.56"	2.5"	3/8" UNC	4,800	13,200	82
12.0"	A2-8(I)	4200	9141-531__	.160"	.730"	3.54"	3.0"	3/8" UNC	6,600	18,000	150
12.0"	A2-11(D)	4200	9141-631__	.160"	.730"	3.54"	3.0"	3/8" UNC	6,600	18,000	150

① Insert last two digits for Master Jaw type...Example 9141-21723...Indicates 1.5mm x 60°: Master Jaw Required

Use 23 for 1.5mm x 60° Japanese type.

Use 26 for Acme Serration.

Use 10 for 1/16 X 90° Serrations.

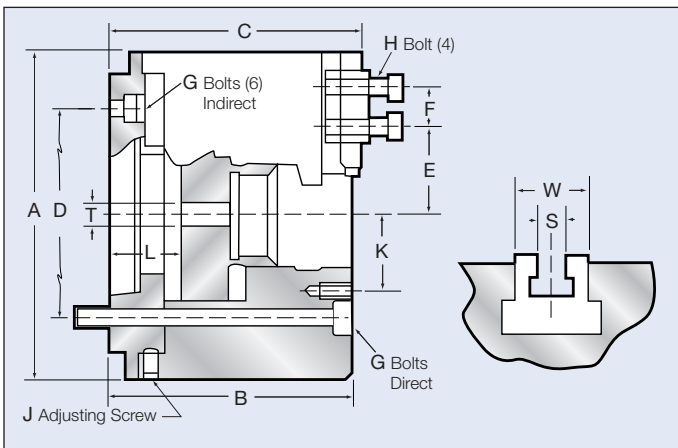
Use 07 for Am. Std Tongue & Groove.

Use 27 for Square Serration.

HOW TO ORDER: State quantity, Model Number of chuck, Machine Make & Model, and shipping instructions.

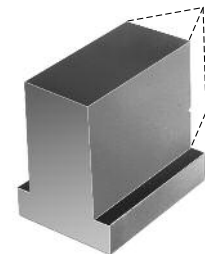
## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
6-A4	6.5	4.685	4.803	3.250	.787	2.126	1.339	M10x25(6)	M10x25	5/16 UNFx1/2	2.99	.94	1.57	.475	1.22
6-A5	6.5	4.842	4.960	4.125	.787	2.126	1.339	M10x130(4)	M10x25	5/16 UNFx1/2	2.99	1.10	1.73	.475	1.22
6-A6	6.5	5.078	5.196	5.250	.787	2.126	1.339	M12x30(6)	M10x25	5/16 UNFx1/2	2.99	1.50	2.13	.475	1.22
8-A5	8.25	5.119	5.275	4.125	1.000	2.637	1.733	M10x30(6)	M12x35	3/8 UNFx3/4	3.94	.98	1.61	.551	1.57
8-A6	8.25	5.354	5.510	5.250	1.000	2.637	1.733	M12x130(4)	M12x35	3/8 UNFx3/4	3.94	1.19	1.81	.551	1.57
8-A8	8.25	5.705	5.862	6.750	1.000	2.637	1.733	M16x30(6)	M12x35	3/8 UNFx3/4	3.94	2.02	2.65	.551	1.57
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	1/2 UNFx3/4	4.53	1.02	1.75	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(4)	M12x35	1/2 UNFx3/4	4.53	1.44	2.15	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M16x160(4)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81



(T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service **Mono Block Jaws** are made from a nitride hardening material to allow hardening after forming without major distortion.

**Mono Block Jaws**  
See page 67 Dimensions.

## Extra Sets of Master Jaws for Quick Change Jaw Power Chucks

	6"	8"	10"	12"
Master Jaw Type - 15mm x 60° Fine Serration (Japanese Type)	8140-17623	8140-21623	8140-26623	8140-31623
1/16 x 90° Fine serration (European Type)	8140-17610	8140-21610	8140-26610	8140-31610
Acme Serration	N/A	8140-21626	8140-26626	8140-31626
American Std. Tongue & Groove	8140-17607	8140-21607	8140-26607	8140-31607
Square Serration	N/A	8140-21627	8140-26627	8140-31627
Mono Block Jaw***	8130-17601P	8130-21601	8130-26601	8130-31601

\*\*\* Also available in longer pointed design



# Constant Grip Quick Change and Non-Quick Change Power Chuck

## Closed Center Power Chucks Designed for Vertical Turning Lathes

Jaw Presetting Fixture Order number  
1009-07090

for use with 6", 8", 10", 12", 15", 18",  
and 20" sizes Standard Bore and King  
Bore Models Quick Change Jaw  
Power Chucks.

- Ⓐ One Year Warranty
- Ⓐ ±.0005" Repeatability
- Ⓐ 3-Point Adjusting Feature in the chuck body permits indicating in to zero. Increase Soft Jaw Life by using adjustment feature. Reduce or eliminate re-boring of Soft Jaws.
- Ⓐ Close center design with chip ejecting discharge chutes in the chuck body face reducing build-up to near zero.
- Ⓐ High RPM ... up to 5,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design.
- Ⓐ Quick Change Master Jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job reducing traditional setup time by 95%.
- Ⓐ SAFE Visual Indicator shows when Master Jaws are in the unlocked mode.
- Ⓐ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16 x 90, Am. Std. Acme, Am. Std. Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- Ⓐ Doubles as collet chuck as master jaws have keyed radius in front that accept standard W & S collet pads. Eliminate time wasted on switching over to collet chuck.
- Ⓐ Utilize the machine's existing actuating cylinder - including Japanese types.
- Ⓐ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube of drawbar PBA can supply chuck sleeve prethreaded on request, at a nominal charge.
- Ⓐ Optional Jaw Setting Fixture (as shown) for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- Ⓐ Sizes 6", 8", 10", 12", 15", 18", 20", and 24" diameters.

Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
<b>Quick Change Jaw VTL Chucks</b>										
10.0"	A2-6(I)	5000	9101-426__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9101-526__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9101-531__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9101-631__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9101-538__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9101-638__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9101-546__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9101-646__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9101-650__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	1800	9101-660__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(I)	1800	9101-760__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
<b>Non-Quick Change Jaw VTL Chucks</b>										
10.0"	A2-6(I)	5000	9111-426__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9111-526__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9111-531__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9111-631__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9111-538__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9111-638__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9111-546__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9111-646__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9111-650__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	1800	9111-660__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(I)	1800	9111-760__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760

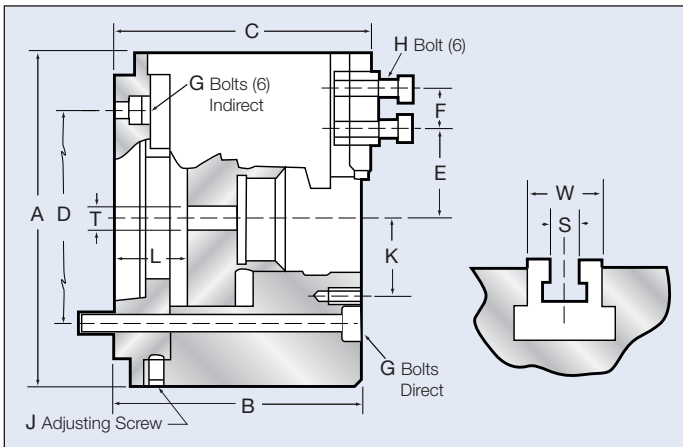
① Insert last two digits for Master Jaw type...Example 9101-42623...Indicates 1.5mm x 60°: Master Jaw Required  
 Use 23 for 1.5mm x 60° Japanese type.\*\* Use 07 for Am. Std. Tongue & Groove. Use 10 for 1/16 X 90° Serrations.\*  
 Use 26 for Acme Serration. Use 27 for Square Serration.

HOW TO ORDER: State quantity, Model Number of chuck, Machine make & Model, and shipping instructions.

## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	½ UNFx¾	4.53	1.42	2.15	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	½ UNFx¾	4.53	1.30	2.03	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	½ UNFx¾	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M20x110(3)	M14x45	½ UNFx¾	5.71	1.38	2.16	.710	1.81
15-A8	15	6.929	7.086	6.750	1.693	5.000	3.228	M16x35(6)	M20x55	½ UNFx¾	7.08/11.81	1.38	2.16	.866	2.36
15-A11	15	6.929	7.086	9.250	1.693	5.000	3.228	M20x180(6)	M20x55	½ UNFx¾	7.08/11.81	1.38	2.36	.866	2.36
18-A8	18	7.720	7.780	6.750	1.693	6.772	4.527	M16x40(6)	M20x55	½ UNFx¾	8.66/12.6	1.38	2.36	.984	2.36
18-A11	18	7.720	7.780	9.250	1.693	6.772	4.527	M20x35(6)	M20x55	½ UNFx¾	8.66/12.6	1.38	2.36	.984	2.36
20-A11	19.7	7.362	7.499	9.250	2.362	8.090	5.059	M20x45(6)	M20x35	½ UNFx¾	8.66/12.21	1.38	3.36	.984	2.36
24-A11	24	7.560	7.720	9.250	2.362	10.090	5.770	M20x45(6)	M20x35	½ UNFx¾	***	1.57	2.56	.984	2.36
24-A15	24	7.560	7.720	13.000	2.362	10.090	5.770	7/8-9x8(6)	M20x35	½ UNFx¾	***	1.57	2.56	.984	2.36

\*\*\*9.45"/13"/16.53"/20.08"



(T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service **Mono Block Jaws** are made from a nitride hardening material to allow hardening after forming without major distortion.

**Mono Block Jaws**  
See page 67 for Dimensions.

## Extra Sets of Master Jaws for Quick Change Jaw Power Chucks

	10"	12"	15"	18"	20"	24"
Master Jaw Type - 15mm x 60° Fine Serration (Japanese Type)	8130-26623	8130-31623	8130-40623	8130-46623	8130-50623**	8130-61623**
1/16 x 90° Fine serration (European Type)	8130-26610	8130-31610	8130-38610*	8130-46610*	8130-50610*	8130-61610*
Acme Serration	8130-26626	8130-31626	8130-40626	8130-46626	8130-50626	8130-61626
American Std. Tongue & Groove	8130-26607	8130-31607	8130-40607	8130-46607	8130-50607	8130-61607
Square Serration	8130-26627	8130-31627	8130-40627	8130-46627	8130-50627	8130-61627
Mono Block Jaw ***	8130-26601	8130-31601	8130-38601	8130-46601	8130-50601	8130-61601

\*\* 20" and 24" diameter chucks supplied with 3mm x 60° serrations \* 15", 18", 20" and 24" diameter chucks supplied with 3/32" x 90° serrations

\*\*\* Also available in long pointed design

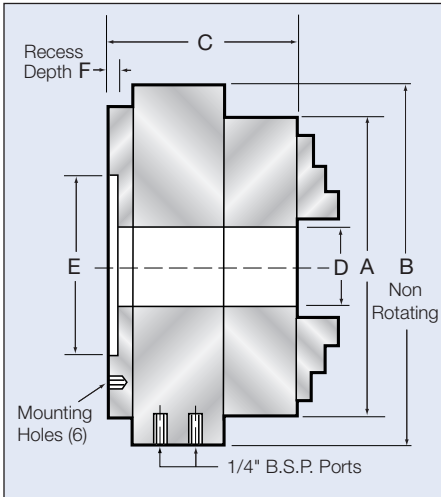


Chuck shown with optional hard reversible top jaws.

# MK3 3-Jaw Self-Contained Air Power Chucks

Turn your engine lathe into a production machine with this easy retrofit self-contained power chuck.

- ⊕ One-year warranty
- ⊕ Precision manufactured to fit types A and D spindles and adapter mounting
- ⊕ Repetitive gripping within .001" TIR
- ⊕ Safe, Chuck operates independently of air supply when gripping
- ⊕ No separate actuating cylinder
- ⊕ No draw tube to restrict thru-hole
- ⊕ Sizes 6 1/2", 8", 10", 12", and 14"
- ⊕ Suitable for chucking or barwork
- ⊕ Less overhang. Lighter in weight
- ⊕ Minimum maintenance
- ⊕ Quick, simple Lever or Foot Pedal Operation
- ⊕ Easy installation ref. page 41
- ⊕ Optional top jaws ref. page 41
- ⊕ 1/16" x 90° serrated master jaws standard with T-nut



Dimensions are for adapter mount chucks.

Chuck Size	Adapter Mount Model No.	Type D Spindles		Type A Spindles	
		Spindle Size	3-Jaw Model No.	Spindle Size	3-Jaw Model No.
6 1/2"	3-Jaw 9760-01710	D-3	9762-21710	-	-
		D-4	9762-31710	-	-
		D-5	9762-41710	A-5	9761-31710
		D-6	9762-51710	A-6	-
8"	3-Jaw 9760-02110	D-4	9762-32110	-	-
		D-5	9762-42110	A-5	9761-32110
		D-6	9762-52110	A-6	9761-42110
10"	3-Jaw 9760-02610	D-5	9762-42610	-	-
		D-6	9762-52610	A-6	9761-42610
		D-8	9762-62610	A-8	9761-52610
12"	3-Jaw 9760-03210	D-8	9762-63210	A-8	9761-53210
		D-11	9762-73210	A-11	9761-63210
14"	3-Jaw 9760-03510	D-8	9762-63510	A-8	9761-53510
		D-11	9762-73510	A-11	9761-63510

Table Mount, "L" Type Mounts and Special Mounts available upon request.

## Dimensional and Technical Data (in inch)

Chuck Size	A	B	C	D	E	F	Mtg Hole	6-Hole B.C.	Wt. Lbs	Max rpm*	Jaw Travel	Ext. Gripping Range Std. Hard Jaws	Int. Gripping Range Std. Hard Jaws	Force**
6 1/2	6.50	9.45	5.06	1.50	4.921	.24	M10	5.91	50	3000	.180	.63 to 7.09	2.80 to 7.80	6,930
8	7.87	10.63	5.16	2.05	6.102	.24	M10	7.09	68	2500	.180	.98 to 8.62	3.58 to 9.58	10,230
10	9.84	12.20	5.73	2.56	7.283	.24	M10	8.27	100	2000	.197	1.22 to 10.71	4.45 to 11.39	15,180
12 1/2	12.40	13.98	5.79	3.54	8.858	.26	M10	9.84	144	1500	.197	1.57 to 13.35	5.31 to 14.69	18,080
14	13.78	15.35	7.28	5.59	10.000	.26	M12	11.00	200	1300	.236	3.50 to 14.60	7.30 to 15.90	18,960

\*Max. RPM at 85 PSI with standard hard top jaws. Consult factory for increased RPM rating.

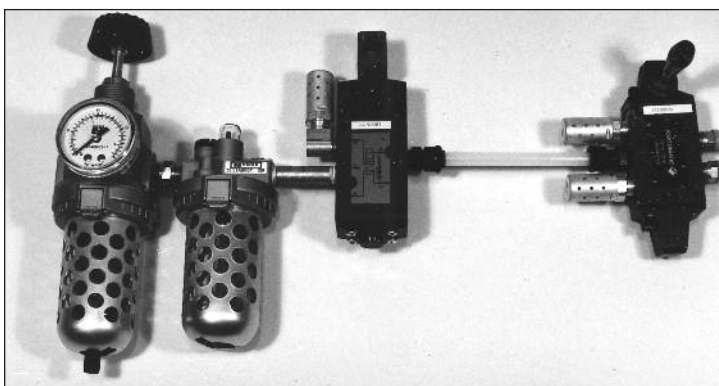
\*\* Total Gripping Force (lbs) at 85 PSI

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

# Pratt Burnerd Accessories and Installation For MK3 Self-Contained Power Chucks

## Lever Control Unit - Part Number 1157-12800

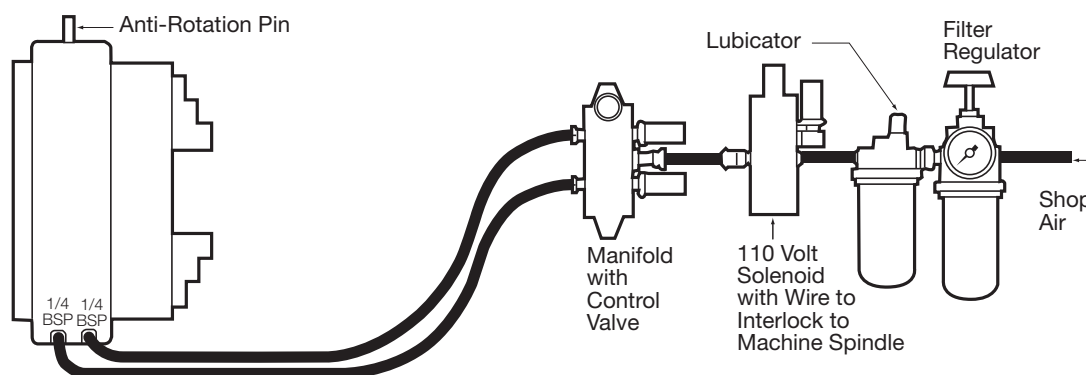
## Foot Pedal Control Unit - Part Number 1157-12801 (Not Shown)



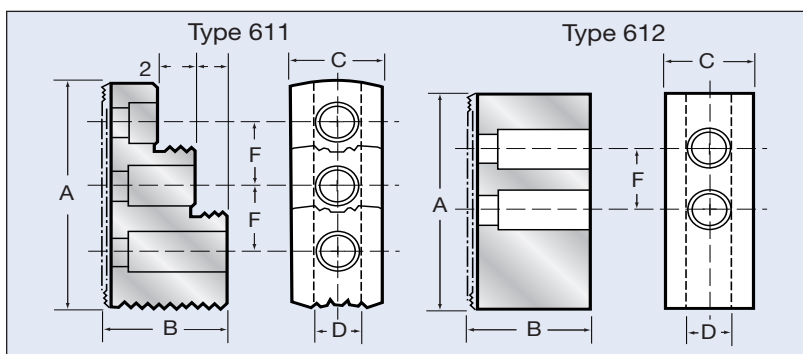
This unit is essential in order to operate MK3 self-contained power chucks. It is designed to be interlocked with the machine spindle so that the chuck cannot be actuated while the spindle is under power. Care must be taken not to actuate the chuck while the spindle is decelerating.

Units are supplied complete with pressure gage, pressure regulator, oil mist lubricator, air filter and lines with fittings.

Unit is operated by air and 110 volt/60 cycle (24 volt DC on request).



## Top Jaws for MK3 Self-Contained Chucks - 1/16" x 90° Serrations



**Type 611** - Hardened and ground reversible jaws with serrated gripping faces. (supplied in sets of 3 for 3 jaw chucks only)

**Type 612** - Soft blank jaws, case hardening quality steel. (supplied as single units only)

### Dimensional Data

Chuck Size	Jaw Type	Part Number	A	B	C	D	F	Bolt Size	Step Height
6½"	611	8130-17611	2.56"	1.56"	1.18"	.475"	.67"	M8	.39"
6½"	612	8140-17512	2.75"	1.50"	1.25"	.475"	.787"	M8	-
8"/10"	611	8130-21611	3.00"	1.97"	1.57"	.670"	.75"	M12	.47"
8"/10"	612	2860-21512	3.50"	2.00"	1.50"	.670"	1.00"	M12	-
12"/14"	611	8130-31611	4.92"	2.36"	2.36"	.830"	1.25"	M16	.55"
12"/14"	612	2860-32512	4.50"	2.50"	2.00"	.830"	1.25"	M16	-





## ATL Series 3 Jaw Power Chuck

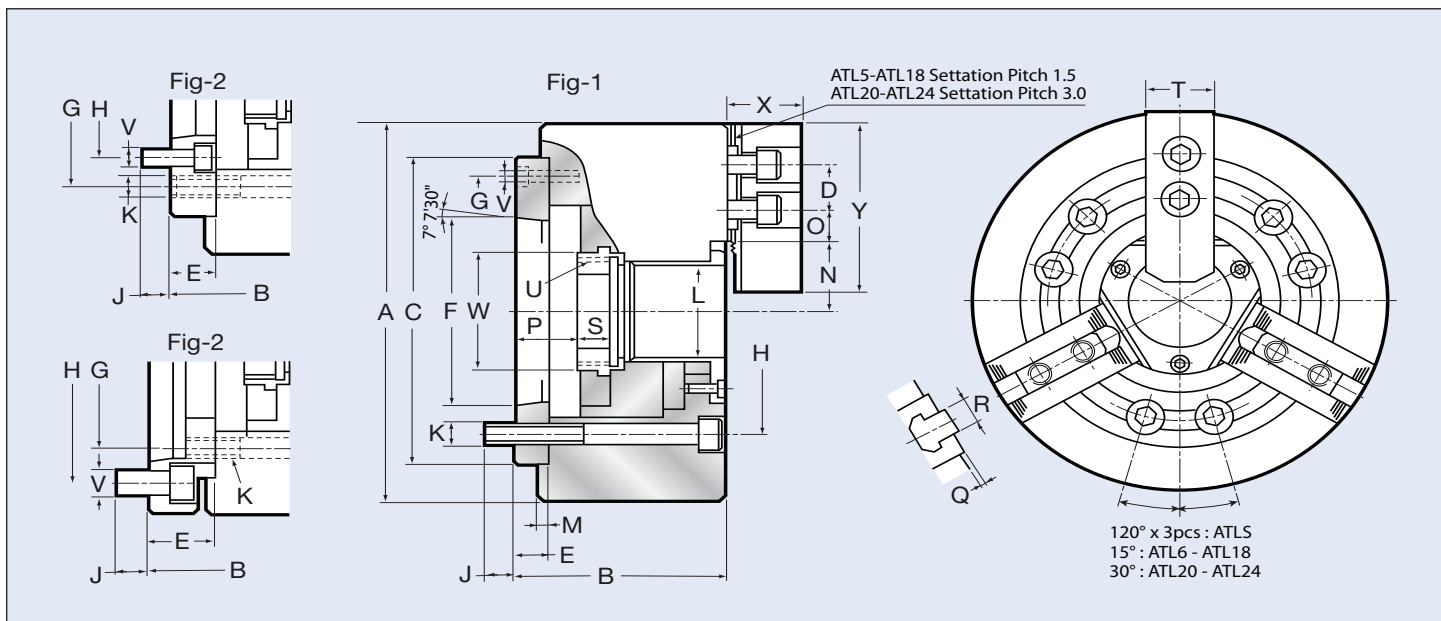
### 5" thru 24"

#### Direct replacement chucks for Kitagawa B200 Series

- ⚙ Easy retrofit
- ⚙ Interchangeable Top Tooling 1.5mm x 60° Serrations up to 18" sizes, 3mm x 60° Serrations 20" & 24" sizes
- ⚙ High speed
- ⚙ Full 2 year warranty parts and labor
- ⚙ Hardened jaw ways, master jaws and internal parts
- ⚙ Large thru-holes, plus Quick Change cover plate for closed center applications.
- ⚙ Chuck accuracy plus/minus .0005" repeatability
- ⚙ Great price and value

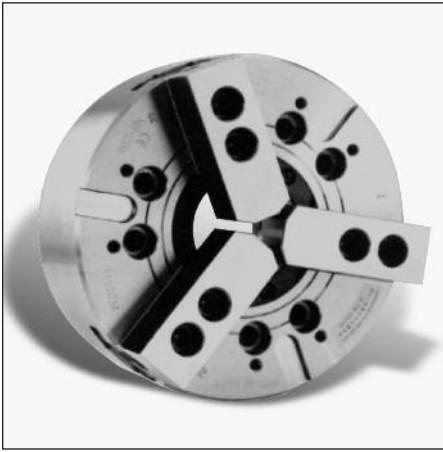
Model	Through Hole (in)	Plunger Stroke (in)	Jaw Stroke (Dia. in)	Max. Pull Force (lbf)	Max. Gripping Force (lbf)	Max. Speed (rpm)	Weight (lbs)	Moment of Inertia I (kg - m <sup>2</sup> )	Gripping O. D. Range (in)
ATL5-A5	1.30	.394	.2125	3925	8080	7000	20	0.023	.24-4.0
ATL6-A5	1.77	.472	.2165	4935	12790	6000	33	0.062	.59-5.0
ATL6-A6	1.77	.472	.2165	4935	12790	6000	38	0.073	.59-5.0
ATL8-A5	2.07	.630	.2913	7830	19970	5000	57	0.190	.79-6.16
ATL8-A6	2.07	.630	.2913	7830	19970	5000	55	0.184	.79-6.16
ATL8-A8	2.07	.630	.2913	7830	19970	5000	65	0.217	.79-6.16
ATL10-A6	2.95	.748	.3464	9659	24902	4200	90	0.370	.98-8.0
ATL10-A8	2.95	.748	.3464	9650	24902	4200	84	0.340	.98-8.0
ATL12-A6	3.58	.905	.4173	12790	32978	3300	138	0.809	1.18-10.0
ATL12-A8	3.58	.905	.4173	12790	32978	3300	131	0.770	1.18-10.0
ATL12-A11	3.58	.905	.4173	12790	32978	3300	154	0.912	1.18-10.0
ATL15-A8	4.62	.905	.4173	15930	40382	2500	276	2.255	1.96-13.0
ATL15-A11	4.62	.905	.4173	15930	40382	2500	260	2.241	1.96-13.0
ATL18-A8	4.62	.905	.4173	15930	40382	2000	322	3.961	1.96-16.0
ATL18-A11	4.62	.905	.4173	15930	40382	2000	364	3.744	1.96-16.0
ATL18-A15	4.62	.905	.4173	15930	40382	2000	421	5.183	1.96-16.0
ATL20-A11	7.08	.905	.4173	20190	52495	1800	173	7.355	4.72-18.0
ATL20-A15	7.08	.905	.4173	20190	52495	1800	445	6.910	4.72-18.0
ATL24-A11	8.07	1.023	.4724	20190	52495	1400	732	18.199	5.90-22.0
ATL24-A15	8.07	1.023	.4724	20190	52495	1400	699	17.376	5.90-22.0
ATL24-A20	8.07	1.023	.4724	20190	52495	1400	630	15.677	5.90-22.0

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



**Dimensional Data (in inch)**

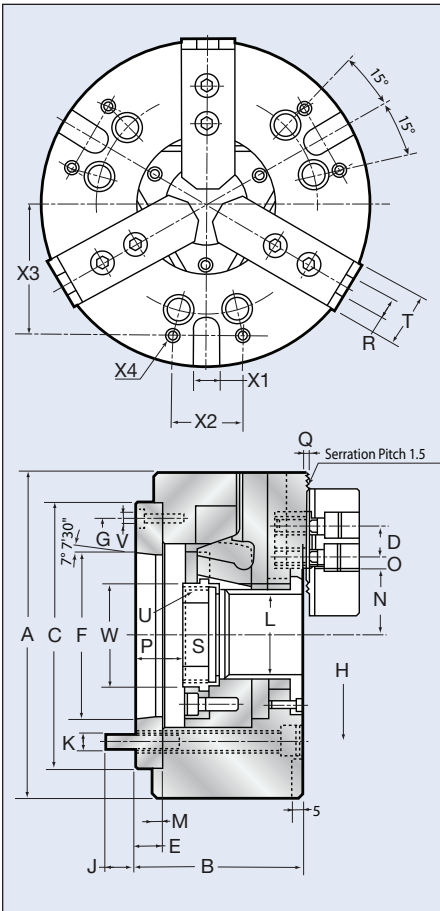
Model	A	B	C H6	D	E	F	G	H	J	K	L	M	N Max.	O Max.	O Min.	P Max.	P Min.	Q	R	S	T	U Max.	V	W	X	Y	Ref.
ATL5-A5	5.31	3.46	4.33	.551	1.260	3.250	3.250	4.125	.551	3-M10	1.30	.157	1.043	.777	.305	1.30	.905	.079	.393	.787	.984	M40x1.5	6-M10	1.771	1.220	2.126	Fig-3
ATL6-A5	6.65	3.58	5.51	.787	.590	3.250	4.566	4.125	.629	6-M10	1.77	.197	1.260	.895	.364	1.023	.551	.079	.472	.748	1.220	M55x2	3-M6	2.362	1.456	2.874	Fig-1
ATL6-A6	6.65	4.37	5.51	.787	1.378	4.187	4.125	5.250	.629	6-M10	1.77	.197	1.260	.895	.364	1.811	1.338	.079	.472	.748	1.220	M55x2	6-M12	2.362	1.456	2.874	Fig-3
ATL8-A5	8.27	4.29	6.69	.984	.905	3.250	5.250	4.125	.512	6-M12	2.05	.197	1.523	1.171	.462	1.476	.846	.079	.551	.807	1.378	M60x2	6-M10	2.598	1.496	3.740	Fig-2
ATL8-A6	8.27	4.05	6.69	.984	.669	4.187	5.905	5.250	.708	6-M12	2.05	.197	1.523	1.171	.462	1.240	.610	.079	.551	.807	1.378	M60x2	3-M6	2.598	1.496	3.740	Fig-1
ATL8-A8	8.27	4.96	6.69	.984	1.575	5.50	5.205	6.750	.945	6-M12	2.05	.197	1.523	1.171	.462	2.145	1.515	.079	.551	.807	1.378	M60x2	6-M16	2.598	1.496	3.740	Fig-3
ATL10-A6	10.0	4.721	8.66	1.181	.987	4.187	6.750	5.250	.708	6-M16	2.95	.197	2.007	1.328	.561	1.318	.571	.079	.630	.984	1.575	M85x2	6-M12	3.70	1.693	4.338	Fig-2
ATL10-A8	10.0	4.45	8.66	1.181	.708	5.507	7.480	6.750	.945	6-M16	2.95	.197	2.007	1.328	.561	1.043	.295	.079	.630	.984	1.575	M85x2	3-M8	3.70	1.693	4.338	Fig-1
ATL12-A6	11.96	5.08	8.66	1.181	.987	4.187	6.750	5.250	.708	6-M16	3.58	.236	2.413	1.801	.620	1.30	.394	.079	.826	1.102	1.968	M100x2	6-M12	4.252	2.009	5.118	Fig-2
ATL12-A8	11.96	4.80	8.66	1.181	.708	5.50	7.480	6.750	.984	6-M16	3.58	.236	2.413	1.801	.620	1.023	.118	.079	.826	1.102	1.968	M100x2	3-M8	4.252	2.009	5.118	Fig-1
ATL12-A11	11.96	6.06	8.66	1.181	1.968	7.750	6.750	9.252	1.102	6-M16	3.584	.236	2.413	1.801	.620	2.283	1.378	.079	.826	1.102	1.968	M100x2	6-M20	4.252	2.009	5.118	Fig-3
ATL15-A8	15.0	6.30	11.81	1.692	1.299	5.50	9.252	6.780	.945	6-M20	4.62	.236	3.228	1.801	.620	1.575	.669	.197	.866	1.693	2.441	M130x2	6-M16	5.472	2.598	6.496	Fig-2
ATL15-A11	15.0	5.86	11.81	1.692	.866	7.750	10.236	9.252	1.102	6-M20	4.62	.236	3.228	1.801	.620	1.141	.236	.197	.866	1.693	2.441	M130x2	6-M20	5.472	2.598	6.496	Fig-1
ATL18-A8	17.72	6.30	11.81	1.692	1.299	5.50	9.252	6.750	.945	6-M20	4.62	.236	3.228	3.139	.620	1.578	.236	.197	.866	1.693	2.441	M130x2	6-M16	5.472	2.598	6.496	Fig-2
ATL18-A11	17.72	5.86	11.81	1.692	.866	7.750	10.236	9.252	1.102	6-M20	4.62	.236	3.228	3.139	.620	1.141	.236	.197	.866	1.693	2.441	M130x2	3-M10	5.472	2.598	6.496	Fig-1
ATL18-A15	17.72	7.24	11.81	1.692	2.244	11.250	9.252	13.00	.945	6-M20	4.62	.236	3.228	3.139	.620	2.578	1.614	.197	.866	1.693	2.441	M130x2	6-M24	5.472	2.598	6.496	Fig-3
ATL20-0A11	20.0	6.65	14.96	2.362	1.614	7.750	13.00	9.252	1.181	6-M24	7.08	.236	4.429	2.381	.964	2.047	1.141	.197	.984	1.496	2.559	M190x2	6-M20	8.110	2.874	7.086	Fig-2
ATL20-A15	20.0	6.10	14.96	2.362	1.062	11.250	13.00	13.00	1.299	6-M24	7.08	.236	4.429	2.381	.964	1.496	.590	.197	.984	1.496	2.559	M190x2	6-M12	8.110	2.874	7.086	Fig-1
ATL24-A11	24.01	7.32	20.47	2.362	1.771	7.750	18.251	9.252	1.102	6-M24	8.07	.236	5.507	3.445	.964	2.401	1.378	.197	.984	1.496	2.559	M215x2	6-M20	9.055	2.874	7.086	Fig-2
ATL24-A15	24.01	7.20	20.47	2.362	1.653	11.250	18.251	13.00	1.299	6-M24	8.07	.236	5.507	3.445	.964	2.283	1.259	.197	.984	1.496	2.559	M215x2	6-M24	9.055	2.874	7.086	Fig-2
ATL24-A20	24.01	6.53	20.47	2.362	.984	16.250	18.251	18.252	1.299	6-M24	8.07	.236	5.507	3.445	.964	1.614	.590	.197	.984	1.496	2.559	M215x2	3-M10	9.055	2.874	7.086	Fig-1



# King Bore 3 Jaw Power Chuck

## ATLB Series 6" thru 18"

- ⚙ Super large thru-hole
- ⚙ Easy Retrofit
- ⚙ Interchangeable Top Tooling 1.5mm x 60° serrations
- ⚙ High speed
- ⚙ Full 2 year warranty parts and labor
- ⚙ Hardened jaw ways, master jaws and internal parts
- ⚙ Quick Change cover plate for closed center applications.
- ⚙ Chuck accuracy plus/minus .0005" repeatability



MODEL	ATLB6-A5	ATLB8-A5/A6	ATLB10-A6/A8	ATLB12-A8/A11	ATLB15-A11/A15	ATLB18-A11/A15
Through-Hole (in)	2.047	2.598	3.071	4.803	5.590	6.555
Plunge Stroke (in)	.472	.630	.748	.905	.905	.905
Jaw Stroke (in)	.212	.291	.346	.413	.413	.413
Pull Force (lbf)	7974	7828	9647	12788	15928	15928
Grip Force (lbf)	12788	19965	24902	32978	40381	40381
Oper. Pressure (psi)	262	292	392	292	363	363
Max. Speed (rpm)	6000	5000	4200	3200	2500	2000
Weight (lbs)	31	53	83	144	287	355
Mount of Inertia (kg-m <sup>2</sup> )	0.16	0.14	0.4	0.95	3.0	4.77
Grip O.D. Range (in)	.63-5.0	.78-6.25	.98-8.25	1.61-10.75	2.36-14.0	2.95-16.0

### Dimensional Data

Model	A	B	C H6	D	E	F	G	H	J	K	L	M	N Max.	O Max.	O Min.	P Max.	P Min.	Q	R	S	T	U Max.	V	W	X1 (H12)	X2	X3	X4
ATLB6-A5	6.69	3.58	5.51	.787	.590	3.250	4.566	4.125	.570	6xM10	2.04	.197	1.350	.718	.364	1.023	.551	.079	.472	.787	1.260	M60x2	3xM6	2.559	.630	1.417	2.559	M8
ATLB8-A6	8.26	4.05	6.69	.984	.669	4.188	5.905	5.250	.767	6xM12	2.59	.197	1.653	.935	.462	1.240	.610	.079	.551	.787	1.456	M74x2	3xM6	3.149	.630	1.771	3.149	M8
ATLB10-A8	10.0	4.45	8.66	1.181	.708	5.50	7.480	6.750	.944	6xM16	3.07	.197	2.086	1.328	.561	1.043	.295	.079	.630	.984	1.653	M87x2	3xM8	3.701	.630	2.362	4.016	M10
ATLB12-A11	12.40	5.27	11.81	1.181	.866	7.716	10.236	9.252	1.102	6xM20	4.80	.236	2.921	1.427	.501	1.653	.748	.079	.827	1.102	2.047	M135x2	3xM10	5.630	.787	2.362	5.433	M10
ATLB15-A11	15.94	6.06	14.96	1.692	1.063	11.25	13.00	13.00	1.299	6xM24	5.59	.236	3.681	1.781	.600	1.338	.433	.197	.866	1.693	2.441	M155x2	3xM12	6.456	.787	3.149	6.30	M12
ATLB20-A15	18.0	6.06	14.96	1.692	1.063	11.25	13.00	3.30	1.299	3xM24	6.65	.236	3.807	2.490	.718	1.338	.433	.197	.866	1.693	2.441	M180x3	3xM12	7.440	.787	3.937	6.30	M12

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



## Front-Mount Hydraulic 3-Jaw Chucks

For use on machines with hydraulic ports in the spindle nose.

- Ⓜ One Year Warranty
- Ⓜ Hardened Steel Body
- Ⓜ Sizes 8", 10" and 12"
- Ⓜ Large Thru-Hole
- Ⓜ No Draw Tube Required
- Ⓜ .001" T.I.R. Repeatability on Duplicate Parts
- Ⓜ High RPM Ability
- Ⓜ Collet Pad Facility for Bar Work
- Ⓜ Totally Self - Lubricating
- Ⓜ Mechanically Self-Locking - No Hydraulic Check Valves Necessary
- Ⓜ Hydraulic Cylinder and Actuator are Integrated
- Ⓜ Direct Mount to Type "A" Spindles
- Ⓜ Acme, Tongue & Groove, and 1/16" by 90° Base Jaws Available
- Ⓜ Quick-Change Base Jaws Available
- Ⓜ **2-JAW MODELS** Available On Request

### Dimensional and Performance Data

Part No.	1749-02400	1749-02410 <sup>①</sup>	1749-02420 <sup>①</sup>
Body Diameter	8.25"	10.0"	12.0"
Body Width	5.35"	5.91"	6.93"
Tooling Height*	5.47"	6.02"	7.05"
Thru-Hole	2.06"	2.55"***	3.18"***
Movement Per Jaw	.200"	.236"	.280"
Max. RPM	4750	4050	3800
Total Static Grip	24,750	34,500	51,000
Max. Hydraulic Pressure	550 psi	550 psi	550 psi
Approx. Weight	64.5 lbs	104 lbs	170 lbs

\*May vary slightly depending on the style of Base Jaw required.

\*\*Special thru-holes available: 3-1/16" for 10" chuck; 4" for 12" chuck.



### Mounting Plates for Stationary Front Mount Hydraulic 3-Jaw Chucks

Easy retrofit No Draw Tube Required

Chuck Size	Chuck Model No.	Mounting Plate Diameter
8"	7749-21000	12"
10"	7749-26000	14"
12"	7749-31000	16"

**NOTE:** As shown in photo at left, flanged base plate is supplied less slots or mounting holes. PBA can machine as required for an additional charge. For dimensional and performance data, reference the above.

<sup>①</sup> Chuck numbers shown are for Cincinnati machines with 2 hydraulic ports in spindle. Consult factory for part number of 4-port spindle designs.

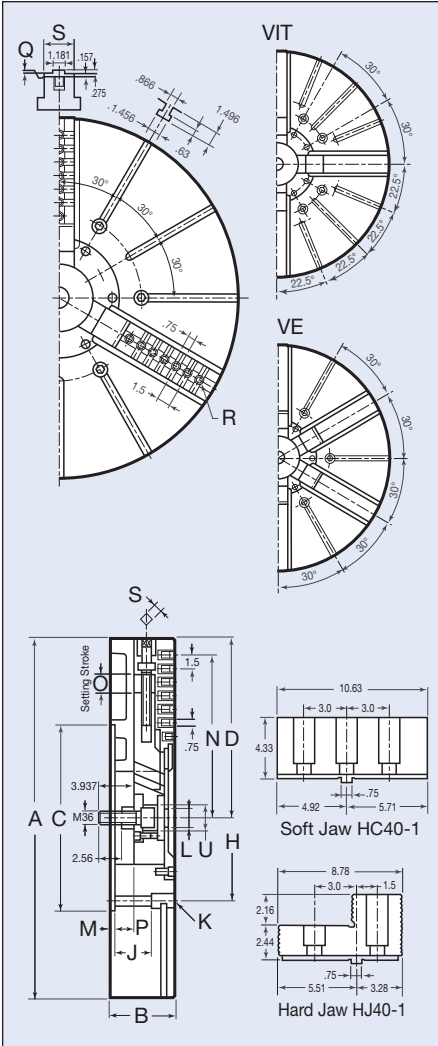
HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.



# Large Closed Center Adjustable Jaw Power Chucks for Vertical and Horizontal Lathes

40 - 79 inches

- ⚙ Ideal for Large vertical and Horizontal Lathe applications
- ⚙ Universal Wedge Design with manually adjustable Master Jaws
- ⚙ Available in 3, 4 and 6-Jaw configurations
- ⚙ Sealed front Master Jaw design for Vertical Use
- ⚙ High Speed Design
- ⚙ Available Mountings Straight Recess and 'A' Type Spindles
- ⚙ Contact Factory for application expertise and quotation



MODEL	V-240	VIT-240	V-250	VIT-250	VE-250	VIT-263	VE-263	VE-279
Number of Jaws	3	4	3	4	6	4	6	6
Plunge Stroke (in)	2.244	2.244	2.244	2.244	2.244	2.362	2.362	2.362
Radial Jaw Stroke (+ Manual Setting) (in)	.90+1.18	.90+1.18	.90+1.18	.90+1.18	.90+1.18	1.34+1.57	1.34+1.57	1.34+1.57
Pull Force (lbf)	40465	40465	40465	40465	40465	44961	44961	44961
Grip Force (lbf)	71938	71938	71938	71938	71938	80931	80931	80931
Oper. Pressure (psi)	610	610	610	610	610	670	670	670
Max. Speed (rpm)	630	550	500	400	360	300	280	230
Weight (lbs)	1422	1544	1962	2073	2140	3748	3969	6284
Mount of Inertia (kg-m <sup>2</sup> )	82	89	168	177	183	518	548	1350
Matching Cylinder	ALT250C	ALT250C	ALT250C	ALT250C	ALT250C	ALT250C	ALT250C	ALT250C
Grip O.D. Range (in)	11.22-38	11.22-38	10.63-47	10.63-47	10.63-47	15.35-61	15.35-61	17.32-76

## Dimensional Data (in inch)

Model	A	B	C	D Max	H	J	K	L	M	N Max.	O	P Max.	P Min.	Q	R	S	T	U
40" V/VIT-240	39.56	7.086	20.47	19.76	18.25	4.25	M24	M52x1.5	.315	17.992	1.181	2.323	.078	.157	7-M24	.748	3.346	2.834
50" V/VIT/VE-250	49.21	7.068	20.47	24.53	18.25	4.25	M24	M52x1.5	.315	22.165	1.181	2.323	.078	.157	10-M24	.748	3.346	2.834
63" VIT/VE-263	63.0	8.661	28.34	31.34	25.49	5.67	M30	M52x1.5	.315	29.055	1.575	3.228	.866	.236	13-M24	.866	4.331	2.834
79" VE-279	78.74	9.37	28.34	39.21	25.49	5.67	M30	M52x1.5	.315	35.984	1.575	3.937	.866	.236	17-M24	.866	4.331	2.834

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# 3 Jaw Wedge Type Closed Center Power Chuck

## PA 18" - 63" Large Diameter Chucks

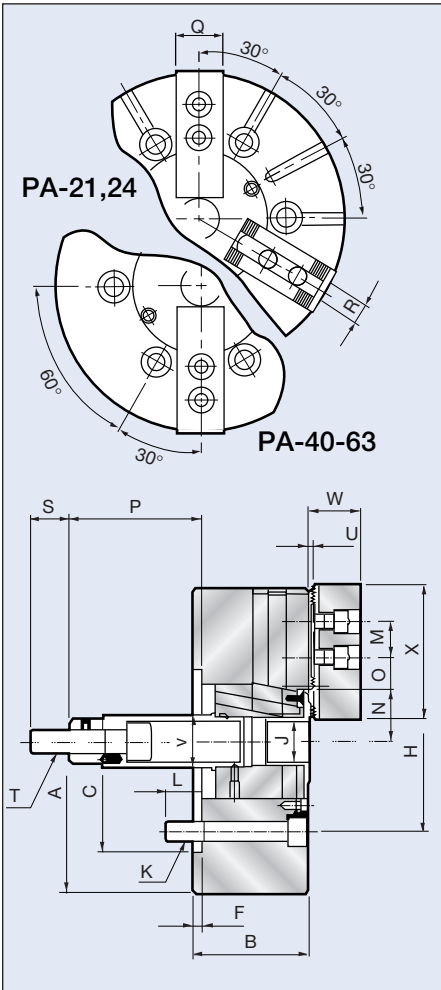
- ⚙ All steel body
- ⚙ Standard 3 jaw closed center wedge chuck for general machining
- ⚙ Hardened jaw ways and all internal parts
- ⚙ Standard metric serrations 3.0mm serration pitch

Model No.	Mount Width*	Jaw Stroke Dia	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt lbs
				Max	Min				
PA18-A11	1.06"	.630"	1.378"	17.71"	5.19"	18,400	55,977	2710	274
PA21-A11	1.06"	.630"	1.378"	20.87"	2.68"	18,400	61,350	1940	367
PA24-A11	1.06"	.630"	1.378"	24.02"	5.98"	18,400	61,350	1760	492
PA24-A15	1.06"	.630"	1.378"	24.02"	5.98"	18,400	61,350	1760	492
PA28-A11	1.06"	.630"	1.378"	27.95"	1.37"	18,400	61,350	1200	617
PA28-A15	1.06"	.630"	1.378"	27.95"	1.37"	18,400	61,350	1200	617
PA32-A11	1.06"	.787"	1.496"	31.49"	7.08"	22,500	53,900	900	705
PA32-A15	1.06"	.787"	1.496"	31.49"	7.08"	22,500	53,900	900	705
PA40-A11	1.06"	1.181"	2.244"	39.37"	11.42"	40,450	89,900	500	1,323
PA40-A15	1.06"	1.181"	2.244"	39.37"	11.42"	40,450	89,900	500	1,323
PA40-A20	1.06"	1.181"	2.244"	39.37"	11.42"	40,450	89,900	500	1,323
PA50	1.06"	1.181"	2.244"	49.21"	11.42"	40,450	89,900	450	1,763
PA55	1.06"	1.181"	2.244"	53.12"	11.42"	40,450	89,900	400	2,425
PA63	1.06"	1.181"	2.244"	62.99"	11.42"	40,450	89,900	350	3,307

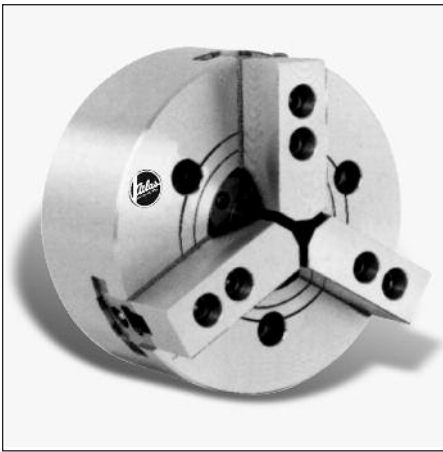
\*Add to dimension B for total width

### Dimensional Data (in inch)

Model	PA-18	PA-21	PA-24	PA-28	PA-32	PA-40	PA-50	PA-55	PA-63
A	17.71	20.87	24	27.95	31.49	39.37	49.21	55	63
B	4.48	4.92	4.92	5.90	5.90	7.09	7.09	7.8	7.8
C	11.81	14.96	14.96	14.96	14.96	20.47	20.47	28.35	28.35
F	.236	.236	.236	.236	.236	.314	.314	.314	.314
H	9.25	13.0	13.0	13.0	13.0	18.25	18.25	25.5	25.5
J	-	-	-	-	-	-	-	-	-
K	6-M20	6-M22	6-M22	6-M22	6-M24	6-M24	6-M24	6-M24	6-M24
L	1.18	1.22	1.22	1.22	1.38	1.38	1.38	1.38	1.38
M	1.69	2.36	2.36	2.36	2.99	3.94	3.94	3.94	3.94
N max.	4.25	3.38	4.92	3.86	3.91	5.77	5.77	5.77	5.77
N min.	3.93	3.07	4.61	3.46	3.52	5.18	5.18	5.18	5.18
O max.	1.98	3.68	3.68	5.63	7.08	8.86	9.25	16.73	20.67
O min.	.91	.96	.96	1.18	1.18	1.18	1.18	1.18	1.18
P max.	3.62	3.82	3.82	1.37	1.10	1.38	1.38	1.38	1.38
P min.	.88	2.44	2.44	-.118	-.39	-.87	-.87	-.87	-.87
Q	1.97	2.56	2.56	2.95	2.95	3.35	3.35	3.35	3.35
R	1.00	.984	.984	9.84	1.00	.984	.984	.984	.984
S	2.16	2.165	2.17	2.56	2.36	2.539	2.559	2.559	2.559
T	M30x3.5	M30x3.5	M30x3.5	M30x3.5	M30x3.5	M36x4.0	M36x4.0	M36x4.0	M36x4.0
U	.078	.118	.118	.354	.236	-.159	-.159	-.159	-.159
V	2.36	2.36	2.36	-	-	-	-	-	-
W	2.40	2.8	2.8	2.95	3.19	4.17	4.17	4.17	4.17
X	5.31	7.09	7.09	6.30	6.30	7.87	7.87	7.87	7.87



HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# 3 Jaw Open Center 'Long Stroke' Power Chuck

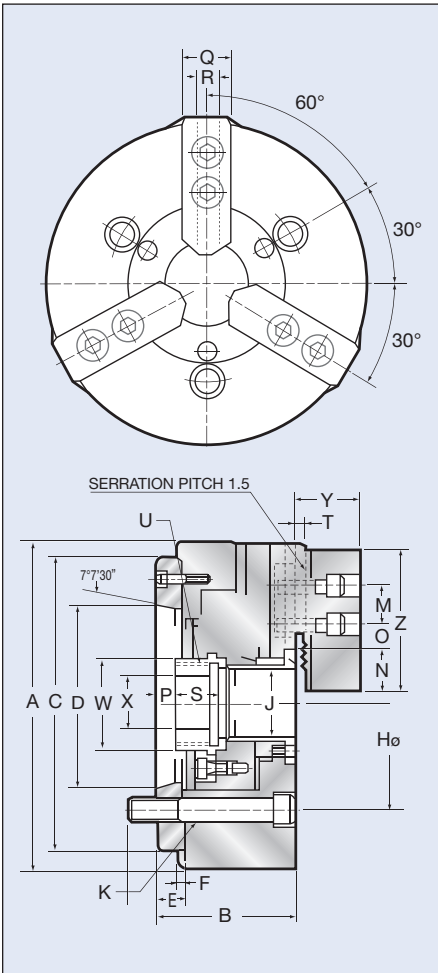
## ALS 6" - 12" Chucks

- ⚙️ Extended jaw stroke
- ⚙️ ± .0005 repeatability
- ⚙️ 1.5mm x 60° master jaws
- ⚙️ All steel body
- ⚙️ Hardened jaw ways, master jaws and internal parts
- ⚙️ Open center

Model No.	Thru Hole Dia	Jaw Stroke Dia	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt lbs
				Max	Min				
ALS6-A5 (D)	1.102"	.787"	.590"	6.49"	1.102"	6,272	7,015	4500	31
ALS8-A6 (D)	1.771"	.984"	.748"	8.46"	1.259"	9,239	11,016	3300	55
ALS8-A8 (I)	1.771"	.984"	.748"	8.46"	1.259"	9,239	11,016	3300	55
ALS10-A6 (I)	2.086"	1.181"	.866"	10.00"	1.653"	12,094	14,169	3000	99
ALS10-A8 (D)	2.086"	1.181"	.866"	10.00"	1.653"	12,094	14,169	3000	99
ALS12-A6 (I)	2.480"	1.377"	.984"	11.96"	1.692"	15,579	18,075	2200	172
ALS12-A8 (D)	2.480"	1.377"	.984"	11.96"	1.692"	15,579	18,075	2200	172
ALS12-A11 (I)	2.480"	1.377"	.984"	11.96"	1.692"	15,579	18,075	2200	172

(I) Indirect mount (D) Direct mount

### Dimensional Data (in inch)



MODEL	ALS6-A5	ALS8-A6	ALS8-A8	ALS10-A6	ALS10-A8	ALS12-A6	ALS12-A8	ALS12-A11
A	6.65	8.46	8.46	10.00	10.00	11.97	11.97	11.97
B	5.91	6.69	7.17	5.20	5.24	9.45	9.17	9.33
C	5.512	6.693	6.693	8.661	8.661	8.661	8.661	8.661
D	3.250	4.188	5.501	4.188	5.501	4.188	5.501	7.751
E	.622	.699	.738	1.014	.738	.945	.669	.827
F	.197	.197	.197	.197	.197	.197	.197	.197
H	4.126	5.252	6.748	5.252	6.748	5.252	6.748	9.250
J	1.102	1.771	1.771	2.086	2.086	2.480	2.480	2.480
K	M10	M12	M16	M12	M16	M12	M16	M20
M	.787	.984	.984	1.181	1.181	1.181	1.181	1.181
N max.	1.545	2.086	2.086	2.460	2.460	2.933	2.933	2.933
N min.	1.151	1.594	1.594	1.870	1.870	1.244	1.244	1.244
O max.	.659	.817	.817	1.053	1.053	1.505	1.505	1.505
O min.	.364	.462	.462	.443	.443	.502	.502	.502
P max.	.394	.118	.118	.236	.236	.323	.323	.323
P min.	.197	-.630	-.630	-1.102	-1.102	-.661	-.661	-.661
Q	1.023	1.378	1.378	1.575	1.575	1.969	1.969	1.969
R	.472	.551	.551	.630	.630	.826	.826	.826
S	.945	1.260	1.260	1.575	1.575	1.496	1.496	1.496
T	.079	.079	.079	.079	.079	.118	.118	.118
U max.	M38x1.5	M55x2.0	M55x2.0	M65x2.0	M65x2.0	M75x2.0	M75x2.0	M75x2.0
W	1.771	2.560	2.560	2.874	2.874	3.268	3.268	3.268
X	.787	1.181	1.181	1.771	1.771	1.968	1.968	1.968
Y	1.141	1.535	1.535	1.693	1.693	2.047	2.047	2.047
Z	2.598	3.740	3.740	4.331	4.331	4.370	4.370	4.370

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

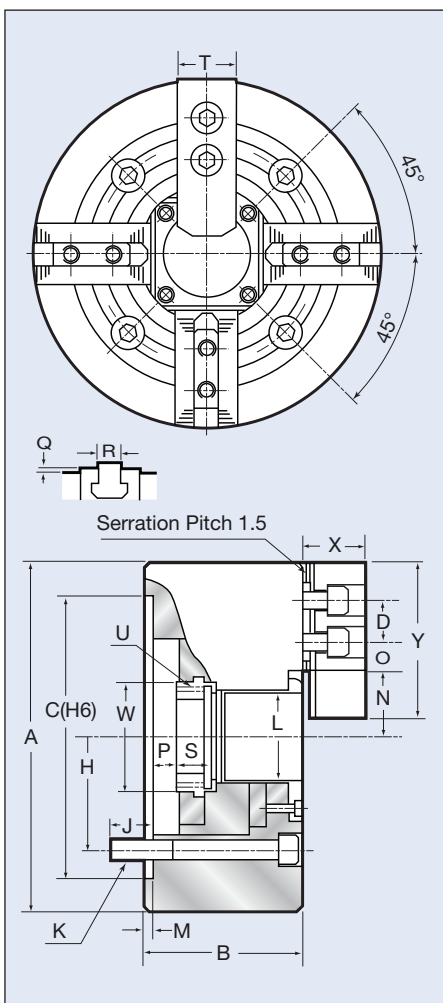


# 4 Jaw Universal Power Chuck

## 4ATL 6", 8", 10", 12", 15", 18" & 24" Chucks

- ⚙ All steel body
- ⚙ Hardened jaw way and internal parts
- ⚙ ± .0005 repeatability
- ⚙ 1.5mm x 60° master jaws
- ⚙ 4-Jaw universal design

Model No.	Through Hole	Plunger Stroke	Jaw Stroke	Max Draw Bar Pull Force lb/f	Max. Gripping Force lb/fi	Max RPM <sup>®</sup>	Wt lbs	Moment of Inertia I (kg-m <sup>2</sup> )
4ATL6-A5	1.771"	.472"	.216"	4,945	12,813	4500	30	0.058
4ATL8-A5	2.047"	.629"	.291"	7,844	20,007	3600	53	0.177
4ATL8-A6	2.047"	.629"	.291"	7,844	20,007	3600	53	0.177
4ATL10-A6	2.952"	.748"	.346"	9,667	24,932	3200	79	0.324
4ATL10-A8	2.952"	.748"	.346"	9,667	24,932	3200	79	0.324
4ATL12-A6	3.582"	.905"	.417"	12,813	33,047	2700	129	0.763
4ATL12-A8	3.582"	.905"	.417"	12,813	33,047	2700	129	0.763
4ATL12-A11	3.582"	.905"	.417"	12,813	33,047	2700	129	0.763
4ATL15-A8	4.625"	.905"	.417"	15,961	40,405	1900	251	2.331
4ATL15-A11	4.625"	.905"	.417"	15,961	40,405	1900	251	2.331
4ATL18-A8	4.625"	.905"	.417"	15,961	40,405	1500	269	3.798
4ATL18-A11	4.625"	.905"	.417"	15,961	40,405	1500	269	3.798
4ATL24-A11	8.070"	1.023"	.472"	20,232	52,604	1000	582	15.20
4ATL24-A15	8.070"	1.023"	.472"	20,232	52,604	1000	582	15.20

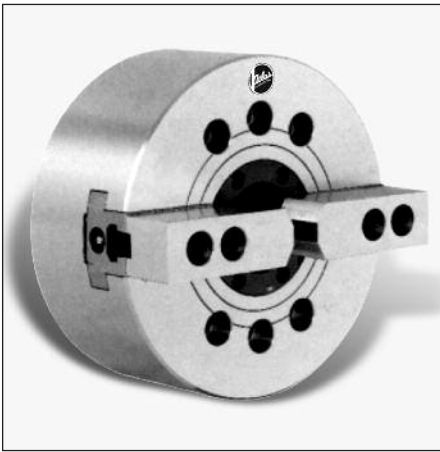


### Dimensional Data (in inch)

MODEL	4ATL6	4ATL8	4ATL10	4ATL12	4ATL15	4ATL18	4ATL24
A	6.65	8.26	10	11.96	15	17.71	24
B	3.18	3.58	3.93	4.33	5.23	5.23	5.78
C (H6)	5.51	6.69	8.66	8.66	11.81	11.81	20.47
D	.787	.984	1.181	1.181	1.692	1.692	2.362
H	4.125	5.25	6.75	6.75	9.251	9.251	18.251
J	.629	.787	.866	.905	1.377	1.377	1.377
K	4-M10x80	4-M12x90	4-M16x100	4-M16x110	4-M20x135	4-M20x135	8-M24x150
L	1.771	2.047	2.952	3.582	4.625	4.625	8.070
M	.196	.196	.196	.236	.236	.236	.236
N max.	1.259	1.523	2.007	2.413	3.22	3.22	5.507
O max.	.895	1.171	1.328	1.801	1.781	3.139	3.444
min	.364	.580	.561	.620	.600	.600	.945
P max.	.433	.570	.334	.314	.275	.275	.630
min	-.039	-.059	-.413	-.590	-.630	-.630	-.393
Q	.078	.078	.078	.078	.196	.196	.196
R	.472	.551	.629	.826	.866	.866	.984
S	.748	.807	.984	1.102	1.692	1.162	1.496
T	1.220	1.377	1.574	1.968	2.440	2.440	2.559
U max	M55x2	M60x2	M85x2	M100x2	M130x2	M130x2	M215x3
W	2.362	2.598	3.700	4.251	5.472	5.472	9.055
X	1.456	1.496	1.692	2.007	2.598	2.598	2.874
Y	2.874	3.740	4.330	5.118	6.496	6.496	7.086

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.





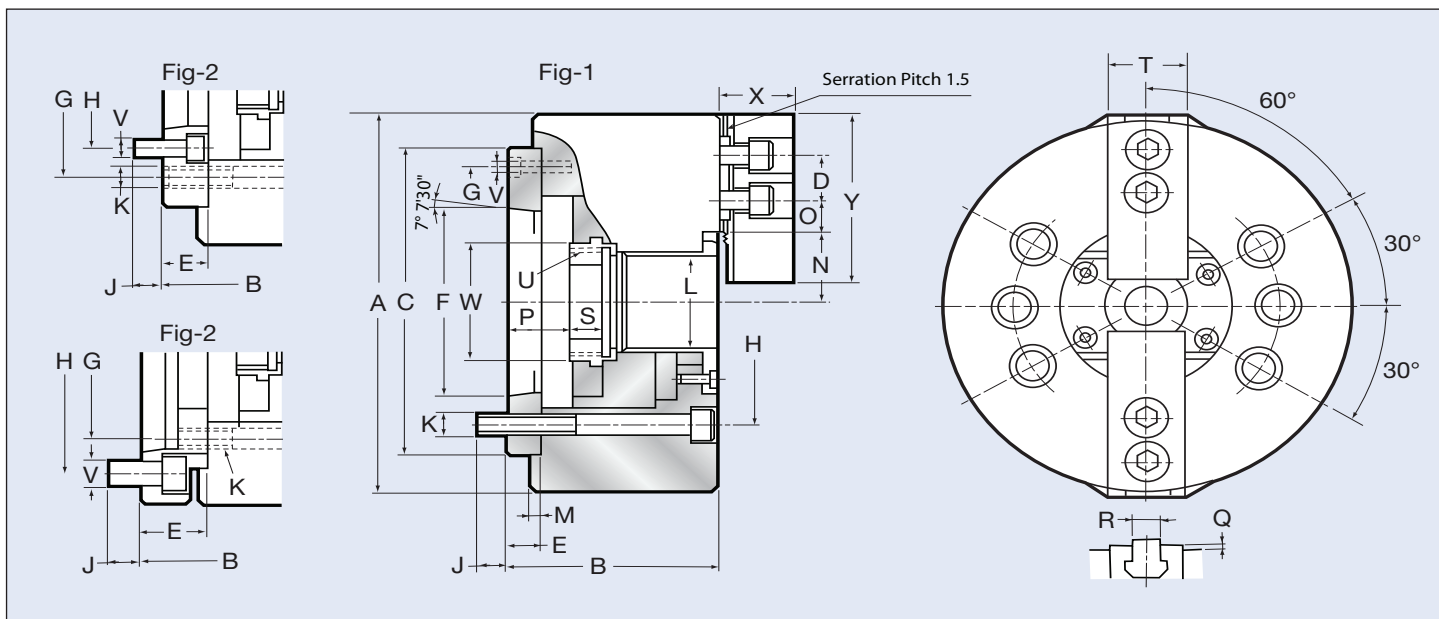
## 2 Jaw High Speed Open Center Power Chuck

### 2ATL 6" - 12" Chucks

- ⚙️ 1.5mm x 60° master jaw
- ⚙️ Repeatability  $\pm .0005"$
- ⚙️ Large thru-hole
- ⚙️ Hardened jaw ways and all internal parts
- ⚙️ All steel body
- ⚙️ High RPM

Model	Through Hole (in)	Plunger Stroke (in)	Jaw Stroke (Dia. in)	Max. Pull Force (lbf)	Max. Gripping Force (lbf)	Max. Speed (rpm)	Weight (lbs)	Moment of Inertia I (kg - m <sup>2</sup> )	Gripping O. D. Range (in)
2ATL6-A5	1.77	.472	.2165	4935	12790	6000	33	0.062	.59-5.0
2ATL8-A5	2.07	.630	.2913	7830	19970	5000	57	0.190	.79-7.0
2ATL8-A6	2.07	.630	.2913	7830	19970	5000	55	0.184	.79-7.0
2ATL10-A6	2.95	.748	.3464	9659	24902	4200	90	0.370	.98-8.25
2ATL10-A8	2.95	.748	.3464	9650	24902	4200	84	0.340	.98-8.25
2ATL12-A6	3.58	.905	.4173	12790	32978	3300	138	0.809	1.18-10.0
2ATL12-A8	3.58	.905	.4173	12790	32978	3300	131	0.770	1.18-10.0
2ATL12-A11	3.58	.905	.4173	12790	32978	3300	154	0.912	1.18-10.0
2ATL15-A8	4.62	.905	.4173	15930	40382	2500	276	2.255	1.96-13.0
2ATL15-A11	4.62	.905	.4173	15930	40382	2500	260	2.241	1.96-13.0
2ATL18-A11	4.62	.905	.4173	15930	40382	2000	364	3.744	1.96-16.0
2ATL18-A15	4.62	.905	.4173	15930	40382	2000	421	5.183	1.96-16.0

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



### Dimensional Data (in inch)

Model	A	B	C H6	D	E	F	G	H	J	K	L	M	N Max.	O Max.	O Min.	P Max.	P Min.	Q	R	S	T	U Max.	V	W	X	Y	Ref.
2ATL6-A5	6.65	3.58	5.51	.787	.590	3.250	4.566	4.125	.629	3-M10	1.77	.197	1.260	.895	.364	1.023	.551	.079	.472	.748	1.220	M55x2	3-M6	2.362	1.456	2.874	Fig-1
2ATL8-A5	8.27	4.29	6.69	.984	.905	3.250	5.250	4.125	.512	3-M12	2.05	.197	1.523	1.171	.462	1.476	.846	.079	.551	.807	1.378	M60x2	6-M10	2.598	1.496	3.740	Fig-2
2ATL8-A6	8.27	4.05	6.69	.984	.669	4.187	5.905	5.250	.708	3-M12	2.05	.197	1.523	1.171	.462	1.240	.610	.079	.551	.807	1.378	M60x2	3-M6	2.598	1.496	3.740	Fig-1
2ATL10-A6	10.0	4.721	8.66	1.181	.987	4.187	6.750	5.250	.708	3-M16	2.95	.197	2.007	1.328	.561	1.318	.571	.079	.630	.984	1.575	M85x2	6-M12	3.70	1.693	4.338	Fig-2
2ATL10-A8	10.0	4.45	8.66	1.181	.708	5.507	7.480	6.750	.945	3-M16	2.95	.197	2.007	1.328	.561	1.043	.295	.079	.630	.984	1.575	M85x2	3-M8	3.70	1.693	4.338	Fig-1
2ATL12-A6	11.96	5.08	8.66	1.181	.987	4.187	6.750	5.250	.708	3-M16	3.58	.236	2.413	1.801	.620	1.30	.394	.079	.826	1.102	1.968	M100x2	6-M12	4.252	2.009	5.118	Fig-2
2ATL12-A8	11.96	4.80	8.66	1.181	.708	5.50	7.480	6.750	.984	3-M16	3.58	.236	2.413	1.801	.620	1.023	.118	.079	.826	1.102	1.968	M100x2	3-M8	4.252	2.009	5.118	Fig-1
2ATL12-A11	11.96	6.06	8.66	1.181	1.968	7.750	6.750	9.252	1.102	3-M16	3.584	.236	2.413	1.801	.620	2.283	1.378	.079	.826	1.102	1.968	M100x2	6-M20	4.252	2.009	5.118	Fig-3
2ATL15-A8	15.0	6.30	11.81	1.692	1.299	5.50	9.252	6.780	.945	3-M20	4.62	.236	3.228	1.801	.620	1.575	.669	.197	.866	1.693	2.441	M130x2	6-M16	5.472	2.598	6.496	Fig-2
2ATL15-A11	15.0	5.86	11.81	1.692	.866	7.750	10.236	9.252	1.102	3-M20	4.62	.236	3.228	1.801	.620	1.141	.236	.197	.866	1.693	2.441	M130x2	6-M20	5.472	2.598	6.496	Fig-1
2ATL18-A11	17.72	5.86	11.81	1.692	.866	7.750	10.236	9.252	1.102	3-M20	4.62	.236	3.228	3.139	.620	1.141	.236	.197	.866	1.693	2.441	M130x2	3-M10	5.472	2.598	6.496	Fig-1
2ATL18-A15	17.72	7.24	11.81	1.692	2.244	11.250	9.252	13.00	.945	3-M20	4.62	.236	3.228	3.139	.620	2.578	1.614	.197	.866	1.693	2.441	M130x2	6-M24	5.472	2.598	6.496	Fig-3

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# 2/3 Jaw Thru-Hole Power Chuck

## PAFH 8" - 24" Chucks

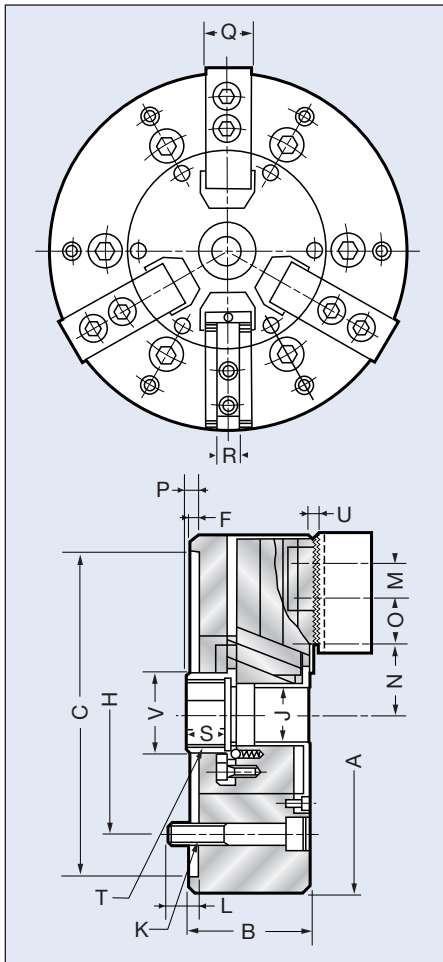
- ⚙ Used as 2 jaw or 3 Jaw Power Chuck
- ⚙ Thru-hole and long stroke
- ⚙ Adapter mounted
- ⚙ Serration Pitch 1.5mm 8", 10" & 12" - 3mm 15"
- ⚙ Larger diameters available

Model No.	Jaw Stroke Dia	Sleeve Stroke	Gripping Dia.		Maximum Pull		Max Grip		Max RPM	Wt lbs
			2 Jaw Max	3 Jaw Min	2 Jaw lbs	3 Jaw lbs	2 Jaw lbs	3 Jaw lbs		
PAFH8-A5	.378"	.709"	7.87	1.181	3,306	4,409	7,275	9,700	3000	44
PAFH8-A6	.378"	.709"	7.87	1.181	3,306	4,409	7,275	9,700	3000	44
PAFH10-A6	.728"	.984"	9.84	1.181	5,070	7,716	9,038	13,668	3000	70
PAFH10-A8	.728"	.984"	9.84	1.181	5,070	7,716	9,038	13,668	3000	70
PAFH12-A8	.803"	1.102"	11.81	1.967	6,613	9,920	11,684	17,636	2500	121
PAFH12-A11	.803"	1.102"	11.81	1.967	6,613	9,920	11,684	17,636	2500	121
PAFH15-A8	.803"	1.102"	13.78	2.756	8,818	13,227	15,652	23,148	2000	218
PAFH15-A11	.803"	1.102"	13.78	2.756	8,818	13,227	15,652	23,148	2000	218

**Also available in 18", 21" and 24", contact factory.**

### Dimensional Data (in inch)

MODEL	PAFH-8	PAFH-10	PAFH-12	PAFH-15
A	8.26	10	11.97	15
B	2.874	3.346	3.819	4.803
C	7.480	9.055	11.024	13.760
F	.197	.197	.197	.276
H	5.250	6.750	7.874	9.843
J	1.378	1.575	2.165	2.953
K	6-M12	6-M16	6-M20	6-M20
L	.787	.984	.984	1.063
M	.984	.984	1.181	1.969
N max.	1.803	2.020	2.891	3.378
N min	1.614	1.661	2.189	2.976
O max.	1.181	1.654	1.831	2.608
O min	.295	.374	.413	.591
P max.	.827	0	0	0
P min	.118	-.984	-1.102	-1.102
Q	1.181	1.378	1.575	1.575
R	.475	.630	.630	.826
S	1.063	1.102	1.181	1.575
T	M42	M50	M65	M85
U	.197	.197	.197	.197
V	1.890	2.283	2.953	3.740



**HOW TO ORDER:** State quantity, Model Number of chuck and shipping instructions.

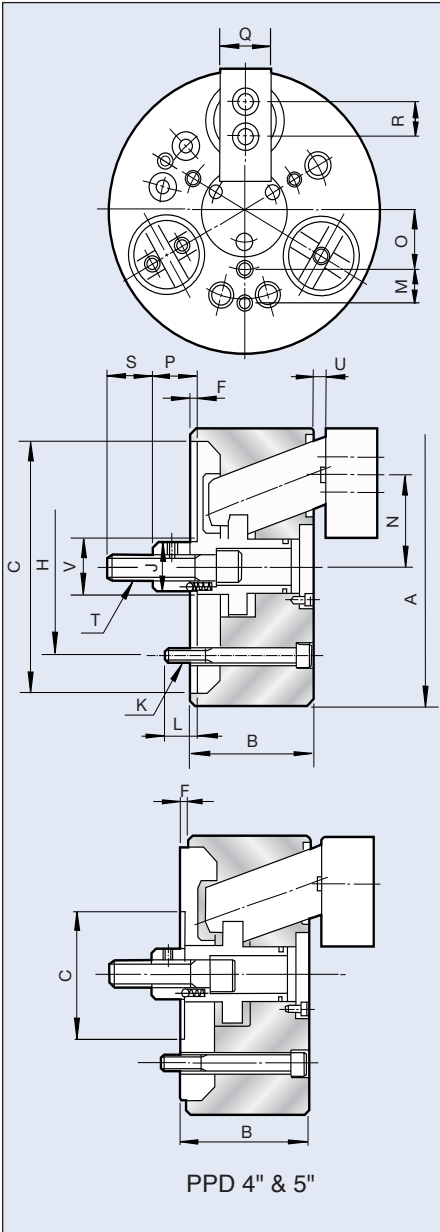


# Draw Down Power Chuck

## PDD 4" - 15" Chucks

- ⚙️ 3 jaw draw down chuck for machining work requiring squareness and parallelism
- ⚙️ High accuracy
- ⚙️ Maintains high grip forces
- ⚙️ Adapter mount for A type spindles, other mounts available

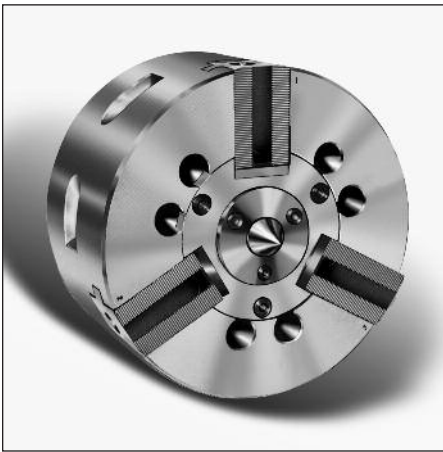
Model No.	Jaw Stroke Dia.	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt. lbs
			Max.	Min.				
PDD4	.197"	.276"	1.97"	.591"	1,300	3,300	3500	10
PDD5	.197"	.276"	2.56"	.591"	2,200	4,400	3500	16
PDD6-A4	.285"	.394"	3.35"	1.378"	3,300	5,500	3500	30
PDD6-A5	.285"	.394"	3.35"	1.378"	3,300	5,500	3500	30
PDD6-A6	.285"	.394"	3.35"	1.378"	3,300	5,500	3500	30
PDD8-A5	.283"	.394"	7.87"	1.575"	5,500	9,900	3000	60
PDD8-A6	.283"	.394"	7.87"	1.575"	5,500	9,900	3000	60
PDD10-A6	.425"	.591"	9.84"	1.969"	7,700	13,200	2500	101
PDD10-A8	.425"	.591"	9.84"	1.969"	7,700	13,200	2500	101
PDD12-A8	.425"	.591"	11.81"	1.969"	9,900	16,550	2000	150
PDD12-A11	.425"	.591"	11.81"	1.969"	9,900	16,550	2000	150
PDD15-A8	.573"	.787"	14.96"	2.362"	12,100	19,850	1500	243
PDD15-A11	.573"	.787"	14.96"	2.362"	12,100	19,850	1500	243



### Dimensional Data (in inch)

MODEL	PD-4	PD-5	PD-6	PD-8	PD-10	PD-12	PD-15
A	4.33	5.12	6.50	8.25	10	12	15
B	2.36	2.76	3.35	3.74	4.33	4.92	5.52
C	2.362	3.150	5.512	7.480	9.055	9.055	11.81
F	.197	.197	.197	.197	.197	.197	.315
H	3.150	3.937	4.125	5.250	6.750	6.750	9.055
J	.984	1.103	1.260	1.496	1.969	2.047	2.362
K	3-M8	3-M8	6-M10	6-M12	6-M16	6-M16	6-M20
L	.511	.511	.630	.906	.866	1.063	1.181
M	-	-	.787	.984	1.181	1.378	1.772
N max.	1.657	1.732	2.283	2.795	3.346	4.016	5.261
N min	1.358	1.634	2.142	2.654	3.134	3.803	4.975
O	.984	1.181	1.378	1.272	2.165	2.756	3.740
P max.	.748	.748	1.299	1.496	1.850	1.850	2.795
P min	.472	.472	.906	1.102	1.206	1.206	2.008
Q	.984	1.181	1.378	1.575	1.967	2.362	2.756
R	-	-	-	1.024	1.260	1.417	1.575
S	.787	.984	1.417	1.417	1.811	1.989	1.989
T	M10x1.5	M12x1.75	M16x2.0	M20x2.5	M20x3.0	M20x3.0	M30x3.5
U max.	.413	.413	.551	.551	.748	.748	1.024
U min	.138	.138	.155	.155	.155	.155	.236
V	1.102	1.181	1.378	1.654	2.047	2.165	3.543

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# Floating Type Compensating Power Chuck

## DFC Chucks 7" - 16"

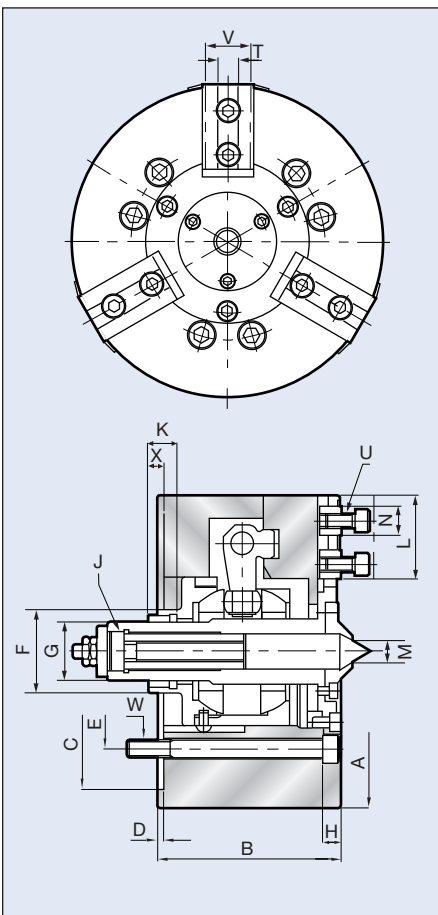
- ⚙️ 3 jaw power chuck with float compensation designed for shaft applications machined on centers
- ⚙️ Supplied with fixed or spring center (specify when ordering)
- ⚙️ Maximum durability achieved through internal sliding on spherical surface
- ⚙️ Adapter mount for A type spindles
- ⚙️ Larger sizes available on request

Model No.	Jaw Stroke Dia.	Sleeve Stroke	Comp Range Stroke	Min. Gripping Dia.	Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt. lbs
DFC7-A4	.394	.787	.157	.787	3,200	5,550	4000	33
DFC7-A5	.394	.787	.157	.787	3,200	5,550	4000	33
DFC7-A6	.394	.787	.157	.787	3,200	5,550	4000	33
DFC8-A6	.787	.984	.157	.984	4,400	6,600	3200	62
DFC8-A8	.787	.984	.157	.984	4,400	6,600	3200	62
DFC10-A6	.787	.984	.196	1.181	5,076	7,936	2500	108
DFC10-A8	.787	.984	.196	1.181	5,076	7,936	2500	108
DFC12-A8	.984	1.181	.236	1.181	5,700	9,250	2000	128
DFC12-A11	.984	1.181	.236	1.181	5,700	9,250	2000	128
DFC16-A8	1.181	1.634	.394	1.575	6,850	19,850	1000	374
DFC16-A11	1.181	1.634	.394	1.575	6,850	19,850	1000	374

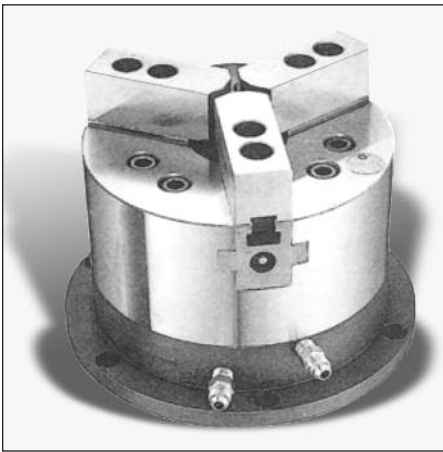
**DFC18 and Larger sizes available on request.**

### Dimensional Data

MODEL	DFC7	DFC8	DFC10	DFC12	DFC16
A	6.69	8.46	10	11	16.5
B	3.90	4.97	5.63	6.09	7.28
C	5.512	7.480	8.66	10.039	14.961
D	.157	.165	.196	.224	.224
E	4.125	5.250	6.75	6.748	8.661
F	1.654	2.244	2.64	2.835	3.543
G	1.024	1.575	1.77	1.969	1.969
H	.433	.512	.67	.669	1.102
J	M34x1.5	M50x1.5	M58x1.5	M55x1.5	M70x1.5
K	.787	.787	.787	.787	.787
L	1.772	2.264	2.519	2.835	5.295
M	.433	.591	.708	.787	.787
N	.630	.787	.745	1.024	1.102
T	.433	.551	.708	.787	.826
U	M8	M10	M12	M12	M16
V	1.083	1.339	1.575	1.732	1.929
W	M10x100	6-M12x125	6-M16x160	6-M16x160	9-M20x180
X	1.102	1.062	1.062	1.063	.984



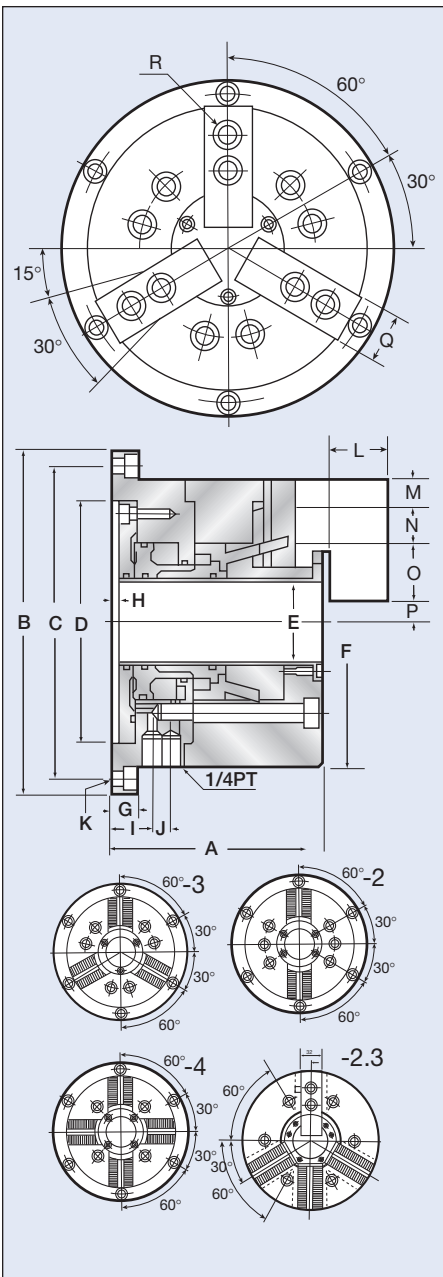
HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# Stationary 2 and 3 Jaw Power Chuck

## OLU 6" - 10" Chucks

- ⊕ Super thin body
- ⊕ Accuracy, plus minus .0005"
- ⊕ Easy Retrofit
- ⊕ Hydraulic Operation Standard
- ⊕ Optional air operation
- ⊕ Standard 1.5mm 60 degree fine serrated master jaws
- ⊕ 1 year warranty



Model	Stroke	Jaw Stroke Dia.	Hydraulic Pressure	Max. Grip ID	Max. Grip OD	Weight
OLU06D	.591"	.197"	350 psi	6,888 lbs.	4,774 lbs.	46 lbs.
OLU08D	.787"	.256"	350 psi	11,270 lbs.	6,370 lbs.	72 lbs.
OLU10D	.787"	.256"	350 psi	19,180 lbs.	13,020 lbs.	98 lbs.

### Dimensional Data

MODEL	OLU06D	OLU08D	OLU10D
A	4.96"	5.79"	6.30"
B	7.80"	9.76"	10.87"
C	7.09"	8.86"	9.84"
D	5.51"	6.69"	8.66"
E	1.65"	2.05"	2.95"
F	6.50"	8.07"	10.00"
G	.59"	.59"	.71"
H	.177"	.177"	.197"
I	1.10"	1.10"	1.18"
J	1.38"	1.73"	2.17"
K	M8	M8	M10
L	1.42"	1.50"	1.65"
M	.59"	.94"	1.18"
N	.79"	.98"	1.18"
O	1.46"	1.81"	1.97"
P max.	.394"	.531"	.650"
P min.	.197"	.256"	.394"
Q	1.26"	1.38"	1.57"
R	M10 x 30	M12 x 35	M12 x 35

Hydraulic unit pump and tank available

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

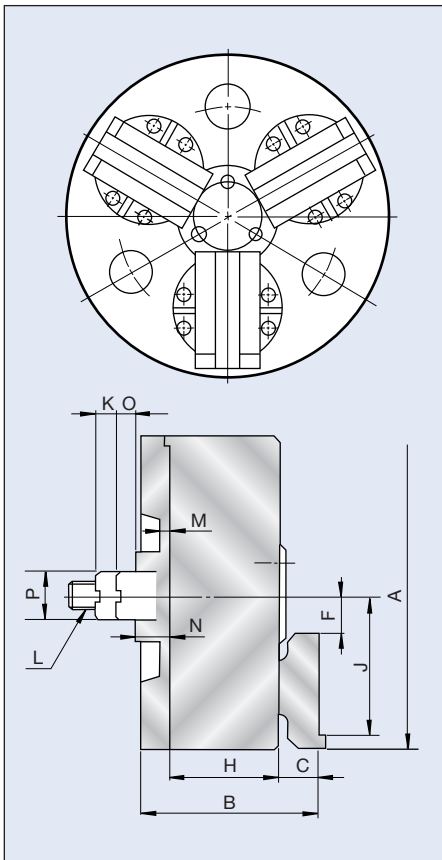


# Ball Lock Power Chuck

## BL 6" - 21" Chucks

- ⚙ This chuck is used for gripping castings and forgings. It pulls back workpieces with tapered surfaces of up to 10 degrees while providing a right and left compliance of 5 degrees resulting in strong clamping force.
- ⚙ Available in self-centering version (add "CT" to end of part number "BL8-A5CT")
- ⚙ Available as compensating chuck with center or plug (add "CP" to end of part number "BL8-A5CP")
- ⚙ Also available in 2 jaw configuration (add "2" to end of part number "BL8-A5PT2")
- ⚙ Available as adapter or direct mount

Model* No.	Jaw Stroke Dia	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt lbs
			Max	Min				
BL6-A4	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL6-A5	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL6-A6	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL8-A5	.374"	.563"	5.98"	.630"	7,950	23,800	3500	60
BL8-A6	.374"	.563"	5.98"	.630"	7,950	23,800	3500	60
BL10-A6	.500"	.689"	7.99"	1.969"	9,900	29,750	3000	99
BL10-A8	.500"	.689"	7.99"	1.969"	9,900	29,750	3000	99
BL12-A8	.500"	.689"	9.49"	2.480"	9,900	35,700	2500	149
BL12-A11	.500"	.689"	9.49"	2.480"	9,900	35,700	2500	149
BL15-A8	.622"	.878"	12.48"	2.992"	15,000	45,000	2000	186
BL15-A11	.622"	.878"	12.48"	2.992"	15,000	45,000	2000	186
BL18-A8	.622"	.878"	15.51"	3.504"	15,000	45,000	1500	265
BL18-A11	.622"	.878"	15.51"	3.504"	15,000	45,000	1500	265
BL21-A11	.622"	.878"	18.50"	6.378"	15,000	45,000	1000	397



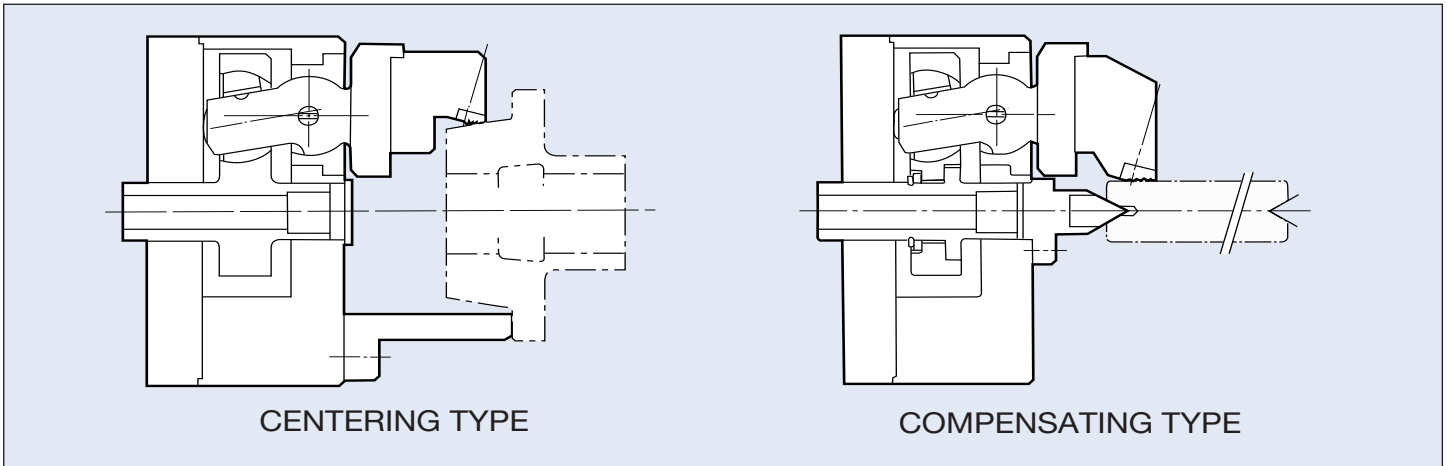
### Dimensional Data

MODEL	BL6	BL8	BL10	BL12	BL15	BL18	BL21
A	6.38	7.87	10	11.81	15	18	21
B	4.12	4.85	5.79	5.79	6.433	6.433	6.433
C	.760	.917	1.146	1.46	1.276	1.276	1.276
F	.799	.990	1.181	1.988	2.991	4.091	5.591
H	2.331	2.756	3.409	3.409	3.783	3.783	3.783
J Outer Dia.	2.880	3.502	4.437	1.307	6.750	8.250	9.750
J Inner Dia.	.874	.998	1.193	2.0	2.748	4.248	5.748
K max.	.445	.563	.689	.689	.878	.878	.878
K min	.244	.354	.374	.374	.472	.472	.472
L	M16	M16	M18	M18	M24	M24	M24
M	.189	.236	.279	.276	.276	.276	.394
N	.780	.846	1.023	1.023	1.441	1.441	1.441
O	.173	.118	.157	.157	.500	.500	.500
P	1.187	1.250	1.625	1.625	2.250	3.500	3.500

2 jaw dimensions same as 3 jaw

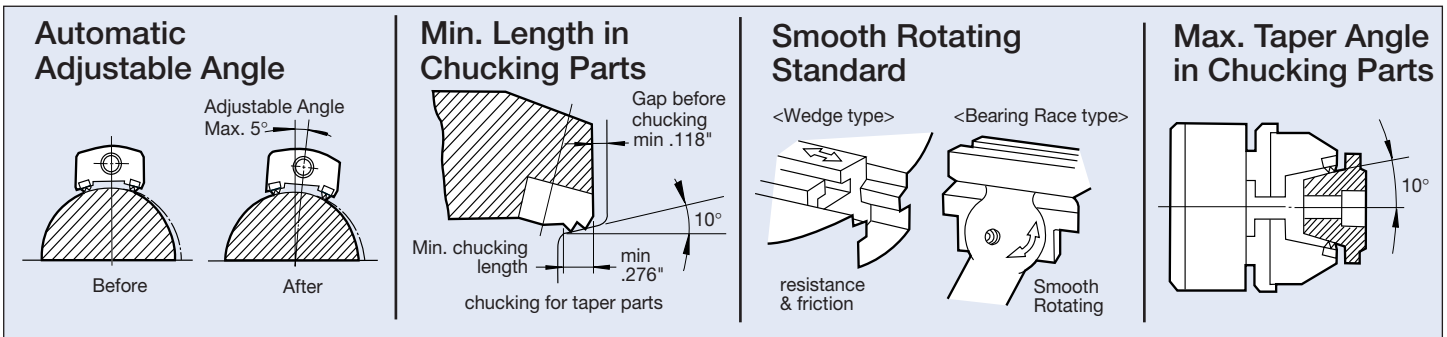
HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

## BL Chuck Structure

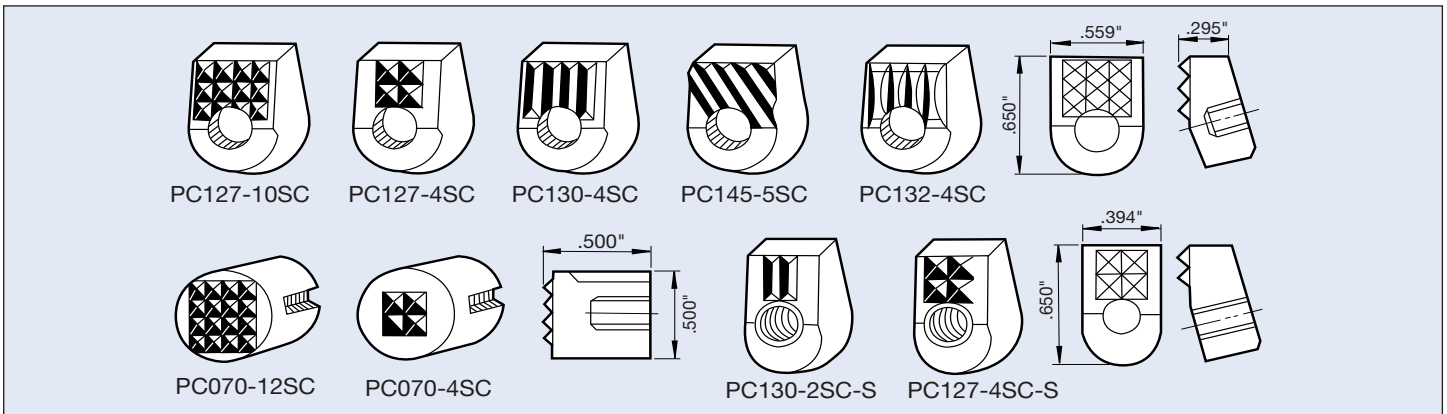


## BL Chuck Features

- ⚙️ Centers work, pulls work back and clamps firm
- ⚙️ Clamps tapered parts up to 10°
- ⚙️ Automatic radial adjustment of ± 5°
- ⚙️ I.D. and O.D. clamping of forgings or castings
- ⚙️ O.D. clamping of shafts
- ⚙️ Sealed against contamination
- ⚙️ High speed rotation
- ⚙️ Excellent retention of clamp force
- ⚙️ Also available as a 2 jaw



## BL Inserts







# Cylinder Integrated Diaphragm Chucks

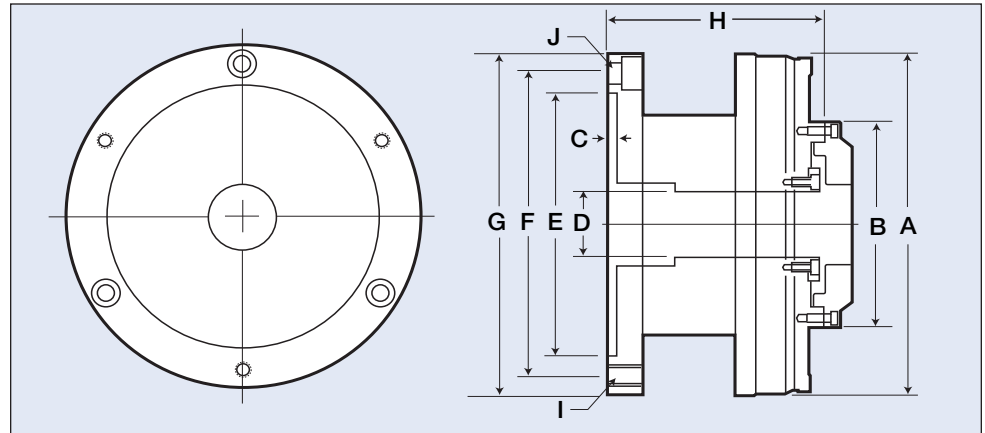
It becomes very easy to set up your precise chucking system by using the Atlas ATL100 series Cylinder-integrated Diaphragm Chuck. ATL100's built-in air cylinder eliminates the needs for installing an additional air cylinder in the back of the spindle, or tailor-making any air tubes. ATL100's front-mounting design, assembling a super precision chucking system has never been easier.

Atlas Precision advanced air cylinder technology that minimizes air leakage by the unique air containing design and by largely decreasing the clearance between the rotary and the stationary parts of the cylinder down to 0.005mm (0.0002"). This technology allows building an open center air cylinder into the diaphragm chuck.

ATL100 uses our patented diaphragm chucking technology. The super precision chucking repeatability is within 0.002mm (0.00008"), plus its gentle clamping force, making this chuck a perfect solution for any accuracy-critical and fragile material machining tasks. Send us your sample and or drawing and we will machine 1 set at no additional charge or buy Soft Blank Jaws and machine in your facility.

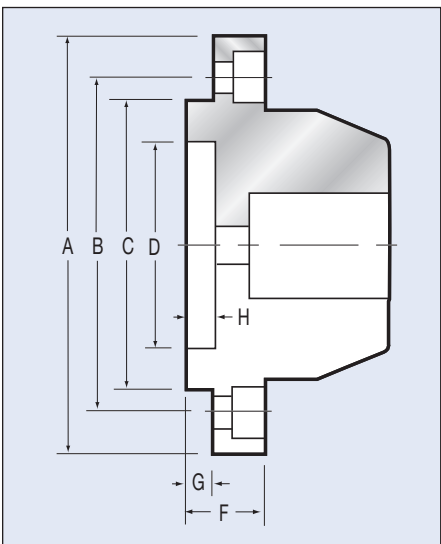
- ⊕ A Chucking Repeatability is within 0.002mm (0.00008")
- ⊕ Air Cylinder is integrated into the chuck body: no cylinder or draw tube is needed
- ⊕ Real front-mounted design allows easy installation and operation
- ⊕ Complete through-hole is reserved for bar machining, no limitation caused by a draw tube or an air feeder
- ⊕ Highly-sealed chuck body helps protect cutting chips, dust or coolant fluid from entering
- ⊕ Gentle and precise clamping: suitable for fragile or thin parts machining.
- ⊕ No sliding parts to wear out ensures a longer product life.
- ⊕ Low maintenance is required.
- ⊕ Oil-mist air lubricated, the chuck generates very low heat under long period operation.
- ⊕ Clamping force is proportional to input air pressure, easy adjustment

## Dimensional Data



	Model No.	ATL104	ATL105	ATL106	ATL107	
A	mm/in	100/3.94	136.5/5.37	166/6.54	207/8.15	
B	mm/in	60/2.36	70/2.76	100/3.94	146/5.75	
C	mm/in	4/0.16	4/0.16	5/0.20	4/0.16	
D	mm/in	10/0.39	14.5/0.57	28/1.10	60/2.36	
E	mm/in	70/2.76	100/3.94	130/5.12	160/6.30	
F	mm/in	82/3.23	115/4.53	147/5.79	172/6.77	
G	mm/in	97/3.82	136.5/5.37	167/6.57	197/7.76	
H	mm/in	73/2.87	88.8/3.50	101.5/4.0	120/4.72	
I	mm/in	N/A	M8 x 3	M10 x 3	M10 x 3	
J	mm/in	7.0x4/.28x4	9.0x3/.35x3	11.5x3/.45x3	11.5x3+M10xP15x3	
	Maximum speed	rpm	5500	4750	3350	2500
	Air pressure	kg-cm <sup>2</sup> /psi	0.5-7/7-100	0.5-7/7-100	0.5-7/7-100	0.5-7/7-100
	*Stroke per jaw	mm/in	0.20/0.008	0.25/0.010	0.20/0.008	0.25/0.010
	Chuck capacity (through hole)	mm/in	10/.039	14.5/0.57	28/1.10	60/2.36
	Chuck capacity (none-through hole)	mm/in	45/1.77	50/1.97	80/3.15	124/4.88
	Weight	kg/lbs	2.8/6.16	6/13.2	9.5/20.9	18/39.7

## Blank Jaws for ATL100 Series Air Diaphragm Chucks



Suitable Diaphragm Chucks	Soft Jaws	A	B	C	D	F	G	H	Segments
ATL104	JD-60	65mm 2.56"	52mm 2.05"	45mm 1.77"	32mm 1.26"	12mm 0.47"	4.0mm 0.16"	4.5mm 0.18"	6
ATL105	JD-70	75mm 2.95"	60mm 2.36"	50mm 1.97"	37mm 1.46"	14mm 0.55"	5.0mm 0.20"	5.0mm 0.20"	6
ATL106	JD-100	105mm 4.13"	90mm 3.54"	80.2mm 3.16"	65mm 2.56"	14mm 0.55"	5.5mm 0.22"	5.0mm 0.20"	6
ATL107	JD-70	147mm 5.79"	132mm 5.20"	120mm 4.72"	100mm 3.94"	18mm 0.71"	6mm 0.24"	6.5mm 0.26"	6



Shown without coolant catcher  
Coolant catcher included

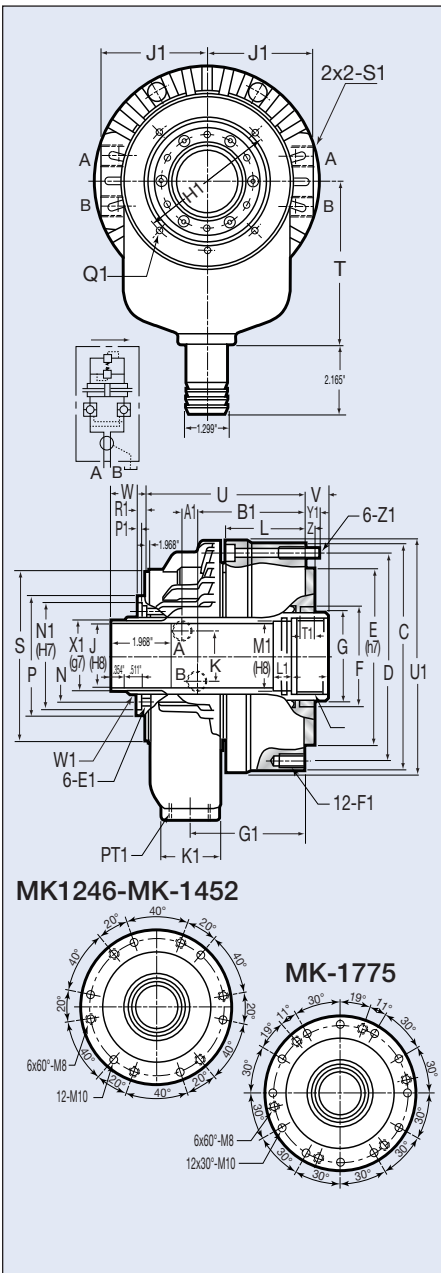
# MK Series High Speed Thru-Hole Hydraulic Cylinders

- ⚙ Thru-hole
- ⚙ High speed
- ⚙ Safety check valve if line pressure is intruded
- ⚙ Low cost

Model	Piston Dia.	Piston Area (sq. in.)			Max. Draw Bar Pull		Operating Pressure psi/(sq. in.)	Max. Speed rpm	Mount of Inertia I kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
		Push Side	Pull Side	Piston Stroke	Push Side lbf	Pull Side lbf					
MK-1246	5.039"	15.90	14.16	.630"	9,846	8,746	9.92(7.114)	8000	0.017	19	3.1
MK-1452	5.708"	20.61	19.00	.866"	12,700	11,713	9.92(7.114)	6500	0.028	26.5	3.9
MK-1775	6.692"	25.73	23.56	.984"	15,893	14,543	9.92(7.114)	5500	0.060	39.5	4.5

## Dimensional Data

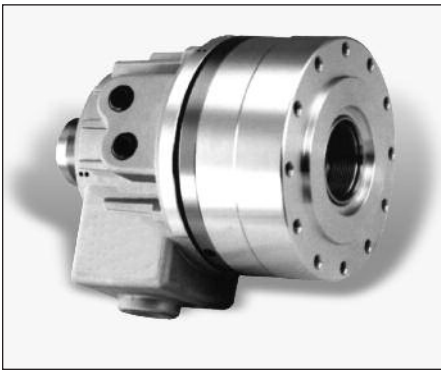
MODEL	MK-1246	MK-1452	MK-1775
C	6.378"	7.244"	8.34"
D	5.787"	6.496"	7.677"
E	5.118"	5.512"	6.299"
F	2.953"	3.149"	4.134"
G	2.559"	2.756"	3.543"
H thread	M55 x 2.0	M60 x 2.5	M85 x 2.0
J thru-hole	1.811"	2.047"	2.953"
K	1.575"	1.575"	1.811"
L	2.283"	2.598"	2.795"
N	2.519"	2.874"	3.858"
P	3.346"	3.779"	4.764"
S	4.467"	5.315"	6.457"
T	4.724"	5.118"	6.299"
U	4.724"	5.118"	6.181"
V max.	.512"	.7481"	.866"
V min.	-.118"	-.118"	-.118"
W max.	1.732"	1.850"	1.968"
W min.	1.102"	.984"	.984"
Z	.315"	.315"	.315"
A1	.335"	.354"	.689"
B1	3.130"	3.464"	3.898"
C1	.984"	1.181"	1.181"
E1	M6 x 10L	M6 x 7L	M6 x 13L
F1	M10 x 20L	M10 x 20L	M10 x 20L
G1	3.307"	3.661"	4.330"
H1	3.858"	4.331"	6.102"
J1	2.992"	3.386"	3.937"
K1	1.850"	1.850"	1.850"
L1	.590"	.590"	.590"
M1	1.968"	2.156"	3.149"
N1	2.992"	3.346"	4.251"
P1	.157"	.157"	.157"
Q1	M5 x 6L	M6 x 6L	M6 x 10L
R1	.354"	.275"	.275"
S1	PT3/8	PT3/8	PT1/2
T1	.472"	.472"	.472"
U1	6.496"	7.254"	8.504"
W1	M52 x 1.5	M58 x 1.5	M84 x 2.0
X1	1.968"	2.204"	3.189"
Y1	.590"	.472"	.709"
Z1	M8	M8	M10



Hydraulic unit pump and tank available

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

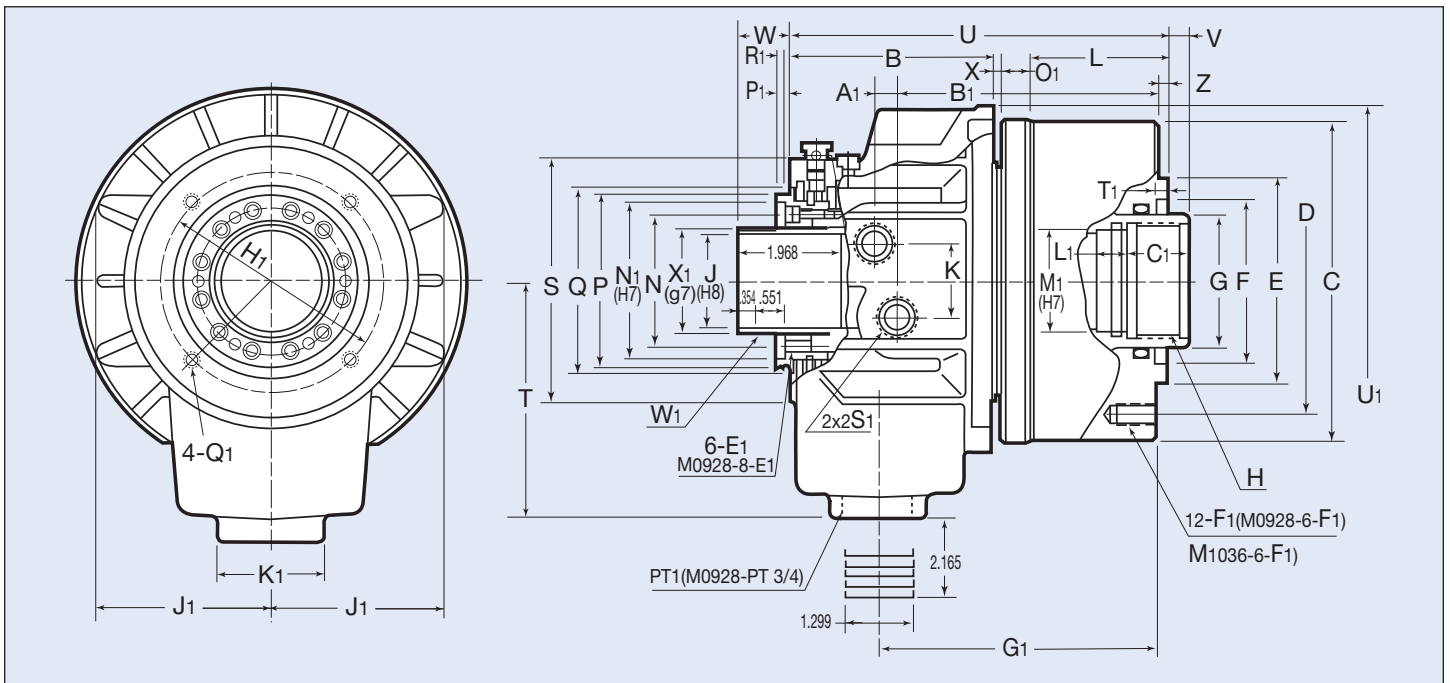
Cylinders



## ATL Series High Speed Thru-Hole Hydraulic Cylinders

- ⚙ High speed
- ⚙ Compact Design-lighter in weight
- ⚙ Less spindle stress
- ⚙ Large Thru-hole Capacity
- ⚙ Include Removable Coolant Catcher
- ⚙ Built-in Safety Check Valves

Model	Piston Dia. (in./mm)	Piston Area (sq. in.)		Max. Draw Bar Force		Piston Stroke (in./mm)	Max. Operating Pressure psi	Thru Hole (in./mm)	Max. Speed rpm	Moment of Inertia kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
		Push Side (sq. in.)	Pull Side (sq. in.)	Push Side lbf	Pull Side lbf							
ATL1246-CM12B	4.921/(125)	15.500	13.795	8543	7418	.590/(15)	580	1.811/(46)	7000	0.019	27	3.0
ATL1552-CM15B	6.102/(155)	24.955	23.250	13488	12588	.866/(22)	580	2.047/(52)	6200	0.052	37	3.9
ATL1868-CM18B	7.086/(180)	30.690	30.080	16636	16523	.984/(25)	580	2.677/(68)	4700	0.098	62	4.2
ATL1875-CM18B	7.086/(180)	30.690	28.365	16636	15511	.984/(25)	580	2.953/(75)	4700	0.095	57	4.2
ATL1875-CM18B	7.086/(180)	30.690	28.365	16636	15511	.984/(25)	580	3.071/(78)	4700	0.095	56	4.2
ATL2091-CM20B	8.071/(205)	39.060	36.270	21131	19782	1.181/(30)	580	3.582/(91)	3800	0.15	82	4.5
ATL2511-CM25B	9.842/(250)	53.940	52.080	27875	26975	.905/(23)	580	4.626/(117.5)	2800	0.45	126	7.0



### Dimensional Data (inch)

Model	C1	E1	F1	G1	H1	J1	K1	L1	M1	N1	O1	P1	Q1	R1	S1	T1	U1	W1	X1	B	C
ATL1246-CM12B	1.181	M6x1.0	M10x1.5	5.315	3.838	2.992	1.850	.590	1.968	3.071	.551	.157	M5x0.8	.236	PT 1/2	.236	6.653	M52x1.5	1.968	3.897	6.082
ATL1552-CM15B	1.181	M6x1.0	M10x1.5	5.708	4.331	3.386	1.850	.590	2.165	3.346	.551	.157	M6x1.0	.275	PT 1/2	.236	7.382	M58x1.5	2.205	4.055	7.480
ATL1868-CM18B	1.378	M6x1.0	M10x1.5	6.535	6.102	3.976	1.850	.590	2.756	4.252	.627	.157	M6x1.0	.295	PT 1/2	.236	8.661	M84x2	3.189	4.960	8.460
ATL1875-CM18B	1.378	M6x1.0	M10x1.5	6.535	6.102	3.976	1.850	.590	3.149	4.252	.627	.157	M6x1.0	.295	PT 1/2	.236	8.661	M84x2	3.189	4.960	8.460
ATL1878-CM18B	1.378	M6x1.0	M10x1.5	6.535	6.102	3.976	1.850	.787	3.228	4.252	.627	.157	M6x1.0	.295	PT 1/2	.236	8.661	M84x2	3.189	4.960	8.460
ATL2091-CM20B	1.378	M6x1.0	M12x1.75	7.176	6.496	4.331	1.850	.590	3.740	4.724	.627	.157	M6x1.0	.275	PT 1/2	.236	10.512	M99x2	3.779	5.551	9.449
ATL2511-CM25B	1.771	M6x1.0	M16x2.0	7.756	8.110	2.843	2.165	.787	4.842	6.299	.708	.197	M6x1.0	.275	PT 1/2	.236	11.575	-	5.299	7.323	12.204

Model	D	E	F	G	H	J	K	L	N	P	Q	S	T	U	V	V	W	W	X	Z	A1	B1
					Thread	Thru. Hole										Max.	Min.	Max.	Min.			
ATL1246-CM12B	5.118	3.937	3.149	2.559	M55x2	1.811	6.750	2.519	2.519	3.346	3.543	4.645	4.488	7.244	.393	-199	1.575	.984	.157	.197	.433	4.980
ATL1552-CM15B	6.693	5.118	3.346	2.756	M60x2	2.047	6.750	2.874	2.874	3.779	4.015	5.393	5.118	7.716	.669	-199	1.450	.984	.157	.197	.433	5.0354
ATL1868-CM18B	7.480	6.299	4.724	3.740	M75x2	2.677	7.480	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-199	1.968	.984	.157	.197	.689	5.984
ATL1875-CM18B	7.480	6.299	4.724	1.692	M85x2	2.953	9.252	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-199	1.968	.984	.157	.197	.689	5.984
ATL1878-CM18B	7.480	6.299	4.724	3.740	M87x2	3.071	9.252	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-199	1.968	.984	.157	.197	.689	5.984
ATL2091-CM20B	8.464	7.086	5.512	4.331	M100x2	3.582	10.236	3.661	4.252	5.433	5.828	7.165	7.283	9.961	.984	-199	2.165	.984	.118	.197	.827	6.555
ATL2511-CM25B	10.827	9.055	6.535	5.512	M130x2	4.626	9.252	3.504	5.828	1.882	-	9.134	8.464	11.653	.708	-199	1.496	.590	.118	.197	1.063	7.264



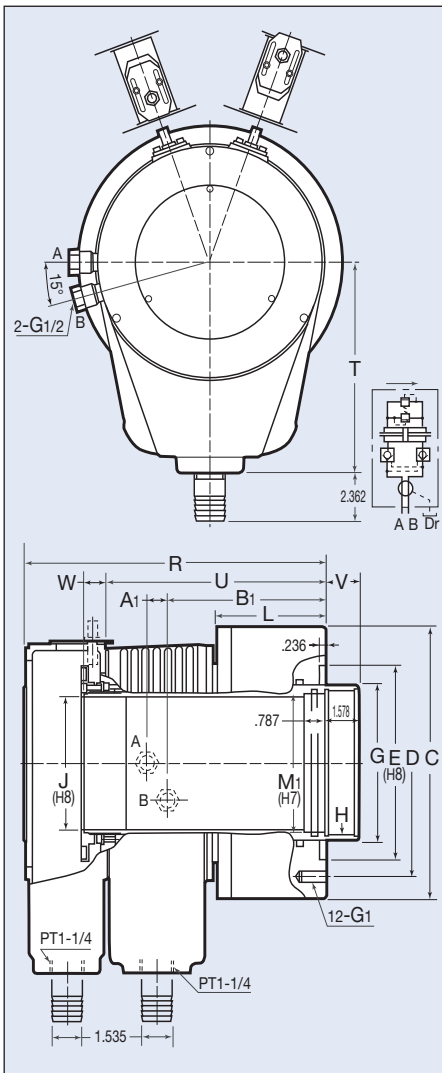
## ATL-KBC King Bore Open Center Hydraulic Cylinders

- ⚙️ Large Thru-Hole up to 8.26"
- ⚙️ High RPM
- ⚙️ Built-in Coolant Catcher included
- ⚙️ Built-in Safety Check Valves

Model	Piston Dia. inch	Piston Area		Piston Stroke inch	Max. Draw Bar Pull		Max. Operating Pressure psi	Thru Hole inch	Max. Speed rpm	Moment of Inertial kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
		Push Side (sq. in.)	Pull Side (sq. in.)		Push Side lbf	Pull Side lbf						
ATL2814-CM28B	11.22	61.07	54.25	1.653	26,202	23,285	478	5.708	2000	1.08	198	3.1
ATL2816-CM28B	11.22	61.07	54.25	1.653	26,202	23,285	478	6.633	2000	0.90	159	3.9
ATL3320-CM33B	13.18	79.82	64.62	1.653	34,300	30,712	478	8.070	1600	1.09	227	4.5

### Dimensional Data (inch)

MODEL	ATL2814-CM28B	ATL2816-CM28B	ATL3320-CM33B
C	13.189	13.189	15.354
D	11.023	11.023	12.598
E (H6)	9.449	9.449	11.023
G	7.480	7.480	9.055
H	M158x3.0	M180x3.0	M215x3.0"
J thru-hole	5.708	6.633	8.070
L	5.518	5.518	5.787
R	15.04	15.04	15.43
T	10.236	10.236	10.236
U	10.984	10.984	11.496
V max.	1.614	1.614	1.614
V min.	-.039	-.039	-.039
W max.	2.637	2.637	2.637
W min.	.984	.984	.984
A1	.708	.708	.708
B1	7.952	7.952	7.952
F1	M16x32L	M16x32L	M20x32L
M1	5.905	6.693	8.267



HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

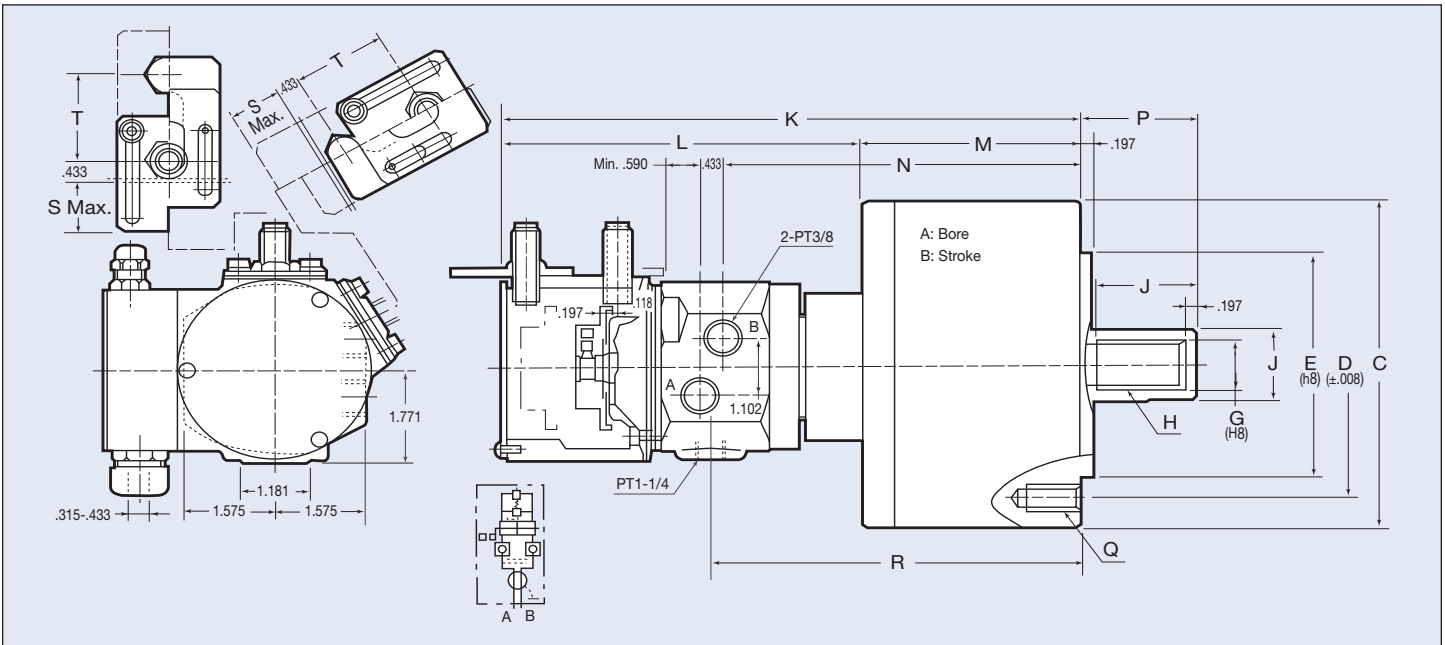


# ATL-CC Series Closed Center Rotary Hydraulic Cylinders

- ⚙ High RPM
- ⚙ Compact Design
- ⚙ Built-in Safety Check Valves
- ⚙ Proximity Switch Detective Plate Included
- ⚙ Proximity Switch optional

Model	Piston Area (sq. in.)		Piston Stroke inch	Max. Draw Bar Force Pull Side lbf	Max. Operating Pressure psi	Max. Speed rpm	Moment of Inertia I kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
	Pull Side	Pull Side							
ATLCC-105C	13.02	12.24	.787	6,505	580	6000	0.0125	17	0.8
ATLCC-125C	18.6	17.52	.984	9,422	580	6000	0.022	24	0.8
ATLCC-125C35	18.6	17.52	1.378	9,422	580	6000	0.022	24	0.8
ATLCC-150C	26.97	24.8	1.181	13,459	580	5500	0.047	31	0.8
ATLCC-200C	48.36	44.95	1.378	24,228	580	5500	0.047	50	0.8

## Dimensional Data (inch)



Model No.	A	B	C	D	E	F	G	H	J	K	L	M	N	P		Q	R	S	T
														Max	Min				
ATLCC-105C	4.134	.787	5.315	3.937	3.149	1.181	.827	M20x2.5	1.378	10.118	6.614	3.504	5.984	1.771	.984	6-M10x20	6.220	.905	1.811
ATLCC-125C	4.921	.984	6.299	5.118	4.331	1.378	.984	M24x3.0	1.732	10.433	6.614	3.819	6.299	2.008	1.023	6-M12x24	6.535	.905	1.811
ATLCC-125C35	4.921	1.378	6.299	5.118	4.331	1.378	.984	M24x3.0	1.732	10.590	6.614	3.976	6.456	2.244	.866	6-M12x24	6.693	.905	1.811
ATLCC-150C	5.905	1.181	7.480	5.118	4.331	1.771	1.220	M30x3.5	1.771	10.787	6.614	4.173	6.259	2.204"	1.023	6-M12x24	6.889	.905	1.811
ATLCC-200C	7.784	1.378	9.645	5.708	4.724	2.165	1.457	M36x4.0	2.362	11.338	6.535	4.803	7.204	2.716"	1.338	12-M16x30	7.440	1.102	1.811

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.

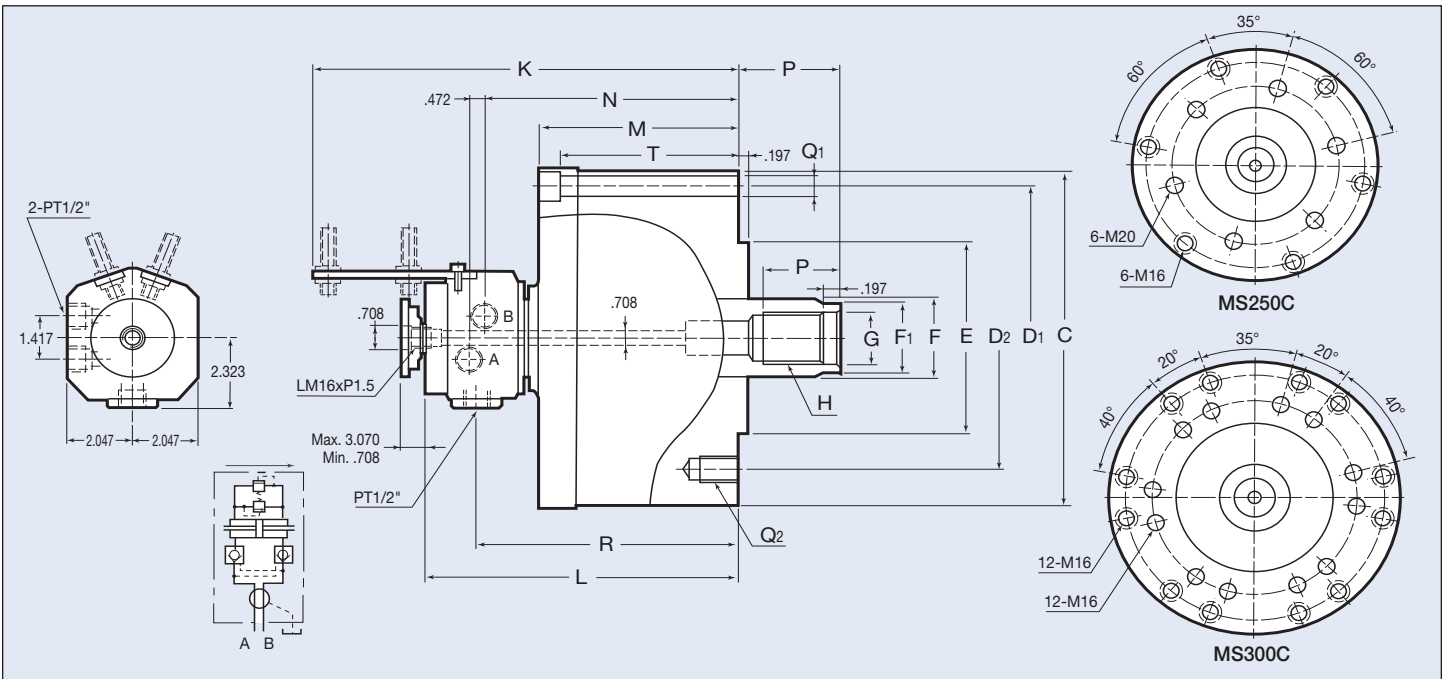


# ATL250C/ATL300C Closed Center Rotary Hydraulic Cylinders

- ⚙ Extreme High Force Closed Center Cylinder
- ⚙ Use with Large Chucks that demand high Draw-Bar Pull
- ⚙ Mounting Bolts mount from the front or rear
- ⚙ Built-in Safety Check Valves
- ⚙ Proximity Bracket included
- ⚙ Proximity Switch optional

Model	Piston Dia. inch	Piston Area (sq. in.)		Piston Stroke inch	Max. Draw Bar Pull		Operating Pressure psi	Max. Speed rpm	Moment of Inertia I kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
		Push Side	Pull Side		Push Side lbf	Pull Side lbf					
ATL250C	74.63	70.30	17.858	2.362	50923	48008	710	2000	0.87	172	2
ALT300C	108.11	102.08	25.929	2.362	58775	55409	580	1500	1.60	234	3

Cylinders



## Dimensional Data (inch)

Model No.	C	D1	D2	E (h7)	F	F1	G	H	J	K	L	M	N	P		Q1	Q2	R	T
														Max	Min				
ATL250C	11.8100	10.826	8.661	6.299	2.559	2.441	1.732	M42x3.0	2.362	14.015	10.512	6.968	8.661	3.346	.984	6-.669	6-M20	8.897	6.299
ATL300C	13.976	12.992	10.630	8.267	2.953	2.756	1.968	M48x3.0	2.756	14.134	10.630	7.165	8.779	3.346	.984	12-.669	12-M20	9.016	6.496

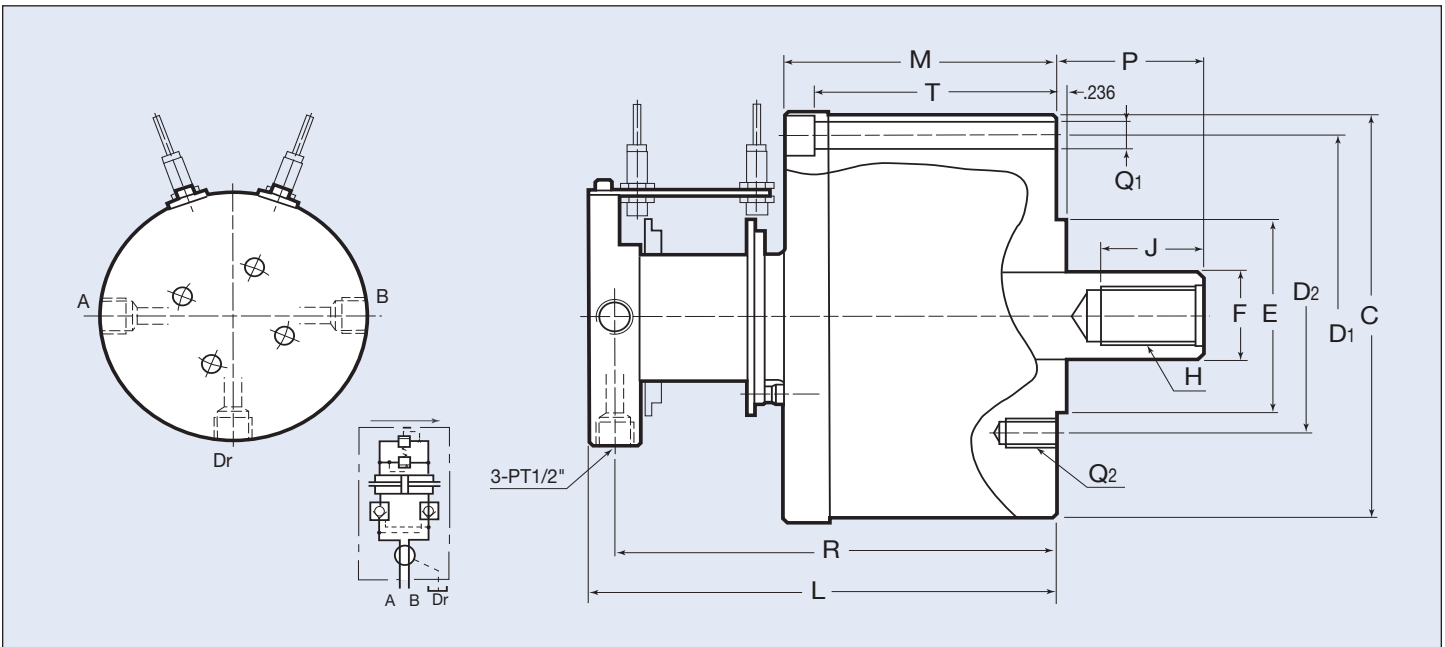
HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# ATLV Series Closed Center Rotary Hydraulic Cylinders

- ⚙ High RPM
- ⚙ Light Weight design spindle loading for Vertical Lathes
- ⚙ Rear through mounting bolts
- ⚙ Built-in Safety Check Valves
- ⚙ Proximity Switch Bracket
- ⚙ Proximity Switch optional

Model	Piston Dia. inch	Piston Area (sq. in.)		Piston Stroke inch	Max. Draw Bar Pull		Max. Operating Pressure psi	Max. Speed rpm	Mount of Inertia I kg-m <sup>2</sup>	Weight lbs	Total Leakage L/min
		Push Side	Pull Side		Push Side lbf	Pull Side lbf					
ATL20060	7.874	48.05	44.33	2.362	32751	30060	710	5500	0.55	108	2
ATL25060	9.842	74.63	70.30	2.362	50923	48008	710	2000	0.81	159	2



Cylinders

## Dimensional Data (inch)

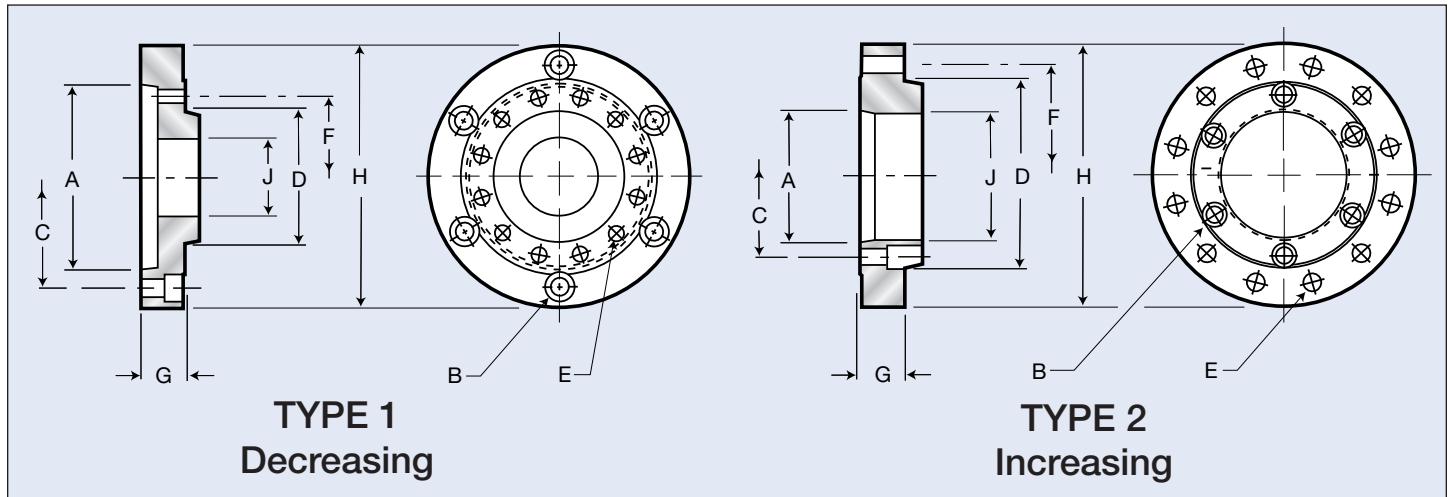
Model No.	C	D1	D2	E (h7)	F	G	H	J	L	M	P Max	P Min	Q1	Q2	R	T
ATL20060	9.842	8.858	5.708	4.724	2.165	1.456	M36xP4.0	2.362	10.630	6.142	3.346	.984	6-.669	6-M16	10.167	5.512
ATL25060	11.811	10.826	8.661	6.299	2.559	1.732	M42xP3.0	2.362	11.023	6.614	3.346	.984	6-.669	6-M20	10.433	5.905

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



# Spindle Conversion Adapters

- ⊕ Made from steel
- ⊕ Dimensions are per USA Standards
- ⊕ Available with UNC or metric mounting bolt holes
- ⊕ Precision CNC turned in the U.S.A.



Cylinders

Part No.	Spindle (Machine)						Chuck					Offset G	Dia H	Hole J
	Type	Mount	A	B(bolt) in.*	B(bolt) mm *	C	Mount	D	E(tap) in	E(tap) mm	F			
A5-A6	2	5	3.250"	7/16	10	4.125"	6	4.188"	1/2x13	12x1.75	5.250"	1.000"	6.500"	2.500"
A5-A8	2	5	3.250"	7/16	10	4.125"	8	5.500"	5/8x11	16x2	6.750"	1.125"	8.250"	3.000"
A6-A5	1	6	4.188"	1/2	12	5.250"	5	3.250"	7/16x14	10x1.5	4.125"	1.500"	6.500"	1.700"
A6-A8	2	6	4.188"	1/2	12	5.250"	8	5.500"	5/8x11	16x2	6.750"	1.125"	8.250"	3.250"
A6-A11	2	6	4.188"	1/2	12	5.205"	11	7.750"	3/4x10	20x2.5	9.250"	1.375"	11.000"	4.000"
A8-A6	1	8	5.500"	5/8	16	6.750"	6	4.188"	1/2x13	12x1.75	5.250"	1.750"	8.250"	2.500"
A8-A11	2	8	5.500"	5/8	18	6.750"	11	7.750"	3/4x10	20x2.5	9.250"	1.375"	11.000"	5.250"
A8-A15	2	8	5.500"	5/8	16	6.750"	15	11.250"	7/8x9	22x2.5	13.000"	1.625"	15.000"	5.250"
A11-A6	1	11	7.750"	3/4	20	9.250"	6	4.188"	1/2x13	12x1.75	5.250"	1.750"	11.000"	2.500"
A11-A8	1	11	7.750"	3/4	20	9.250"	8	5.500"	5/8x11	16x2	6.750"	1.875"	11.000"	3.250"
A11-A15	2	11	7.750"	3/4	20	9.250"	15	11.250"	7/8x9	22x2.5	13.000"	1.625"	15.000"	7.500"
A11-A20	2	11	7.750"	3/4	20	9.250"	20	16.250"	1x8	24x3	18.250"	1.875"	20.500"	7.500"
A15-A8	1	15	11.250"	7/8	22	13.000"	8	5.500"	5/8x11	16x2	6.750"	2.000"	15.000"	3.250"
A15-A11	1	15	11.250"	7/8	22	13.000"	11	7.500"	3/4x10	20x2.5	9.250"	2.250"	15.000"	5.250"
A15-A20	2	15	11.250"	7/8	22	13.000"	20	16.250"	1x8	24x3	18.250"	1.875"	20.500"	11.000"
A20-A11	1	20	16.250"	1	24	18.250"	11	7.750"	3/4x10	20x2.5	9.250"	2.125"	20.500"	5.250"
A20-A15	1	20	16.250"	1	24	18.250"	15	11.250"	7/8x9	22x2.5	13.000"	2.500"	20.500"	8.250"

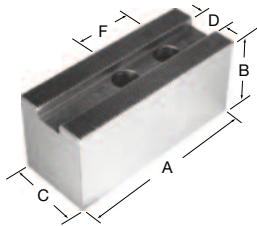
\* Specify metric or inch requirements when ordering

**NOTE:**

1. Spindle and chuck mountings are outer bolt circle (type A2).
2. "A" and "D" are diameters to sharp corners (large diameter of taper).
3. "B" bolts are a total of 6 equally spaced (60 deg. apart) on a bolt circle of "C".
4. "E" tapped holes are a total of 12 equally spaced (30 deg. apart) on a bolt circle of "F".
5. See standard spindle dimensions on page 109.

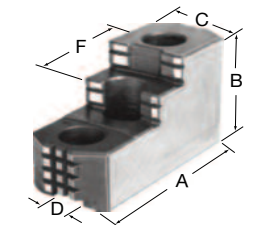
# Top Jaws and Accessories

For Constant Grip, Quick Change, VTL, Setrite® Power, Self Contained and Front Mount Hydraulic Chucks



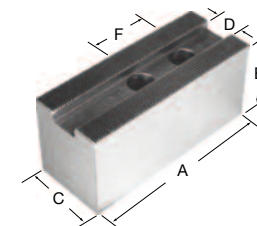
## 1.5mm x 60° Serrated Soft Top Jaws - Constant Grip, Quick Change, & International Chucks

Chuck Dia.	Jaw No.	A	B	C	D	F	Screw Size	T-Nut 2 Req'd per Jaw
6"	8140-17525*	3.125"	1.50"	1.25"	.475"	.787"	M-10	8130-17590
8"	8140-21525	3.50"	2.00"	1.50"	.551"	1.00"	M-12	8130-21590
10"	8140-26525	4.00"	2.00"	1.50"	.630"	1.18"	M-12	8130-26590
12"	8140-31525	5.25"	2.00"	2.00"	.710"	1.18"	M-14	8130-31590
15/18"	8140-40525	6.50"	2.50"	2.00"	.866"	1.69"	M-20	8130-40590
20/24"	8130-50525①	7.00"	2.50"	2.50"	.984"	2.362"	M-20	8130-50590



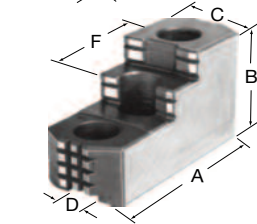
## 1.5mm x 60° Hard Reversible Top Jaw \*Comes standard as offset points

Chuck Dia.	Jaw No.	A	B	C	D	F	Screw Size	T-Nut 2 Req'd per Jaw
6"	8130-17624	2.56"	1.38"	1.18"	.475"	.669"	M-10	8130-17590
8"	8130-21624	2.95"	1.96"	1.57"	.551"	.748"	M-12	8130-21590
10"	8130-26624	2.95"	1.96"	1.57"	.630"	.748"	M-12	8130-26590
12"	8130-31624	4.52"	2.28"	1.97"	.710"	.948"	M-14	8130-31590
15/18"	8130-40624	4.96"	2.95"	2.36"	.866"	.984"	M-20	8130-40590
20/24"	8130-50624①	6.50"	3.50"	2.50"	.984"	2.36	M-20	8130-50590



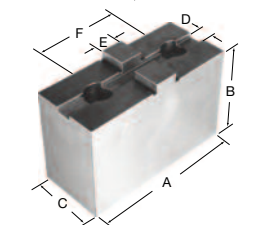
## 1/16 x 90° Serrated Soft Top Jaws for Constant Grip/Int'l and Self Contained Power Chucks

Chuck Dia.	Jaw No.	A	B	C	D	F	Screw Size	T-Nut 2 Req'd per Jaw
6"	8140-17512	2.75"	1.50"	1.00"	.475"	.787"	M-8	8820-17591
8"	2860-21512	3.25"	2.00"	1.50"	.670"	1.00"	M-12	2870-17591
10"	2860-21512	3.25"	2.00"	1.50"	.670"	1.00"	M-12	2870-17591
12"	2860-32512	4.50"	2.50"	2.00"	.827"	1.25"	M-16	2870-26591
15"-24"	2860-40512②	6.00"	3.00"	2.00"	1.000"	1.75"	M-20	



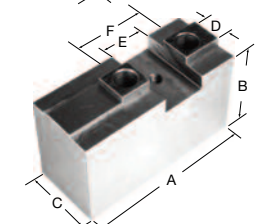
## 1/16 x 90° Hard Reversible Top Jaw

Chuck Dia.	Jaw No.	A	B	C	D	F	Screw Size	T-Nut 2 Req'd per Jaw
6"	8130-17611	2.54"	1.57"	1.18"	.475"	.67"	M-8	8820-17591
8"	8130-21611	3.00"	1.97"	1.57"	.670"	.75"	M-12	2870-17591
10"	8130-21611	3.00"	1.97"	1.57"	.670"	.75"	M-12	2870-17591
12"	8130-31611	4.92"	2.36"	2.36"	.830"	.98"	M-16	2870-26591
15"-24"	8130-40611②	4.92"	2.95"	2.36"	1.000"	1.22"	M-20	



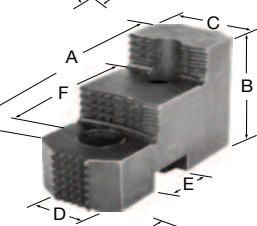
## AM Tongue & Groove Soft Top Jaws for Constant Grip Quick Change Chucks

Chuck Dia.	Jaw No.	A	B	C	D	E	F	Screw Size	T-Nut
6"	2770-17509	2.81"	1.37"	1.00"	.315"	.499"	1.50"	7/16"	Not Required
8"	8130-21509	3.31"	1.875"	1.25"	.315"	.499"	1.75"	1/2"	
10"	2770-26509	3.93"	1.875"	1.50"	.501"	.749"	2.12"	5/8"	
12"	2770-32509	4.50"	2.12"	1.75"	.501"	.749"	2.50"	5/8"	
15"	2770-38509	5.18"	2.81"	2.25"	.501"	.749"	3.00"	3/4"	



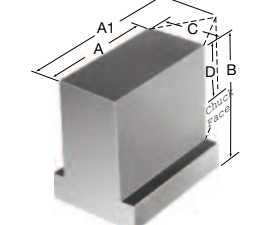
## Acme Serrated Soft Top Jaws for Constant Grip Quick Change/Front Mount Hydraulic Chucks

Chuck Dia.	Jaw No.	A	B	C	D	E	F	Screw Size	T-Nut 1 Req'd per Jaw
6"	N/A	-	-	-	-	-	-	-	-
8"	7749-22038	3.75"	1.812"	1.50"	.670"	.601"	1.25"	1/2"	2749-02407
10"	7749-26047	4.12"	2.31"	1.75"	.750"	1.031"	1.75"	1/2"	2749-02417
12"	7749-32056	5.12"	2.31"	1.75"	.875"	1.031"	2.00"	5/8"	2749-02427
15"-24"	8140-40533	6.00"	3.25"	2.50"	1.000"	1.530"	2.50"	3/4"	8130-40531



## Acme Serrated Hard Rev. Top Jaws for Constant Grip Quick Change/Front Mount Hydraulic Chucks

Chuck Dia.	Jaw No.	A	B	C	D	E	F	Screw Size	Acme Key 1 Req'd per Jaw
6"	N/A	-	-	-	-	-	-	-	-
8"	7749-22036	3.50"	2.00"	1.50"	.670"	.601"	1.25"	1/2"	2749-02405
10"	7749-26042	4.25"	2.50"	1.75"	.750"	1.031"	1.75"	1/2"	2749-02415
12"	7749-32052	4.87"	2.50"	1.75"	.875"	1.031"	2.00"	5/8"	2749-02425
15"-24"	8130-40632	5.50"	3.50"	2.50"	1.000"	1.531"	2.50"	3/4"	8130-40530



## Mono Jaws for Quick Change Jaw Power Chucks

Chuck Dia.	Jaw No.	A	A1	B	C	D
6"	8130-17601P	2.598"	2.835"	1.218"	1.66"	
8"	8130-21601	3.346"	4.037"	3.346"	1.560"	2.00"
10"	8130-26601	4.420"	5.000"	3.543"	1.560"	2.29"
12"	8130-31601	6.039"	5.950"	4.133"	1.811"	2.42"
15"	8130-38601	6.299"	7.420"	4.920"	2.360"	2.90"

Mono jaws are made from nitride hardening steel. This allows them to be case hardened after machining. Mono jaws for 18" and larger chucks available upon request.

\* 8140-17525 are pointed type

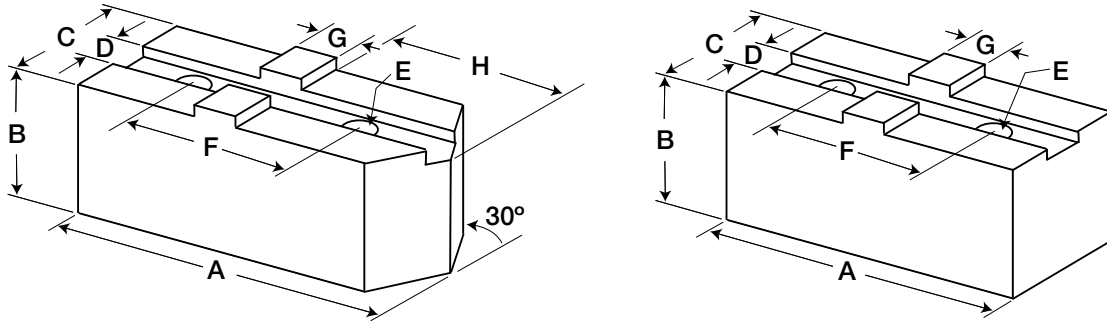
① 3mm x 60° Serrations

② 3/32 x 90° Serrations

Top Tooling

# Tongue and Groove Soft Blank Top Jaws

For: Pratt Burnerd, Buck, Cushman, Forkhart, Rohm, SCA and others



## Soft Jaws, Medium Duty

Chuck Size	Part Number	Length A	Height B	Width C	L/Wise Slot D	Bolt Size E	Bolt Spacing F	Cross Key G	Offset Pointed Part Number	Offset Pointed A	H	Extra High Part Number	Extra High B
5"	2210-13609	2.18"	1.37"	.75"	.25"	5/16"	.87"	.375"	N/A	--		N/A	--
6"	2210-17609	2.81"	1.37"	1.0"	.31"	3/8"	1.5"	.501"	2210-17609OP	3.25"	1.81"	2210-17609EH	3.5"
8"	2210-20609	3.31"	1.87"	1.25"	.31"	3/8"	1.75"	.501"	2210-20609OP	3.75"	2.18"	2210-20609EH	3.5"
10"	2210-25609	3.93"	1.87"	1.5"	.5"	1/2"	2.12"	.749"	2210-25609OP	4.62"	2.62"	2210-25609EH	3.5"
12"	2210-32609	4.5"	2.125"	1.75"	.5"	1/2"	2.5"	.749"	2210-32609OP	5.37"	3.12"	2210-32609EH	4.0"
15"	2210-38609	5.18"	2.125"	1.75"	.5"	5/8"	3.0"	.749"	2210-38609OP	6.25"	3.62"	2210-38609EH	3.81"
18"& Up*	2980-38509	5.18"	2.81"	2.25"	.5"	3/4"	3.0"	.749"	2980-38509OP	6.37"	3.75"	2980-38509EH	3.81"

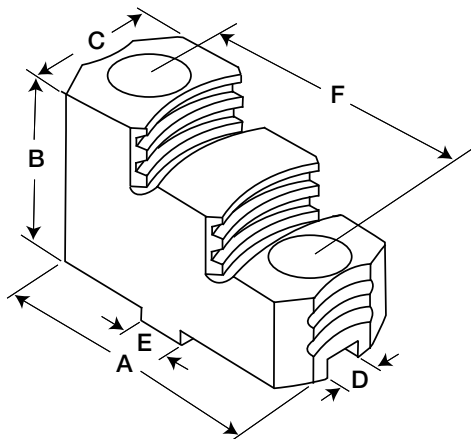
Standard length jaws have centered cross key

## Soft Jaws, Heavy Duty

Chuck Size	Part Number	Length A	Height B	Width C	L/Wise Slot D	Bolt Size E	Bolt Spacing F	Cross Key G
6"	2770-17509	2.81"	1.37"	1.0"	.31"	7/16"	1.5"	.501"
8"	8130-21509	3.31"	1.87"	1.25"	.31"	1/2"	1.75"	.501"
10"	2770-26509	3.93"	1.87"	1.5"	.5"	5/8"	2.12"	.749"
12"	2770-32509	4.5"	2.125"	1.75"	.5"	5/8"	2.5"	.749"
15"	2980-38509	5.18"	2.81"	2.25"	.5"	3/4"	3.0"	.749"

Standard length jaws have centered cross key

Top Tooling



## Hard Top Jaws - Medium Duty

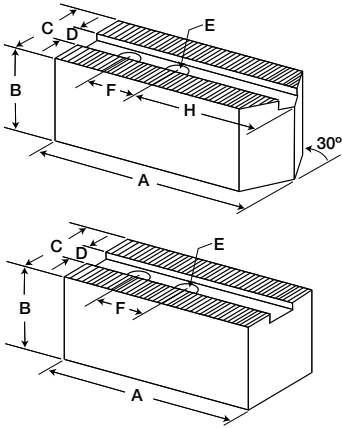
Chuck Size	Part Number	Length A	Height B	Width C	L/Wise Slot D	Cross Key E	Bolt Spacing F	Bolt Size
6"	8210-17608	2.63"	1.63"	.98"	.313"	.5"	1.5"	3/8"
8"	8210-20608	3.34"	1.71"	1.06"	.313"	.5"	1.75"	3/8"
10"	8210-25608	3.74"	2.03"	1.28"	.5"	.75"	2.12"	1/2"
12"	8210-32608	4.33"	2.17"	1.45"	.5"	.75"	2.5"	1/2"
15"	8210-38608	5.06"	2.68"	1.68"	.5"	.75"	3"	5/8"
18"& Up*	2980-38608	5.06"	2.93"	1.65"	.5"	.75"	3"	3/4"

# Top Tooling

## 1.5mm x 60° and 3mm x 60° Serrations

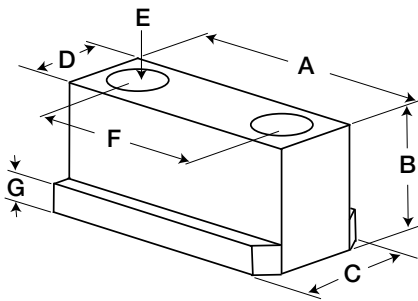
For: Pratt Burnerd, Howa, Kitagawa, Matsumoto and others

### Soft Jaws



Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Hole Spacing F	Offset Pointed Part Number	Offset Length A	H	Extra High Part Number	Extra High B Height
6"	8140-17525	3.125"	1.5"	1.25"	.475"	M10	.78"	N/A	-	-	N/A	-
8"	8140-21525	3.5"	2.0"	1.5"	.551"	M12	1.0"	8140-21525OP	4.25"	2.45"	8140-21525EH	3.5"
10"	8140-26525	4.0"	2.0"	1.5"	.630"	M12	1.18"	8140-26525OP	5.0"	3.15"	8140-26525EH	3.5"
12"	8140-31525	5.25"	2.0"	2.0"	.71"	M14	1.18"	8140-31525OP	6.25"	4.15"	8140-31525EH	3.5"
12"	8140-B212	5.5"	2.0"	2.0"	.826"	M16	1.18"	8140-B212OP	6.25"	4.15"	8140-B212EH	3.5"
15" & 18"	8140-40525	6.5"	2.5"	2.5"	.866"	M20	1.69"	8140-40525OP	7.5"	4.41"	8140-40525EH	3.5"
20" & 24" **	8140-50525	7.0"	2.5"	2.5"	.984"	M20	2.36"	8140-50525OP	8.0"	-	8140-50525EH	3.5"

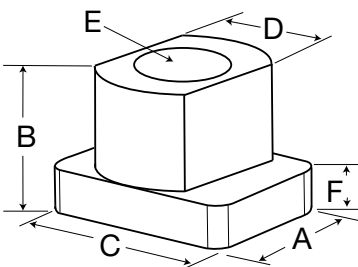
\* 6" Jaw Part No. 8140-17525 Comes Standard as Offset Pointed \*\* 20" & 24" Jaws have 3mm x 60° Serrations



### T-Nuts: for Atlas ATL Series and Kitagawa Chucks (inch/mm)

Chuck Size	Part Number	Length A	Height B	Width C	Neck D	Bolt Size E	Hole Spacing F	Shoulder G
6"	N206-10	1.417/36	.728/18.5	.689/17.5	.472/12	M10	.787/20	.295/7.5
8"	N208-10	1.83/46.5	.807/20.5	.807/20.5	.551/14	M12	.984/25	.335/8.5
10"	N210-10	2.0/51	8.46/21.5	.886/22.5	.629/16	M12	1.18/30	.335/8.5
12"	N212-10	2.18/55.5	1.095/27.8	1.16/29.5	.826/21	M16	1.18/30	.453/11
15"/18"	N215-10	3.15/80	1.791/45.5	1.32/33.5	.945/24	M20	1.69/43	.649/16.5
20"/24" **	V224-10	1.81/46	1.77/45	1.476/37.5	.984/25	M20	Split Design	.748/19

\* Part No. V224-10 Spit T-Nut design 2 required per jaw



### T-Nuts: for PBA Constant Grip, Quick Change Jaw Chucks and PBA Setrite Power Chucks (Split type) 2 required per jaw

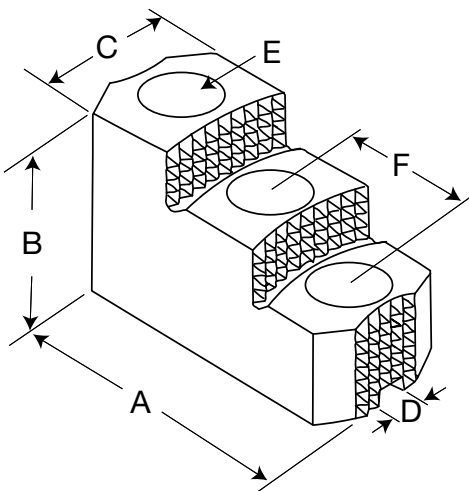
Chuck Size	Part Number	Length A	Height B	Width C	Neck D	Bolt Size E	Shoulder F
6"	8130-17590	.64"	.82"	.69"	.472"	M10	.30"
8"	8130-21590	.74"	.98"	.87"	.550"	M12	.37"
10"	8130-26590	.74"	1.0"	.91"	.627"	M12	.34"
12"	8130-31590	.97"	1.3"	1.03"	.707"	M14	.53"
15" - 18"	8130-40590	.97"	1.75"	1.32"	.864"	M20	.62"
20" & Up	8130-50590	1.2"	1.47"	1.32"	.980"	M20	.43"

### \*Hard Top Jaws: for PBA, Kitagawa and others (Split T-Nut Req'd)

Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Bolt Spacing F
6"	8130-17624	2.56"	1.57"	1.18"	.475"	M10	.669"
8"	8130-21624	2.95"	1.96"	1.57"	.551"	M12	.748"
10"	8130-26624	2.95"	1.96"	1.57"	.63"	M12	.748"
12"	8130-31624	4.52"	2.36"	1.96"	.71"	M14	.948"
15" & 18"	8130-40624	4.92"	2.95"	2.36"	.866"	M20	.948"
20" & Up **	8130-50624	6"	2.95"	2.36"	.984"	M20	2.36"

\* Some manufacturers' "F" dimension may vary. It may be necessary to buy split T-nuts or split existing nuts

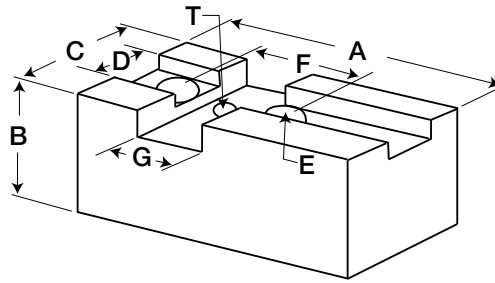
\*\* 20" & up" Jaws have 3mm x 60° Serrations



# Top Tooling

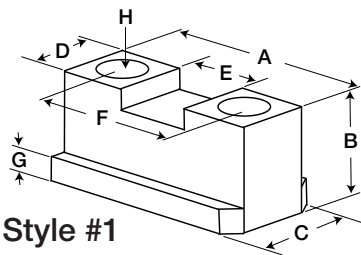
## Square Serrations

For: Pratt Burnerd, S.P., Cushman, Logansport and others

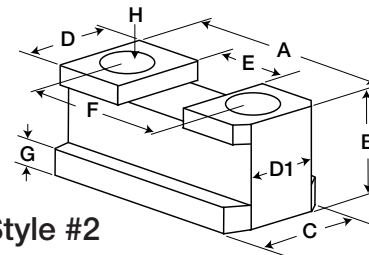


### Soft Jaws

Chuck Size	Part Number	Length A	Height B	Width C	Tongue D	Bolt Size E	Hole Spacing F	Key Slot G
8"	8140-21527	3.0"	2.0"	1.25"	.5"	3/8"	1.437"	.745"
10"-12"	8140-26527	4.37"	2.5"	1.75"	.75"	1/2"	1.75"	.994"
15"-18"	8140-38527	5.0"	3.0"	2.0"	1.0"	3/4"	2.5"	1.488"



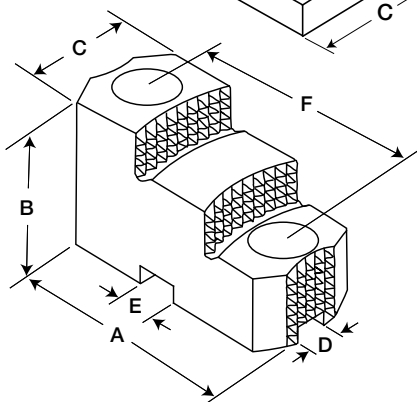
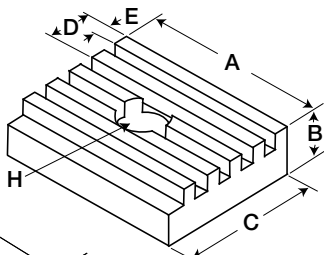
Style #1



Style #2

### T-Nuts

Chuck Size	Part Number	Style Number	Length A	Height B	Width C	Neck D	Bolt Neck D1	Cross Size H	Bolt Slot E	Spacing F	Shoulder G
8"	8130-21528	1	2.12"	.99"	.87"	.49"	-	3/8"-16	.875"	1.44"	.31"
10"	8130-26528	2	2.5"	1.13"	.86"	.74"	.61"	1/2"-13	1.063"	1.75"	.40"
10"-12"	8130-25528	1	2.44"	1.0"	1.0"	.74"	-	1/2"-13	1.063"	1.75"	.37"
12"	8130-31528	1	2.5"	.98"	1.02"	.74"	.61"	5/8"-11	1.063"	1.75"	.35"
15"-18"	8130-40528	1	3.75"	1.25"	1.25"	1.0"	-	3/4"-10	1.563"	2.5"	.43"



### Keys

Chuck Size	Part Number	A	Length B	Height C	Width D	E	Bolt Size H
8"	2179-00856	1.31"	.37"	.744"	.2"	.098"	1/4"-20
10"-12"	2179-01056	1.68"	.5"	.993"	.25"	.124"	5/16"-18
15"-18"-21"	8130-40529	2.50"	.5"	1.487"	.25"	.124"	3/8"-16

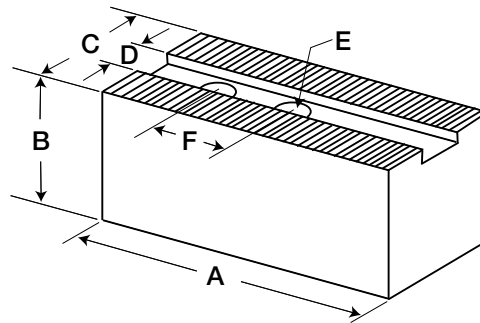
### Hard Top Jaws

Chuck Size	Part Number	Length A	Height B	Width C	Tongue D	Key Slot E	Hole Spacing F	Bolt Size
10"-12"	8130-26327	4.87"	2.5"	1.75"	.75"	.994"	1.75"	1/2"
15"-18"	8130-38327	5.5"	3.5"	2.25"	1.0"	1.488"	2.5"	3/4"

# Top Tooling

## 1/16" x 90° and 3/32" x 90° Serrations

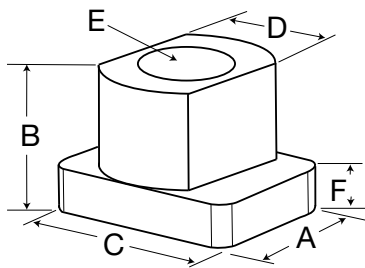
For: Pratt Burnerd and others



### Soft Jaws

Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Hole Spacing F
6"	8140-17512	2.75"	1.5"	1.25"	.475"	M8	.79"
8"	2860-21512	3.25"	2.0"	1.5"	.670"	M12	1"
10"	2860-21512	3.25"	2.0"	1.5"	.670"	M12	1"
12"	2860-32512	4.5"	2.5"	2.0"	.830"	M16	1.25"
15"&24"*	2860-40512	6.0"	3.0"	2.0"	1.00"	M20	1.56"

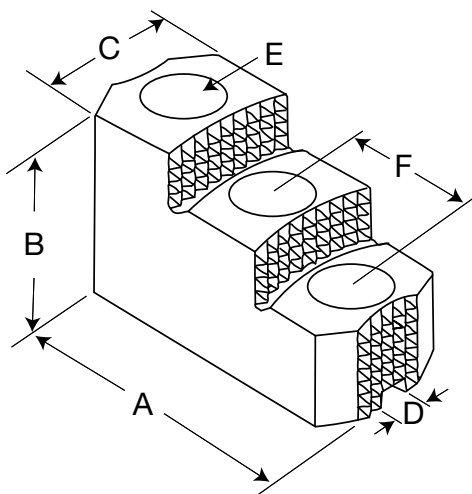
\*3/32" x 90° serrations



### T-Nuts 2 required per jaw

Chuck Size	Part Number	Length A	Height B	Width C	Neck D	Bolt Size E	Shoulder
6"	8820-17591	.47"	.82"	.69"	.470"	M8	-
8"	2870-17591	.88"	.91"	.73"	.669"	M12	.35
10"	2870-17591	.88"	.91"	.73"	.669"	M12	.35
12"	2870-26591	1.12"	1.06"	.94"	.826"	M16	.43
15"-24"	2870-40591	1.10"	1.14"	1.42"	.999"	M20	.43

Top Tooling



### Hard Stepped Top Jaws

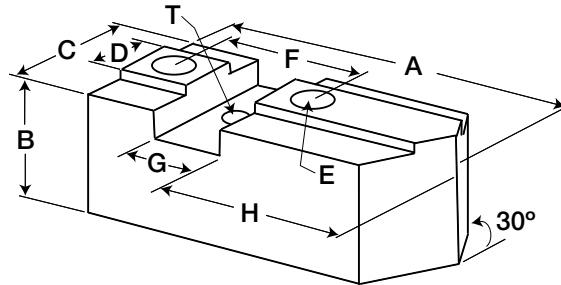
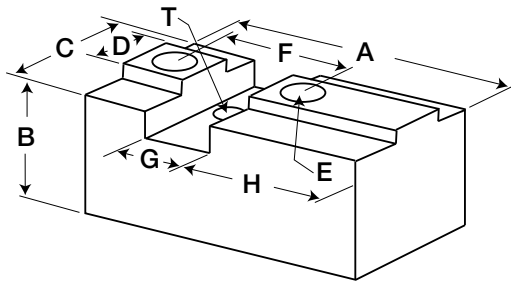
Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Bolt Spacing F
6"	8130-17611	2.56"	1.56"	1.18"	.475"	M8	.67"
8"	8130-21611	3.00"	1.97"	1.57"	.670"	M12	.75"
10"	8130-21611	3.00"	1.97"	1.57"	.670"	M12	.75"
12"	8130-31611	4.92"	2.36"	2.36"	.830"	M16	.98"
15"&24"*	8130-40611	4.92"	2.95"	2.36"	1.00"	M20	1.22"

\*3/32" x 90° serrations

# Top Tooling

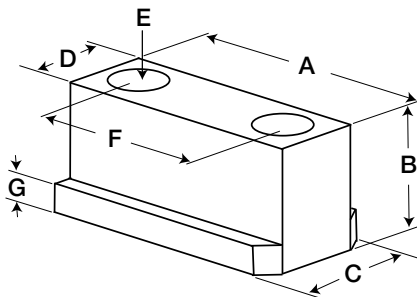
## American Standard Acme Serrations

For: Pratt Burnerd, Buck, Cushman, S. P. and others



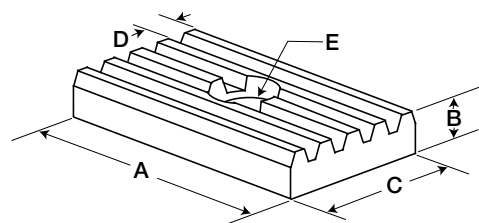
### Soft Jaws

Chuck Size	Part Number	Length A	Height B	Width C	Tongue D	Bolt Size E	Hole Spacing F	Key Slot G	H	Tapped Hole T	Offset Pointed Part Number	Offset Pointed A	H	Extra High Part Number	Extra High B
8"	7749-22038	3.75"	2.0"	1.5"	.67"	1/2"	1.25	.601"	2.12"	10-24	7749-22038OP	N/A		7749-22038EH	N/A
10"	7749-26047	4.12"	2.31"	1.75"	.75"	1/2"	1.75"	1.031"	2.12"	5/16"-18	7749-26047OP	5.5"	3.5"	7749-26047EH	3.31"
12"	7749-32056	5.12"	2.31"	1.75"	.875"	5/8"	2.0"	1.031"	2.87"	5/16"-18	7749-32056OP	5.5"	3.25"	7749-32056EH	3.31"
15",18"&20"	8140-40533	6.0"	3.31"	2.5"	1.0"	3/4"	2.5"	1.531"	2.62"	3/8"-16	8140-40533OP	7.5"	4.25"	8140-40533EH	4.81"
21"-UP	8140-50533	6.0"	3.31"	3.0"	1.25"	7/8"	3.0"	1.531"	2.62"	3/8"-16	8140-50533OP	7.5"	4.25"	8140-50533EH	4.81"



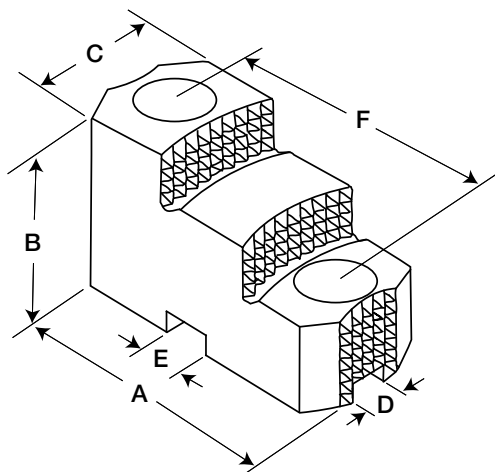
### T-Nuts

Chuck Size	Part Number	Length A	Height B	Width C	Neck D	Bolt Size E	Hole Spacing F	Shoulder G
8"	2749-02407	2.0"	1.0"	.94"	.670"	1/2"-13	1.25"	.44"
10"	2749-02417	2.5"	.64"	.94"	.678"	1/2"-13	1.75"	.38"
12"	2749-02427	3.0"	.74"	1.06"	.802"	5/8"-11	2.0"	.44"
15",18"&20"	8130-40531	3.5"	.93"	1.25"	.933"	3/4"-10	2.5"	.55"
21&Up	8130-50531	4.25"	1.18"	1.55"	1.159"	7/8"-9	3.0"	.68"



### Keys

Chuck Size	Part Number	Length A	Height B	Width C	D	Bolt Size E
8"	2749-02405	1.5"	.38"	.6"	.156"	10-24
10" & 12"	2749-02415	1.70"	.5"	1.030"	.25"	5/16"-18
12"	2749-02425	2.25"	.5"	1.030"	.25"	5/16"-18
15" & Up	8130-40530	2.87"	.5"	1.530"	.25"	3/8"-16



### Hard Top Jaws

Chuck Size	Part Number	Length A	Height B	Width C	Tongue D	Slot E	Bolt Spacing F
8"	7749-22036	3.50"	2.0"	1.75"	.67"	.601"	1.25"
10"	7749-26042	4.25"	2.50"	1.75"	.75"	1.031"	1.75"
12"	7749-32052	4.87"	2.50"	1.75"	.87"	1.031"	2.0"
15",18"&20"	8130-40632	5.5"	3.31"	2.5"	1.0"	1.531"	2.5"
21 & UP	8130-50532	6.5"	3.31"	2.5"	1.25"	1.531"	3.0"

# Machining Soft Blank Top Jaws

Standard hard top jaws can be used for most normal work. Soft jaws may be used for second operation work, for previously machined surfaces to prevent part marring and for improved concentricity. Soft jaws are generally machined to size, in position on chuck or formed into the desired shape for holding difficult shaped workpieces.

Soft jaws generally conform to existing industry standards or accepted standards to fit master jaws that may have fine, metric, acme or square serrations or have tongue and groove type cross tenon mount.

Steel used in making soft jaws is mostly mild, low carbon content capable of being case hardened through specific heat treating steps. Due to clamping force factors (heavy jaws reduce clamping force and rpm's) reducing weight thru use of lighter materials such as aluminum may be considered. All jaws should be designed and formed keeping in mind the potential grip force loss due to centrifugal forces.

The initial fitting of the top jaws to the chuck prior to machining is important if repeat accuracy is to be achieved. For all types except on chucks with fine serrated base jaws, the jaws should be loaded radially outward to take up any fitting clearance prior to tightening the jaw screws. This applies to top jaws which are intended to hold a workpiece externally. In the case of internal gripping the jaws should load inwards.

Operate the chuck several times gripping a suitable size piece of material to load the top jaws back and then lock the base jaws in their approximate mid-stroke position. On chucks which accept collet pads a suitable sized ring may be placed in the collet seating diameter of the chuck's base jaws. If extreme accuracy is not required the jaws may then be turned directly to the size required to suit the gripped workpiece diameter. On long grip faces a back taper should be allowed to ensure that the jaws initially contact the workpiece at their outer end. A back taper of .003"t per inch on jaw height will be found adequate in most cases.

Where very accurate concentricity is required top jaws should be machined as described previously but to accept a suitable loading ring rather than the workpiece itself. The ring should be thin axially but of sufficient radial thickness

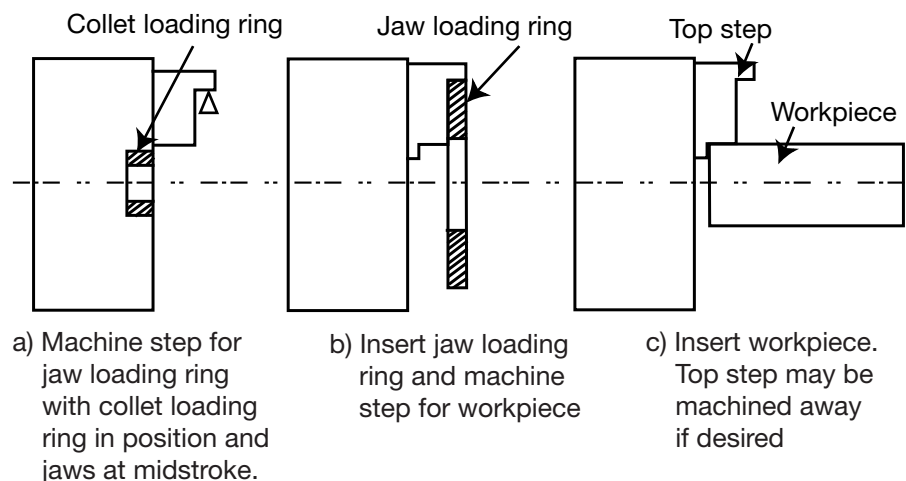
to withstand the gripping force. A diameter is machined to receive the ring at the outer end of the jaws with the chuck in its mid stroke condition, master jaws are flush with the chuck body. The ring previously fitted to the base jaw collet seating diameter is removed after first opening the chuck. The jaws are then closed to grip the loading ring in the top jaws. This effectively pre-loads the top jaws in a similar manner to the loading which occurs when the workpiece is gripped.

The top jaws are then machined to hold the workpiece. Since the top jaws are fully loaded during machining it is generally unnecessary to include any back taper on the gripping face as this occurs automatically. The jaws are then opened and the loading ring removed. If the top step of the jaw used for holding the loading ring interferes with the workpiece then it may be machined away. Otherwise it should be left on to allow the jaws to be reskimmed at a later date with the loading ring in position. The procedure for carrying out this operation is shown in figure 3.

To obtain good concentricity it is important that the top jaws are loaded in an identical manner when holding the ring as when gripping the workpiece. Thus the same chuck operating pressure should be used and the ring should be held either externally or internally to suit the particular case.

If care is taken in machining top jaws, concentricity between a turned diameter and the gripped diameter of .001" TIR can be achieved. As an aid to improving concentricity it is better when loading the workpiece if the chuck is positioned with a single rather than two jaws at the bottom. Simultaneous location on two jaws can cause a trapping effect on large diameter workpieces as the workpiece is lifted to contact the third jaw. This may be detrimental if very accurate concentricity is demanded.

Figure 3 - Machining Soft Jaws





# Guide to Top Tooling

Top jaws should be designed to hold the workpiece as close to the chuck face as possible. Excessive jaw height reduces the effective gripping force available and is detrimental to accuracy. As a general rule the height of the grip point above the chuck front face should not exceed one-quarter of the chuck's diameter. Thus for a 12 inch chuck the height of the grip point should not exceed 3 inches.

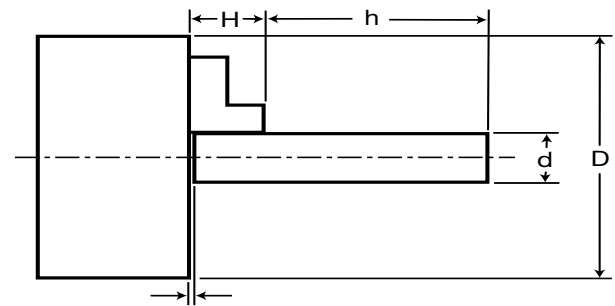
Large heavy top jaws should be avoided if possible since the loss in gripping force due to centrifugal effects at high spindle speeds is increased. If heavy jaws are unavoidable it may be necessary to restrict the spindle speed below the chuck's maximum recommended speed to ensure that sufficient gripping force is retained to hold the workpiece.

All top jaws in a set should be of equal weight to ensure no large out-of-balance forces occur. In the case of workpieces with a residual out-of-balance this may be corrected by designing the top jaws to counteract the imbalance component. Alternatively, it may be necessary to restrict the machine spindle to low speeds to avoid possible vibration problems.

Ideally, top jaws should not extend beyond the chuck periphery. If this is unavoidable, the amount of projection should be restricted within safe limits bearing in mind that the loss in gripping force due to centrifugal effect is a function of the product of top jaw mass and the distance to the jaws center of mass about the chuck's rotational axis. Precautions should also be taken to ensure that projecting top jaws will not collide with tooling during the machining cycle.

Care should be exercised in machining workpieces whose length protrudes excessively beyond the chuck jaws. As a general guide, for workpieces up to approximately one-third of the chuck diameter whose inner end face is located close to the chuck, machining should not be carried out at a distance greater than five times the workpiece diameter or three times the axial length gripped by the jaws measured from the outer end of the jaws. The lesser of these two values should be used and the maximum height of the top jaws should be restricted to one-quarter of the chuck diameter. The proportions for this condition are shown in figure 1.

Figure 1 For  $d$  less than  $D/3$



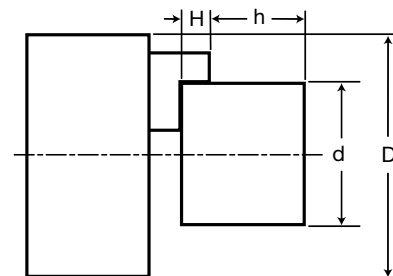
Workpiece close to chuck face

Max  $h = 3H$  or  $5d$  whichever is the smallest  
Max  $H = 1/4D$

If the protrusion of the workpiece exceeds this amount then support by the tailstock and/or use of a steady rest should be considered.

When the workpiece diameter is greater than approximately one-third of the chuck diameter and the workpiece is well-supported axially close to its outer periphery, the distance to the machining point from the outer end face of the jaws should not normally exceed three-quarters of the workpiece diameter. This is based on the assumption that the axial length of the workpiece gripped by the jaws is not less than one-tenth of the workpiece diameter. The proportions for this condition are shown in figure 2.

Figure 2 For  $d$  greater than  $D/3$



Max  $h = 3/4d$  Min  $H = 1/10d$

If these conditions cannot be satisfied, support by the machine's tailstock should be considered.

With slender or thin-walled tubular workpieces, care should be taken to ensure that the workpiece is sufficiently rigid to withstand the cutting force incurred.

The position of the top jaw securing screws is important with tee-slotted and serrated type jaws, particularly when split tee nuts are used. The centers of the screws should always be within the length of the base jaw. In addition, the center distance between pairs of screws on chucks

with split tee nuts should always be as large as possible to restrain any lifting effect. It is particularly important that the inner screws should be as far forward as possible to counteract the couple arising from application of the gripping force at some distance above the chuck face.

If distortion occurs with thin-walled workpieces, the amount may be reduced by lowering the chuck's operating pressure thus reducing the gripping force. In general the amount of distortion reduces in direct proportion to gripping force. Thus, halving the gripping force will reduce distortion to one-half of the original amount. Extreme care should be exercised in lowering the chuck's operating pressure since the resulting lower gripping force may be inadequate to hold the workpiece at high speed due to the effect of centrifugal force. In many cases it is better to overcome distortion problems by using wraparound top jaws. These should preferably contact the workpiece circumferentially at six-equally spaced points with the gripping force distributed equally between all six points. If this ideal arrangement is achieved the resulting distortion will be reduced to approximately 1/20th of that experienced with an equivalent total gripping force distributed over only three grip points. When the diameter to be gripped is not perfectly round the provision of a rocking top jaw arrangement may be necessary to ensure that the total gripping force is equally distributed between all six grip points.

Where it is desired to ensure that the turned end face of a workpiece is perfectly parallel with a previously machined rear face, the use of end location stops should be considered. These are fitted directly to the chuck body so that the machined face of the workpiece rests against them rather than on the top jaw step faces. Tapped holes are provided in most chucks on their front face for this purpose. Three locators of equal length should be used, positioned at as large a diameter as possible. For extreme accuracy the end faces of the locators may be machined in position on the chuck with the top jaws temporarily removed.

Top jaws can be used for holding workpieces either externally or internally and should be positioned on the chuck's base jaws accordingly. When fitting top jaws they should be located to grip the mean workpiece diameter at the master jaw at mid-stroke position, which is indicated when master jaws are flush with the chuck O.D.

The effect of variations in workpiece grip diameters should be considered to ensure in the workpiece maximum metal condition that sufficient clearance exists with the jaws fully

opened to permit insertion of the workpiece. It is even more important to ensure that in the workpiece minimum metal condition the jaws do not close an excessive amount to guarantee that the workpiece is securely gripped. The latter is important from a safety aspect since it is possible with an undersize workpiece for the jaws to close to their end-of-stroke position while only loosely holding the part. As a safety check to ensure that the workpiece is gripped, rotating hydraulic cylinders can be fitted with electrical proximity probes to detect the end-of-stroke condition.

The length of the workpiece and its axial location when loaded are important to prevent an excessive depth of cut occurring during end facing operations. This in the extreme case may dislodge the workpiece from the chuck jaws. Similarly, variations in unmachined diameters of forged and cast workpieces should be considered to ensure that an excessive depth of cut does not inadvertently occur. In certain cases an additional preliminary pass of the tool may be necessary in the interest of safety.

Always check that all the top jaw securing screws are correctly tightened. Avoid over-tightening as this can spread the width of tee-slotted master jaws, distorting them and tightening their fit in the chuck body. Use top jaws conforming to flatness and fit tolerance standards since poor quality top jaws can also promote distortion of the chuck's master jaws. Cheap soft blank top jaws not conforming to the tolerance standards can be dangerous and should not be used.

**Pratt Burnerd's Constant Grip, Quick Change Jaw Chuck** will accept collet pads. Collet pads are ideal for bar stock work and are fitted to the inner end of the base jaws. Always ensure that the pads are correctly secured but do not over-tighten the pad expander plug as this can distort the chuck's base jaws.

Do not leave loose keys or tee nuts in the chuck as these will be thrown out if spindle rotation is started and may cause damage or injury. Always check that the workpiece is correctly loaded and securely gripped and ensure that the covers and guards are in place before commencing spindle rotation.

Please understand that the foregoing recommendations can only act as a general guide and may require modification depending on other factors such as the severity of the machining operation being carried out particularly where interrupted cutting conditions appertain.



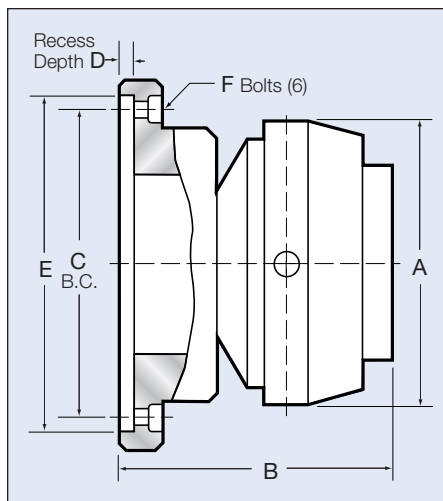
# Manual Collet Chucks

## Key Operated KC Series

- 🔧 Two-year warranty
- 🔧 .001" repeatability
- 🔧 Capacities from 1/16" through 2½"
- 🔧 Precision manufactured to fit types A, D and L spindles and adapter recess
- 🔧 Steel components are hardened and ground
- 🔧 Simple operation. No drawbar or actuating cylinder required

For KC Collets see page 110

Chuck Size	Capacity	Uses Collet Type	Adapter Recess Model No.	Type A Spindle		Type D Spindle		Type L Spindle	
				Spindle Size	Chuck Model No.	Spindle Size	Chuck Model No.	Spindle Size	Chuck Model No.
KC15	1/16" - 1-1/2"	EC	KC15/AP (6010-01300)	A-5	6011-31300	D-3	6012-21300	L-00	6013-11300
				A-6	6011-41300	D-4	6012-31300	L-0	6013-21300
						D-5	6012-41300		
						D-6	6012-51300		
KC25	1/2" - 2-1/2"	EE	KC25/AP (6010-02100)	A-6	6011-42100	D-6	6012-52100	L-1	6013-32100
				A-8	6011-52100	D-8	6012-62100	L-2	6013-42100
						D-11	6012-72100		



Other mounting available upon request.

### Dimensional and Performance Data

Chuck Size	A	B	C	D	E	F	Max rpm	Wt lbs
KC15/AP	4.65	4.56	5.51	.15	4.921	M10	4000	16
KC25/AP	6.00	5.15	6.93	.15	6.299	M10	3000	30

HOW TO ORDER: State quantity, model number, spindle specification and shipping instructions.



## KC Series Multisize Collets

### Advantages of the Pratt Burnerd Multisize Collets

#### WIDE RANGE CAPACITY

Each multisize collet has a gripping range of .125" with an extended range of .010" above and below each nominal size for a total range of .145" per collet.

#### ADAPTABILITY

Fractional, decimal, metric and non-standard bar sizes are all accommodated as the collet range is stepless. The collets will accept round and hexagonal bars.

#### UNEQUALLED ACCURACY

Each collet is inspected to .0005 maximum eccentricity at the nose of the collet.

#### NO DISTORTION

Geometrically designed. Ensures freedom from collet distortion and provides constant parallel grip throughout the gripping range with even wear and long life.

#### ALL STEEL COLLETS

Collet blades are all hardened and ground.

#### INTERCHANGEABILITY

Multisize collets are interchangeable between the various types of Pratt Burnerd collet chucks.

#### MULTISIZE COLLETS

Multisize collets are available with smooth blades or serrated blades for gripping black or scaly type material.

Use with chucks prefixed by No.	KC-15	KC-25
Capacity Collets	Collet Numbers	Collet Numbers
1/16 - 3/16	EC2 3150-30200	-
1/8 - 1/4	EC3 3150-30300	-
1/4 - 3/8	EC4 3150-30400	-
3/8 - 1/2	EC5 3150-30500	-
1/2 - 5/8	EC6 3150-30600	EE6 3150-50600
5/8 - 3/4	EC7 3150-30700	EE7 3150-50700
3/4 - 7/8	EC8 3150-30800	EE8 3150-50800
7/8 - 1	EC9 3150-30900	EE9 3150-50900
1 - 1-1/8	EC10 3150-31000	EE10 3150-51000
1-1/8 - 1-1/4	EC11 3150-31100	EE11 3150-51100
1-1/4 - 1-3/8	EC12* 3150-31200	EE12 3150-51200
1-3/8 - 1-1/2	EC13* 3150-31300	EE13 3150-51300
1-1/2 - 1-5/8	-	EE14 3150-51400
1-5/8 - 1-3/4	-	EE15 3150-51500
1-3/4 - 1-7/8	-	EE16 3150-51600
1-7/8 - 2	-	EE1 3150-51700
2 - 2-1/8	-	EE18 3150-51800
2-1/8 - 2-1/4	-	EE19 3150-51900
2-1/4 - 2-3/8	-	EE20 3150-52000
2-3/8 - 2-1/2	-	EE21 3150-52100
Complete Set	EC14 3160-31300	EE22 3160-52100

\*For round stock only.

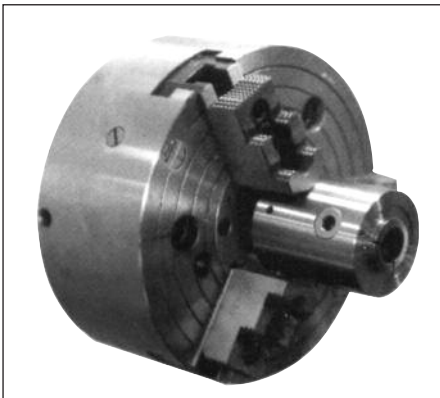
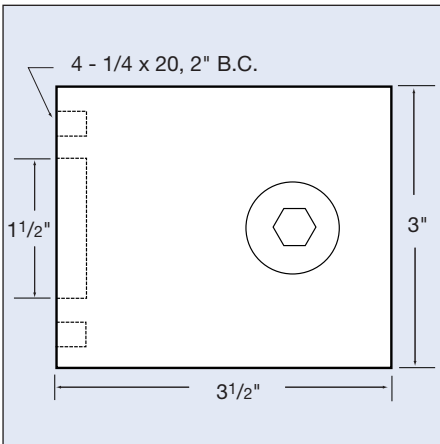
HOW TO ORDER: State quantity, Collet number and shipping instructions.



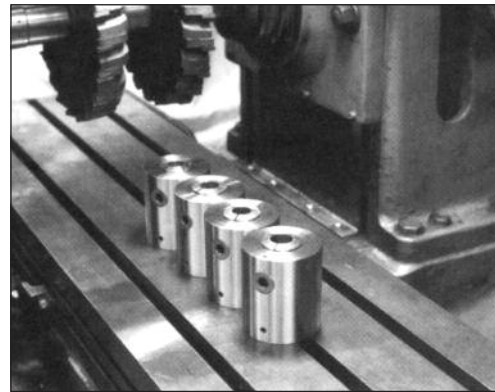
## Quick Change 5C Collet Chuck

### Atlas Model No. COL5C

- ⌚ One-year warranty
- ⌚ Quickly change from chuck work to collet work
- ⌚ Hold the collet chuck O. D. in your power or manual chucks
- ⌚ Mount in vertical mills, horizontal mills and machining centers
- ⌚ Drilled and tapped for fixture mounting
- ⌚ Dead length
- ⌚ Hardened and ground
- ⌚ No set-up
- ⌚ Hex key included



Ideal for short run production on CNC lathes. No tear down or change over

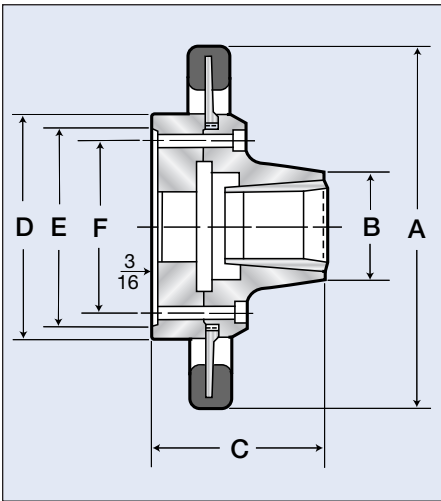


Stack units for multiple part production



# Front Hand Wheel Quickie 5C Collet Chucks

- ⚙️ Fast and easy, front hand wheel operation
- ⚙️ Reduces operator fatigue
- ⚙️ Quick Change over Chuck to Collet Chuck - No linkages or drawtubes
- ⚙️ For 5C collets
- ⚙️ One year warranty
- ⚙️ Accurate-Maximum cone TIR .0005"
- ⚙️ Available in D type (camlock), A type, L type (long tapered nose) threaded, Flat Back and 4° taper
- ⚙️ Hand wheel teeth nitrided for longer life
- ⚙️ Body nickel plated for corrosion resistance



Uses 5C Collets see page 88-89

## Plain Back Chuck Specifications

Item No.	Desc.	Collet Type	Round Cap.	A	B	C**	D	E	F	Weight
PB23-00	5C-PB	5C	1.06	9.0*	2.25	4.25	5.5	5.0	4.12	19

## D Type Cam-Lock Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB23-D3	D1-3	1.06	22
PB23-D4	D1-4	1.06	22
PB23-D5	D1-5	1.06	22
PB23-D6	D1-6	1.06	25
PB23-D8	D1-8	1.06	30
PB23-D11	D1-11	1.06	35

## A Type American Standard Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB23-A4	A1-4	1.06	22
PB23-A5	A1-5	1.06	22
PB23-A6	A1-6	1.06	25
PB23-A8	A1-8	1.06	28
PB23-A11	A1-11	1.06	33

## L Type American Standard Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB23-L00	L00	1.06	23
PB23-L0	L0	1.06	25
PB23-L1	L1	1.06	35
PB23-L2	L2	1.06	40

## Threaded Mount Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB23-41	1-1/2-8	1.06	23
PB23-42	1-3/4-8	1.06	23
PB23-43	2-1/4-8	1.06	23
PB23-44	4° Taper	1.06	25
PB23-45	2-3/16-10	1.06	23
PB23-46	2-3/8-6	1.06	23

\*\*Dimension C is chuck without spindle adapter mounting plate. Add approximately 1.125" to dimension C. If exact 'B' Dimension with mounting plate is required contact factory.



5C Collet Chuck



16C Collet Chuck

Uses 5C Collets see page 88-89  
or 16C Collets see page 90-91

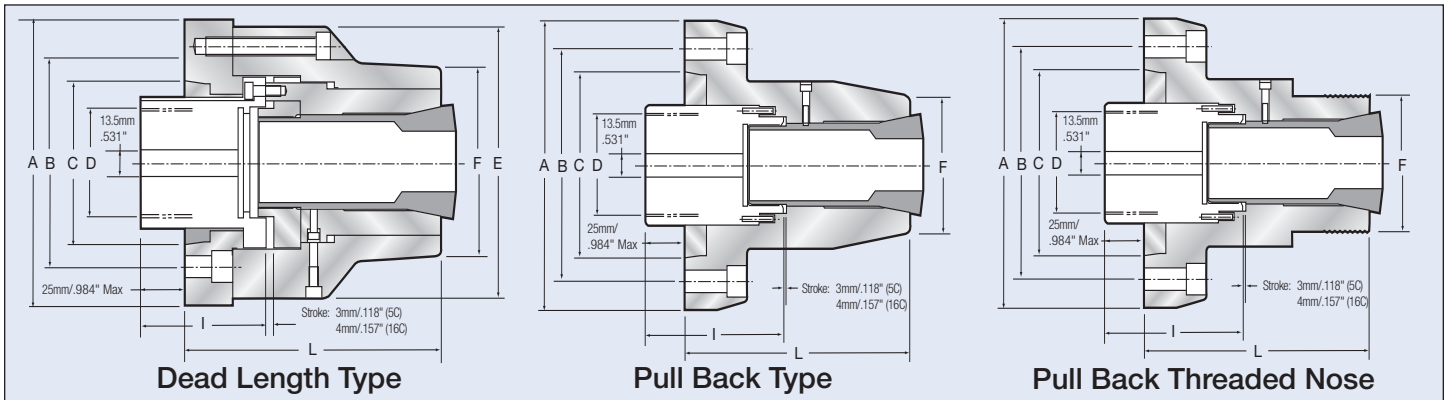
# 5C & 16C Dead Length & Pull Back Collet Power Chucks

## A Type Mount

- ⌚ Short overall length excellent for main or sub-spindle applications.
- ⌚ Chuck accuracy is 0003" TIR from rear mounting register and working collet taper.
- ⌚ High speed up to 6000 rpm ⌚ Body nickel plated for corrosion resistance
- ⌚ Hardened and ground main body and cone
- ⌚ Dead Length feature eliminates part pullback
- ⌚ Straight recess or available with A type mountings. Other mounting types available on request
- ⌚ In second operations work, shoulder components can be stopped against the face of the collet
- ⌚ Both collet types are internally threaded in the rear end to house either a backstop or ejector if required
- ⌚ Drawback Spring Collets achieve the highest possible concentric accuracy
- ⌚ Chuck includes threaded connector to customers specifications

## 5C & 16C Dead Length

Chuck Type	5C	5C	16C	16C
Spindle Mount	A2-5	A2-6	A2-5	A2-6
A (mm/in)	137/5.393	158/6.220	137/5.393	158/6.220
B (mm/in)	104.8/4.125	133.4/5.252	104.8/4.125	133.4/5.252
C (mm/in)	82.56/3.250	106.38/4.188	82.56/3.250	106.38/4.188
D (mm/in)	Max. M65	Max. M65	Max. M65	Max. M65
E (mm/in)	137/5.393	137/5.393	137/5.393	137/5.393
F (mm/in)	78/3.071	78/3.071	90/3.543	90/3.543
I (mm/in)	68/2.677	68/2.677	68/2.677	68/2.677
L (mm/in)	122/4.803	122/4.803	145/5.708	145/5.708
Maximum Force	1800kaf/3968lbf	1800kaf/3968lbf	2300kaf/5070lbf	2300kaf/5070lbf
Maximum RPM	6000	6000	5000	5000
Chuck Order No.	CPD-5CA5	CPD-5CA6	CPD-16CA5	CPD-16CA6



## 5C & 16C Pull Back

Chuck Type	5C	5C	5C Threaded	5C Threaded	16C	16C
Spindle Mounting	A2-5	A2-6	A2-5	A2-6	A2-5	A2-6
A (mm/in)	137/5.393	166/6.535	137/5.393	166/6.535	137/5.393	166/6.535
B (mm/in)	104.8/4.125	133.4/5.252	104.8/4.125	133.4/5.252	104.8/4.125	133.4/5.252
C (mm/in)	82.56/3.250	106.38/4.188	82.56/3.250	106.38/4.188	82.56/3.250	106.38/4.188
D (mm/in)	Max. M58	Max. M65	Max. M65	Max. M58	Max. M58	Max. M65
F (mm/in)	70/2.756	70/2.756	55/2.187-10T	55/2.187-10T	76/2.992	80/3.149
I (mm/in)	83/3.267	83/3.267	83/3.267	83/3.267	89/3.504	89/3.504
L (mm/in)	122/4.803	122/4.803	122/4.803	122/4.803	145/5.708	145/5.708
Maximum Force	1800kgf/3968lbf	1800kgf/3968lbf	1800kgf/3968lbf	1800kgf/3968lbf	2300kgf/5070lbf	2300kgf/5070lbf
Maximum RPM	6000	6000	6000	6000	5000	5000
Chuck Order No.	CPB-5CA5	CPB-5CA6	CPB-5CA5-TH	CPB-5CA6-TH	CPB-16CA5	CPB-16CA6

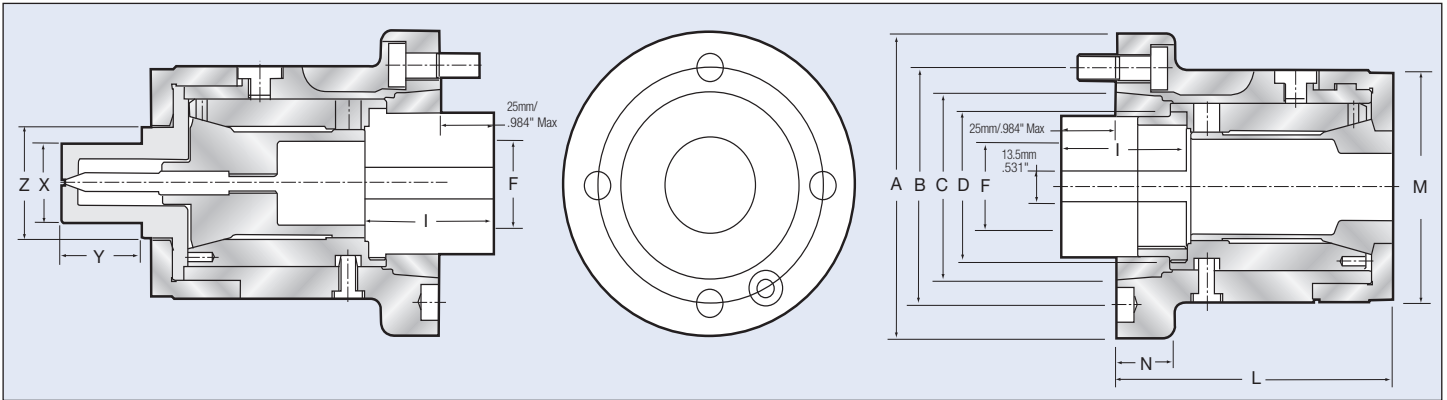


# CPC Series Dead-Length Collet Chucks

## Use with B type Spring or DIN 6343 Multibore Collets

Uses B Type Spring Collets  
see page 92-96  
or Din 6343 Multibore Collets  
see page 99

- ⓘ Ideal for bar work or for second operation work.
- ⓘ Precision dead-length operation
- ⓘ High speed up to 8000 rpm ⓘ Body nickel plated for corrosion resistance
- ⓘ Repeatability .0001" (0.0025mm) on duplicate parts
- ⓘ Large thru-hole up to 3.15" (80mm)
- ⓘ Collets are available for Round, Hex or Square parts
- ⓘ Large clamping force up to 16,060 lbf (7300 kgf)
- ⓘ CPC collet types: B42, B60 and B80 or Multi-Bore Din 6343 Collets
- ⓘ 1 Year Warranty
- ⓘ Chuck includes threaded connector to customers specifications



### CPC Series for B type Spring or DIN 6343 Multi-Bore Collets

Order Number	CPC-42A5	CPC-42A6	CPC-60A6	CPC-60A8	CPC-80A8
Spindle Mounting	A2-5	A2-6	A2-6	A2-8	A2-8
A (mm/in)	135/5.31	170/6.69	170/6.69	220/8.66	220/8.66
B (mm/in)	104.8/4.13	133.4/5.25	133.4/5.25	171.4/6.75	171.4/6.75
C (mm/in)	82.56/3.25	106.3/4.19	106.3/4.19	139.7/5.50	139.7/5.50
D	M66 x P15	M66 x P15	M90 x P15	M90 x P15	M114 x P2.0
F (Max Threading)	M60	M60	M90	M90	M100
I (mm/in)	57/2.244	69/2.176	66/2.598	66/2.598	72/2.834
M (mm/in)	103/4.06	103/4.06	132/5.20	132/5.20	155/6.10
N (mm/in)	27/1.06	32/1.26	27/1.06	32/1.26	35/1.38
L (mm/in)	129/5.08	133/5.24	155/6.10	155/6.10	175/6.89
X (mm/in) Std-Max	16/.63-50/1.968	16/.63-50/1.968	-	-	-
Y (mm/in) Std-Max	40/1.57-80/3.15	40/1.57-80/3.15	-	-	-
Mount Screw	M10 x 4	M12 x 4	M12 x 6	M16 x 6	M16 x 6
Collet (Spring/Multi-Bore)	B42/173E	B42/173E	B60/185E	B60/185E	B80/193E
Taper Stroke	6.0/0.24	6.0/0.24	6.0/0.24	6.0/0.24	6.0/0.24
Chuck Thru-Hole (mm/in)	42/1.65	42/1.65	60/2.36	60/2.36	80/3.15
Draw Bar Force (kgf/lbf)	2500/5500	2500/5500	3000/6600	3000/6600	3500/7700
Clamping Force (kgf/lbf)	5400/11800	5400/11800	6500/14300	6500/14300	7300/16060
Max rpm	6000	6000	5000	5000	4000
I.D Function	No	No	No	No	No

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.





Uses 5C Collets see page 88-89

**Collet Chuck Order No. with Mount:**

**ATL206-5C**

**Straight Recess Mount Type A Mount**

- ATL206-5CA4
- ATL206-5CA5
- ATL206-5CA6
- ATL206-5CA8

**Type D Mount**

- ATL206-5CD3
- ATL206-5CD4
- ATL206-5CD5
- ATL206-5CD6
- ATL206-5CD8

**Other Mounts**

- ATL206-5C43-2 1/4-8
- ATL206-5C44-4°-Taper
- ATL206-5C45-2 3/16-10
- ATL206-5C46-2 3/8-6

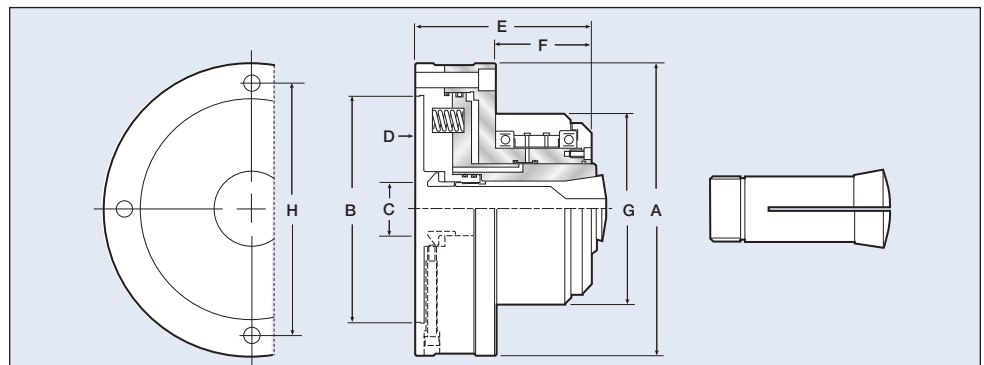
**Collet Chuck Supplied with:**

- 2 Filter Bars
- 2 Air Hoses
- 1 Fixing Bracket for Hoses
- 1 5C Collet Wrench
- 1 Hex Key
- Mounting Bolts
- Users Manual

# Air Powered Front Mount 5C Dead Length Collet Chucks

## No Draw-tube or Air Feed Tubes Required: for Lathes, Rotary Tables and Grinders: Series ATL206-5C

- ⊕ No Hydraulic System Required
- ⊕ No Draw Tube or Air Feed Tubes Restricting Spindle Bore
- ⊕ No Rear Cylinders and Cylinder Adapters
- ⊕ Low Cost
- ⊕ Easily Convert any Lathe or Grinder into a Production Machine
- ⊕ Ideal for Rotary Table Applications
- ⊕ Change from Collet Chuck to Standard Chuck Quick and Easy
- ⊕ High Speed 4000 RPM
- ⊕ High Accuracy Less Than .001" TIR
- ⊕ Repeats on Duplicate Parts Plus Minus .00015"
- ⊕ Dead Length Design
- ⊕ For Best Accuracy Use High Quality Crawford Collets
- ⊕ Lever or Foot Pedal Actuated
- ⊕ Low Maintenance with Oil Mist Lubrication System
- ⊕ High Resistance to Coolant and Chip Penetration
- ⊕ Uses 5C Collets, Range 1/64" (.5mm) to 1-1/8" (27mm)
- ⊕ Available in A, D, L, 4 Degree, Threaded and Straight Recess Mounting



Collet Chuck	ATL206-5C
A	168mm (6.61")
B	130mm (5.12")
C	26mm (1.02")
D	5mm (0.20")
E	100mm (3.94")
F	55mm (2.17")
G	106mm (4.17")
H	147mm (5.79")

Specifications	ATL206-5C
Screw Hole Dia	9mm (0.35") x 4
Collet Type	5C Collets
Max. RPM	4000
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm <sup>2</sup> (42-114 psi)
Through Hole Dia	26mm (1.06")
Chuck Weight	10kg (22lbs)
Grip Force	10,500 lbs @ 100 PSI

**NOTE:** "E" shown is for model ATL206-5C Collet Chuck with no mounting plate. Add 3/4" to the "E" dimension for mounting plate. This will vary slightly depending on the mounting required. If an exact "E" dimension is required, consult factory.

**OPTIONS:** Order No: **LEV100** Lever Control Package: (Includes: Lever Control, Line Filter, Lubricator and regulator.  
Order No: **FOT200** Foot Pedal Control Package: (Includes: Foot Pedal, Line Filter, Lubricator and regulator.)



Uses 16C Collets see page 90-91

**Collet Chuck Order No. with Mount:**

**ATL207-16CAP**

**Straight Recess Mount Type A Mount**

**ATL207-16CA5**

**ATL207-16CA6**

**ATL207-16CA8**

**Type D Mount**

**ATL207-16CD4**

**ATL207-16CD5**

**ATL207-16CD6**

**ATL207-16CD8**

**Other Mounts**

**ATL207-16C44-4° Taper**

**ATL207-16C45-2<sup>3</sup>/<sub>16</sub>-10**

**ATL207-16C46-2<sup>3</sup>/<sub>8</sub>-6**

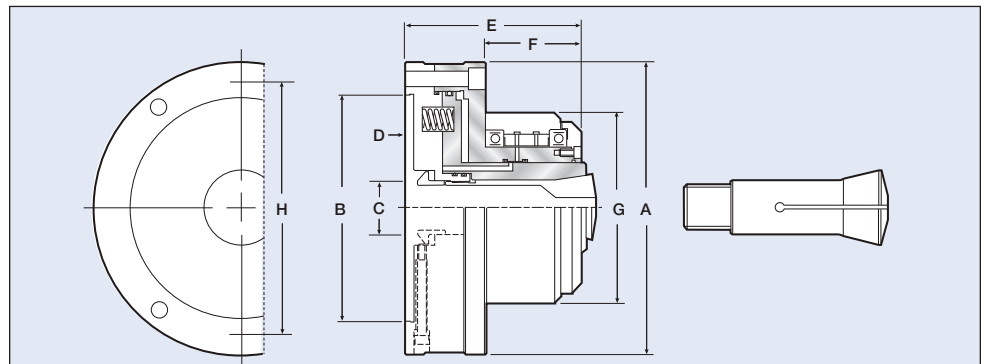
**Collet Chuck Supplied with:**

- 2 Filter Bars
- 2 Air Hoses
- 1 Fixing Bracket for Hoses
- 1 16C Collet Wrench
- 1 Hex Key
- Mounting Bolts
- Users Manual

# Air Powered Front Mount 16C Dead Length Collet Chucks

**No Draw-tube or Air Feed Tubes Required: for Lathes, Rotary Tables and Grinders: Series ATL207-16C**

- No Hydraulic System Required
- No Draw Tube or Air Feed Tubes Restricting Spindle Bore
- No Rear Cylinders and Cylinder Adapters
- Low Cost
- Easily Convert any Lathe or Grinder into a Production Machine
- Ideal for Rotary Table Applications
- Change from Collet Chuck to Standard Chuck Quick and Easy
- High Speed 3500 RPM
- High Accuracy Less Than .001" TIR7
- Repeats on Duplicate Parts Plus Minus .00015"
- Dead Length Design
- For Best Accuracy Use High Quality Crawford Collets
- Lever or Foot Pedal Actuated
- Low Maintenance with Oil Mist Lubrication System
- High Resistance to Coolant and Chip Penetration
- Uses 16C Collets, Range 1/16" (1mm) to 1-5/8" (42.5mm)
- Available in A, D, L, 4 Degree, Threaded and Straight Recess Mounting



Collet Chuck	ATL207-16C
A	195mm (7.67")
B	160mm (6.30")
C	40mm (1.57")
D	5mm (0.20")
E	112mm (4.41")
F	63mm (2.48")
G	133mm (5.23")
H	176mm (6.93")

Specifications	ATL207-16C
Screw Hole Dia	9mm (0.35") x 3
Collet Type	16C Collets
Max. RPM	3500
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm <sup>2</sup> (42-114 psi)
Through Hole Dia	40mm (1.57")
Chuck Weight	14kg (30.8lbs)
Grip Force	12,300 lbs @ 100 PSI

**NOTE:** "E" shown is for model ATL207-16C Collet Chuck with no mounting plate. Add 3/4" to the "E" dimension for mounting plate. This will vary slightly depending on the mounting required. If an exact "E" dimension is required, consult factory.

**OPTIONS:** Order No: **LEV100** Lever Control Package: (Includes: Lever Control, Line Filter, Lubricator and regulator.  
Order No: **FOT200** Foot Pedal Control Package: (Includes: Foot Pedal, Line Filter, Lubricator and regulator.



# Air Powered Front Mount B42 Dead Length Collet Chucks

**No Draw-tube or Air Feed Tubes Required: for Lathes,  
Rotary Tables and Grinders: Series ATL207-B42**

Uses B42 Collets see page 92-93

**Collet Chuck Order No.  
with Mount:**

**ATL207-B42**

**Straight Recess Mount  
Type A Mount**

**ATL207-B42A5**

**ATL207-B42A6**

**ATL207-B42A8**

**Type D Mount**

**ATL207-B42D4**

**ATL207-B42D5**

**ATL207-B42D6**

**ATL207-B42D8**

**Other Mounts**

**ATL207-B4244-4°-Taper**

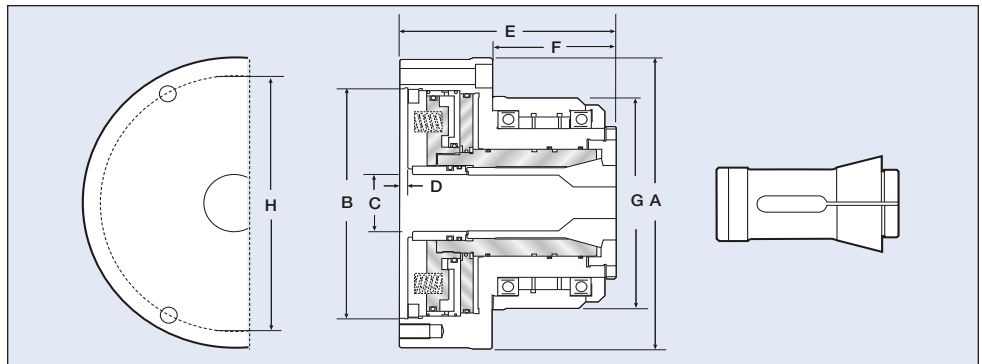
**ATL207-B4245-2<sup>3</sup>/<sub>16</sub>-10**

**ATL207-B4246-2<sup>3</sup>/<sub>8</sub>-6**

**Collet Chuck  
Supplied with:**

- 2 Filter Bars
- 2 Air Hoses
- 1 Fixing Bracket for Hoses
- 1 Hex Key
- Mounting Bolts
- Users Manual

- No Hydraulic System Required
- No Draw Tube or Air Feed Tubes Restricting Spindle Bore
- No Rear Cylinders and Cylinder Adapters
- Low Cost
- Easily Convert any Lathe or Grinder into a Production Machine
- Ideal for Rotary Table Applications
- Change from Collet Chuck to Standard Chuck Quick and Easy
- High Speed 2500 RPM
- High Accuracy Less Than .001" TIR
- Repeats on Duplicate Parts Plus Minus .00015"
- Dead Length Design
- For Best Accuracy Use High Quality Crawford Collets
- Lever or Foot Pedal Actuated
- Low Maintenance with Oil Mist Lubrication System
- High Resistance to Coolant and Chip Penetration
- Uses B42 Collets, Range 1/16" (1mm) to 1-5/8" (42.5mm)
- Available in A, D, L, 4 Degree, Threaded and Straight Recess Mounting



Collet Chuck	ATL207-B42
A	196mm (7.72")
B	155mm (6.10")
C	42mm (1.65")
D	5mm (0.20")
E	136mm (5.35")
F	75mm (2.95")
G	150mm (5.92")
H	172mm (6.77")

Specifications	ATL207-B42
<b>Screw Hole Dia</b>	11mm (0.43")x3 - M10xP1.5x3
<b>Collet Type</b>	B42 Collets
<b>Max. RPM</b>	2500
<b>Sleeve Stroke</b>	4mm (0.16")
<b>Air Pressure</b>	3-8 kg/cm <sup>2</sup> (42-114 psi)
<b>Through Hole Dia</b>	42mm (1.65")
<b>Chuck Weight</b>	16kg (35.2lbs)
<b>Grip Force</b>	13,000 lbs @ 100 PSI

**NOTE:** "E" shown is for model ATL207-B42 Collet Chuck with no mounting plate. Add 3/4" to the "E" dimension for mounting plate. This will vary slightly depending on the mounting required. If an exact "E" dimension is required, consult factory.

**OPTIONS:** Order No: **LEV100** Lever Control Package: (Includes: Lever Control, Line Filter, Lubricator and regulator.

Order No: **FOT200** Foot Pedal Control Package: (Includes: Foot Pedal, Line Filter, Lubricator and regulator.



# Air Powered Front Mount B60 Dead Length Collet Chucks

**No Draw-tube or Air Feed Tubes Required: for Lathes,  
Rotary Tables and Grinders: Series ATL208-B60**

Uses B60 Collets see page 94-95

**Collet Chuck Order No.  
with Mount:**

**ATL208-B60**

**Straight Recess Mount  
Type A Mount**

**ATL208-B60A5**

**ATL208-B60A6**

**ATL208-B60A8**

**Type D Mount**

**ATL208-B60D4**

**ATL208-B60D5**

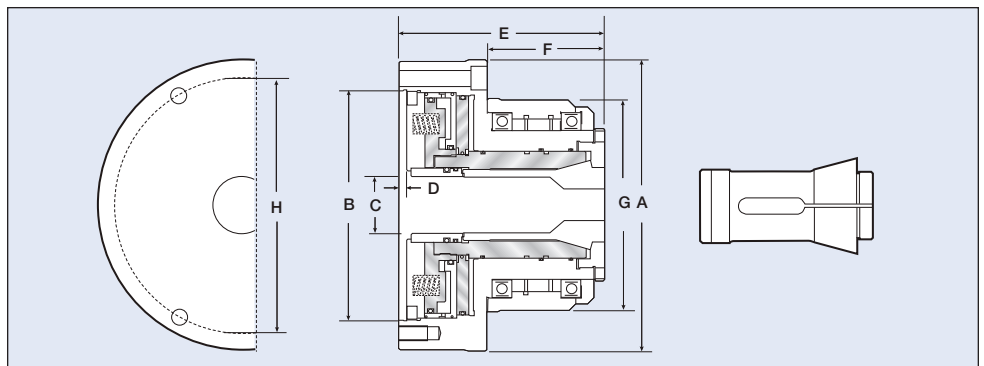
**ATL208-B60D6**

**ATL208-B60D8**

**Collet Chuck Supplied with:**

- 2 Filter Bars
- 2 Air Hoses
- 1 Fixing Bracket for Hoses
- 1 Hex Key
- Mounting Bolts
- Users Manual

- No Hydraulic System Required
- No Draw Tube or Air Feed Tubes Restricting Spindle Bore
- No Rear Cylinders and Cylinder Adapters
- Low Cost
- Easily Convert any Lathe or Grinder into a Production Machine
- Ideal for Rotary Table Applications
- Change from Collet Chuck to Standard Chuck Quick and Easy
- High Speed 2500 RPM
- High Accuracy Less Than .001" TIR
- Repeats on Duplicate Parts Plus Minus .0002"
- Dead Length Design
- For Best Accuracy Use High Quality Crawford Collets
- Lever or Foot Pedal Actuated
- Low Maintenance with Oil Mist Lubrication System
- High Resistance to Coolant and Chip Penetration
- Uses B60 Collets, Range 1/16" (1mm) to 2-3/8" (60.5mm)
- Available in A, D, L, Threaded and Straight Recess Mounting



Collet Chuck	ATL208-B60
A	207mm (8.15")
B	170mm (6.69")
C	60.5mm (2.37")
D	5mm (0.20")
E	148mm (5.83")
F	86mm (3.39")
G	168mm (6.61")
H	186mm (7.32")

Specifications	ATL208-B60
<b>Screw Hole Dia</b>	11mm (0.43")x3 - M10xP1.5x3
<b>Collet Type</b>	B60 Collets
<b>Max. RPM</b>	2500
<b>Sleeve Stroke</b>	4mm (0.16")
<b>Air Pressure</b>	3-8 kg/cm <sup>2</sup> (42-114 psi)
<b>Through Hole Dia</b>	65mm (2.375")
<b>Chuck Weight</b>	18.kgkg (42.6lbs)
<b>Grip Force</b>	15,950 lbs @ 100 PSI

**NOTE:** "E" shown is for model ATL208-B60 Collet Chuck with no mounting plate. Add 3/4" to the "E" dimension for mounting plate. This will vary slightly depending on the mounting required. If an exact "E" dimension is required, consult factory.

**OPTIONS:** Order No: **LEV100** Lever Control Package: (Includes: Lever Control, Line Filter, Lubricator and regulator.

Order No: **FOT200** Foot Pedal Control Package: (Includes: Foot Pedal, Line Filter, Lubricator and regulator.



Uses B80 Collets see page 96

**Collet Chuck Order No. with Mount:**

**ATL210-B80**

**Straight Recess Mount Type A Mount**

**ATL210-B80A5**

**ATL210-B80A6**

**ATL210-B80A8**

**Type D Mount**

**ATL210-B80D5**

**ATL210-B80D6**

**ATL210-B80D8**

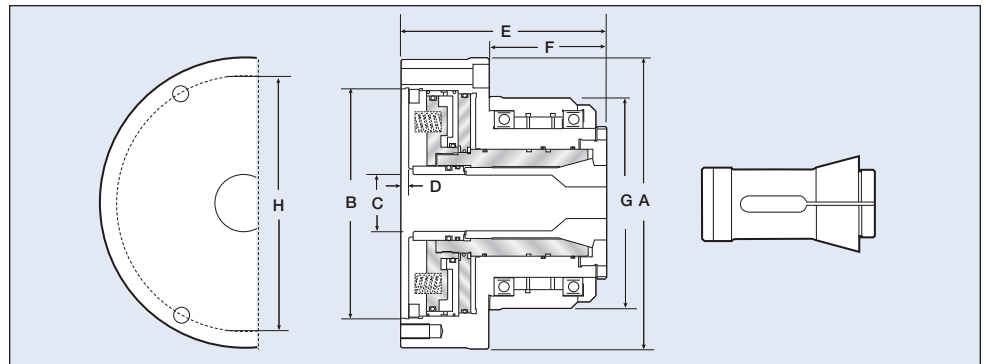
**Collet Chuck Supplied with:**

- 2 Filter Bars
- 2 Air Hoses
- 1 Fixing Bracket for Hoses
- 1 Hex Key
- Mounting Bolts
- Users Manual

# Air Powered Front Mount B80 Dead Length Collet Chucks

## No Draw-tube or Air Feed Tubes Required: for Lathes, Rotary Tables and Grinders: Series ATL210-B80

- ⌚ No Hydraulic System Required
- ⌚ No Draw Tube or Air Feed Tubes Restricting Spindle Bore
- ⌚ No Rear Cylinders and Cylinder Adapters
- ⌚ Low Cost
- ⌚ Easily Convert any Lathe or Grinder into a Production Machine
- ⌚ Ideal for Rotary Table Applications
- ⌚ Change from Collet Chuck to Standard Chuck Quick and Easy
- ⌚ High Speed 2000 RPM
- ⌚ High Accuracy Less Than .001" TIR
- ⌚ Repeats on Duplicate Parts Plus Minus .0002"
- ⌚ Dead Length Design
- ⌚ For Best Accuracy Use High Quality Crawford Collets
- ⌚ Lever or Foot Pedal Actuated
- ⌚ Low Maintenance with Oil Mist Lubrication System
- ⌚ High Resistance to Coolant and Chip Penetration
- ⌚ Uses B80 Collets, Range 1/16" (1mm) to 3.150" (80mm)
- ⌚ Available in A, D, L, Threaded and Straight Recess Mounting



Collet Chuck	ATL210-B80
A	246mm (9.67")
B	200mm (7.87")
C	80mm (3.15")
D	5mm (0.20")
E	152mm (5.98")
F	80mm (3.15")
G	196mm (7.72")
H	226mm (8.90")

Specifications	ATL210-B80
Screw Hole Dia	11mm (0.43") x 6
Collet Type	B80 Collets
Max. RPM	2000
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm <sup>2</sup> (42-114 psi)
Through Hole Dia	80mm (3.15")
Grip Force	19,932 lbs @ 100 PSI
Chuck Weight	32.kg (71.1lbs)

**NOTE:** "E" shown is for model ATL210-B80 Collet Chuck with no mounting plate. Add 3/4" to the "E" dimension for mounting plate. This will vary slightly depending on the mounting required. If an exact "E" dimension is required, consult factory.

**OPTIONS:** Order No: **LEV100** Lever Control Package: (Includes: Lever Control, Line Filter, Lubricator and regulator.

Order No: **FOT200** Foot Pedal Control Package: (Includes: Foot Pedal, Line Filter, Lubricator and regulator.

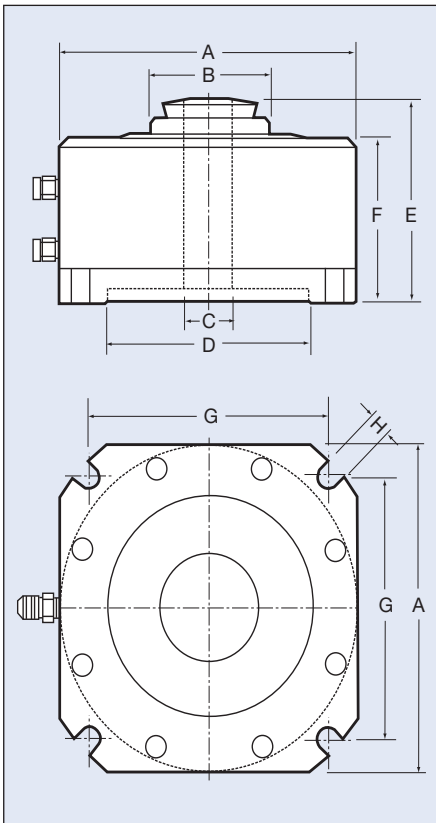


Uses 5C Collets see page 88-89

# Stationary ATL225-5C Dead Length Collet Chuck

**Use for Pallets, Tombstones, Machining Centers,  
Standard Mills and Drill Presses**

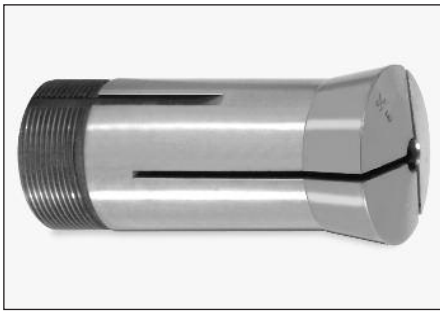
- ⌚ Powered by Air and/or Hydraulics
- ⌚ Small Foot Print
- ⌚ Low Cost
- ⌚ Easy to Install
- ⌚ Repeatability Plus Minus .0012"-.002" (0.030-0.050mm)
- ⌚ Dead Length Design
- ⌚ Lever or Foot Pedal Actuated
- ⌚ Low Maintenance with Oil Mist Lubrication System
- ⌚ High Resistance to Coolant and Chip Penetration
- ⌚ Low Maintenance, Long Life



ATL225-5C Collet Type

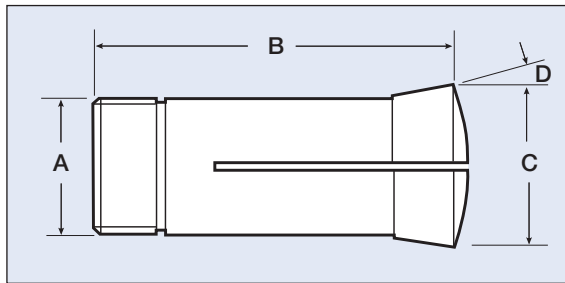
Order Number	ATL225-5C
A (mm/in)	144/5.67
B (mm/in)	55/2.17
C (mm/in)	26/1.02
D (mm/in)	100/3.94
E (mm/in)	95/3.74
F (mm/in)	75/2.95
G (mm/in)	117/4.65
H (mm/in)	8.5/0.33
Working Collet/Jaws	5C Collet
Air/Hydro Actuated	Air
Operating Pressure	3-15kg/cm <sup>2</sup> 43-214psi
Capacity Min. Max.	1.0mm/1/16" 27mm/1-1/8"
Piston Area	112cm <sup>2</sup> /17.4in <sup>2</sup>
Clamping Force	4950 kgf@7kg/cm <sup>2</sup> 7693 lbf@100psi
Net Weight	9 kgs/19.8 lbs

HOW TO ORDER: State quantity, Model Number of chuck and shipping instructions.



See page 101 for Accuracy Chart

## 5C Collets (Inch)



Dimensions

A	B	C	D
1.25"	3.28"	1.47"	10°

Size	Round	Hex	Square
1/16"	0123-R-1/16	-	-
5/64"	0123-R-5/64	-	-
3/32"	0123-R-3/32	-	-
7/64"	0123-R-7/64	-	-
1/8"	0123-R-1/8	H-0123-1/8	S-0123-1/8
9/64"	0123-R-9/64	-	-
5/32"	0123-R-5/32	-	-
11/64"	0123-R-11/64	-	-
3/16"	0123-R-3/16	H-0123-3/16	S-0123-3/16
13/64"	0123-R-13/64	-	-
7/32"	0123-R-7/32	-	-
15/64"	0123-R-15/64	-	-
1/4"	0123-R-1/4	H-0123-1/4	S-0123-1/4
17/64"	0123-R-17/64	-	-
9/32"	0123-R-9/32	-	-
19/64"	0123-R-19/64	-	-
5/16"	0123-R-5/16	H-0123-5/16	S-0123-5/16
21/64"	0123-R-21/64	-	-
11/32"	0123-R-11/32	-	-
23/64"	0123-R-23/64	-	-
3/8"	0123-R-3/8	H-0123-3/8	S-0123-3/8
25/64"	0123-R-25/64	-	-
13/32"	0123-R-13/32	-	-
27/64"	0123-R-27/64	-	-
7/16"	0123-R-7/16	H-0123-7/16	S-0123-7/16
29/64"	0123-R-29/64	-	-
15/32"	0123-R-15/32	-	-
31/64"	0123-R-31/64	-	-
1/2"	0123-R-1/2	H-0123-1/2	S-0123-1/2
33/64"	0123-R-33/64	-	-
17/32"	0123-R-17/32	-	-
35/64"	0123-R-35/64	-	-
9/16"	0123-R-9/16	H-0123-9/16	S-0123-9/16
37/64"	0123-R-37/64	-	-
19/32"	0123-R-19/32	-	-
39/64"	0123-R-39/64	-	-
5/8"	0123-R-5/8	H-0123-5/8	S-0123-5/8
41/64"	0123-R-41/64	-	-
21/32"	0123-R-21/32	-	-
43/64"	0123-R-43/64	-	-
11/16"	0123-R-11/16	H-0123-11/16	S-0123-11/16
45/64"	0123-R-45/64	-	-

See page 124 for Accuracy Chart

Size	Round	Hex	Square
23/32"	0123-R-23/32	-	-
47/64"	0123-R-47/64	-	-
3/4"	0123-R-3/4	H-0123-3/4	S-0123-3/4
49/64"	0123-R-49/64	-	-
25/32"	0123-R-25/32	-	-
51/64"	0123-R-51/64	-	-
13/16"	0123-R-13/16	H-0123-13/16	-
53/64"	0123-R-53/64	-	-
27/32"	0123-R-27/32	-	-
55/64"	0123-R-55/64	-	-
7/8"	0123-R-7/8	-	-
57/64"	0123-R-57/64	-	-
29/32"	0123-R-29/32	-	-
59/64"	0123-R-59/64	-	-
15/16"	0123-R-15/16	-	-
61/64"	0123-R-61/64	-	-
31/32"	0123-R-31/32	-	-
63/64"	0123-R-63/64	-	-
1"	0123-R-1	-	-
1-1/64"	0123-R-1-1/64	-	-
1-1/32"	0123-R-1-1/32	-	-
1-3/64"	0123-R-1-3/64	-	-
1-1/16"	0123-R-1-1/16	-	-
1-5/64"	0123-R-1-5/64	-	-
1-3/32"	0123-R-1-3/32	-	-
1-7/64"	0123-R-1-7/64	-	-
1-1/8"	0123-R-1-1/8	-	-

5C Emergency Collet Steel Collet 1/8" P/N: 5C Emergency

### 5C Round Collet Sets (inch)

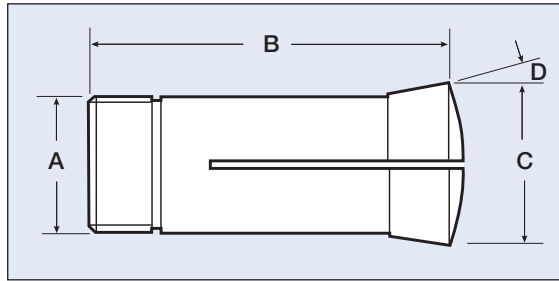
Set	No. of Collets	Part No.
1/16"-1-1/16" x 64ths	65	0123-SET-4
1/16"-1-1/16" x 32nds	33	0123-SET-5
1/16"-1-1/16" x 16ths	17	0123-SET-6
1/8"-1" x 8ths	8	0123-SET-7





See page 101 for Accuracy Chart

## 5C Collets (Metric)



Dimensions

A	B	C	D
31.75	85.4	37.3	10°

Size	Part Number
1.0mm	0123-R-1.0mm
1.5mm	0123-R-1.5mm
2.0mm	0123-R-2.0mm
2.5mm	0123-R-2.5mm
3.0mm	0123-R-3.0mm
3.5mm	0123-R-3.5mm
4.0mm	0123-R-4.0mm
4.5mm	0123-R-4.5mm
5.0mm	0123-R-5.0mm
5.5mm	0123-R-5.5mm
6.0mm	0123-R-6.0mm
6.5mm	0123-R-6.5mm
7.0mm	0123-R-7.0mm
7.5mm	0123-R-7.5mm
8.0mm	0123-R-8.0mm
8.5mm	0123-R-8.5mm
9.0mm	0123-R-9.0mm
9.5mm	0123-R-9.5mm
10.0mm	0123-R-10.0mm
10.5mm	0123-R-10.5mm
11.0mm	0123-R-11.0mm
11.5mm	0123-R-11.5mm
12.0mm	0123-R-12.0mm
12.5mm	0123-R-12.5mm
13.0mm	0123-R-13.0mm
13.5mm	0123-R-13.5mm
14.0mm	0123-R-14.0mm
14.5mm	0123-R-14.5mm
15.0mm	0123-R-15.0mm
15.5mm	0123-R-15.5mm
16.0mm	0123-R-16.0mm
16.5mm	0123-R-16.5mm
17.0mm	0123-R-17.0mm
17.5mm	0123-R-17.5mm
18.0mm	0123-R-18.0mm
18.5mm	0123-R-18.5mm
19.0mm	0123-R-19.0mm
19.5mm	0123-R-19.5mm

See page 124 for Accuracy Chart

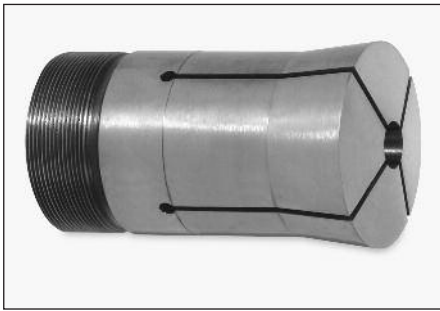
Size	Part Number
20.0mm	0123-R-20.0mm
20.5mm	0123-R-20.5mm
21.0mm	0123-R-21.0mm
21.5mm	0123-R-21.5mm
22.0mm	0123-R-22.0mm
22.5mm	0123-R-22.5mm
23.0mm	0123-R-23.0mm
23.5mm	0123-R-23.5mm
24.0mm	0123-R-24.0mm
24.5mm	0123-R-24.5mm
25.0mm	0123-R-25.0mm
25.5mm	0123-R-25.5mm
26.0mm	0123-R-26.0mm
26.5mm	0123-R-26.5mm
27.0mm	0123-R-27.0mm

### 5C Round Collet Sets (Metric)

Set	No. of Collets	Part No.
3mm-27mm x 0.5mm	49	0123-SET-1
3mm-27mm x 1mm	25	0123-SET-2



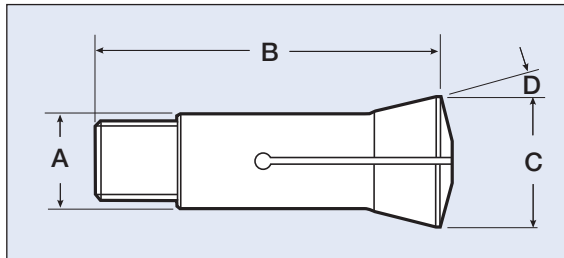




# 16C Collets (Inch)

See page 101 for Accuracy Chart

Emergency Collet P/N G-444



Dimensions

A	B	C	D
1.89"	4.35"	2.26"	10°

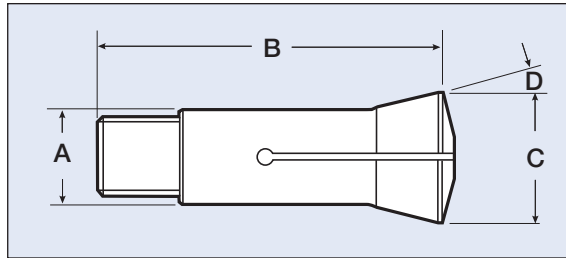
Size	16C inch		
	Round	Hex	Square
1/16"	G119-R-1/16	-	-
5/64"	G119-R-5/64	-	-
3/32"	G119-R-3/32	-	-
7/64"	G119-R-7/64	-	-
1/8"	G119-R-1/8	-	-
9/64"	G119-R-9/64	-	-
5/32"	G119-R-5/32	-	-
11/64"	G119-R-11/64	-	-
3/16"	G119-R-3/16	-	-
13/64"	G119-R-13/64	-	-
7/32"	G119-R- 7/32	-	-
15/64"	G119-R-15/64	-	-
1/4"	G119-R-1/4	G119-X-1/4	G119-S-1/4
17/64"	G119-R-17/64	-	-
9/32"	G119-R-9/32	-	-
19/64"	G119-R-19/64	-	-
5/16"	G119-R-5/16	G119-X-5/16	G119-S-5/16
21/64"	G119-R-21/64	-	-
11/32"	G119-R-11/32	-	-
23/64"	G119-R-23/64	-	-
3/8"	G119-R-3/8	G119-X-3/8	G119-S-3/8
25/64"	G119-R-25/64	-	-
13/32"	G119-R-13/32	-	-
27/64"	G119-R-27/64	-	-
7/16"	G119-R-7/16	G119-X-7/16	G119-S-7/16
29/64"	G119-R-29/64	-	-
15/32"	G119-R-15/32	-	-
31/64"	G119-R-31/64	-	-
1/2"	G119-R-1/2	G119-X-1/2	G119-S-1/2
33/64"	G119-R-33/64	-	-
17/32"	G119-R-17/32	-	-
35/64"	G119-R-35/64	-	-
9/16"	G119-R-9/16	G119-X-9/16	G119-S-9/16
37/64"	G119-R-37/64	-	-
19/32"	G119-R-19/32	-	-
39/64"	G119-R-39/64	-	-
5/8"	G119-R-5/8	G119-X-5/8	G119-S-5/8
41/64"	G119-R-41/64	-	-
21/32"	G119-R-21/32	-	-
43/64"	G119-R-43/64	-	-
11/16"	G119-R-11/16	G119-X-11/16	G119-S-11/16
45/64"	G119-R-45/64	-	-
23/32"	G119-R-23/32	-	-
47/64"	G119-R-47/64	-	-
3/4"	G119-R-3/4	G119-X-3/4	G119-S-3/4
49/64"	G119-R-49/64	-	-
25/32"	G119-R-25/32	-	-
51/64"	G119-R-51/64	-	-
13/16"	G119-R-13/16	G119-X-13/16	G119-S-13/16
53/64"	G119-R-53/64	-	-
27/32"	G119-R-27/32	-	-

Size	16C inch		
	Round	Hex	Square
55/64"	G119-R-55/64	-	-
7/8"	G119-R-7/8	G119-X-7/8	G119-S-7/8
29/32"	G119-R-29/32	-	-
59/64"	G119-R-59/64	-	-
15/16"	G119-R-15/16	G119-X-15/16	G119-S-15/16
61/64"	G119-R-61/64	-	-
31/32"	G119-R-31/32	-	-
63/64"	G119-R-63/64	-	-
1"	G119-R-1	G119-X-1	G119-S-1
1-1/64"	G119-R-1-1/64	-	-
1-1/32"	G119-R-1-1/32	-	-
1-3/64"	G119-R-1-3/64	-	-
1-1/16"	G119-R-1-1/16	G119-X-1-1/16	-
1-5/64"	G119-R-1-5/64	-	-
1-3/32"	G119-R-1-3/32	-	-
1-7/64"	G119-R-1-7/64	-	-
1-1/8"	G119-R-1-1/8	G119-X-1-1/8	-
1-9/64"	G119-R-1-9/64	-	-
1-5/32"	G119-R-1-5/32	-	-
1-11/64"	G119-R-1-11/64	-	-
1-3/16"	G119-R-1-3/16	G119-X-1-3/16	-
1-13/64"	G119-R-1-13/64	-	-
1-7/32"	G119-R-1-7/32	-	-
1-15/64"	G119-R-1-15/64	-	-
1-1/4"	G119-R-1-1/4	G119-X-1-1/4	-
1-17/64"	G119-R-1-17/64	-	-
1-9/32"	G119-R-1-9/32	-	-
1-19/64"	G119-R-1-19/64	-	-
1-5/16"	G119-R-1-5/16	G119-X-1-5/16	-
1-21/64"	G119-R-1-21/64	-	-
1-11/32"	G119-R-1-11/32	-	-
1-23/64"	G119-R-1-23/64	-	-
1-3/8"	G119-R-1-3/8	G119-X-1-3/8	-
1-25/64"	G119-R-1-25/64	-	-
1-13/32"	G119-R-1-13/32	-	-
1-27/64"	G119-R-1-27/64	-	-
1-7/16"	G119-R-1-7/16	-	-
1-29/64"	G119-R-1-29/64	-	-
1-15/32"	G119-R-1-15/32	-	-
1-31/64"	G119-R-1-31/64	-	-
1-1/2"	G119-R-1-1/2	-	-
1-33/64"	G119-R-1-33/64	-	-
1-17/32"	G119-R-1-17/32	-	-
1-35/64"	G119-R-1-35/64	-	-
1-9/16"	G119-R-1-9/16	-	-
1-37/64"	G119-R-1-37/64	-	-
1-19/32"	G119-R-1-19/32	-	-
1-39/64"	G119-R-1-39/64	-	-
1-5/8"	G119-R-1-5/8	-	-



See page 101 for Accuracy Chart

# 16C Collets (Metric)



Dimensions

A	B	C	D
48	110.5	57.5	10°

Size	16C metric		
	Round	Hex	Square
1.0mm	G119-R-1.0mm	-	-
1.5mm	G119-R-1.5mm	-	-
2.0mm	G119-R-2.0mm	-	-
2.5mm	G119-R-2.5mm	-	-
3.0mm	G119-R-3.0mm	-	-
3.5mm	G119-R-3.5mm	-	-
4.0mm	G119-R-4.0mm	-	-
4.5mm	G119-R-4.5mm	-	-
5.0mm	G119-R-5.0mm	-	-
5.5mm	G119-R-5.5mm	-	-
6.0mm	G119-R-6.0mm	G119-X-6.0mm	G119-S-6.0mm
6.5mm	G119-R-6.5mm	G119-X-6.5mm	G119-S-6.5mm
7.0mm	G119-R-7.0mm	G119-X-7.0mm	G119-S-7.0mm
7.5mm	G119-R-7.5mm	G119-X-7.5mm	G119-S-7.5mm
8.0mm	G119-R-8.0mm	G119-X-8.0mm	G119-S-8.0mm
8.5mm	G119-R-8.5mm	G119-X-8.5mm	G119-S-8.5mm
9.0mm	G119-R-9.0mm	G119-X-9.0mm	G119-S-9.0mm
9.5mm	G119-R-9.5mm	G119-X-9.5mm	G119-S-9.5mm
10.0mm	G119-R-10.0mm	G119-X-10.0mm	G119-S-10.0mm
10.5mm	G119-R-10.5mm	G119-X-10.5mm	G119-S-10.5mm
11.0mm	G119-R-11.0mm	G119-X-11.0mm	G119-S-11.0mm
11.5mm	G119-R-11.5mm	G119-X-11.5mm	G119-S-11.5mm
12.0mm	G119-R-12.0mm	G119-X-12.0mm	G119-S-12.0mm
12.5mm	G119-R-12.5mm	G119-X-12.5mm	G119-S-12.5mm
13.0mm	G119-R-13.0mm	G119-X-13.0mm	G119-S-13.0mm
13.5mm	G119-R-13.5mm	G119-X-13.5mm	G119-S-13.5mm
14.0mm	G119-R-14.0mm	G119-X-14.0mm	G119-S-14.0mm
14.5mm	G119-R-14.5mm	G119-X-14.5mm	G119-S-14.5mm
15.0mm	G119-R-15.0mm	G119-X-15.0mm	G119-S-15.0mm
15.5mm	G119-R-15.5mm	G119-X-15.5mm	G119-S-15.5mm
16.0mm	G119-R-16.0mm	G119-X-16.0mm	G119-S-16.0mm
16.5mm	G119-R-16.5mm	G119-X-16.5mm	G119-S-16.5mm
17.0mm	G119-R-17.0mm	G119-X-17.0mm	G119-S-17.0mm
17.5mm	G119-R-17.5mm	G119-X-17.5mm	G119-S-17.5mm
18.0mm	G119-R-18.0mm	G119-X-18.0mm	G119-S-18.0mm
18.5mm	G119-R-18.5mm	G119-X-18.5mm	G119-S-18.5mm
19.0mm	G119-R-19.0mm	G119-X-19.0mm	G119-S-19.0mm
19.5mm	G119-R-19.5mm	G119-X-19.5mm	G119-S-19.5mm
20.0mm	G119-R-20.0mm	G119-X-20.0mm	G119-S-20.0mm
20.5mm	G119-R-20.5mm	G119-X-20.5mm	G119-S-20.5mm
21.0mm	G119-R-21.0mm	G119-X-21.0mm	G119-S-21.0mm
21.5mm	G119-R-21.5mm	G119-X-21.5mm	G119-S-21.5mm

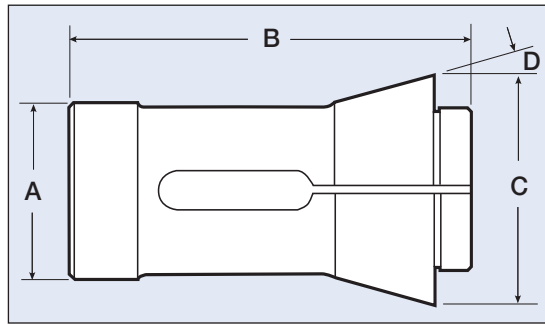
Size	16C metric		
	Round	Hex	Square
22.0mm	G119-R-22.0mm	G119-X-22.0mm	G119-S-22.0mm
22.5mm	G119-R-22.5mm	G119-X-22.5mm	G119-S-22.5mm
23.0mm	G119-R-23.0mm	G119-X-23.0mm	G119-S-23.0mm
23.5mm	G119-R-23.5mm	G119-X-23.5mm	G119-S-23.5mm
24.0mm	G119-R-24.0mm	G119-X-24.0mm	G119-S-24.0mm
24.5mm	G119-R-24.5mm	G119-X-24.5mm	G119-S-24.5mm
25.0mm	G119-R-25.0mm	G119-X-25.0mm	G119-S-25.0mm
25.5mm	G119-R-25.5mm	G119-X-25.5mm	-
26.0mm	G119-R-26.0mm	G119-X-26.0mm	-
26.5mm	G119-R-26.5mm	G119-X-26.5mm	-
27.0mm	G119-R-27.0mm	G119-X-27.0mm	-
27.5mm	G119-R-27.5mm	G119-X-27.5mm	-
28.0mm	G119-R-28.0mm	G119-X-28.0mm	-
28.5mm	G119-R-28.5mm	G119-X-28.5mm	-
29.0mm	G119-R-29.0mm	G119-X-29.0mm	-
29.5mm	G119-R-29.5mm	G119-X-29.5mm	-
30.0mm	G119-R-30.0mm	G119-X-30.0mm	-
30.5mm	G119-R-30.5mm	G119-X-30.5mm	-
31.0mm	G119-R-31.0mm	G119-X-31.0mm	-
31.5mm	G119-R-31.5mm	G119-X-31.5mm	-
32.0mm	G119-R-32.0mm	G119-X-32.0mm	-
32.5mm	G119-R-32.5mm	G119-X-32.5mm	-
33.0mm	G119-R-33.0mm	G119-X-33.0mm	-
33.5mm	G119-R-33.5mm	G119-X-33.5mm	-
34.0mm	G119-R-34.0mm	G119-X-34.0mm	-
34.5mm	G119-R-34.5mm	G119-X-34.5mm	-
35.0mm	G119-R-35.0mm	G119-X-35.0mm	-
35.5mm	G119-R-35.5mm	-	-
36.0mm	G119-R-36.0mm	-	-
36.5mm	G119-R-36.5mm	-	-
37.0mm	G119-R-37.0mm	-	-
37.5mm	G119-R-37.5mm	-	-
38.0mm	G119-R-38.0mm	-	-
38.5mm	G119-R-38.5mm	-	-
39.0mm	G119-R-39.0mm	-	-
39.5mm	G119-R-39.5mm	-	-
40.0mm	G119-R-40.0mm	-	-
40.5mm	G119-R-40.5mm	-	-
41.0mm	G119-R-41.0mm	-	-
41.5mm	G119-R-41.5mm	-	-
42.0mm	G119-R-42.0mm	-	-
42.5mm	G119-R-42.5mm	-	-

Emergency Collet P/N G444



See page 100 for Accuracy Chart

## B-42 Spring Series 173E Collets (Inch)



Dimensions

A	B	C	D
1.89"	3.7"	2.36"	15°

Size	B-42 inch		
	Round*	Hex	Square
1/16"	4728-R-1/16	4728-X-1/16	4728-S-1/16
1/8"	4728-R-1/8	4728-X-1/8	4728-S-1/8
3/16"	4728-R-3/16	4728-X-3/16	4728-S-3/16
1/4"	4728-R-1/4	4728-X-1/4	4728-S-1/4
5/16"	4728-R-5/16	4728-X-5/16	4728-S-5/16
3/8"	4728-R-3/8	4728-X-3/8	4728-S-3/8
7/16"	4728-R-7/16	4728-X-7/16	4728-S-7/16
1/2"	4728-R-1/2	4728-X-1/2	4728-S-1/2
9/16"	4728-R-9/16	4728-X-9/16	4728-S-9/16
5/8"	4728-R-5/8	4728-X-5/8	4728-S-5/8
11/16"	4728-R-11/16	4728-X-11/16	4728-S-11/16
3/4"	4728-R-3/4	4728-X-3/4	4728-S-3/4
13/16"	4728-R-13/16	4728-X-13/16	4728-S-13/16
7/8"	4728-R-7/8	4728-X-7/8	4728-S-7/8
15/16"	4728-R-15/16	4728-X-15/16	4728-S-15/16
1"	4728-R-1	4728-X-1	4728-S-1
1-1/16"	4728-R-1-1/16	4728-X-1-1/16	4728-S-1-1/16
1-1/8"	4728-R-1-1/8	4728-X-1-1/8	4728-S-1-1/8
1-3/16"	4728-R-1-3/16	4728-X-1-3/16	4728-S-1-3/16
1-1/4"	4728-R-1-1/4	4728-X-1-1/4	-
1-5/16"	4728-R-1-5/16	4728-X-1-5/16	-
1-3/8"	4728-R-1-3/8	4728-X-1-3/8	-
1-7/16"	4728-R-1-7/16	-	-
1-1/2"	4728-R-1-1/2	-	-
1-9/16"	4728-R-1-9/16	-	-
1-5/8"	4728-R-1-5/8	-	-

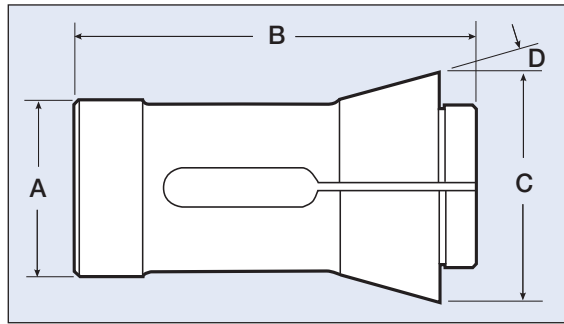
Emergency Collet P/N J550

\*To order Round Plain Bore Collets replace **R** with **RP** in part number:  
Example: 4728-**RP**-1/16



# B-42 Spring Series 173E Collets (Metric)

See page 100 for Accuracy Chart



Dimensions

A	B	C	D
48mm	94mm	60mm	15°

Size	B-42 metric		
	Round*	Hex	Square
1.0mm	4728-R-1.0mm	4728-X-1.0mm	4728-S-1.0mm
1.5mm	4728-R-1.5mm	4728-X-1.5mm	4728-S-1.5mm
2.0mm	4728-R-2.0mm	4728-X-2.0mm	4728-S-2.0mm
2.5mm	4728-R-2.5mm	4728-X-2.5mm	4728-S-2.5mm
3.0mm	4728-R-3.0mm	4728-X-3.0mm	4728-S-3.0mm
3.5mm	4728-R-3.5mm	4728-X-3.5mm	4728-S-3.5mm
4.0mm	4728-R-4.0mm	4728-X-4.0mm	4728-S-4.0mm
4.5mm	4728-R-4.5mm	4728-X-4.5mm	4728-S-4.5mm
5.0mm	4728-R-5.0mm	4728-X-5.0mm	4728-S-5.0mm
5.5mm	4728-R-5.5mm	4728-X-5.5mm	4728-S-5.5mm
6.0mm	4728-R-6.0mm	4728-X-6.0mm	4728-S-6.0mm
6.5mm	4728-R-6.5mm	4728-X-6.5mm	4728-S-6.5mm
7.0mm	4728-R-7.0mm	4728-X-7.0mm	4728-S-7.0mm
7.5mm	4728-R-7.5mm	4728-X-7.5mm	4728-S-7.5mm
8.0mm	4728-R-8.0mm	4728-X-8.0mm	4728-S-8.0mm
8.5mm	4728-R-8.5mm	4728-X-8.5mm	4728-S-8.5mm
9.0mm	4728-R-9.0mm	4728-X-9.0mm	4728-S-9.0mm
9.5mm	4728-R-9.5mm	4728-X-9.5mm	4728-S-9.5mm
10.0mm	4728-R-10.0mm	4728-X-10.0mm	4728-S-10.0mm
10.5mm	4728-R-10.5mm	4728-X-10.5mm	4728-S-10.5mm
11.0mm	4728-R-11.0mm	4728-X-11.0mm	4728-S-11.0mm
11.5mm	4728-R-11.5mm	4728-X-11.5mm	4728-S-11.5mm
12.0mm	4728-R-12.0mm	4728-X-12.0mm	4728-S-12.0mm
12.5mm	4728-R-12.5mm	4728-X-12.5mm	4728-S-12.5mm
13.0mm	4728-R-13.0mm	4728-X-13.0mm	4728-S-13.0mm
13.5mm	4728-R-13.5mm	4728-X-13.5mm	4728-S-13.5mm
14.0mm	4728-R-14.0mm	4728-X-14.0mm	4728-S-14.0mm
14.5mm	4728-R-14.5mm	4728-X-14.5mm	4728-S-14.5mm
15.0mm	4728-R-15.0mm	4728-X-15.0mm	4728-S-15.0mm
15.5mm	4728-R-15.5mm	4728-X-15.5mm	4728-S-15.5mm
16.0mm	4728-R-16.0mm	4728-X-16.0mm	4728-S-16.0mm
16.5mm	4728-R-16.5mm	4728-X-16.5mm	4728-S-16.5mm
17.0mm	4728-R-17.0mm	4728-X-17.0mm	4728-S-17.0mm
17.5mm	4728-R-17.5mm	4728-X-17.5mm	4728-S-17.5mm
18.0mm	4728-R-18.0mm	4728-X-18.0mm	4728-S-18.0mm
18.5mm	4728-R-18.5mm	4728-X-18.5mm	4728-S-18.5mm
19.0mm	4728-R-19.0mm	4728-X-19.0mm	4728-S-19.0mm
19.5mm	4728-R-19.5mm	4728-X-19.5mm	4728-S-19.5mm
20.0mm	4728-R-20.0mm	4728-X-20.0mm	4728-S-20.0mm
20.5mm	4728-R-20.5mm	4728-X-20.5mm	4728-S-20.5mm
21.0mm	4728-R-21.0mm	4728-X-21.0mm	4728-S-21.0mm
21.5mm	4728-R-21.5mm	4728-X-21.5mm	4728-S-21.5mm

Size	B-42 metric		
	Round*	Hex	Square
22.0mm	4728-R-22.0mm	4728-X-22.0mm	4728-S-22.0mm
22.5mm	4728-R-22.5mm	4728-X-22.5mm	4728-S-22.5mm
23.0mm	4728-R-23.0mm	4728-X-23.0mm	4728-S-23.0mm
23.5mm	4728-R-23.5mm	4728-X-23.5mm	4728-S-23.5mm
24.0mm	4728-R-24.0mm	4728-X-24.0mm	4728-S-24.0mm
24.5mm	4728-R-24.5mm	4728-X-24.5mm	4728-S-24.5mm
25.0mm	4728-R-25.0mm	4728-X-25.0mm	4728-S-25.0mm
25.5mm	4728-R-25.5mm	4728-X-25.5mm	4728-S-25.5mm
26.0mm	4728-R-26.0mm	4728-X-26.0mm	4728-S-26.0mm
26.5mm	4728-R-26.5mm	4728-X-26.5mm	4728-S-26.5mm
27.0mm	4728-R-27.0mm	4728-X-27.0mm	4728-S-27.0mm
27.5mm	4728-R-27.5mm	4728-X-27.5mm	4728-S-27.5mm
28.0mm	4728-R-28.0mm	4728-X-28.0mm	4728-S-28.0mm
28.5mm	4728-R-28.5mm	4728-X-28.5mm	4728-S-28.5mm
29.0mm	4728-R-29.0mm	4728-X-29.0mm	4728-S-29.0mm
29.5mm	4728-R-29.5mm	4728-X-29.5mm	4728-S-29.5mm
30.0mm	4728-R-30.0mm	4728-X-30.0mm	4728-S-30.0mm
30.5mm	4728-R-30.5mm	4728-X-30.5mm	-
31.0mm	4728-R-31.0mm	4728-X-31.0mm	-
31.5mm	4728-R-31.5mm	4728-X-31.5mm	-
32.0mm	4728-R-32.0mm	4728-X-32.0mm	-
32.5mm	4728-R-32.5mm	4728-X-32.5mm	-
33.0mm	4728-R-33.0mm	4728-X-33.0mm	-
33.5mm	4728-R-33.5mm	4728-X-33.5mm	-
34.0mm	4728-R-34.0mm	4728-X-34.0mm	-
34.5mm	4728-R-34.5mm	4728-X-34.5mm	-
35.0mm	4728-R-35.0mm	4728-X-35.0mm	-
35.5mm	4728-R-35.5mm	4728-X-35.5mm	-
36.0mm	4728-R-36.0mm	4728-X-36.0mm	-
36.5mm	4728-R-36.5mm	4728-X-36.5mm	-
37.0mm	4728-R-37.0mm	4728-X-37.0mm	-
37.5mm	4728-R-37.5mm	4728-X-37.5mm	-
38.0mm	4728-R-38.0mm	4728-X-38.0mm	-
38.5mm	4728-R-38.5mm	-	-
39.0mm	4728-R-39.0mm	-	-
39.5mm	4728-R-39.5mm	-	-
40.0mm	4728-R-40.0mm	-	-
40.5mm	4728-R-40.5mm	-	-
41.0mm	4728-R-41.0mm	-	-
41.5mm	4728-R-41.5mm	-	-
42.0mm	4728-R-42.0mm	-	-
42.5mm	4728-R-42.5mm	-	-

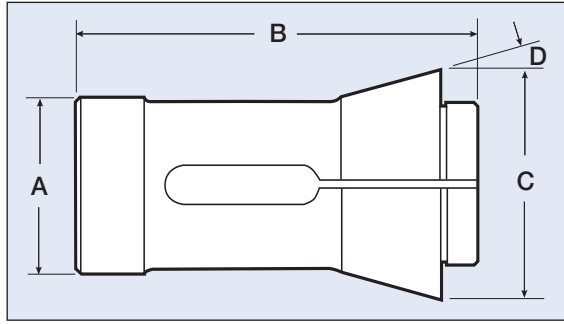
Emergency Collet P/N J-550

\*To order Round Plain Bore Collets replace **R** with **RP** in part number: Example 4728-**RP**-1/16



# B-60 Spring Series 185E Collet (Inch & metric)

See page 100 for Accuracy Chart



Dimensions

A	B	C	D
2.6"	4.33"	3.31"	15°

Size	B-60 inch		
	Round*	Hex	Square
1/16"	4291-R-1/16	4291-X-1/16	4291-S-1/16
1/8"	4291-R-1/8	4291-X-1/8	4291-S-1/8
3/16"	4291-R-3/16	4291-X-3/16	4291-S-3/16
1/4"	4291-R-1/4	4291-X-1/4	4291-S-1/4
5/16"	4291-R-5/16	4291-X-5/16	4291-S-5/16
3/8"	4291-R-3/8	4291-X-3/8	4291-S-3/8
7/16"	4291-R-7/16	4291-X-7/16	4291-S-7/16
1/2"	4291-R-1/2	4291-X-1/2	4291-S-1/2
9/16"	4291-R-9/16	4291-X-9/16	4291-S-9/16
5/8"	4291-R-5/8	4291-X-5/8	4291-S-5/8
11/16"	4291-R-11/16	4291-X-11/16	4291-S-11/16
3/4"	4291-R-3/4	4291-X-3/4	4291-S-3/4
13/16"	4291-R-13/16	4291-X-13/16	4291-S-13/16
7/8"	4291-R-7/8	4291-X-7/8	4291-S-7/8
15/16"	4291-R-15/16	4291-X-15/16	4291-S-15/16
1"	4291-R-1	4291-X-1	4291-S-1
1-1/16"	4291-R-1-1/16	4291-X-1-1/16	4291-S-1-1/16
1-1/8"	4291-R-1-1/8	4291-X-1-1/8	4291-S-1-1/8
1-3/16"	4291-R-1-3/16	4291-X-1-3/16	4291-S-1-3/16
1-1/4"	4291-R-1-1/4	4291-X-1-1/4	4291-S-1-1/4
1-5/16"	4291-R-1-5/16	4291-X-1-5/16	4291-S-1-5/16
1-3/8"	4291-R-1-3/8	4291-X-1-3/8	4291-S-1-3/8
1-7/16"	4291-R-1-7/16	4291-X-1-7/16	4291-S-1-7/16
1-1/2"	4291-R-1-1/2	4291-X-1-1/2	4291-S-1-1/2
1-9/16"	4291-R-1-9/16	4291-X-1-9/16	4291-S-1-9/16
1-5/8"	4291-R-1-5/8	4291-X-1-5/8	4291-S-1-5/8
1-11/16"	4291-R-1-11/16	4291-X-1-11/16	-
1-3/4"	4291-R-1-3/4	4291-X-1-3/4	-
1-13/16"	4291-R-1-13/16	4291-X-1-13/16	-
1-7/8"	4291-R-1-7/8	4291-X-1-7/8	-
1-15/16"	4291-R-1-15/16	4291-R-1-15/16	-
2"	4291-R-2	4291-R-2	-
2-1/16"	4291-R-2-1/16	-	-
2-1/8"	4291-R-2-1/8	-	-
2-3/16"	4291-R-2-3/16	-	-
2-1/4"	4291-R-2-1/4	-	-
2-5/16"	4291-R-2-5/16	-	-

Size	B-60 metric		
	Round*	Hex	Square
1.0mm	4291-R-1.0mm	4291-X-1.0mm	4291-S-1.0mm
1.5mm	4291-R-1.5mm	4291-X-1.5mm	4291-S-1.5mm
2.0mm	4291-R-2.0mm	4291-X-2.0mm	4291-S-2.0mm
2.5mm	4291-R-2.5mm	4291-X-2.5mm	4291-S-2.5mm
3.0mm	4291-R-3.0mm	4291-X-3.0mm	4291-S-3.0mm
3.5mm	4291-R-3.5mm	4291-X-3.5mm	4291-S-3.5mm
4.0mm	4291-R-4.0mm	4291-X-4.0mm	4291-S-4.0mm
4.5mm	4291-R-4.5mm	4291-X-4.5mm	4291-S-4.5mm
5.0mm	4291-R-5.0mm	4291-X-5.0mm	4291-S-5.0mm
5.5mm	4291-R-5.5mm	4291-X-5.5mm	4291-S-5.5mm
6.0mm	4291-R-6.0mm	4291-X-6.0mm	4291-S-6.0mm
6.5mm	4291-R-6.5mm	4291-X-6.5mm	4291-S-6.5mm
7.0mm	4291-R-7.0mm	4291-X-7.0mm	4291-S-7.0mm
7.5mm	4291-R-7.5mm	4291-X-7.5mm	4291-S-7.5mm
8.0mm	4291-R-8.0mm	4291-X-8.0mm	4291-S-8.0mm
8.5mm	4291-R-8.5mm	4291-X-8.5mm	4291-S-8.5mm
9.0mm	4291-R-9.0mm	4291-X-9.0mm	4291-S-9.0mm
9.5mm	4291-R-9.5mm	4291-X-9.5mm	4291-S-9.5mm
10.0mm	4291-R-10.0mm	4291-X-10.0mm	4291-S-10.0mm
10.5mm	4291-R-10.5mm	4291-X-10.5mm	4291-S-10.5mm
11.0mm	4291-R-11.0mm	4291-X-11.0mm	4291-S-11.0mm
11.5mm	4291-R-11.5mm	4291-X-11.5mm	4291-S-11.5mm
12.0mm	4291-R-12.0mm	4291-X-12.0mm	4291-S-12.0mm
12.5mm	4291-R-12.5mm	4291-X-12.5mm	4291-S-12.5mm
13.0mm	4291-R-13.0mm	4291-X-13.0mm	4291-S-13.0mm
13.5mm	4291-R-13.5mm	4291-X-13.5mm	4291-S-13.5mm
14.0mm	4291-R-14.0mm	4291-X-14.0mm	4291-S-14.0mm
14.5mm	4291-R-14.5mm	4291-X-14.5mm	4291-S-14.5mm
15.0mm	4291-R-15.0mm	4291-X-15.0mm	4291-S-15.0mm
15.5mm	4291-R-15.5mm	4291-X-15.5mm	4291-S-15.5mm
16.0mm	4291-R-16.0mm	4291-X-16.0mm	4291-S-16.0mm
16.5mm	4291-R-16.5mm	4291-X-16.5mm	4291-S-16.5mm
17.0mm	4291-R-17.0mm	4291-X-17.0mm	4291-S-17.0mm
17.5mm	4291-R-17.5mm	4291-X-17.5mm	4291-S-17.5mm
18.0mm	4291-R-18.0mm	4291-X-18.0mm	4291-S-18.0mm
18.5mm	4291-R-18.5mm	4291-X-18.5mm	4291-S-18.5mm
19.0mm	4291-R-19.0mm	4291-X-19.0mm	4291-S-19.0mm
19.5mm	4291-R-19.5mm	4291-X-19.5mm	4291-S-19.5mm
20.0mm	4291-R-20.0mm	4291-X-20.0mm	4291-S-20.0mm
20.5mm	4291-R-20.5mm	4291-X-20.5mm	4291-S-20.5mm
21.0mm	4291-R-21.0mm	4291-X-21.0mm	4291-S-21.0mm
21.5mm	4291-R-21.5mm	4291-X-21.5mm	4291-S-21.5mm

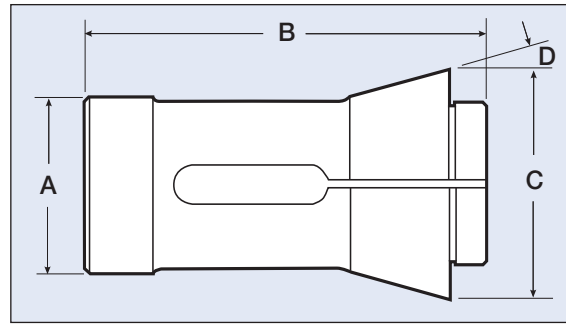
Emergency Collet P/N H-767

\*To order Round Plain Bore Collets replace R with RP in part number: Example 4291-RP-1/16



See page 100 for Accuracy Chart

# B-60 Spring Series 185E Collets (Metric)



Dimensions

A	B	C	D
66mm	110mm	84mm	15°

Size	B-60 metric		
	Round*	Hex	Square
22.0mm	4291-R-22.0mm	4291-X-22.0mm	4291-S-22.0mm
22.5mm	4291-R-22.5mm	4291-X-22.5mm	4291-S-22.5mm
23.0mm	4291-R-23.0mm	4291-X-23.0mm	4291-S-23.0mm
23.5mm	4291-R-23.5mm	4291-X-23.5mm	4291-S-23.5mm
24.0mm	4291-R-24.0mm	4291-X-24.0mm	4291-S-24.0mm
24.5mm	4291-R-24.5mm	4291-X-24.5mm	4291-S-24.5mm
25.0mm	4291-R-25.0mm	4291-X-25.0mm	4291-S-25.0mm
25.5mm	4291-R-25.5mm	4291-X-25.5mm	4291-S-25.5mm
26.0mm	4291-R-26.0mm	4291-X-26.0mm	4291-S-26.0mm
26.5mm	4291-R-26.5mm	4291-X-26.5mm	4291-S-26.5mm
27.0mm	4291-R-27.0mm	4291-X-27.0mm	4291-S-27.0mm
27.5mm	4291-R-27.5mm	4291-X-27.5mm	4291-S-27.5mm
28.0mm	4291-R-28.0mm	4291-X-28.0mm	4291-S-28.0mm
28.5mm	4291-R-28.5mm	4291-X-28.5mm	4291-S-28.5mm
29.0mm	4291-R-29.0mm	4291-X-29.0mm	4291-S-29.0mm
29.5mm	4291-R-29.5mm	4291-X-29.5mm	4291-S-29.5mm
30.0mm	4291-R-30.0mm	4291-X-30.0mm	4291-S-30.0mm
30.5mm	4291-R-30.5mm	4291-X-30.5mm	4291-S-30.5mm
31.0mm	4291-R-31.0mm	4291-X-31.0mm	4291-S-31.0mm
31.5mm	4291-R-31.5mm	4291-X-31.5mm	4291-S-31.5mm
32.0mm	4291-R-32.0mm	4291-X-32.0mm	4291-S-32.0mm
32.5mm	4291-R-32.5mm	4291-X-32.5mm	4291-S-32.5mm
33.0mm	4291-R-33.0mm	4291-X-33.0mm	4291-S-33.0mm
33.5mm	4291-R-33.5mm	4291-X-33.5mm	4291-S-33.5mm
34.0mm	291-R-34.0mm	4291-X-34.0mm	4291-S-34.0mm
34.5mm	4291-R-34.5mm	4291-X-34.5mm	4291-S-34.5mm
35.0mm	4291-R-35.0mm	4291-X-35.0mm	4291-S-35.0mm
35.5mm	4291-R-35.5mm	4291-X-35.5mm	4291-S-35.5mm
36.0mm	4291-R-36.0mm	4291-X-36.0mm	4291-S-36.0mm
36.5mm	4291-R-36.5mm	4291-X-36.5mm	4291-S-36.5mm
37.0mm	4291-R-37.0mm	4291-X-37.0mm	4291-S-37.0mm
37.5mm	4291-R-37.5mm	4291-X-37.5mm	4291-S-37.5mm
38.0mm	4291-R-38.0mm	4291-X-38.0mm	4291-S-38.0mm
38.5mm	4291-R-38.5mm	4291-X-38.5mm	4291-S-38.5mm
39.0mm	4291-R-39.0mm	4291-X-39.0mm	4291-S-39.0mm
39.5mm	4291-R-39.5mm	4291-X-39.5mm	4291-S-39.5mm
40.0mm	4291-R-40.0mm	4291-X-40.0mm	4291-S-40.0mm
40.5mm	4291-R-40.5mm	4291-X-40.5mm	4291-S-40.5mm
41.0mm	4291-R-41.0mm	4291-X-41.0mm	4291-S-41.0mm
41.5mm	4291-R-41.5mm	4291-X-41.5mm	4291-S-41.5mm
42.0mm	4291-R-42.0mm	4291-X-42.0mm	4291-S-42.0mm
42.5mm	4291-R-42.5mm	4291-X-42.5mm	4291-S-42.5mm

Size	B-60 metric		
	Round*	Hex	Square
43.0mm	4291-R-43.0mm	4291-X-43.0mm	-
43.5mm	4291-R-43.5mm	4291-X-43.5mm	-
44.0mm	4291-R-44.0mm	4291-X-44.0mm	-
44.5mm	4291-R-44.5mm	4291-X-44.5mm	-
45.0mm	4291-R-45.0mm	4291-X-45.0mm	-
45.5mm	4291-R-45.5mm	4291-X-45.5mm	-
46.0mm	4291-R-46.0mm	4291-X-46.0mm	-
46.5mm	4291-R-46.5mm	4291-X-46.5mm	-
47.0mm	4291-R-47.0mm	4291-X-47.0mm	-
47.5mm	4291-R-47.5mm	4291-X-47.5mm	-
48.0mm	4291-R-48.0mm	4291-X-48.0mm	-
48.5mm	4291-R-48.5mm	4291-X-48.5mm	-
49.0mm	4291-R-49.0mm	4291-X-49.0mm	-
49.5mm	4291-R-49.5mm	4291-X-49.5mm	-
50.0mm	4291-R-50.0mm	4291-X-50.0mm	-
50.5mm	4291-R-50.5mm	4291-X-50.5mm	-
51.0mm	4291-R-51.0mm	4291-X-51.0mm	-
51.5mm	4291-R-51.5mm	4291-X-51.5mm	-
52.0mm	4291-R-52.0mm	4291-X-52.0mm	-
52.5mm	4291-R-52.5mm	4291-X-52.5mm	-
53.0mm	4291-R-53.0mm	-	-
53.5mm	4291-R-53.5mm	-	-
54.0mm	4291-R-54.0mm	-	-
54.5mm	4291-R-54.5mm	-	-
55.0mm	4291-R-55.0mm	-	-
55.5mm	4291-R-55.5mm	-	-
56.0mm	4291-R-56.0mm	-	-
56.5mm	4291-R-56.5mm	-	-
57.0mm	4291-R-57.0mm	-	-
57.5mm	4291-R-57.5mm	-	-
58.0mm	4291-R-58.0mm	-	-
58.5mm	4291-R-58.5mm	-	-
59.0mm	4291-R-59.0mm	-	-
59.5mm	4291-R-59.5mm	-	-
60.0mm	4291-R-60.0mm	-	-
60.5mm	4291-R-60.5mm	-	-

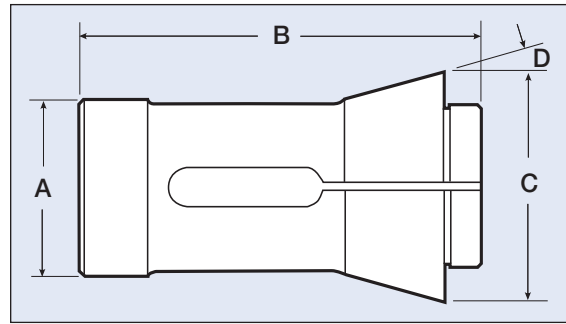
Emergency Collet P/N H-767

\*To order Round Plain Bore Collets replace **R** with **RP** in part number: Example 4291-**RP**-1/16



# B-80 Spring Series 193E Collets (Inch & metric)

See page 100 for Accuracy Chart



Dimensions

A	B	C	D
3.543"	5.118"	4.212"	15°

Size	B-80 (inch) Part Number
9/16"	H047-R-9/16
5/8"	H047-R-5/8
11/16"	H047-R-11/16
3/4"	H047-R-3/4
13/16"	H047-R-13/16
7/8"	H047-R-7/8
15/16"	H047-R-15/16
1"	H047-R-1-0
1-1/16"	H047-R-1-1/16
1-1/8"	H047-R-1-1/8
1-3/16"	H047-R-1-3/16
1-1/4"	H047-R-1-1/4
1-5/16"	H047-R-1-5/16
1-3/8"	H047-R-1-3/8
1-7/16"	H047-R-1-7/16
1-1/2"	H047-R-1-1/2
1-9/16"	H047-R-1-9/16
1-5/8"	H047-R-1-5/8
1-11/16"	H047-R-1-11/16
1-3/4"	H047-R-1-3/4
1-13/16"	H047-R-1-13/16
1-7/8"	H047-R-1-7/8
1-15/16"	H047-R-1-15/16
2"	H047-R-2
2-1/16"	H047-R-2-1/16
2-1/8"	H047-R-2-1/8
2-3/16"	H047-R-2-3/16
2-1/4"	H047-R-2-1/4
2-5/16"	H047-R-2-5/16
2-3/8"	H047-R-2-3/8
2-7/16"	H047-R-2-7/16
2-1/2"	H047-R-2-1/2
2-9/16"	H047-R-2-9/16
2-5/8"	H047-R-2-5/8
2-11/16"	H047-R-2-11/16
2-3/4"	H047-R-2-3/4
2-13/16"	H047-R-2-13/16
2-7/8"	H047-R-2-7/8
2-15/16"	H047-R-2-15/16
3"	H047-R-3
3-1/16"	H047-R-3-1/16

Size	B-80 (Metric) Part Number
15mm	H047-R-15mm
15.5mm	H047-R-15.5mm
16mm	H047-R-16mm
16.5mm	H047-R-16.5mm
17mm	H047-R-17mm
17.5mm	H047-R-17.5mm
18mm	H047-R-18mm
18.5mm	H047-R-18.5mm
19mm	H047-R-19mm
19.5mm	H047-R-19.5mm
20mm	H047-R-20mm
20.5mm	H047-R-20.5mm
21mm	H047-R-21mm
21.5mm	H047-R-21.5mm
22mm	H047-R-22mm
22.5mm	H047-R-22.5mm
23mm	H047-R-23mm
23.5mm	H047-R-23.5mm
24mm	H047-R-24mm
24.5mm	H047-R-24.5mm
25mm	H047-R-25mm
25.5mm	H047-R-25.5mm
26mm	H047-R-26mm
26.5mm	H047-R-26.5mm
27mm	H047-R-27mm
27.5mm	H047-R-27.5mm
28mm	H047-R-28mm
28.5mm	H047-R-28.5mm
29mm	H047-R-29mm
29.5mm	H047-R-29.5mm
30mm	H047-R-30mm
30.5mm	H047-R-30.5mm
31mm	H047-R-31mm
31.5mm	H047-R-31.5mm
32mm	H047-R-32mm
32.5mm	H047-R-32.5mm
33mm	H047-R-33mm
33.5mm	H047-R-33.5mm
34mm	H047-R-34mm
34.5mm	H047-R-34.5mm
35mm	H047-R-35mm
35.5mm	H047-R-35.5mm
36mm	H047-R-36mm
36.5mm	H047-R-36.5mm
37mm	H047-R-37mm
37.5mm	H047-R-37.5mm

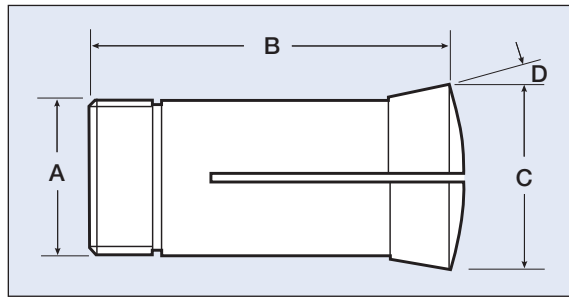
Size	B-80 (Metric) Part Number
38mm	H047-R-38mm
38.5mm	H047-R-38.5mm
39mm	H047-R-39mm
39.5mm	H047-R-39.5mm
40mm	H047-R-40mm
40.5mm	H047-R-40.5mm
41mm	H047-R-41mm
41.5mm	H047-R-41.5mm
42mm	H047-R-42mm
42.5mm	H047-R-42.5mm
43mm	H047-R-43mm
43.5mm	H047-R-43.5mm
44mm	H047-R-44mm
44.5mm	H047-R-44.5mm
45mm	H047-R-45mm
45.5mm	H047-R-45.5mm
46mm	H047-R-46mm
46.5mm	H047-R-46.5mm
47mm	H047-R-47mm
47.5mm	H047-R-47.5mm
48mm	H047-R-48mm
48.5mm	H047-R-48.5mm
49mm	H047-R-49mm
49.5mm	H047-R-49.5mm
50mm	H047-R-50mm
50.5mm	H047-R-50.5mm
51mm	H047-R-51mm
51.5mm	H047-R-51.5mm
52mm	H047-R-52mm
52.5mm	H047-R-52.5mm
53mm	H047-R-53mm
53.5mm	H047-R-53.5mm
54mm	H047-R-54mm
54.5mm	H047-R-54.5mm
55mm	H047-R-55mm
55.5mm	H047-R-55.5mm
56mm	H047-R-56mm
56.5mm	H047-R-56.5mm
57mm	H047-R-57mm
57.5mm	H047-R-57.5mm
58mm	H047-R-58mm
58.5mm	H047-R-58.5mm
59mm	H047-R-59mm
59.5mm	H047-R-59.5mm
60mm	H047-R-60mm
60.5mm	H047-R-60.5mm

Size	B-80 (Metric) Part Number
61mm	H047-R-61mm
61.5mm	H047-R-61.5mm
62mm	H047-R-62mm
62.5mm	H047-R-62.5mm
63mm	H047-R-63mm
63.5mm	H047-R-63.5mm
64mm	H047-R-64mm
64.5mm	H047-R-64.5mm
65mm	H047-R-65mm
65.5mm	H047-R-65.5mm
66mm	H047-R-66mm
66.5mm	H047-R-66.5mm
67mm	H047-R-67mm
67.5mm	H047-R-67.5mm
68mm	H047-R-68mm
68.5mm	H047-R-68.5mm
69mm	H047-R-69mm
69.5mm	H047-R-69.5mm
70mm	H047-R-70mm
70.5mm	H047-R-70.5mm
71mm	H047-R-71mm
71.5mm	H047-R-71.5mm
72mm	H047-R-72mm
72.5mm	H047-R-72.5mm
73mm	H047-R-73mm
73.5mm	H047-R-73.5mm
74mm	H047-R-74mm
74.5mm	H047-R-74.5mm
75mm	H047-R-75mm
75.5mm	H047-R-75.5mm
76mm	H047-R-76mm
76.5mm	H047-R-76.5mm
77mm	H047-R-77mm
77.5mm	H047-R-77.5mm
78mm	H047-R-78mm
78.5mm	H047-R-78.5mm
79mm	H047-R-79mm
79.5mm	H047-R-79.5mm
80mm	H047-R-80mm

B80-Emergency



## 3J Collets (Inch)



Dimensions

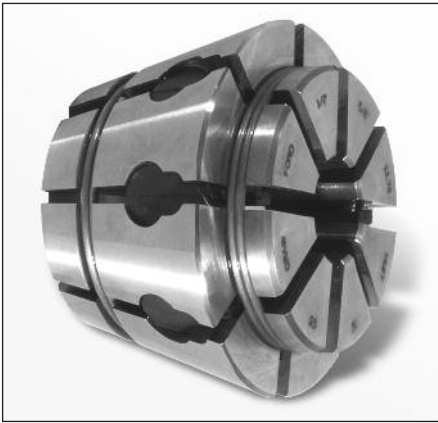
A	B	C	D
1.988 x 20 tpi	3.937"	2.2"	7°

Size	Part Number
1/16"	3J-R-1/16
5/64"	3J-R-5/64
3/32"	3J-R-3/32
7/64"	3J-R-7/64
1/8"	3J-R-1/8
9/64"	3J-R-9/64
5/32"	3J-R-5/32
11/64"	3J-R-11/64
3/16"	3J-R-3/16
13/64"	3J-R-13/64
7/32"	3J-R-7/32
15/64"	3J-R-15/64
1/4"	3J-R-1/4
17/64"	3J-R-17/64
9/32"	3J-R-9/32
19/64"	3J-R-19/64
5/16"	3J-R-5/16
21/64"	3J-R-21/64
11/32"	3J3J-R-11/32
23/64"	3J-R-23/64
3/8"	3J-R-3/8
25/64"	3J-R-25/64
13/32"	3J-R-13/32
27/64"	3J-R-27/64
7/16"	3J-R-7/16
29/64"	3J-R-29/64
15/32"	3J-R-15/32
31/64"	3J-R-31/64
1/2"	3J-R-1/2
33/64"	3J-R-33/64
17/32"	3J-R-17/32
35/64"	3J-R-35/64
9/16"	3J-R-9/16
37/64"	3J-R-37/64
19/32"	3J-R-19/32
39/64"	3J-R-39/64
5/8"	3J-R-5/8

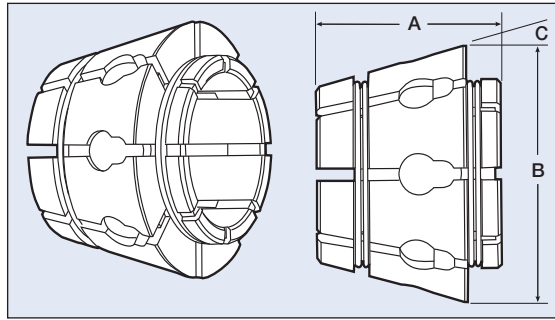
Size	Part Number
41/64"	3J-R-41/64
21/32"	3J-R-21/32
43/64"	3J-R-43/64
11/16"	3J-R-11/16
45/64"	3J-R-45/64
23/32"	3J-R-23/32
47/64"	3J-R-47/64
3/4"	3J-R-3/4
49/64"	3J-R-49/64
25/32"	3J-R-25/32
51/64"	3J-R-51/64
13/16"	3J-R-13/16
53/64"	3J-R-53/64
27/32"	3J-R-27/32
55/64"	3J-R-55/64
7/8"	3J-R-7/8
57/64"	3J-R-57/64
29/32"	3J-R-29/32
59/64"	3J-R-59/64
15/16"	3J-R-15/16
61/64"	3J-R-61/64
31/32"	3J-R-31/32
63/64"	3J-R-63/64
1"	3J-R-1
1-1/16"	3J-R-1-1/16
1-1/8"	3J-R-1-1/8
1-3/16"	3J-R-1-3/16
1-1/4"	3J-R-1-1/4
1-5/16"	3J-R-1-5/16
1-3/8"	3J-R-1-3/8
1-7/16"	3J-R-1-7/16
1-1/2"	3J-R-1-1/2
1-9/16"	3J-R-1-9/16
1-5/8"	3J-R-1-5/8
1-11/16"	3J-R-1-11/16
1-3/4"	3J-R-1-3/4

P/N 3J-Emergency





# Plain Bore Multibore Collets



## Dimensions

Part No.	A	B	C
T-980	1.66"	1.99"	14°
W-850	2.04"	2.76"	15°
V-120	2.47"	3.46"	15°
T-285	2.88"	3.91"	15°
N-175	3.15"	4.72"	15°

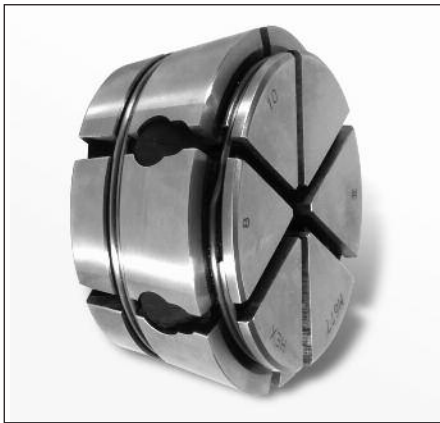
U.S. Trade Mark 2,898,519

Grip Range		T-980			W-850		
Inch	MM	Round	Hex	Square	Round	Hex	Square
1/16 - 3/16	1.58 - 4.76	T980-R-B1	T980-X-B68	T980-S-B86	W850-R-C1	W850-X-C68	W850-S-C86
1/8 - 1/4	3.17 - 6.35	T980-R-B2	T980-X-B69	T980-S-B87	W850-R-C2	W850-X-C69	W850-S-C87
1/4 - 3/8	6.35 - 9.52	T980-R-B3	T980-X-B70	T980-S-B88	W850-R-C3	W850-X-C70	W850-S-C88
3/8 - 1/2	9.52 - 12.70	T980-R-B4	T980-X-B71	T980-S-B89	W850-R-C4	W850-X-C71	W850-S-C89
1/2 - 5/8	12.70 - 15.87	T980-R-B5	T980-X-B72	T980-S-B90	W850-R-C5	W850-X-C72	W850-S-C90
5/8 - 3/4	15.87 - 19.05	T980-R-B6	T980-X-B73	T980-S-B91	W850-R-C6	W850-X-C73	W850-S-C91
3/4 - 7/8	19.05 - 22.22	T980-R-B7	T980-X-B74	-	W850-R-C7	W850-X-C74	W850-S-C92
7/8 - 1	22.22 - 25.40	T980-R-B8	T980-X-B75	-	W850-R-C8	W850-X-C75	W850-S-C93
1 - 1-1/8	25.40 - 28.57	T980-R-B9	-	-	W850-R-C9	W850-X-C76	W850-S-C94
1-1/8 - 1-1/4	28.57 - 31.75	-	-	-	W850-R-C10	W850-X-C77	W850-S-C95
1-1/4 - 1-3/8	31.75 - 34.92	-	-	-	W850-R-C11	W850-X-C78	-
1-3/8 - 1-1/2	34.92 - 38.10	-	-	-	W850-R-C12	W850-X-C79	-
1-1/2 - 1-5/8	38.10 - 41.27	-	-	-	W850-R-C13	-	-
1-5/8 - 1-3/4	41.27 - 44.45	-	-	-	W850-R-C14*	-	-

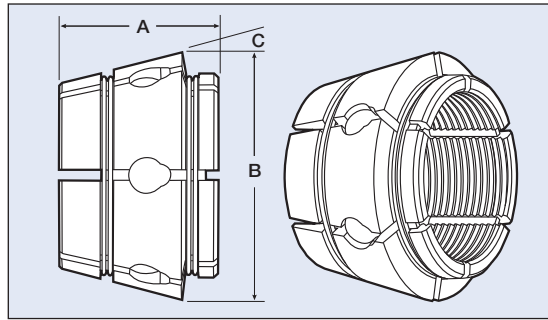
\*39-42mm round only

Grip Range		V-120			T-285			Round	N-175	
Inch	MM	Round	Hex	Square	Round	Hex	Square	& Smooth Bore	Hex	Square
1/16 - 3/16	1.58 - 4.76	V120-R-D1	-	-	-	-	-	-	-	-
1/8 - 1/4	3.17 - 6.35	V120-R-D2	V120-X-D69	V120-S-D87	T285-R-E2	T285-X-E69	T285-S-E87	-	-	-
1/4 - 3/8	6.35 - 9.52	V120-R-D3	V120-X-D70	V120-S-D88	T285-R-E3	T285-X-E70	T285-S-E88	-	-	-
3/8 - 1/2	9.52 - 12.70	V120-R-D4	V120-X-D71	V120-S-D89	T285-R-E4	T285-X-E71	T285-S-E89	-	-	-
1/2 - 5/8	12.70 - 15.87	V120-R-D5	V120-X-D72	V120-S-D90	T285-R-E5	T285-X-E72	T285-S-E90	N175-R-F5	N175-X-F72	N175-S-F100
5/8 - 3/4	15.87 - 19.05	V120-R-D6	V120-X-D73	V120-S-D91	T285-R-E6	T285-X-E73	T285-S-E91	N175-R-F6	N175-X-F73	N175-S-F101
3/4 - 7/8	19.05 - 22.22	V120-R-D7	V120-X-D74	V120-S-D92	T285-R-E7	T285-X-E74	T285-S-E92	N175-R-F7	N175-X-F74	N175-S-F102
7/8 - 1	22.22 - 25.40	V120-R-D8	V120-X-D75	V120-S-D93	T285-R-E8	T285-X-E75	T285-S-E93	N175-R-F8	N175-X-F75	N175-S-F103
1 - 1-1/8	25.40 - 28.57	V120-R-D9	V120-X-D76	V120-S-D94	T285-R-E9	T285-X-E76	T285-S-E94	N175-R-F9	N175-X-F76	N175-S-F104
1-1/8 - 1-1/4	28.57 - 31.75	V120-R-D10	V120-X-D77	V120-S-D95	T285-R-E10	T285-X-E77	T285-S-E95	N175-R-F10	N175-X-F77	N175-S-F105
1-1/4 - 1-3/8	31.75 - 34.92	V120-R-D11	V120-X-D78	V120-S-D96	T285-R-E11	T285-X-E78	T285-S-E96	N175-R-F11	N175-X-F78	N175-S-F106
1-3/8 - 1-1/2	34.92 - 38.10	V120-R-D12	V120-X-D79	V120-S-D97	T285-R-E12	T285-X-E79	T285-S-E97	N175-R-F12	N175-X-F79	N175-S-F107
1-1/2 - 1-5/8	38.10 - 41.27	V120-R-D13	V120-X-D80	V120-S-D98	T285-R-E13	T285-X-E80	T285-S-E98	N175-R-F13	N175-X-F80	N175-S-F108
1-5/8 - 1-3/4	41.27 - 44.45	V120-R-D14	V120-X-D81	-	T285-R-E14	T285-X-E81	T285-S-E99	N175-R-F14	N175-X-F81	N175-S-F109
1-3/4 - 1-7/8	44.45 - 47.62	V120-R-D15	V120-X-D82	-	T285-R-E15	T285-X-E82	-	N175-R-F15	N175-X-F82	N175-S-F110
1-7/8 - 2	47.62 - 50.80	V120-R-D16	V120-X-D83	-	T285-R-E16	T285-X-E83	-	N175-R-F16	N175-X-F83	N175-S-F111
2 - 2-1/8	50.80 - 53.97	V120-R-D17	-	-	T285-R-E17	T285-X-E84	-	N175-R-F17	N175-X-F84	N175-S-F112
2-1/8 - 2-1/4	53.97 - 57.15	-	-	-	T285-R-E18	T285-X-E85	-	N175-R-F18	N175-X-F85	-
2-1/4 - 2-3/8	57.15 - 60.32	-	-	-	T285-R-E19	-	-	N175-R-F19	N175-X-F86	-
2-3/8 - 2-1/2	60.32 - 63.50	-	-	-	T285-R-E20	-	-	N175-R-F20	N175-X-F87	-
2-1/2 - 2-5/8	63.50 - 66.67	-	-	-	T285-R-E21	-	-	N175-R-F21	N175-X-F88	-
2-5/8 - 2-3/4	66.67 - 69.85	-	-	-	-	-	-	N175-R-F22	-	-
2-3/4 - 2-7/8	69.85 - 73.02	-	-	-	-	-	-	N175-R-F23	-	-
2-7/8 - 3	73.02 - 76.20	-	-	-	-	-	-	N175-R-F24	-	-
3 - 3-1/8	76.20 - 79.37	-	-	-	-	-	-	N175-R-F25	-	-

Collet Chuck available



# Multibore Collets DIN 6343 Serrated Bore



## Dimensions

Part No.	A	B	C
<b>M-673</b>	1.53"	2.42"	14.75°
<b>M-677</b>	1.77"	3.36"	14.75°
<b>J-660</b>	1.89"	4.27"	14.75°

U.S. Trade Mark 2,898,519

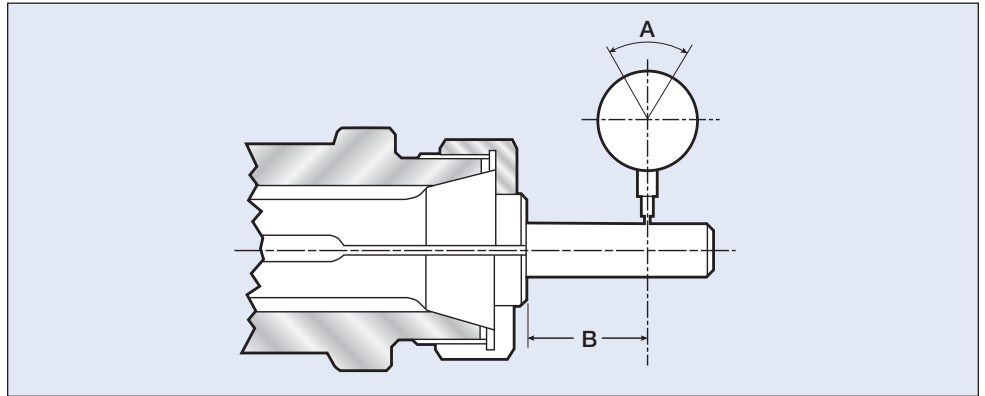
Grip Range		M-673 175E Compatible (4728)			M-677 185E Compatible (4291)			J-660 193E Compatible (H-47)		
Inch	MM	Round	Hex	Square	Round	Hex	Square	Round	Hex	Square
.15 - .23	4 - 6	M673-R-6*	M673-X-6*	M673-S-6*	M677-R-6*	M677-X-6*	M677-S-6*	-	-	-
.23 - .31	6 - 8	M673-R-8*	M673-X-8*	M673-S-8*	M677-R-8	M677-X-8	M677-S-8	-	-	-
.31 - .39	8 - 10	M673-R-10	M673-X-10	M673-S-10	M677-R-10	M677-X-10	M677-S-10	-	-	-
.39 - .47	10 - 12	M673-R-12	M673-X-12	M673-S-12	M677-R-12	M677-X-12	M677-S-12	-	-	-
.47 - .55	12 - 14	M673-R-14	M673-X-14	M673-S-14	M677-R-14	M677-X-14	M677-S-14	J660-R-14	J660-X-14	J660-S-14
.55 - .63	14 - 16	M673-R-16	M673-X-16	M673-S-16	M677-R-16	M677-X-16	M677-S-16	J660-R-16	J660-X-16	J660-S-16
.63 - .70	16 - 18	M673-R-18	M673-X-18	M673-S-18	M677-R-18	M677-X-18	M677-S-18	J660-R-18	J660-X-18	J660-S-18
.70 - .78	18 - 20	M673-R-20	M673-X-20	M673-S-20	M677-R-20	M677-X-20	M677-S-20	J660-R-20	J660-X-20	J660-S-20
.78 - .86	20 - 22	M673-R-22	M673-X-22	M673-S-22	M677-R-22	M677-X-22	M677-S-22	J660-R-22	J660-X-22	J660-S-22
.86 - .94	22 - 24	M673-R-24	M673-X-24	M673-S-24	M677-R-24	M677-X-24	M677-S-24	J660-R-24	J660-X-24	J660-S-24
.94 - 1.02	24 - 26	M673-R-26	M673-X-26	M673-S-26	M677-R-26	M677-X-26	M677-S-26	J660-R-26	J660-X-26	J660-S-26
1.02 - 1.10	26 - 28	M673-R-28	M673-X-28	M673-S-28	M677-R-28	M677-X-28	M677-S-28	J660-R-28	J660-X-28	J660-S-28
1.10 - 1.18	28 - 30	M673-R-30	M673-X-30	M673-S-30	M677-R-30	M677-X-30	M677-S-30	J660-R-30	J660-X-30	J660-S-30
1.18 - 1.25	30 - 32	M673-R-32	M673-X-32	-	M677-R-32	M677-X-32	M677-S-32	J660-R-32	J660-X-32	J660-S-32
1.25 - 1.33	32 - 34	M673-R-34	M673-X-34	-	M677-R-34	M677-X-34	M677-S-34	J660-R-34	J660-X-34	J660-S-34
1.33 - 1.41	34 - 36	M673-R-36	M673-X-36	-	M677-R-36	M677-X-36	M677-S-36	J660-R-36	J660-X-36	J660-S-36
1.41 - 1.49	36 - 38	M673-R-38	-	-	M677-R-38	M677-X-38	M677-S-38	J660-R-38	J660-X-38	J660-S-38
1.49 - 1.57	38 - 40	M673-R-40	-	-	M677-R-40	M677-X-40	M677-S-40	J660-R-40	J660-X-40	J660-S-40
1.57 - 1.65	40 - 42	M673-R-42	-	-	M677-R-42	M677-X-42	M677-S-42	J660-R-42	J660-X-42	J660-S-42
1.65 - 1.73	42 - 44	-	-	-	M677-R-44	M677-X-44	-	J660-R-44	J660-X-44	J660-S-44
1.73 - 1.81	44 - 46	-	-	-	M677-R-46	M677-X-46	-	J660-R-46	J660-X-46	J660-S-46
1.81 - 1.89	46 - 48	-	-	-	M677-R-48	M677-X-48	-	J660-R-48	J660-X-48	J660-S-48
1.89 - 1.92	48 - 50	-	-	-	M677-R-50	M677-X-50	-	J660-R-50	J660-X-50	J660-S-50
1.92 - 2.04	50 - 52	-	-	-	M677-R-52	M677-X-52	-	J660-R-52	J660-X-52	J660-S-52
2.04 - 2.12	52 - 54	-	-	-	M677-R-54	-	-	J660-R-54	J660-X-54	J660-S-54
2.12 - 2.20	54 - 56	-	-	-	M677-R-56	-	-	J660-R-56	J660-X-56	J660-S-56
2.20 - 2.28	56 - 58	-	-	-	M677-R-58	-	-	J660-R-58	J660-X-58	-
2.28 - 2.36	58 - 60	-	-	-	M677-R-60	-	-	J660-R-60	J660-X-60	-
2.36 - 2.44	60 - 62	-	-	-	-	-	-	J660-R-62	J660-X-62	-
2.44 - 2.52	62 - 64	-	-	-	-	-	-	J660-R-64	J660-X-64	-
2.52 - 2.59	64 - 66	-	-	-	-	-	-	J660-R-66	J660-X-66	-
2.59 - 2.67	66 - 68	-	-	-	-	-	-	J660-R-68	J660-X-68	-
2.67 - 2.75	68 - 70	-	-	-	-	-	-	J660-R-70	-	-
2.75 - 2.83	70 - 72	-	-	-	-	-	-	J660-R-72	-	-
2.83 - 2.91	72 - 74	-	-	-	-	-	-	J660-R-74	-	-
2.91 - 2.99	74 - 76	-	-	-	-	-	-	J660-R-76	-	-
2.99 - 3.07	76 - 78	-	-	-	-	-	-	J660-R-78	-	-
3.07 - 3.14	78 - 80	-	-	-	-	-	-	J660-R-80	-	-

Round bore collets are supplied with spiral serrations except where marked with (\*)  
Hexagonal and square collets are supplied with annular serrations except where marked with (\*)  
All collets marked with (\*) are supplied with plain bore

**Collet Chuck available**

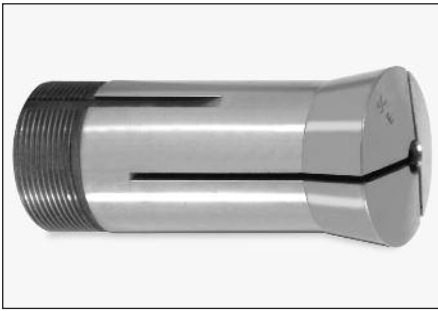


## B42, B60 & B80 Type Collet Accuracy Chart

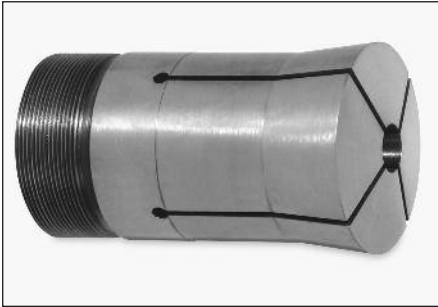


**Accuracy chart for Crawford Drawback, Screwback, Pushback and Dead Length Spring Collets**

Bore Size Center or A/Flat	A		B Test Length
	Round	Hex & Square	
1.0mm 0.039"	0.015mm 0.0006"	0.046mm 0.0018"	3.0mm 0.125"
1.0mm - 1.5mm 0.039" - 0.059"	0.020mm 0.0008"	0.060mm 0.0024"	6.5mm 0.250"
1.5mm - 3.0mm 0.059" - 0.118"	0.020mm 0.0008"	0.060mm 0.0024"	9.5mm 0.375"
3.0mm - 6.0mm 0.118" - 0.236"	0.020mm 0.0008"	0.060mm 0.0024"	16.0mm 0.625"
6.0mm - 10.0mm 0.236" - 0.394"	0.020mm 0.0008"	0.060mm 0.0024"	25.5mm 1.0"
10.0mm - 19.0mm 0.394" - 0.748"	0.030mm 0.0012"	0.091mm 0.0036"	38.0mm 1.5"
19.0mm - 25.4mm 0.748" - 1.0"	0.030mm 0.0012"	0.091mm 0.0036"	51.0mm 2.0"
25.4mm - 32.0mm 1.0" - 1.26"	0.040mm 0.0016"	0.120mm 0.0048"	63.5mm 2.5"
32.0mm - 50.8mm 1.26" - 2.0"	0.040mm 0.0016"	0.120mm 0.0048"	76.0mm 3.0"
Over 50.8mm 2.0"	0.040mm 0.0016"	0.120mm 0.0048"	101.5mm 4.0"

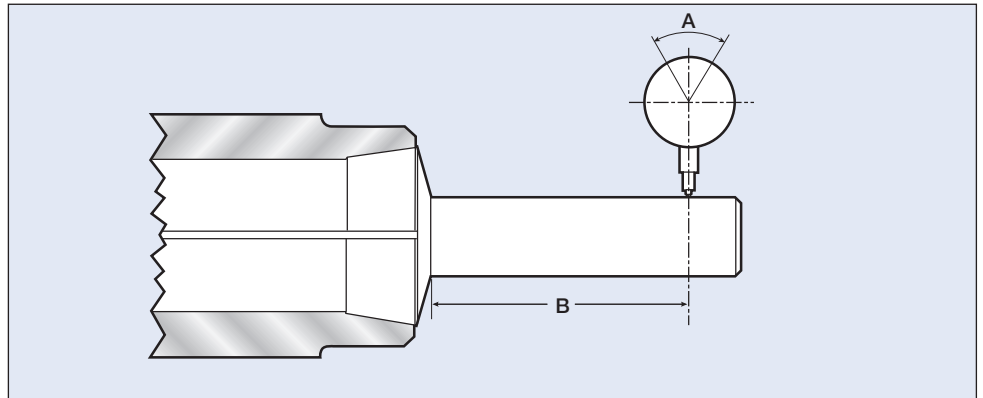


5C Collets page 88-89



16C Collets page 90-91

## 5C and 16C Collet Accuracy Chart



**Accuracy chart for Crawford Drawback Collets**

Collet Bore Size Center or A/Flat	A Round	B Test Length
1.0mm 0.039"	0.007mm 0.0003"	3.0mm 0.125"
1.0mm - 1.5mm 0.039" - 0.059"	0.010mm 0.0004"	6.5mm 0.250"
1.5mm - 3.0mm 0.059" - 0.118"	0.020mm 0.0004"	9.5mm 0.375"
3.0mm - 6.0mm 0.118" - 0.236"	0.010mm 0.0004"	16.0mm 0.625"
6.0mm - 10.0mm 0.236" - 0.394"	0.010mm 0.0004"	25.5mm 1.0"
10.0mm - 19.0mm 0.394" - 0.748"	0.015mm 0.0006"	38.0mm 1.5"
19.0mm - 25.4mm 0.748" - 1.0"	0.015mm 0.0006"	51.0mm 2.0"
25.4mm - 32.0mm 1.0" - 1.26"	0.020mm 0.0008"	63.5mm 2.5"
32.0mm - 50.8mm 1.26" - 2.0"	0.020mm 0.0008"	76.0mm 3.0"
Over 50.8mm 2.0"	0.020mm 0.0008"	101.5mm 4.0"



# Chuck Lubricant

## for Manual and Power Chucks

This is a specially formulated high pressure Chuck Lubricant and is the recommended lubricant to be used in all Pratt Burnerd Chuck that require grease type lubrication.

### Features:

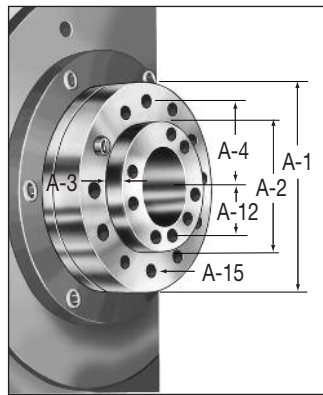
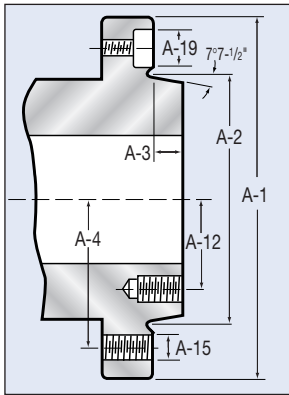
- ⚙ Dramatically improves Chuck jaw forces over conventional lubricants, withstands pressure up to 500,000 pounds per square inch.
- ⚙ Rust and oxidation inhibitors
- ⚙ Tacky nature gives high resistance to centrifugal force.
- ⚙ Contains molybdenum disulfide to reduce seizing, fretting wear galling and lower friction under conditions of extreme pressure.
- ⚙ Help reduce maintenance costs.
- ⚙ An effective lubricant for all brands of chucks

### Ordering Information:

Order No.	Description
PB16OZ	16 oz (453.6 gms) tube
PB10LB	10 lb (4.5 kilo) pail

# American Standard Spindle Nose Data

Source: American Standard Bulletin ASA B5.9 1960



## Type A American Standard A-1, A-2, B-1, B-2 Spindle

	A5	A6	A8	A11	A15	A20
A-1	5 1/4	6 1/2	8 1/4	11	15	20 1/2
A-2*	3.2505	4.1880	5.50075	7.75075	11.251**	16.251**
A-3***	.5625	.625	.6875	.750	.8125	.875
A-4	2 1/16	2 5/8	3 3/8	4 5/8	6 1/2	9 1/8
A-12	17/32	1 5/8	2 3/16	3 1/4	4 7/8	7 1/4
A-15	7/16-14	1/2-13	5/8-11	3/4-10	7/8-9	1-8

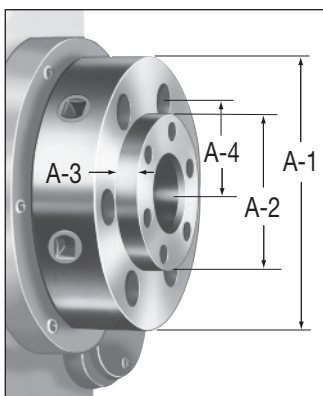
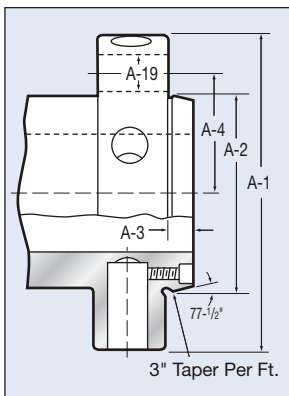
\*Tolerance +.0005/-0.000 \*\*Tolerance +.001/-0.000 \*\*\*Tolerance +.000/-0.001

A-1 Has tapped holes on both the inner bolt circle and outer bolt circle.

A-2 Has tapped holes on the outer bolt circle, but has no hole on inner bolt circle.

B-1 Has drilled holes on the outer bolt circles, and has tapped holes on inner bolt circle.

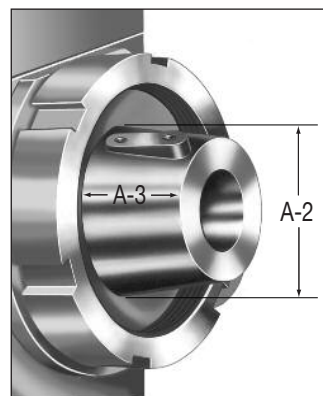
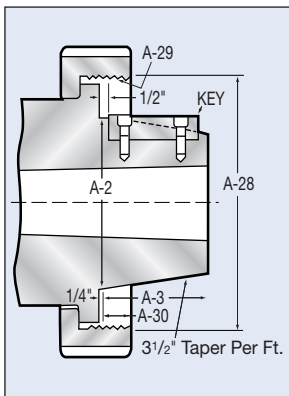
B-2 Has drilled holes on the outer bolt circles, but has no holes on inner bolt circle.



## Type D1 American Standard cam lock spindles

	D3	D4	D5	D6	D8	D11
A-1	3 5/8	4 5/8	5 3/4	7 1/4	8 7/8	11 3/4
A-2*	2.1250**	2.5005	3.2505	4.1880	5.50075	7.75075
A-3	7/16	7/16	1/2	9/16	5/8	11/16
A-4	1 25/64	1 5/8	2 1/16	2 5/8	3 3/8	4 5/8
A-19	.594	.656	.781	.906	1.031	1.218

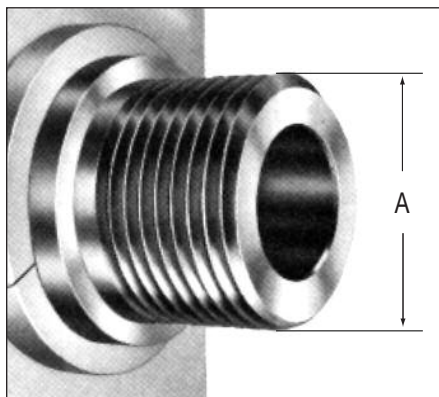
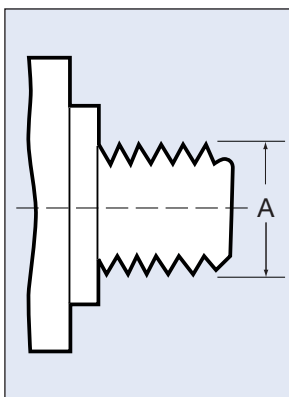
\*Tolerance +.0005/-0.000 \*\*Tolerance +.00025/-0.000



## Type L long taper key drive

	L00	L0	L1	L2	L3
A-2*	2 3/4	3 1/4	4 1/8	5 1/4	6 1/2
A-3	2	2 3/8	2 7/8	3 3/8	3 7/8
A-28	3 3/4	4 1/2	6	7 3/4	10 3/8
A-29	6TPI	6TPI	6TPI	5TPI	4TPI

\*Tolerance +.002/-0.000



## Threaded Spindle

Thread size
A
1 1/2-8
2 1/4-8
2 3/8-6



# Radio Frequency Gripmeter

**The measurement of dynamic clamping force has never been more important than it is today. With the trend for faster and faster cutting speeds and the recent changes in legislation, you cannot afford to ignore it...**

The latest version of our gripmeter now provides a host of new features resulting from the incorporation of 'state of the art' microcontrollers - including the facility to transfer measurements to your personal computer for presentation, analysis or storage. The NEW way to accurately measure the gripping force of manual and power operated chucks under both static and rotating conditions. An indispensable aid for production and maintenance engineers and a necessity for anyone concerned with machine shop safety.

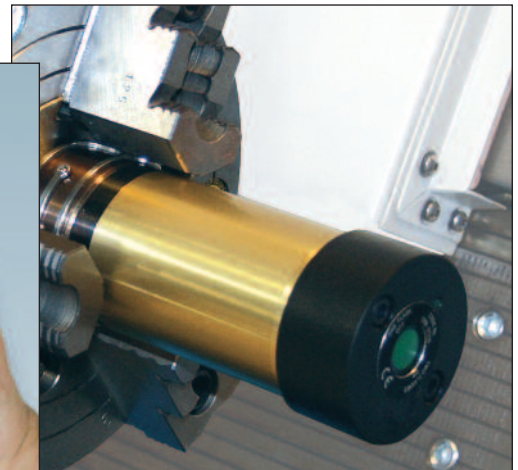
## Features...

- ⌚ One-year warranty
- ⌚ Measures the chuck's gripping force under both static and dynamic condition up to 22,480 lbf (or equivalent) per jaw
- ⌚ Measures speed of rotation up to 6000 rpm
- ⌚ Convenient and safe during use. Radio frequency signal between loadcell and handset hence no electrical slip rings or connecting wires
- ⌚ Stores up to 120 readings, comprising grip, speed, cylinder pressure and date/time stamp
- ⌚ Readings can be stored indefinitely or selectively deleted
- ⌚ PC compatible - download readings for long term storage, presentation and analysis with 'Grip Analyzer' the new Windows® compatible software from PBA
- ⌚ Read-out in any one of four selectable units kN, lbf, Mgf, Tons(long)
- ⌚ High stiffness load cell ensures accurate measurement of gripping force
- ⌚ Extension rings are included to enable measurement of larger diameters
- ⌚ Can be used for 2 jaw chucks and vices
- ⌚ Low battery warning
- ⌚ Powered by long-life batteries with automatic "power off" feature to extend battery life to the maximum. New easy battery replacement... uses 4 each AA in the readout unit and 1 each D cell 3.6 volt in the load cell.
- ⌚ No re-calibration required after a battery change
- ⌚ Automatic zeroing
- ⌚ Indication of overload
- ⌚ Complies with CE and EMC directives

HOW TO ORDER: State quantity, Part Number, and shipping instructions.

## Radio Frequency Gripmeter

The Radio Frequency Gripmeter or RFG comprises a hand held receiver unit and loadcell transmitter that is gripped in the chuck under test. The loadcell is completely self-contained and is free to rotate in the chuck to its maximum speed of 6000rpm. The loadcell when 'on' measures the grip and speed and then transmits the data at a permissible frequency (433.92Mhz) to the handset receiver. A valuable advantage of using radio frequency transmission is that there is no need for 'line of sight' between the loadcell transmitter and handset, which often can be difficult with machine guards obstructing clear view. The reading can be taken even with the loadcell and handset as much as 65.5 feet apart. The data when received at the handset is then converted to the operator's choice of units and displayed at the handset on a dot matrix screen. The grip reading is updated every 1/2 second and the speed measurement every 2 seconds. The data can then be stored at handset simply by pressing a few keys, up to 120 readings can be stored at one time. This information can subsequently be downloaded onto a PC for storage, analysis and printing. The RFG kit includes loadcell extension rings that extend the gripping diameter from 2.36" to 3.93" and 6.30". The instrument may also be used to measure the grip of 2 jaw chucks and vices.



Loadcell Transmitter

Hand Held Receiver

## RFG Kit Contents...

\* Magnet required for speed measurement

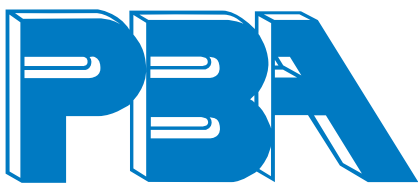


## Specifications:

Maximum Load Per Jaw (3 jaw)	22,480 lbf
Unit of Measurement (user selectable)	kN, lbf, Mgf, Tons (long)
Grip Accuracy	± 1% (FSD)
Maximum Distance Between Units	65.5'
Loadcell Diameter	2.36"
Smallest gripping Diameter Over Protection Ring	2.48"
Alternative Diameters with Extension Rings	3.94"/6.30"
Maximum speed	6000 rpm
Set Zero	Automatic
PC Communications	RS232 (serial bus)
Handset Battery	AA (four)
Loadcell Battery	D 3v long-life lithium
Part Number	1009-07360



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