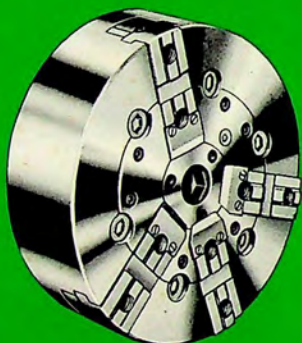


Syr. Supply July 1968

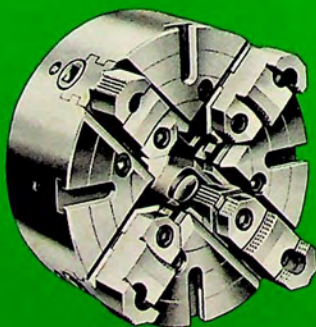
SKINNER

HORTON-UNION CHUCKS



POWER OPERATED CHUCKS and CYLINDERS

Power Chucking is the best way to reduce floor-to-floor time. Power chucks and actuating air and hydraulic cylinders have been designed and built for continuous production line service with the benefits of reduced chucking time, positive gripping, accurate repeatability, and precision workholding on the latest machine tool equipment available today.



MANUALLY OPERATED CHUCKS

This series of chucks incorporates the most advanced principles of design and engineering, resulting in workholding devices with the ability to assure positive gripping, repetitive accuracy, and a long trouble-free service life. Each style will provide the maximum in workholding performance on modern machine tools.

***POWER and
MANUAL
OPERATED
WORKHOLDING
EQUIPMENT***

SYRACUSE SUPPLY
COMPANY
SYRACUSE SCHENECTADY
BINGHAMTON

SKINNER CHUCK DIVISION HORTON - UNION

CUSHMAN INDUSTRIES, INCORPORATED
806 WINDSOR STREET, HARTFORD, CONNECTICUT 06102
Telephone: 203-527-0741

All products subject to prior sale. The Company reserves the right to make changes in product design, specifications, and prices without prior notice. For prices refer to separate price list.

MANUAL and POWER WORKHOLDING EQUIPMENT

EXPLANATION OF REFERENCE NUMBERS

10	124	12	A08
SERIES NUMBER		CHUCK SIZE	CHUCK MOUNTING

Note: To assist in making the transition to the present series number, a numerical index by former catalog number is provided on the inside back cover.

DEFINITION OF CHUCK CLASSES:

Subject to change. Refer to current Price List.

CLASS A—Chucks having greatest demand and usually available from stock.

CLASS B—Delivery within about two weeks of Class A. Chucks.

CLASS D—Price and delivery on application.

CHUCKS NOT DESIGNATED ARE CLASS A.

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*See inside back cover for index by former catalog number.

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CHUCK AND CYLINDER DIMENSIONS ARE PROVIDED IN DIMENSION BULLETINS AVAILABLE ON REQUEST

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POWER CHUCK INSTALLATION

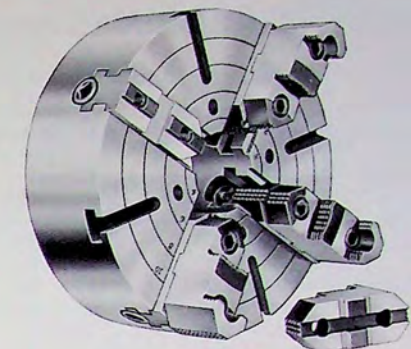
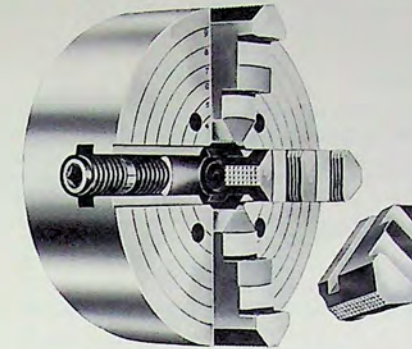
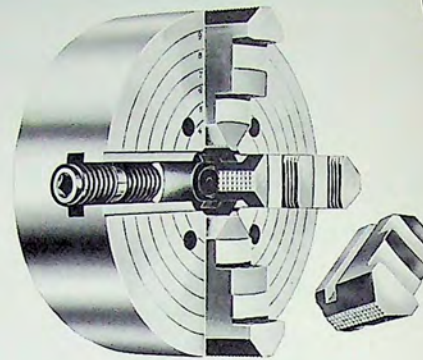
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MANUALLY OPERATED WORKHOLDING EQUIPMENT

4-JAW INDEPENDENT CHUCKS

Independent Chucks meet the requirements of modern production practice for strength and maintained accuracy in service. Self-Aligning, patented, two-piece thrust bearings eliminate thread and shoulder cutting. Operating screws are threaded for their entire length, permitting maximum jaw movement. Bodies are heavily reinforced at their centers, providing wide, heavy ribs for jaw bearings. Parts are of carefully heat-treated selected steels.

Steel chucks 12" to 24" have T-slots. Semi-steel chucks 4½" to 6" have plain faces; 8" to 12" have bolt openings; 15" to 24" have elongated bolt openings. Chucks 28" to 36" have T-slots and elongated bolt openings. T-handle type heat-treated alloy steel wrench is provided with each chuck.



STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-001 SEMI-STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
4	10-001-04-000	A	21	10-001-21-000	A
8	10-001-08-000	A	24	10-001-24-000	A
10	10-001-10-000	A	28	11-001-28-000	D
12	10-001-12-000	A	32	11-001-32-000	D
15	10-001-15-000	A	36	11-001-36-000	D
18	10-001-18-000	A			

SERIES 10-002 SEMI-STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
24	10-002-24-000	B	32	11-002-32-000	D
28	11-002-28-000	D	36	11-002-36-000	D

SERIES 10-003 STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-003-06-000	A	21	10-003-21-000	A
8	10-003-08-000	A	24	10-003-24-000	A
10	10-003-10-000	A	28	11-003-28-000	D
12	10-003-12-000	A	32	11-003-32-000	D
15	10-003-15-000	A	36	11-003-36-000	D
18	10-003-18-000	A			

SERIES 10-004 STEEL BODIES AM. STD. TWO PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-004-08-000	B	21	10-004-21-000	B
10	10-004-10-000	B	24	10-004-24-000	B
12	10-004-12-000	B	28	11-004-28-000	D
15	10-004-15-000	B	32	11-004-32-000	D
18	10-004-18-000	B	36	11-004-36-000	D

4-JAW INDEPENDENT CHUCKS

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-003 STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-003-08-A06	A	15	11-003-15-A11	D
10	10-003-10-A06	A	18	10-003-18-A11	A
12	10-003-12-A06	B	21	11-003-21-A11	D
15	11-003-15-A06	D	24	10-003-24-A11	A
12	10-003-12-A08	A	28	11-003-28-A11	D
15	10-003-15-A08	A	32	10-003-32-A11	B

SERIES 10-004 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
10	10-004-10-A06	B	18	10-004-18-A11	B
12	10-004-12-A06	B	24	10-004-24-A11	B
12	10-004-12-A08	B	32	10-004-32-A11	B
15	10-004-15-A08	B			

TYPE D AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-003 STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-003-06-D03	A	21	10-003-21-D08	A
8	10-003-08-D03	A	24	10-003-24-D08	A
6	11-003-06-D04	D	28	11-003-28-D08	D
8	10-003-08-D06	A	32	10-003-32-D08	B
10	10-003-10-D06	A	36	11-003-36-D08	D
12	10-003-12-D06	A	18	10-003-18-D11	A
15	10-003-15-D06	A	21	11-003-21-D11	D
18	10-003-18-D06	A	24	10-003-24-D11	A
12	10-003-12-D08	A	28	10-003-28-D11	A
15	10-003-15-D08	A	32	10-003-32-D11	B
18	10-003-18-D08	A	36	10-003-36-D11	B

Continued on Next Page.

MANUALLY OPERATED WORKHOLDING EQUIPMENT

Continued from Preceding Page.

4-JAW INDEPENDENT CHUCKS (continued)

TYPE D AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-004 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
10	10-004-10-D06	B	32	10-004-32-D08	B
12	10-004-12-D06	B	36	11-004-36-D08	D
15	10-004-15-D06	B	18	10-004-18-D11	B
18	10-004-18-D06	B	21	11-004-21-D11	D
12	10-004-12-D08	B	24	10-004-24-D11	B
15	10-004-15-D08	B	28	10-004-28-D11	B
18	10-004-18-D08	B	32	10-004-32-D11	B
21	10-004-21-D08	B	36	10-004-36-D11	B
24	10-004-24-D08	B			

TYPE L AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-001 SEMI-STEEL BODIES SOLID REVERSIBLE JAWS.

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-001-08-L00	A	10	10-001-10-L0	A
10	10-001-10-L00	A	12	10-001-12-L0	A
8	10-001-08-L0	A	15	10-001-15-L0	A

SERIES 10-003 STEEL BODIES SOLID REVERSIBLE JAWS

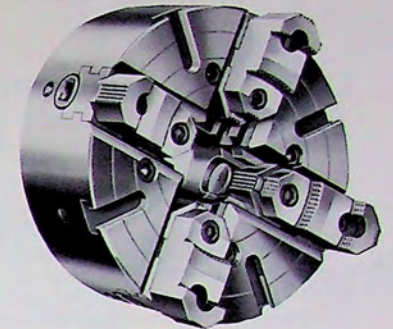
SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
10	10-003-10-L01	A	24	10-003-24-L02	A
12	10-003-12-L01	A	18	11-003-18-L03	D
15	10-003-15-L01	A	21	11-003-21-L03	D
18	10-003-18-L01	A	24	10-003-24-L03	A
12	11-003-12-L02	D	28	10-003-28-L03	A
15	10-003-15-L02	A	32	10-003-32-L03	B
18	10-003-18-L02	A	36	10-003-36-L03	B
21	10-003-21-L02	A			

SERIES 10-004 STEEL BODIES TWO-PIECE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
10	10-004-10-L01	B	21	10-004-21-L02	B
12	10-004-12-L01	B	24	10-004-24-L02	B
15	10-004-15-L01	B	24	10-004-24-L03	B
18	10-004-18-L01	B	28	10-004-28-L03	B
15	10-004-15-L02	B	32	10-004-32-L03	B
18	10-004-18-L02	B	36	10-004-36-L03	B

HEAVY DUTY INDEPENDENT CHUCKS

Heavy Duty chucks are recommended for use on turret and automatic lathes, and meet the requirements of heavy duty chucking. Engineered and designed for continuous heavy duty service, these chucks will provide a long, trouble-free life.



TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

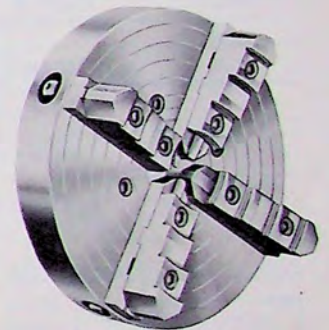
SERIES 20-014 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS*

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
12	20-014-12-A08	A	21	20-014-21-A15	A
15	20-014-15-A11	A	24	20-014-24-A15	A
18	20-014-18-A11	A	28	21-014-28-A15	D
21	21-014-21-A11	D			

*Serrated Master Jaws available on application

DUST-PROOF INDEPENDENT CHUCKS

Designed especially for use on grinding machines or other applications where excessive dust, dirt, and abrasive materials are prevalent. Internal parts are thoroughly protected against entry of dust-type chips produced by metals such as brass, cast iron, etc.



TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)
AND FOR MOUNTING WITH ADAPTER PLATES

SERIES 20-042 SEMI-STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

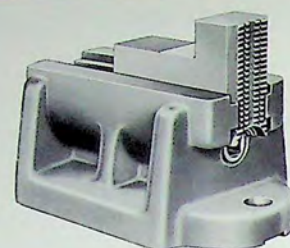
TYPE A AM. STD. MOUNTING			ADAPTER PLATE MOUNTING		
SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	20-042-06-A05	A	4	20-042-04-000	A
8	20-042-08-A06	A	6	20-042-06-000	A
			8	20-042-08-000	A

MANUALLY OPERATED WORKHOLDING EQUIPMENT

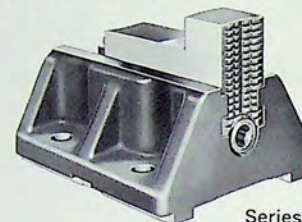
FACE PLATE and BORING MILL JAWS

FOR MOUNTING ON LARGE FACE PLATES and BORING MILL TABLES, SERIES 10-061 and 10-063 are furnished with locating key 1" wide extending lengthwise of body. SERIES 10-073 has two locating keys 1" wide, 6" centers, integral with the body. Body width, and heavy supporting ribs, provide necessary rigidity and strength in the side walls. Cross sections are heavy, with no cored pockets below the screw. Operating screws are of heat-treated Chrome Nickel Steel and the thrust bearings are of the patented two-piece type. Each set of jaws is furnished with necessary bolts and wrenches.

See Dimension Bulletin for T-bolt specifications.



Series 10-061, 10-063



Series 10-073

FACE PLATE JAWS—FOR TABLES with SINGLE RADIAL SLOTS

SERIES 10-061
SERIES 10-063

SET OF 4 WITH SOLID REVERSIBLE JAWS

SEMI-STEEL BODIES			STEEL BODIES		
SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
4	10-061-04-000	A	8	10-063-08-000	A
6	10-061-06-000	A	10	10-063-10-000	A
8	10-061-08-000	A	12	10-063-12-000	A

BORING MILL JAWS—FOR TABLES with DOUBLE PARALLEL SLOTS

SERIES 10-073

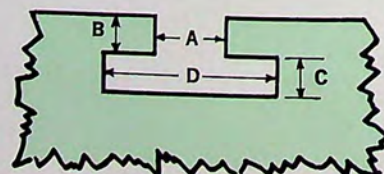
SET of 4 WITH SOLID REVERSIBLE JAWS STEEL BODIES

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-073-08-000	A	12	10-073-12-000	A
10	10-073-10-000	A	14	10-073-14-000	A

CORRECT T-BOLTS CAN ONLY BE FURNISHED WHEN THIS INFORMATION IS SUPPLIED WITH YOUR ORDER

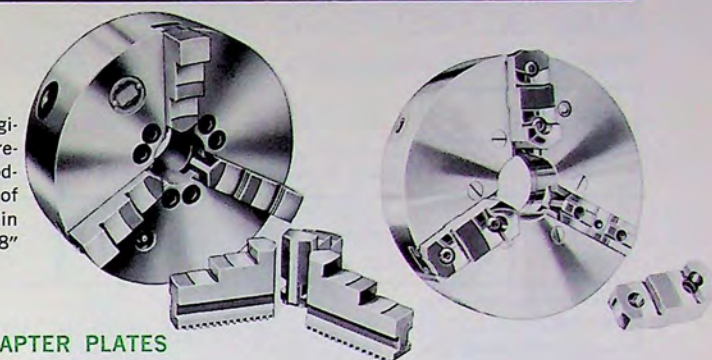
Due to the varying construction of face plates and boring mill tables, we can furnish the proper mounting bolts only when the following information is supplied with your order:

1. Referring to the T-slot drawing shown at the right, specify dimensions A, B, C and D.
2. When ordering Nos. 10-061 and 10-063 Jaws, specify width of key.
3. When ordering No. 10-073 Jaws, specify distance between keys and specify dimension of keys.



3-JAW SELF-CENTERING CHUCKS

Geared Scroll Self-Centering Chucks are designed and engineered with the necessary precision to meet the requirements demanded by the high-performance standards of modern machine tools. All working parts of these chucks are of carefully heat-treated steels, and are tested to center within a maximum of .003" total-indicator reading. Chuck sizes 18" to 24" have T-slots.



STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-103

STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
3	10-103-03-000	A	6	10-103-06-000	A
4	10-103-04-000	A	8	10-103-08-000	B
5	10-103-05-000	A	10	10-103-10-000	B

SERIES 10-104

STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-104-06-000	A	15	10-104-15-000	A
8	10-104-08-000	A	18	10-104-18-000	A
10	10-104-10-000	A	21	10-104-21-000	A
12	10-104-12-000	A	24	10-104-24-000	A

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-104

STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	11-104-06-A06	D	12	10-104-12-A08	A
8	10-104-08-A06	A	15	10-104-15-A08	A
10	10-104-10-A06	A	18	10-104-18-A08	A
12	10-104-12-A06	A	15	10-104-15-A11	A
10	10-104-10-A08	A	18	10-104-18-A11	A

TYPE D AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-103

STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-103-06-D03	A	8	11-103-08-D06	D
8	10-103-08-D03	A	10	11-103-10-D06	D

SERIES 10-104

STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-104-06-D03 *	A	12	10-104-12-D08	A
8	10-104-08-D03	A	15	10-104-15-D08	A
6	10-104-06-D04	A	18	10-104-18-D08	A
6	11-104-06-D06	D	21	10-104-21-D08	A
8	10-104-08-D06	A	24	10-104-24-D08	A
10	10-104-10-D06	A	15	10-104-15-D11	A
12	10-104-12-D06	A	18	10-104-18-D11	A
15	10-104-15-D06	A	21	10-104-21-D11	A
10	10-104-10-D08	A	24	10-104-24-D11	A

*Not American Standard Tongue & Groove Jaws.

Continued on Next Page.

MANUALLY OPERATED WORKHOLDING EQUIPMENT

3-JAW SELF-CENTERING CHUCKS (continued)

TYPE L AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-101 SEMI STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-101-06-L00	B	6	10-101-06-L0	B
8	10-101-08-L00	B	8	10-101-08-L0	B
10	11-101-10-L00	D	10	11-101-10-L0	D

SERIES 10-102 SEMI-STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-102-06-L00	A	8	10-102-08-L0	A
8	10-102-08-L00	A	10	10-102-10-L0	A
10	10-102-10-L00	A	12	10-102-12-L0	A
6	10-102-06-L0	A			

SERIES 10-103 STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-103-08-L01	B	10	10-103-10-L01	B

SERIES 10-104 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-104-08-L01	A	18	10-104-18-L02	A
10	10-104-10-L01	A	15	11-104-15-L03	D
12	10-104-12-L01	A	18	10-104-18-L03	A
15	10-104-15-L01	A	21	10-104-21-L03	A
12	10-104-12-L02	A	24	10-104-24-L03	A
15	10-104-15-L02	A			

EXTRA THIN BODY SERIES

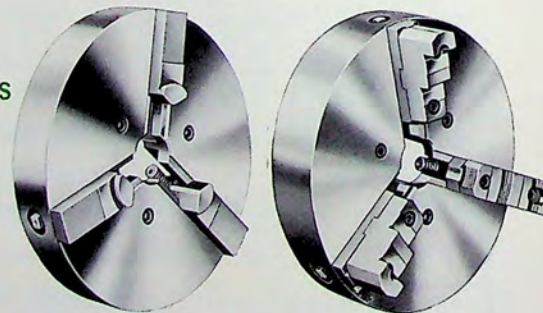
STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 20-221 SEMI-STEEL BODIES ONE SET (3) SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS
6	20-221-06-000	A
8	20-221-08-000	A

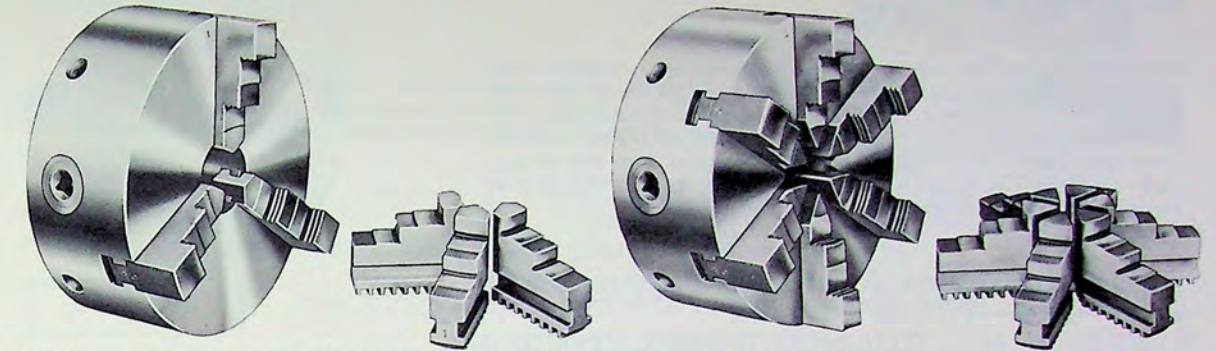
SERIES 20-222 SEMI-STEEL BODIES TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
4	20-222-04-000	A	9	20-222-09-000	A
5	20-222-05-000	A	12	20-222-12-000	A
6	20-222-06-000	A	15	20-222-15-000	A
8	20-222-08-000	A			



3 or 6 JAW SELF-CENTERING CHUCKS

ACCRA-SET ADJUSTABLE TYPE



This type of manually scroll operated chuck provides extreme accuracy and will repeat within .0005" or better t.i.r. Ideal for precision bar work and, with a quick, simple, mi-

nute adjustment, one Accra-Set Chuck will replace the most accurate collet chuck and its range of collets.

STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-161 3-JAW CHUCKS SEMI-STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-161-06-000	A	10	10-161-10-000	A
8	10-161-08-000	A			

SERIES 10-162 3-JAW CHUCKS SEMI-STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-162-06-000	A	10	10-162-10-000	A
8	10-162-08-000	A			

SERIES 10-171 6-JAW CHUCKS SEMI-STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-171-06-000	A	10	10-171-10-000	A
8	10-171-08-000	A			

SERIES 10-172 6-JAW CHUCKS SEMI-STEEL BODIES TWO-PIECE TONGUE & GROOVE JAWS

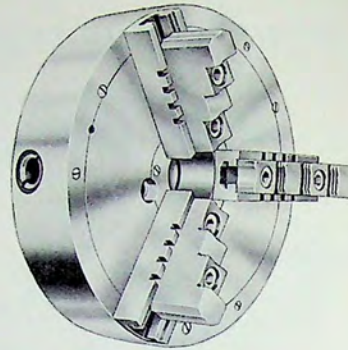
SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-172-06-000	A	10	10-172-10-000	A
8	10-172-08-000	A			

MANUALLY OPERATED WORKHOLDING EQUIPMENT

3-JAW SELF-CENTERING CHUCKS

DUST-PROOF SERIES

Recommended type for use on grinding machines, and wherever excess dust and grit are present. Completely enclosed and protected, Dust-Tight Chucks conform to general specifications and precision standards of all Self-Centering Geared Scroll Chucks. Chuck body, containing operating movement, is suitably gasketed to prevent entrance of dust, and abrasive particles. Hence Dust-Tight Chucks are recommended for use where abrasive particles, dust, etc. would cause wear on internal parts.



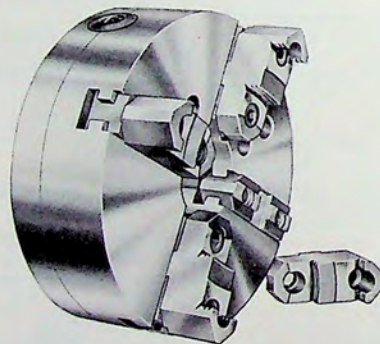
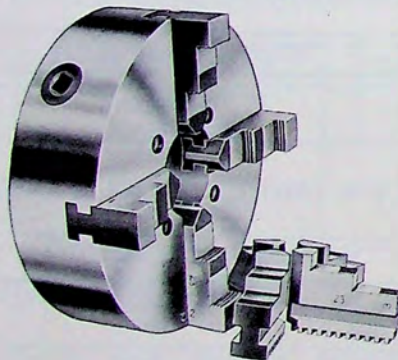
STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-144 STEEL BODIES TWO-PIECE SERRATED JAWS

SIZE*	REFERENCE NUMBER	CLASS	SIZE*	REFERENCE NUMBER	CLASS
12	10-144-12-000	A	14	10-144-14-000	A

* Other sizes on application

4-JAW SELF-CENTERING CHUCKS



STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-153 STEEL BODIES TWO SETS SOLID JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
6	10-153-06-000	A			

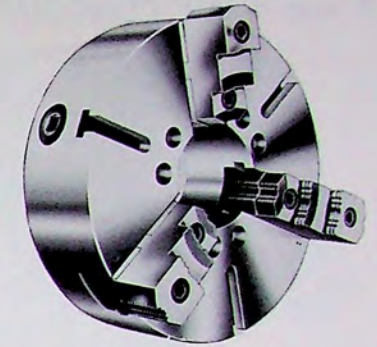
SERIES 10-154 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-154-08-000	A	12	10-154-12-000	A
10	10-154-10-000	A	15	10-154-15-000	A

3-JAW SELF-CENTERING CHUCKS

HEAVY DUTY SERIES

Heavy-Duty Self-Centering Chucks are recommended for use on turret and automatic lathes and meet the requirements of heavy duty chucking. Engineered and designed for heavy duty service, they will provide a long, trouble-free life.



TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-114 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS*

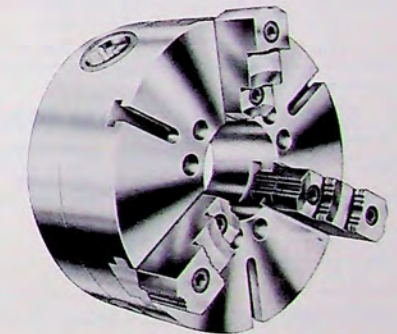
SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-114-08-A06	A	15	10-114-15-A11	A
10	10-114-10-A06	A	18	10-114-18-A11	A
10	10-114-10-A08	A	21	11-114-21-A15	D
12	10-114-12-A08	A	24	11-114-24-A15	D
15	10-114-15-A08	A			

* Serrated Master Jaws available on application

3-JAW SELF-CENTERING CHUCKS

HEAVY DUTY SERIES FOR USE WITH POWER WRENCHES

Designed and built to provide dependable production line service with Power Wrenches. Specialized heavy duty construction of lug type pinions and scrolls withstands shock, thrust and torque loads under continuous operation.



FOR DATA ON POWER WRENCHES, REQUEST BULLETIN

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

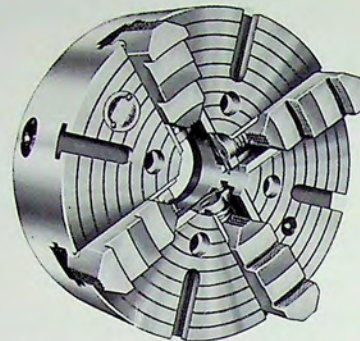
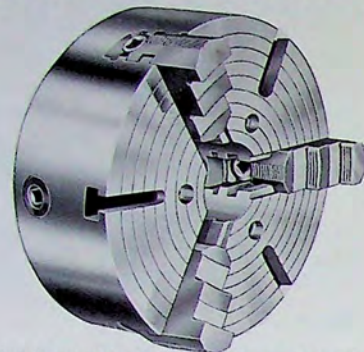
SERIES 10-124 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS*

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
12	10-124-12-A08	A	18	11-124-18-A11	D
15	11-124-15-A08	D	21	10-124-21-A15	A
15	10-124-15-A11	A	24	11-124-24-A15	D

* Serrated Master Jaws available on application

MANUALLY OPERATED WORKHOLDING EQUIPMENT

3 and 4-JAW COMBINATION CHUCKS



Combination Chucks combine in one body the advantages of both independent and self-centering chucks without sacrifice of ruggedness. Centering accuracy will easily be maintained within .005" total indicator reading. The patented mechanical jaw register assures accurate "indexing" of the jaw screw at each revolution with a feelable "click" as a guide to the op-

erator. Once set, no further jaw adjustment is required and the chuck accuracy will be held indefinitely within .005" for self-centering operation. All bodies are of steel and all parts are of heat-treated alloy steels. Chucks 12" through 18" sizes have T-slots.

THREE-JAW CHUCKS STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-183 STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-183-08-000	D	15	10-183-15-000	A
10	10-183-10-000	A	18	10-183-18-000	A
12	10-183-12-000	A			

SERIES 10-184 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-184-08-000	D	15	10-184-15-000	A
10	10-184-10-000	A	18	10-184-18-000	A
12	10-184-12-000	A			

FOUR-JAW CHUCKS STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

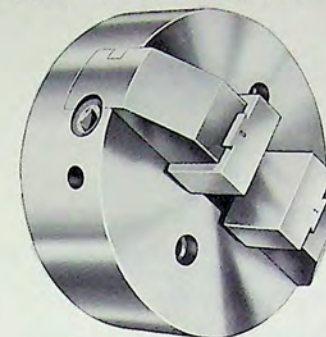
SERIES 10-193 STEEL BODIES SOLID REVERSIBLE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-193-08-000	D	15	10-193-15-000	A
10	10-193-10-000	A	18	10-193-18-000	A
12	10-193-12-000	A			

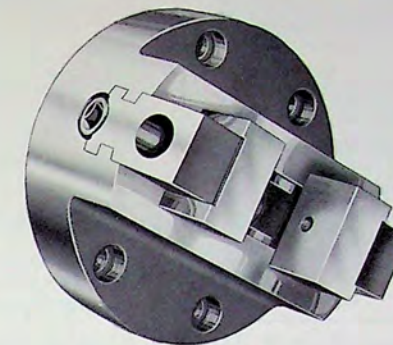
SERIES 10-194 STEEL BODIES AM. STD. TWO-PIECE TONGUE & GROOVE JAWS

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-194-08-000	D	15	10-194-15-000	A
10	10-194-10-000	A	18	10-194-18-000	A
12	10-194-12-000	A			

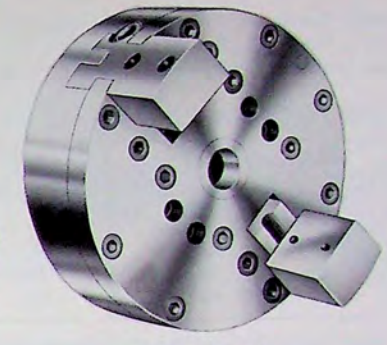
TWO JAW CHUCKS



Series 10-202 & 10-201



Series 10-203



Series 10-204

Two-Jaw Self-Centering Chucks, recommended for turret and automatic lathes, are designed and built to provide a combination of ruggedness and accuracy. All chucks are furnished with slip jaws and feature patented thrust bearings.

Chuck bodies are of semi-steel, except the 4" size which is steel and the heavy duty series which have hardened steel bodies.

STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES

SERIES 10-202 and 10-201 SEMI-STEEL BODIES (except 4")

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
4	10-202-04-000	A	9	10-201-09-000	A
6	10-201-06-000	A	12	10-201-12-000	A

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-203 SEMI-STEEL BODIES

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	10-203-08-A06	A	10	10-203-10-A08	A
10	10-203-10-A06	A	12	10-203-12-A08	A
12	10-203-12-A06	A	15	11-203-15-A08	D

TYPE D AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-203 SEMI-STEEL BODIES

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-203-08-D06	D	12	10-203-12-D06	A
10	11-203-10-D06	D			

HEAVY DUTY FOR TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

SERIES 10-204 HARDENED STEEL BODIES

SIZE	REFERENCE NUMBER	CLASS	SIZE	REFERENCE NUMBER	CLASS
8	11-204-08-A06	D	12	10-204-12-A08	A
10	11-204-10-A06	D	15	11-204-15-A08	D
12	11-204-12-A06	D	12	11-204-12-A11	D
10	11-204-10-A08	D	15	10-204-15-A11	A

MANUALLY OPERATED WORKHOLDING EQUIPMENT

ADAPTER PLATES—FINISHED, SEMI-FINISHED and ROUGH CASTINGS

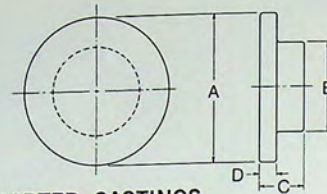
Listed below are finished and semi-finished adapters for fitting Straight Recess Manual and Power Chucks to Am. Std. spindles. Semi-finished adapters are finished spindle side only.

FOR TYPES A & D AM. STD. SPINDLES

CHUCK SIZE	SPINDLE	CHUCK SIZE	SPINDLE
6-8	D3	12	A8 -D8
8	A6 -D6	15	A6 -D6
10	A6 -D6	15	A8 -D8
10	A8 -D8	18	A11-D11
12	A6 -D6		

FOR TYPE L AM. STD. SPINDLES

CHUCK SIZE	SPINDLE	CHUCK SIZE	SPINDLE
6-8	L00	12	L0
8	L0	12	L1
8	L1	12	L2
10	L0	15	L1
10	L1	15	L2
10	L2		



ROUGH ADAPTER CASTINGS

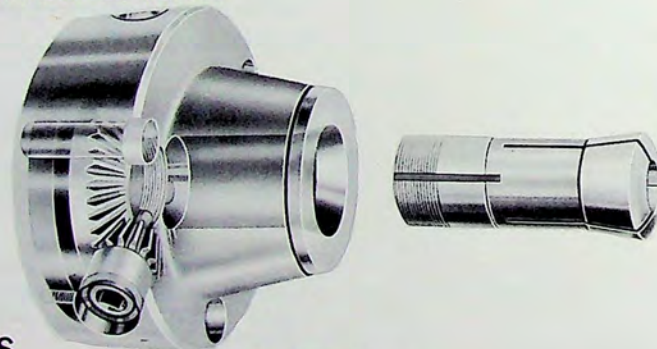
For adapting straight recess chucks to threaded spindles. All surfaces and thread to be machined by customer.

CASTING NO.	A	B	C	D	CASTING NO.	A	B	C	D
03-2640-1	3 3/4	2 1/4	1 3/4	3/4	03-2640-10	7 1/4	4 1/4	3 3/4	1 1/4
					03-2640-11	8 1/4	4 1/4	3 3/4	1 1/4
03-2640-3	4 3/4	3 3/4	2 1/4	1	03-2640-12	9 3/4	5	3 3/4	1 1/2
03-2640-4	5	3 3/4	2 3/4	1 1/4	03-2640-13	11 1/4	6	4 1/4	1 3/4
					03-2640-14	13 1/4	6 1/4	4 3/4	2
03-2640-6	5 1/4	3	1 3/4	3/4	03-2640-15	15 1/4	7	4 3/4	2
03-2640-7	5 3/4	3 1/2	2 3/4	1 1/4	03-2640-16	18	8 1/4	4 3/4	2
03-2640-8	6 3/4	3 3/4	2 3/4	1	03-2640-17	8 1/2	3 1/4	2 3/4	1 1/4
03-2640-9	6 3/4	4	3 3/4	1 1/4					

Note: Dimensions are as cast. Allow a min. of 1/8" per surface for machining.

COLLET CHUCKS and SPRING COLLETS

STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES



SERIES 10-913

COLLET CHUCKS

Hardened Steel Bodies Less Spring Collets

SIZE	REFERENCE NUMBER	ROUND HOLDING CAPACITY, INCHES
01	10-913-01-000	1/8-1 1/8
02	10-913-02-000	1/4-1 1/4
03	10-913-03-000	1-3 1/4

SPRING COLLETS ONLY

Maximum Capacity, Inches**

SIZE	ROUND	SQUARE	HEXAGONAL
01	1 1/8	3/4	1 3/8
02	1 1/4	1 1/8	1 1/2
03	3 1/4	2 1/4	2 13/16

**Other sizes on application

ADAPTERS FOR SERIES 10-913 COLLET CHUCKS

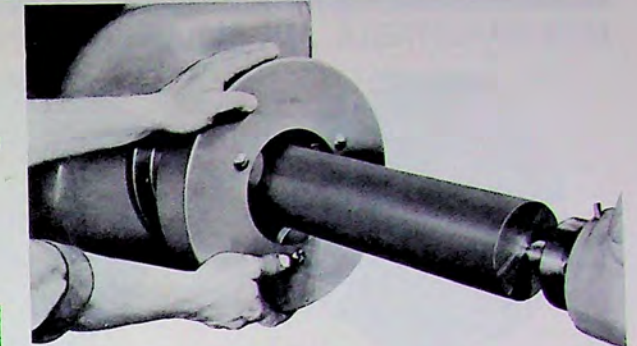
CHUCK SIZE	MOUNTING
01-02	A6, A8
03	A8

CHUCK SIZE	MOUNTING
01-02	D3, D5, D6, D8
03	D8

CHUCK SIZE	MOUNTING
01-02	L00, L0
01-02	L1, L2, L3
03	L2, L3

+GF+ WORK DRIVERS

Best device for turning work between centers. Easy hand rotation of hood provides fast gripping or release.



SERIES 60, 90, 140, and 200 WORK DRIVERS

STRAIGHT RECESS—FOR MOUNTING WITH ADAPTER PLATES Work Driver Adapters Listed Below

WORK DRIVERS WITHOUT JAWS OR ADAPTER PLATE	Driver Number	Capacity
	60	1 1/2-2 3/4
	90	3 1/4-3 1/2
	140	4 3/4-5 1/2
	200	4 3/4-8 1/8

JAWS

Set of 3 No. 60 Jaws only	Capacity	Set of 3 No. 90 Jaws only	Capacity
7721-4012	1 1/8-2 3/4	7820-4832	2 3/4-3 1/2
7721-4191	1 1/8-2 1/8	7723-3121	2 3/8-3 1/4
7721-4181	1 1/2-1 3/4	7723-3041	1 1/4-2 3/4
7721-4171	3/4-1 1/2	7723-3101	1 1/8-2 3/4
7721-4161	1 1/2-1 3/8	7723-3081	3 1/4-1 7/8
Set of 3 No. 140 Jaws	Capacity	Set of 3* No. 200 Jaws	Capacity
7820-4832	4 3/4-5 1/2	Note: Six Jaws Required*	
7723-3121	4 1/2-5 1/4		
7723-3041	3 3/4-4 3/4		
7723-3101	3 1/8-4 1/4		
7723-3081	2 1/8-3 3/4		
7723-3061	1 3/4-3 3/4		
7820-4802	4 3/4-2 1/4	7724-4081	(7 1/2-8 1/8
		7724-4012	(7 1/2-8 3/8
		7724-3061	(6 1/2-7 1/8
		7724-3012	(6 1/2-7 1/8
		7724-3051	(4 3/4-6 1/2
		7724-3002	(4 3/4-6 1/2

FINISHED ADAPTER PLATES

Spindle Size & Type	No. 60 Specify Number	No. 90 Specify Number	No. 140 Specify Number	No. 200 Specify Number
A-5	60-A5	90-A5		
A-6	60-A6	90-A6	140-A6	
A-8		90-A8	140-A8	200-A8
A-11			140-A11	200-A11
D-3	60-D3			
D-4	60-D4			
D-5	60-D5	90-D5		
D-6	60-D6	90-D6	140-D6	
D-8		90-D8	140-D8	200-D8
D-11			140-D11	200-D11
L-00	60-L00			
L-0	60-L0	90-L0		200-L1
L-1	60-L1	90-L1	140-L1	200-L2
L-2		90-L2	140-L3	200-L3
L-3				
Rough Casting	03-2640-8	03-2640-12	03-2640-13	03-2640-15

*Six jaws required—3 driving and 3 braking.

POWER OPERATED WORKHOLDING EQUIPMENT

All power Chucks are carefully designed and built to provide accurate repetitive workholding. Bodies are of steel with all moving sur-

faces precision ground and all wearing surfaces flame hardened and ground. Internal parts are protected by dust plates carefully fit-

ted to the chuck face thereby preventing the entry of chips and dirt. Reliability combined with heavy duty type performance enables

these chucks to be used for most types of workholding over a long, rugged, trouble-free service life. Note: Chucks listed

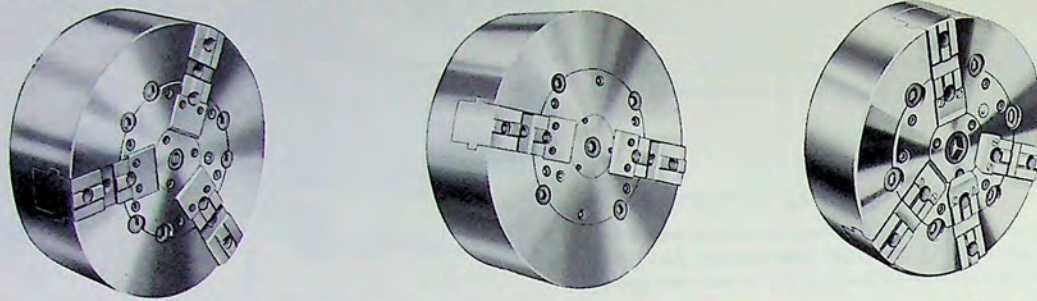
do not include top jaws. All chucks in sizes 12" and larger are furnished with T-slots. To order chucks with Draw Tubes, change the

reference number as shown above each listing. (Example: to order chuck number 20-620-12-A06 with draw tube, change reference

number to 20-623-12-A06. See price list for additional amount required.) Most of the chucks listed in this catalog are for direct

mounting on Type A American Standard Spindles. Other chuck sizes and spindle seats are available on request.

NON-ADJUSTABLE JAW SELF-CENTERING POWER CHUCKS



Recommended for general manufacturing service where adjustability of individual jaws is not required. Particularly suited for repetitive operations, especially heavy workpieces. When fitted with soft blank jaws machined to desired shapes,

provides a simple and economical method of workholding, eliminating costly special devices. Balanced to eliminate vibration and chatter at high r.p.m.

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS

SERIES 20-620 3-JAW CHUCKS (For Draw Tube type change Number to 20-623)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
6	20-620-06-A05	10	20-620-10-A08	18	20-620-18-A11
6	20-620-06-A06	12	20-620-12-A06	21	20-620-21-A11
8	20-620-08-A06	12	20-620-12-A08	21	20-620-21-A15
8	20-620-08-A08	15	20-620-15-A08	24	20-620-24-A15
10	20-620-10-A06	15	20-620-15-A11		

SERIES 20-621 2-JAW CHUCKS (For Draw Tube type change Number to 20-624)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
6	20-621-06-A05	10	20-621-10-A08	18	20-621-18-A11
6	20-621-06-A06	12	20-621-12-A06	21	20-621-21-A11
8	20-621-08-A06	12	20-621-12-A08	21	20-621-21-A15
8	20-621-08-A08	15	20-621-15-A08	24	20-621-24-A15
10	20-621-10-A06	15	20-621-15-A11		

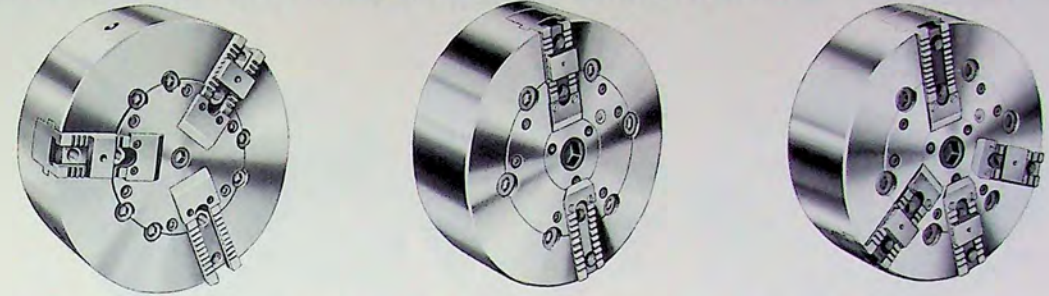
SERIES 20-622 2 & 3-JAW CHUCKS (For Draw Tube type change Number to 20-625)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	20-622-08-A06	12	20-622-12-A08	21	20-622-21-A11
8	20-622-08-A08	15	20-622-15-A08*	21	20-622-21-A15
10	20-622-10-A06	15	20-622-15-A11	24	20-622-24-A15
10	20-622-10-A08	18	20-622-18-A11		

*Adapter for mounting included

†See statement at top of page

SERRATED JAW SELF-CENTERING POWER CHUCKS



Self-centering power chucks with Am. Std. Serrated Master Jaws. Chucks with serrated master jaws are especially recommended for production and chucking operations where it is necessary to provide a wide range of jaw capacity and is

achieved by "stepping" the top jaw along the master jaw. One set of master jaw keys are furnished with each chuck; top jaws are not included. Balanced to eliminate vibration and chatter at high r.p.m.

TYPE A AMERICAN STANDARD SPINDLES (SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD SERRATED MASTER JAWS*

SERIES 20-670 3-JAW CHUCKS (For Draw Tube type change Number to 20-673)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
10	20-670-10-A06	15	20-670-15-A08	21	20-670-21-A11
10	20-670-10-A08	15	20-670-15-A11	21	20-670-21-A15
12	20-670-12-A06	18	20-670-18-A11	24	20-670-24-A15
12	20-670-12-A08				

SERIES 20-671 2-JAW CHUCKS (For Draw Tube type change Number to 20-674)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
10	20-671-10-A06	15	20-671-15-A08	21	20-671-21-A11
10	20-671-10-A08	15	20-671-15-A11	21	20-671-21-A15
12	20-671-12-A06	18	20-671-18-A11	24	20-671-24-A15
12	20-671-12-A08				

SERIES 20-672 2 & 3-JAW CHUCKS (For Draw Tube type change Number to 20-675)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
10	20-672-10-A06	15	20-672-15-A11	21	20-672-21-A11
10	20-672-10-A08	18	20-672-18-A11	21	20-672-21-A15
12	20-672-12-A08			24	20-672-24-A15
15	20-672-15-A08**				

*Accralock Angular Serrated Master Jaws can be furnished at slight extra cost.

**Adapter for mounting included

†See statement at top of page

POWER OPERATED WORKHOLDING EQUIPMENT

All power Chucks are carefully designed and built to provide accurate repetitive workholding. Bodies are of steel with all moving sur-

faces precision ground and all wearing surfaces flame hardened and ground. Internal parts are protected by dust plates carefully fit-

ted to the chuck face thereby preventing the entry of chips and dirt. Reliability combined with heavy duty type performance enables

these chucks to be used for most types of workholding over a long, rugged, trouble-free service life. Note: Chucks listed below

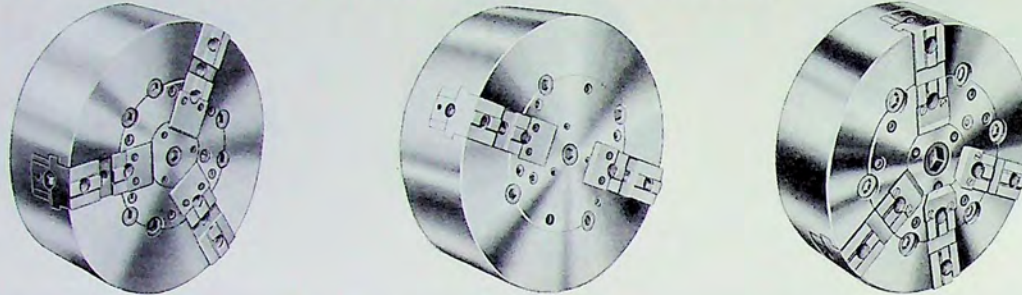
do not include top jaws. All chucks in sizes 12" and larger are furnished with T-slots. To order chucks with Draw Tubes, change the

reference number as shown above each listing. (Example: to order chuck number 20-620-12-A06 with draw tube, change reference

number to 20-623-12-A06. See price list for additional amount required.) Most of the chucks listed in this catalog are for direct

mounting on Type A American Standard Spindles. Other chuck sizes and spindle seats are available on request.

ADJUSTABLE JAW SELF-CENTERING POWER CHUCKS



Self-centering power chucks with Am. Std. Master Jaws providing independent jaw action are simple and quick to adjust. This series of chucks is designed for accurate, expedi-

tious holding of irregularly shaped workpieces. Initial accuracy maintained on repetitive chucking operations.

AMERICAN STANDARD TYPE A SPINDLES—(SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS

SERIES 20-640 3-JAW CHUCKS (For Draw Tube type change Number to 20-643)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	20-640-08-A06	12	20-640-12-A08	21	20-640-21-A11
8	20-640-08-A08	15	20-640-15-A08	21	20-640-21-A15
10	20-640-10-A06	15	20-640-15-A11	24	20-640-24-A11
10	20-640-10-A08	18	20-640-18-A11	24	20-640-24-A15
12	20-640-12-A06				

SERIES 20-641 2-JAW CHUCKS (For Draw Tube type change Number to 20-644)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	20-641-08-A06	12	20-641-12-A08	21	20-641-21-A11
8	20-641-08-A08	15	20-641-15-A08	21	20-641-21-A15
10	20-641-10-A06	15	20-641-15-A11	24	20-641-24-A11
10	20-641-10-A08	18	20-641-18-A11		
12	20-641-12-A06				

SERIES 20-642 2 & 3-JAW CHUCKS (For Draw Tube type change Number to 20-645)†

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	20-642-08-A06	15	20-642-15-A08*	21	20-642-21-A11
8	20-642-08-A08	15	20-642-15-A11	21	20-642-21-A15
10	20-642-10-A06	18	20-642-18-A11	24	20-642-24-A11
10	20-642-10-A08			24	20-642-24-A15
12	20-642-12-A08				

*Adapter for mounting included †See statement at top of page.

COMPENSATING JAW POWER CHUCKS



With floating Am. Std. Tongue & Groove Master Jaws Compensating Chucks offer the user two distinct and important chucking advantages in one chuck body. One, it offers far greater compensating action than ever before possible, thus enabling accurate chucking of odd shaped workparts located

between lathe centers; and two, this workholding device can be used as an ordinary self-centering power-operated chuck after compensating action has been "locked-out" and the chuck trued on the spindle. Compensation on standard chucks is 1/8" per jaw or 1/4" total indicator reading.

AMERICAN STANDARD TYPE A SPINDLES—(SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS

SERIES 10-560 3 Floating Non-Adjustable Jaws*

SERIES 10-561 2 Floating Non-Adjustable Jaws*

For recommended cylinder size, consult factory.

SERIES 10-560 3-JAW CHUCKS

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	10-560-08-A06	10	10-560-10-A08	15	10-560-15-A08
10	10-560-10-A06	12	10-560-12-A08	15	10-560-15-A11

*Note: This series not available with T-slots or Draw Tubes

SERIES 10-561 2-JAW CHUCKS

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	10-561-08-A06	10	10-561-10-A08	15	10-561-15-A08
10	10-561-10-A06	12	10-561-12-A08	15	10-561-15-A11

*Note: This series not available with T-slots or Draw Tubes

POWER OPERATED WORKHOLDING EQUIPMENT

All power Chucks are carefully designed and built to provide accurate repetitive workholding. Bodies are of steel with all moving sur-

faces precision ground and all wearing surfaces flame hardened and ground. Internal parts are protected by dust plates carefully fit-

ted to the chuck face thereby preventing the entry of chips and dirt. Reliability combined with heavy duty type performance enables

these chucks to be used for most types of workholding over a long, rugged, trouble-free service life. Note: Chucks listed below

do not include top jaws. All chucks in sizes 12" and larger are furnished with T-slots. To order chucks with Draw Tubes, change the

reference number as shown above each listing. (Example: to order chuck number 20-620-12-A06 with draw tube, change reference

number to 20-623-12-A06. See price list for additional amount required.) Most of the chucks listed in this catalog are for direct

mounting on Type A American Standard Spindles. Other chuck sizes and spindle seats are available on request.

DRAW DOWN POWER CHUCKS

Self-Centering Draw Down Chucks are particularly suited for precision first and/or second machining operations on single and multi spindle machines. Equipped with Am. Std. Tongue & Groove Master Jaws and for direct mounting on most machine spindles, Draw Down Power Operated Chucks provide positive draw down action combined with simultaneous locating and centering. Among the many important features designed into this chuck are reliable repeatability of .0005" T.I.R. and accuracy of .001" T.I.R. plus the widest range of jaw forces and usable jaw travel.

AMERICAN STANDARD TYPE A SPINDLES—(SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS†

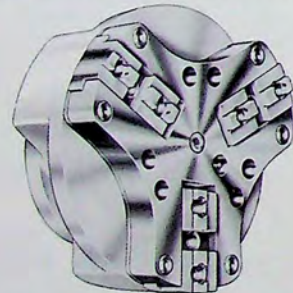
SERIES 10-730 3-JAW SELF-CENTERING

Note: This series not available with T-slots or Draw Tubes

SIZE*	REFERENCE NUMBER	SIZE*	REFERENCE NUMBER	SIZE*	REFERENCE NUMBER
8	10-730-08-A06	12	10-730-12-A08	15	10-730-15-A11
10	10-730-10-A06	15	10-730-15-A08		

*Other sizes and mountings on application †Always furnish chuck size when ordering top jaws.

ALUMINUM BODY POWER CHUCKS



SELF-CENTERING with Am. Std. Tongue and Groove Master Jaws, these chucks effectively reduce weight by almost 50% without sacrificing accuracy or holding power. Jaws are fitted

in hardened steel wear plate. Precision fit and alignment of the hardened plate provides higher standards of accuracy in work alignment and adherence to close tolerances.

AMERICAN STANDARD TYPE A SPINDLES (SPECIFICATIONS ON PAGE 30)

AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS

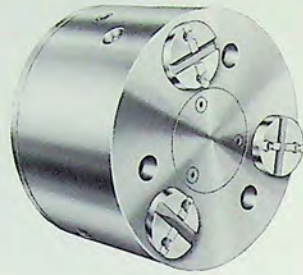
SERIES 10-690 3-JAW SELF-CENTERING*

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	10-690-08-A06	12	10-690-12-A08
10	10-690-10-A06	15	10-690-15-A08

SERIES 10-691 2 JAW SELF-CENTERING*

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
8	10-691-08-A06	12	10-691-12-A08
10	10-691-10-A06		

*Note: This series not available with T-slots or Draw Tubes



TWO-JAW POWER CHUCKS

SELF-CENTERING—Screw Adjustable Jaw Type Two-Jaw Chucks have an extremely wide holding range and are well adapted to a large variety of repetitive operations required in machining non-ferrous metal as well as in the toughest alloy steels where rigidity is essential. Jaws provide an unusually wide range of adjustment and, when fitted with slip jaws formed from soft blanks, odd-shaped pieces can be held for precise finishing.

ADAPTER PLATES REQUIRED FOR MOUNTING*

SERIES 10-596

2-JAW SELF-CENTERING CHUCKS Less Slip Jaws

For recommended cylinder size, consult factory.

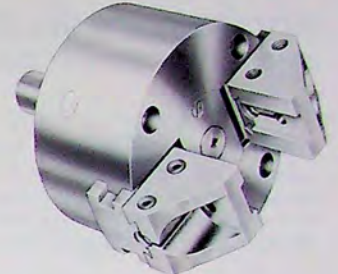
SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
6	10-596-06-000	12	10-596-12-000
8	10-596-08-000	15	10-596-15-000
10	10-596-10-000	18	10-596-18-000

*Available for American Standard Type A and Cam Lock Spindles at extra cost.

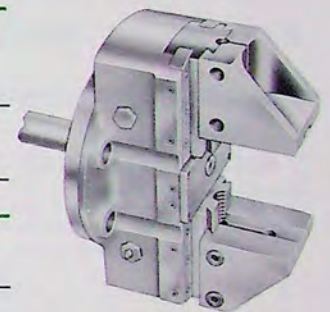
SLIP JAWS FOR SERIES 10-596 CHUCKS*

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
6	15-1987	10	15-1136
8	15-1050	12-18	15-2616

*Special Dovetail available at additional cost.



6" size only



8"—18" Sizes

POWER COLLET CHUCKS

Power Operated Collet Chucks are designed to assure positive, parallel grip on the work. A positive end stop is provided to assure accurate workpart seating thus enabling repetitive machining in relation to the end of the piece held in the collet. Because design is both simple and rugged, high initial accuracy can be maintained over a long service life on typical everyday production line applications.

ADAPTER PLATES REQUIRED FOR MOUNTING

SERIES 10-912

COLLET CHUCKS Less Spring Collets

SIZE	REFERENCE NUMBER	ROUND HOLDING CAPACITY, INCHES*
01	10-912-01-000	1/8—1 1/8
02	10-912-02-000	1/8—1 3/4
03	10-912-03-000	1—3 1/4

SPRING COLLETS ONLY FOR SERIES 10-912

CHUCK SIZE	MAXIMUM CAPACITY, INCHES*		
	ROUND	SQUARE	HEXAGONAL
01	1 1/8	3/4	1 5/16
02	1 3/4	1 1/16	1 1/2
03	3 1/4	2 1/4	2 13/16

*Other sizes on application

ADAPTER PLATES FOR SERIES 10-912

CHUCK SIZE	TYPE A SPINDLE	TYPE D SPINDLE	TYPE L SPINDLE
01	A6, A8	D3, D5, D6, D8	L1, L2, L3
02	A6, A8	D3, D5, D6, D8	L1, L2, L3
03	A8	D6, D8	L2, L3

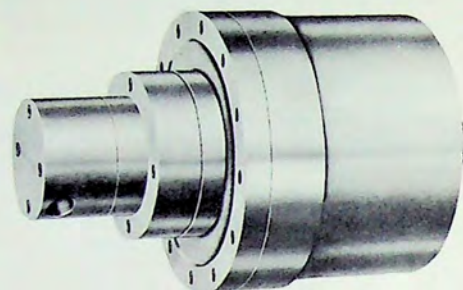


POWER OPERATED WORKHOLDING EQUIPMENT

ROTATING CYLINDERS

ALUMINUM BODY—DOUBLE ACTING

These double-acting, rotating, aluminum body, air and hydraulic operated cylinders are especially designed for power chuck actuation. Trouble-free service is due to precision finishing bores and the patented swivel connection which provides maximum performance, minimum loss of air or hydraulic fluid under the heaviest recommended loads.



SERIES 10-751 AIR CYLINDERS

SERIES 10-760 HYDRAULIC CYLINDERS

CYLINDER ADAPTER REQUIRED FOR MOUNTING

SERIES 10-751 AIR OPERATED CYLINDERS

SIZE	STROKE	REFERENCE NUMBER	SIZE	STROKE	REFERENCE NUMBER
4	1"	10-751-04-000	14	2"	10-751-14-000
6	1 1/2"	10-751-06-000	16	2"	10-751-16-000
8	1 1/2"	10-751-08-000	18	2"	10-751-18-000
10	1 3/4"	10-751-10-000	20	2"	10-751-20-000
12	1 3/4"	10-751-12-000			

SERIES 10-760 HYDRAULIC OPERATED CYLINDERS

SIZE	STROKE	REFERENCE NUMBER	SIZE	STROKE	REFERENCE NUMBER
4	2"	10-760-04-000	8	2"	10-760-08-000
6	2"	10-760-06-000			

ADAPTERS FOR SERIES 10-751 AIR CYLINDERS

ALUMINUM SEMI-FINISHED (finished cylinder end only)*

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
4	14-2004	10-20	14-2006
6-8	14-2005		

ADAPTERS FOR SERIES 10-760 HYDRAULIC CYLINDERS

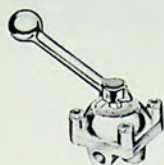
ALUMINUM SEMI-FINISHED (finished cylinder end only)*

SIZE	REFERENCE NUMBER	SIZE	REFERENCE NUMBER
4	14-2005	6-8	04-205463

*Finished both ends on application.

POWER CHUCK ACCESSORY EQUIPMENT

ACCESSORY EQUIPMENT FOR AIR OPERATION



HAND VALVE $\frac{3}{8}$ " ports Ref. No. 05-205621

HAND VALVE $\frac{1}{2}$ " ports Ref. No. 05-205622

FOOT VALVE $\frac{3}{8}$ " ports* Ref. No. 05-205623

*For other size air lines, use bushings.

AIR UNIT CONTROL COMPLETE* Ref. No. 05-205624

*Includes air filter, lubricator, pressure reducing valve and indicator

PRESSURE SAFETY SWITCH Ref. No. 05-205608

The Barksdale-Meletron Model 424 Pressure Switch is recommended as a safety precaution for air powered chucking installations. This device incorporates two snap action switches which function at two different pre-selected air pressures. Installation in the air supply line should be near the machine with the electrical connection so that upon reduction in air pressure a warning signal is actuated, and any further air pressure drop will stop the machine. Available from factory or the manufacturer.

DRAW BARS FOR AIR OPERATED CYLINDERS SERIES 10-751
Standard length 48" Semi-finished (finished on cylinder end only*)

CYLINDER SIZE	REFERENCE NUMBER	CYLINDER SIZE	REFERENCE NUMBER
4-8	25-13689	16-18	25-13691
10-14	25-13690	20	25-13692

*Finished both ends on application

ACCESSORY EQUIPMENT FOR HYDRAULIC OPERATION

HAND VALVE $\frac{3}{8}$ " ports Ref. No. 05-205464

DRAW BARS FOR HYDRAULIC CYLINDERS SERIES 10-760
Standard length 48" Semi-finished (finished on cylinder end only*)

CYLINDER SIZE	REFERENCE NUMBER	CYLINDER SIZE	REFERENCE NUMBER
4-6	25-13690	8	25-13691

*Finished both ends on application.

DRAW TUBES Available on Request

SOFT BLANK TOP JAWS See Page 31.

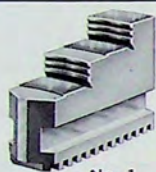
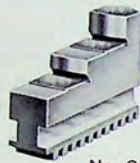
POWER AND MANUAL CHUCK PARTS NOMENCLATURE

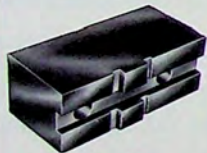
HOW TO ORDER PARTS: The following charts will help you identify the needed part and show the correct part name. **IMPORTANT:** When ordering chuck parts always use the correct name and provide us with the complete number shown on the face of the chuck or cylinder which will include a letter

suffix. (Example: 1 Scroll for chuck #10-003-06-000C) This information is essential to process your order promptly.

If the part required is not illustrated, send us the complete number on the chuck or cylinder and a detailed drawing or the actual part to be replaced.

MANUALLY OPERATED CHUCK PARTS NOMENCLATURE

JAWS	CORRECT PART NAME			
CHUCK TYPE	 Solid Reversible Jaw	 No. 1 Solid Jaw for external gripping	 No. 2 Solid Jaw for internal gripping	 No. 6 Top Jaw for 2-piece jaw
Independent	x			x
Self-Centering		x	x	x
Combination	x			x

JAWS	CORRECT PART NAME			
CHUCK TYPE	 Master Jaw for 2-piece jaws	 No. 7 Soft Blank Top Jaw for 2-piece jaws	 Master Jaw	 Slip Jaw
Independent	x	x		
Self-Centering	x	x		
Combination	x	x		
2-Jaw Chucks			x	x

BODY PARTS	CORRECT PART NAME					
CHUCK TYPE	 Operating Screw	 Thrust Bearing	 Scroll	 Pinion and Pinion Retainer	 Operating Screw Carrier	 Spring latch and ball
Independent	A	x				
Self-Centering			x	x		
Combination	A		x	x	x	x
2-Jaw Chucks	B	x				

*Heavy Duty Chucks Only

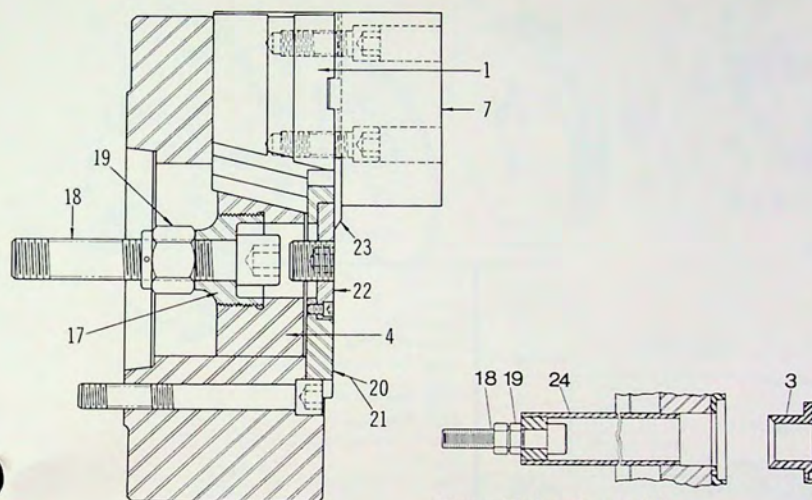
POWER OPERATED CHUCK PARTS NOMENCLATURE

See "How to Order Parts" on page 24

SERIES 20-620, 20-621, 20-622 — Non-Adjustable Type

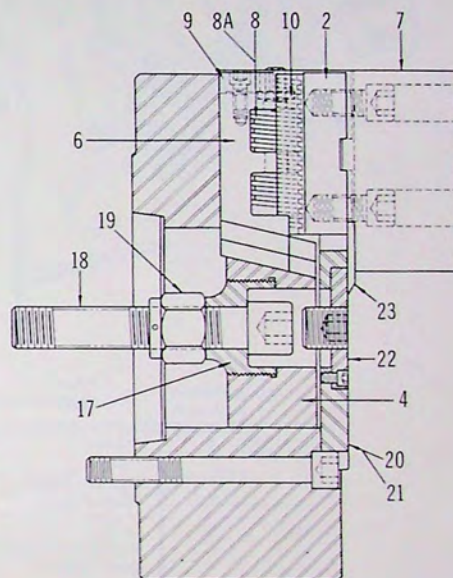
SERIES 20-670, 20-671, 20-672 — Serrated Jaw Type

SERIES 20-640, 20-641, 20-642 — Adjustable Jaw Type



Draw Tube Assembly

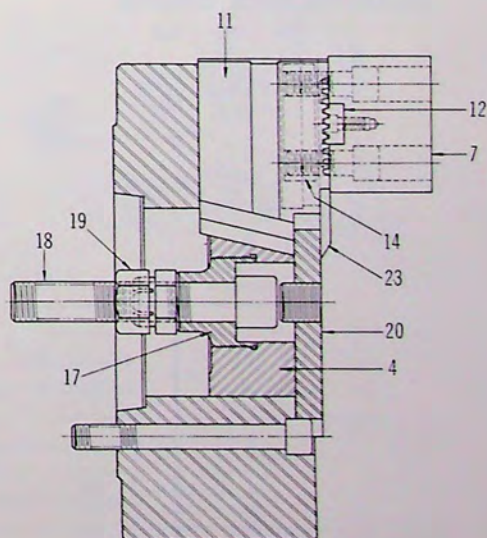
Non-Adjustable Type



Adjustable Jaw Type

PART NUMBER	CHUCK PART NAME
1	Master Jaws For Non-Adjustable Jaw Types
2	Master Jaws For Adjustable Jaw Types
3	Center Hole Bushing
4	Wedge
6	Actuating Jaws For Adjustable Jaw Types
7	Soft Blank Top Jaw
8	Adjust. Screw For Adjustable Jaw Type
9	Screw Locking Plate For Adjustable Jaw Type
10	Screw Locking Washer For Adjustable Jaw Type
11	Master Jaw For Serrated Jaw Type
12	Serrated Jaw Key
14	Jaw Nut
17	Wedge Plug
18*	Draw Rod Stud
19*	Draw Rod Stud Lock Nut
20	Protector Plate (Solid)
21	Protector Plate with Cover Plate Recess
22	Cover Plate
23	Chip Plates
24*	Draw Tube

*Available as an assembly

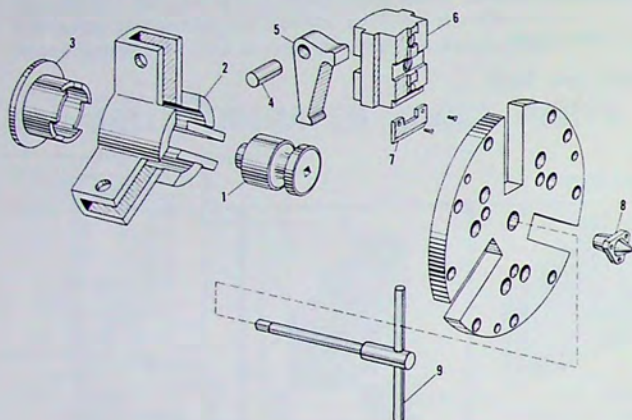


Serrated Jaw Type

POWER OPERATED CHUCK PARTS NOMENCLATURE

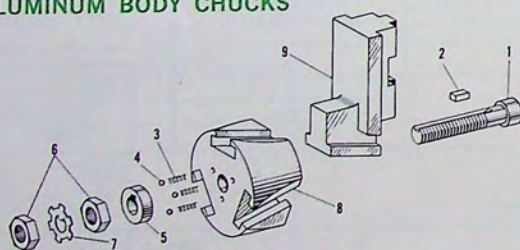
See "How to Order Parts" on page 24

COMPENSATING CHUCK PARTS SERIES 10-560, 10-561



PART NUMBER	PART NAME
1	Plunger
2	Cage
3	Plunger Sleeve
4	Lever Pin
5	Lever Pin Plug
6	Lever Pin Retainer Washer
7	Adjusting Screw
8	Master Jaw (sets of 2)
9	Dust Guard
10	Center
11	Wrench

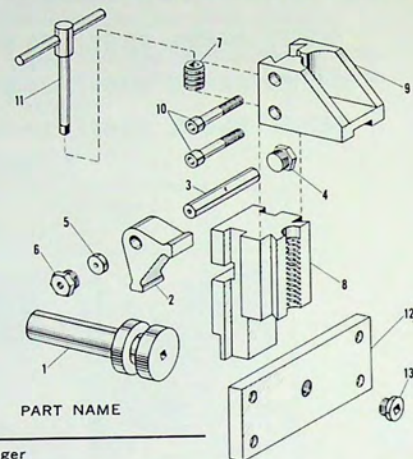
SERIES 10-690, 10-691 ALUMINUM BODY CHUCKS



PART NUMBER	PART NAME
1*	Draw Bolt
2*	Draw Bolt Key
3*	Adjusting Nut Spring
4*	Steel Ball
5*	Adjusting Lock Washer
6*	Jam Nut
7*	Lug Type Lock Washer
8	Wedge
9	Master Jaw (sets of 3)

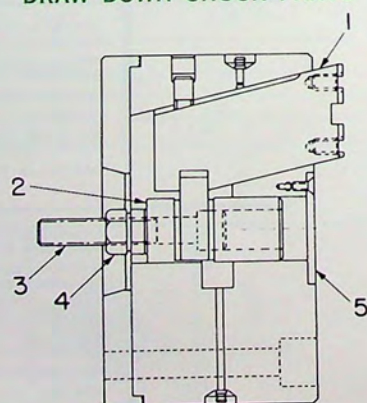
*Available as an assembly only

TWO-JAW POWER CHUCK PARTS SERIES 10-596



PART NUMBER	PART NAME
1	Plunger
2	Lever
3	Lever Pin
4	Lever Pin Plug
5	Lever Pin Retainer Washer
6	Lever Pin Oil Plug
7	Adjusting Screw
8	Master Jaw (sets of 2)
9	Top Jaw
10	Top Jaw Clamp Screws
11	Wrench
12	Dust Plate
13	Dust Plate Plug

SERIES 10-730 DRAW DOWN CHUCK PARTS

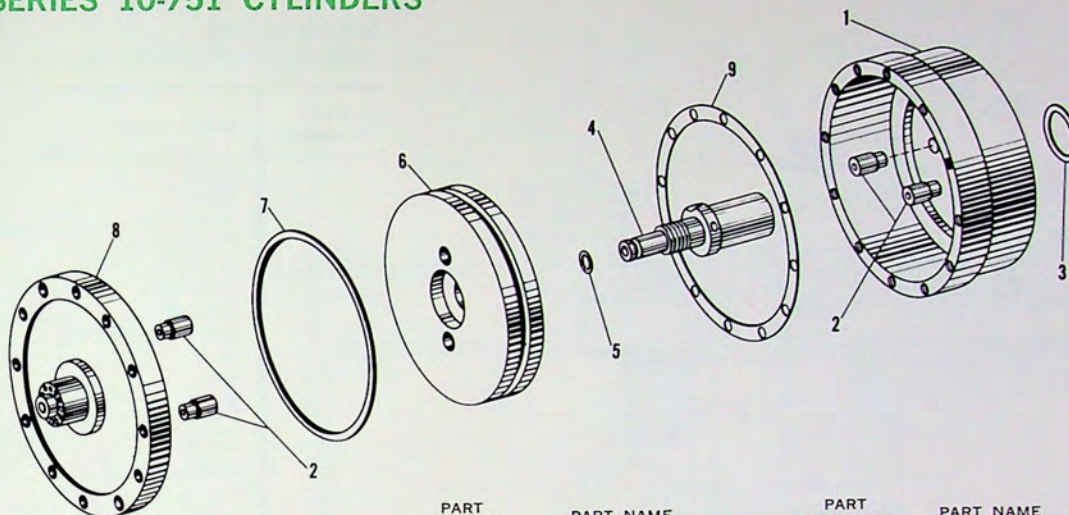


PART NUMBER	PART NAME
1	Master Jaw
2	Draw Head
3	Draw Rod Stud
4	Draw Rod Stud Lock Nut
5	Cover Plate

AIR OPERATED CYLINDER PARTS NOMENCLATURE

See "How To Order Parts" on page 24

SERIES 10-751 CYLINDERS

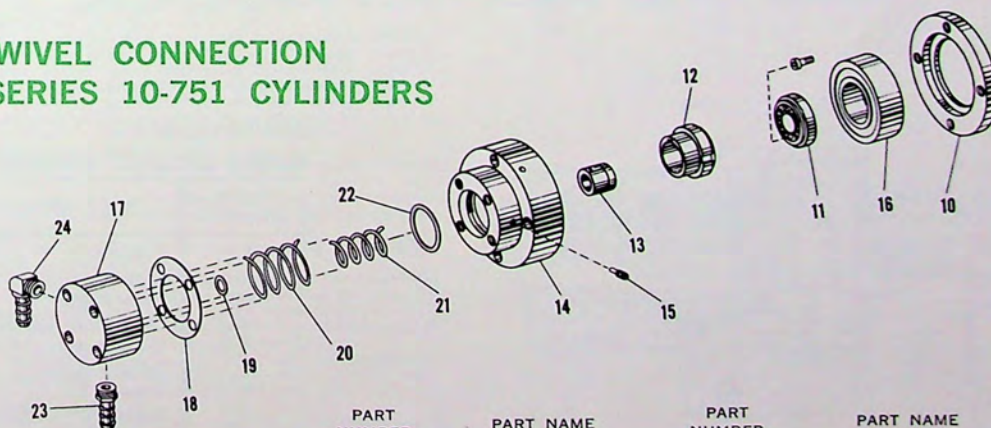


PART NUMBER	PART NAME
1	Cylinder Body
2	Guide Pin
3*	Cylinder Body "O" Ring
4	Piston Rod
5*	Piston Rod "O" Ring

PART NUMBER	PART NAME
6	Piston
7*	Piston "O" Ring
8	Cylinder Cap
9*	Gasket

*These parts available in repair kits only.

AIR SWIVEL CONNECTION FOR SERIES 10-751 CYLINDERS



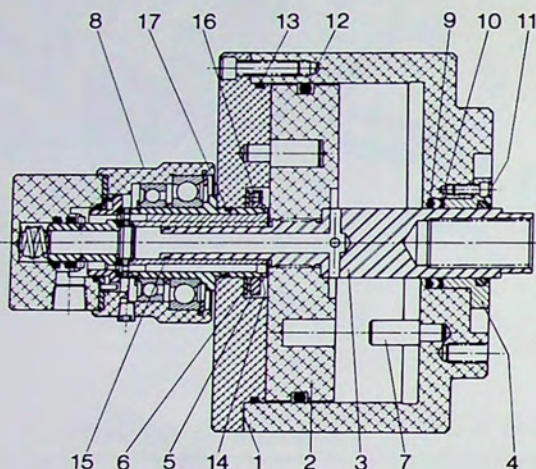
PART NUMBER	PART NAME
10	Swivel Clamp Ring
11	Bearing Plate
12*	Outer Bearing Ass'y.
13*	Inner Bearing Ass'y.
14 & 15	Swivel Body Ass'y.
16	Ball Bearing

PART NUMBER	PART NAME
17	Swivel Cap
18*	Swivel Cap Gasket
19*	"O" Ring
20*	Outer Spring
21*	Inner Spring
22*	"O" Ring
23	Hose Stem
24	Hose Stem Ell

*These parts available in repair kits only.

HYDRAULIC OPERATED CYLINDER PARTS NOMENCLATURE

See "How to Order Parts" on page 24

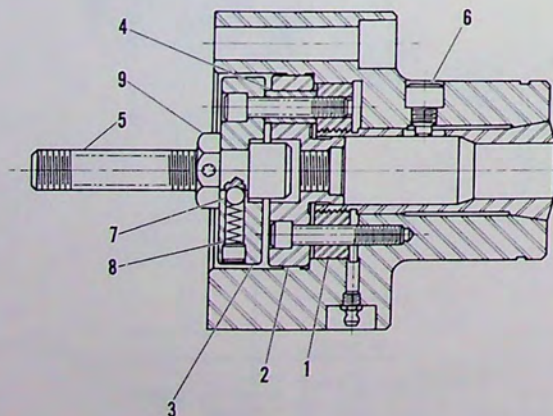


SERIES 10-760 HYDRAULIC CYLINDER PARTS

PART NUMBER	PART NAME
1	Cover
2	Piston
3	Piston Rod
4	Bushing
5	Lockring
6	Lockring
7	Guide Pin
8	Swivel Connection
9*	Seal
10*	Seal
11*	Rod Wiper
12*	"O" Ring
13*	"O" Ring
14	Retaining Ring
15*	"O" Ring
16	1/4-20 X 1/4 nylok
17	"O" Ring

*Available in Parts Kit only.

POWER COLLET CHUCK PARTS NOMENCLATURE

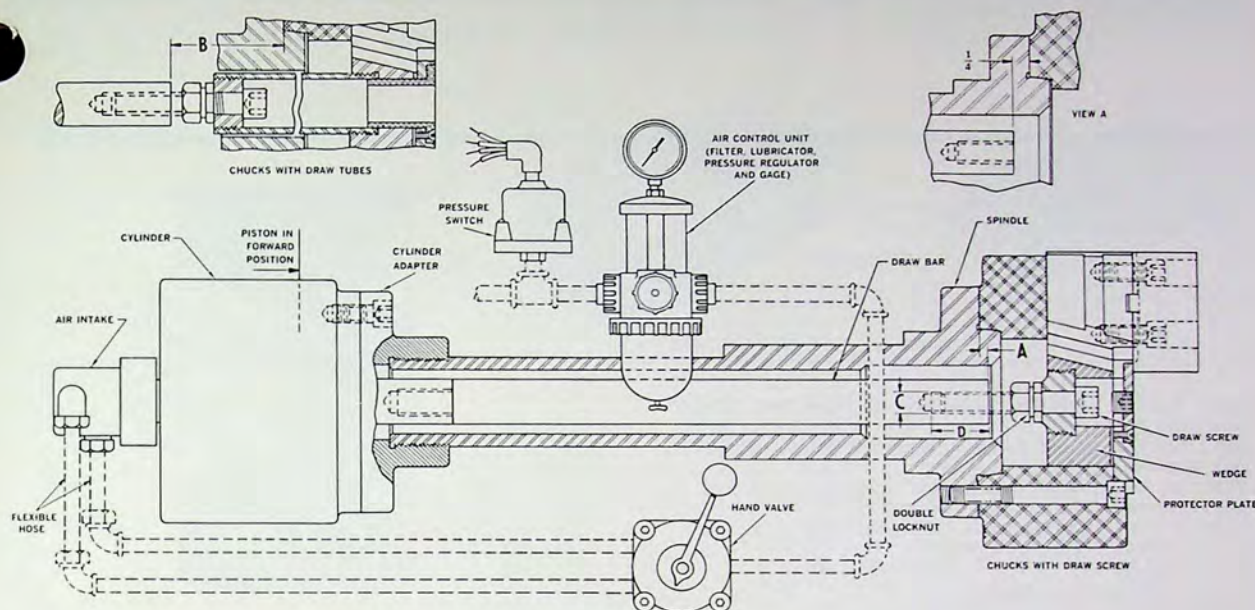


SERIES 10-913 POWER COLLECT CHUCKS

PART NUMBER	PART NAME
1.	Collet Nut
2.	Stop Plate
3.*	Draw Plate
4.	Draw Plate Spacer
5.*	Draw Bolt
6.	Collet Key
7.*	Steel Ball
8.*	Adjusting Nut Spring
9.*	Draw Bolt Nut

*Available as an assembly only.

POWER CHUCK INSTALLATION INSTRUCTIONS



Every power chuck and air cylinder installation should be equipped with an air filter to remove dirt and scale; a pressure regulating valve and gauge to control air pressure; and lubricator to provide adequate lubrication for the air cylinder. An operating valve either hand, foot, or solenoid operated is also required.

The use of semi-finished cylinder adapters and draw bars is recommended to expedite power chuck installations. The semi-finished adapter is to be machined to fit the rear of the spindle and the draw bar is to be fitted in accordance with the following instructions:

1. Mount the cylinder adapter on the rear of the spindle making sure that the spindle bottoms in the adapter and that the rear face and pilot of the adapter run true.
2. Attach the semi-finished draw bar to the cylinder and mount the cylinder on the adapter.
3. Mount the operating valve in a position convenient to the machine operator. Use clean tubing or pipe to make the installation as shown above. Short lengths of flexible hose must be used to connect the cylinder to the piping to prevent the possibility of damage to the air intake. It may be necessary to make brackets to attach the pipes near the flexible hose to the machine frame to provide rigidity to the pipes.
4. Set air pressure 10 to 20 p.s.i.
5. Use the operating valve to put the draw bar in the forward position.
6. Measure the amount to be cut from the draw bar per the A or B dimension of table. Remove the draw bar and cylinder from the machine.
7. Cut off the draw bar and drill and tap per table. Reinstall the draw bar and cylinder as above.
8. The chuck is installed by setting the jaws in the outer position as shown and then supporting the chuck with a sling or eye bolt so that the draw bar stud may be inserted in the draw bar. (The double lock-nut on the draw bar stud is factory set to .001 to .010 inches play to prevent binding.)
9. Screw the draw bar stud in so that the chuck just makes contact with the spindle face while the jaws remain in their outer position. Rotate the draw bar stud $\frac{1}{2}$ to 1 more turn clockwise and insert the mounting screws.
10. Make the final adjustment of the draw bar stud by rotating it counterclockwise until it causes the wedge to hit solidly on the protector plate and then rotate clockwise so that the jaws start to move towards center. This will insure that the wedge will not hit the protector plate when the cylinder is in the forward position.
11. Check the installation by opening and closing the chuck. With the jaws closed recheck the securing screws to see that they are tight. With the jaws open recheck the draw bar stud to see that it is free by rotating it slightly. Check to see that the full travel of the jaws is obtained from the open to the closed position.
12. Set the air pressure to the operating value.

The above instructions apply to wedge operated chucks. For Series 10-560, 10-561 Compensating Chucks and Series 10-596 Two-Jaw Chucks, write for special installation procedures.

PERTINENT INSTALLATION DIMENSIONS

Chuck Size	A $\pm 3/32$	B $\pm 3/32$	C Tap	D Min. Full Depth
6	0	$6\frac{5}{8}$	$5\frac{3}{8}$ -18	$1\frac{3}{4}$
8	$\frac{1}{4}$	$6\frac{3}{8}$	$5\frac{3}{8}$ -18	$1\frac{3}{4}$
10	$\frac{1}{4}$	11	$3\frac{3}{4}$ -16	$1\frac{3}{4}$
12 A6	0	11	$3\frac{3}{4}$ -16	$1\frac{3}{4}$
12 A8	See View A	11	1"-14	$2\frac{3}{4}$
15	0	12	1"-14	$2\frac{3}{4}$
18	$\frac{1}{4}$	$13\frac{3}{8}$	1"-14	$2\frac{3}{4}$
21	$\frac{1}{2}$	18	1"-14	$2\frac{3}{4}$
24	$\frac{1}{2}$	18	1"-14	$2\frac{3}{4}$

MAXIMUM RECOMMENDED CYLINDER SIZE FOR USE WITH 2 OR 3 JAW WEDGE CHUCKS (FOR HYDRAULIC CYLINDERS AND LEVER CHUCKS CONSULT FACTORY.)

Sizes of Chucks Inches	2 JAW		3 JAW	
	Sizes of Cylinder Inches	Line Pressure Pounds	Sizes of Cylinder Inches	Line Pressure Pounds
6	6	55	6	80
8	8	55	8	80
10	8	80	10	80
12	10	80	12	80
15	14	70	16	80
18	16	65	18	80
21	16	80	20	80

SPINDLE IDENTIFICATION AMERICAN STANDARD SPINDLE NOSES

DIMENSIONS—INCHES

TYPE & SIZE					
	5	6	8	11	15
S-1	5 $\frac{1}{4}$	6 $\frac{1}{2}$	8 $\frac{1}{4}$	11	15
S-2	3 $\frac{1}{4}$	4 $\frac{3}{16}$	5 $\frac{1}{2}$	7 $\frac{3}{4}$	11 $\frac{1}{4}$
S-15	$\frac{7}{16}$ -14	$\frac{1}{2}$ -13	$\frac{5}{8}$ -11	$\frac{3}{4}$ -10	$\frac{7}{8}$ -9

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

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

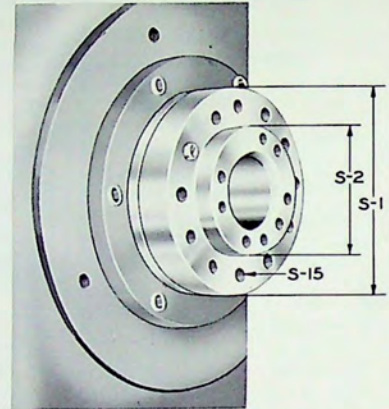
TYPE B-1 Has drilled holes on the outer bolt circle and tapped holes on the inner bolt circle.

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

Identify this spindle by size and type
(Example: 6" Type A-1 Am. Std. Nose)

TYPE A or B

A-1, A-2, B-1, B-2
(See note.)



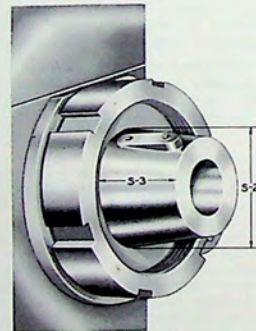
Type A Spindle shown.

DIMENSIONS—INCHES

TYPE & SIZE					
	L00	L0	L1	L2	L3
S-2	2 $\frac{3}{4}$	3 $\frac{1}{4}$	4 $\frac{1}{8}$	5 $\frac{1}{4}$	6 $\frac{1}{2}$
S-3	2	2 $\frac{3}{8}$	2 $\frac{7}{8}$	3 $\frac{3}{8}$	3 $\frac{7}{8}$

TYPE L

LONG TAPER KEY DRIVE

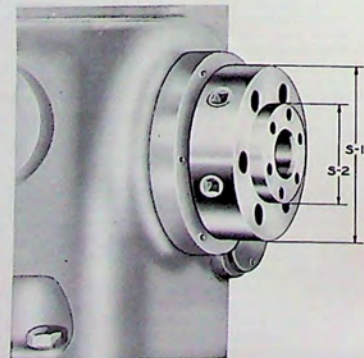


DIMENSIONS—INCHES

TYPE & SIZE						
	D3	D4	D5	D6	D8	D11
S-1	3 $\frac{5}{8}$	4 $\frac{5}{8}$	5 $\frac{3}{4}$	7 $\frac{1}{8}$	8 $\frac{7}{8}$	11 $\frac{3}{4}$
S-2	2 $\frac{1}{8}$	2 $\frac{1}{2}$	3 $\frac{1}{4}$	4 $\frac{3}{16}$	5 $\frac{1}{2}$	7 $\frac{3}{4}$

TYPE D-1

CAM-LOCK

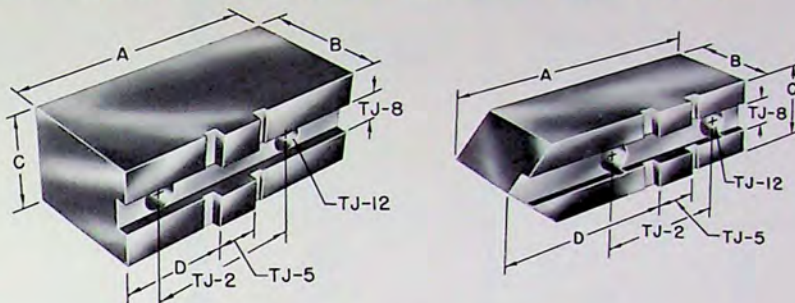


SOFT BLANK TOP JAWS

NOTE: ALWAYS CHECK DIMENSIONS BEFORE ORDERING

FOR ALL CHUCKS WITH AMERICAN STANDARD TONGUE & GROOVE MASTER JAWS

Soft Blank Top Jaws are precision made to American Standards specifications from low carbon steel which can be easily shaped, carburized, and hardened. They can be shaped to hold irregular workpieces which sometimes require expensive fixtures and extensive set-up and machine down-time. You just can't make your own soft blank jaws at our prices.



FOR USE ON

Draw Down Chucks	Manual Scroll Chucks (Except Heavy Duty)	Independent, Combination, Power Chucks, Heavy Duty Scroll Chucks
CHUCK SIZE	CHUCK SIZE	CHUCK SIZE
8" & 10"	6"	6"
12" & 15"	8"	8"
—	10"	10"
—	12"	12"
—	15"	15"
—	18" thru 32"	15" thru 36"
—	—	15" thru 36"

SOFT BLANK TOP JAW DIMENSIONS

STANDARD HEIGHT									EXTRA HIGH	
Reference Number	A	B	C	D	TJ-2	TJ-5	TJ-8	TJ-12*	Reference Number	B
05-201447	2 5/8	1 5/8	1 1/4	1 1/8	1 1/2	.499-.498	.315-.313	3/8	05-201471	3 3/4
05-201448	2 5/8	1 5/8	1 1/4	1 1/8	1 1/2	.499-.498	.315-.313	7/16	05-201472	3 3/8
05-201450	3 1/2	1 5/8	1 1/4	1 5/8	1 3/4	.499-.498	.315-.313	3/8	05-201474	3 3/8
05-201451	3 1/2	1 7/8	1 1/2	1 5/8	1 3/4	.499-.498	.315-.313	1/2	05-201475	3 3/8
05-201452	4 1/4	1 7/8	1 1/2	1 11/16	2 1/8	.749-.748	.503-.501	1/2	05-201476	3 3/4
05-201453	4 1/4	2 3/8	1 3/4	1 11/16	2 1/8	.749-.748	.503-.501	3/8	05-201477	3 3/8
05-201454	4 7/8	2 3/8	1 3/4	2 1/8	2 1/2	.749-.748	.503-.501	1/2	05-201478	3 3/8
05-201455	4 7/8	2 3/8	2	2 1/8	2 1/2	.749-.748	.503-.501	3/8	05-201479	3 3/4
05-201456	5 3/8	2 1/4	2	2 3/4	3	.749-.748	.503-.501	3/8	05-201480	3 3/4
05-201457†	5 3/8	2 1/4	2	2 3/4	3	.749-.748	.503-.501	3/4	05-201481	3 3/4
05-201458	5 3/8	3 1/4	2 1/2	2 3/4	3	.749-.748	.503-.501	3/4	05-201482	4 3/4

LONG POINT SOFT BLANK TOP JAW DIMENSIONS

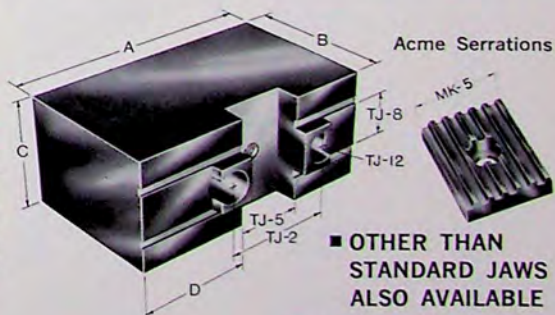
8" & 10"	6"	—	05-201459	3 3/8	1 3/8	1 1/4	1 11/16	1 1/2	.499-.498	.315-.313	3/8	05-201483	3 3/8
—	—	6"	05-201460	3 3/8	1 3/8	1 1/4	1 11/16	1 1/2	.499-.498	.315-.313	7/16	05-201484	3 3/8
12" & 15"	8"	—	05-201462	3 11/16	1 3/8	1 1/4	2 1/4	1 3/4	.499-.498	.315-.313	3/8	05-201486	3 3/8
—	—	8"	05-201463	3 11/16	1 7/8	1 1/2	2 1/4	1 3/4	.499-.498	.315-.313	1/2	05-201487	3 3/8
—	10"	—	05-201464	4 13/16	1 7/8	1 1/2	2 11/16	2 1/8	.749-.748	.503-.501	1/2	05-201488	3 3/8
—	—	10"	05-201465	4 13/16	2 3/8	1 3/4	2 11/16	2 1/8	.749-.748	.503-.501	3/8	05-201489	3 3/8
—	12"	—	05-201466	5 3/4	2 3/8	1 3/4	3 3/8	2 1/2	.749-.748	.503-.501	1/2	05-201490	3 3/8
—	—	12"	05-201467	5 3/4	2 3/8	2	3 3/8	2 1/2	.749-.748	.503-.501	3/8	05-201491	3 3/8
—	15"	—	05-201468	7 1/4	2 1/4	2	4 1/2	3	.749-.748	.503-.501	3/8	05-201495	3 3/4
—	—	15"	05-201469†	7 1/4	2 1/4	2	4 1/2	3	.749-.748	.503-.501	3/4	05-201496	3 3/4
—	18" thru 32"	15" thru 36"	05-201519	7 1/4	3 1/4	2 1/2	4 1/2	3	.749-.748	.503-.501	3/4	05-201520	4 3/4

* Bolt size

† Narrow jaw model

FOR ALL CHUCKS WITH SERRATED MASTER JAWS

Screw is supplied when jaw and corresponding key are purchased together. This is sound practice since it permits key and jaw to be stored assembled as a matched set when not in use. Serrated Master Keys are precision-ground from top quality, hardened steel. Acme serrations are so positioned that by reversing master key 180°, the top jaws can be adjusted to 1/2 the pitch of the serrations. The feature permits easy adjustment of the top jaws in reference to the work.



■ OTHER THAN STANDARD JAWS ALSO AVAILABLE

SERRATED JAWS

MASTER KEYS

Chuck Size	Reference Number	DIMENSIONS—INCHES								Chuck Size	Reference Number	Dimension MK-5*
		A	B	C	D	TJ-2	TJ-5	TJ-8	TJ-12†			
10	25-13072	4 1/8	2 3/8	1 3/4	1 11/16	1 3/4	1.030	.750	1/2	10	25-10912	1.030
12	25-13071	4 1/8	2 3/8	1 3/4	1 11/16	2	1.030	.875	3/8	12	25-10912	1.030
15-18	25-13070	5 3/8	3 1/4	2 1/2	2 3/8	2 1/2	1.530	1.000	3/4	15-18	25-10907	1.530
21	25-13069	5 3/8	3 1/4	2 1/2	2 3/4	3	1.530	1.250	7/8	21-24	04-8280	1.530

*—.001

† Bolt size.

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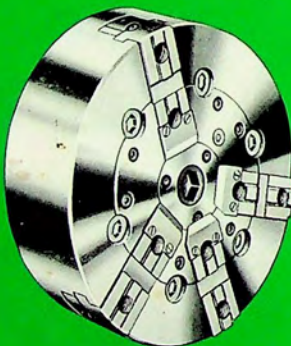
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*New design equivalent

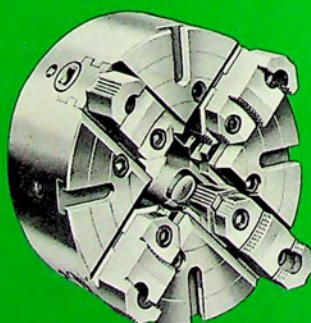
SKINNER

HORTON-UNION CHUCKS



POWER OPERATED CHUCKS and CYLINDERS

Power Chucking is the best way to reduce floor-to-floor time. Power chucks and actuating air and hydraulic cylinders have been designed and built for continuous production line service with the benefits of reduced chucking time, positive gripping, accurate repeatability, and precision workholding on the latest machine tool equipment available today.



MANUALLY OPERATED CHUCKS

This series of chucks incorporates the most advanced principles of design and engineering, resulting in workholding devices with the ability to assure positive gripping, repetitive accuracy, and a long trouble-free service life. Each style will provide the maximum in workholding performance on modern machine tools.

***POWER and
MANUAL
OPERATED
WORKHOLDING
EQUIPMENT***