

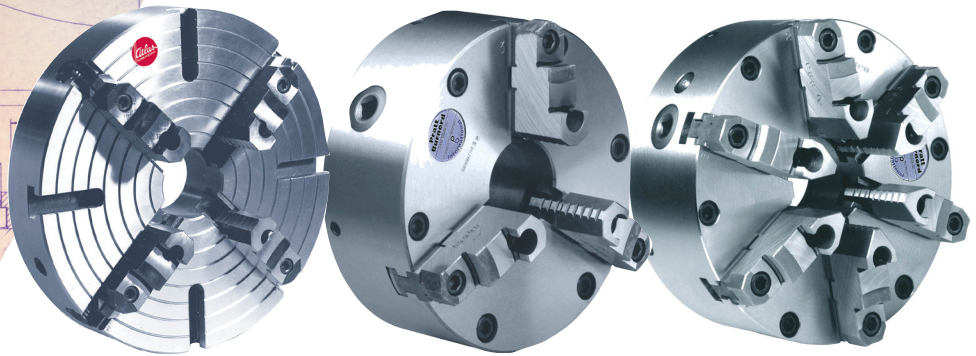
PBA

Pratt Burnerd America

Crawford Collets

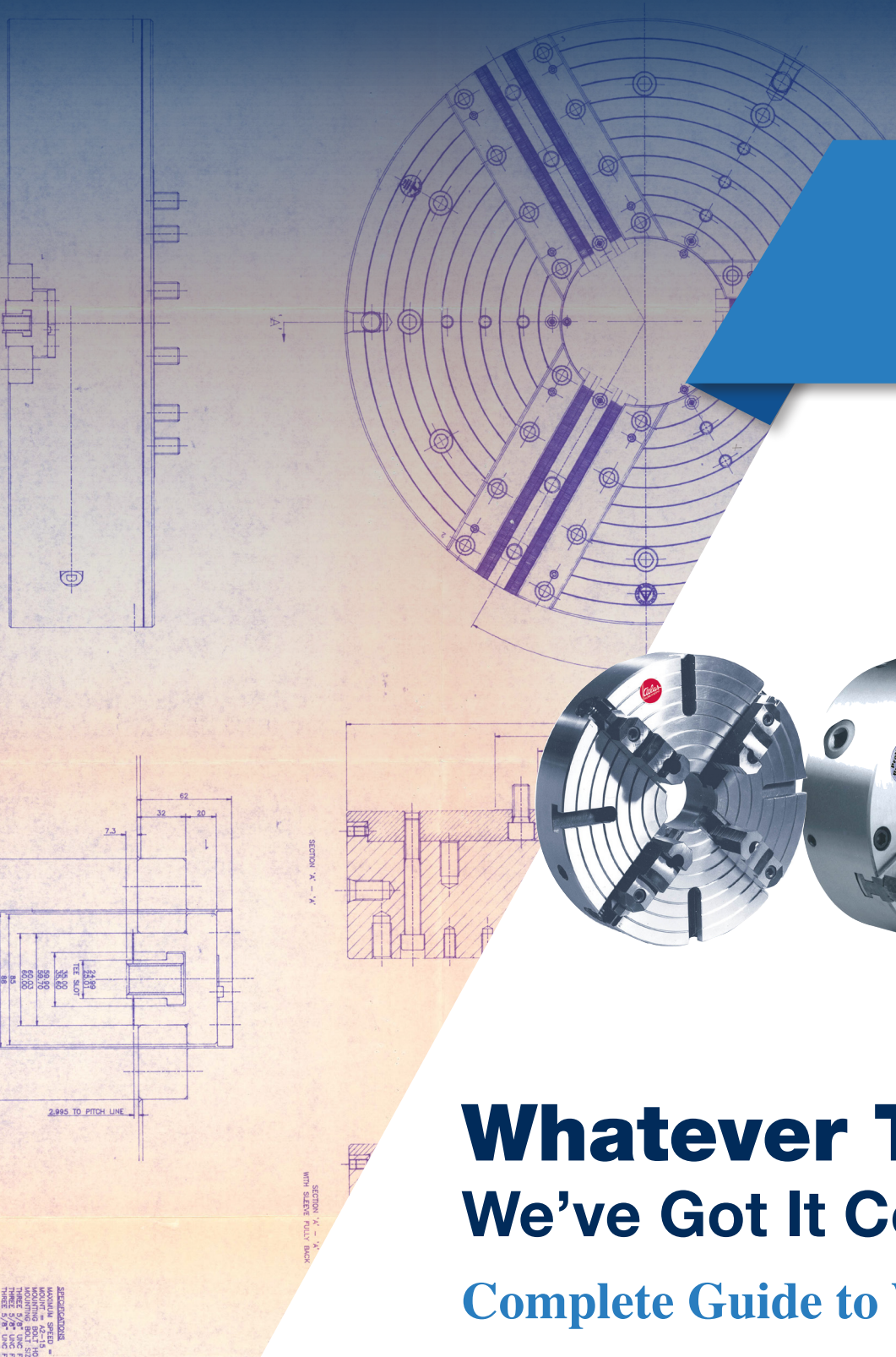


2021 CATALOG



Whatever The Size We've Got It Covered

Complete Guide to Workholding

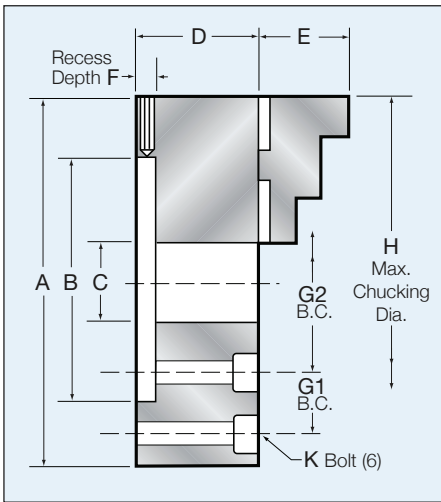
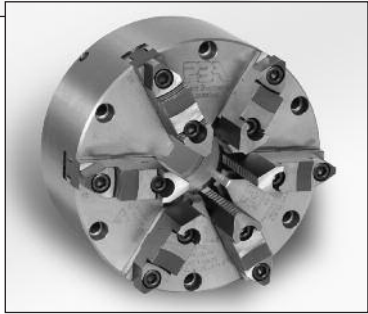


SECTION X-X, INCHES
SECTION Y-Y, INCHES
SECTION Z-Z, INCHES
WITH SLEEVE FULLY BACK
SECTION X-X, MILLIMETERS
SECTION Y-Y, MILLIMETERS
SECTION Z-Z, MILLIMETERS
MOUNTING SPEED = 1200 rpm
MOUNTING BOLT HEADS & THREE FLARE FOR
THREE 9/16" DIA. FLARE HEADS ON A 3/2"
THREE 3/4" DIA. FLARE HEADS ON A 3/2"
THREE 1" DIA. FLARE HEADS ON A 3/2"

Index of Products

Self-Centering Universal Scroll & Independent Chucks with Mounting Plates	SETRITE® Self-Centering 253 & 263 Series 3 & 6-Jaw Universal Chucks	4
	Easy-Set™ Self-Centering Series 3-Jaw Universal Chucks	6
	Self-Centering 234 & 235 Series 3-Jaw Chucks	8
	Self-Centering Dust-Proof 3-Jaw Universal SG Iron Body Chucks With 1.5X60 Degree Jaw	10
	Special Manual Large Thru-Hole Rotary Table Chucks and Lathe Chucks	11
	Chuck Semi-Finished Mounting Plates	12
	Self-Centering Series 342 3-Jaw Universal Iron Body Chucks.	13
	Self-Centering Series 332 3-Jaw Universal Chucks (A, L and D Type Mounting)	14
	Self-Centering 4-Jaw Universal Steel Body Chuck Series 732	15
	2-Jaw Self Centering Scroll Chucks	16
	King Bore Oil Country Series 332EX 3-Jaw Universal Heavy-Duty Chucks	17
	King Bore Oil Country Series 432EX 4-Jaw Independent Extra Heavy-Duty Chucks	18
	Series 441 4-Jaw Independent Chucks	19
	Series 144 Medium-Duty and 145 Heavy-Duty 4-Jaw Independent Chucks	20
	Series 432 4-Jaw Standard Steel Body Independent Chucks.	22
	Heavy-Duty 4-Jaw Independent Chucks.	23
	Heavy-Duty 4-Jaw Independent XLChucks.	24
	4-Jaw Independent Manual VTL Chucks	25
	Self-Centering VTL Manual 3-Jaw Universal	26
	4-Jaw Large Diameter Combination Chucks for Large Swing Lathes and VTL	27
	Chuck Face Plates up to 275"	28
	Boring Mill Jaws for Parallel Tee-slot and Face Plate Jaws for Radial Tee-slot	29
	Atlas Series MCA Super Thin Square Chucks.	30
Atlas Series NBK Super Thin Round Chucks	31	
Power Chucks	Quick-Change Jaw Grip Fast Power Chucks, Standard and King Bore and Jaw Presetting Fixture.	32
	3-Jaw Constant Grip Power Chuck	34
	Quick-Change 2-Jaw Power Chucks and Jaw Presetting Fixture	36
	Closed Center Constant Grip Quick-Change and Non-Quick Change Power Chucks	38
	MK4 3-Jaw Self-Contained Power Chucks	40
	ATL Series Power Chucks 5" Thru 32"	42
	2ATL 2-Jaw High Speed Open Center 6" - 18" Power Chuck.	44
	ATLB Series King Bore Power Chucks 6"Thru 18"	46
	PA 18" Thru 63" 3-Jaw Wedge Type Closed Center Power Chucks	47
	ALS 6" Thru 10" 3-Jaw Open Center Long Stroke Power Chucks	48
	Large Closed Center Adjustable Jaw Power Chucks for Vertical and Horizontal Lathes	49
	4ATL 6" Thru 24" 4-Jaw Universal Power Chuck	50
	PAFH 8" Thru 24" 2/3-Jaw Thru-Hole Power Chucks.	51
	PDD 4" Thru 15" Draw Down Power Chucks	52
	DFC 7" Thru 16" Floating Type Compensating Power Chucks	53
BL 6" Thru 21" Ball Lock Power Chucks.	54	
OLU 6" Thru 10" Stationary 2, 3, and 4-Jaw Power Chucks.	56	
Cylinders	Cylinder-integrated Diaphragm Chuck	57
	MK Series High Speed Thru-Hole Hydraulic Cylinders	58
	ATL-KBC King Bore Open Center Hydraulic Cylinders Large	59
	ATL Series High Speed Thru-Hole Hydraulic Cylinders	60
	ATL-CC Series Closed Center Rotary Hydraulic Cylinders.	62
	ATL250C/ATL300C Closed Center Rotary Hydraulic Cylinders	63
	ATLV Series Closed Center Rotary Hydraulic Cylinders	64
Spindle Conversion Adapters	65	

Top Tooling	Top Jaws and Accessories	66	
	Top Tooling American Standard Tongue & Groove.	67	
	Top Tooling 1.5mm x 60° Serrations and 3mm x 60° Serrations	68	
	Top Tooling Square Serrations.	69	
	Top Tooling 1/16" x 90° and 3/32" x 90° Serrations	70	
	Top Tooling American Standard Acme Serrations	71	
	Guide to Top Tooling	72	
	Machining Soft Blank Top Jaws	74	
	<hr/>		
	Collet Chucks	Quick Change 5C Collet Chuck	76
Quickie Front Hand Wheel Quickie 5C Collet Chuck		77	
Quickie Front Hand Wheel Quickie 16C Collet Chuck		78	
5C & 16C Dead-Length and Pull Back Power Chucks (A Type Mounts)		79	
CPC Series Dead-Length Collet Chucks		80	
Air Powered Front Mount 5C Dead Length Collet Chucks.		81	
Air Powered Front Mount 16C Dead Length Collet Chucks.		82	
Air Powered Front Mount B42 Dead Length Collet Chucks		83	
Air Powered Front Mount B60 Dead Length Collet Chucks		84	
Stationary ATL225-5C Dead Length Collet Chuck.		85	
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Collets	Crawford 5C Collets (inch)	86	
	Crawford 5C Collets (metric)	87	
	Crawford 16C Collets (inch)	88	
	Crawford 16C Collets (metric)	89	
	Crawford B-42 Collets (inch)	90	
	Crawford B-42 Collets (metric)	91	
	Crawford B-60 Spring Series Collets 185E (inch & metric)	92	
	Crawford B-60 Spring Series Collets 185E (metric)	93	
	Crawford B-80 Spring Series Collets 193E (inch & metric)	94	
	Crawford 3J Collets (inch)	95	
	Crawford Plain Bore Multibore Collets	96	
	Crawford Multibore Collets DIN 6343 Serrated Bore	97	
	Crawford B42, B60 & B80 Type Collet Accuracy Chart	98	
	Crawford 5C and 16C Collet Accuracy Chart	99	
	PBA Chuck Lubricant	100	
	American Spindle Nose Data	101	



Jaws shown in O.D. position

Self-Centering Universal Forged 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 15"
- ⚙️ Semi-steel body on the 5" chucks ⚙️ 4 adjusting screws - 5", 6", 8", 10", 12"
- ⚙️ 8 adjusting screws - 15" ⚙️ Sizes 5" to 15"
- ⚙️ Nitride hardened scroll ⚙️ Hardened pinion
- ⚙️ Two-piece American standard tongue and groove jaws on chuck sizes 6" thru 15"
- ⚙️ 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"
- ⚙️ Durability - double the contact surface of the master jaw and body versus our competitor's chucks

Chuck Size (in)	Model Number	Approx. Weight (lbs)	Maximum RPM*
253 Series - 3 Jaw			
5	0515400	14	5000
6	0625300	26	4900
8	0825300	46	4200
10	1025300	71	3300
12	1225300	120	2300
15*	1525300	218	2000
263 Series - 6 Jaw			
5	0516400	15	3600
6	0626300	27	3500
8	0826300	49	3000
10	1026300	76	2400
12	1226300	130	2000
15	1526300	226	1500

*Come with three t-slots

*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"

* Tolerance - .000/+ .001 **6-Jaw Chuck minimum grip, consult factory

Soft top jaws shown on page 67. ® Ajust-Tru is a registered trade mark of Illinois Tool Works.

**Contact us for maximum bore diameters & boring fees.

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"
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
D-11	-	-	-	1205025	1505025

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

Spindle	6"	8"	10"	12"	15"
A-4	0605009	-	-	-	-
A-5	0605010	0805010	1005010	-	-
A-6	-	0805011	1005011	1205011	-
A-8	-	-	1005012	1205012	1505012
A-11	-	-	-	-	1505013

Type L American Standard Long Taper Key Drive Spindle

Spindle	6"	8"	10"	12"	15"
L-00	0605031	0805031	1005031	-	-
L-0	0605032	0805032	1005032	1205032	-
L-1	-	0805033	1005033	1205033	1505033
L-2	-	-	-	1205034	1505034
L-3	-	-	-	-	1505035

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

Spindle	5"	6"	Spindle	5"	6"	8"	10"	12"
4° Taper	0505044	0605044	Blank	0505040	0605040	0805040	1005040	1205040
2 ³ / ₁₆ "-10 Threaded	0505045	0605045	1 ¹ / ₂ "-8	0505041	0605041	0805041	-	-
			1 ³ / ₄ "-8	0505042	0605042	0805042	-	-
			2 ¹ / ₄ "-8	0505043	0605043	0805043	-	-
			2 ³ / ₈ "-6	-	0605046	0805046	-	-

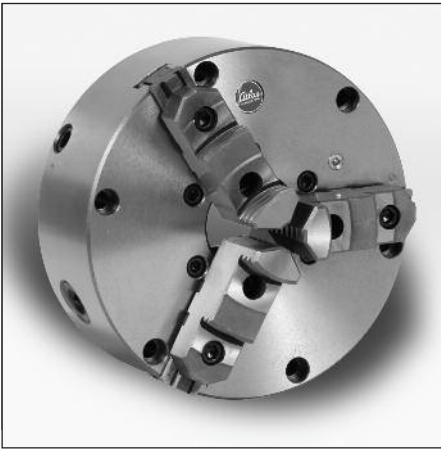
Rotary table adapter also available

*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 101.

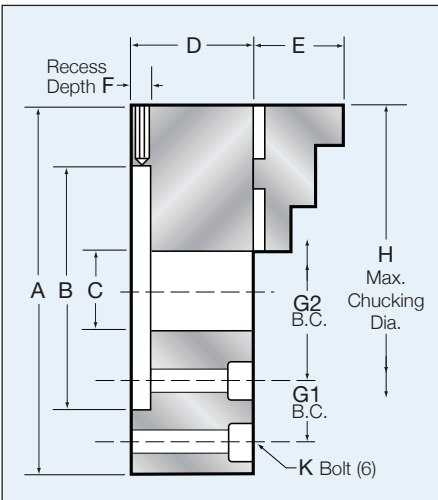


Easy-Set™ Self-Centering Universal Chuck

Low Cost 3-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*
Easy-set 3-Jaw			
6	EZ63	20	3000
8	EZ83	43	2500
10	EZ103	67	2000
12	EZ123	115	1500
15	EZ153	225	1000

*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"	2.52"	1.728"	0.69"	5.34"	-	6.5"	1/4"	1/8"	5"
8"	8.25"	4.750"	2.362"	3.122"	1.141"	0.732"	7.50"	-	8.5"	3/8"	3/16"	6 1/2"
10"	10.0"	6.375"	3.031"	3.504"	2.118"	0.803"	-	4.38"	11.0"	7/16"	15/32"	8"
12"	12.0"	7.906"	4.055"	4.035"	2.492"	0.799"	-	5.25"	12.5"	1/2"	27/64"	10"
15"	15.0"	11.781"	4.567"	5.362"	2.866"	1.091"	-	6.75"	16.0"	5/8"	9.16"	15"

* Tolerance - .003/+ .002 **Contact us for maximum bore diameters & boring fees.

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 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	1005021	-	-
D-5	0605022	0805022	1005022	-	-
D-6	-	0805023	1005023	1205023	1505023
D-8	-	-	1005024	1205024	1505024
D-11	-	-	-	1205025	1505025

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

Spindle	6"	8"	10"	12"	15"
A-4	0605009	-	-	-	-
A-5	0605010	0805010	1005010	-	-
A-6	-	0805011	1005011	1205011	-
A-8	-	-	1005012	1205012	1505012
A-11	-	-	-	-	1505013

Type L American Standard Long Taper Key Drive Spindle

Spindle	6"	8"	10"	12"	15"
L-00	0605031	0805031	1005031	-	-
L-0	0605032	0805032	1005032	1205032	-
L-1	-	0805033	1005033	1205033	1505033
L-2	-	-	-	1205034	1505034
L-3	-	-	-	-	1505035

For Hardinge® and Elgin Lathe

Spindle	6"
4° Taper	0605044
2¾"-10 TH'D	0605045

Rotary table adapters also available

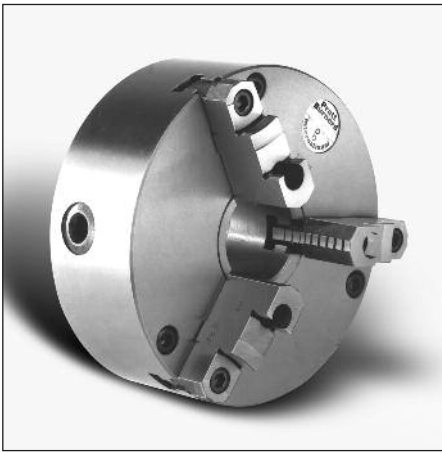
Threaded & Blank Mountings* for Easy-Set™ Chucks

Spindle	6"	8"
Blank	0605040	0805040
1½"-8	0605041	0805041
1¾"-8	0605042	0805042
2¼"-8	0605043	0805043
2⅝"-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 101.

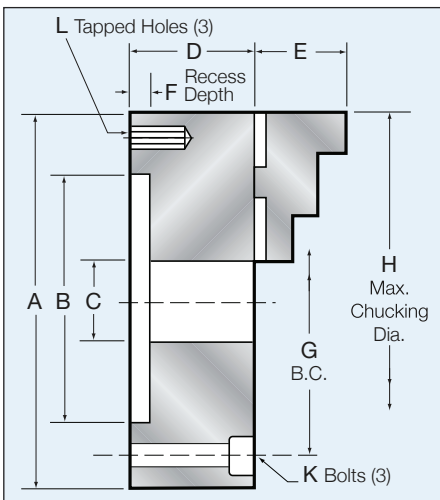


Self-Centering High Quality 3-Jaw Universal Chucks

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

- ⌚ Two-year warranty
- ⌚ Precision manufactured for adapter plate 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 234 & 235 Series Adapter Mount 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

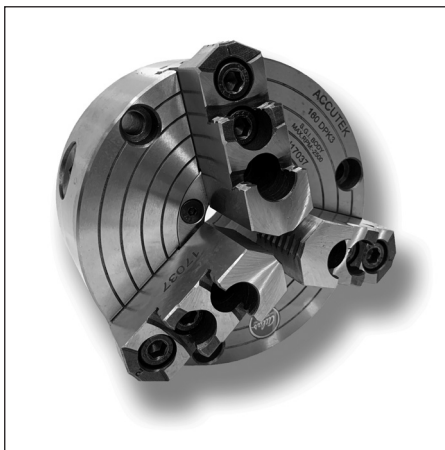
Type L American Standard Long Taper Key Drive Spindles

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

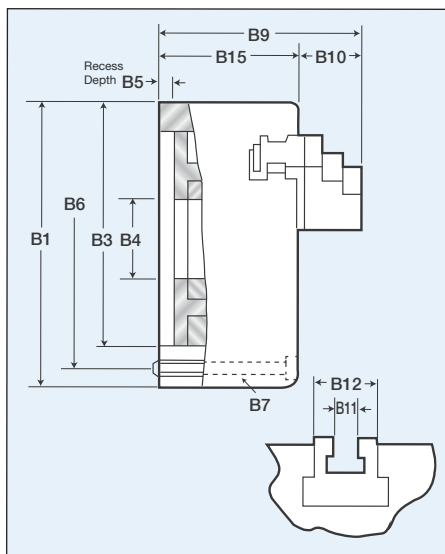
Special adapter plates available upon request. Specify chuck number and spindle nose specifications. For spindle nose specifications, see page 101.



Self-Centering Dust-Proof 3-Jaw Universal SG Iron Body Chucks with 1.5mm X60 degree jaw

Dust Proof Chuck Medium-Duty Flatback, D and A Type Mounting Size 6" thru 12"

- ⊕ Uses 1.5mm X60 degree master jaws and top jaws
- ⊕ One year warranty
- ⊕ Standard chuck sizes 6" Thru 12"
- ⊕ Maximum .003" TIR using nomination pinion
- ⊕ Hardened scroll
- ⊕ Three hardened pinions
- ⊕ SG iron bodies
- ⊕ Precision manufactured for adapter plate mounting



Chuck Size	Flatback Chuck No.	Type D Spindle Size	Chuck No.	Type A Spindle Size	Chuck No.
6"	06DP300	D-4	06DP321	A-4	06DP309
6"	-----		-----	A-5	06DP310
8"	08DP300	D-4	08DP321		-----
8"	-----	D-5	08DP322	A-5	08DP310
10"	10DP300	D-5	10DP322	A-5	10DP310
10"	-----	D-6	10DP322	A-6	10DP312
10"	-----	D-8	10DP322	A-6	10DP311
12"	12DP300	D-6	12DP323	A-6	12DP311
12"	-----	D-8	12DP324	A-8	12DP312

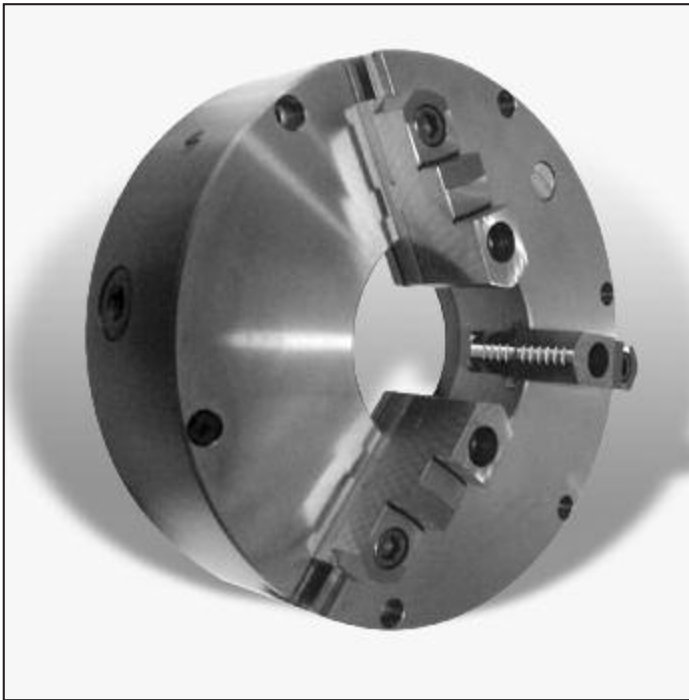
Dimensions for Universal Flatback Mounting Chucks with Two-piece Jaws (in/mm)

Chuck Size	B1	B3	B4	B6	B7	B9	B10	B11	B12	B15	Max RPM
6"/152	6.30"/160	4.92"/125	1.45"/37	5.51"/140	M-10	4.65"/118	1.85"/47	.47"/12	2.80"/71	1.18"/30	2500
8"/203	7.87"/200	6.30"/160	1.97"/50	6.93"/176	M-10	5.35"/136	2.17"/55	.55"/14	3.19"/81	1.34"/34	2000
10"/254	9.84"/250	7.87"/200	2.76"/70	8.81"/224	M-12	5.83"/149	2.28"/58	.63"/16	3.54"/90	1.38"/35	1600
12"/305	12"/315	10.83"/200	3.94"/80	11.26"/286	M-12	6.30"/160	2.36"/85	.83"/21	2.44"/62	1.77"/45	1300

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

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
- ⌚ Consult factory for specifications



3-Jaw Universal Chucks



4-Jaw Independent Chucks

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.

"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

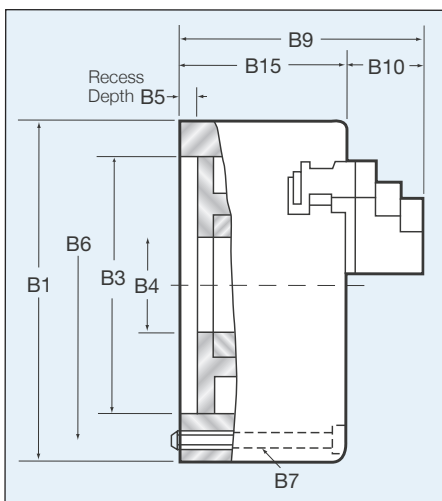
Part No.	Spindle Type	Diameter	Plate Thickness
0503039	1-10	5.0"	.750"
0503041	1-1/2-8	5.0"	.750"
0603041	1-1/2-8	6.312"	.687"
0603042	1-3/4-8	6.312"	.687"
0603043	2-1/4-8	6.312"	.687"
0803043	2-1/4-8	7.875"	.781"
0803046	2-3/8-6	7.875"	.781"
1003043	2-1/4-8	9.875"	.906"
1203046	2-3/8-6	12.42"	1.10"



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".

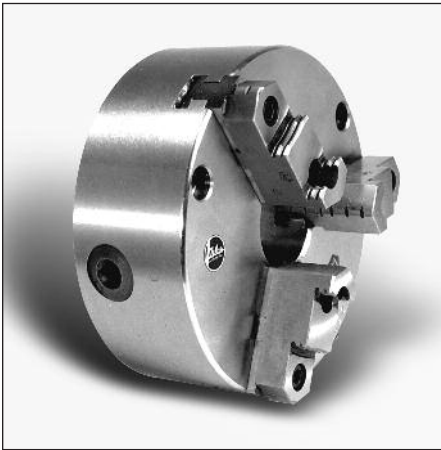
Dimensions for Universal Flatback Mounting Chucks with Two-piece Jaws (in/mm)

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-8	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	17.32"/440	7.87"/200	.236"/6	18.31"/465	(6) M-16	7.99"/203	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

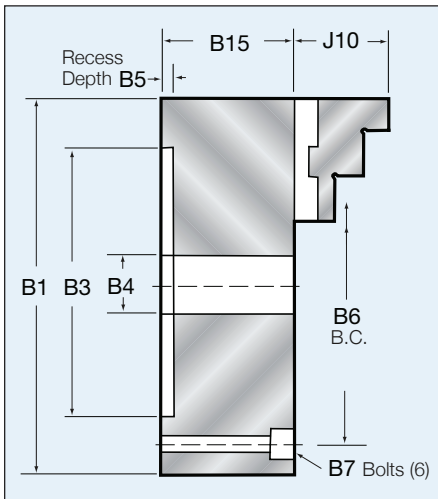
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



Self-Centering 3-Jaw Universal Steel Body 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"	6.49" ⁽¹⁾	.236"	18.03"	M-16	5.51"	3.19"	1200
24"	25.59"	21.456"	8.07" ⁽¹⁾	.236"	23.07"	M-16	5.51"	3.19"	972
28"	27.5"	23.818"	8.859"	.236"	25.98"	M-20	5.71"	3.66"	873
32"	31.5"	28.740"	10.55"	.236"	29.92"	M-20	6.10"	3.66"	764

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.

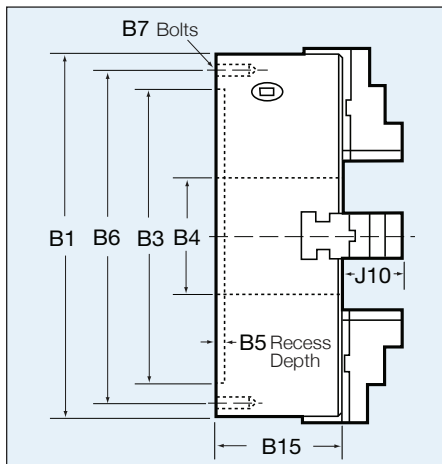


Self-Centering 4-Jaw Universal Steel Body Chucks

Series 732 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		

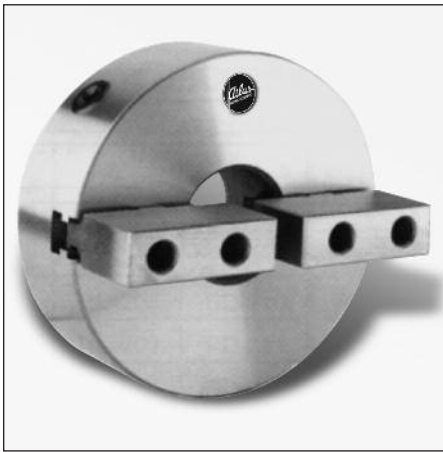


Dimensional Data For Universal Flatback Mounting Chucks with Two-piece Jaws

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"	7.952"	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.

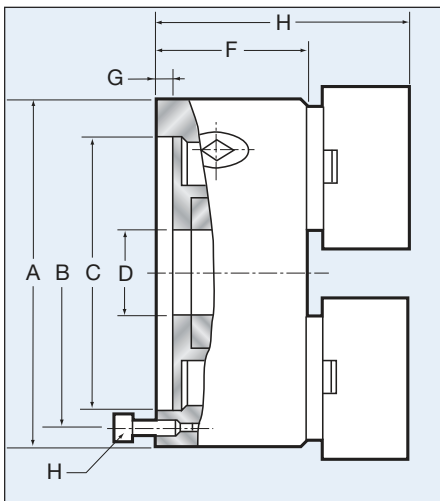


Self-Centering 2-Jaw Scroll Chucks

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",
- ⊕ Semi-steel body
- ⊕ Comes with master jaws and soft top jaws, T-wrench and mounting screws
- ⊕ One year warranty
- ⊕ Precision manufactured for adapter plate mounting

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	0624-20A1
6"		D-4	0624-20D4	L-0	0624-20L0	A-5	0624-20A5	1-3/4-8	0624-20A2
6"								2-1/4-8	0624-20A3
6"								2-3/8-6	0624-20A6
8"	0824-2000	D-4	0824-20D4	L-00	0824-2L00	A-5	0824-20A5	2-1/4-8	0824-20A3
8"		D-5	0824-20D5	L-0	0824-20L0	A-6	0824-20A6	2-3/8-6	0824-20A6
8"		D-6	0824-20D6						
10"	1024-2000	D-5	1024-20D5	L-0	1024-20L0	A-5	1024-20A5	2-1/4-8	1024-20A3
10"		D-6	1024-20D6	L-1	1024-20L1	A-6	1024-20A6	2-3/8-6	1024-20A6
10"		D-8	1024-20D8			A-8	1024-20A8		
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				
12"									
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

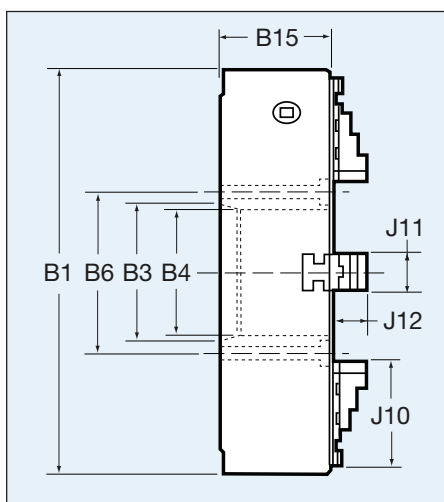
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



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 [Ⓜ]	850	670 lbs
28	2833-2A15EX	A2-15	11.06	750	890 lbs
28	2833-2A20EX	A2-20	12.60 [Ⓜ]	750	870 lbs
32	3233-2A15EX	A2-15	11.06	600	1290 lbs
32	3233-2A20EX	A2-20	12.60 [Ⓜ]	600	1270 lbs
36	3633-2A20EX	A2-20	12.60 [Ⓜ]	550	1610 lbs
40	4033-2A20EX	A2-20	14.56 [Ⓜ]	500	1975 lbs
40	4033-2A28EX	A2-28	18.50	500	1910 lbs

[Ⓜ]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 [Ⓜ]	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 [Ⓜ]	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 [Ⓜ]	9.175"	7.09"	8.50"	2.95"	3.62"
3633-2A20EX	35.43"	A2-20	16.25"	12.60 [Ⓜ]	9.175"	7.48"	9.84"	2.95"	3.62"
4033-2A20EX	39.37"	A2-20	16.25"	14.56 [Ⓜ]	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"

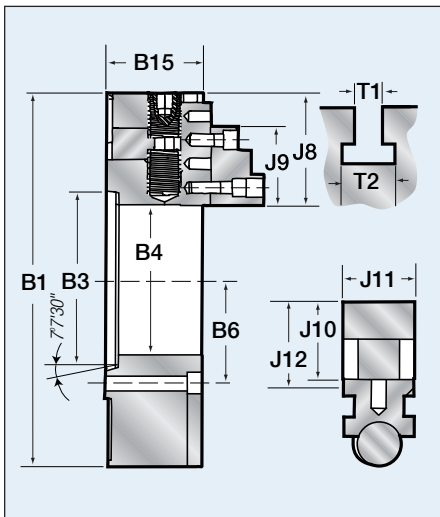
HOW TO ORDER: State quantity, model number of chuck, part number of adapter, and shipping instructions.



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 upon request



Chuck Size	Model No.	Mount	Thru Hole	Max rpm's ^①	Approx. Weight
18	1843-2A11EX	A2-11	6.70"	1350*	230 lbs
21	2143-2A11EX	A2-11	6.70"	1150	460 lbs
21	2143-2A15EX	A2-15	7.30"	1150	460 lbs
24	2443-2A11EX	A2-11	6.70"	970	660 lbs
24	2443-2A15EX	A2-15	11.06"	970	660 lbs
24	2443-2A20EX	A2-20	12.60"	970	660 lbs
28	2843-2A15EX	A2-15	11.06"	870	825 lbs
28	2843-2A20EX	A2-20	12.60"	870	825 lbs
32	3243-2A15EX	A2-15	11.06"	760	1,190 lbs
32	3243-2A20EX	A2-20	12.60"*	760	1,190 lbs
36	3643-2A20EX	A2-20	12.60"*	670	1,540 lbs
40	4043-2A20EX	A2-20	12.60"*	600	1,800 lbs
40	4043-2A28EX	A2-28	18.50"	600	1,800 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"	6.70"	4.625"	5.75"	6.50"	5.00"	2.87"	2.40"	3.26"	.708"	1.557"
2143-2A11EX	21"	A2-11	7.75"	6.70"	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"	6.70"	4.625"	6.10"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2443-2A15EX	23.62"	A2-15	11.25"	11.06"	6.50"	6.10"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2443-2A20EX	23.62"	A2-20	16.25"	12.60"	9.125"	6.10"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2843-2A15EX	27.55"	A2-15	11.25"	11.06"	6.50"	6.10"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
2843-2A20EX	27.55"	A2-20	16.25"	12.60"	9.125"	6.10"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3243-2A15EX	31.49"	A2-15	11.25"	11.06"	6.50"	6.50"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3243-2A20EX	31.49"	A2-20	16.25"	12.60"	9.125"	6.50"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
3643-2A20EX	35.43"	A2-20	16.25"	12.60"	9.125"	6.50"	8.00"	5.00"	3.26"	3.00"	3.62"	.866"	1.557"
4043-2A20EX	39.37"	A2-20	16.25"	12.60"	9.125"	6.50"	8.00"	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"	8.00"	5.00"	3.26"	3.00"	3.62"	1.100"	1.565"

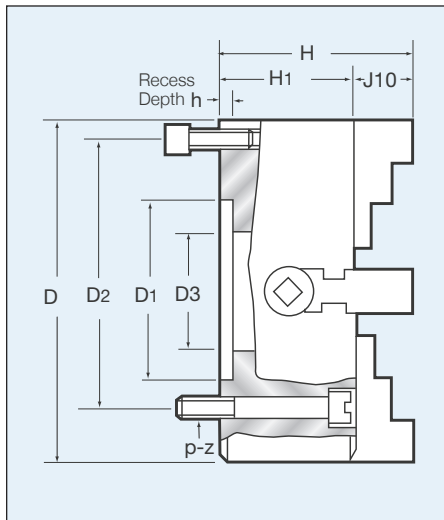
HOW TO ORDER: State quantity, model number of chuck, part number of adapter, and shipping instructions.



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.	D	D1	D2	D3	H	H1	h	z-d
5"/125	4.921"/125	3.740"/95	4.252"/108	1.181"/30	3.071"/78	2.205"/56	0.197"/5	4-M8
6"/160	6.290"/160	2.560"/65	3.740"/95	1.772"/45	3.661"/93	2.559"/65	0.197"/5	4-M10
8"/200	7.844"/200	2.953"/75	3.740"/95	2.165"/55	4.212"/107	2.953"/75	0.236"/6	4-M10
10"/250	9.842"/250	4.351"/110	5.118"/130	2.953"/75	4.724"/120	3.149"/80	0.236"/6	4-M12
12"/315	12.406"/315	5.512"/140	6.496"/165	3.740"/95	5.433"/138	3.543"/90	0.236"/6	4-M16
16"/400	15.748"/400	6.300"/160	7.283"/185	4.921"/125	5.630"/143	3.740"/95	0.315"/8	4-M16
18"/450	17.17"/450	7.08"/180	8.07"/205	5.51"/140	5.79"/147	3.94"/100	0.15"/8	4-M16
20"/500	19.685"/500	7.874"/200	9.291"/236	6.300"/160	6.300"/160	4.134"/105	0.315"/8	4-M20
24"/630	24.803"/630	8.661"/220	10.157"/258	7.866"/180	7.087"/180	4.567"/116	0.394"/10	4-M20
32"/800	31.493"/800	9.842"/250	11.811"/300	8.267"/210	8.267"/210	5.319"/135	0.472"/12	4-M20

Note: Dimensions are for flatback-mounted chucks; on A, L and D mounted chucks dimension H1 & H will vary. All A & D-11 mount chucks have 6.5" thru-hole as standard.

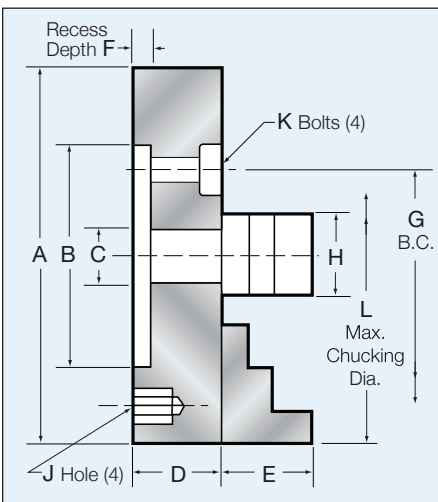
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



4-Jaw High Quality Independent Chucks

Medium Duty-144 Series Heavy Duty-145 Series

- ⊕ Two-year warranty precision manufactured for adapter plate mounting
- ⊕ Ductile iron body
- ⊕ Sizes 6" - 16"
- ⊕ Hardened operating screws
- ⊕ Solid reversible hard jaws
- ⊕ Special jaw and jaw way design adding extra bearing surfaces, increasing 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"*	1224400	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"*	1624500	A-11	1614513	D-11	1614525	L-2	1614534

Larger diameter chucks available, contact us for price and delivery.
*2 piece American standard T & G Jaws

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

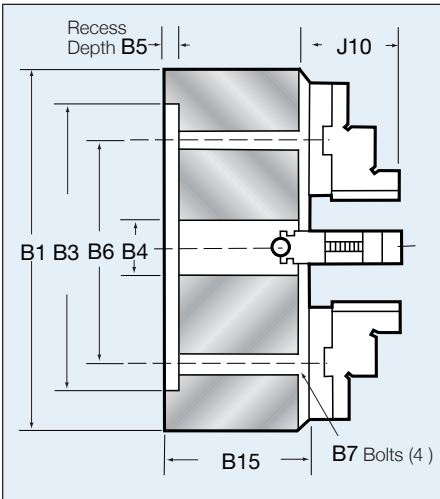
Special adapter plates available upon request. Specify chuck number and spindle nose specifications. 6", 8", 10" and 12" adapters are the same as 3 Jaw adapters on page 9. For standard spindle dimensions, see page 101.



4-Jaw Standard Independent Steel Body Chucks

Series 432 Heavy-Duty Steel Body Sizes 18" - 80"

- ⌚ One year warranty
- ⌚ Sizes 18" thru 80"
- ⌚ Two-piece American standard tongue and groove jaws
- ⌚ Hard reversible top jaws
- ⌚ Hardened and ground operating screws
- ⌚ Steel body
- ⌚ T-slots standard
- ⌚ Straight recess for adapter mounting
- ⌚ **Larger chucks available up to 80" upon request**



Chuck Size	Flatback Chuck No.	Type A Spindle Size	Type A Spindle Chuck No.	Type D Spindle Size	Type D Spindle Chuck No.
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"	154 lbs.
16"	15.74"	10.236"	4.13"	.295"	11.26"	M-12	3.86"	2.34"	220 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.

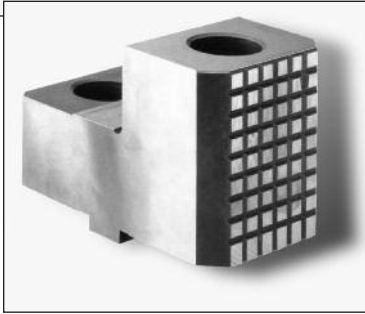
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



Heavy-Duty 4-Jaw Independent Chucks

32" to 79" Steel Body chucks

- ⌚ One year warranty
- ⌚ Heavy-duty steel body
- ⌚ Two-piece jaws
- ⌚ Long master jaws
- ⌚ One step reversible 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

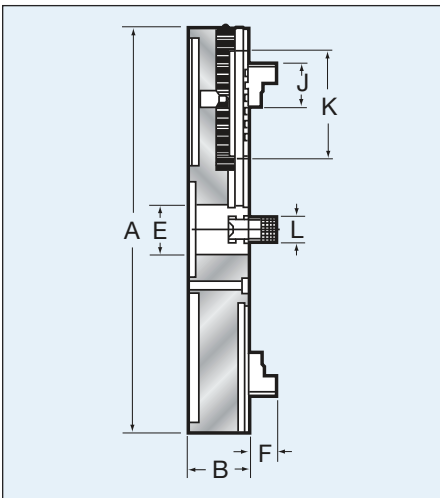


Optional Long Base Jaw

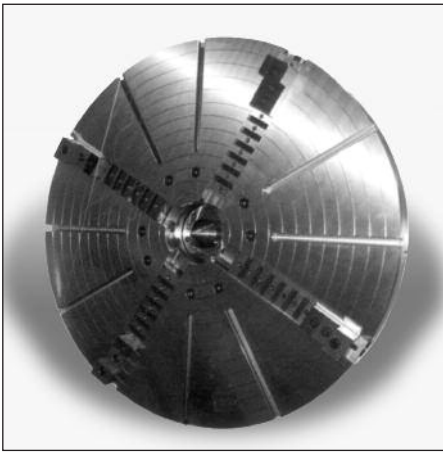
Chuck Size	Recess Mount Cast Steel	Size	Type A Spindle Cast Steel
32"	3224500	A-8	3224512
32"		A-11	3224513
32"		A-15	3224514
36"	3624500	A-11	3624513
36"		A-15	3624514
40"	4024500	A-11	4024513
40"		A-15	4024514
40"		A-20	4024515
48"	4824500	A-11	4824513
48"		A-15	4824514
48"		A-20	4824515
55"	5524500	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"



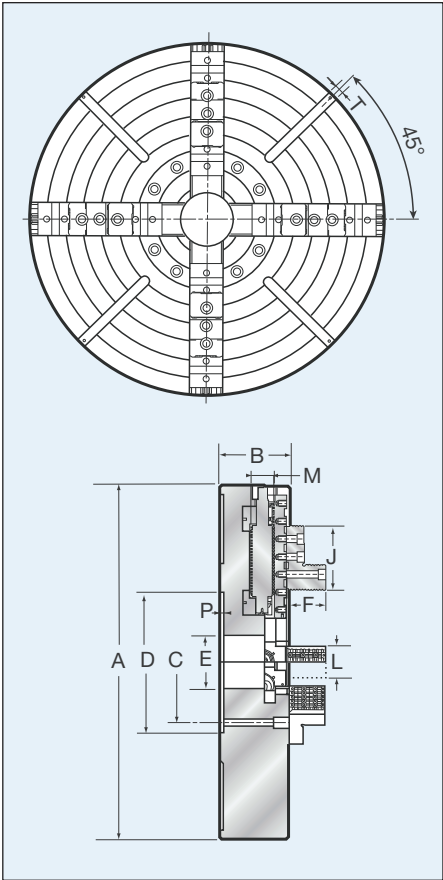
HOW TO ORDER: State quantity, chuck number, and shipping instructions.



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

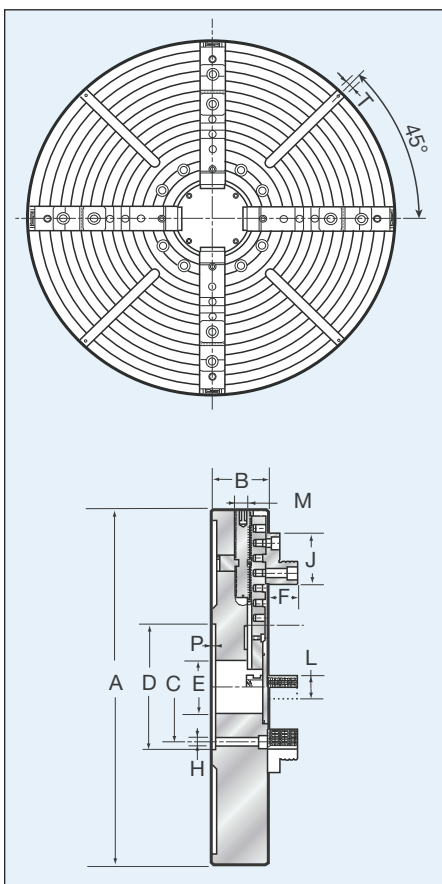
HOW TO ORDER: State quantity, model number of chuck, part number of adapter, and shipping instructions.

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



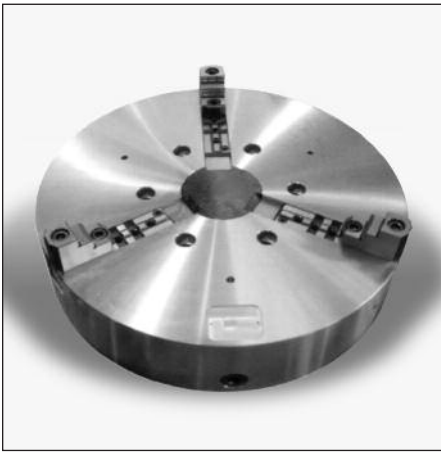
(mm/inch)

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	135/3.31	235/9.25	300/11.81	8xM20	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
700/27.5	135/3.31	235/9.25	300/11.81	8xM20	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
800/31.5	135/3.31	330/12.99	380/14.96	8xM24	74/2.91	130/5.12	60/2.36	4x22/.866	40/1.575
900/35.4	135/3.31	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

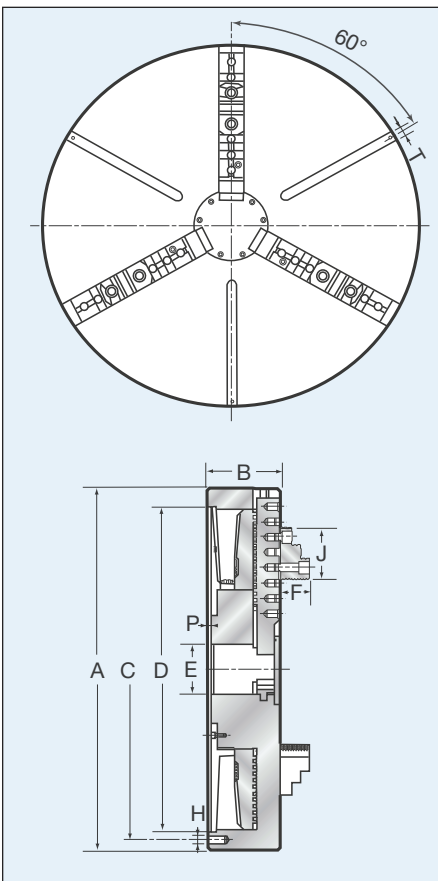
HOW TO ORDER: State quantity, model number of chuck, part number of adapter, and shipping instructions.



Self-Centering VTL Manual 3-Jaw Universal Chucks

Sizes 700mm/27.5" to 1800mm/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	5533-2000VTL	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

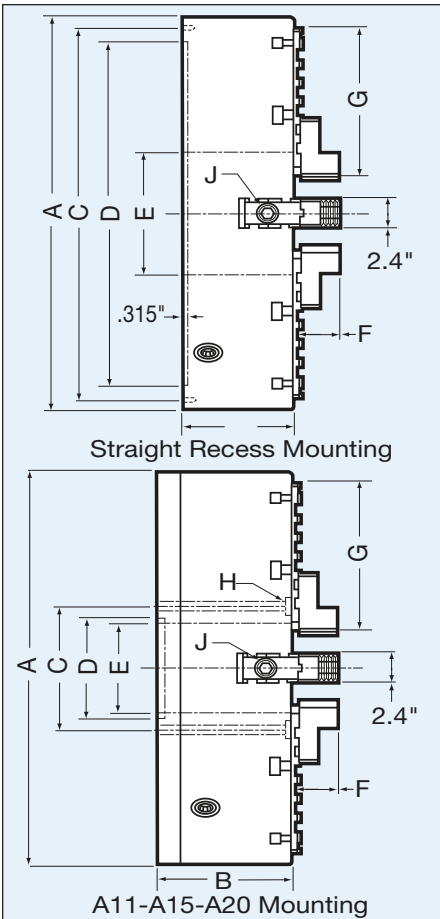
24" - 120" Chucks

- ⊕ 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

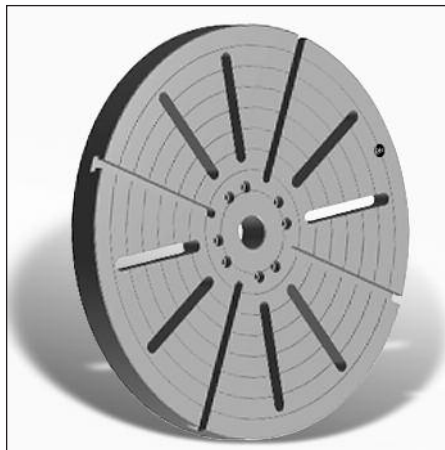
For sizes larger than 40" consult factory

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"

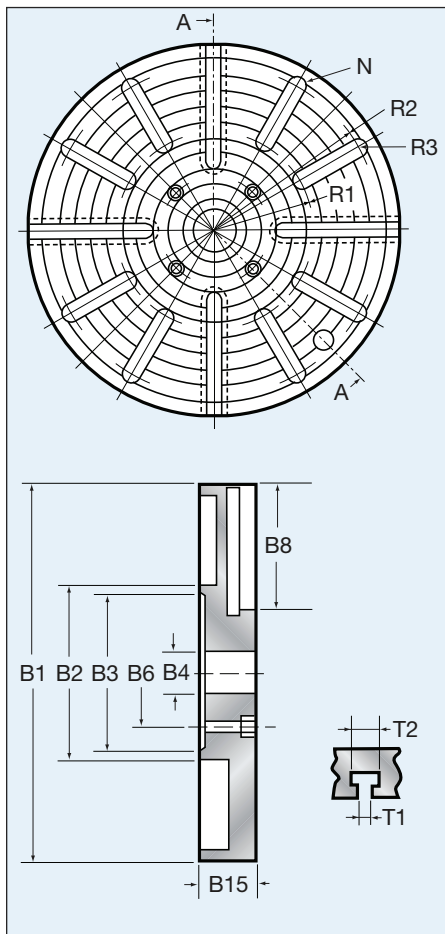
HOW TO ORDER: State quantity, model number of chuck and shipping instructions.



Face Plates up to 275"

- ⊕ Steel or cast face plate for special fixturing needs
- ⊕ All face plates are custom made in USA
- ⊕ 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



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

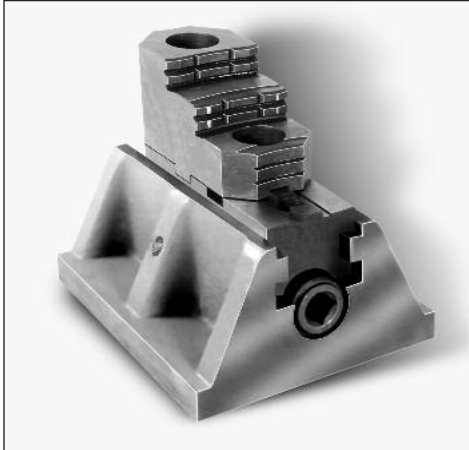
Dimensional Data (in inch)

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
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
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
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
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
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
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
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

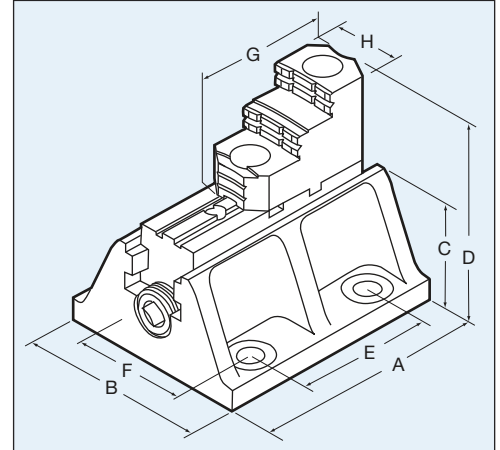
Boring Mill Jaws for Parallel Tee-slot and Face Plate Jaws for Radial Tee-slot

- 🕒 One year warranty
- 🔧 Heavy duty
- 📦 Set of 4

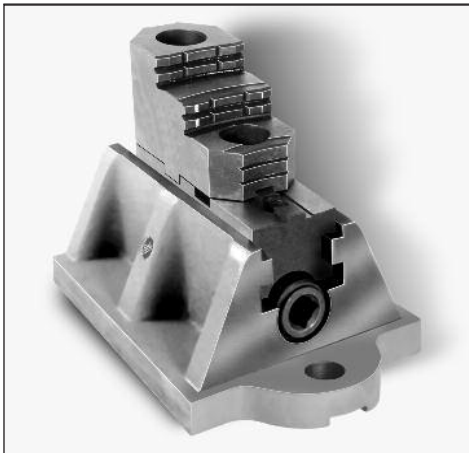
Boring Mill Jaw Set with 2 piece Jaw for Parallel Tee Slots



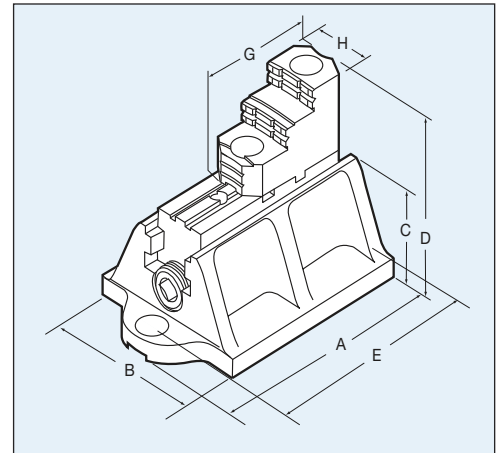
Model	1BL0100300	1BL0100400
A	8.26"	12.00"
B	6.77"	8.66"
C	3.86"	4.66"
D	7.10"	8.40"
E	4.92"	7.00"
F	4.92"	6.00"
G	5.00"	5.00"
H	2.36"	2.95"



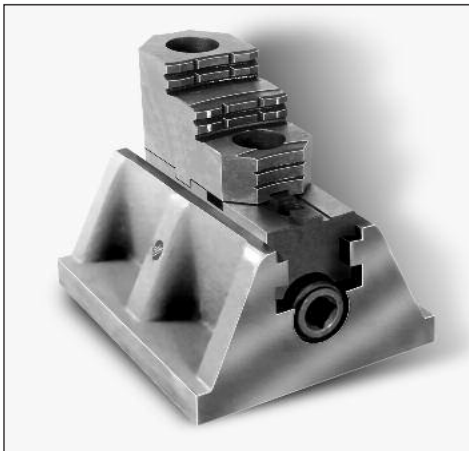
Face Plate Jaw Set with 2 piece Jaw for Radial Tee Slots



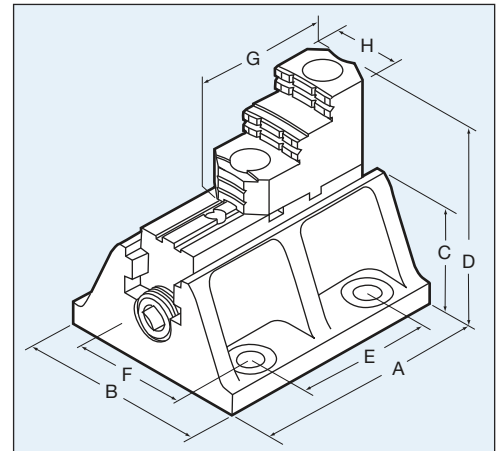
Model	1BL0000600
A	14.17"
B	6.69"
C	3.65"
D	8.40"
E	12.40"
G	5.00"
H	2.95"



Low Cost Boring Mill Jaw Set with 2 piece Jaw for Parallel Tee Slots



Model	ATL-HB4-2P
A	8.85"
B	6.69"
C	3.82"
D	7.24"
E	5.70"
G	6.50"
H	2.36"



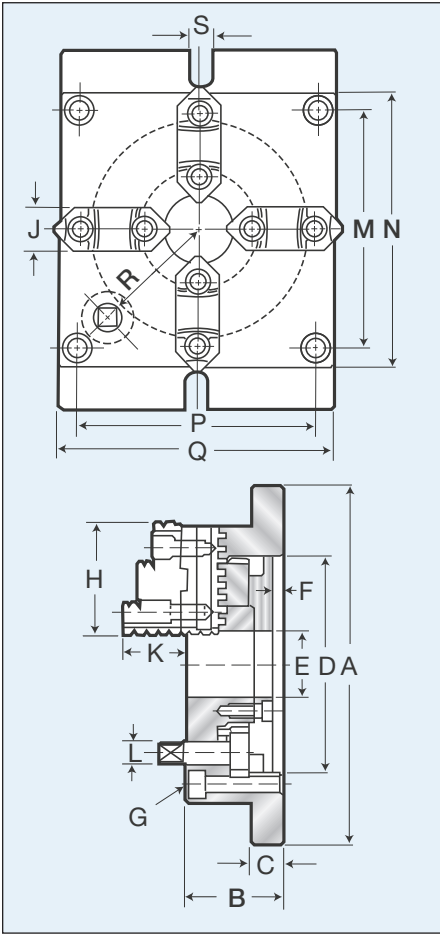
HOW TO ORDER: State quantity, model number and shipping instructions.



Super Thin Low Profile Square Chucks

Series MCA

- Universal 4-jaw 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.
- One year warranty



Model	Approx Weight	Gripping capacity			
		External		Internal	
		Min.	Max.	Min.	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	M8x1.5P	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.

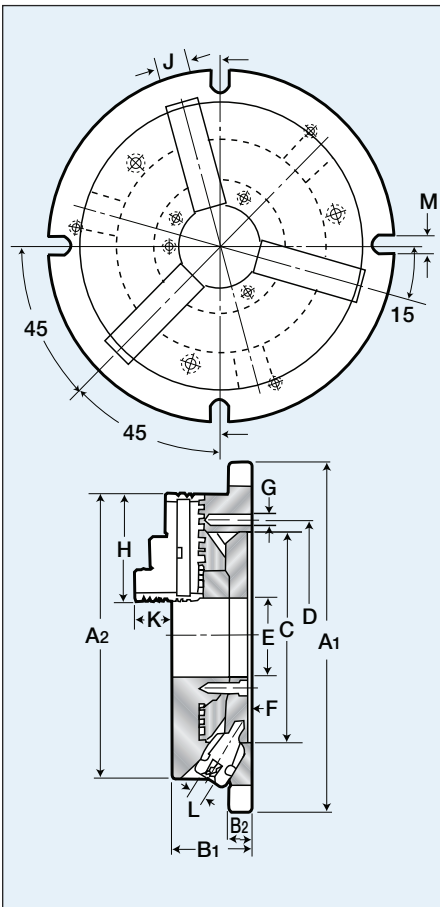


Super Thin Low Profile Round Chucks

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 Min.	External Max.	Internal Min.	Internal 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.



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

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

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.

Made in USA

- Ⓐ 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 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

King Bore Quick-Change Chucks

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.

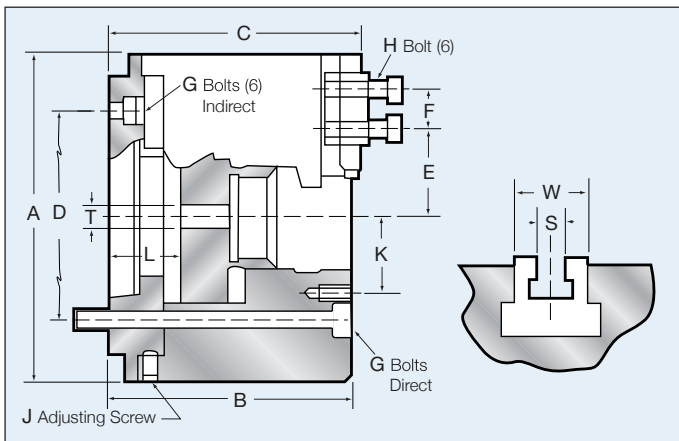
NOTE: 18, 20" & 24" dia. chucks require separate collet pad master jaws: 18"-#8130-46696, 20"-#8130-50696 & 24"-#8130-61696.

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	1.18	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	1.69	2.32	.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	2.14	.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	2.17	.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	2.17	.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	2.17	.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	2.17	.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	***	1.30	2.28	.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	***	1.30	2.28	.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 66 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.

Made in USA

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
King Bore Chucks											
7.0"	A2-5(D)	7000	9161-317__	.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.

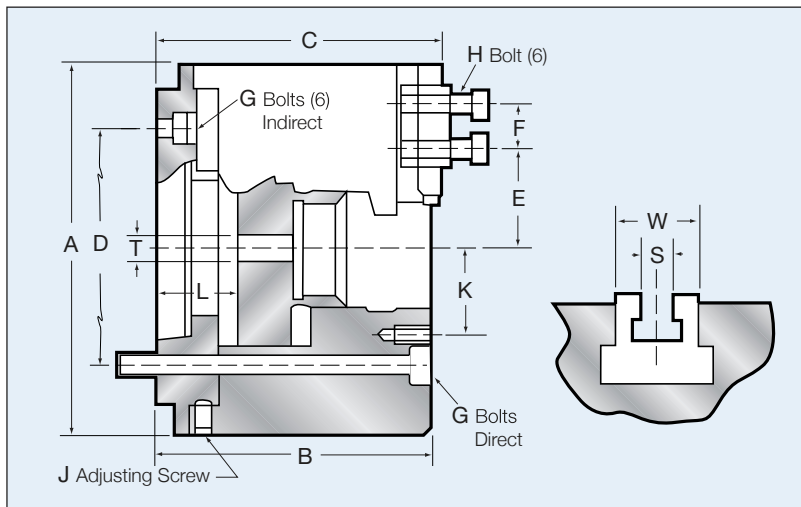
3mm on 20" and 24" dia. chucks *3/32 x 90° on 20" and 24" chucks

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	1.18	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	1.69	2.32	.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	2.14	.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	2.17	.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	2.17	.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	2.17	.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	2.17	.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	***	1.30	2.28	.984	2.36
24-A15	24	7.560	7.720	13.000	2.362	10.090	5.770	7/8-9x3(6)	M20x35	1/2 UNFx3/4	***	1.30	2.28	.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°.



Made in USA

Special order only

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 2-Jaw Power Chucks

Constant Grip High Speed Thru-Hole 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.

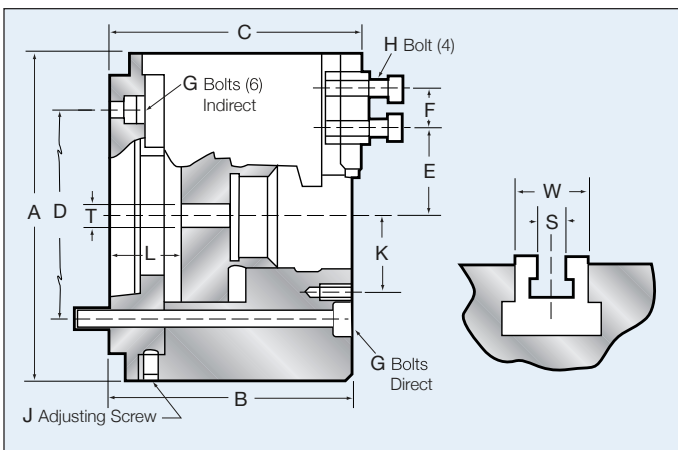
Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9141-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
6.5"	A2-5(D)	6000	9141-317__	.140"	.630"	1.65"	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.

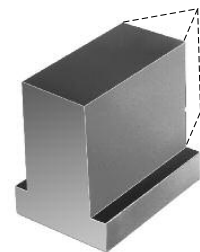
Dimensional and Performance Data (in inch)

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	1.18	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	1.69	2.32	.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	1.41	2.14	.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 66 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

- Ⓐ 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 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.

Made in USA

Special order only

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.

Power Chucks

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)
Quick Change Jaw VTL Chucks										
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
Non-Quick Change Jaw VTL Chucks										
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

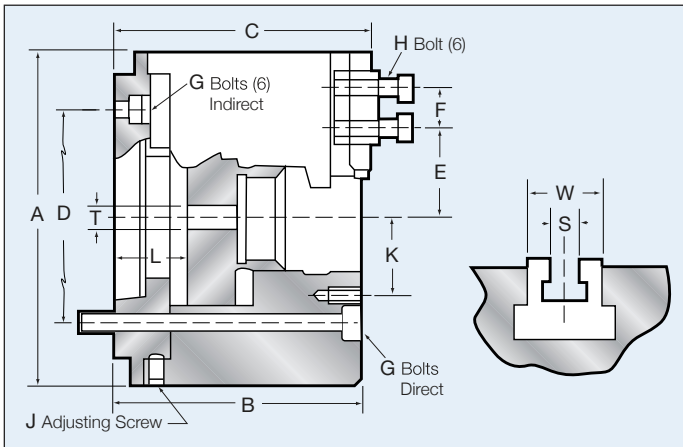
① Insert last two digits for Master Jaw type...Example 9101-42623...Indicates 1.5mm x 60°: Master Jaw Required
 Use 23 for 1.5mm x 60° Japanese type.** Use 07 for Am. Std Tongue & Groove. Use 10 for 1/16 X 90° Serrations.*
 Use 26 for Acme Serration. Use 27 for Square Serration.

HOW TO ORDER: State quantity, model number of chuck, machine make & model, and shipping instructions.

Dimensional and Performance Data (in inch)

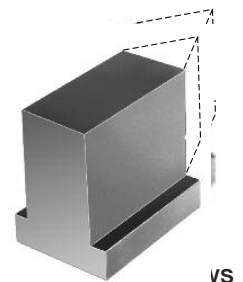
Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	½ UNFx¾	4.53	1.02	1.75	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	½ UNFx¾	4.53	1.41	2.14	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	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	1.30	2.03	.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	2.17	.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	2.17	.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	2.17	.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	2.17	.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	2.36	.984	2.36
24-A11	24	7.560	7.720	9.250	2.362	10.090	5.770	M20x45(6)	M20x35	½ UNFx¾	***	1.30	2.28	.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	***	1.30	2.28	.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.



vs

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.

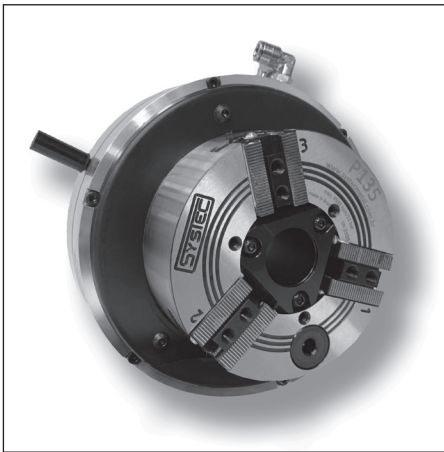
See page 66 for Dimensions.

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

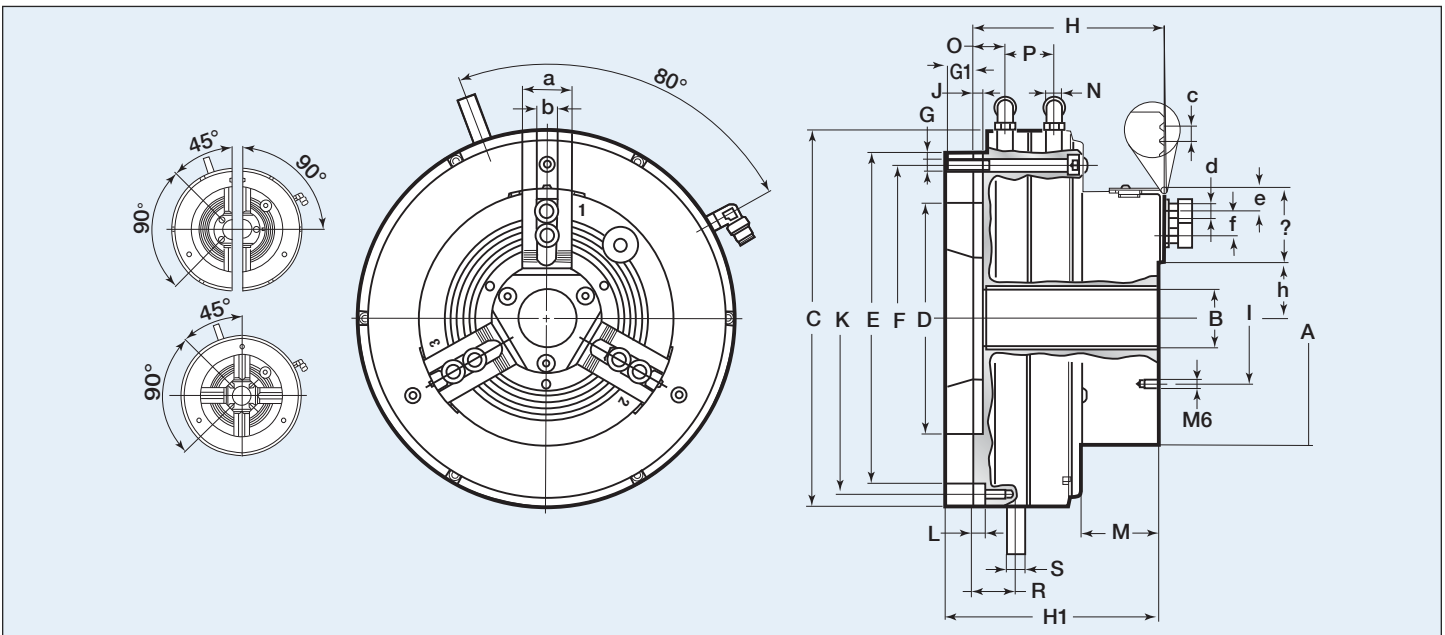
*** Also available in long pointed design



MK4 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 for adapter mounting plates
- ⊕ 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 5", 6 1/2", 8", 10", and 12"
- ⊕ Suitable for chucking or barwork
- ⊕ Less overhang. Lighter in weight
- ⊕ No ring adjustment needed
- ⊕ Also available in 2 & 4 jaw



Dimensional and Technical Data (in inch)

Chuck Size	A	Thru Hole B	C	D	E	F	G	G1	H	H1	J	K	L	M
5"	5.354"	.260"	8.0315"	4.7244"	6.8504"	6.2795"	M6x70 (6)	0.4134"	4.8031"	5.4331"	0.2559"	-	0.3543"	2.0472"
6 1/2"	5.354"	1.535"	9.9213"	6.1024"	8.7402"	8.0906"	M8x75 (8)	0.4921"	5.0394"	5.4331"	0.2559"	9.6063"	0.3543"	2.0472"
8	8.465"	2.047"	11.4961"	7.6772"	10.3150"	9.6654"	M8x75 (8)	0.4921"	5.3150"	5.7087"	0.2559"	11.1811"	0.3543"	2.3228"
10	10.236"	3.622"	13.1890"	9.2520"	12.0079"	11.2795"	M10x90 (8)	0.7283"	6.0236"	6.6535"	0.2559"	-	0.4331"	2.5984"
12*	12.402"	4.528"	14.2520"	9.2520"	13.0709"	12.3031"	M10x40 (8)	-	6.4960"	7.5197"	0.2559"	-	0.4331"	3.0315"

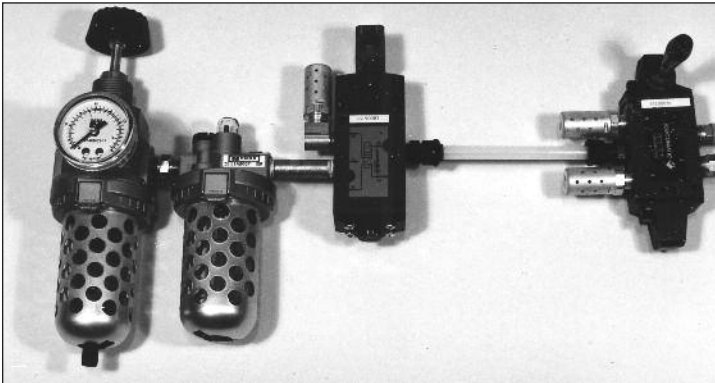
Chuck Size	N	O	P	R	S	a	b	c	d	e	f	g	h	i
5"	G 1/8"	0.7756"	1.1614"	1.1024"	0.4921"	1.1811"	0.4724"	1/16"x90"/1.5x60°	M8x20	0.2756"	0.6299"	1.5354"	1.0827"/1.2008"	2.7559"
6 1/2"	G 1/8"	0.8346"	1.2795"	1.2205"	0.4921"	1.2992"	0.5512"	1/16"x90"/1.5x60°	M10x20	0.2956"	0.4646"	1.9488"	1.3189"/1.4764"	3.4646"
8	G 1/8"	0.8346"	1.2795"	1.2205"	0.4921"	1.4961"	0.6693"	1/16"x90"/1.5x60°	M12x25	0.3937"	0.9055"	2.5984"	1.5748"/1.7323"	4.5276"
10	G 1/8"	0.9843"	1.5000"	1.4567"	0.4921"	1.4960"	0.6693"	1/16"x90"/1.5x60°	M12x25	0.3937"	0.9055"	2.5984"	2.4016"/2.5984"	6.2992"
12*	G 1/8"	0.9843"	1.5000"	1.4567"	0.4921"	1.7717"	0.8268"	1/16"x90"/1.5x60°	M16x30	0.5118"	1.1811"	3.0512"	3.0118"/3.20866"	7.4803"

HOW TO ORDER: State quantity, model number of chuck and shipping instructions. * The 12" chuck is rear mounted

Pratt Burnerd Accessories and Installation For MK4 Self-Contained Power Chucks

Lever Control Unit - Part Number 1157-12800

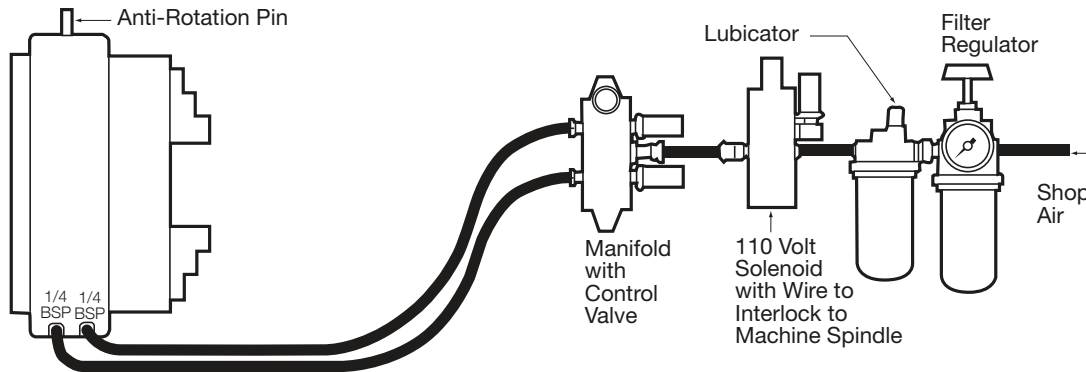
Foot Pedal Control Unit - Part Number 1157-12801 (Not Shown)



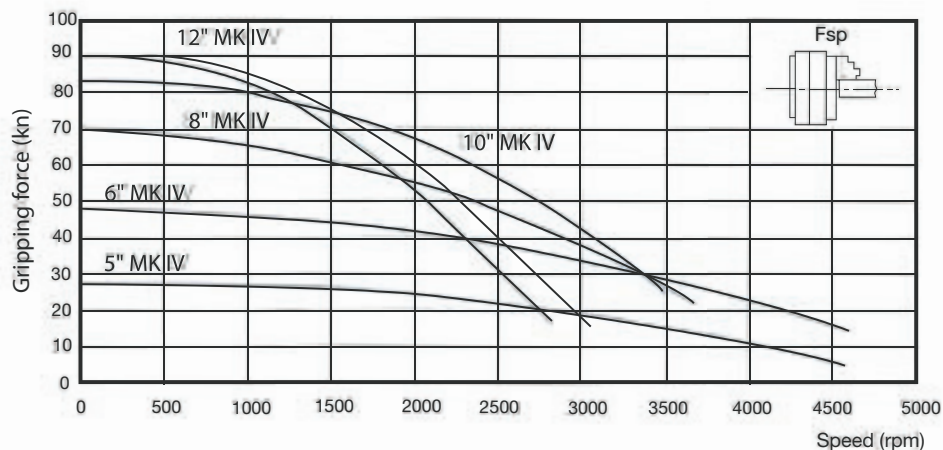
This unit is essential in order to operate MK4 self-contained power chucks. It is designed to be interlocked with the machine spindle so that the chuck cannot be actuated while the spindle is under power. Care must be taken not to actuate the chuck while the spindle is decelerating.

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 (24 volt DC on request).



Model		5" MK4	6" MK4	8" MK4	10" MK4	12" MK4
Inch Seration (1/16"/90°) order no.	3 Jaw	9730-01310	9730-01710	9730-01710	9730-02610	9730-03210
Metric Seration (1.5/60°) order no.	3 Jaw	9730-01323	9730-01723	9730-01723	9730-02623	9730-03223
Stroke per jaw	in.	0.1181"	0.1575"	0.1575"	0.1969"	0.1969"
Operating pressure min./max.	lb/ft²	7310/20885	7310/20885	7310/20885	7310/20885	7310/20885
Piston area	ft²	0.1765	0.2992	0.4306	0.5479	0.6254
Gripping force at 6 bar	lbs.	5845	10566	15737	18659	20458
Max. Speed at 6 bar	rpm	4500	4500	3600	3500	2500
Air consumption	ft³	0.0671	0.1624	0.2366	0.3708	0.4238
Weight (without jaws)	lbs.	31	51	77	112	154
Moment of inertia	lb/ft³	1.14	3.06	6.72	14.05	25.46





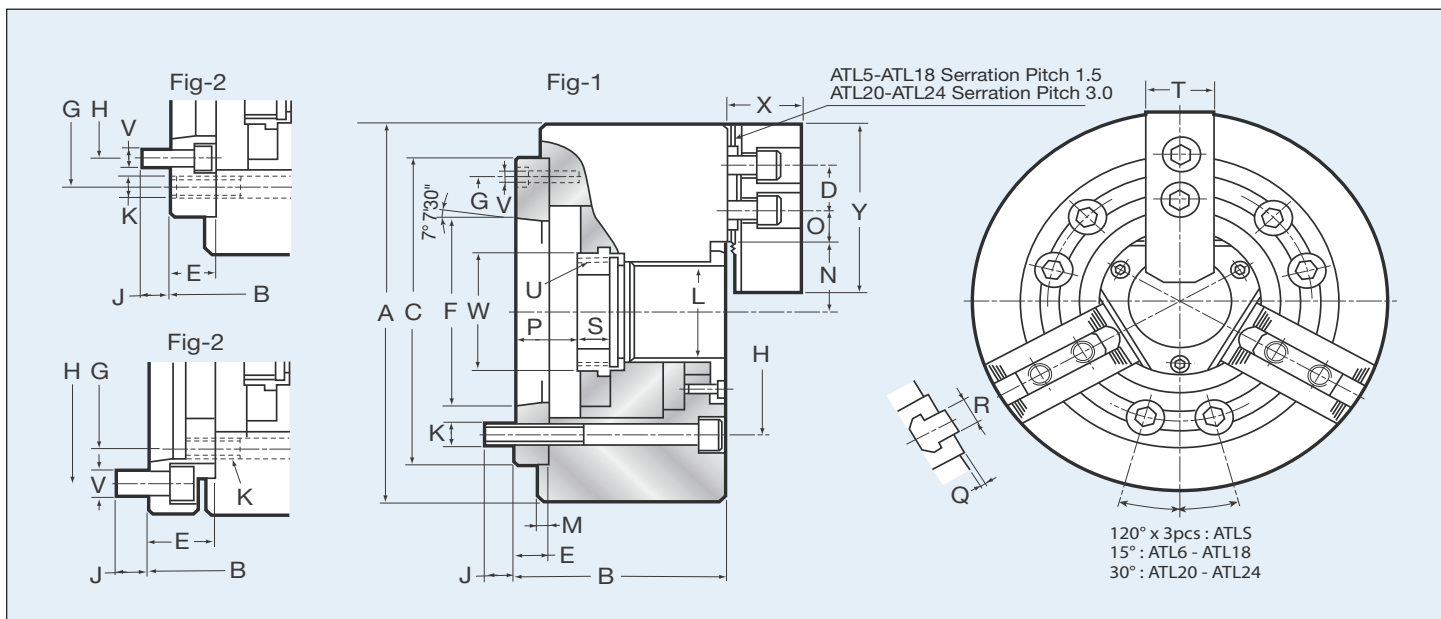
ATL Series 3-Jaw Power Chuck 5" thru 32"

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

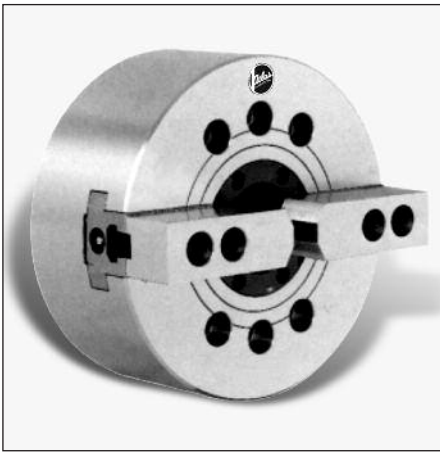
Model	Through Hole (in)	Plunger Stroke (in)	Jaw Stroke (Dia. in)	Max. Pull Force (lbf)	Max. Gripping Force (lbf)	Max. Speed (rpm)	Weight (lbs)	Moment of Inertia I (kg - m ²)	Gripping O. D. Range (in)
ATL5-A5	1.30	.394	.2125	3,925	8,080	7000	20	0.023	.24-4.0
ATL6-A5	1.77	.472	.2165	4,935	12,790	6000	33	0.062	.59-5.0
ATL6-A6	1.77	.472	.2165	4,935	12,790	6000	38	0.073	.59-5.0
ATL8-A5	2.07	.630	.2913	70,830	19,970	5000	57	0.190	.79-6.16
ATL8-A6	2.07	.630	.2913	7,830	19,970	5000	55	0.184	.79-6.16
ATL8-A8	2.07	.630	.2913	7,830	19,970	5000	65	0.217	.79-6.16
ATL10-A6	2.95	.748	.3464	9,659	24,902	4200	90	0.370	.98-8.0
ATL10-A8	2.95	.748	.3464	9,650	24,902	4200	84	0.340	.98-8.0
ATL12-A6	3.58	.905	.4173	12,790	32,978	3300	138	0.809	1.18-10.0,
ATL12-A8	3.58	.905	.4173	12,790	32,978	3300	131	0.770	1.18-10.0
ATL12-A11	3.58	.905	.4173	12,790	32,978	3300	154	0.912	1.18-10.0
ATL15-A8	4.62	.905	.4173	15,930	40,382	2500	276	2.255	1.96-13.0
ATL15-A11	4.62	.905	.4173	15,930	40,382	2500	260	2.241	1.96-13.0
ATL18-A8	4.62	.905	.4173	15,930	40,382	2000	322	3.961	1.96-16.0
ATL18-A11	4.62	.905	.4173	15,930	40,382	2000	364	3.744	1.96-16.0
ATL18-A15	4.62	.905	.4173	15,930	40,382	2000	421	5.183	1.96-16.0
ATL20-A11	7.08	.905	.4173	20,190	52,495	1800	173	7.355	4.72-18.0
ATL20-A15	7.08	.905	.4173	20,190	52,495	1800	445	6.910	4.72-18.0
ATL24-A11	8.07	1.023	.4724	20,190	52,495	1400	732	18.199	5.90-22.0
ATL24-A15	8.07	1.023	.4724	20,190	52,495	1400	699	17.376	5.90-22.0
ATL24-A20	8.07	1.023	.4724	20,190	52,495	1400	630	15.677	5.90-22.0
ATL32-A11	9.06	1.339	.709	22,481	53,952	1200	1169	43	8.27-31.5
ATL32-A15	9.06	1.339	.709	22,481	53,952	1200	1136	43	8.27-31.5
ATL32-A20	9.06	1.339	.709	22,481	53,952	1200	1070	42	8.27-31.5

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
ATL32-A11	31.5	7.44	20.47	2.362	1.771	7.750	18.251	9.252	1.102	6-M24	9.06	.236	6.378	6.043	.964	2.401	1.063	.197	.984	1.496	2.559	M250X3	6-M20	10.315	2.874	7.086	Fig-2
ATL32-A15	31.5	7.32	20.47	2.362	1.653	11.251	18.251	13.00	1.299	6-M24	9.06	.236	6.378	6.043	.964	2.283	.945	.197	.984	1.496	2.559	M250X3	6-M24	10.315	2.874	7.086	Fig-2
ATL32-A20	31.5	7.44	20.47	2.362	.984	16.250	18.251	18.252	1.378	6-M24	9.06	.236	6.378	6.043	.964	1.614	.276	.197	.984	1.496	2.559	M250X3	3-M10	10.315	2.874	7.086	Fig-1



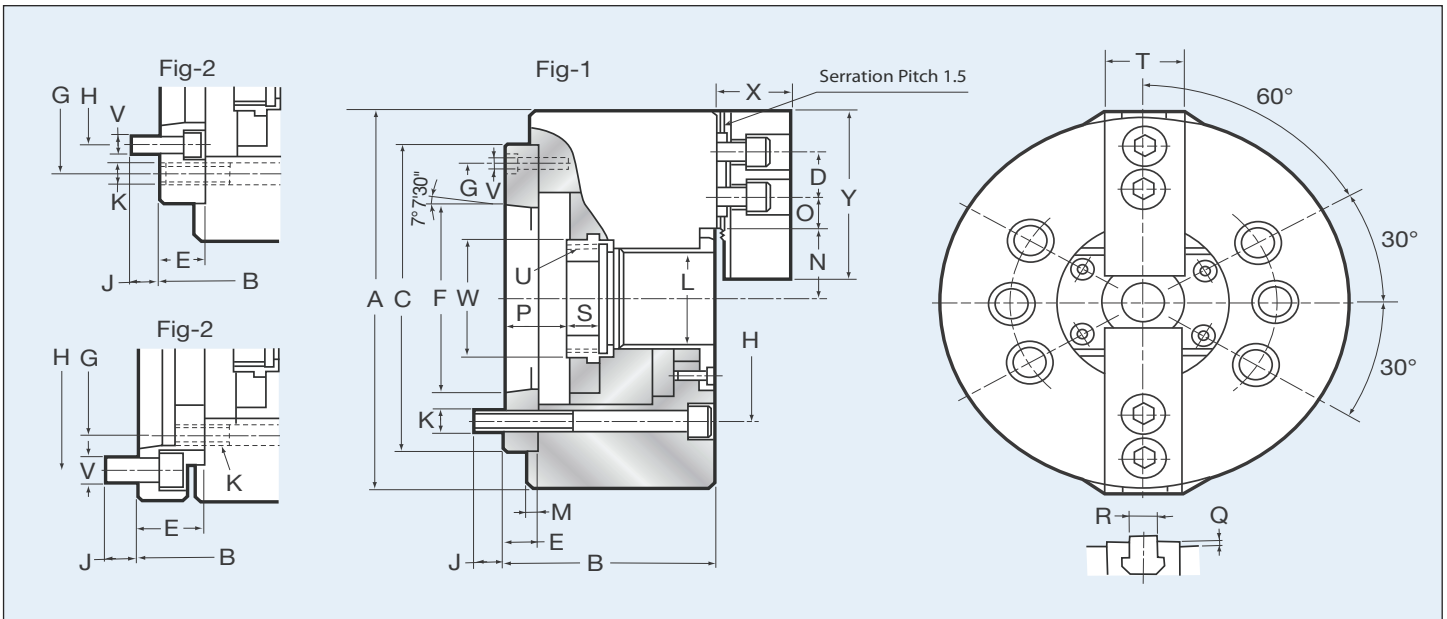
2-Jaw High Speed Open Center Power Chuck

2ATL 6" - 18" Chucks

- ⚙️ 1.5mm x 60° master jaw
- ⚙️ Repeatability ± .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 ²)	Gripping O. D. Range (in)
2ATL6-A5	1.77	.472	.2165	4,935	12,790	6000	33	0.062	.59-5.0
2ATL8-A5	2.07	.630	.2913	7,830	19,970	5000	57	0.190	.79-7.0
2ATL8-A6	2.07	.630	.2913	7,830	19,970	5000	55	0.184	.79-7.0
2ATL10-A6	2.95	.748	.3464	9,659	24,902	4200	90	0.370	.98-8.25
2ATL10-A8	2.95	.748	.3464	9,650	24,902	4200	84	0.340	.98-8.25,
2ATL12-A6	3.58	.905	.4173	12,790	32,978	3300	138	0.809	1.18-10.0
2ATL12-A8	3.58	.905	.4173	12,790	32,978	3300	131	0.770	1.18-10.0,
2ATL12-A11	3.58	.905	.4173	12,790	32,978	3300	154	0.912	1.18-10.0
2ATL15-A8	4.62	.905	.4173	15,930	40,382	2500	276	2.255	1.96-13.0
2ATL15-A11	4.62	.905	.4173	15,930	40,382	2500	260	2.241	1.96-13.0
2ATL18-A11	4.62	.905	.4173	15,930	40,382	2000	364	3.744	1.96-16.0
2ATL18-A15	4.62	.905	.4173	15,930	40,382	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

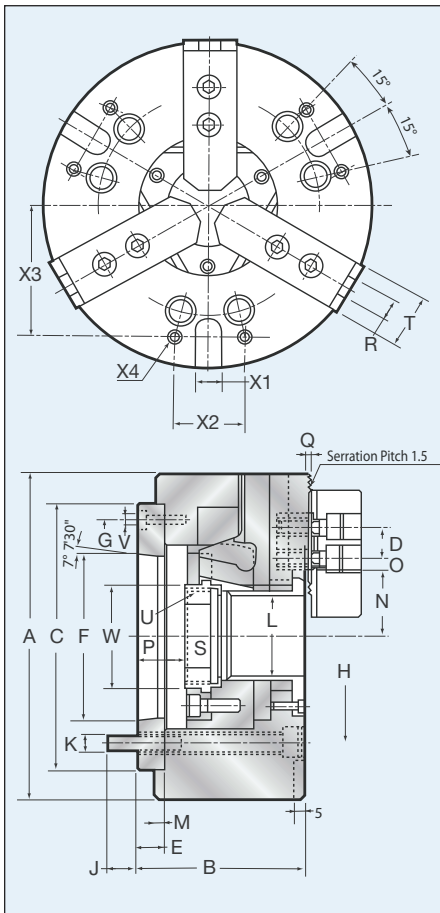
HOW TO ORDER: State quantity, model number of chuck and shipping instructions.



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
Plunger Stroke (in)	.472	.630	.748	.905	.905	.905
Jaw Stroke (in)	.212	.291	.346	.413	.413	.413
Pull Force (lbf)	7,974	7,828	9647	12788	15,928	15,928
Grip Force (lbf)	12,788	19,965	24,902	32,978	40,381	40,381
Oper. Pressure (psi)	262	292	392	292	363	363
Max. Speed (rpm)	6,000	5,000	4,200	3,200	2,500	2000
Weight (lbs)	31	53	83	144	287	355
Moment of Inertia (kg-m ²)	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	M75x2	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
ATLB18-A15	18.0	6.06	14.96	1.692	1.063	11.25	13.00	3.30	1.299	3xM24	6.55	.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.



3-Jaw Wedge Type Closed Center Power Chuck

PA 18" - 63" Large Diameter Chucks

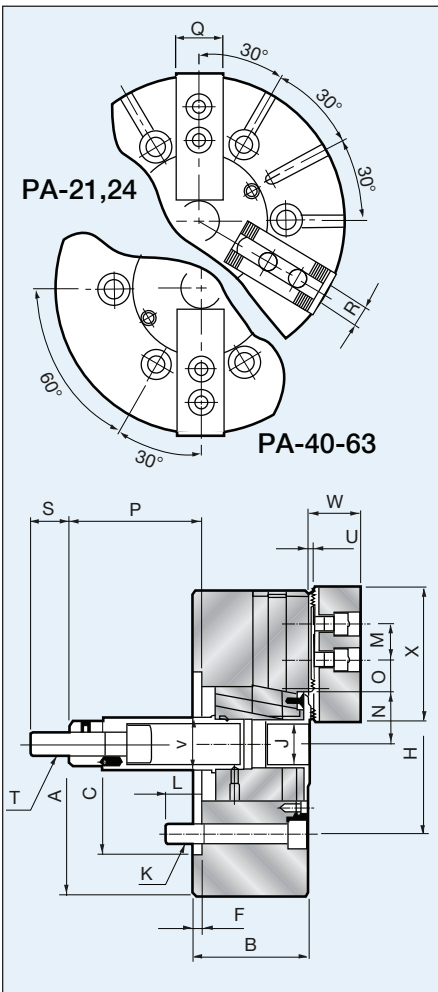
- ⚙ All steel body
- ⚙ Standard 3-jaw closed center wedge chuck for general machining
- ⚙ Hardened jaw ways and all internal parts
- ⚙ Standard 3.0mm metric serrations

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

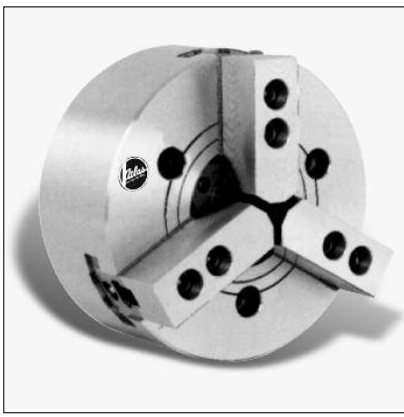
*Add to dimension B for total width

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.



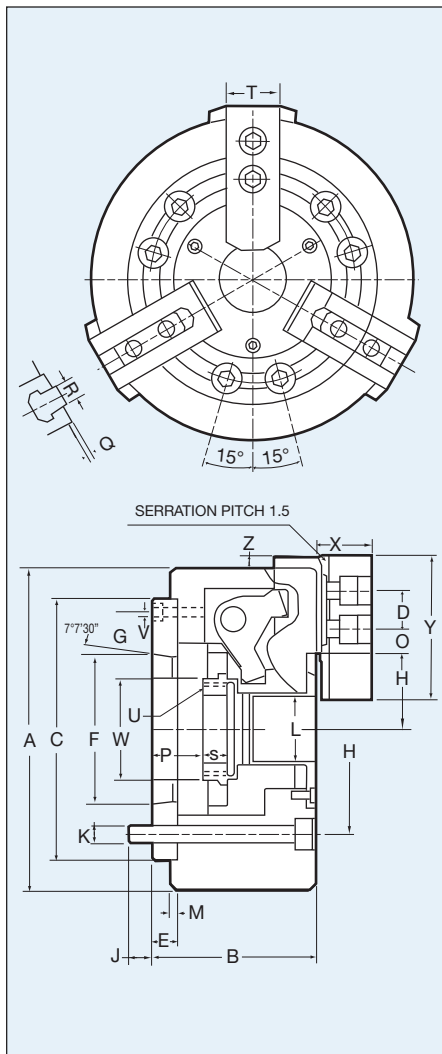
3-Jaw Long Stroke Through-hole Power Chuck (adapter included)

ALS 6" - 10" Chucks

- ⚙️ Designed to have extra long stroke
- ⚙️ High-strength alloy, all sliding surfaces are hardened and ground
- ⚙️ Can clamp over workpieces with extremely uneven surface
- ⚙️ The installation is the same as ATL's type chuck

Model No.	Thru Hole Dia	Plunger Stroke	Jaw Stroke Dia	Max Pull Force (Kn)	Max Gripping Force (Kn)	Max Operating Min (kgf/cm ²)	Max Speed RPM	Gripping Capacity		Wt.
								Max	Min	
ALS6-A5	1.575" (40 mm)	.591" (15mm)	.945" (24mm)	2243	2651	28.3	3600	1.378" (33mm)	6.614" (168mm)	33 lbs (14.8kg)
ALS8-A6	1.889" (48 mm)	.787" (20mm)	1.260" (32mm)	3701	4190	27.5	3000	1.968" (50mm)	8.468" (215mm)	62 lbs (28kg)
ALS10-A8	2.578" (66 mm)	.984" (255mm)	1.476" (37.5mm)	4853	5505	29.5	2400	2.165" (55mm)	10.679" (55mm)	96 lbs (43.58kg)

Dimensional Data



MODEL	ALS6-A5	ALS8-A6	ALS10-A8
A	6.614"/168mm	8.464"/215mm	10.079"/256mm
B	3.789"/96mm	4.409"/112mm	4.921"/125mm
C(H6)	5.512"/140mm	6.693"/170mm	8.661"/220mm
D	.787"/20mm	.984"/25mm	1.181"/30mm
E	.592"/15mm	.669"/17mm	.708"/18mm
F	3.251"/82.563mm	4.189"/106.375mm	5.501"/139.719mm
G	5.567"/116mm	5.905"/150mm	7.480"/190mm
H	4.125"/104.78mm	5.20"/133.35mm	6.750"/171.45mm
J	.263"/16mm	.708"/18mm	.945"/24mm
K	6-M10	6-M12	9-M16
L	1.575"/40mm	1.889"/48mm	5.598"/112mm
M	.197"/5mm	.197"/5mm	.197"/5mm
N max	1.929"/49mm	2.382"/60.5mm	2.933"/74.5mm
O max	.656"/16.75mm	.817"/20.75mm	.974"/24.75mm
min	.305"/7.75mm	.462"/11.75mm	.443/11.25mm
P max	1.024"/26mm	1.240"/31.5mm	1.043"/26.5mm
min	.433"/11mm	.453"/11.5mm	.059"/1.5mm
Q	.079"/2mm	.079"/2mm	.079"/2mm
R	.472"/12mm	.551"/14mm	.630"/16mm
S	.748"/19mm	.807"/20.5mm	.984"/25mm
T	1.220"/31mm	1.377"/35mm	1.575"/40mm
U max.	M55x2	M60x2	M85x2
V	3xM6	3xM6	3xM8
W	2.362"/60mm	2.598"/66mm	3.701"/94mm
X	1.567"/37mm	1.496"/38mm	1.693"/436mm
Y	2.874"/73mm	3.740"/95mm	1.330"/110mm
Z	.394"/10mm	.394"/10mm	.492"/12.5mm

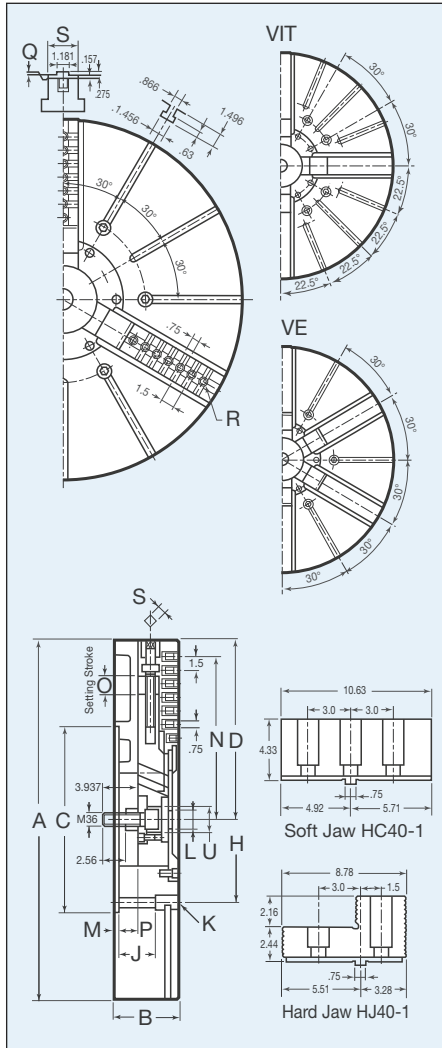
HOW TO ORDER: State quantity, model number of chuck and shipping instructions.



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



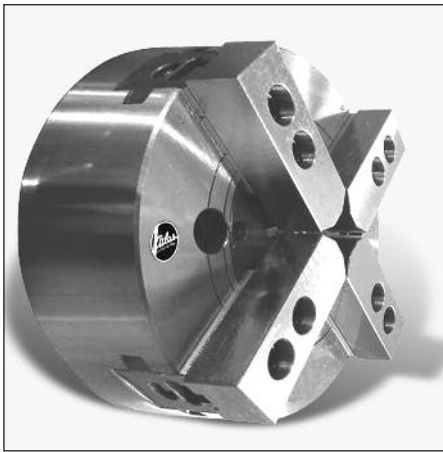
MODEL	V-240	VIT-240	V-250	VIT-250	VE-250	VIT-263	VE-263	VE-279
Number of Jaws	3	4	3	4	6	4	6	6
Plunger Stroke (in)	2.244	2.244	2.244	2.244	2.244	2.362	2.362	2.362
Radial Jaw Stroke (+ Manual Setting) (in)	.90+1.18	.90+1.18	.90+1.18	.90+1.18	.90+1.18	1.34+1.57	1.34+1.57	1.34+1.57
Pull Force (lbf)	4,0465	40,465	40,465	40,465	40,465	44,961	44,961	44,961
Grip Force (lbf)	71,938	71,938	71,938	71,938	71,938	80,931	80,931	80,931
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
Moment of Inertia (kg-m ²)	82	89	168	177	183	518	548	1350
Matching Cylinder	ATL250C	ATL250C	ATL250C	ATL250C	ATL250C	ATL250C	ATL250C	ATL250C
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

Power Chucks

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.

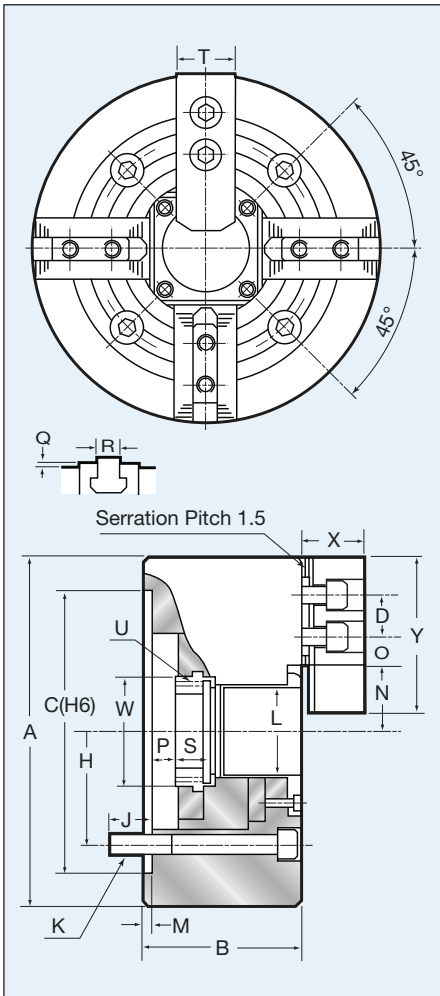


4-Jaw Universal Power Chuck

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

- Ⓐ All steel body
- Ⓑ Hardened jaw ways 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 [Ⓓ]	Wt lbs	Moment of Inertia I (kg-m ²)
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.



2/3-Jaw Thru-Hole Power Chuck

PAFH 8" - 24" Chucks

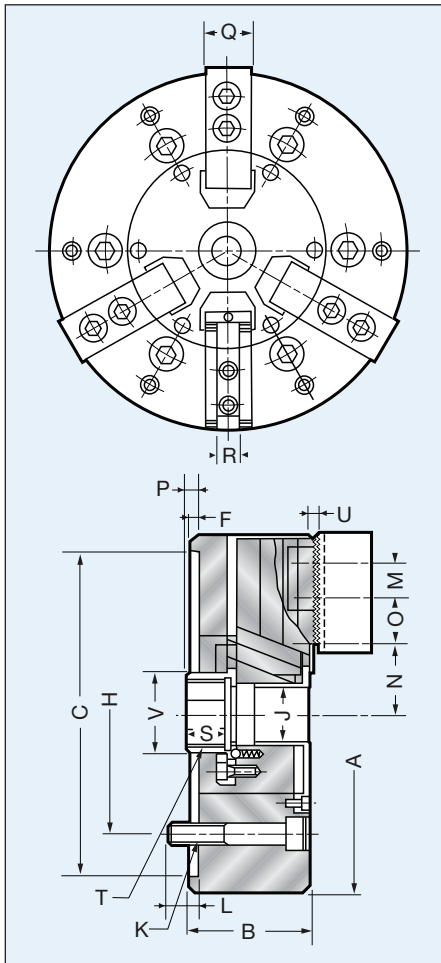
- ⊕ Used as 2-jaw or 3-jaw power chuck
- ⊕ Thru-hole and long stroke
- ⊕ Adapter mounted
- ⊕ Serration Pitch 1.5mm 8", 10" & 12" - 3mm 15"
- ⊕ Larger diameters available

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

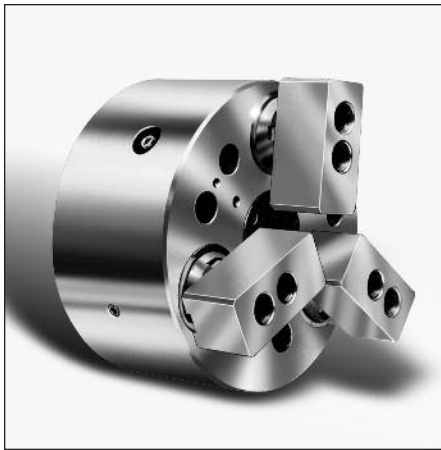
Also available in 18", 21" and 24", contact factory.

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.

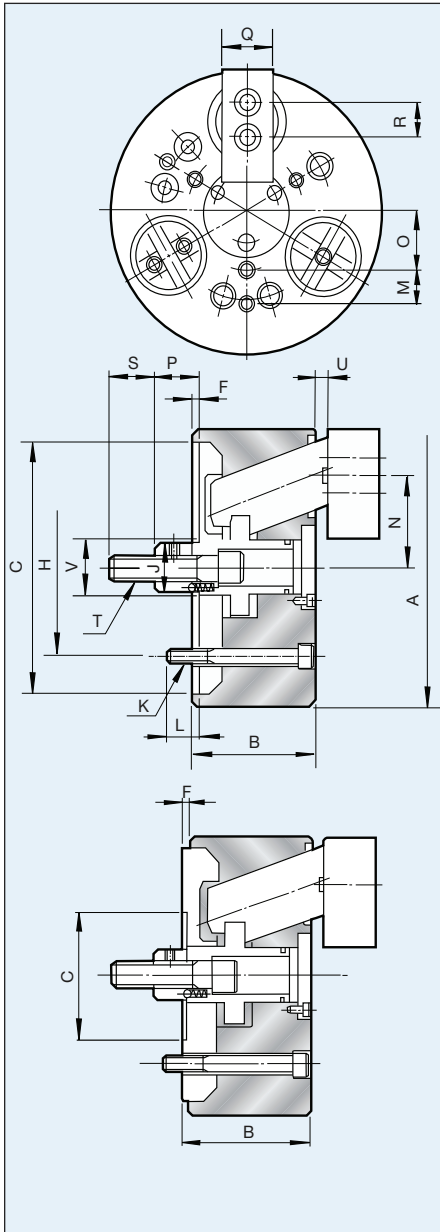


Draw Down Power Chuck

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

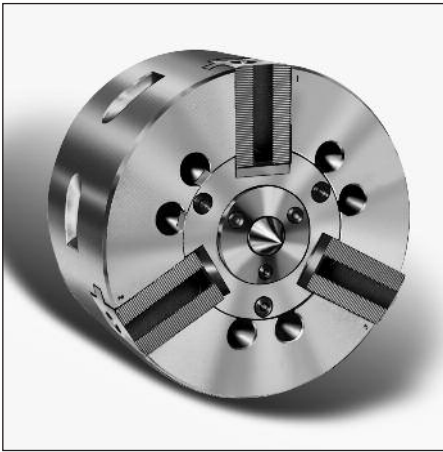
Model No.	Jaw Stroke Dia.	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt. lbs
			Max.	Min.				
PDD4	.197"	.276"	1.97"	.591"	1,300	3,300	3500	10
PDD5	.197"	.276"	2.56"	.591"	2,200	4,400	3500	16
PDD6-A4	.285"	.394"	3.35"	1.378"	3,300	5,500	3500	30
PDD6-A5	.285"	.394"	3.35"	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.

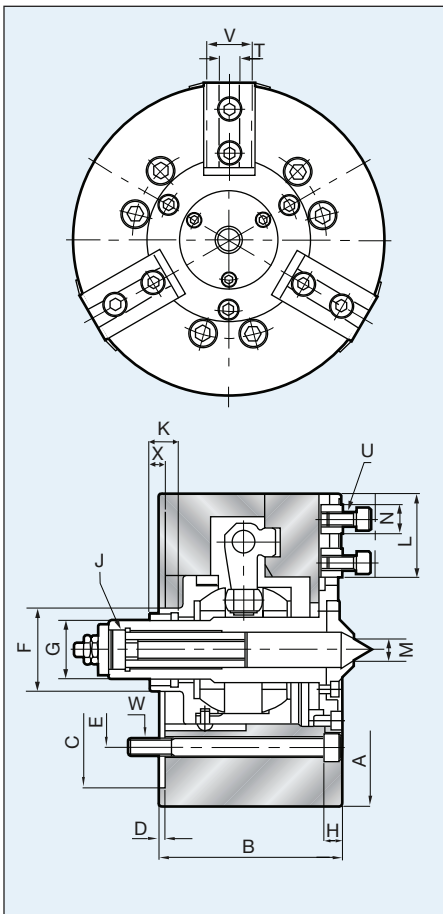


Floating Type Compensating Power Chuck

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.

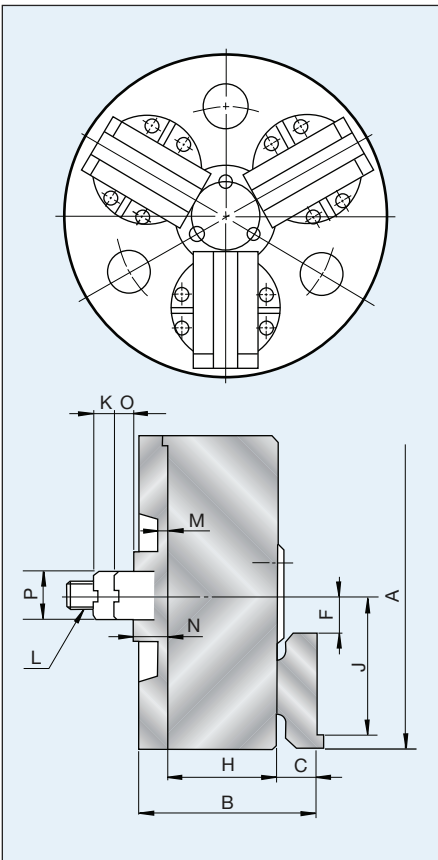


Ball Lock Power Chuck

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



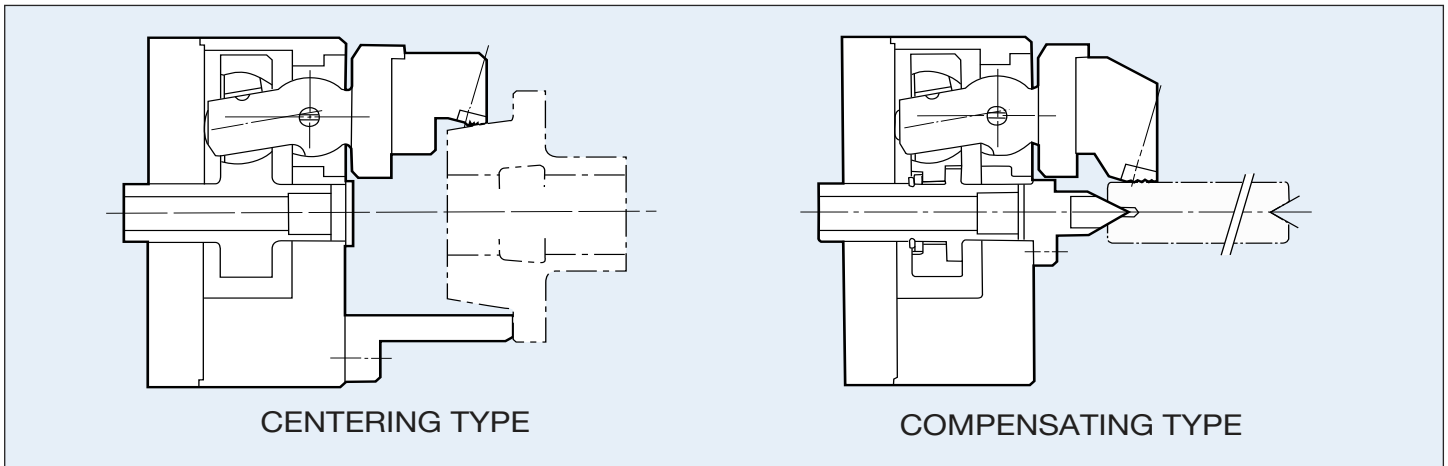
Dimensional Data

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

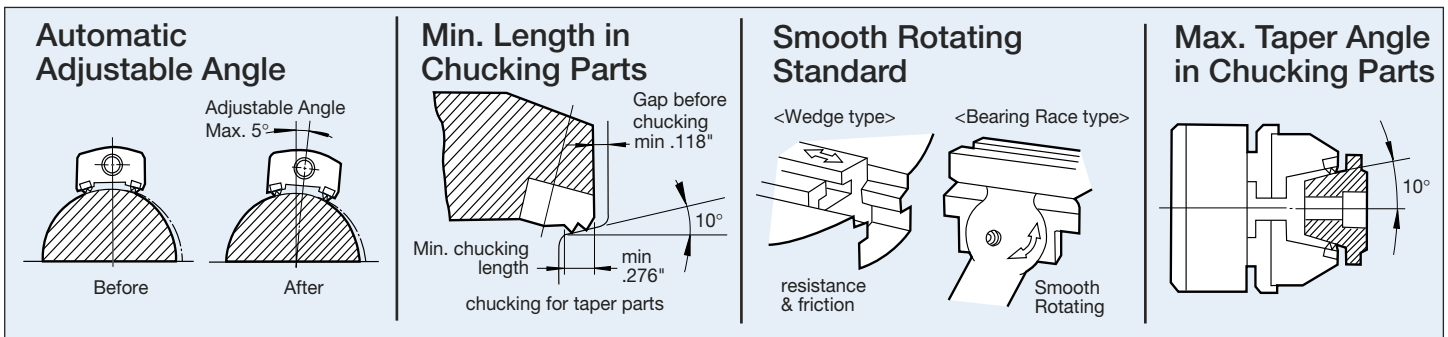
HOW TO ORDER: State quantity, model number of chuck and shipping instructions.

BL Chuck Structure

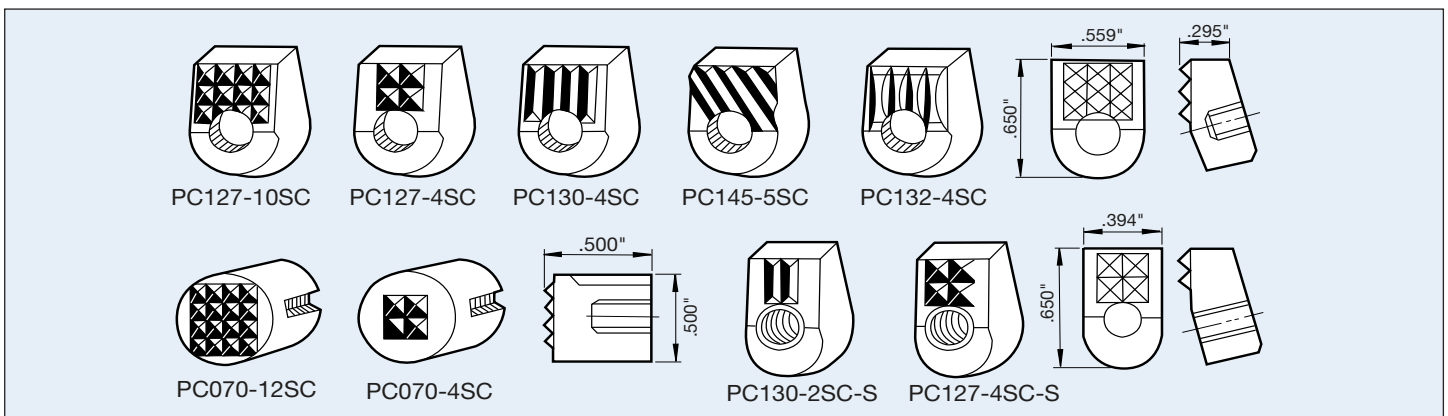


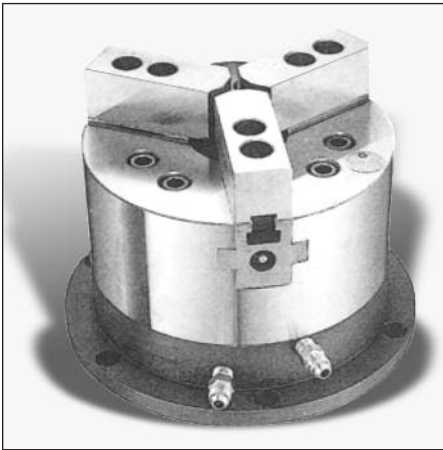
BL Chuck Features

- ⊕ 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

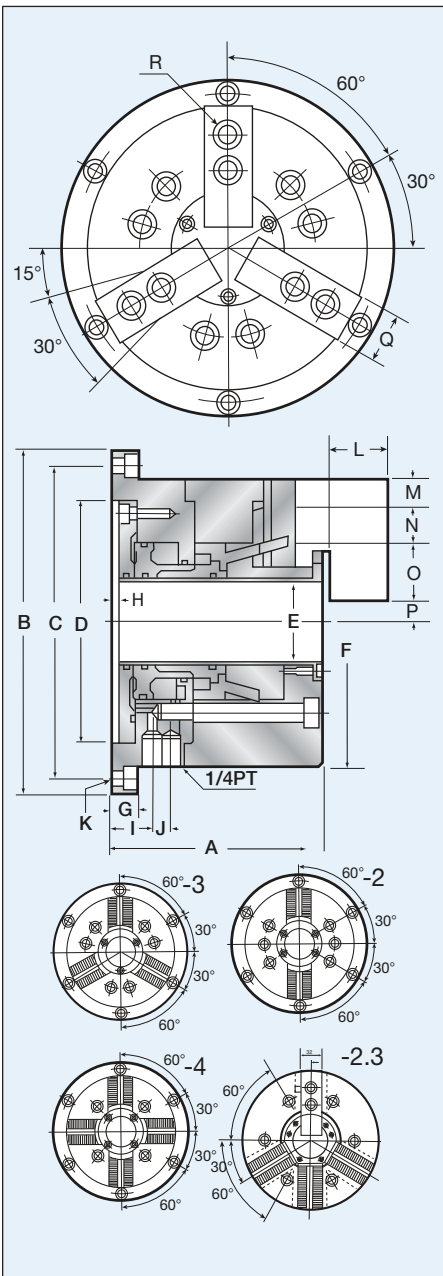




Stationary 2, 3 and 4-Jaw Power Chuck

OLU 6" - 12" 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



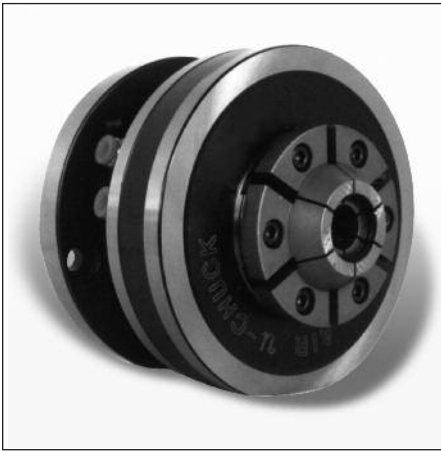
Model	Stroke	Jaw Stroke Dia.	Hydraulic Pressure	Max. Grip ID	Max. Grip OD	Weight
OLU06D	.591"	.197"	350 psi	6,888 lbs.	4,774 lbs.	46 lbs.
OLU08D	.787"	.256"	350 psi	11,270 lbs.	6,370 lbs.	72 lbs.
OLU10D	.787"	.256"	350 psi	19,180 lbs.	13,020 lbs.	98 lbs.
OLU12D	.905"	.417"	350 psi	19,180 lbs.	13,020 lbs.	137 lbs.

Dimensional Data

MODEL	OLU06D	OLU08D	OLU10D	OLU12D
A	4.96"	5.79"	6.30"	4.33"
B	7.80"	9.76"	10.87"	10.87"
C	7.09"	8.86"	9.84"	6.748"
D	5.51"	6.69"	8.66"	8.661"
E	1.65"	2.05"	2.95"	3.58"
F	6.50"	8.07"	10.00"	11.79"
G	.59"	.59"	.71"	.71"
H	.177"	.177"	.197"	.136"
I	1.10"	1.10"	1.18"	1.18"
J	1.38"	1.73"	2.17"	2.17"
K	M8	M8	M10	M10
L	1.42"	1.50"	1.65"	1.97"
M	.59"	.94"	1.18"	1.18"
N	.79"	.98"	1.18"	1.18"
O	1.46"	1.81"	1.97"	1.97"
P max.	.394"	.531"	.650"	1.912"
P min.	.197"	.256"	.394"	1.713"
Q	1.26"	1.38"	1.57"	1.18"
R	M10 x 30	M12 x 35	M12 x 35	M12 x 35

Hydraulic unit pump and tank available

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



Cylinder Integrated Diaphragm Chucks

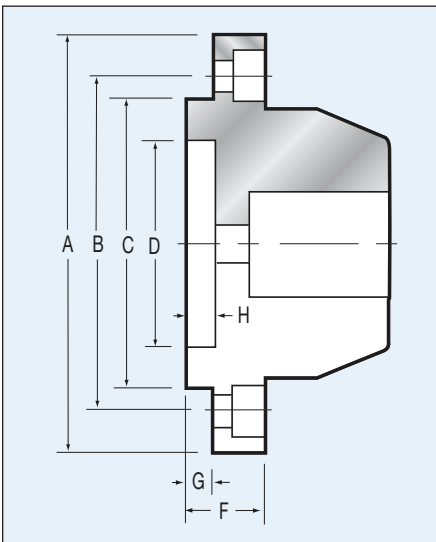
It becomes very easy to set up your precise chucking system by using the Atlas ATL100 series Cylinder-integrated Diaphragm Chuck. ATL100's built-in air cylinder eliminates the needs for installing an additional air cylinder in the back of the spindle, or tailor-making any air tubes. ATL100's front-mounting 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.

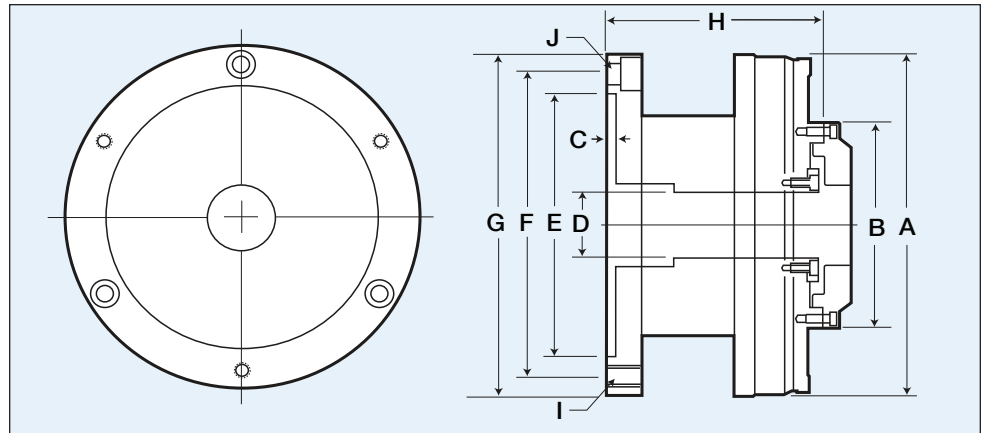
ATL100 uses our patented diaphragm chucking technology. The super precision chucking repeatability is within 0.002mm (0.00008"), plus its gentle clamping force, making this chuck a perfect solution for any accuracy-critical and fragile material machining tasks. Send us your sample and or drawing and 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

Blank Jaws for ATL100 Series Air Diaphragm Chucks



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-cm2/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

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 0.17"	6mm 0.24"	6.5mm 0.26"	6



Shown without coolant catcher
Coolant catcher included

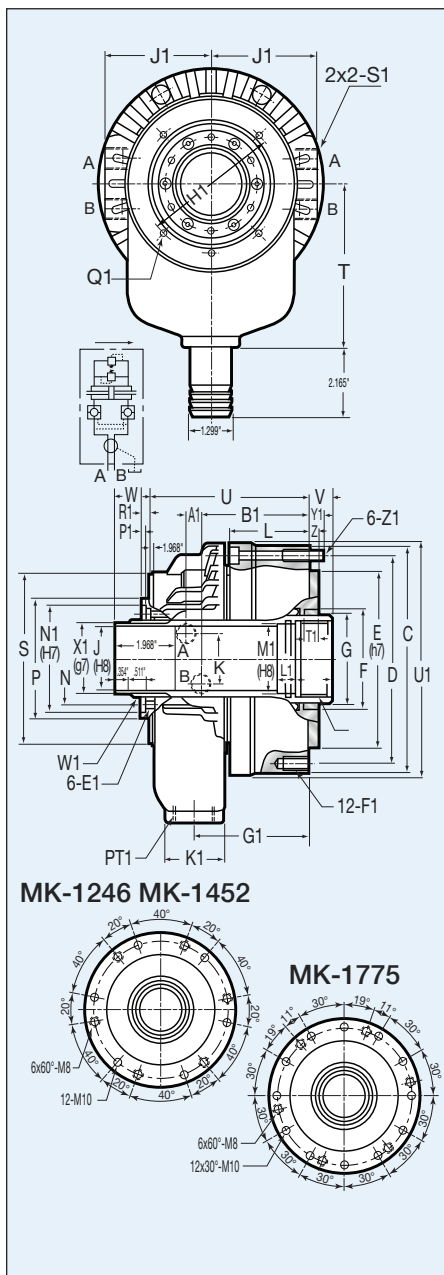
MK Series High Speed Thru-Hole Hydraulic Cylinders

- ⚙ 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	Moment of Inertia I kg-m ²	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

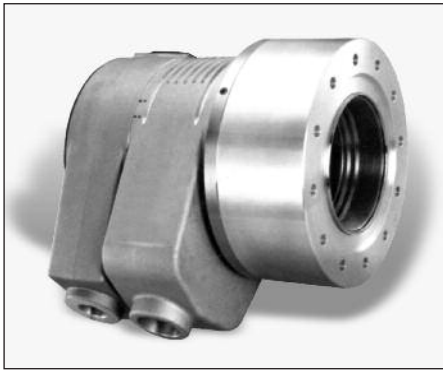
Dimensional Data

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.



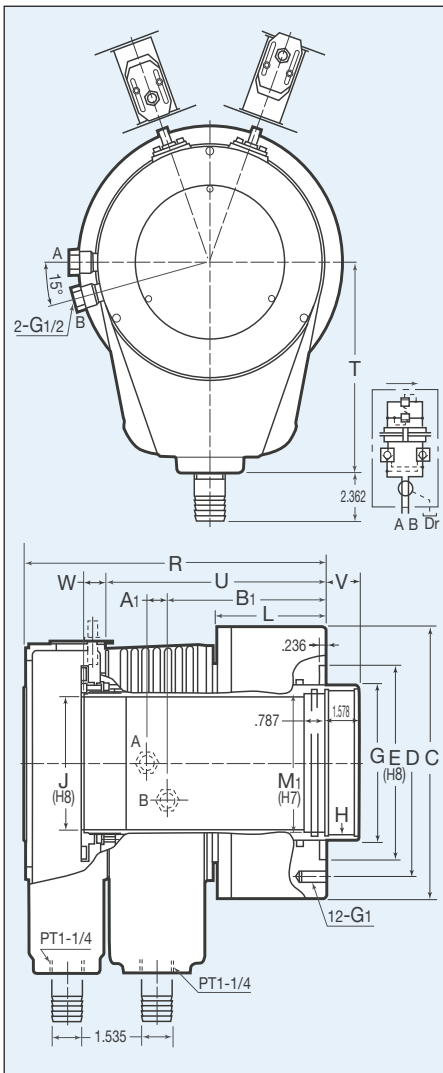
ATL-KBC King Bore Open Center Hydraulic Cylinders

- ⚙ Large thru-hole up to 8.26"
- ⚙ High RPM
- ⚙ 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 ²	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

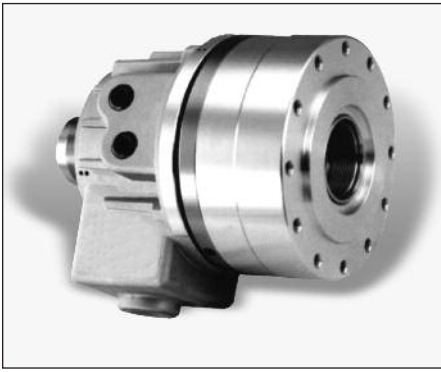
Dimensional Data (inch)

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



Cylinders

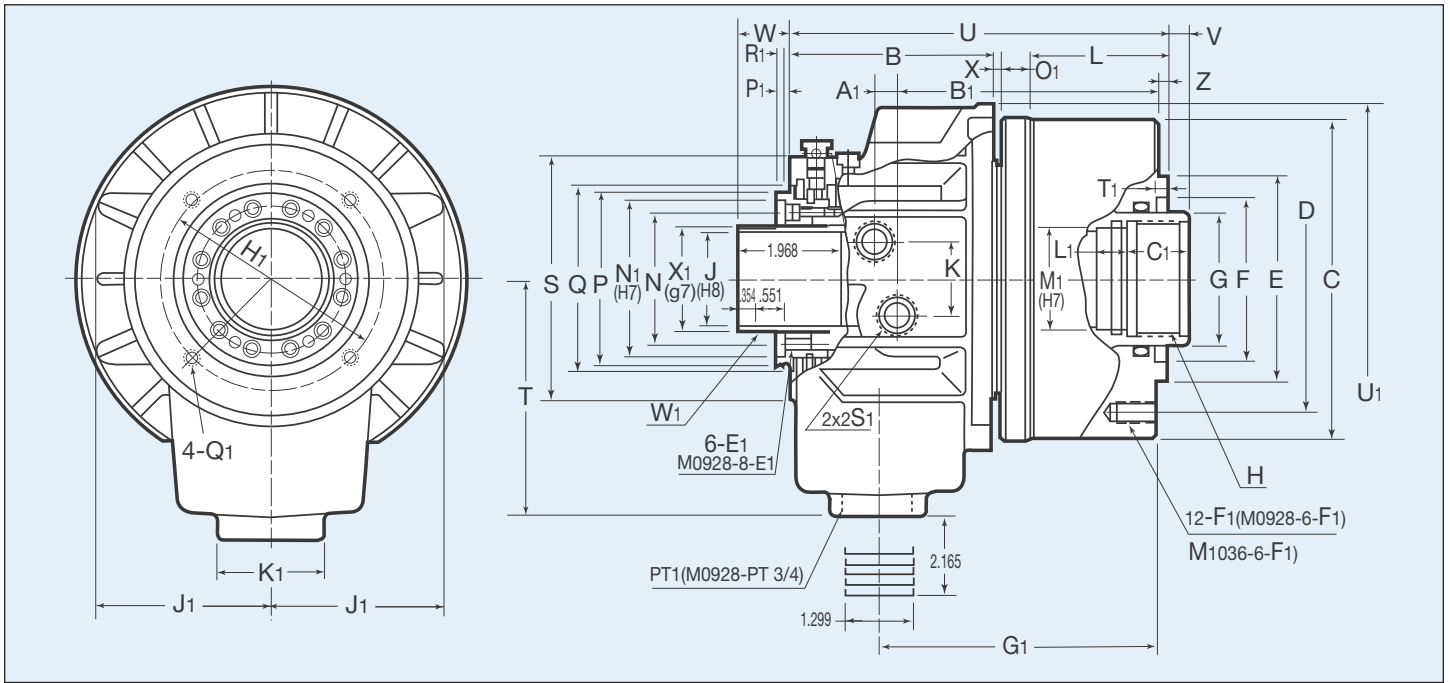
HOW TO ORDER: State quantity, model number of chuck and shipping instructions.



ATL Series High Speed Thru-Hole Hydraulic Cylinders

- ⚙ High speed
- ⚙ Light weight compact design
- ⚙ Less spindle stress
- ⚙ Large thru-hole capacity
- ⚙ Included 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 ²	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	8,543	7,418	.590/(15)	580	1.811/(46)	7000	0.019	27	3.0
ATL1552-CM15B	6.102/(155)	24.955	23.250	13,488	12,588	.866/(22)	580	2.047/(52)	6200	0.052	37	3.9
ATL1868-CM18B	7.086/(180)	30.690	30.080	16,636	16,523	.984/(25)	580	2.677/(68)	4700	0.098	62	4.2
ATL1870-CM18B	7.086/(180)	30.690	28.365	16,636	15,511	.984/(25)	580	2.755/(70)	4700	0.095	58	4.2
ATL1875-CM18B	7.086/(180)	30.690	28.365	16,636	15,511	.984/(25)	580	2.953/(75)	4700	0.095	57	4.2
ATL1878-CM18B	7.086/(180)	30.690	28.365	16,636	15,511	.984/(25)	580	3.071/(78)	4700	0.095	56	4.2
ATL2091-CM20B	8.071/(205)	39.060	36.270	21,131	19,782	1.181/(30)	580	3.582/(91)	3800	0.15	82	4.5
ATL2511-CM25B	9.842/(250)	53.940	52.080	27,875	26,975	.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
ATL1870-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
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

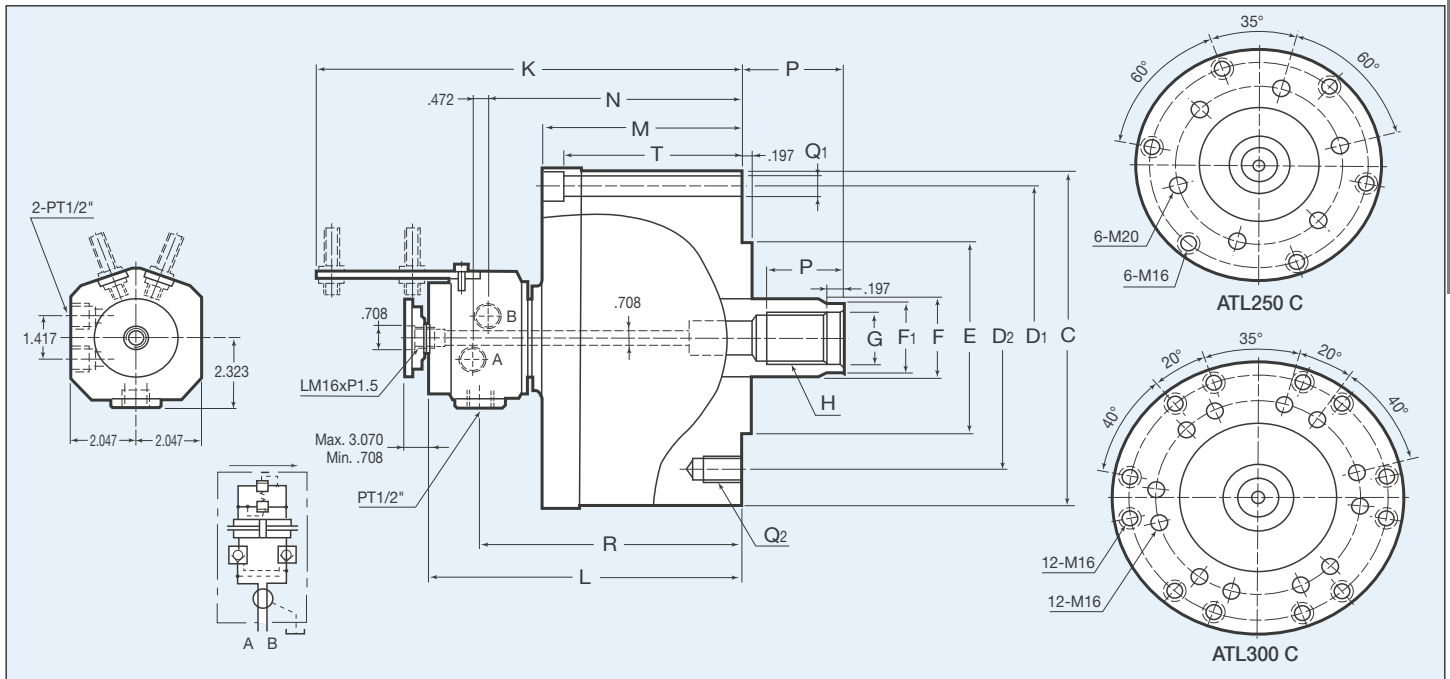
Model	D	E	F	G	H	J	K	L	N	P	Q	S	T	U	V	V	W	W	X	Z	A1	B1
					Thread	Thru. Hole										Max.	Min.	Max.	Min.			
ATL1246-CM12B	5.118	3.937	3.149	2.559	M55x2	1.811	1.417	2.519	2.519	3.346	3.543	4.645	4.488	7.244	.393	-1.99	1.575	.984	.157	.197	.433	4.980
ATL1552-CM15B	6.693	5.118	3.346	2.756	M60x2	2.047	1.417	2.874	2.874	3.779	4.015	5.393	5.118	7.716	.669	-1.99	1.450	.984	.157	.197	.433	5.0354
ATL1868-CM18B	7.480	6.299	4.724	3.740	M75x2	2.677	1.417	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-1.99	1.968	.984	.157	.197	.689	5.984
ATL1870-CM18B	7.480	6.299	4.724	3.740	M78x2	2.755	1.417	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-1.99	1.968	.984	.157	.197	.689	5.984
ATL1875-CM18B	7.480	6.299	4.724	1.692	M85x2	2.953	1.417	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-1.99	1.968	.984	.157	.197	.689	5.984
ATL1878-CM18B	7.480	6.299	4.724	3.740	M87x2	3.071	1.417	3.858	3.858	4.764	5.157	6.535	6.299	9.055	.787	-1.99	1.968	.984	.157	.197	.689	5.984
ATL2091-CM20B	8.464	7.086	5.512	4.331	M100x2	3.582	1.417	3.661	4.252	5.433	5.828	7.165	7.283	9.961	.984	-1.99	2.165	.984	.118	.197	.827	6.555
ATL2511-CM25B	10.827	9.055	6.535	5.512	M130x2	4.626	1.417	3.504	5.828	1.882	-	9.134	8.464	11.653	.708	-1.99	1.496	.590	.118	.197	1.063	7.264



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 Area (sq. in.)		Piston Stroke inch	Max. Draw Bar Force		Operating Pressure psi	Max. Speed rpm	Moment of Inertia I kg-m ²	Weight lbs	Total Leakage L/min	
	Piston Dia. inch	Push Side		Pull Side	Push Side lbf						Pull Side lbf
ATL250C	74.63	70.30	17.858	2.362	50,923	48,008	710	2000	0.87	172	2
ATL300C	108.11	102.08	25.929	2.362	58,775	55,409	580	1500	1.60	234	3



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.

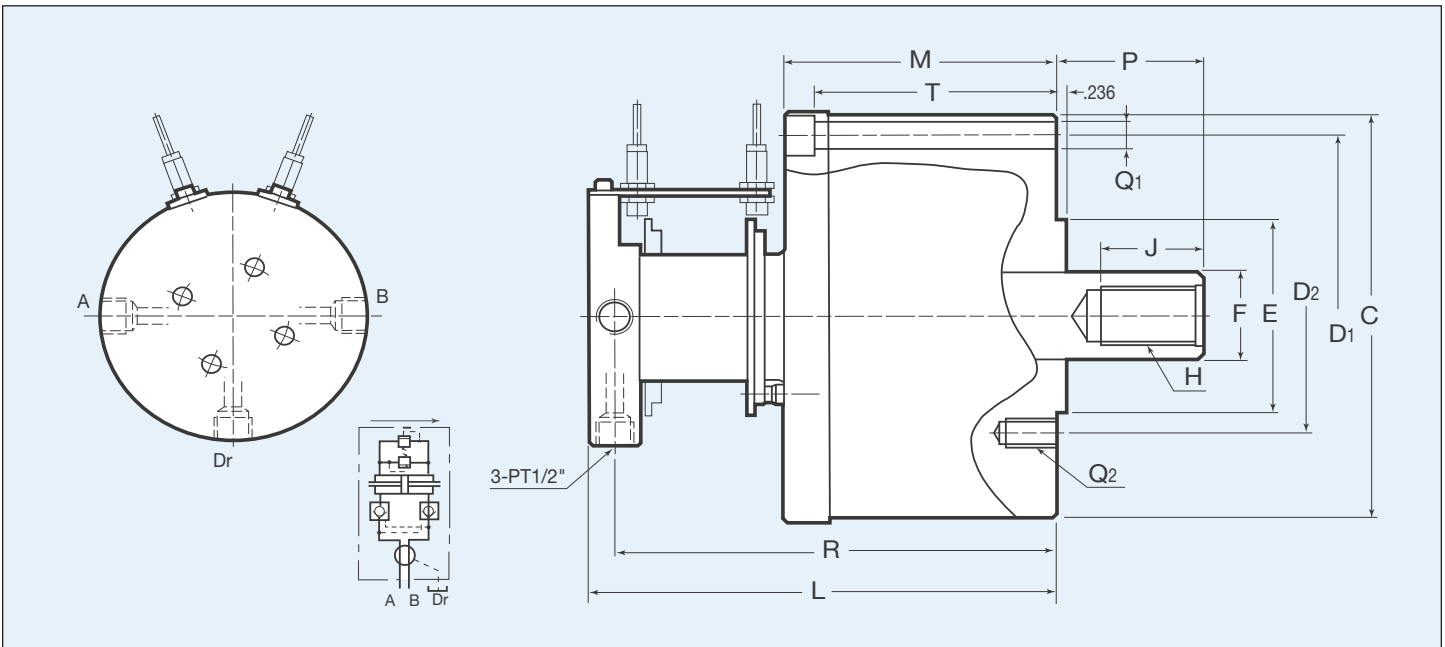


ATLV Series Closed Center Rotary Hydraulic Cylinders

- ⚙ 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 Force		Max. Operating Pressure psi	Max. Speed rpm	Moment of Inertia I kg-m ²	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	32,751	30,060	710	5500	0.55	108	2
ATL25060	9.842	74.63	70.30	2.362	50,923	48,008	710	2000	0.81	159	2

Cylinders



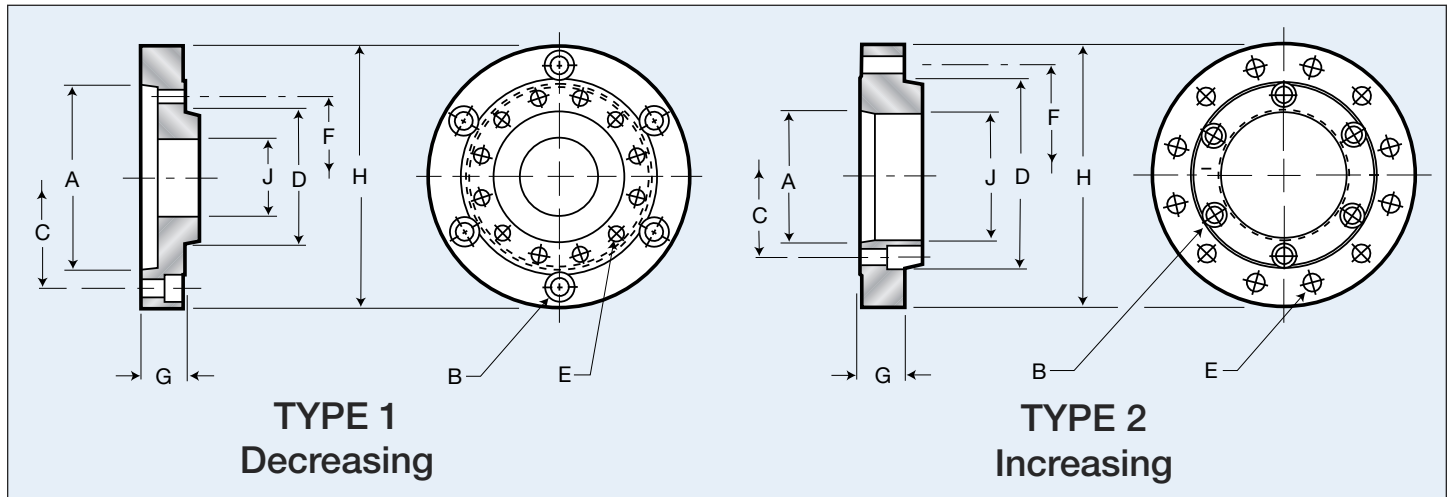
Dimensional Data (inch)

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 to order from 4140 prehardened material
- ⊕ Dimensions are per USA Standards
- ⊕ Available with UNC or metric mounting bolt holes
- ⊕ Precision CNC turned in the U.S.A.



Part No.	Spindle (Machine side female)						Spindle (side male)					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

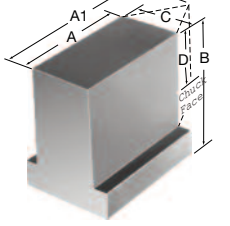
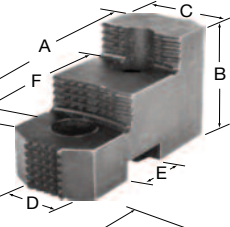
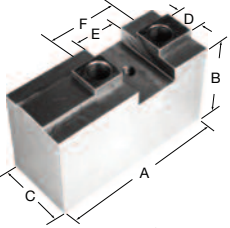
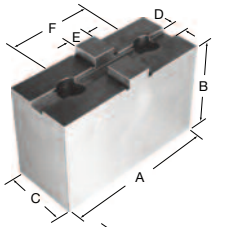
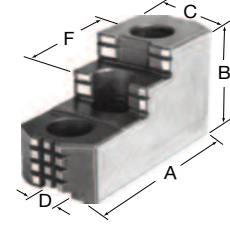
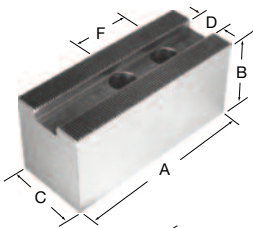
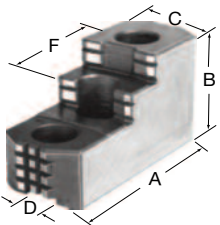
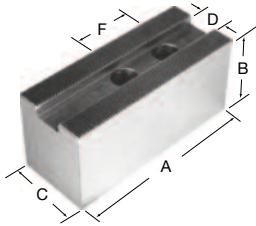
NOTE:

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 101.

Cylinders

Top Jaws and Accessories

For Constant Grip, Quick Change, VTL, Setrite® Power



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.	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Bolt Spacing F
6"	HJ06	2.64"	1.387"	1.22"	.472"	M-10	.787"
8"	HJ08	3.38"	2.01"	1.38"	.551"	M-12	.984"
10"	HJ10	3.92"	2.13"	1.57"	.630"	M-12	1.181"
12"	HJ12	4.06"	2.05"	1.97"	.826"	M-16	1.181"
HJ12-1	HJ12	4.06"	2.05"	1.97"	.708"	M-14	1.181"
15/18"	HJ15	5.87"	3.39"	2.44"	.866"	M-20	1.698"
20" & Up	HJ24-1	6.28"	3.54"	2.15"	.984"	M-20	1.968"

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"	Required
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	5.037"	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.

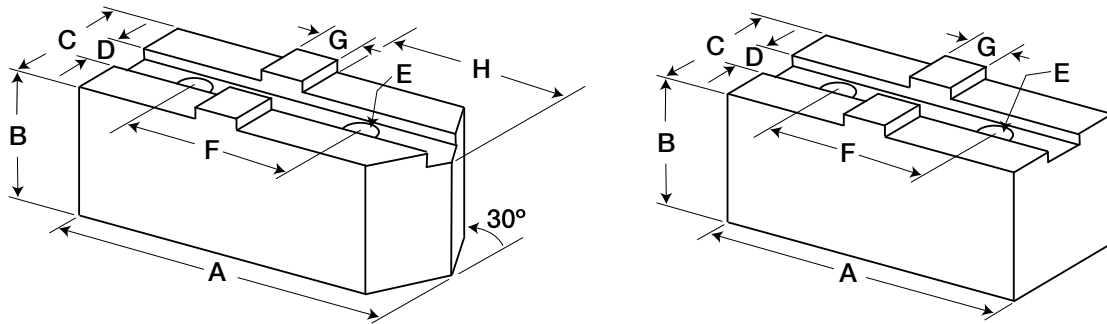
* 8140-17525 are pointed type

① 3mm x 60° Serrations

② 3/32 x 90° Serrations

Top Tooling American Standard Tongue & Groove

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"

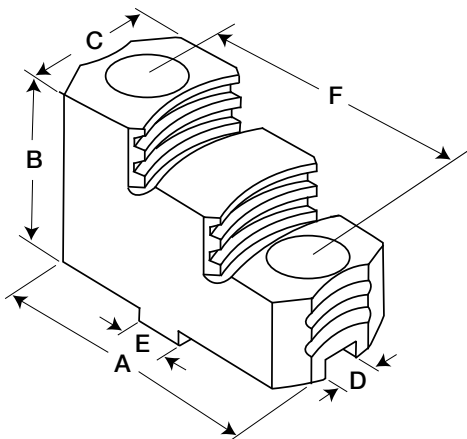
Standard length jaws have centered cross key

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

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**	8210-40608	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"

* All hard top reversible step jaws need to be finish ground in chuck

* Grind in service available at PBA

* Add SR for setrite replacement jaws

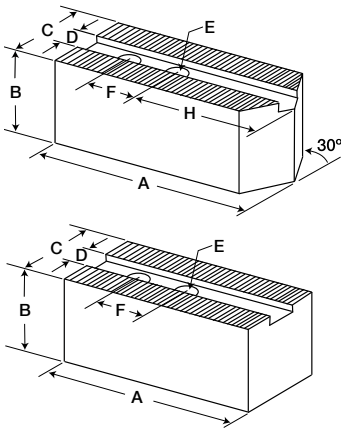
* Easy set replacement jaws available

Top Tooling

1.5mm x 60° and 3mm x 60° Serrations

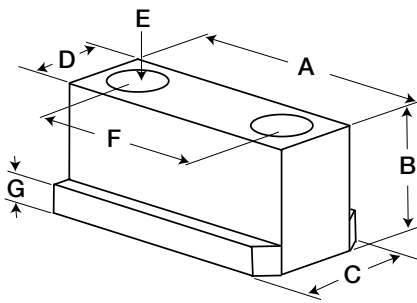
For: Pratt Burnerd, Howa, Kitagawa, Matsumoto and others

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" x 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 split 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" ***	HJ06	2.64"	1.387"	1.22"	.472"	M10	.787"
8"	HJ08	3.38"	2.01"	1.38"	.551"	M12	.984"
10"	HJ10	3.92"	2.13"	1.57"	.63"	M12	1.181"
12" ***	HJ12	4.06"	2.05"	1.97"	.826"	M16	1.181"
12"	HJ12-1	4.06"	2.05"	1.97"	.708"	M14	1.181"
15" & 18"	HJ15	5.87"	3.39"	2.44"	.866"	M20	1.698"
20" & Up**/***	HJ24-1	6.28"	3.54"	3.15"	.984"	M20	1.968"

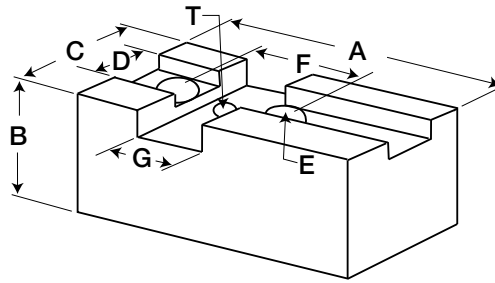
* Some manufacturers' "F" dimension may vary. It may be necessary to buy split t-nuts or split existing nuts

** 20" & up" jaws have 3mm x 60° serrations ***Single step

Top Tooling

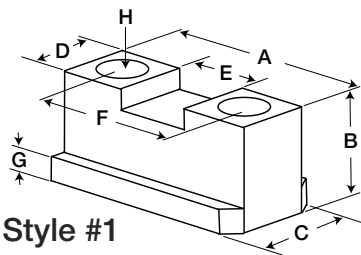
Square Serrations

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

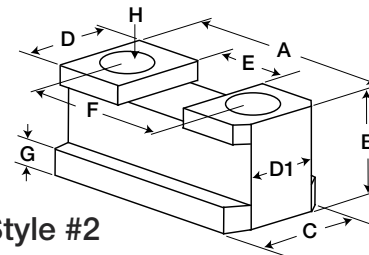


Soft Jaws

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"



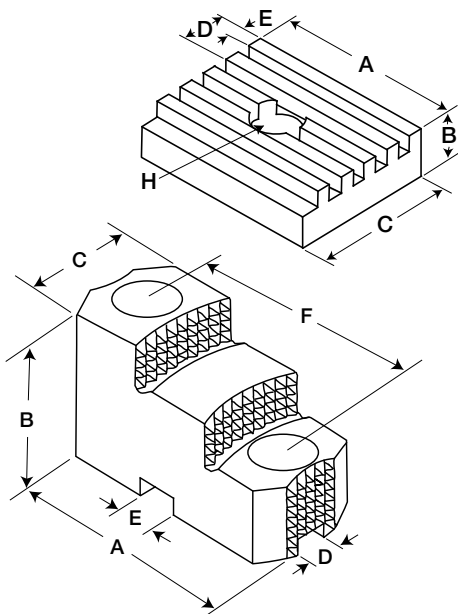
Style #1



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

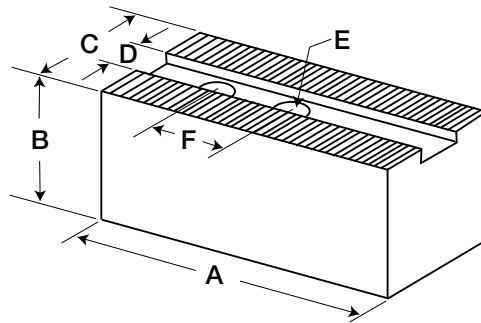
Chuck Size	Part Number	Length A	Height B	Width C	Tongue D	Key Slot E	Hole Spacing F	Bolt Size
10"-12"	8130-26327	4.87"	2.5"	1.75"	.75"	.994"	1.75"	1/2"
15"-18"	8130-38327	5.5"	3.5"	2.25"	1.0"	1.488"	2.5"	3/4"

Top Tooling

Top Tooling

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

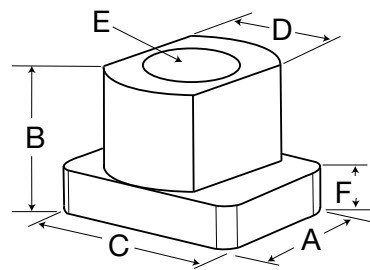
For: Pratt Burnerd and others



Soft Jaws

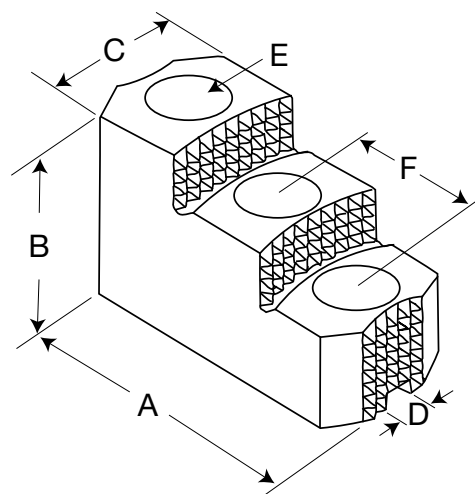
Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Hole Spacing F
6"	8140-17512	2.75"	1.5"	1.00"	.475"	M8	.72"
8"	2860-21512	3.25"	2.0"	1.5"	.670"	M12	1"
10"	2860-21512	3.25"	2.0"	1.5"	.670"	M12	1"
12"	2860-32512	4.5"	2.5"	2.0"	.830"	M16	1.25"
15"&24"*	2860-40512	6.0"	3.0"	2.0"	1.00"	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



Hard Stepped Top Jaws

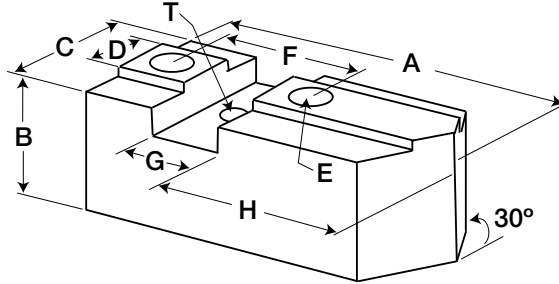
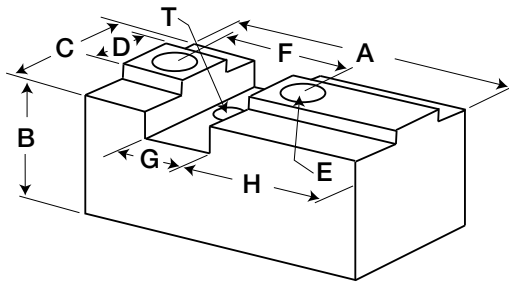
Chuck Size	Part Number	Length A	Height B	Width C	Slot D	Bolt Size E	Bolt Spacing F
6"	8130-17611	2.56"	1.56"	1.18"	.475"	M8	.67"
8"	8130-21611	3.00"	1.97"	1.57"	.670"	M12	.75"
10"	8130-21611	3.00"	1.97"	1.57"	.670"	M12	.75"
12"	8130-31611	4.92"	2.36"	2.36"	.830"	M16	.98"
15"&24"*	8130-40611	4.92"	2.95"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

*3/32" x 90° serrations

Top Tooling

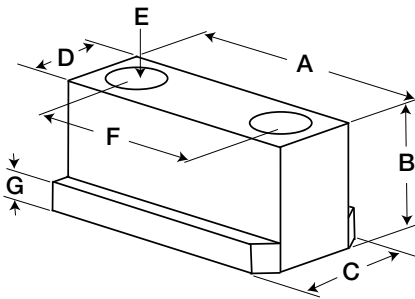
American Standard Acme Serrations

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



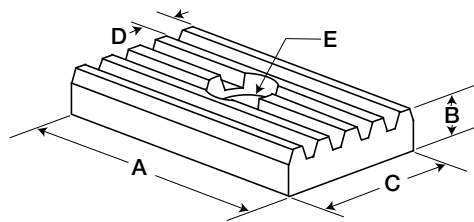
Soft Jaws

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"



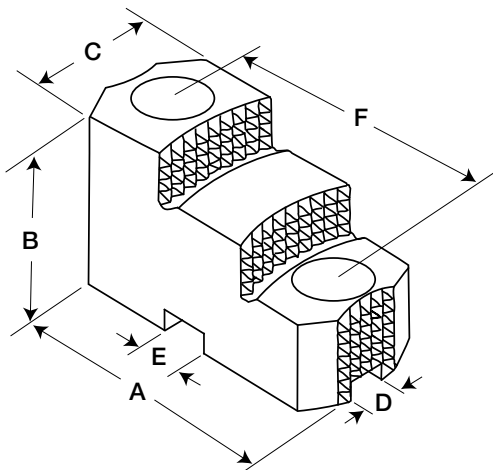
T-Nuts

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"v



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"

Top Tooling

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.

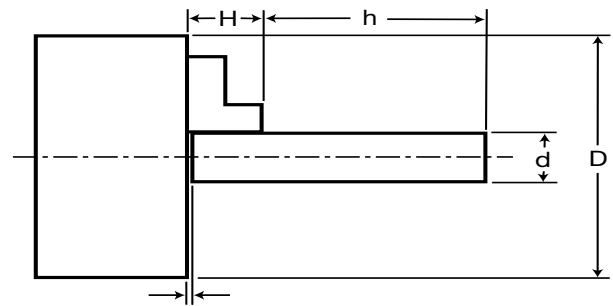
Large heavy top jaws should be avoided if possible since the loss in gripping force due to centrifugal effects at high spindle speeds is increased. If heavy jaws are unavoidable it may be necessary to restrict the spindle speed below the chuck's maximum recommended speed to ensure that sufficient gripping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

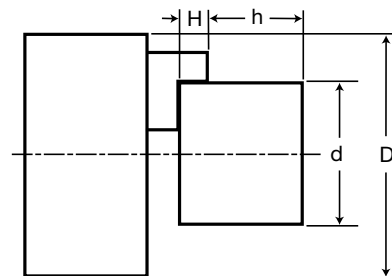
Max $h = 3H$ or $5d$ whichever is the smallest

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.

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

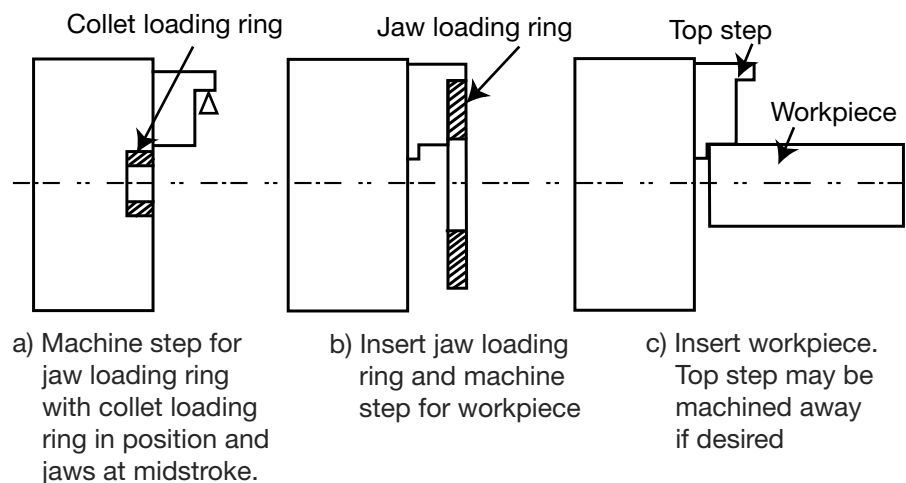
to withstand the gripping force. A diameter is machined to receive the ring at the outer end of the jaws with the chuck in its mid stroke condition, master jaws are flush with the chuck body. The ring previously fitted to the base jaw collet seating diameter is removed after first opening the chuck. 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

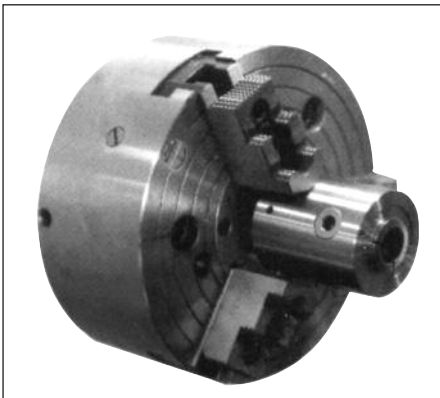
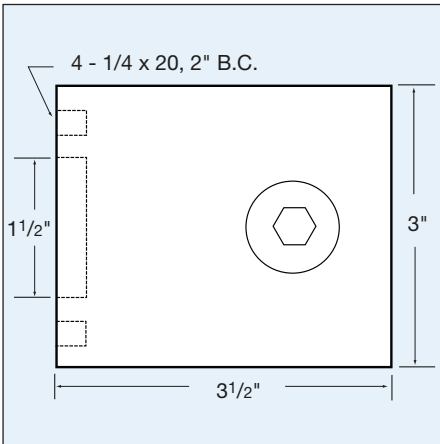




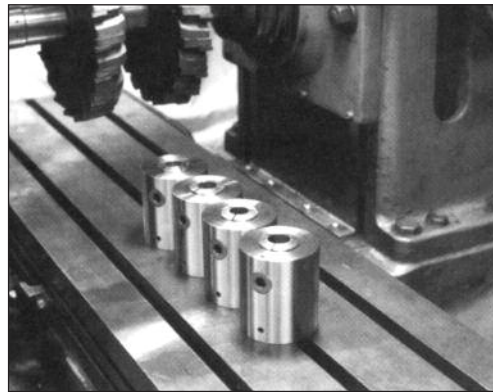
Quick Change 5C Collet Chuck

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

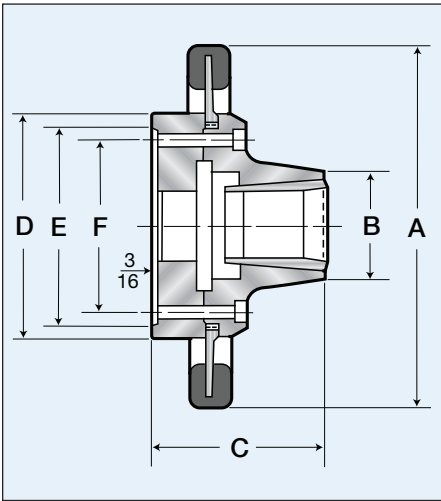


Stack units for multiple part production



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 86-87

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

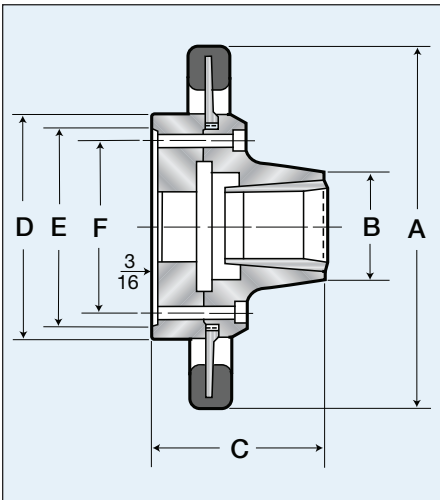
Item No.	Spindle	Round Cap.	Weight Lbs
PB23-41	1-1/2-8	1.06	23
PB23-42	1-3/4-8	1.06	23
PB23-43	2-1/4-8	1.06	23
PB23-44	4° Taper	1.06	25
PB23-45	2-3/16-10	1.06	23
PB23-46	2-3/8-6	1.06	23

**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.



Front Hand Wheel Quickie 16C Collet Chucks

- ⚙️ Fast and easy, front hand wheel operation
- ⚙️ Reduces operator fatigue
- ⚙️ Quick change over chuck to collet chuck - no linkages or drawtubes
- ⚙️ For 16C collets (Max 16C Gripping Round 1-5/8")
- ⚙️ 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 16C Collets see page 88-89

Plain Back Chuck Specifications

Item No.	Desc.	Collet Type	Round Cap.	A	B	C**	D	E	F	Weight Lbs
PB16-00	PB16C	16C	1.625	10	3.15	5.44	7.00	6.00	5.25	30

D Type Cam-Lock Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB16-D3	D1-3	1.625	36
PB16-D4	D1-4	1.625	36
PB16-D5	D1-5	1.625	38
PB16-D6	D1-6	1.625	38
PB16-D8	D1-8	1.625	44
PB16-D11	D1-11	1.625	52

A Type American Standard Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB16-A4	A1-4	1.625	36
PB16-A5	A1-5	1.625	36
PB16-A6	A1-6	1.625	40
PB16-A8	A1-8	1.625	42
PB16-A11	A1-11	1.625	50

L Type American Standard Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB16-L00	L00	1.625	36
PB16-L0	L0	1.625	40
PB16-L1	L1	1.625	44
PB16-L2	L2	1.625	52

Threaded Mount Chuck Specifications

Item No.	Spindle	Round Cap.	Weight Lbs
PB16-43	2-1/4-8	1.625	37
PB16-44	4° Taper	1.625	40
PB16-45	2-3/16-10	1.625	40
PB16-46	2-3/8-6	1.625	42

**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.

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



5C Collet Chuck



16C Collet Chuck

Uses 5C Collets see page 86-87
or 16C Collets see page 88-89

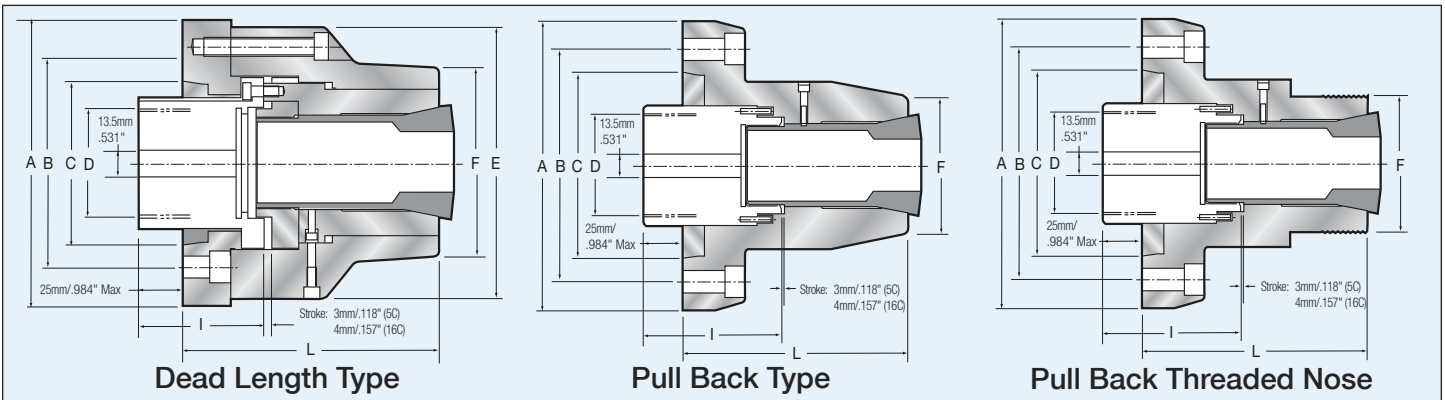
5C & 16C Dead Length & Pull Back Collet Power Chucks

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

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

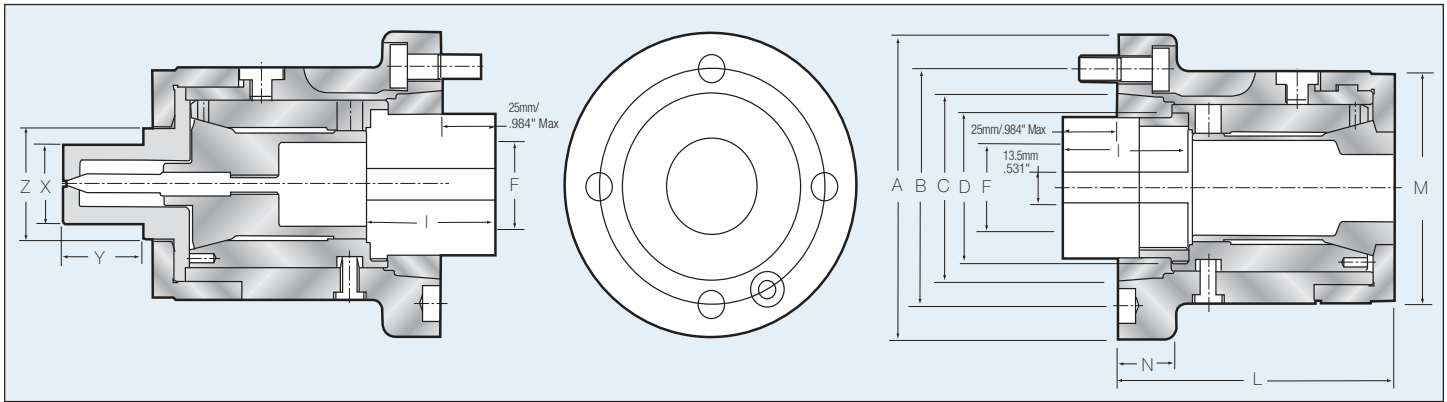


CPC Series Dead-Length Collet Chucks

Use with B type Spring or DIN 6343 Multibore Collets

- ⚙️ 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

Uses B Type Spring Collets
see page 90-94
or Din 6343 Multibore Collets
see page 97



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.



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**

Uses 5C Collets see page 86-87

**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

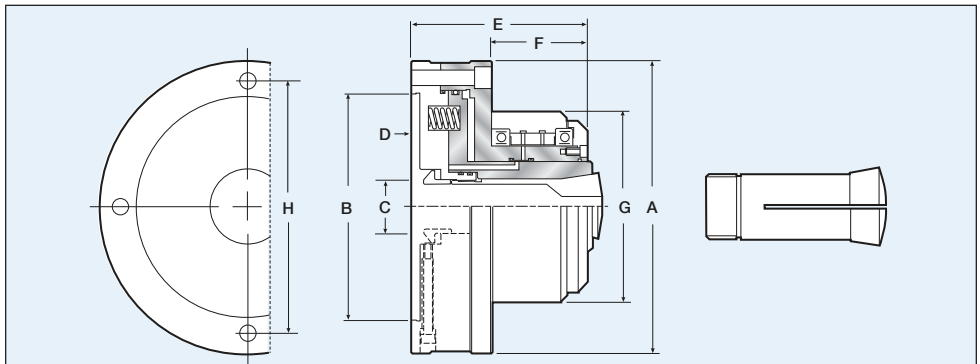
ATL206-5C46-2 3/8-6

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

- 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 with A, D, L, 4 degree, threaded and straight recess mounting plate



Collet Chuck	ATL206-5C
A	168mm (6.61")
B	130mm (5.12")
C	26mm (1.02")
D	4.5mm (0.18")
E	100mm (3.94")
F	55mm (2.17")
G	116mm (4.57")
H	147mm (5.79")

Specifications	ATL206-5C
Screw Hole Dia	9mm (0.35") x 4
Collet Type	5C Collets
Max. RPM	2600
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm ² (42-114 psi)
Through Hole Dia	26mm (1.02")
Chuck Weight	10kg (22lbs)
Grip Force	7,623 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.)



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**

Uses 16C Collets see page 88-89

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

ATL207-16C

**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

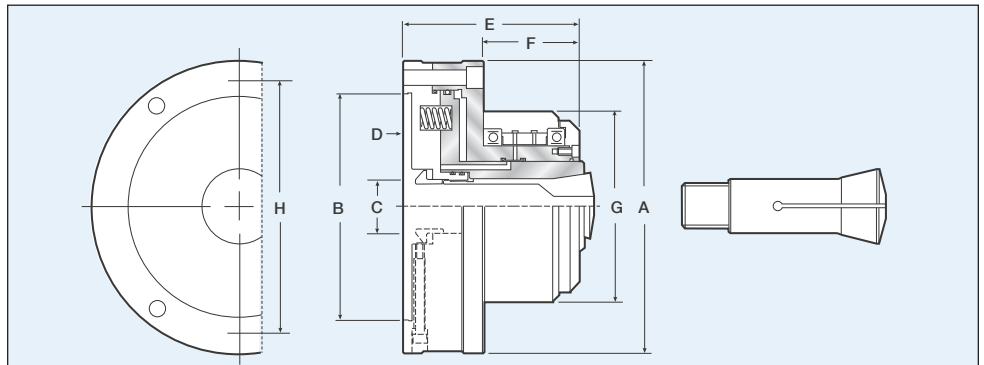
ATL207-16C45-2³/₁₆-10

ATL207-16C46-2³/₈-6

**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

- 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" 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 16C collets, range 1/16" (1mm) to 1-5/8" (42.5mm)
- Available with A, D, L, 4 degree, threaded and straight recess mounting plate



Collet Chuck	ATL207-16C
A	203mm (7.99")
B	160mm (6.30")
C	40mm (1.57")
D	4.5mm (0.18")
E	113mm (4.44")
F	65mm (2.56")
G	136mm (5.35")
H	176mm (6.93")

Specifications	ATL207-16C
Mounting Bolt	M10x3
Collet Type	16C Collets
Max. RPM	2800
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm ² (42-114 psi)
Through Hole Dia	40mm (1.57")
Chuck Weight	17kg (37bs)
Grip Force	8,971 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 90-91

**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

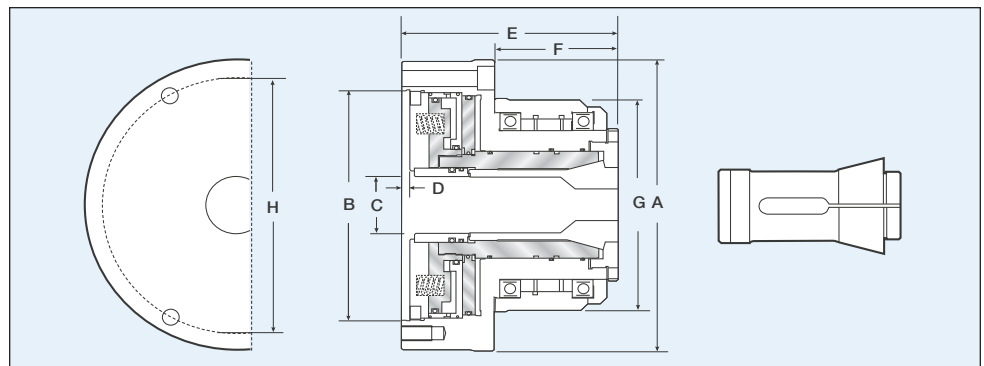
ATL207-B4245-2³/₁₆-10

ATL207-B4246-2³/₈-6

**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 with A, D, L, 4 degree, threaded and straight recess mounting plate



Collet Chuck	ATL207-B42
A	197mm (7.76")
B	155mm (6.10")
C	42mm (1.65")
D	4.5mm (0.18")
E	138mm (5.43")
F	77mm (3.03")
G	146mm (5.76")
H	172mm (6.77")

Specifications	ATL207-B42
Mounting	M10x3
Collet Type	B42 Collets
Max. RPM	2500
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm ² (42-114 psi)
Through Hole Dia	42mm (1.65")
Chuck Weight	17kg (37lbs)
Grip Force	12,258 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.)



Uses B60 Collets see page 92-93

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

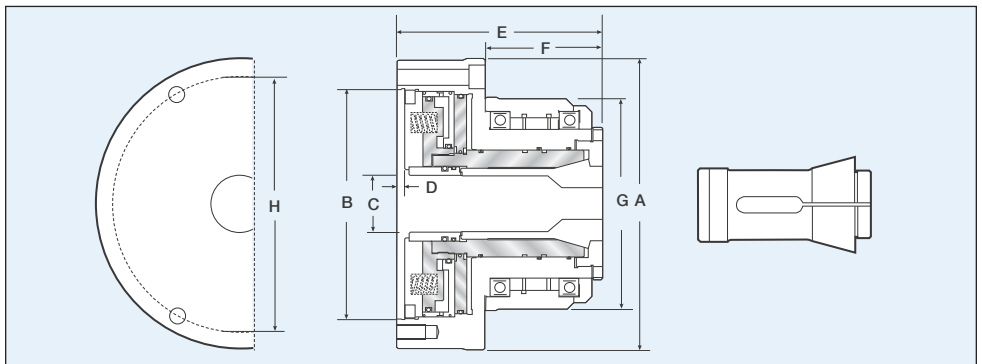
Collet Chuck Supplied with:

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

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

- 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 with A, D, L, threaded and straight recess mounting plate



Collet Chuck	ATL208-B60
A	214mm (8.43")
B	170mm (6.69")
C	60mm (2.36")
D	4.5mm (0.18")
E	148mm (5.83")
F	85mm (3.35")
G	164mm (6.96")
H	186mm (7.32")

Specifications	ATL208-B60
Mounting	M10x3
Collet Type	B60 Collets
Max. RPM	2000
Sleeve Stroke	4mm (0.16")
Air Pressure	3-8 kg/cm ² (42-114 psi)
Through Hole Dia	65mm (2.375")
Chuck Weight	21.kgkg (46lbs)
Grip Force	13,358 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.)

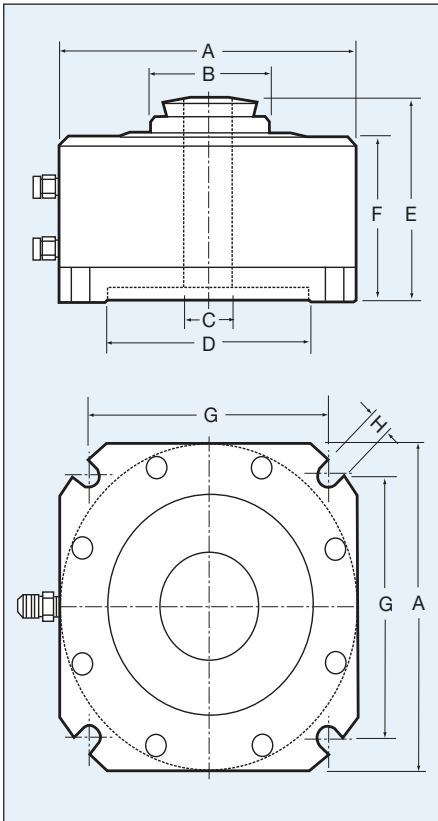


Uses 5C Collets see page 86-87

Stationary ATL225-5C Dead Length Collet Chuck

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

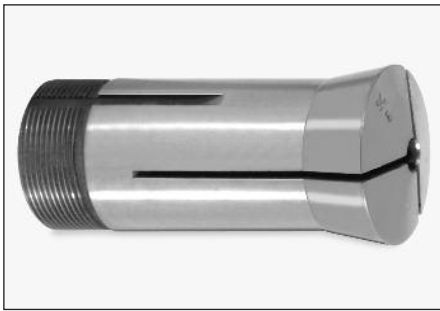
- ⌚ Powered by air
- ⌚ Small foot print
- ⌚ Low cost
- ⌚ Easy to install
- ⌚ Repeatability plus minus .0004"
- ⌚ Dead length design
- ⌚ Lever or foot pedal actuated
- ⌚ Low maintenance with oil mist lubrication system
- ⌚ High resistance to coolant and chip penetration
- ⌚ Low maintenance, long life



ATL225-5C Collet Type

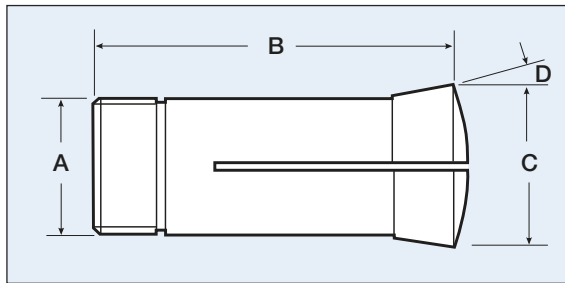
Order Number	ATL225-5C
A (mm/in)	144mm/5.67"
B (mm/in)	55mm/2.17"
C (mm/in)	26mm/1.02"
D (mm/in)	100mm/3.94"
E (mm/in)	93mm/3.66"
F (mm/in)	74mm/2.91"
G (mm/in)	118mm/4.65"
H (mm/in)	9mm/0.35"
Working Collet/Jaws	5C Collet
Air/Hydro Actuated	Air
Operating Pressure	3-15kg/cm ² 43-214psi
Capacity Min. Max.	1.0mm/1/16" 27mm/1-1/8"
Piston Area	112cm ² /17.4in ²
Clamping Force	3890 kgf@7kg/cm ² 8550 lb f@100psi
Net Weight	9 kgs/19.8 lbs

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



5C Collets (Inch)

See page 99 for Accuracy Chart



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 97 for Accuracy Chart

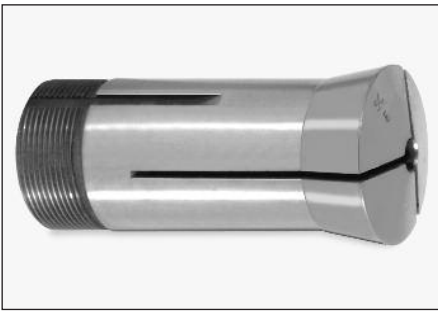
Size	Round	Hex	Square
23/32"	0123-R-23/32	-	-
47/64"	0123-R-47/64	-	-
3/4"	0123-R-3/4	H-0123-3/4	S-0123-3/4
49/64"	0123-R-49/64	-	-
25/32"	0123-R-25/32	-	-
51/64"	0123-R-51/64	-	-
13/16"	0123-R-13/16	H-0123-13/16	-
53/64"	0123-R-53/64	-	-
27/32"	0123-R-27/32	-	-
55/64"	0123-R-55/64	-	-
7/8"	0123-R-7/8	-	-
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 Collet 1/8" P/N: 5C-Emergency

5C Round Collet Sets (inch)

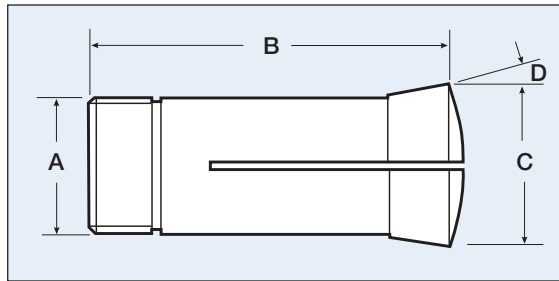
Set	No. of Collets	Part No.
1/16"-1-1/16" x 64ths	65	0123-SET-4
1/16"-1-1/16" x 32nds	33	0123-SET-5
1/16"-1-1/16" x 16ths	17	0123-SET-6
1/8"-1" x 8ths	8	0123-SET-7





See page 99 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 97 for Accuracy Chart

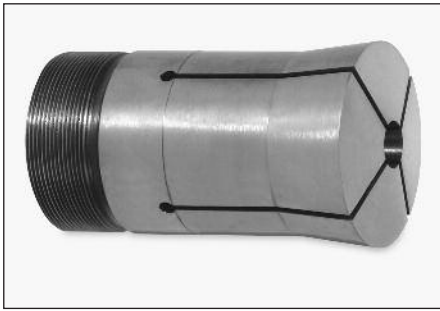
Size	Part Number
20.0mm	0123-R-20.0mm
20.5mm	0123-R-20.5mm
21.0mm	0123-R-21.0mm
21.5mm	0123-R-21.5mm
22.0mm	0123-R-22.0mm
22.5mm	0123-R-22.5mm
23.0mm	0123-R-23.0mm
23.5mm	0123-R-23.5mm
24.0mm	0123-R-24.0mm
24.5mm	0123-R-24.5mm
25.0mm	0123-R-25.0mm
25.5mm	0123-R-25.5mm
26.0mm	0123-R-26.0mm
26.5mm	0123-R-26.5mm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

5C Emergency Steel Collet 3.175mm P/N: 5C-Emergency

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

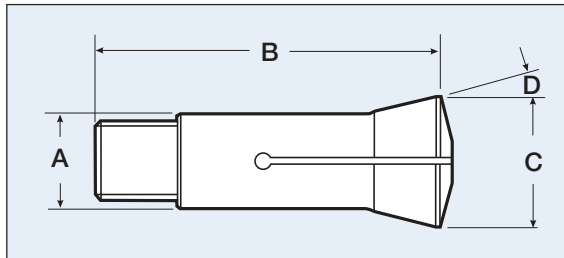




16C Collets (Inch)

See page 99 for Accuracy Chart

Emergency Collet P/N G-444



Dimensions

A	B	C	D
1.89"	4.35"	2.26"	10°

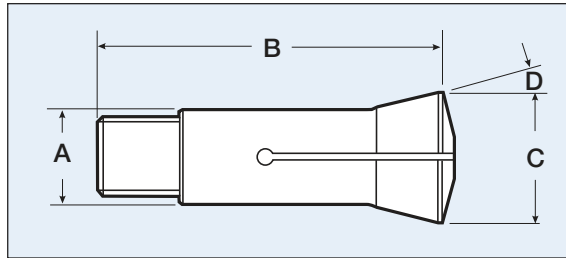
Size	16C inch		
	Round	Hex	Square
1/16"	G119-R-1/16	-	-
5/64"	G119-R-5/64	-	-
3/32"	G119-R-3/32	-	-
7/64"	G119-R-7/64	-	-
1/8"	G119-R-1/8	-	-
9/64"	G119-R-9/64	-	-
5/32"	G119-R-5/32	-	-
11/64"	G119-R-11/64	-	-
3/16"	G119-R-3/16	-	-
13/64"	G119-R-13/64	-	-
7/32"	G119-R- 7/32	-	-
15/64"	G119-R-15/64	-	-
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 99 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

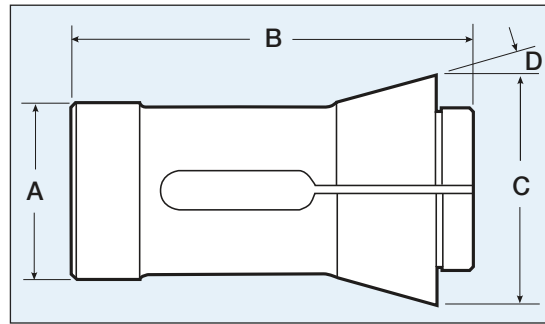
Size	16C metric		
	Round	Hex	Square
22.0mm	G119-R-22.0mm	G119-X-22.0mm	G119-S-22.0mm
22.5mm	G119-R-22.5mm	G119-X-22.5mm	G119-S-22.5mm
23.0mm	G119-R-23.0mm	G119-X-23.0mm	G119-S-23.0mm
23.5mm	G119-R-23.5mm	G119-X-23.5mm	G119-S-23.5mm
24.0mm	G119-R-24.0mm	G119-X-24.0mm	G119-S-24.0mm
24.5mm	G119-R-24.5mm	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 G-444



See page 98 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	-	-

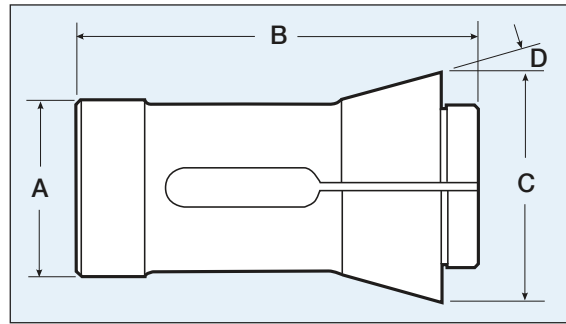
Emergency Collet P/N J-550

*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 98 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	-	-

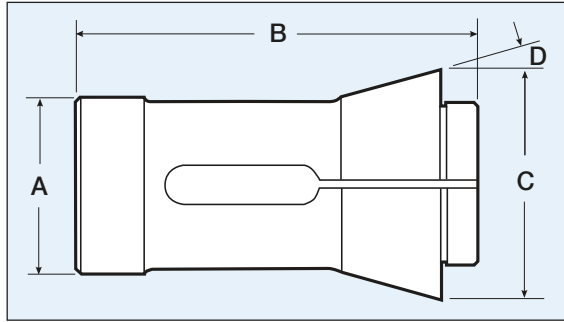
Emergency Collet P/N J-550

*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 98 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-X-1-15/16	-
2"	4291-R-2	4291-X-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

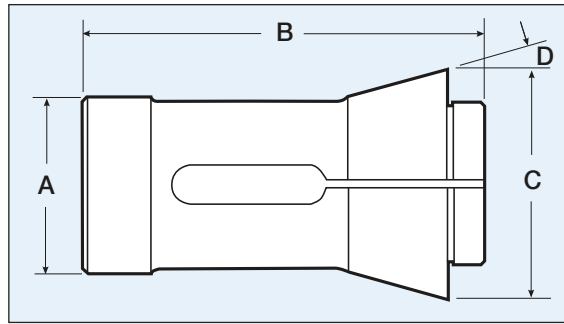
Emergency Collet P/N H-767

*To order round plain bore collets replace R with RP in part number: Example 4291-RP-1/16



B-60 Spring Series 185E Collets (Metric)

See page 98 for Accuracy Chart



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	-	-

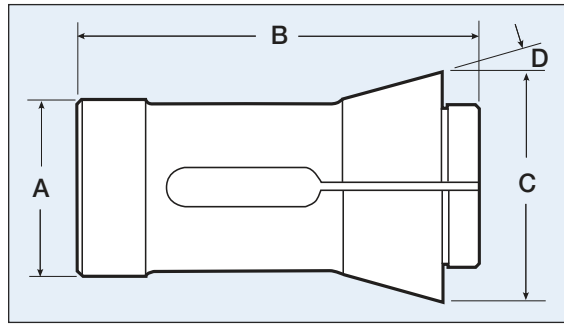
Emergency Collet P/N H-767

*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 98 for Accuracy Chart



Dimensions

A	B	C	D
3.543"	5.118"	4.212"	15°

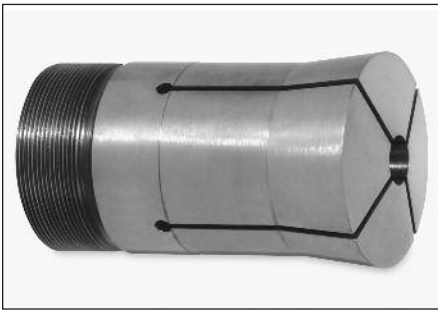
Size	B-80 (inch) Part Number
9/16"	H047-R-9/16
5/8"	H047-R-5/8
11/16"	H047-R-11/16
3/4"	H047-R-3/4
13/16"	H047-R-13/16
7/8"	H047-R-7/8
15/16"	H047-R-15/16
1"	H047-R-1-0
1-1/16"	H047-R-1-1/16
1-1/8"	H047-R-1-1/8
1-3/16"	H047-R-1-3/16
1-1/4"	H047-R-1-1/4
1-5/16"	H047-R-1-5/16
1-3/8"	H047-R-1-3/8
1-7/16"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

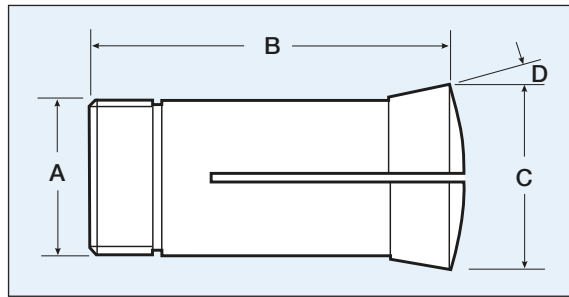
Size	B-80 (Metric) Part Number
38mm	H047-R-38mm
38.5mm	H047-R-38.5mm
39mm	H047-R-39mm
39.5mm	H047-R-39.5mm
40mm	H047-R-40mm
40.5mm	H047-R-40.5mm
41mm	H047-R-41mm
41.5mm	H047-R-41.5mm
42mm	H047-R-42mm
42.5mm	H047-R-42.5mm
43mm	H047-R-43mm
43.5mm	H047-R-43.5mm
44mm	H047-R-44mm
44.5mm	H047-R-44.5mm
45mm	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)



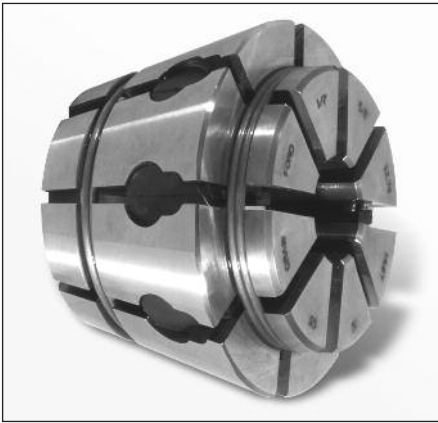
Dimensions

A	B	C	D
1.988 x 20 tpi	3.937"	2.2"	7°

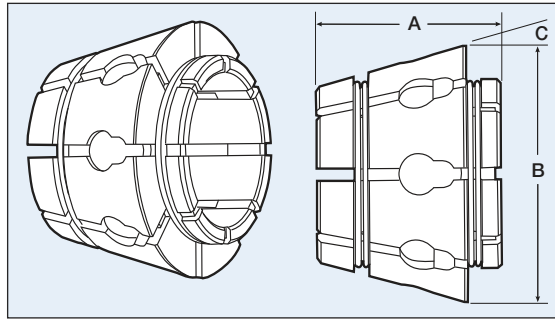
Size	Part Number
1/16"	3J-R-1/16
5/64"	3J-R-5/64
3/32"	3J-R-3/32
7/64"	3J-R-7/64
1/8"	3J-R-1/8
9/64"	3J-R-9/64
5/32"	3J-R-5/32
11/64"	3J-R-11/64
3/16"	3J-R-3/16
13/64"	3J-R-13/64
7/32"	3J-R-7/32
15/64"	3J-R-15/64
1/4"	3J-R-1/4
17/64"	3J-R-17/64
9/32"	3J-R-9/32
19/64"	3J-R-19/64
5/16"	3J-R-5/16
21/64"	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

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°

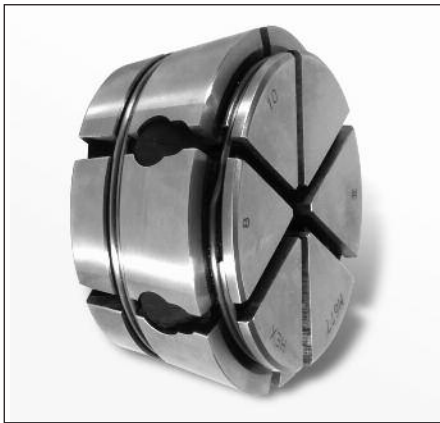
U.S. Trade Mark 2,898,519

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*	-	-

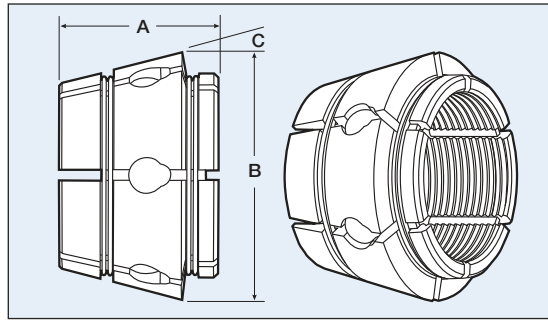
*39-42mm round only

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
M-673	1.53"	2.42"	14.75°
M-677	1.77"	3.36"	14.75°
J-660	1.89"	4.27"	14.75°

U.S. Trade Mark 2,898,519

Grip Range		M-673 173E 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 (*)

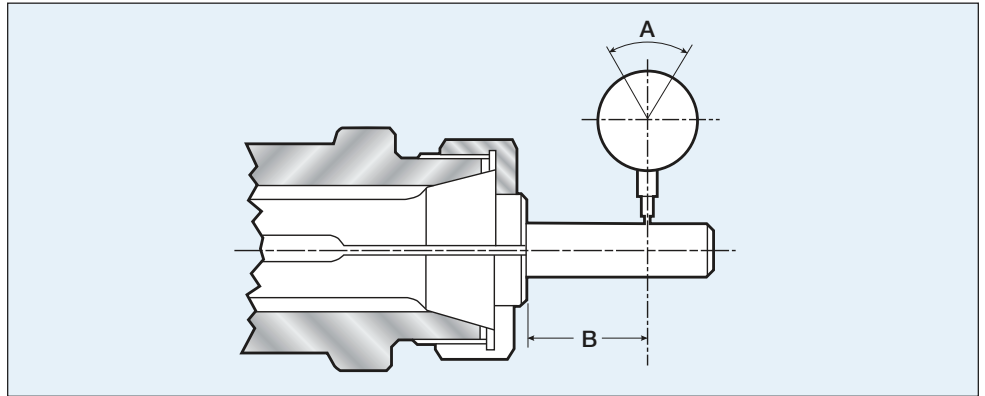
Hexagonal and square collets are supplied with annular serrations except where marked with (*)

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"

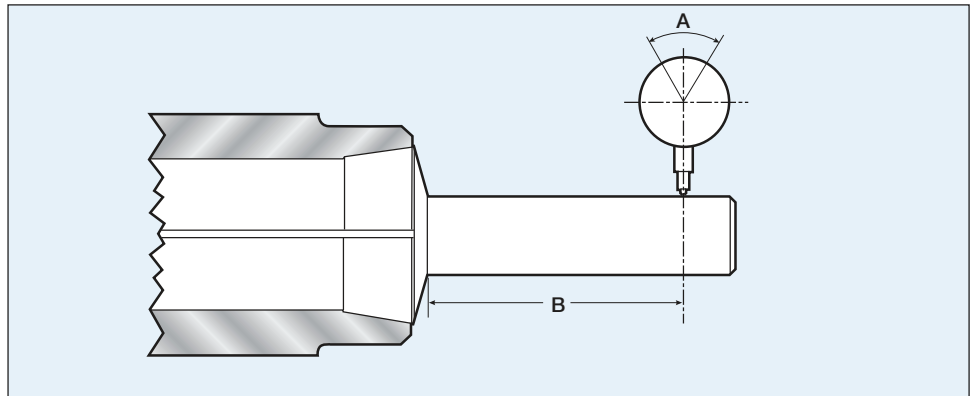


5C Collets page 86-87



16C Collets page 88-89

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:

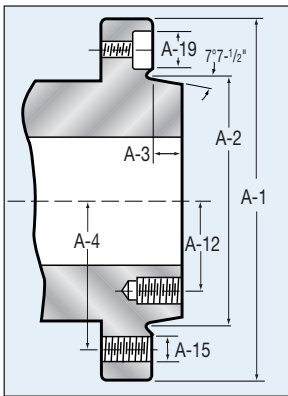
- ⚙ Dramatically improves chuck jaw forces over conventional lubricants, withstands pressure up to 500,000 pounds per square inch.
- ⚙ Rust and oxidation inhibitors
- ⚙ Tacky nature gives high resistance to centrifugal force.
- ⚙ Contains molybdenum disulfide to reduce seizing, fretting wear galling 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

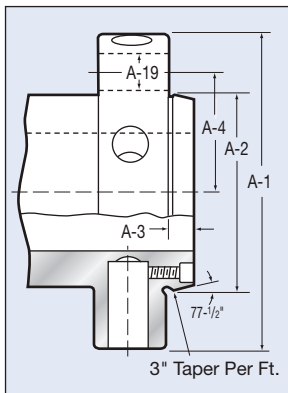
Source: American Standard Bulletin ASA B5.9 1960



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

	A5	A6	A8	A11	A15	A20
A-1	5¼	6½	8¼	11	15	20½
A-2*	3.2505	4.1880	5.50075	7.75075	11.251**	16.251**
A-3***	.5625	.625	.6875	.750	.8125	.875
A-4	2¼/16	2⅝	3⅜	4⅝	6½	9⅝
A-12	17/32	1⅝	2¾/16	3¼	47/8	7¼
A-15	7/16-14	1/2-13	5/8-11	¾-10	7/8-9	1-8
	10mm	12mm	16mm	20mm	24mm	24mm

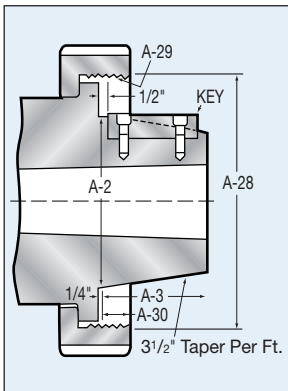
*Tolerance +.0005/-.000 **Tolerance +.001/-.000 ***Tolerance +.000/-.001
 A-1 Has tapped holes on both the inner bolt circle and outer bolt circle.
 A-2 Has tapped holes on the outer bolt circle, but has no hole on inner bolt circle.
 B-1 Has drilled holes on the outer bolt circles, and has tapped holes 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	3⅝	4⅝	5¾	7¼	87/8	11¾
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	1¼/16
A-4	125/64	1⅝	2¼/16	2⅝	3⅜	4⅝
A-19	.594	.656	.781	.906	1.031	1.218

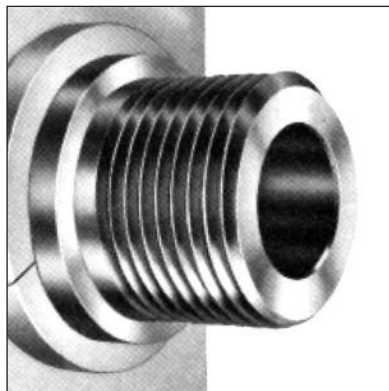
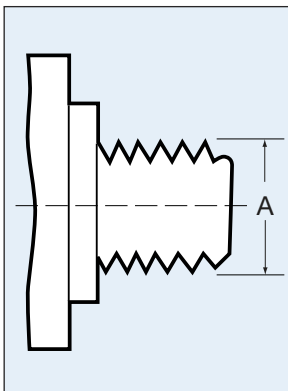
*Tolerance +.0005/-.000 **Tolerance +.00025/-.000



Type L long taper key drive

	L00	L0	L1	L2	L3
A-2*	2¾	3¼	4⅛	5¼	6½
A-3	2	2⅜	27/8	3⅜	37/8
A-28	3¾	4½	6	7¾	10⅝
A-29	6TPI	6TPI	6TPI	5TPI	4TPI

*Tolerance +.002/-.000



Threaded Spindle

Thread size
A
1½-8
2¼-8
2⅝-6

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