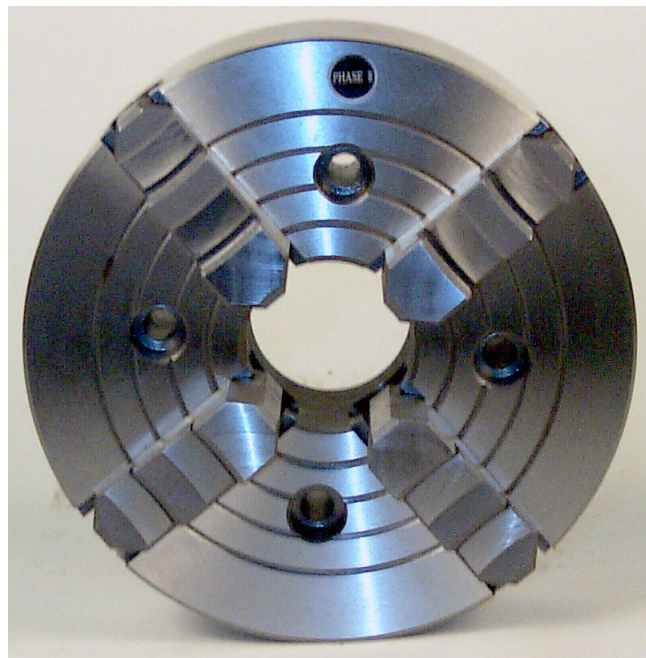


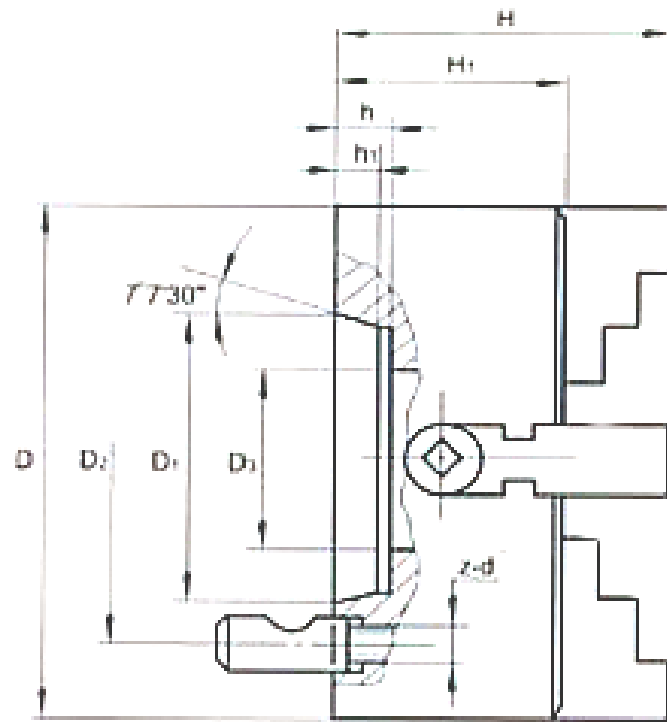
4-Jaw Lathe Chucks

Technical Specifications



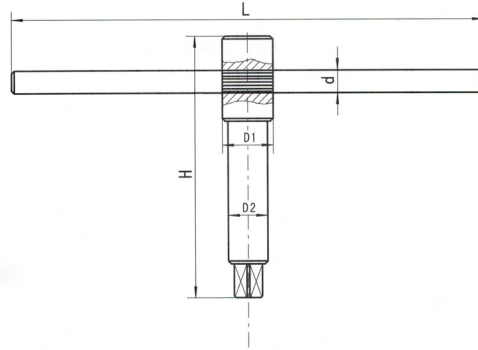
Plain Back and Direct Mount (D1)

Mounting Specifications: D1 Direct Mount Lathe Chucks



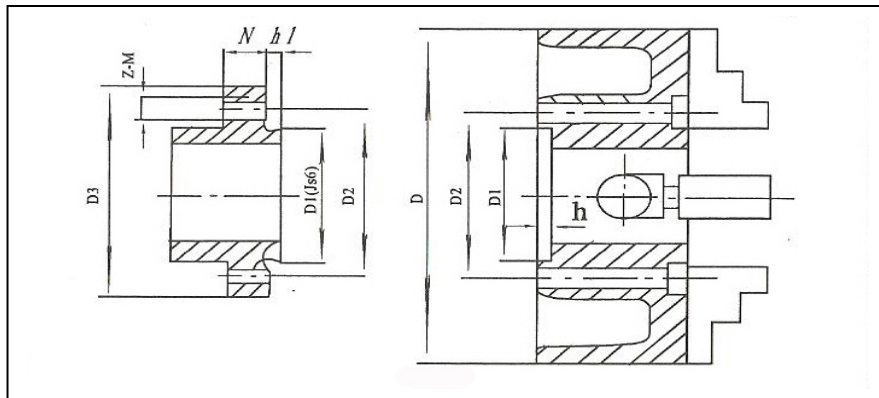
Size D	Spindle	D1	D2	D3	H	H1	h	h1	Z-d
8"	D1-4	63.513	82.6	56	107	75	13	10	3-M10
10"	D1-6	106.375	133.4	75	120	80	16	13	6-M16
12"	D1-6	106.375	133.4	95	138	90	16	13	6-M16
12"	D1-8	139.719	171.4	95	138	90	18	14	6-M20
16"	D1-8	139.719	171.4	125	143	95	18	14	6-M20

Lathe Chuck Key Spec



SIZEmm	Lxd	HxD1xD2	Key Size
125 (5")	160xΦ 8	78xΦ 16xΦ 13	7
160 (6")	180xΦ 10	96xΦ 20xΦ 18	10
200 (8")	200xΦ 12	110xΦ 20xΦ 16	10
250 (10")	250xΦ 12	120xΦ 20xΦ 20	12
315 (12")	315xΦ 14	150xΦ 24xΦ 24	14
400 (15")	400xΦ 16	200xΦ 30xΦ 24	14
500 (20")	400xΦ 16	200xΦ 30xΦ 24	14
630 (25")	450xΦ 16	220xΦ 30xΦ 26	17

Mounting Specifications: Plain Back Lathe Chucks

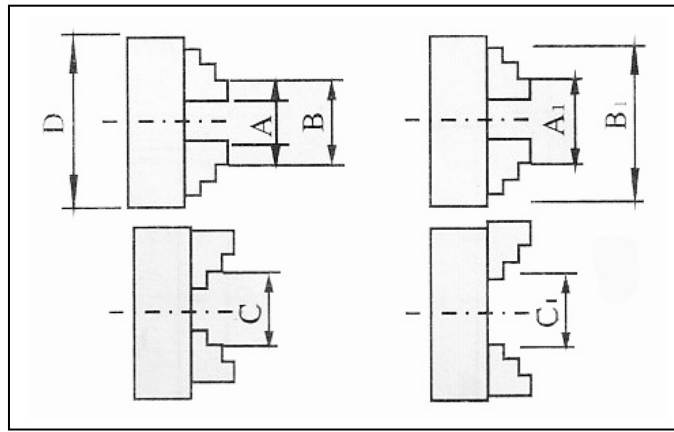


Lathe Chuck

Adapter Plate

D	D1	D2	h	D3 >	N >	h1	Z-M
6"	2.55"	3.74"	.196"	4.72"	.787"	.157"	4-M10
8"	2.95"	3.74"	.236"	4.72"	.787"	.196"	4-M10
10"	4.33"	5.11"	.236"	6.10"	.984"	.196"	4-M12
12"	5.51"	6.49"	.236"	7.67"	1.10"	.196"	4-M16
16"	6.29"	7.28"	.314"	8.46"	1.18"	.275"	4-M16
20"	7.87"	9.29"	.314"	10.82"	1.25"	.275"	4-M20

Clamping Range:



Diameter of Chuck	Internal Jaws		External Jaws
	A-A1	B-B1	C-C1
6"	.118 - 2.16"	1.96 - 6.30"	2.16 - 5.70"
8"	.157 - 3.34"	2.56 - 7.87"	2.56 - 7.87"
10"	.236 - 4.33"	3.15 - 9.84"	3.54 - 9.84"
12"	.393 - 5.51"	3.74 - 12.79"	3.93 - 12.79"
16"	.590-8.26"	4.72 - 15.74"	4.72 - 15.74"
20"	.984-11.02"	5.90-19.68"	5.90-19.68"

No.	Inspection Items	Sketch showing method of test	Chuck Size	Allowable Tolerance	
				a	b
G0.	Radial runout of the outside diameter and axial runout of face of flange and adaptor		6" up to 20"	(a) 0.0001"	
			6" up to 20"	(b) 0.0003"	
G1.	Radial runout of outside diameter and end runout of the chuck			a	b
			6"	0.001"	0.001"
			8" up to 10"	0.002"	0.002"
			12" up to 16"	0.002"	0.002"
G2.	Diameter runout of testing bar clamped in the jaws of the chuck			L	a
			6" up to 8"	1.96"	0.003"
			10"	2.95"	0.003"
			12" up to 16"	2.95"	0.004"
			20"	3.93"	0.006"

No.	Inspection Items	Sketch showing method of test
G3.	Runout of testing ring clamped on the inside stepped surface of the chuck	

L1=.472"	a	b
6"	0.002"	0.001"
8" up to 10"	0.002"	0.001"
12" up to 16"	0.003"	0.002"
20"	0.004"	0.003"

L1=.472"	a	b
6"	0.002"	0.001"
8" up to 10"	0.002"	0.002"
12" up to 15"	0.003"	0.002"
20"	0.004"	0.003"