gator chucks® BY FUERDA

Gator ISO 9001 - 2008 a certified lathe chuck factory has been servicing machine tool customers for over 40 years. During this long period of production experience Gator Factory has managed to significantly expand product offering, introducing to the workholding markets a number of new designs of high quality lathe chucks. Gator offers unbeatable value where quality products , quality service and competitive pricing make a difference for workholding customers. All Gator products meet ANSI, DIN & ISO Standard requirements.
Gator Factory has also established and applies an internal Quality Systems for development, production and sales of Manual Lathe Chucks focusing everyday on: customer needs, factory leadership, direct worker's engagement in a factory constant development and improvement, manufacturing and quality control process approach, management system development and improvement and mutually beneficial relationships with factory suppliers and distributors. The factory also provides constant trainings for factory workers and distributor teams. The printed training materials are also available.

All factory authorized distribution centers located all over the world (including most demanding markets like USA and Europe) offer full technical and application support. They are readey to aswer any questions concerning Gator products or directly assist in customer clamping solution applications.
All most popular Gator products are stocked in major factory authorized distribution centers.
Technical and sales teams are open for close cooperation with customers to solve every workholding application. Comprehensive chuck diameter ( 3" thru 50") and mounting (A, D1, L, Threaded, Plain Back & Special) offering gives the customer large application flexibility. Special chucks for special applications are pretty common in a factory every day production life.
For more detailed information please contact your local distributor or Gator factory direct at:
info@gatorchucks.com

Limited Warranty
All Gator lathe chuck and adapter plate , spare parts are warranted against manufacturer defects and workmanship under normal use (single shift) according to the chuck application (listed in the chuck manual) for one year from the date of purchase. Any chuck modifications, normal wear and tear are not covered by the factory.

The company, purchasing and using any Gator Lathe Chuck is responsible for ensuring that all personal operating or servicing the lathe chuck read and understand the Gator Chuck Manual safety, installation and operating requirements.

All chuck defects should be immediately reported to the Gator Chuck Distributor in order to limit the extent of damage and avoid compromising the safety of the chuck. Failure to comply with these instructions will void the warranty.
All customer quality feedbacks are very welcome by the factory.
Please NOTE that additional warranty terms may apply through the Gator local distribution centers.
For more detailed information please contact your local distributor or Gator factory direct at:
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# Contents

**PA** — Page1-20

*Tech-Tru™*
PA Series Forged Steel Body Adjustable Scroll Chucks

**PB** — Page21-40

*Tech-Tru™*
PB Series Semi-Steel Body Adjustable Scroll Chucks

**PO** — Page41-66

PO Series Forged Steel Body Precision Scroll Chucks

**PS** — Page67-92

PS Series Semi-Steel Body Universal Scroll Chucks

**PI** — Page93-114

PI Series Semi-Steel & Cast Steel Body Independent Chucks

**Front Mounting** — Page115-124

PO & PS Series Front Mounting Scroll Chucks

**PSL** — Page125-130

PSL Series Forged Steel Body Large Thru Hole Scroll Chucks

**PEI & PEO** — Page131-141

*Forged Steel Body*
*4-Jaw Independent Chucks*
*3-Jaw Self-Centering Chucks*
PEI & PEO Series Heavy Duty Oil Country Chucks

**EA** — Page142-150

EA Series Semi-Steel Body Adjustable Scroll Chucks

# Chuck Selection Guide

## Determining the Proper Spindle Type and Size

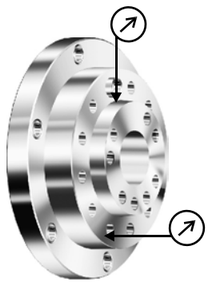
**Gator Chucks meet all of the requirements of ASA Standard B5.9-1960.**

For spindle nose accuracy (T.I.R) see page G5.

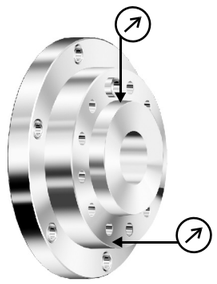
**Selecting the chuck mounting:**

- Choose from the types shown below.
- For short taper spindle noses Type A, D, & C (DIN),measure the pilot diameter and length(B& C), bolt circle diameter (dimensions F1 & F2) and diameter of the holes (dimensions E1 & E2).
- In the case of A type mount, check the number of bolt circles (A2 mount or A1 mount).
- All chucks with A1 mount can be installed on A1spindle nose only.
- All chucks with A2 mount can be installed on either A1 or A2 spindle nose.
- For the long taper spindle noses Type L, check pilot diameter, length and thread size ( A, C & B).
- For the threaded spindle noses, check the thread diameter, number of threads per inch and length (dimensions B & D), plus overall length (dimension F).

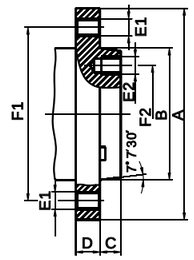
### Spindle Type A1&A2



Type A1 has tapped holes on both inner and outer bolt circles.

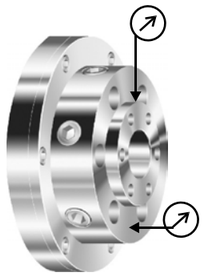


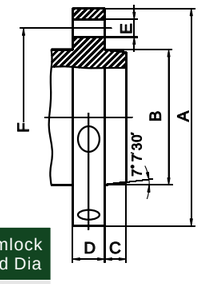
Type A2 does not have holes in the inner bolt circles.




| Spindle Nose | F1 | F2 | B | C max. | Thread E1=E2 UNC-3B |
|---|---|---|---|---|---|
| A-4 | 3.2500 | - | 2.5005+.0005 | .4375 | 7/16-14 |
| A-5 | 4.1250 | 2.4374 | 3.2505+.0005 | .5625 | 7/16-14 |
| A-6 | 5.2500 | 3.2500 | 4.1880+.0005 | .6250 | 1/2-13 |
| A-8 | 6.7500 | 4.3750 | 5.50075+.0005 | .6875 | 5/8-11 |
| A-11 | 9.2500 | 6.5000 | 7.75075+.0005 | .7500 | 3/4-10 |
| A-15 | 13.0000 | 9.7500 | 11.251+.001 | .8125 | 7/8-9 |
| A-20 | 18.2500 | 14.5000 | 16.251+.001 | .8750 | 1-8 |
| A-28 | 25.5000 | 20.8750 | 23.001+.001 | 1.000 | 1-1/4-7 |

### Camlock Spindle Type D1





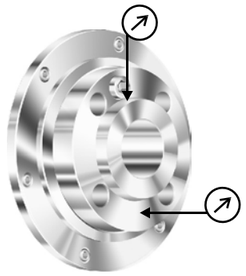

| Spindle Nose | A | F | B | C max. | E | No .of Holes | Camlock Stud Dia |
|---|---|---|---|---|---|---|---|
| D1-3 | 3.622 | 2.7820 | 2.1250+.00025 | .4375 | .5937 | 3 | 9/16 |
| D1-4 | 4.606 | 3.2500 | 2.5005+.0005 | .4375 | .6562 | | 5/8 |
| D1-5 | 5.748 | 4.1250 | 3.2505+.0005 | .5000 | .8750 | 6 | 3/ 4 |
| D1-6 | 7.126 | 5.2500 | 4.1880+.0005 | .5625 | 1.000 | | 7/8 |
| D1-8 | 8.858 | 6.7500 | 5.50075+.0005 | .6250 | 1.125 | | 1 |
| D1-11 | 11.732 | 9.2520 | 7.75075+.0005 | .6875 | 1.250 | | 1-3/16 |
| D1-15 | 15.866 | 13.0000 | 11.251+.001 | .7500 | 1.375 | | 1-3/8 |

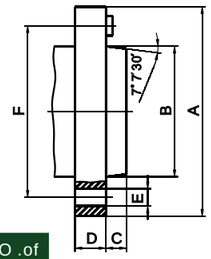




Chuck Selection Guide

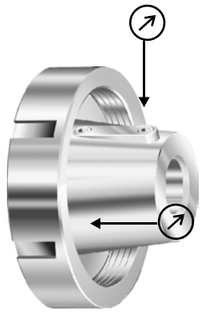
### German Standard DIN55027,Spindle Type C

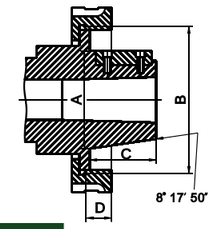





| Spindle Nose | F | B | C max. | E | NO .of Holes |
|---|---|---|---|---|---|
| C-4 | 3.2500 | 2.5005 | .4331 | .83 | 3 |
| C-5 | 4.1250 | 3.2505 | .5118 | .83 | 4 |
| C-6 | 5.2500 | 4.1880 | .5512 | .91 | 4 |
| C-8 | 6.7500 | 5.50075 | .6299 | 1.14 | 4 |
| C-11 | 9.2520 | 7.75075 | .7087 | 1.42 | 6 |

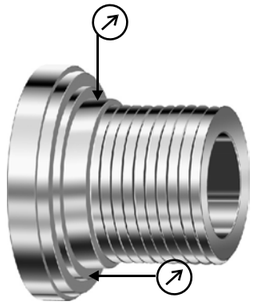
### Long Taper Key Drive,Spindle Type L

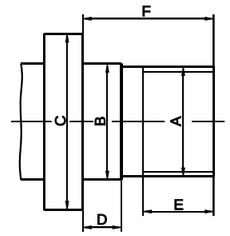





| Spindle Nose | Thread B | C | A | Key |
|---|---|---|---|---|
| L00 | 3-3/ 4" - 6" | 2 | 2.75 | 3/8 x3/8 x 1-1/ 2 |
| L0 | 4-1/ 2" - 6" | 2-3/8 | 3.250 | 3/8 x3/8 x 1-3/ 4 |
| L1 | 6" - 6" | 2-7/8 | 4.125 | 5/8 x5/8 x 2-3/ 8 |
| L2 | 7-3/ 4"-5" | 3-3/8 | 5.250 | 3/4 x3/4 x 2-7/ 8 |
| L3 | 10-3/ 8"-4" | 3-7/8 | 6.500 | 1 x1 x 3- 1/ 4 |

### Threaded Spindle





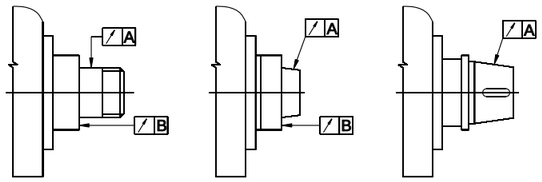

| Spindle Nose A | B | F1 | D | E |
|---|---|---|---|---|
| 1"-10" UNS-2B | 1.015 | 1.500 | .4375 | 1.000 |
| 1-1/2"-8" UNS-2B | 1.515 | 1.500 | .4375 | 1.000 |
| 2-3/16"-10"UNS-2B | 2.2025 | 1.750 | .5625 | 1.125 |
| 2-1/4"-8" UNS-2B | 2.260 | 1.750 | .5625 | 1.125 |
| 2-3/16"-6" - UNS-2B | 2.2025 | 1.750 | .5625 | 1.125 |
| 2-3/4"-8" UNS-2B | 2.760 | 2.0625 | .6875 | 1.3125 |

# Chuck Selection Guide

## Permissible Spindle Runout

**To obtain the specified clamping accuracy of a chuck mounted on a machine tool, it is necessary to:**

1. Reduce play in the spindle bearings to allowable minimum.
2. Ensure the machine spindle nose does not exceed the values specified.
3. Meet the basic requirements for correct mounting of the chuck on the spindle nose.
4. Follow the chuck manual.

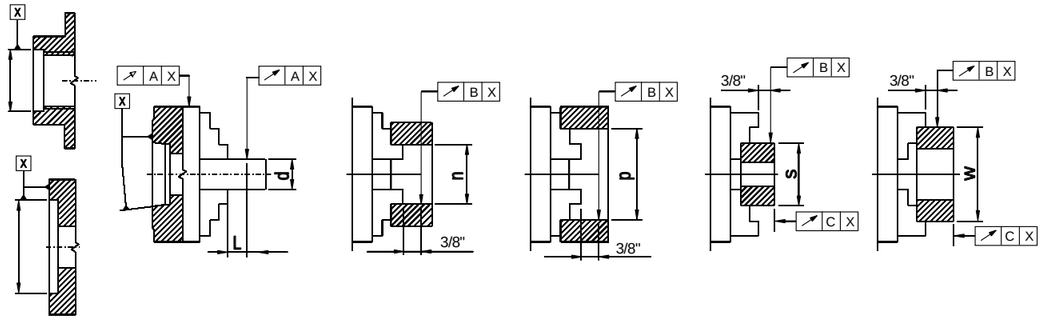



| Chuck Dia. | Spindle Runout |
|---|---|
| PO Series Steel Body Chucks | |
| 3" - 16" | .00012"max. |
| 20" - 25" | .0002"max. |
| PS Series Semi-Steel Body | |
| 3" - 6" | .00012"max. |
| 8" - 32" | .0002"max. |

## Self-Centering Scroll Chuck Accuracy

All allowable runouts which are specified concern measurements at three different jaw openings d(1, 2 & 3).

| Chuck Dia. D | Universal and Precision Chuck Types: PASeries ,PO Series ,PS Series | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | d | | | L | n | p | s | w solid jaws | w 2 pc.jaws | Radial Runout | | Axial Runout |
| | 1 | 2 | 3 | | | | | | | A | B | C |
| 3-1/4" | 0.39 | - | 0.55 | 1.57 | 1.57 | 2.36 | 1.38 | 2.48 | - | 0.0008 | 0.001 | 0.0006 |
| 4" | 0.39 | 0.55 | 0.71 | 1.57 | 1.57 | 2.95 | 1.97 | 3.15 | - | 0.0008 | 0.001 | 0.0006 |
| 5" | 0.71 | 0.98 | 1.18 | 2.36 | 1.97 | 3.94 | 2.44 | 3.94 | 4.72 | 0.0012 | 0.0014 | 0.0008 |
| 6-1/4" | 0.71 | 1.18 | 1.57 | 2.36 | 1.97 | 5.31 | 3.46 | 3.94 | 5.9 | 0.0012 | 0.0014 | 0.0008 |
| 8" | 1.18 | 1.57 | 2.08 | 3.15 | 3.15 | 6.38 | 3.78 | 6.3 | 7.28 | 0.0016 | 0.0018 | 0.001 |
| 10" | 1.18 | 2.08 | 2.95 | 3.15 | 3.15 | 7.87 | 5.9 | 6.3 | 8.86 | 0.0016 | 0.0018 | 0.001 |
| 12-1/2" | 2.08 | 2.95 | 3.94 | 4.72 | 4.92 | 9.92 | 8.27 | 9.84 | 11.81 | 0.002 | 0.0022 | 0.0012 |
| 15-3/4" | 2.08 | 3.94 | 4.92 | 4.72 | 4.92 | 11.1 | 9.84 | 9.84 | 13.78 | 0.0024 | 0.0025 | 0.0012 |
| 20" | 2.95 | 3.94 | 4.92 | 6.3 | 7.87 | 11.1 | 11.81 | 15.75 | 15.75 | 0.004 | 0.004 | 0.002 |
| 25" | 2.95 | 4.92 | 6.3 | 6.3 | 7.87 | 12.79 | 15.75 | 15.75 | 15.75 | 0.004 | 0.004 | 0.002 |
| 31-1/2" | 6.3 | 7.87 | 9.84 | 6.3 | 12.8 | 19.7 | 15.75 | 19.7 | 19.7 | 0.0059 | 0.0059 | 0.0024 |





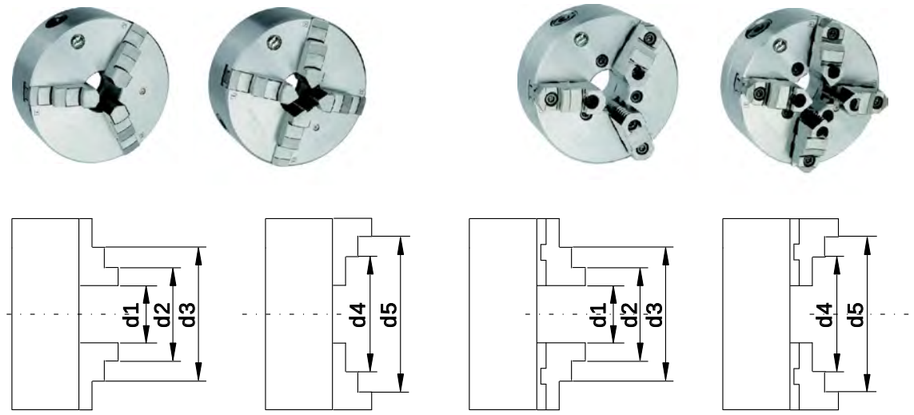

Chuck Selection Guide

# Chuck Selection Guide

## Clamping Ranges for Self-Centering Scroll Chucks

Solid Jaws

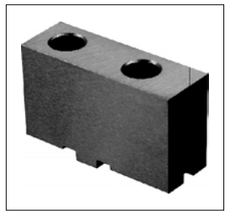
Two-piece Reversible Jaws




| Chuck Diameter | | d1 | | d2 | | d3 max. | | d4 max. | | d5 max. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | JAWS | | | | | | | | | |
| mm | inch | solid | reversible | solid | reversible | solid | reversible | solid | reversible | solid | reversible |
| 60 | 2-1/3 | .02-.95 | - | .79-1.65 | - | 1.46-2.36 | - | .79-1.65 | - | 1.50-2.36 | - |
| 80 | 3-1/4 | .08-1.06 | - | .87-1.81 | - | 1.77-2.72 | - | .98-1.97 | - | 1.89-2.80 | - |
| 100 | 4 | .12-1.30 | | .98-2.20 | - | 2.20-3.43 | - | 1.26-2.44 | - | 2.44-3.27 | |
| 125 | 5 | .12-1.97 | .12-1.97 | 1.37-2.91 | 1.34-2.99 | 2.83-4.53 | 2.95-4.65 | 1.54-3.27 | 2.05-3.78 | 3.15-4.92 | 3.74-4.92 |
| 160 | 6-1/4 | .12-2.52 | .12-2.52 | 1.65-3.94 | 1.65-3.82 | 3.70-6.06 | 3.46-5.75 | 1.97-4.21 | 2.44-4.76 | 3.86-6.30 | 4.53-6.30 |
| 200 | 8 | .16-3.54 | .16-3.54 | 2.05-5.31 | 1.97-5.12 | 4.72-7.95 | 4.13-7.48 | 2.36-5.71 | 2.83-6.14 | 5.12-7.87 | 5.24-7.87 |
| 250 | 10 | .20-4.65 | .20-4.65 | 2.44-6.85 | 2.28-6.50 | 5.70-10.43 | 4.92-9.25 | 3.03-7.40 | 3.38-7.75 | 6.30-9.84 | 6.30-9.84 |
| 315 | 12-1/2 | .39-5.16 | .20-5.16 | 3.07-7.87 | 2.56-7.16 | 6.77-11.77 | 5.70-10.43 | 3.54-8.46 | 4.06-8.90 | 7.48-12.40 | 7.48-12.40 |
| 400 | 15-3/4 | .39-7.09 | .39-7.09 | 3.35-9.92 | 2.83-8.98 | 8.27-14.96 | 6.50-12.95 | 4.05-10.71 | 5.00-11.57 | 9.05-15.75 | 9.05-15.75 |
| 500 | 20 | .79-9.25 | .79-9.25 | 4.72-13.19 | 4.72-16.14 | 9.65-18.74 | 7.87-19.10 | 5.51-14.06 | 4.33-15.75 | 10.87-19.69 | 7.48-19.69 |
| 630 | 25 | 1.18-13.19 | 1.18-13.19 | 6.30-18.31 | 5.51-23.23 | 12.80-24.80 | 8.27-26.18 | 7.09-19.17 | 4.72-22.44 | 13.58-24.80 | 7.88-24.80 |
| 800 | 31-1/2 | 5.9-18.98 | 5.9-18.98 | 11.10-24.17 | 9.92-28.99 | 17.64-30.71 | 12.91-31.97 | 11.89-24.96 | 9.45-28.5 | 18.43-31.50 | 12.44-31.50 |

## To Avoid a Chuck Gripping Problem, Select the proper Hard Top Jaws or Soft Top Jaws

Jaw for Heavy Machining



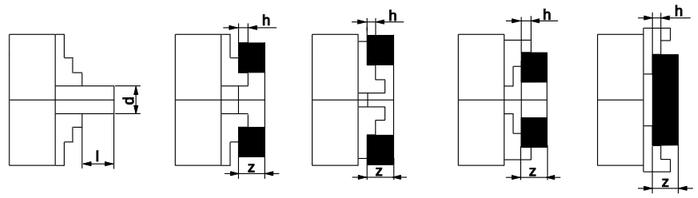
Jaw for Special Applications

Jaw for Finishing

# Chuck Selection Guide

## Safe Operating Parameters

Conditions: l&z=maximum length of workpiece
d=workpiece diameter
h=height of the clamping jaw step
workpiece is clamped into the chuck jaws with out additional support.




| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|---|---|---|---|---|---|---|---|---|---|---|---|
| l | 1.2 x d | | | | | | 1.5 x d | | | 1 x d | |
| z | 4 x h | | | | | | | | | | |

## Total Gripping Force of all Self-Centering Chucks (lbs.)

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Steel & Semi-Steel Chucks | 2,200 | 3,750 | 5,300 | 6,800 | 8,200 | 10,000 | 12,000 | 14,300 | 16,000 | 17,700 | 19,800 |

## Recommended Maximum Speeds for Self-Centering Chucks(RPM)

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Universal Chucks(Semi-steel body) | 4000 | 3500 | 3200 | 3000 | 2500 | 2000 | 1500 | 1000 | 700 | 500 | 300 |
| Precision Chucks (Steel body) | 6000 | 5200 | 4800 | 4500 | 4000 | 3500 | 2800 | 2000 | 1200 | 1000 | 450 |

## Value of Balancing for Precision Self-Centering Chucks Only.

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" |
|---|---|---|---|---|---|---|---|---|---|---|
| Balancing (ounce-inch) | 0.15 | 0.22 | 0.32 | 0.44 | 0.62 | 0.87 | 1.25 | 1.94 | 4.16 | 8.88 |

## Lathe Chuck Safety Conditions

- Due to chuck rotating speeds and cutting forces during machining, care should be taken to insure the proper and safe use of your chuck.
- Cleaning should be done often for safety purposes as well as to provide a long work life for your chuck.
- Proper maintenance will insure your satisfaction.

**PRIOR TO OPERATING YOUR LATHE CHUCK, PLEASE**:

- Read the chuck manual.
- Do not start the lathe until all is clear. A collision between the chuck and lathe will cause damage to both.
- Do not use the chuck on heavy work where the chuck jaws project appreciably from the chuck body. Refer to the tables on page 6 to select the correct size chuck for the application.
- Do not clamp long work pieces in the chuck without additional support, this can cause heavy damage to the lathe and work environment .Refer to the table on this page for safety parameters.
- Always remove the chuck wrench before starting the machine.
- Do not remove the safety spring from the chuck wrench.
- Never operate the chuck if any parts are damaged ,missing or cracked.
- Do not tamper with the chuck. If an inaccuracy is found, check the spindle nose or adapter plate for true-running and make sure there is no dirt or foreign matter between the mounting faces.
- Never exceed maximum speed (RPM) of the chuck. The MAX RPM is stamped on the chuck face.
- Refer to the table on this page for recommended maximum speeds for self-centering chucks.
- Periodically inspect and service chucks for wear to avoid inadequate workholding conditions.
- Be sure top jaws are securely bolted to the master jaws.
- Never do any unauthorized chuck modifications.
- Always keep your chuck clean and lubricated.



Chuck Selection Guide

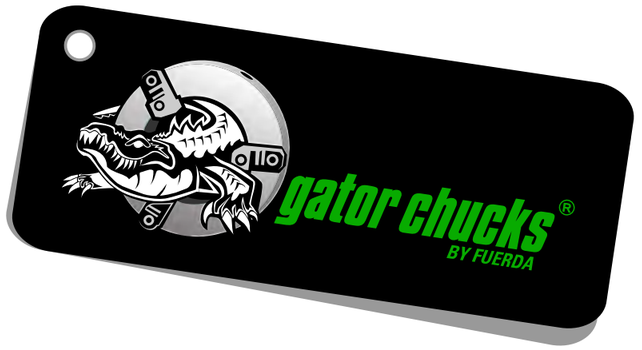
# Chuck Selection Guide

## Quick Reference


| Part No.. | Page |
|---|---|
| 1-101 | 7 |
| 1-102 | 7 |
| 1-103 | 8 |
| 1-104 | 8 |
| 1-105 | 47 |
| 1-106 | 47 |
| 1-107 | 48 |
| 1-108 | 48 |
| 1-115 | 49 |
| 1-119 | 139 |
| 1-125 | 50 |
| 1-151 | 27 |
| 1-152 | 27 |
| 1-153 | 28 |
| 1-154 | 28 |
| 1-201 | 72 |
| 1-202 | 72 |
| 1-203 | 73 |
| 1-204 | 73 |
| 1-205 | 71 |
| 1-207 | 128 |
| 1-211 | 74 |
| 1-221 | 75 |
| 1-241 | 76 |
| 1-301 | 98 |
| 1-302 | 97 |
| 1-311 | 100 |
| 1-312 | 99 |
| 1-317 | 134 |
| 1-321 | 102 |
| 1-322 | 101 |
| 1-901 | 145 |
| 1-903 | 145 |

| Part No.. | Page |
|---|---|
| BA-SCREWS | 49, 74 |
| CA-CAM STUDS | 50, 75 |
| FM-ADAPTERS | 55, 81 |
| FLA-ADAPTERS | 9, 29 |
| FLE-ADAPTERS | 147 |
| FLI-ADAPTERS | 103 |
| FS-E | 150 |
| FS-P | 20 |
| HR-P | 20, 40, 66 |
| HR-PEO- | 141 |
| IJ-PS3 | 18, 38, 64, 90 |
| IJ-PS4 | 64, 90 |
| IJ-PS6 | 18, 36 |
| MB-BA | 20, 20 |
| MB-PL | 128 |
| MJ-PEI- | 135 |
| MJ-PEO- | 140 |
| MJ-PI | 110 |
| MJ-PS2 | 88 |
| MJ-PS3 | 15, 35, 61, 87 |
| MJ-PS4 | 61, 87 |
| MJ-PS6 | 15, 35 |
| MJ-PSL | 129 |
| MT-J1 | 66, 92 |
| MT-J2 | 66, 92 |
| OJ-PS3 | 17, 37, 63, 89 |
| OJ-PS4 | 63, 89 |
| OJ-PS6 | 17, 37 |
| OS-PEI- | 136 |
| OS-PI | 113 |
| PH-L | 130 |

| Part No.. | Page |
|---|---|
| PH-P | 92 |
| PI-E | 150 |
| PI-PEO- | 141 |
| PI-PL | 130 |
| PI-PO | 20, 40, 66 |
| PI-PS | 92 |
| PS-P | 20, 40, 66 |
| RJ-PI | 111 |
| SC-PEO- | 141 |
| SC-PL | 130 |
| SC-PS | 20, 40, 66, 92 |
| SM-ADAPTERS | 51, 77 |
| SJ-PS3 | 19, 39, 65, 91 |
| SJ-PS4 | 65, 91 |
| SJ-PS6 | 19, 39 |
| STJ-PS1 | 16, 36, 62, 88 |
| STJ-PS2 | 88 |
| STJ-PS6 | 16, 36, 149 |
| TB-PEI | 136 |
| TB-PI | 113 |
| TJ-PEI- | 135 |
| TJ-PEO- | 140 |
| TJ-PI | 110 |
| TJ-PS3 | 14, 34, 60, 86 |
| TJ-PS4 | 60, 86 |
| TJ-PS6 | 14, 34 |
| W-P | 20, 40, 66, 92 |
| W-PEI | 136 |
| W-PEO | 141 |
| W-PL | 130 |
| W-PI | 114 |

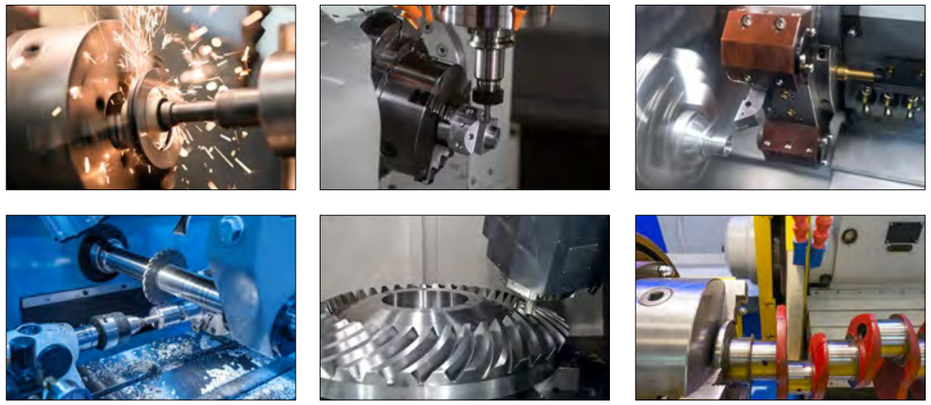



gator chucks® BY FUERDA

# PA SERIES

## Medium Duty Forged Steel Body Adjustable Scroll Chucks

PA Series Forged Steel Body Adjustable Scroll Chucks can be used for all high speed machining operations where universal chucks are unsuitable. High accuracy, versatility and durability make PA chucks invaluable in the modern workshops and indispensable in the tool rooms.



Tech-Tru™

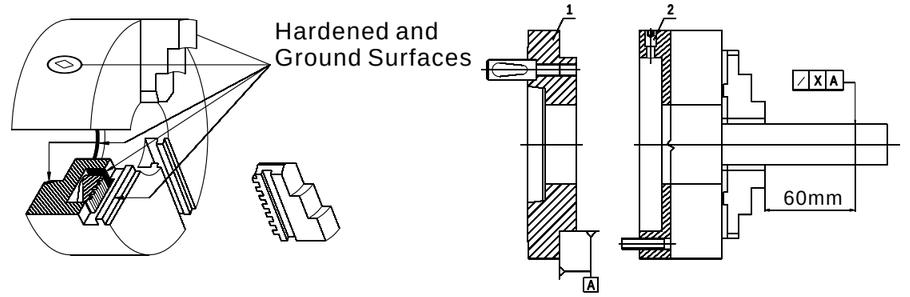


# PA Series - Steel Body Adjustable Scroll Chucks

Medium Duty
3-Jaw & 6-Jaw, With Fine Adjustment,
Forged Steel Body, 0.0004" T.I.R.

## Features and Benefits

- 3 pinion design.
- 4 micro-fine adjustment screws allow 0.0004" T.I.R. (4" thru 12-1/2" chucks).
- 8 micro-fine adjustment screws allow 0.0004" T.I.R. (15-3/4" thru 25" chucks).
- Two piece hard top & master jaws are American Standard tongue and groove.
- High quality forged steel body construction allows for higher lathe speed and longer life.
- Forged and hardened scrolls are precision ground and balanced for longer life and higher accuracy.
- Jaws and pinions are hardened and precision ground to increase life of the chuck.
- Each chuck is balanced within fine limit for the high speed machining.
- Steel adapter plates are interchangeable with PA Series chucks of the same size so that one chuck can be used on different lathe spindles.
- Proper chuck maintenance can extend the life of your PA chuck significantly.
- It must be cleaned and lubricated on a regular basis as recommended in Gator service instruction.
- For the best gripping results, use the Gator recommended chuck grease.
- The 6-jaw chucks grip firmly with less pressure and less distortion per jaw and they are ideal for thin wall and finishing operations. They eliminate the need for spring collets

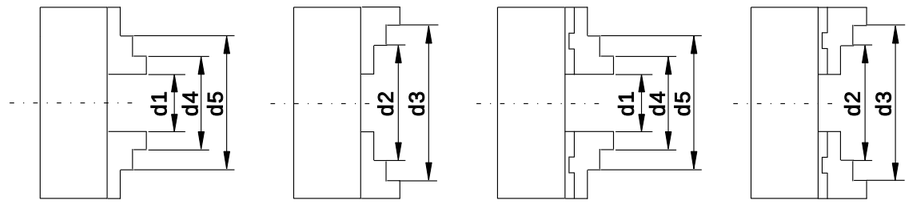





gator chucks® BY FUERDA
PA Series - Forged Steel Body Adjustable Scroll Chucks
Tech-Tru™
PA

# Clamping Ranges

- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Use proper jaws for rough and finishing machining.




## 3-Jaw Chucks

- with Solid Jaws
- with Two-Piece Jaws

| Chuck Dia. | mm | 100 | 125 | 160 | 200 | 250 | 315 | 400 | 500 | 630 | 800 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | inch | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
| Solid Jaws | d1 | .118-1.30 | .118-1.97 | .118-2.52 | .157-3.54 | .197-4.65 | .394-5.16 | - | - | - | - |
| | d2 | 1.26-2.44 | 1.54-3.27 | 1.97-4.21 | 2.36-5.71 | 3.03-7.40 | 3.54-8.46 | - | - | - | - |
| | d3 | 2.44-3.27 | 3.15-4.92 | 3.86-6.30 | 5.12-7.87 | 6.30-9.84 | 7.48-12.40 | - | - | - | - |
| | d4 | .98-2.20 | 1.34-2.91 | 1.65-3.94 | 2.05-5.31 | 2.44-6.85 | 3.07-7.87 | - | - | - | - |
| | d5 | 2.20-3.43 | 2.83-4.53 | 3.70-6.06 | 4.72-7.95 | 5.71-10.08 | 6.77-11.77 | - | - | - | - |
| Two-Piece Jaws | d1 | - | .118-1.97 | .118-2.52 | .157-3.54 | .197-4.65 | .394-5.16 | .394-7.09 | .787-9.25 | 1.18-13.19 | 5.9-18.98 |
| | d2 | - | 2.05-3.78 | 2.44-4.76 | 2.83-6.14 | 3.39-7.76 | 4.06-8.90 | 5.00-11.57 | 4.33-15.75 | 4.72-22.44 | 9.45-28.50 |
| | d3 | - | 3.74-4.92 | 4.53-6.30 | 5.24-7.87 | 6.30-9.84 | 7.48-12.40 | 9.06-15.75 | 7.48-19.69 | 7.87-24.80 | 12.44-31.50 |
| | d4 | - | 1.34-2.99 | 1.65-3.81 | 1.97-5.12 | 2.28-6.50 | 2.56-7.17 | 2.84-8.98 | 4.72-16.14 | 5.51-23.23 | 9.92-28.99 |
| | d5 | - | 2.95-4.65 | 3.46-5.75 | 4.13-7.48 | 4.92-9.25 | 5.71-10.43 | 6.50-12.95 | 7.87-19.09 | 8.27-26.18 | 12.91-31.97 |

## 6-Jaw Chucks

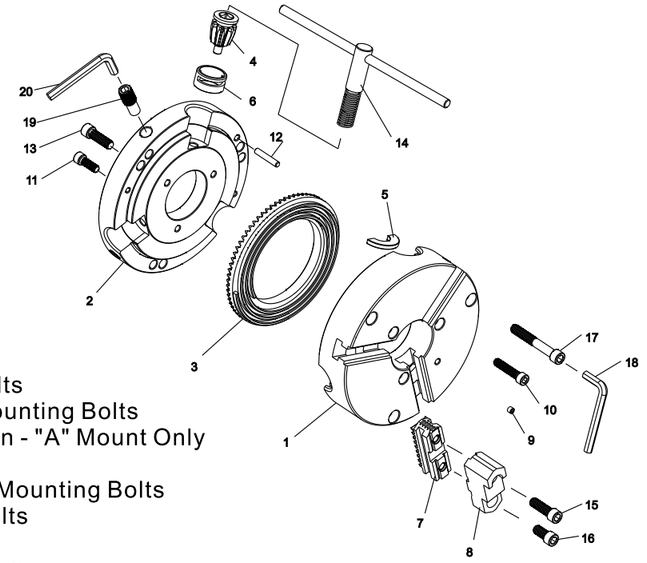
- with Solid Jaws
- with Two-Piece Jaws

| Chuck Dia. | mm | 100 | 125 | 160 | 200 | 250 | 315 | 400 | 500 | 630 | 800 |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | inch | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
| Solid Jaws | d1 | .118-1.299 | .236-1.69 | .315-2.51 | .315-3.54 | .47-4.65 | .47-5.16 | - | - | - | - |
| | d2 | 1.259-2.440 | 1.65-3.07 | 2.05-4.21 | 2.52-5.71 | 3.23-7.40 | 3.74-8.46 | - | - | - | - |
| | d3 | 2.440-3.661 | 3.27-4.72 | 4.02-6.30 | 5.20-7.87 | 6.50-9.84 | 7.56-12.40 | - | - | - | - |
| | d4 | 1.023-2.204 | 1.34-2.68 | 1.85-3.94 | 2.17-5.31 | 2.68-6.85 | 3.23-7.87 | - | - | - | - |
| | d5 | 2.244-3.425 | 2.91-4.33 | 3.86-6.06 | 4.76-7.95 | 5.91-10.08 | 7.01-11.77 | - | - | - | - |
| Two-Piece Jaws | d1 | - | .236-1.69 | .315-2.51 | .315-3.54 | .47-4.65 | .47-5.16 | .59-7.95 | 1.18-9.25 | 1.57-13.19 | 5.9-18.98 |
| | d2 | - | 1.97-3.43 | 2.64-4.76 | 2.91-6.14 | 3.23-7.40 | 4.25-8.90 | 5.20-11.65 | 4.76-15.83 | 5.20-21.85 | 9.45-28.50 |
| | d3 | - | 3.70-4.92 | 4.65-6.30 | 5.28-7.87 | 6.46-9.84 | 6.02-12.40 | 9.29-15.75 | 7.76-18.82 | 8.27-24.80 | 12.44-31.50 |
| | d4 | - | 1.30-2.75 | 1.77-3.82 | 2.05-5.12 | 2.68-6.85 | 2.68-7.17 | 2.87-9.92 | 5.31-16.26 | 5.91-23.03 | 9.92-28.99 |
| | d5 | - | 2.30-4.68 | 3.62-5.75 | 4.29-7.48 | 5.91-10.08 | 5.91-10.08 | 6.65-13.86 | 8.27-19.25 | 8.66-26.02 | 12.91-31.97 |



# Chuck Part Listing

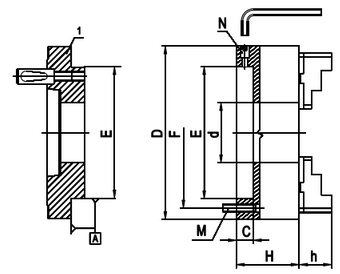
3-Jaw & 6-Jaw, Forged Steel Body
Adjustable Sroll Chucks, 0.0004" T.I.R.



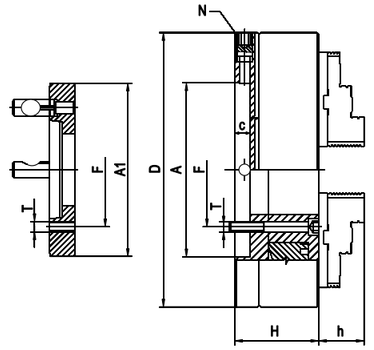

- 1. Chuck Body
- 2. Back Cover
- 3. Scroll Plate
- 4. Pinion
- 5. Pinion Half Ring
- 6. Pinion Sleeve
- 7. Hard Master Jaws
- 8. Hard Top Jaws
- 9. Grease Nipple
- 10.Chuck Mounting Bolts
- 11.&13. Back Cover Mounting Bolts
- 12. Spindle Locating Pin - "A" Mount Only
- 14. Chuck Wrench
- 15 & 16. Hard Top Jaw Mounting Bolts
- 17. Chuck Mounting Bolts
- 18 & 20. Hex Keys
- 19. Fine Adjustment Screw

| Chuck Dia. D | F | E | A1 | A | Hole d (max.) | H | 2-Piece Jaws h | Solid Jaws h | C | Mounting Bolts M & T Thread | Mounting Bolts M & T Qty. | Fine Adjustment Screws N Thread | Fine Adjustment Screws N Qty. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 3.2677 | 1.7717 | - | - | 0.787 | 2.677 | - | 0.63 | 0.51 | M8 x 1.25 | 3 | M10 x 1<br>M12 x 1* | 4 |
| 5" | 4.252 | 2.1654 | - | - | 1.378 | 2.362 | 1.575 | 0.787 | 0.59 | M8 x 1.25 | | M12 x 1 | |
| 6-1/4" | 5.5118 | 3.3858 | - | - | 1.654 | 2.677 | 1.71 | 1.26 | 0.67 | M10 x 1.5 | | | |
| 8" | 6.9291 | 4.3307 | - | - | 2.165 | 3.071 | 1.77 | 1.142 | 0.71 | M10 x 1.5 | | | |
| 10" | 8.8188 | 5.7086 | - | - | 2.992 | 3.504 | 2.05 | 1.339 | 0.79 | M12 x 1.75 | | | |
| 12-1/2" | 11.2598 | 7.0866 | - | - | 4.055 | 3.819 | 2.24 | 1.693 | 0.79 | M16 x 2 | | M18 x 1 | |
| 15-3/4" | 6.75 | - | 11.748 | 11.782 | 5.354 | 4.803 | 2.638 | - | 0.87 | 5/8" x 11 | 6 | | 8 |
| 20" | 9.252 | - | 16.022 | 16.032 | 7.48 | 5.669 | 3.11 | - | 1.18 | 3/4" x 10 | | | |
| 25" | 13 | - | 16.022 | 16.032 | 9.921 | 5.905 | 3.425 | - | 1.18 | 3/4" x 10 | | | |
| 31-1/2" | 14.5 | - | 22.820 | 22.835 | 10.500 | 6.220 | 3.642 | - | 1.18 | 1" x 8 | | | |

* For 6 jaw chucks only




- Chuck Diameters: 4" thru 12-1/2"

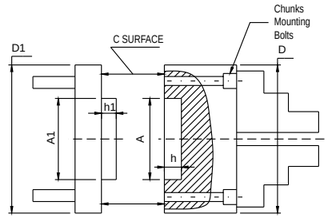


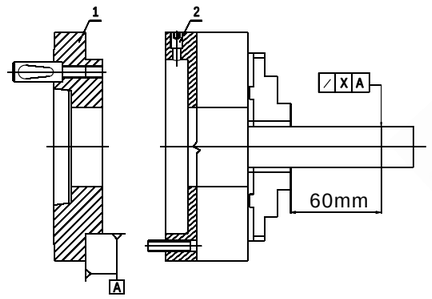

- Chuck Diameters: 15-3/4", 20" & 25"

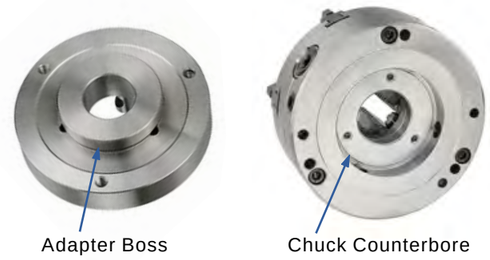
# Application for Adapter Plate

## Adapter Plate & Chuck mounting principles for 4" thru 12-1/2" chucks

A1 < A (A1 has to be always smaller than A & the clearance range between the chuck counterbore ID & adapter boss OD should be from 0.0078" to 0.0129" )
h1 < h (h1 has always to be smaller than h)
D1 = D (Adapter OD has the same diameter as chuck OD)
Installing chuck on the adapter plate or base plate be sure as well that chuck back surface "C" is in a full contact with adapter plate / base plate front surface "C". Both surfaces on the drawing are marked with a black bold line.

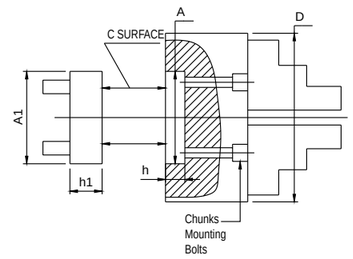


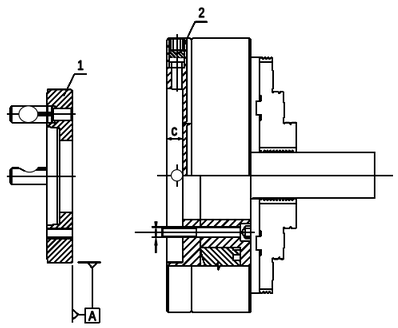



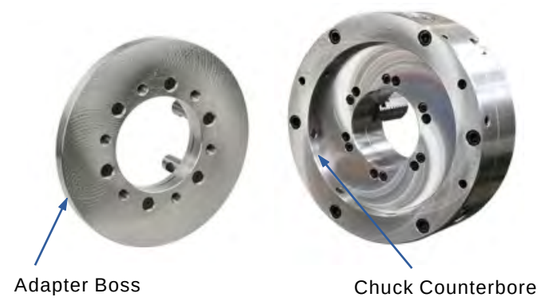




## Adapter Plate & Chuck mounting principles for 15-3/4" thru 31-1/2" chucks

A1 < A (A1 has to be always smaller than A & the clearance range between the chuck counterbore ID & adapter boss OD should be from 0.0141" to 0.0236" )
h1 < h (h1 has always to be larger than h)
D1 = A (Adapter OD has smaller diameter than chuck counterbore ID) Installing chuck on the adapter plate or base plate be sure as well that chuck counterbore bottom surface "C" is in a full contact with adapter plate / base plate front surface "C". Both surfaces on the drawing are marked with a black bold line.



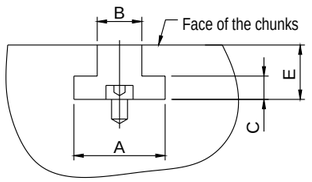






# Chuck Details

## 3-Jaw Chuck T-Slot Dimensions for 20" & 25" PA Chucks

| Chuck Dia. | A | B | C | E | T-Slot Length |
|---|---|---|---|---|---|
| 20" | .9055 | .5512 | .3937 | .8268 | 4.5276 |
| 25" | 1.2598 | .7087 | .5118 | 1.0236 | 5.1181 |
| 31-1/2" | 1.2598 | .7087 | .5118 | 1.0236 | 7.0866 |




## Chuck Eye Bolt Dimensions

From 10" up to 31-1/2"

| Chuck Dia. | Thread Size | Part No. |
|---|---|---|
| 10" | M10 x 1.75 | EB-M10 |
| 12-1/2" | M12 x 1.75 | EB-M12 |
| 15-3/4" | M12 x 1.75 | EB-M12 |
| 20" | M16 x 2 | EB-M16 |
| 25" | M16 x 2 | EB-M16 |
| 31-1/2" | M20 x 2.5 | EB-M20 |

# 3 & 6 Jaw Adjustable Scroll Chucks,0.0004" T.I.R.
## With Fine Adjustment, Forged Steel Body, 3 Pinion Design

### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 32", 40", 50" chucks are available on special order
- 20" & 25" chucks are provided with T-slots
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.378 | 3800 | .118-4.92 | 11 | PA3-5"A | 1-101-0500 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.654 | 3500 | .118-6.30 | 21 | PA3-6"A | 1-101-0600 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | W-P-160 |
| 8" | 2.165 | 3100 | .175-7.87 | 39 | PA3-8"A | 1-101-0800 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | W-P-200 |
| 10" | 2.992 | 2700 | .197-9.84 | 69 | PA3-10"A | 1-101-1000 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | W-P-250 |
| 12-1/2" | 4.055 | 2200 | .394-12.40 | 123 | PA3-12"A | 1-101-1200 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.354 | 1800 | .394-15.75 | 215 | PA3-16"A | 1-101-1600 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | W-P-400 |
| 20" | 7.480 | 1200 | .787-19.69 | 395 | PA3-20"A | 1-101-2000 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | W-P-500 |
| 25" | 9.921 | 1000 | 1.18-24.80 | 640 | PA3-25"A | 1-101-2500 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | W-P-630 |

32", 40", 50" chucks are available on special order.

**W-SP-Extended Wrenches available from stock.

See Page 20

### 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 15-3/4" to 32" chucks are available on special order.
- 20" & 25" chucks are provided with T-slots
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | ID - Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | .787 | 4200 | .118-3.27 | 9.0 | PA3-4" | 1-102-0400 | OJ-PS3-100 | IJ-PS3-100 | SJ-PS3-100 | W-P-100 |
| 5" | 1.378 | 3800 | .118-4.92 | 12 | PA3-5" | 1-102-0500 | OJ-PS3-125 | IJ-PS3-125 | SJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.654 | 3500 | .118-6.30 | 24 | PA3-6" | 1-102-0600 | OJ-PS3-160 | IJ-PS3-160 | SJ-PS3-160 | W-P-160 |
| 8" | 2.165 | 3100 | .175-7.87 | 41 | PA3-8" | 1-102-0800 | OJ-PS3-200 | IJ-PS3-200 | SJ-PS3-200 | W-P-200 |
| 10" | 2.992 | 2700 | .197-9.84 | 71 | PA3-10" | 1-102-1000 | OJ-PS3-250 | IJ-PS3-250 | SJ-PS3-250 | W-P-250 |
| 12-1/2" | 4.055 | 2200 | .394-12.40 | 126 | PA3-12" | 1-102-1200 | OJ-PS3-315 | IJ-PS3-315 | SJ-PS3-315 | W-P-315 |

15-3/4" to 32" chucks are available on special order.

**W-SP-Extended Wrenches available from stock.

See Page 20



3 & 6 Jaw Adjustable Scroll Chucks,0.0004" T.I.R.
With Fine Adjustment, Forged Steel Body, 3 Pinion Design

### 6-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 32", 40", 50" chucks are available on special order
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.378 | 3000 | .236-4.72 | 15 | PA6-5"A | 1-103-0500 | TJ-PS6-125 | MJ-PS6-125 | STJ-PS6-125 | W-P-125 |
| 6-1/4" | 1.654 | 2500 | .315-6.30 | 27 | PA6-6"A | 1-103-0600 | TJ-PS6-160 | MJ-PS6-160 | STJ-PS6-160 | W-P-160 |
| 8" | 2.165 | 2200 | .315-7.87 | 41 | PA6-8"A | 1-103-0800 | TJ-PS6-200 | MJ-PS6-200 | STJ-PS6-200 | W-P-200 |
| 10" | 2.992 | 1900 | .47-9.84 | 72 | PA6-10"A | 1-103-1000 | TJ-PS6-250 | MJ-PS6-250 | STJ-PS6-250 | W-P-250 |
| 12-1/2" | 4.055 | 1500 | .47-12.40 | 115 | PA6-12"A | 1-103-1200 | TJ-PS6-315 | MJ-PS6-315 | STJ-PS6-315 | W-P-315 |
| 15-3/4" | 5.354 | 1500 | .59-15.75 | 240 | PA6-16"A | 1-103-1600 | TJ-PS6-400 | MJ-PS6-400 | STJ-PS6-400 | W-P-400 |
| 20" | 7.480 | 800 | 1.18-18.82 | 408 | PA6-20"A | 1-103-2000 | TJ-PS6-500 | MJ-PS6-500 | STJ-PS6-500 | W-P-500 |
| 25" | 9.921 | 700 | 1.57-24.80 | 652 | PA6-25"A | 1-103-2500 | TJ-PS6-630 | MJ-PS6-630 | STJ-PS6-630 | W-P-630 |

32", 40", 50" chucks are available on special order.

**W-SP-Extended Wrenches available from stock.

See Page 20

### 6-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 15-3/4" to 25" chucks are available on special order.
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | ID - Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | .787 | 4000 | .118-3.661 | 10 | PA6-4" | 1-104-0400 | OJ-PS6-100 | IJ-PS6-100 | SJ-PS6-100 | W-P-100 |
| 5" | 1.378 | 3000 | .236-4.72 | 16 | PA6-5" | 1-104-0500 | OJ-PS6-125 | IJ-PS6-125 | SJ-PS6-125 | W-P-125 |
| 6-1/4" | 1.654 | 2500 | .315-6.30 | 29 | PA6-6" | 1-104-0600 | OJ-PS6-160 | IJ-PS6-160 | SJ-PS6-160 | W-P-160 |
| 8" | 2.165 | 2200 | .315-7.87 | 42 | PA6-8" | 1-104-0800 | OJ-PS6-200 | IJ-PS6-200 | SJ-PS6-200 | W-P-200 |
| 10" | 2.992 | 1900 | .47-9.84 | 79 | PA6-10" | 1-104-1000 | OJ-PS6-250 | IJ-PS6-250 | SJ-PS6-250 | W-P-250 |
| 12-1/2" | 4.055 | 1500 | .47-12.40 | 150 | PA6-12" | 1-104-1200 | OJ-PS6-315 | IJ-PS6-315 | SJ-PS6-315 | W-P-315 |

15-3/4" to 25" chucks are available on special order.

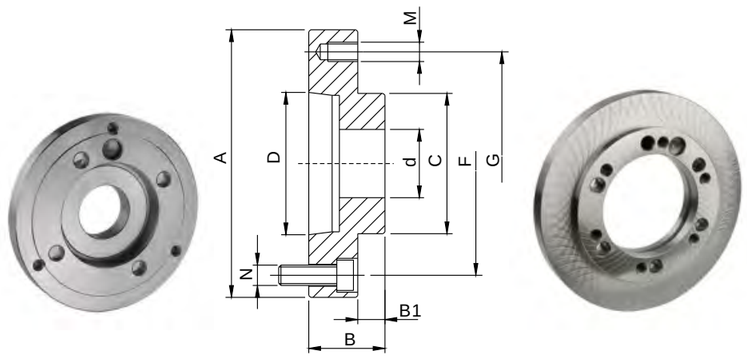
**W-SP-Extended Wrenches available from stock.

See Page 20

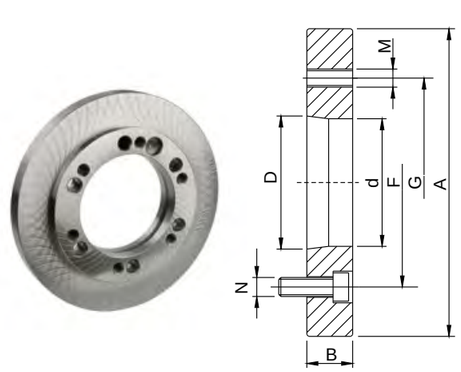
# FLA Series Adapter Plate

## Type A1/A2 Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters come with spindle mounting bolts
- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

| Chuck Dia. | Taper Size | OD A | D | Thru Hole d | F | C | G | Chuck Mountng Bolts M | B1 | B | Spindle Mounting Bolts N | Spindle Mounting Bolts QTY | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | A4 | 4.92 | 2.5005 | 1.378 | 3.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.42 | 7/16-14 | 4 | 4.8 | FLA-125/A4 |
| | A5 | 4.92 | 3.2505 | 1.378 | 4.126 | 2.164 | 4.252 | M8x1.25 | .55 | 1.42 | 7/16-14 | 4 | 4.2 | FLA-125/A5 |
| | A6 | 6.30 | 4.1880 | 1.378 | 5.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.89 | 1/2-13 | 4 | 9.1 | FLA-125/A6 |
| 6-1/4" | A5 | 6.30 | 3.2505 | 1.654 | 4.126 | 3.385 | 5.512 | M10x1.50 | .63 | 1.46 | 7/16-14 | 4 | 6.77 | FLA-160/A5 |
| | A6 | 6.30 | 4.1880 | 1.654 | 5.252 | 3.385 | 5.512 | M10x1.50 | .63 | 1.46 | 1/2-13 | 4 | 6.97 | FLA-160/A6 |
| 8" | A4 | 7.87 | 2.5005 | 2.165 | 3.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.46 | 7/16-14 | 4 | 9.3 | FLA-200/A4 |
| | A5 | 7.87 | 3.2505 | 2.165 | 4.126 | 4.330 | 6.929 | M10x1.50 | .67 | 1.46 | 7/16-14 | 4 | 13.5 | FLA-200/A5 |
| | A6 | 7.87 | 4.1880 | 2.165 | 5.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.49 | 1/2-13 | 4 | 12.6 | FLA-200/A6 |
| 10" | A5 | 9.84 | 3.2505 | 2.992 | 4.126 | 5.708 | 8.819 | M12x1.75 | .75 | 1.49 | 7/16-14 | 4 | 17.3 | FLA-250/A5 |
| | A6 | 9.84 | 4.1880 | 2.992 | 5.252 | 5.708 | 8.819 | M12x1.75 | .75 | 1.49 | 1/2-13 | 4 | 17.3 | FLA-250/A6 |
| | A8 | 9.84 | 5.5007 | 2.992 | 6.748 | 5.708 | 8.819 | M12x1.75 | .75 | 1.81 | 5/8-11 | 4 | 20.2 | FLA-250/A8 |
| 12-1/2" | A6 | 12.40 | 4.1880 | 4.055 | 5.252 | 7.076 | 11.260 | M16x2 | .75 | 1.49 | 1/2-13 | 4 | 27.3 | FLA-315/A6 |
| | A8 | 12.40 | 5.5007 | 4.055 | 6.748 | 7.076 | 11.260 | M16x2 | .75 | 1.81 | 5/8-11 | 4 | 35.7 | FLA-315/A8 |
| | A11 | 12.40 | 7.7507 | 4.055 | 9.252 | 7.076 | 11.260 | M16x2 | .75 | 2.17 | 3/4-10 | 4 | 41.2 | FLA-315/A11 |
| 15-3/4" | A6 | 11.75 | 4.1880 | 4.055 | 5.252 | - | 6.748 | 5/8-11 | - | 1.38 | 1/2-13 | 6 | 31.4 | FLA-400/A6 |
| | A8 | 11.75 | 5.5007 | 5.354 | 6.748 | - | 6.748 | 5/8-11 | - | 1.46 | 5/8-11 | 6 | 28.8 | FLA-400/A8 |
| | A11 | 11.75 | 7.7507 | 5.354 | 9.252 | - | 6.748 | 5/8-11 | - | 1.89 | 3/4-10 | 6 | 35.8 | FLA-400/A11 |
| 20" | A8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 9.252 | 3/4-10 | - | 1.42 | 5/8-11 | 6 | 69 | FLA-500/A8 |
| | A11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 9.252 | 3/4-10 | - | 1.42 | 3/4-10 | 6 | 61 | FLA-500/A11 |
| 25" | A8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 13.000 | 3/4-10 | - | 1.42 | 5/8-11 | 6 | 69 | FLA-630/A8 |
| | A11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 13.000 | 3/4-10 | - | 1.42 | 3/4-10 | 6 | 61 | FLA-630/A11 |
| | A15 | 16.02 | 11.2505 | 9.92 | 13.00 | - | 13.000 | 3/4-10 | - | 2.05 | 7/8-9 | 6 | 76 | FLA-630/A15 |

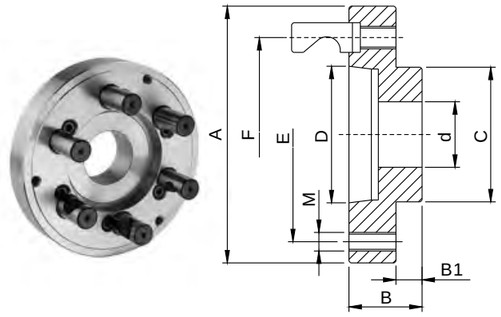
Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counterbore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counterbore and adapter boss OD is from 0.0141" to 0.0236"



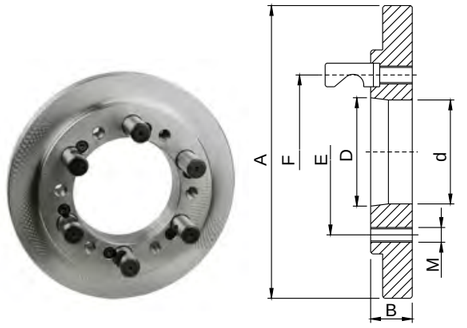
FLA Series Adapter Plate

## Type D1 Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters come with spindle mounting camlock studs
- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

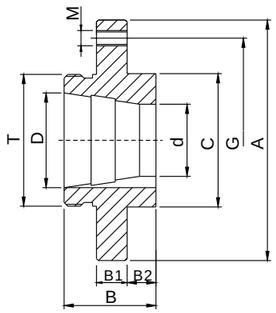
| Chuck Dia. | Taper Size | OD A | D | Thru Hole d | F | C | E | Chuck Mountng Bolts M | B1 | B | Camlock Stud OD | Camlock Stud QTY | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | D1-3 | 4.92 | 2.1250 | 1.378 | 2.78 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 9/16" | 3 | 5.95 | FLA-125/D3 |
| | D1-4 | 4.92 | 2.5005 | 1.378 | 3.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 5/8" | 3 | 5.73 | FLA-125/D4 |
| | D1-5 | 4.92 | 3.2505 | 1.378 | 4.126 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 3/4" | 6 | 5.73 | FLA-125/D5 |
| 6-1/4" | D1-3 | 6.30 | 2.1250 | 1.654 | 2.78 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 9/16" | 3 | 10.80 | FLA-160/D3 |
| | D1-4 | 6.30 | 2.5005 | 1.654 | 3.252 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 5/8" | 3 | 9.92 | FLA-160/D4 |
| | D1-5 | 6.30 | 3.2505 | 1.654 | 4.126 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 3/4" | 6 | 9.89 | FLA-160/D5 |
| 8" | D1-4 | 7.87 | 2.5005 | 2.165 | 3.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.30 | 5/8" | 3 | 10.36 | FLA-200/D4 |
| | D1-5 | 7.87 | 3.2505 | 2.165 | 4.126 | 4.330 | 6.929 | M10x1.50 | .67 | 1.85 | 3/4" | 6 | 15.87 | FLA-200/D5 |
| | D1-6 | 7.87 | 4.1880 | 2.165 | 5.252 | 4.330 | 6.929 | M10x1.50 | .67 | 2.01 | 7/8" | 6 | 17.64 | FLA-200/D6 |
| 10" | D1-5 | 9.84 | 3.2505 | 2.992 | 4.126 | 5.708 | 8.819 | M12x1.75 | .75 | 1.50 | 3/4" | 6 | 17.64 | FLA-250/D5 |
| | D1-6 | 9.84 | 4.1880 | 2.992 | 5.252 | 5.708 | 8.819 | M12x1.75 | .75 | 2.09 | 7/8" | 6 | 28.44 | FLA-250/D6 |
| | D1-8 | 9.84 | 5.5007 | 2.992 | 6.748 | 5.708 | 8.819 | M12x1.75 | .75 | 2.36 | 1" | 6 | 32.41 | FLA-250/D8 |
| 12-1/2" | D1-6 | 12.40 | 4.1880 | 4.055 | 5.252 | 7.076 | 11.260 | M16x2 | .75 | 1.50 | 7/8" | 6 | 28.44 | FLA-315/D6 |
| | D1-8 | 12.40 | 5.5007 | 4.055 | 6.748 | 7.076 | 11.260 | M16x2 | .75 | 2.24 | 1" | 6 | 47.84 | FLA-315/D8 |
| | D1-11 | 12.40 | 7.7507 | 4.055 | 9.252 | 7.076 | 11.260 | M16x2 | .75 | 2.52 | 1-3/16" | 6 | 52.91 | FLA-315/D11 |
| 15-3/4" | D1-6 | 11.75 | 4.1880 | 4.055 | 5.252 | - | 6.748 | 5/8-11 | - | 1.38 | 7/8" | 6 | 29.0 | FLA-400/D6 |
| | D1-8 | 11.75 | 5.5007 | 5.354 | 6.748 | - | 6.748 | 5/8-11 | - | 1.50 | 1" | 6 | 27.2 | FLA-400/D8 |
| | D1-11 | 11.75 | 7.7507 | 5.354 | 9.252 | - | 6.748 | 5/8-11 | - | 1.89 | 1-3/16" | 6 | 26.8 | FLA-400/D11 |
| 20" | D1-8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 9.252 | 3/4-10 | - | 1.42 | 1" | 6 | 74 | FLA-500/D8 |
| | D1-11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 9.252 | 3/4-10 | - | 1.73 | 1-3/16" | 6 | 78 | FLA-500/D11 |
| 25" | D1-8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 13.000 | 3/4-10 | - | 1.42 | 1" | 6 | 74 | FLA-630/D8 |
| | D1-11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 13.000 | 3/4-10 | - | 1.73 | 1-3/16" | 6 | 78 | FLA-630/D11 |
| | D1-15 | 16.02 | 11.2505 | 9.92 | 13.00 | - | 13.000 | 3/4-10 | - | 2.05 | 1-3/8" | 6 | 77 | FLA-630/D15 |

Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counterbore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counterbore and adapter boss OD is from 0.0141" to 0.0236"

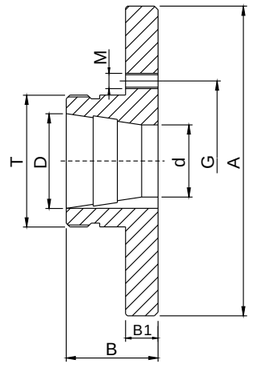
# FLA Series Adapter Plate

## Type L Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

| Chuck Dia. | Taper Size | OD A | Thread T - UNS3 | D | Thru Hole d | C | G | Chuck Mountng Bolts M | B1 | B2 | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | L00 | 6.30 | 3-3/4 - 6 | 2.750 | 2.20 | 3.385 | 5.512 | M10x1.50 | .79 | .63 | 2.52 | 9.0 | FLA-160/L00 |
| 6-1/4" | L0 | 6.30 | 4-1/2 - 6 | 3.250 | 2.60 | 3.385 | 5.512 | M10x1.50 | .79 | .63 | 2.56 | 9.5 | FLA-160/L0 |
| 8" | L00 | 7.87 | 3-3/4 - 6 | 2.750 | 2.20 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.56 | 15.0 | FLA-200/L00 |
| 8" | L0 | 7.87 | 4-1/2 - 6 | 3.250 | 2.60 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.56 | 15.4 | FLA-200/L0 |
| 8" | L1 | 7.87 | 6 - 6 | 4.125 | 3.33 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.99 | 16.5 | FLA-200/L1 |
| 10" | L00 | 9.84 | 3-3/4 - 6 | 2.750 | 2.20 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.76 | 25 | FLA-250/L00 |
| 10" | L0 | 9.84 | 4-1/2 - 6 | 3.250 | 2.60 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.76 | 26 | FLA-250/L0 |
| 10" | L1 | 9.84 | 6 - 6 | 4.125 | 3.33 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.99 | 37 | FLA-250/L1 |
| 12-1/2" | L0 | 12.40 | 4-1/2 - 6 | 3.250 | 2.60 | 7.076 | 11.260 | M16x2 | .91 | .75 | 2.76 | 37 | FLA-315/L0 |
| 12-1/2" | L1 | 12.40 | 6 - 6 | 4.125 | 3.33 | 7.076 | 11.260 | M16x2 | .91 | .75 | 2.99 | 37 | FLA-315/L1 |
| 12-1/2" | L2 | 12.40 | 7-3/4 - 5 | 5.250 | 4.29 | 7.076 | 11.260 | M16x2 | .91 | .75 | 3.50 | 39 | FLA-315/L2 |
| 15-3/4" | L1 | 11.75 | 6 - 6 | 4.125 | 3.33 | 11.75 | 6.748 | 5/8-11 | .87 | - | 2.95 | 34 | FLA-400/L1 |
| 15-3/4" | L2 | 11.75 | 7-3/4 - 5 | 5.250 | 4.29 | 11.75 | 6.748 | 5/8-11 | .87 | - | 3.50 | 45 | FLA-400/L2 |
| 15-3/4" | L3 | 11.75 | 10-3/8 - 4 | 6.500 | 5.43 | 11.75 | 6.748 | 5/8-11 | .87 | - | 3.94 | 67 | FLA-400/L3 |
| 20" | L2 | 16.02 | 7-3/4 - 5 | 5.250 | 4.29 | 16.02 | 9.252 | 3/4-10 | 1.18 | - | 3.66 | 60 | FLA-500/L2 |

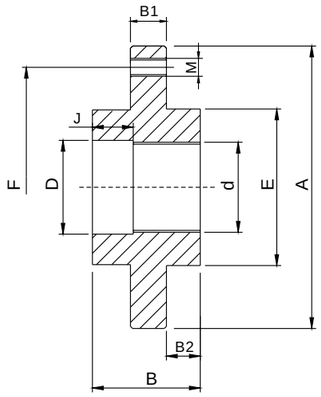
Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0141" to 0.0236"



FLA Series Adapter Plate

## Type "T" Threaded Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters are heat treaded for longer life
- All adapters do not require any additional machining



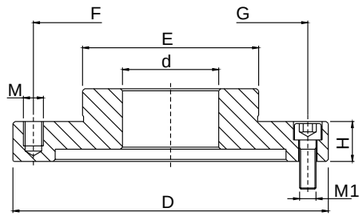

| Chuck Dia. | Thread d | OD A | D | E | F | B | B2 | B1 | M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1-10 UNS-2B | 3.94 | 1.0150 | 1.771 | 3.268 | 1.54 | .47 | .51 | M8x1.25 | 4.85 | FLA-100/T1 |
| | 1-1/2 - 8 UN-2B | 3.94 | 1.5150 | 1.771 | 3.268 | 1.54 | .47 | .51 | M8x1.25 | 5.29 | FLA-100/T2 |
| 5" | 1-1/8 - 12 W | 4.92 | 1.2496 | 2.164 | 4.252 | 1.54 | .55 | .51 | M8x1.25 | 4.05 | FLA-125/T3 |
| | 1-1/2 - 8 UN-2B | 4.92 | 1.5150 | 2.164 | 4.252 | 1.97 | .59 | .51 | M8x1.25 | 6.61 | FLA-125/T2 |
| | 2-3/16 - 10 Hardinge | 4.92 | 2.1889 | 2.164 | 4.252 | 2.85 | .79 | .51 | M8x1.25 | 7.05 | FLA-125/T4 |
| | 2-1/4 - 8 UN-2B | 4.92 | 2.2600 | 2.164 | 4.252 | 2.95 | .79 | .51 | M8x1.25 | 6.80 | FLA-125/T5 |
| 6-1/4" | 1-1/2 - 8 UN-2B | 6.30 | 1.5150 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.05 | FLA-160/T2 |
| | 2-3/16 - 10 Hardinge | 6.30 | 2.1889 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.50 | FLA-160/T4 |
| | 2-1/4 - 8 UN-2B | 6.30 | 2.2600 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.94 | FLA-160/T5 |
| 8" | 1-1/2 - 8 UN-2B | 7.78 | 1.5150 | 4.330 | 6.929 | 1.97 | .67 | .79 | M10x1.50 | 9.92 | FLA-200/T2 |
| | 2-1/4 - 8 UN-2B | 7.78 | 2.2600 | 4.330 | 6.929 | 2.05 | .67 | .79 | M10x1.50 | 11.46 | FLA-200/T5 |
| | 2-3/8 - 6 UN-2B | 7.78 | 2.3850 | 4.330 | 6.929 | 2.05 | .67 | .79 | M10x1.50 | 13.89 | FLA-200/T6 |
| 10" | 2-3/8 - 6 UN-2B | 9.87 | 2.3850 | 5.708 | 8.819 | 2.05 | .75 | .75 | M12x1.75 | 30 | FLA-250/T6 |
| 12-1/2" | 2-3/8 - 6 UN-2B | 12.40 | 2.3850 | 7.076 | 11.260 | 2.05 | .75 | .94 | M16x2 | 50 | FLA-315/T6 |

Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"

# BPA Series Low Profile Base Plates

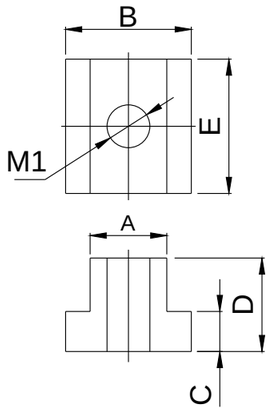
## BPA Base Plate
## for PA Series & PB Series chucks

- Designed for use with 3 & 6 jaw scroll front mount adjustable body chucks with 0.0004" T.I.R.
- Mounting bolts and T-Nuts included.
- Made of Hardened steel.




| Chuck Dia. | OD D | E | F | G | H | M Chuck Mounting Botls | M1 | d | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 4.921 | 2.164 | 4.25 | 4.252 | 0.551 | M8 x 1.25 | M6 | 1.875 | 3.8 | BPA-125 |
| 6-1/4" | 6.299 | 3.385 | 5.512 | 5.512 | 0.630 | M10 x 1.5 | M8 | 1.850 | 5.5 | BPA-160 |
| 8" | 7.874 | 4.330 | 6.929 | 6.929 | 0.709 | M10 x 1.5 | M8 | 2.362 | 7.7 | BPA-200 |
| 10" | 9.843 | 5.708 | 8.819 | 8.819 | 0.787 | M12 x 1.75 | M10 | 3.189 | 12.9 | BPA-250 |
| 12-1/2" | 12.402 | 7.086 | 11.26 | 11.26 | 0.984 | M16 x 2 | M10 | 4.252 | 23.9 | BPA-315 |
| 15-3/4" | 11.750 | 11.750 | 6.748 | 10.236 | 1.181 | 5/8"-11 | M12 | 5.551 | 40.3 | BPA-400 |
| 20" | 16.024 | 16.020 | 9.252 | 14.173 | 1.378 | 3/4"-10 | M16 | 7.677 | 60.2 | BPA-500 |

| Chuck Dia. | M1 | A | B | C | D | E |
|---|---|---|---|---|---|---|
| 5" | M6 | .3150 | .5118 | .1969 | .3543 | .5118 |
| 6-1/4" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 8" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 10" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 12-1/2" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 15-3/4" | M12 | .5512 | .8661 | .3150 | .6299 | .8661 |
| 20" | M16 | .7087 | 1.1024 | .3937 | .7874 | 1.1024 |

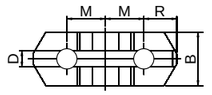


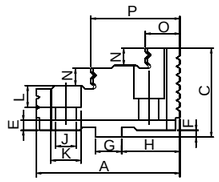





## Hard Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



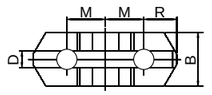
5" to 12-1/2"

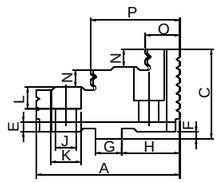
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |

## Hard Top Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



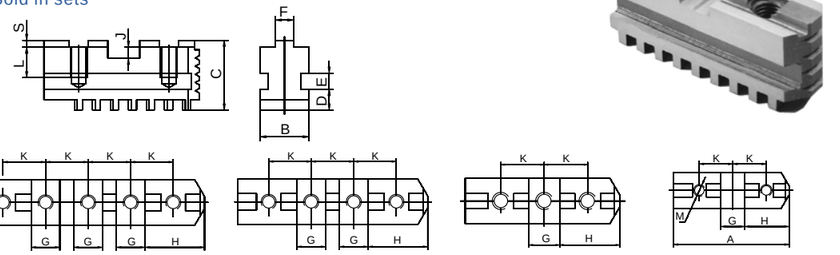



| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 1.90 | TJ-PS6-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 2.40 | TJ-PS6-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 4.20 | TJ-PS6-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 6.40 | TJ-PS6-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 10.20 | TJ-PS6-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 14.60 | TJ-PS6-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 28.80 | TJ-PS6-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 44.20 | TJ-PS6-630 |

# Jaws - Hard Master Jaws

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

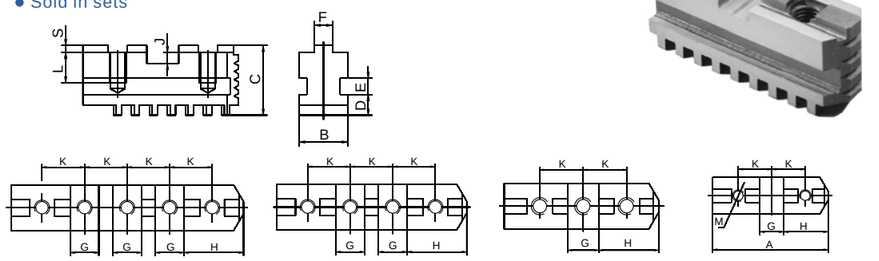



■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 0.93 | MJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS3-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS3-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS3-800 |

## Hard Master Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets




■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

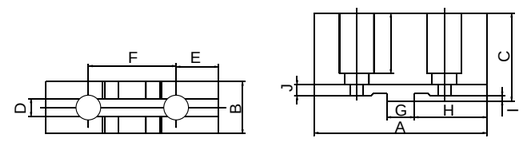
| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 1.90 | MJ-PS6-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 2.40 | MJ-PS6-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 4.20 | MJ-PS6-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 6.40 | MJ-PS6-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 10.20 | MJ-PS6-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 14.60 | MJ-PS6-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 28.80 | MJ-PS6-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 44.20 | MJ-PS6-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 44.20 | MJ-PS6-800 |



# Jaws - Soft Top Jaws

## Soft Top Jaws, For 3-Jaw Chucks

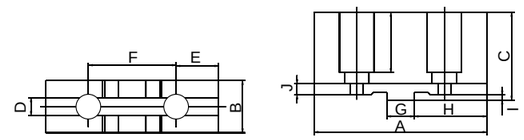
- American Standard Tongue & Groove Jaws
- Sold by piece




| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS1-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS1-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS1-630 |

## Soft Top Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold by piece

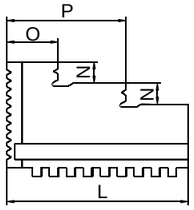


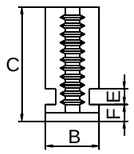

| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS6-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS6-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS6-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS6-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS6-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS6-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS6-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS6-630 |

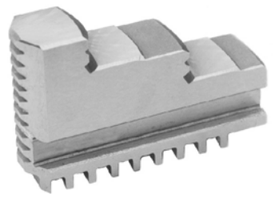
# Jaws - ID Jaws

## ID Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets



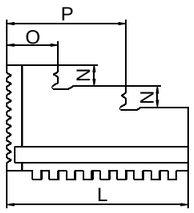



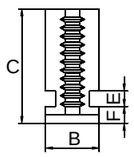



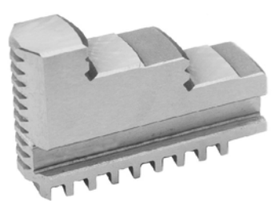
| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS3-500 |

## ID Hard Solid Jaws, For 6-Jaw Chucks

- Sold in sets



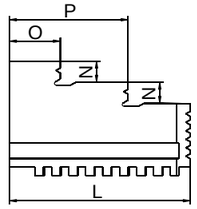
| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS6-500 |

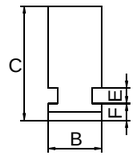


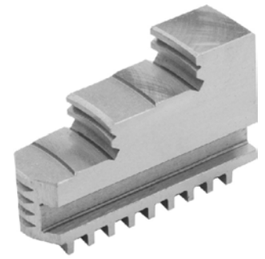
# Jaws - OD Jaws

## OD Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets



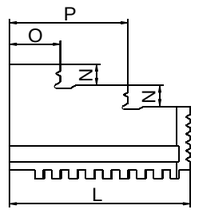



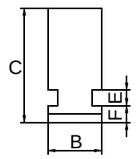



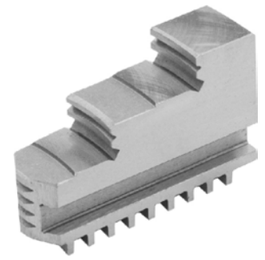
| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS3-500 |

## OD Hard Solid Jaws, For 6-Jaw Chucks

- Sold in sets



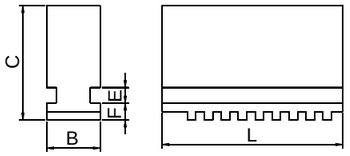



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS6-500 |

# Jaws - Soft Solid Jaws

## Soft Solid Jaws, For 3-Jaw Chucks

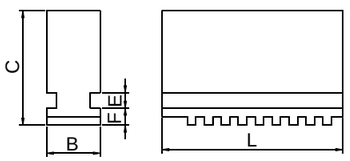
- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS3-500 |

## Soft Solid Jaws, For 6-Jaw Chucks

- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS6-500 |



# Spare Parts

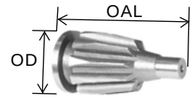
## Scroll Plates

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | SC-PS-100 | 2.7323 |
| 5" | SC-PS-125 | 3.7008 |
| 6-1/4" | SC-PS-160 | 4.8819 |
| 8" | SC-PS-200 | 6.2598 |
| 10" | SC-PS-250 | 7.7953 |
| 12-1/2" | SC-PS-315 | 10.1575 |
| 15-3/4" | SC-PS-400 | 12.9134 |
| 20" | SC-PS-500 | 16.4173 |
| 25" | SC-PS-630 | 21.3386 |

## Pinions

- Sold by piece




| Chuck Dia. | Part No. | OD | OAL |
|---|---|---|---|
| 4" | PI-PS-100 | .9843 | 1.3976 |
| 5" | PI-PO-125 | .9843 | 1.3268 |
| 6-1/4" | PI-PO-160 | 1.1024 | 1.6063 |
| 8" | PI-PO-200 | 1.1811 | 1.9882 |
| 10" | PI-PO-250 | 1.3583 | 2.2638 |
| 12-1/2" | PI-PO-315 | 1.4764 | 2.8543 |
| 15-3/4" | PI-PO-400 | 1.7323 | 3.6614 |
| 20" | PI-PO-500 | 1.9685 | 3.8780 |
| 25" | PI-PO-630 | 2.0472 | 4.7087 |

## Pinion Sleeves

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | - | - |
| 5" | PS-P-125 | 1.2205 |
| 6-1/4" | PS-P-160 | 1.4173 |
| 8" | PS-P-200 | 1.4961 |
| 10" | PS-P-250 | 1.6732 |
| 12-1/2" | PS-P-315 | 1.7913 |
| 15-3/4" | PS-P-400 | 2.0472 |
| 20" | PS-P-500 | 2.3622 |
| 25" | PS-P-630 | 2.4409 |

## Half Rings

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | - | - |
| 5" | HR-P-125 | 1.4567 |
| 6-1/4" | HR-P-160 | 1.7323 |
| 8" | HR-P-200 | 1.8504 |
| 10" | HR-P-250 | 2.0669 |
| 12-1/2" | HR-P-315 | 2.1654 |
| 15-3/4" | HR-P-400 | 2.4213 |
| 20" | HR-P-500 | 2.8346 |
| 25" | HR-P-630 | 2.9134 |

## Fine Adjustment Screws

- Sold by piece

| Chuck Dia. | Part No. | Thread Size | OAL |
|---|---|---|---|
| 4" | FS-P-100 | M10 x 1 | 1.0039 |
| 5" | FS-P-125 | M12 x 1 | 1.2992 |
| 6-1/4" | FS-P-160 | M18 x 1 | 1.4567 |
| 8" | FS-P-200 | M18 x 1 | 1.7323 |
| 10" | FS-P-250 | M18 x 1 | 1.9094 |
| 12-1/2" | FS-P-315 | M18 x 1 | 2.5394 |
| 15-3/4" | FS-P-400 | M18 x 1 | 1.9094 |
| 20" | FS-P-500 | M18 x 1 | 1.7323 |
| 25" | FS-P-630 | M18 x 1 | 4.2520 |

## Chuck Mounting Bolts

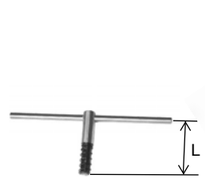
- Sold by piece

| Chuck Dia. | Part No. | Thread Size |
|---|---|---|
| 4" | MB-BA-100 | M8 |
| 5" | MB-BA-125 | M8 |
| 6-1/4" | MB-BA-160 | M10 |
| 8" | MB-BA-200 | M10 |
| 10" | MB-BA-250 | M12 |
| 12-1/2" | MB-BA-315 | M12 |
| 15-3/4" | MB-BA-400 | 5/8"-11 |
| 20" | MB-BA-500 | 3/4"-10 |
| 25" | MB-BA-630 | 3/4"-10 |

## Wrenches (Standard & Extended)

- Sold by piece

| Chuck Dia. | Square Size | Standard | | Extended | |
|---|---|---|---|---|---|
| | | L | Part No. | L | Part No. |
| 4" | .3543 | 3.15 | W-P-100 | - | - |
| 5" | .3543 | 3.15 | W-P-125 | - | - |
| 6-1/4" | .4331 | 3.90 | W-P-160 | 7.87 | W-SP-160 |
| 8" | .4331 | 3.90 | W-P-200 | 10.02 | W-SP-200 |
| 10" | .5512 | 4.78 | W-P-250 | 8.74 | W-SP-250 |
| 12-1/2" | .5512 | 4.76 | W-P-315 | 10.87 | W-SP-315 |
| 15-3/4" | .6693 | 5.51 | W-P-400 | 10.75 | W-SP-400 |
| 20" | .7480 | 9.06 | W-P-500 | 18.11 | W-SP-500 |
| 25" | .7480 | 9.06 | W-P-630 | - | - |




Standard Wrench  Extended Wrench

# PB SERIES

## Medium Duty Semi-Steel Body Adjustable Scroll Chucks

PB Series Semi-Steel Body Adjustable Scroll Chucks can be used for all machining operations where universal direct mount chucks are unsuitable. High quality, versatility and durability make PB chucks more affordable in workshops and indispensable in the tool rooms

**Tech-Tru™**

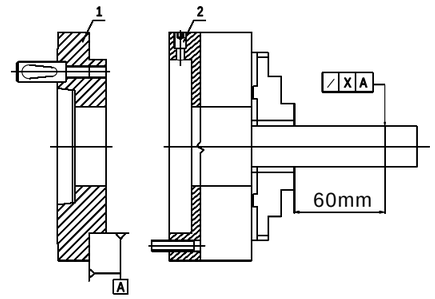


# PB Series - Semi-Steel Body Adjustable Scroll Chucks

Medium Duty
3-Jaw & 6-Jaw, With Fine Adjustment,
Semi-Steel Body, 0.0004" T.I.R.

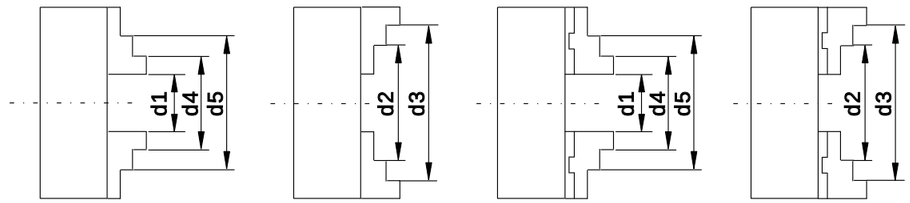
## Features and Benefits

- 3 pinion design.
- 4 micro-fine adjustment screws allow 0.0004" T.I.R. (4" thru 12-1/2" chucks).
- 8 micro-fine adjustment screws allow 0.0004" T.I.R. (15-3/4" thru 25" chucks).
- Two piece hard top & master jaws are American Standard tongue and groove.
- High quality semi-steel body construction allows for higher lathe speed and longer life.
- Forged and hardened scrolls are precision ground and balanced for longer life and higher accuracy.
- Jaws and pinions are hardened and precision ground to increase life of the chuck.
- Each chuck is balanced within fine limit for the high speed machining.
- Steel adapter plates are interchangeable with PA Series chucks of the same size so that one chuck can be used on different lathe spindles.
- Proper chuck maintenance can extend the life of your PA chuck significantly.
- It must be cleaned and lubricated on a regular basis as recommended in Gator service instruction.
- For the best gripping results, use the Gator recommended chuck grease.
- The 6-jaw chucks grip firmly with less pressure and less distortion per jaw and they are ideal for thin wall and finishing operations. They eliminate the need for spring collets



# Clamping Ranges

- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Use proper jaws for rough and finishing machining.




## 3-Jaw Chucks

- with Solid Jaws
- with Two-Piece Jaws

| Chuck Dia. | mm | 100 | 125 | 160 | 200 | 250 | 315 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|
| | inch | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" |
| Solid Jaws | d1 | .118-1.30 | .118-1.97 | .118-2.52 | .157-3.54 | .197-4.65 | .394-5.16 | - | - | - |
| | d2 | 1.26-2.44 | 1.54-3.27 | 1.97-4.21 | 2.36-5.71 | 3.03-7.40 | 3.54-8.46 | - | - | - |
| | d3 | 2.44-3.27 | 3.15-4.92 | 3.86-6.30 | 5.12-7.87 | 6.30-9.84 | 7.48-12.40 | - | - | - |
| | d4 | .98-2.20 | 1.34-2.91 | 1.65-3.94 | 2.05-5.31 | 2.44-6.85 | 3.07-7.87 | - | - | - |
| | d5 | 2.20-3.43 | 2.83-4.53 | 3.70-6.06 | 4.72-7.95 | 5.71-10.08 | 6.77-11.77 | - | - | - |
| Two-Piece Jaws | d1 | - | .118-1.97 | .118-2.52 | .157-3.54 | .197-4.65 | .394-5.16 | .394-7.09 | .787-9.25 | 1.18-13.19 |
| | d2 | - | 2.05-3.78 | 2.44-4.76 | 2.83-6.14 | 3.39-7.76 | 4.06-8.90 | 5.00-11.57 | 4.33-15.75 | 4.72-22.44 |
| | d3 | - | 3.74-4.92 | 4.53-6.30 | 5.24-7.87 | 6.30-9.84 | 7.48-12.40 | 9.06-15.75 | 7.48-19.69 | 7.87-24.80 |
| | d4 | - | 1.34-2.99 | 1.65-3.81 | 1.97-5.12 | 2.28-6.50 | 2.56-7.17 | 2.84-8.98 | 4.72-16.14 | 5.51-23.23 |
| | d5 | - | 2.95-4.65 | 3.46-5.75 | 4.13-7.48 | 4.92-9.25 | 5.71-10.43 | 6.50-12.95 | 7.87-19.09 | 8.27-26.18 |

## 6-Jaw Chucks

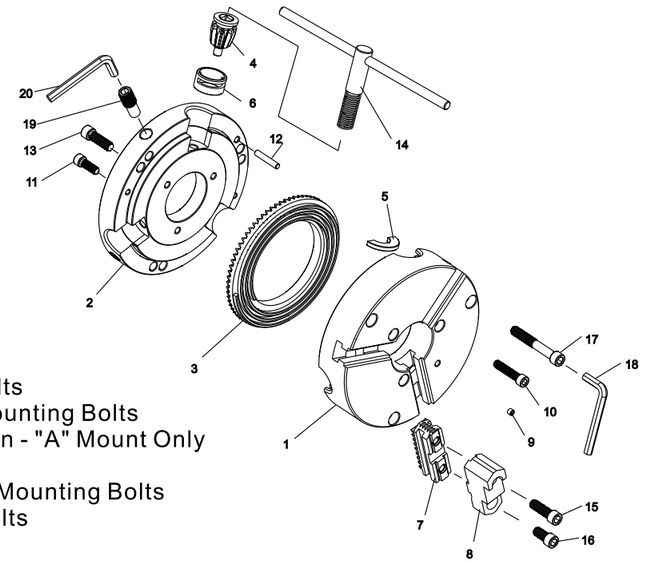
- with Solid Jaws
- with Two-Piece Jaws

| Chuck Dia. | mm | 100 | 125 | 160 | 200 | 250 | 315 | 400 | 500 | 630 |
|---|---|---|---|---|---|---|---|---|---|---|
| | inch | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" |
| Solid Jaws | d1 | .118-1.299 | .236-1.69 | .315-2.51 | .315-3.54 | .47-4.65 | .47-5.16 | - | - | - |
| | d2 | 1.259-2.440 | 1.65-3.07 | 2.05-4.21 | 2.52-5.71 | 3.23-7.40 | 3.74-8.46 | - | - | - |
| | d3 | 2.440-3.661 | 3.27-4.72 | 4.02-6.30 | 5.20-7.87 | 6.50-9.84 | 7.56-12.40 | - | - | - |
| | d4 | 1.023-2.204 | 1.34-2.68 | 1.85-3.94 | 2.17-5.31 | 2.68-6.85 | 3.23-7.87 | - | - | - |
| | d5 | 2.244-3.425 | 2.91-4.33 | 3.86-6.06 | 4.76-7.95 | 5.91-10.08 | 7.01-11.77 | - | - | - |
| Two-Piece Jaws | d1 | - | .236-1.69 | .315-2.51 | .315-3.54 | .47-4.65 | .47-5.16 | .59-7.95 | 1.18-9.25 | 1.57-13.19 |
| | d2 | - | 1.97-3.43 | 2.64-4.76 | 2.91-6.14 | 3.23-7.40 | 4.25-8.90 | 5.20-11.65 | 4.76-15.83 | 5.20-21.85 |
| | d3 | - | 3.70-4.92 | 4.65-6.30 | 5.28-7.87 | 6.46-9.84 | 6.02-12.40 | 9.29-15.75 | 7.76-18.82 | 8.27-24.80 |
| | d4 | - | 1.30-2.75 | 1.77-3.82 | 2.05-5.12 | 2.68-6.85 | 2.68-7.17 | 2.87-9.92 | 5.31-16.26 | 5.91-23.03 |
| | d5 | - | 2.30-4.68 | 3.62-5.75 | 4.29-7.48 | 5.91-10.08 | 5.91-10.08 | 6.65-13.86 | 8.27-19.25 | 8.66-26.02 |



# Chuck Parts

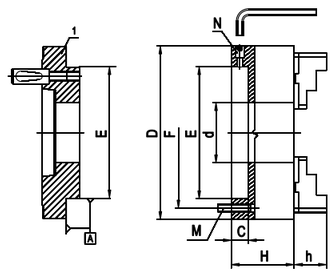
3-Jaw & 6-Jaw, Forged Steel Body
Adjustable Sroll Chucks, 0.0004" T.I.R.



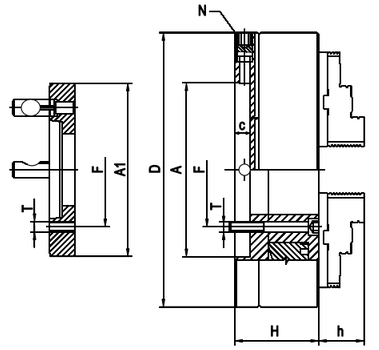

- 1. Chuck Body
- 2. Back Cover
- 3. Scroll Plate
- 4. Pinion
- 5. Pinion Half Ring
- 6. Pinion Sleeve
- 7. Hard Master Jaws
- 8. Hard Top Jaws
- 9. Grease Nipple
- 10.Chuck Mounting Bolts
- 11.&13. Back Cover Mounting Bolts
- 12. Spindle Locating Pin - "A" Mount Only
- 14. Chuck Wrench
- 15 & 16. Hard Top Jaw Mounting Bolts
- 17. Chuck Mounting Bolts
- 18 & 20. Hex Keys
- 19. Fine Adjustment Screw

| Chuck Dia. D | F | E | A1 | A | Hole d (max.) | H | 2-Piece Jaws h | Solid Jaws h | C | Mounting Bolts M & T Thread | Mounting Bolts M & T Qty. | Fine Adjustment Screws N Thread | Fine Adjustment Screws N Qty. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 3.2677 | 1.7717 | - | - | 0.787 | 2.677 | - | 0.63 | 0.51 | M8 x 1.25 | | M10 x 1 | |
| | | | | | | | | | | | | M12 x 1* | |
| 5" | 4.252 | 2.1654 | - | - | 1.378 | 2.362 | 1.575 | 0.787 | 0.59 | M8 x 1.25 | | M12 x 1 | |
| 6-1/4" | 5.5118 | 3.3858 | - | - | 1.654 | 2.677 | 1.71 | 1.26 | 0.67 | M10 x 1.5 | 3 | | 4 |
| 8" | 6.9291 | 4.3307 | - | - | 2.165 | 3.071 | 1.77 | 1.142 | 0.71 | M10 x 1.5 | | | |
| 10" | 8.8188 | 5.7086 | - | - | 2.992 | 3.504 | 2.05 | 1.339 | 0.79 | M12 x 1.75 | | | |
| 12-1/2" | 11.2598 | 7.0866 | - | - | 4.055 | 3.819 | 2.24 | 1.693 | 0.79 | M16 x 2 | | M18 x 1 | |
| 15-3/4" | 6.75 | - | 11.748 | 11.782 | 5.354 | 4.803 | 2.638 | - | 0.87 | 5/8 x 11 | | | |
| 20" | 9.252 | - | 16.022 | 16.032 | 7.48 | 5.669 | 3.11 | - | 1.18 | 3/4 x 10 | 6 | | 8 |
| 25" | 13 | - | 16.022 | 16.032 | 9.921 | 5.905 | 3.425 | - | 1.18 | 3/4 x 10 | | | |

* For 6 jaw chucks only




- Chuck Diameters: 4" thru 12-1/2"

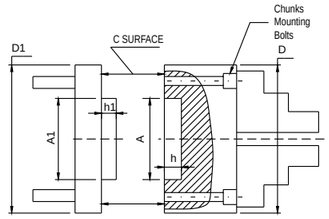


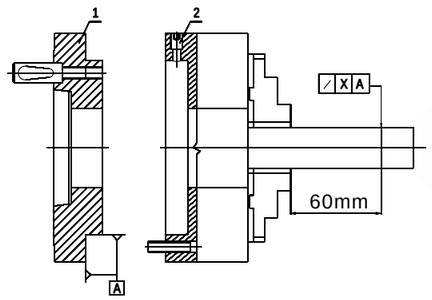

- Chuck Diameters: 15-3/4", 20" & 25"

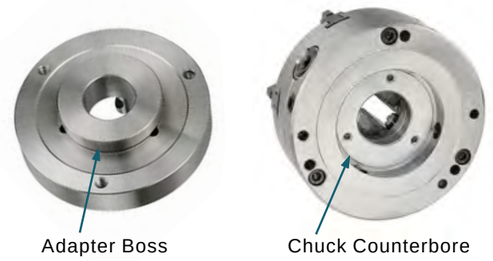
# Application for Adapter Plate

## Adapter Plate & Chuck mounting principles for 4" thru 12-1/2" chucks

A1 < A (A1 has to be always smaller than A & the clearance range between the chuck counterbore ID & adapter boss OD should be from 0.0078" to 0.0129" )
h1 < h (h1 has always to be smaller than h)
D1 = D (Adapter OD has the same diameter as chuck OD)
Installing chuck on the adapter plate or base plate be sure as well that chuck back surface "C" is in a full contact with adapter plate / base plate front surface "C". Both surfaces on the drawing are marked with a black bold line.

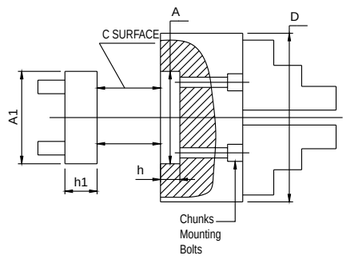


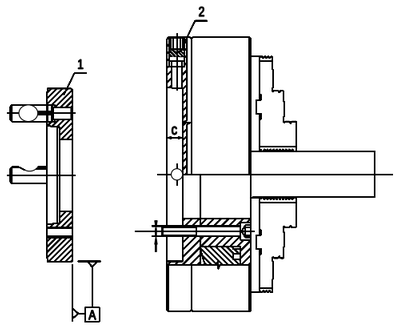




## Adapter Plate & Chuck mounting principles for 15-3/4" thru 25" chucks

A1 < A (A1 has to be always smaller than A & the clearance range between the chuck counterbore ID & adapter boss OD should be from 0.0141" to 0.0236" )
h1 < h (h1 has always to be larger than h)
D1 = A (Adapter OD has smaller diameter than chuck counterbore ID) Installing chuck on the adapter plate or base plate be sure as well that chuck counterbore bottom surface "C" is in a full contact with adapter plate / base plate front surface "C". Both surfaces on the drawing are marked with a black bold line.



# Chuck Details

## Chuck Eye Bolts Dimensions

From 10" up to 31-1/2"

| Chuck Dia. | Thread Size | Part No. |
|---|---|---|
| 10" | M10 x 1.75 | EB-M10 |
| 12-1/2" | M12 x 1.75 | EB-M12 |
| 15-3/4" | M12 x 1.75 | EB-M12 |
| 20" | M16 x 2 | EB-M16 |
| 25" | M16 x 2 | EB-M16 |
| 31-1/2" | M20 x 2.5 | EB-M20 |

# 3 & 6 Jaw Adjustable Scroll Chucks,0.0004" T.I.R.

## With Fine Adjustment, Smei-Steel Body, 3 Pinion Design

### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Semi-Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Chuck wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 20" & 25" chucks are provided with T-slots
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.378 | 3200 | .118-4.92 | 11 | PB3-5"A | 1-151-0500 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.654 | 3000 | .118-6.30 | 21 | PB3-6"A | 1-151-0600 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | W-P-160 |
| 8" | 2.165 | 2500 | .175-7.87 | 39 | PB3-8"A | 1-151-0800 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | W-P-200 |
| 10" | 2.992 | 2000 | .197-9.84 | 69 | PB3-10"A | 1-151-1000 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | W-P-250 |
| 12-1/2" | 4.055 | 1500 | .394-12.40 | 123 | PB3-12"A | 1-151-1200 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.354 | 1000 | .394-15.75 | 215 | PB3-16"A | 1-151-1600 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | W-P-400 |
| 20" | 7.480 | 700 | .787-19.69 | 395 | PB3-20"A | 1-151-2000 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | W-P-500 |
| 25" | 9.921 | 500 | 1.18-24.80 | 640 | PB3-25"A | 1-151-2500 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | W-P-630 |

**W-SP-Extended Wrenches available from stock.
See Page 40

### 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Semi-Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Chuck wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | ID - Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | .787 | 3500 | .118-3.27 | 9.0 | PB3-4" | 1-152-0400 | OJ-PS3-100 | IJ-PS3-100 | SJ-PS3-100 | W-P-100 |
| 5" | 1.378 | 3200 | .118-4.92 | 12 | PB3-5" | 1-152-0500 | OJ-PS3-125 | IJ-PS3-125 | SJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.654 | 3000 | .118-6.30 | 24 | PB3-6" | 1-152-0600 | OJ-PS3-160 | IJ-PS3-160 | SJ-PS3-160 | W-P-160 |
| 8" | 2.165 | 2500 | .175-7.87 | 41 | PB3-8" | 1-152-0800 | OJ-PS3-200 | IJ-PS3-200 | SJ-PS3-200 | W-P-200 |
| 10" | 2.992 | 2000 | .197-9.84 | 71 | PB3-10" | 1-152-1000 | OJ-PS3-250 | IJ-PS3-250 | SJ-PS3-250 | W-P-250 |
| 12-1/2" | 4.055 | 1500 | .394-12.40 | 126 | PB3-12" | 1-152-1200 | OJ-PS3-315 | IJ-PS3-315 | SJ-PS3-315 | W-P-315 |

**W-SP-Extended Wrenches available from stock.
See Page 40



# 3 & 6 Jaw Adjustable Scroll Chucks,0.0004" T.I.R.

## With Fine Adjustment, Forged Steel Body, 3 Pinion Design

### 6-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Semi-Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Chuck wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 25" & up chucks are provided with scroll ejecting screws

| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.378 | 2700 | .236-4.72 | 15 | PB6-5"A | 1-153-0500 | TJ-PS6-125 | MJ-PS6-125 | STJ-PS6-125 | W-P-125 |
| 6-1/4" | 1.654 | 2500 | .315-6.30 | 27 | PB6-6"A | 1-153-0600 | TJ-PS6-160 | MJ-PS6-160 | STJ-PS6-160 | W-P-160 |
| 8" | 2.165 | 2000 | .315-7.87 | 41 | PB6-8"A | 1-153-0800 | TJ-PS6-200 | MJ-PS6-200 | STJ-PS6-200 | W-P-200 |
| 10" | 2.992 | 1600 | .47-9.84 | 72 | PB6-10"A | 1-153-1000 | TJ-PS6-250 | MJ-PS6-250 | STJ-PS6-250 | W-P-250 |
| 12-1/2" | 4.055 | 1100 | .47-12.40 | 115 | PB6-12"A | 1-153-1200 | TJ-PS6-315 | MJ-PS6-315 | STJ-PS6-315 | W-P-315 |
| 15-3/4" | 5.354 | 700 | .59-15.75 | 240 | PB6-16"A | 1-153-1600 | TJ-PS6-400 | MJ-PS6-400 | STJ-PS6-400 | W-P-400 |
| 20" | 7.480 | 400 | 1.18-18.82 | 408 | PB6-20"A | 1-153-2000 | TJ-PS6-500 | MJ-PS6-500 | STJ-PS6-500 | W-P-500 |
| 25" | 9.921 | 250 | 1.57-24.80 | 652 | PB6-25"A | 1-153-2500 | TJ-PS6-630 | MJ-PS6-630 | STJ-PS6-630 | W-P-630 |

**W-SP-Extended Wrenches available from stock.
See Page 40

### 6-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Semi- Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of mounting bolts
- 1 Set of fine adjustment screws
- 1 Chuck wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger

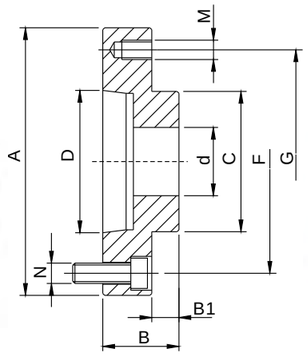
| Chuck Dia. | Hole | RPM Max | Clamping Capacity Min.-Max. | Weight lbs. | Model | Part No. | ID - Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | .787 | 3000 | .118-3.661 | 10 | PB6-4" | 1-154-0400 | OJ-PS6-100 | IJ-PS6-100 | SJ-PS6-100 | W-P-100 |
| 5" | 1.378 | 2700 | .236-4.72 | 16 | PB6-5" | 1-154-0500 | OJ-PS6-125 | IJ-PS6-125 | SJ-PS6-125 | W-P-125 |
| 6-1/4" | 1.654 | 2500 | .315-6.30 | 29 | PB6-6" | 1-154-0600 | OJ-PS6-160 | IJ-PS6-160 | SJ-PS6-160 | W-P-160 |
| 8" | 2.165 | 2000 | .315-7.87 | 42 | PB6-8" | 1-154-0800 | OJ-PS6-200 | IJ-PS6-200 | SJ-PS6-200 | W-P-200 |
| 10" | 2.992 | 1600 | .47-9.84 | 79 | PB6-10" | 1-154-1000 | OJ-PS6-250 | IJ-PS6-250 | SJ-PS6-250 | W-P-250 |
| 12-1/2" | 4.055 | 1100 | .47-12.40 | 150 | PB6-12" | 1-154-1200 | OJ-PS6-315 | IJ-PS6-315 | SJ-PS6-315 | W-P-315 |

**W-SP-Extended Wrenches available from stock.
See Page 40

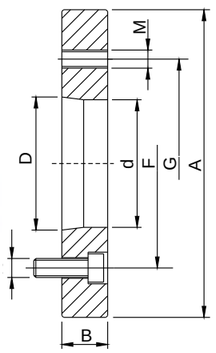
# FLA Series Adapter Plate

## Type A1/A2 Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters come with spindle mounting bolts
- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

| Chuck Dia. | Taper Size | OD A | D | Thru Hole d | F | C | G | Chuck Mountng Bolts M | B1 | B | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | | N | QTY | | |
| 5" | A4 | 4.92 | 2.5005 | 1.378 | 3.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.42 | 7/16-14 | 4 | 4.8 | FLA-125/A4 |
| | A5 | 4.92 | 3.2505 | 1.378 | 4.126 | 2.164 | 4.252 | M8x1.25 | .55 | 1.42 | 7/16-14 | 4 | 4.2 | FLA-125/A5 |
| | A6 | 6.30 | 4.1880 | 1.378 | 5.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.89 | 1/2-13 | 4 | 9.1 | FLA-125/A6 |
| 6-1/4" | A5 | 6.30 | 3.2505 | 1.654 | 4.126 | 3.385 | 5.512 | M10x1.50 | .63 | 1.46 | 7/16-14 | 4 | 6.77 | FLA-160/A5 |
| | A6 | 6.30 | 4.1880 | 1.654 | 5.252 | 3.385 | 5.512 | M10x1.50 | .63 | 1.46 | 1/2-13 | 4 | 6.97 | FLA-160/A6 |
| 8" | A4 | 7.87 | 2.5005 | 2.165 | 3.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.46 | 7/16-14 | 4 | 9.3 | FLA-200/A4 |
| | A5 | 7.87 | 3.2505 | 2.165 | 4.126 | 4.330 | 6.929 | M10x1.50 | .67 | 1.46 | 7/16-14 | 4 | 13.5 | FLA-200/A5 |
| | A6 | 7.87 | 4.1880 | 2.165 | 5.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.49 | 1/2-13 | 4 | 12.6 | FLA-200/A6 |
| 10" | A5 | 9.84 | 3.2505 | 2.992 | 4.126 | 5.708 | 8.819 | M12x1.75 | .75 | 1.49 | 7/16-14 | 4 | 17.3 | FLA-250/A5 |
| | A6 | 9.84 | 4.1880 | 2.992 | 5.252 | 5.708 | 8.819 | M12x1.75 | .75 | 1.49 | 1/2-13 | 4 | 17.3 | FLA-250/A6 |
| | A8 | 9.84 | 5.5007 | 2.992 | 6.748 | 5.708 | 8.819 | M12x1.75 | .75 | 1.81 | 5/8-11 | 4 | 20.2 | FLA-250/A8 |
| 12-1/2" | A6 | 12.40 | 4.1880 | 4.055 | 5.252 | 7.076 | 11.260 | M16x2 | .75 | 1.49 | 1/2-13 | 4 | 27.3 | FLA-315/A6 |
| | A8 | 12.40 | 5.5007 | 4.055 | 6.748 | 7.076 | 11.260 | M16x2 | .75 | 1.81 | 5/8-11 | 4 | 35.7 | FLA-315/A8 |
| | A11 | 12.40 | 7.7507 | 4.055 | 9.252 | 7.076 | 11.260 | M16x2 | .75 | 2.17 | 3/4-10 | 4 | 41.2 | FLA-315/A11 |
| 15-3/4" | A6 | 11.75 | 4.1880 | 4.055 | 5.252 | - | 6.748 | 5/8-11 | - | 1.38 | 1/2-13 | 6 | 31.4 | FLA-400/A6 |
| | A8 | 11.75 | 5.5007 | 5.354 | 6.748 | - | 6.748 | 5/8-11 | - | 1.46 | 5/8-11 | 6 | 28.8 | FLA-400/A8 |
| | A11 | 11.75 | 7.7507 | 5.354 | 9.252 | - | 6.748 | 5/8-11 | - | 1.89 | 3/4-10 | 6 | 35.8 | FLA-400/A11 |
| 20" | A8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 9.252 | 3/4-10 | - | 1.42 | 5/8-11 | 6 | 69 | FLA-500/A8 |
| | A11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 9.252 | 3/4-10 | - | 1.42 | 3/4-10 | 6 | 61 | FLA-500/A11 |
| 25" | A8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 13.000 | 3/4-10 | - | 1.42 | 5/8-11 | 6 | 69 | FLA-630/A8 |
| | A11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 13.000 | 3/4-10 | - | 1.42 | 3/4-10 | 6 | 61 | FLA-630/A11 |
| | A15 | 16.02 | 11.2505 | 9.92 | 13.00 | - | 13.000 | 3/4-10 | - | 2.05 | 7/8-9 | 6 | 76 | FLA-630/A15 |

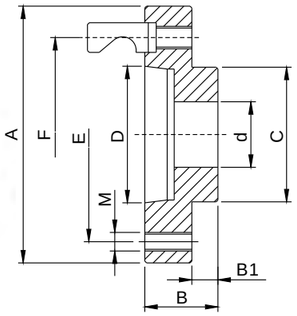
Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0141" to 0.0236"



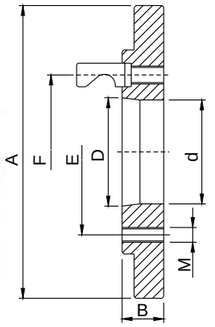
FLA Series Adapter Plate

## Type D1 Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters come with spindle mounting camlock studs
- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

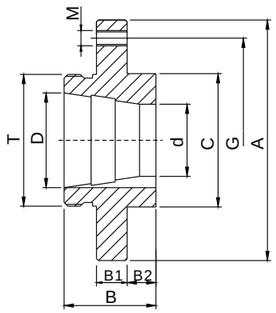
| Chuck Dia. | Taper Size | OD A | D | Thru Hole d | F | C | E | Chuck Mountng Bolts M | B1 | B | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | | OD | QTY | | |
| 5" | D1-3 | 4.92 | 2.1250 | 1.378 | 2.78 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 9/16" | 3 | 5.95 | FLA-125/D3 |
| | D1-4 | 4.92 | 2.5005 | 1.378 | 3.252 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 5/8" | 3 | 5.73 | FLA-125/D4 |
| | D1-5 | 4.92 | 3.2505 | 1.378 | 4.126 | 2.164 | 4.252 | M8x1.25 | .55 | 1.54 | 3/4" | 6 | 5.73 | FLA-125/D5 |
| 6-1/4" | D1-3 | 6.30 | 2.1250 | 1.654 | 2.78 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 9/16" | 3 | 10.80 | FLA-160/D3 |
| | D1-4 | 6.30 | 2.5005 | 1.654 | 3.252 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 5/8" | 3 | 9.92 | FLA-160/D4 |
| | D1-5 | 6.30 | 3.2505 | 1.654 | 4.126 | 3.385 | 5.512 | M10x1.50 | .63 | 1.81 | 3/4" | 6 | 9.89 | FLA-160/D5 |
| 8" | D1-4 | 7.87 | 2.5005 | 2.165 | 3.252 | 4.330 | 6.929 | M10x1.50 | .67 | 1.30 | 5/8" | 3 | 10.36 | FLA-200/D4 |
| | D1-5 | 7.87 | 3.2505 | 2.165 | 4.126 | 4.330 | 6.929 | M10x1.50 | .67 | 1.85 | 3/4" | 6 | 15.87 | FLA-200/D5 |
| | D1-6 | 7.87 | 4.1880 | 2.165 | 5.252 | 4.330 | 6.929 | M10x1.50 | .67 | 2.01 | 7/8" | 6 | 17.64 | FLA-200/D6 |
| 10" | D1-5 | 9.84 | 3.2505 | 2.992 | 4.126 | 5.708 | 8.819 | M12x1.75 | .75 | 1.50 | 3/4" | 6 | 17.64 | FLA-250/D5 |
| | D1-6 | 9.84 | 4.1880 | 2.992 | 5.252 | 5.708 | 8.819 | M12x1.75 | .75 | 2.09 | 7/8" | 6 | 28.44 | FLA-250/D6 |
| | D1-8 | 9.84 | 5.5007 | 2.992 | 6.748 | 5.708 | 8.819 | M12x1.75 | .75 | 2.36 | 1" | 6 | 32.41 | FLA-250/D8 |
| 12-1/2" | D1-6 | 12.40 | 4.1880 | 4.055 | 5.252 | 7.076 | 11.260 | M16x2 | .75 | 1.50 | 7/8" | 6 | 28.44 | FLA-315/D6 |
| | D1-8 | 12.40 | 5.5007 | 4.055 | 6.748 | 7.076 | 11.260 | M16x2 | .75 | 2.24 | 1" | 6 | 47.84 | FLA-315/D8 |
| | D1-11 | 12.40 | 7.7507 | 4.055 | 9.252 | 7.076 | 11.260 | M16x2 | .75 | 2.52 | 1-3/16" | 6 | 52.91 | FLA-315/D11 |
| 15-3/4" | D1-6 | 11.75 | 4.1880 | 4.055 | 5.252 | - | 6.748 | 5/8-11 | - | 1.38 | 7/8" | 6 | 29.0 | FLA-400/D6 |
| | D1-8 | 11.75 | 5.5007 | 5.354 | 6.748 | - | 6.748 | 5/8-11 | - | 1.50 | 1" | 6 | 27.2 | FLA-400/D8 |
| | D1-11 | 11.75 | 7.7507 | 5.354 | 9.252 | - | 6.748 | 5/8-11 | - | 1.89 | 1-3/16" | 6 | 26.8 | FLA-400/D11 |
| 20" | D1-8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 9.252 | 3/4-10 | - | 1.42 | 1" | 6 | 74 | FLA-500/D8 |
| | D1-11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 9.252 | 3/4-10 | - | 1.73 | 1-3/16" | 6 | 78 | FLA-500/D11 |
| 25" | D1-8 | 16.02 | 5.5007 | 5.354 | 6.748 | - | 13.000 | 3/4-10 | - | 1.42 | 1" | 6 | 74 | FLA-630/D8 |
| | D1-11 | 16.02 | 7.7507 | 7.580 | 9.252 | - | 13.000 | 3/4-10 | - | 1.73 | 1-3/16" | 6 | 78 | FLA-630/D11 |
| | D1-15 | 16.02 | 11.2505 | 9.92 | 13.00 | - | 13.000 | 3/4-10 | - | 2.05 | 1-3/8" | 6 | 77 | FLA-630/D15 |

Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0141" to 0.0236"

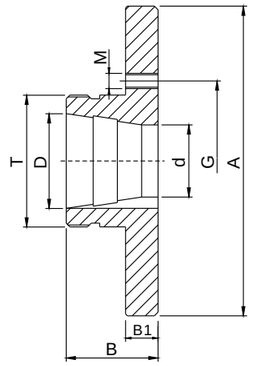
# FLA Series Adapter Plate

## Type L Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters are heat treaded for longer life
- All adapters do not require any additional machining




For Chucks from 5" thru 12-1/2"




For Chucks from 15-3/4" thru 25"

| Chuck Dia. | Taper Size | OD A | Thread T - UNS3 | D | Thru Hole d | C | G | Chuck Mountng Bolts M | B1 | B2 | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | L00 | 6.30 | 3-3/4 - 6 | 2.750 | 2.20 | 3.385 | 5.512 | M10x1.50 | .79 | .63 | 2.52 | 9.0 | FLA-160/L00 |
| 6-1/4" | L0 | 6.30 | 4-1/2 - 6 | 3.250 | 2.60 | 3.385 | 5.512 | M10x1.50 | .79 | .63 | 2.56 | 9.5 | FLA-160/L0 |
| 8" | L00 | 7.87 | 3-3/4 - 6 | 2.750 | 2.20 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.56 | 15.0 | FLA-200/L00 |
| 8" | L0 | 7.87 | 4-1/2 - 6 | 3.250 | 2.60 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.56 | 15.4 | FLA-200/L0 |
| 8" | L1 | 7.87 | 6 - 6 | 4.125 | 3.33 | 4.330 | 6.929 | M10x1.50 | .79 | .67 | 2.99 | 16.5 | FLA-200/L1 |
| 10" | L00 | 9.84 | 3-3/4 - 6 | 2.750 | 2.20 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.76 | 25 | FLA-250/L00 |
| 10" | L0 | 9.84 | 4-1/2 - 6 | 3.250 | 2.60 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.76 | 26 | FLA-250/L0 |
| 10" | L1 | 9.84 | 6 - 6 | 4.125 | 3.33 | 5.708 | 8.819 | M12x1.75 | .91 | .75 | 2.99 | 37 | FLA-250/L1 |
| 12-1/2" | L0 | 12.40 | 4-1/2 - 6 | 3.250 | 2.60 | 7.076 | 11.260 | M16x2 | .91 | .75 | 2.76 | 37 | FLA-315/L0 |
| 12-1/2" | L1 | 12.40 | 6 - 6 | 4.125 | 3.33 | 7.076 | 11.260 | M16x2 | .91 | .75 | 2.99 | 37 | FLA-315/L1 |
| 12-1/2" | L2 | 12.40 | 7-3/4 - 5 | 5.250 | 4.29 | 7.076 | 11.260 | M16x2 | .91 | .75 | 3.50 | 39 | FLA-315/L2 |
| 15-3/4" | L1 | 11.75 | 6 - 6 | 4.125 | 3.33 | 11.75 | 6.748 | 5/8-11 | .87 | - | 2.95 | 34 | FLA-400/L1 |
| 15-3/4" | L2 | 11.75 | 7-3/4 - 5 | 5.250 | 4.29 | 11.75 | 6.748 | 5/8-11 | .87 | - | 3.50 | 45 | FLA-400/L2 |
| 15-3/4" | L3 | 11.75 | 10-3/8 - 4 | 6.500 | 5.43 | 11.75 | 6.748 | 5/8-11 | .87 | - | 3.94 | 67 | FLA-400/L3 |
| 20" | L2 | 16.02 | 7-3/4 - 5 | 5.250 | 4.29 | 16.02 | 9.252 | 3/4-10 | 1.18 | - | 3.66 | 60 | FLA-500/L2 |

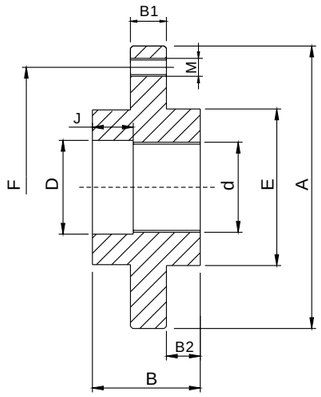
Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"
-For 15-3/4" through 25" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0141" to 0.0236"



FLA Series Adapter Plate

## Type "T" Threaded Steel Adapters, Fully Machined for PA Series & PB Series chucks

- All adapters are heat treaded for longer life
- All adapters do not require any additional machining



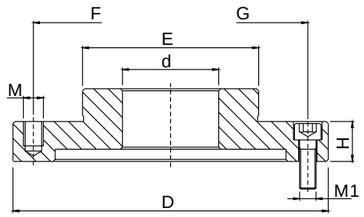

| Chuck Dia. | Thread d | OD A | D | E | F | B | B2 | B1 | M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1-10 UNS-2B | 3.94 | 1.0150 | 1.771 | 3.268 | 1.54 | .47 | .51 | M8x1.25 | 4.85 | FLA-100/T1 |
| | 1-1/2 - 8 UN-2B | 3.94 | 1.5150 | 1.771 | 3.268 | 1.54 | .47 | .51 | M8x1.25 | 5.29 | FLA-100/T2 |
| 5" | 1-1/8 - 12 W | 4.92 | 1.2496 | 2.164 | 4.252 | 1.54 | .55 | .51 | M8x1.25 | 4.05 | FLA-125/T3 |
| | 1-1/2 - 8 UN-2B | 4.92 | 1.5150 | 2.164 | 4.252 | 1.97 | .59 | .51 | M8x1.25 | 6.61 | FLA-125/T2 |
| | 2-3/16 - 10 Hardinge | 4.92 | 2.1889 | 2.164 | 4.252 | 2.85 | .79 | .51 | M8x1.25 | 7.05 | FLA-125/T4 |
| | 2-1/4 - 8 UN-2B | 4.92 | 2.2600 | 2.164 | 4.252 | 2.95 | .79 | .51 | M8x1.25 | 6.80 | FLA-125/T5 |
| 6-1/4" | 1-1/2 - 8 UN-2B | 6.30 | 1.5150 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.05 | FLA-160/T2 |
| | 2-3/16 - 10 Hardinge | 6.30 | 2.1889 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.50 | FLA-160/T4 |
| | 2-1/4 - 8 UN-2B | 6.30 | 2.2600 | 3.385 | 5.512 | 2.05 | .63 | .59 | M10x1.50 | 7.94 | FLA-160/T5 |
| 8" | 1-1/2 - 8 UN-2B | 7.78 | 1.5150 | 4.330 | 6.929 | 1.97 | .67 | .79 | M10x1.50 | 9.92 | FLA-200/T2 |
| | 2-1/4 - 8 UN-2B | 7.78 | 2.2600 | 4.330 | 6.929 | 2.05 | .67 | .79 | M10x1.50 | 11.46 | FLA-200/T5 |
| | 2-3/8 - 6 UN-2B | 7.78 | 2.3850 | 4.330 | 6.929 | 2.05 | .67 | .79 | M10x1.50 | 13.89 | FLA-200/T6 |
| 10" | 2-3/8 - 6 UN-2B | 9.87 | 2.3850 | 5.708 | 8.819 | 2.05 | .75 | .75 | M12x1.75 | 30 | FLA-250/T6 |
| 12-1/2" | 2-3/8 - 6 UN-2B | 12.40 | 2.3850 | 7.076 | 11.260 | 2.05 | .75 | .94 | M16x2 | 50 | FLA-315/T6 |

Note:
-For 4" through 12-1/2" chucks the clearance range between the chuck counter bore and adapter boss OD is from 0.0078" to 0.0129"

# BPA Series Base Plate

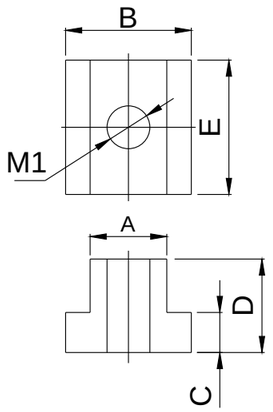
## BPA Base Plate
## for PA Series & PB Series chucks

- Designed for use with 3 & 6 jaw scroll front mount adjustable body chucks with 0.0004" T.I.R.
- Mounting bolts and T-Nuts included.
- Made of Hardened steel.




| Chuck Dia. | OD D | E | F | G | H | M Chuck Mounting Botls | M1 | d | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 4.921 | 2.164 | 4.25 | 4.252 | 0.551 | M8 x 1.25 | M6 | 1.875 | 3.8 | BPA-125 |
| 6-1/4" | 6.299 | 3.385 | 5.512 | 5.512 | 0.630 | M10 x 1.5 | M8 | 1.850 | 5.5 | BPA-160 |
| 8" | 7.874 | 4.330 | 6.929 | 6.929 | 0.709 | M10 x 1.5 | M8 | 2.362 | 7.7 | BPA-200 |
| 10" | 9.843 | 5.708 | 8.819 | 8.819 | 0.787 | M12 x 1.75 | M10 | 3.189 | 12.9 | BPA-250 |
| 12-1/2" | 12.402 | 7.086 | 11.26 | 11.26 | 0.984 | M16 x 2 | M10 | 4.252 | 23.9 | BPA-315 |
| 15-3/4" | 11.750 | 11.750 | 6.748 | 10.236 | 1.181 | 5/8"-11 | M12 | 5.551 | 40.3 | BPA-400 |
| 20" | 16.024 | 16.020 | 9.252 | 14.173 | 1.378 | 3/4"-10 | M16 | 7.677 | 60.2 | BPA-500 |

| Chuck Dia. | M1 | A | B | C | D | E |
|---|---|---|---|---|---|---|
| 5" | M6 | .3150 | .5118 | .1969 | .3543 | .5118 |
| 6-1/4" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 8" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 10" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 12-1/2" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 15-3/4" | M12 | .5512 | .8661 | .3150 | .6299 | .8661 |
| 20" | M16 | .7087 | 1.1024 | .3937 | .7874 | 1.1024 |

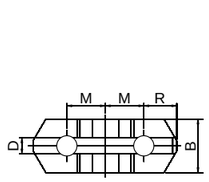


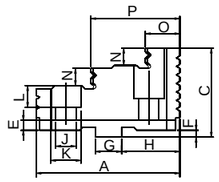





## Hard Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



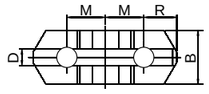
5" to 12-1/2"

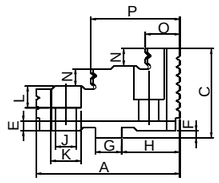
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |

## Hard Top Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



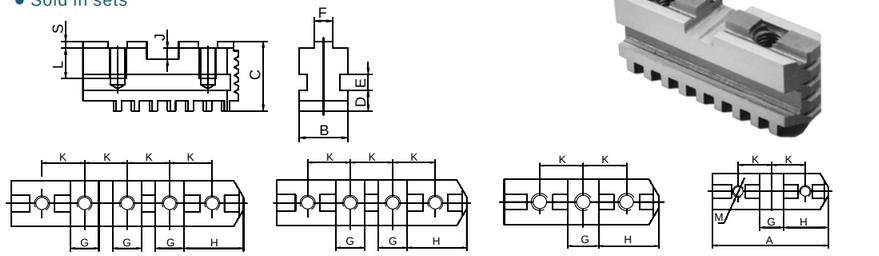



| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 1.90 | TJ-PS6-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 2.40 | TJ-PS6-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 4.20 | TJ-PS6-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 6.40 | TJ-PS6-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 10.20 | TJ-PS6-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 14.60 | TJ-PS6-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 28.80 | TJ-PS6-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 44.20 | TJ-PS6-630 |

# Jaws - Hard Master Jaws

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

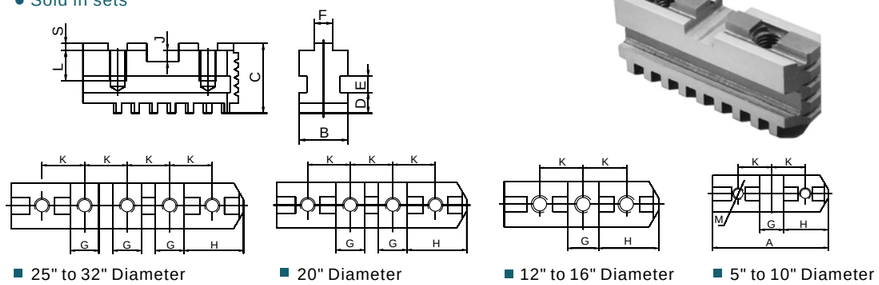



■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 0.93 | MJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS3-630 |

## Hard Master Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets




■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

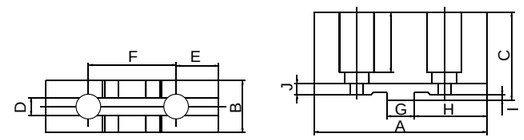
| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 1.90 | MJ-PS6-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 2.40 | MJ-PS6-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 4.20 | MJ-PS6-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 6.40 | MJ-PS6-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 10.20 | MJ-PS6-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 14.60 | MJ-PS6-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 28.80 | MJ-PS6-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 44.20 | MJ-PS6-630 |



# Jaws - Soft Top Jaws

## Soft Top Jaws, For 3-Jaw Chucks

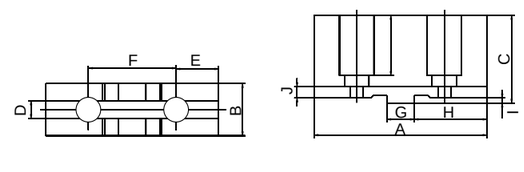
- American Standard Tongue & Groove Jaws
- Sold by piece




| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS1-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS1-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS1-630 |

## Soft Top Jaws, For 6-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold by piece

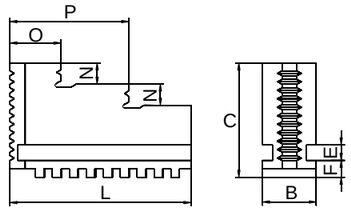


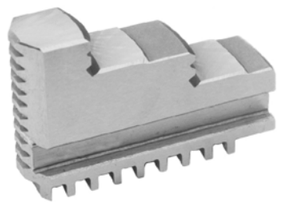

| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS6-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS6-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS6-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS6-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS6-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS6-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS6-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS6-630 |

# Jaws - ID Jaws

## ID Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

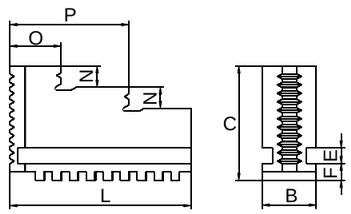


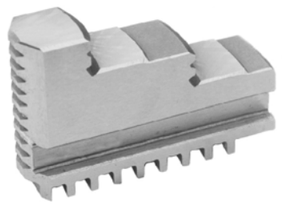



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS3-500 |

## ID Hard Solid Jaws, For 6-Jaw Chucks

- Sold in sets



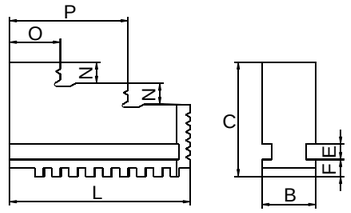
| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS6-500 |

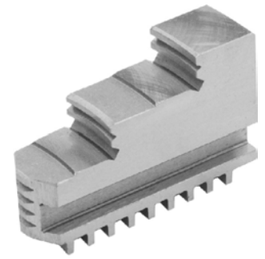


# Jaws - OD Jaws

## OD Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

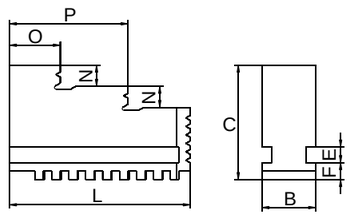


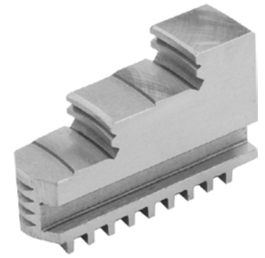



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS3-500 |

## OD Hard Solid Jaws, For 6-Jaw Chucks

- Sold in sets



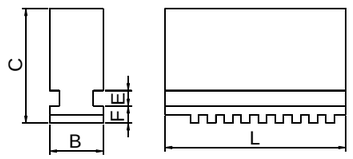



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS6-500 |

# Jaws - Soft Solid Jaws

## Soft Solid Jaws, For 3-Jaw Chucks

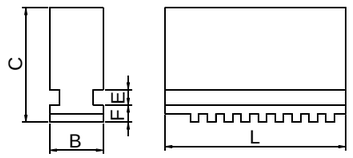
- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS3-500 |

## Soft Solid Jaws, For 6-Jaw Chucks

- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS6-500 |



# Spare Parts

## Scroll Plates

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | SC-PS-100 | 2.7323 |
| 5" | SC-PS-125 | 3.7008 |
| 6-1/4" | SC-PS-160 | 4.8819 |
| 8" | SC-PS-200 | 6.2598 |
| 10" | SC-PS-250 | 7.7953 |
| 12-1/2" | SC-PS-315 | 10.1575 |
| 15-3/4" | SC-PS-400 | 12.9134 |
| 20" | SC-PS-500 | 16.4173 |
| 25" | SC-PS-630 | 21.3386 |

## Pinions

- Sold by piece

| Chuck Dia. | Part No. | OD | OAL |
|---|---|---|---|
| 4" | PI-PS-100 | .9843 | 1.3976 |
| 5" | PI-PO-125 | .9843 | 1.3268 |
| 6-1/4" | PI-PO-160 | 1.1024 | 1.6063 |
| 8" | PI-PO-200 | 1.1811 | 1.9882 |
| 10" | PI-PO-250 | 1.3583 | 2.2638 |
| 12-1/2" | PI-PO-315 | 1.4764 | 2.8543 |
| 15-3/4" | PI-PO-400 | 1.7323 | 3.6614 |
| 20" | PI-PO-500 | 1.9685 | 3.8780 |
| 25" | PI-PO-630 | 2.0472 | 4.7087 |

## Pinion Sleeves

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | - | - |
| 5" | PS-P-125 | 1.2205 |
| 6-1/4" | PS-P-160 | 1.4173 |
| 8" | PS-P-200 | 1.4961 |
| 10" | PS-P-250 | 1.6732 |
| 12-1/2" | PS-P-315 | 1.7913 |
| 15-3/4" | PS-P-400 | 2.0472 |
| 20" | PS-P-500 | 2.3622 |
| 25" | PS-P-630 | 2.4409 |

## Half Rings

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 4" | - | - |
| 5" | HR-P-125 | 1.4567 |
| 6-1/4" | HR-P-160 | 1.7323 |
| 8" | HR-P-200 | 1.8504 |
| 10" | HR-P-250 | 2.0669 |
| 12-1/2" | HR-P-315 | 2.1654 |
| 15-3/4" | HR-P-400 | 2.4213 |
| 20" | HR-P-500 | 2.8346 |
| 25" | HR-P-630 | 2.9134 |

## Fine Adjustment Screws

- Sold by piece

| Chuck Dia. | Part No. | Thread Size | OAL |
|---|---|---|---|
| 4" | FS-P-100 | M10 x 1 | 1.0039 |
| 5" | FS-P-125 | M12 x 1 | 1.2992 |
| 6-1/4" | FS-P-160 | M18 x 1 | 1.4567 |
| 8" | FS-P-200 | M18 x 1 | 1.7323 |
| 10" | FS-P-250 | M18 x 1 | 1.9094 |
| 12-1/2" | FS-P-315 | M18 x 1 | 2.5394 |
| 15-3/4" | FS-P-400 | M18 x 1 | 1.9094 |
| 20" | FS-P-500 | M18 x 1 | 1.7323 |
| 25" | FS-P-630 | M18 x 1 | 4.2520 |

## Chuck Mounting Bolts

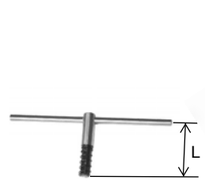
- Sold by piece

| Chuck Dia. | Part No. | Thread Size |
|---|---|---|
| 4" | MB-BA-100 | M8 |
| 5" | MB-BA-125 | M8 |
| 6-1/4" | MB-BA-160 | M10 |
| 8" | MB-BA-200 | M10 |
| 10" | MB-BA-250 | M12 |
| 12-1/2" | MB-BA-315 | M12 |
| 15-3/4" | MB-BA-400 | 5/8"-11 |
| 20" | MB-BA-500 | 3/4"-10 |
| 25" | MB-BA-630 | 3/4"-10 |

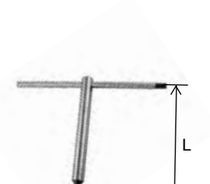
## Wrenches (Standard & Extended)

- Sold by piece

| Chuck Dia. | Square Size | Standard | | Extended | |
|---|---|---|---|---|---|
| | | L | Part No. | L | Part No. |
| 4" | .3543 | 3.15 | W-P-100 | - | - |
| 5" | .3543 | 3.15 | W-P-125 | - | - |
| 6-1/4" | .4331 | 3.90 | W-P-160 | 7.87 | W-SP-160 |
| 8" | .4331 | 3.90 | W-P-200 | 10.02 | W-SP-200 |
| 10" | .5512 | 4.78 | W-P-250 | 8.74 | W-SP-250 |
| 12-1/2" | .5512 | 4.76 | W-P-315 | 10.87 | W-SP-315 |
| 15-3/4" | .6693 | 5.51 | W-P-400 | 10.75 | W-SP-400 |
| 20" | .7480 | 9.06 | W-P-500 | 18.11 | W-SP-500 |
| 25" | .7480 | 9.06 | W-P-630 | - | - |




Standard Wrench

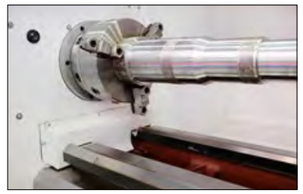



Extended Wrench

# PO SERIES

## Medium Duty Forged Steel Body Precision Self-Centering Scroll Chucks

PO Series Forged Steel Body High Speed Scroll Chucks can be used for all high speed machining operations where universal chucks are unsuitable. High accuracy, versatility and durability make PO chucks invaluable in the modern workshops and indispensable in the tool rooms.



gator chucks BY FUERDA
PO Series - Forged Steel Body Precision Scroll Chucks
PO

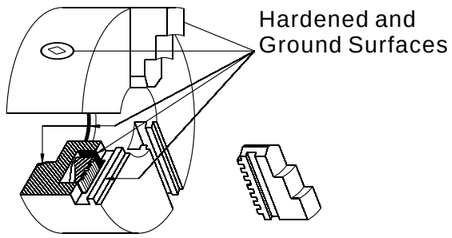
# PO Series Forged Steel Body Precision Scroll Chucks

Medium Duty
3 & 4-Jaw Precision Self-Centering Scroll Chucks.
Forged Steel Body

## Features and Benefits

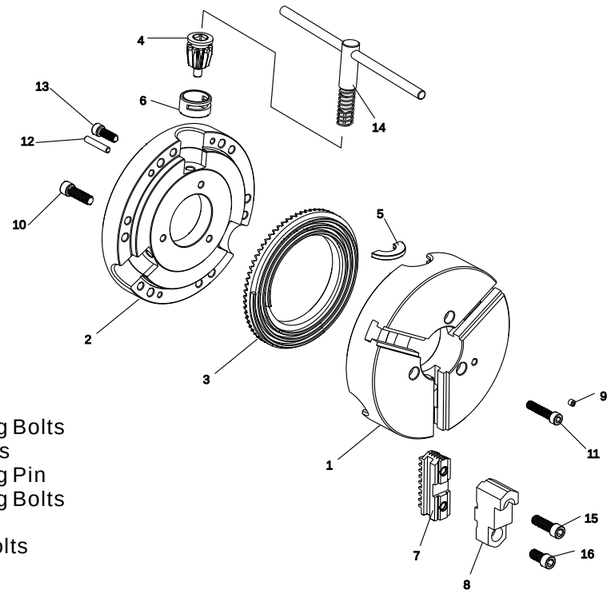
PO Chucks are provided with 2-Pc Hard Reversible Jaws and ID & OD Hard Solid Jaws. Plain Back Chucks with large selection of Adapter Plates (A, D-1, L & Threaded) and Direct ( A & D-1) mounts secure a large variety of the Spindle PO Chuck mounting options.

- **Chuck Body**
  Two piece body construction made of drop forged high quality alloy steel.
  PO chuck forged steel body allows for higher lathe speeds. All working surfaces are induction hardened and precisely ground.Each chuck is balanced within fine limits for longer life, 3 pinion design.
- **Scroll Plate**
  Drop forged of high quality alloy steel and case hardened. Thread flanks are ground on both sides.
  Each scroll is individually balanced for chuck longer life and higher accuracy.
- **Jaws**
  Made of high alloy steel, American Standard Tongue & Groove 2-Pc Jaws.
  Jaw teeth and guideways are hardened and fully ground on both sides.
- **Pinions**
  Hardened and ground.Each pinion is inserted in a steel special bushing to secure precision engagement with the scroll.
- **Bushings**
  Made of high grade alloy steel.
  Hardened and ground.Each bushing is pressed into pinion seat extending chuck life time.




- **Precision grinding of scroll plate and jaw teeth allows you to:**
  Eliminate the possibility of deformation as a result of heat treatment.
  Reach uniform radial gripping force on all teeth of jaws.
  Increases guaranteed period for high centering accuracy.

# Chuck Part Listing

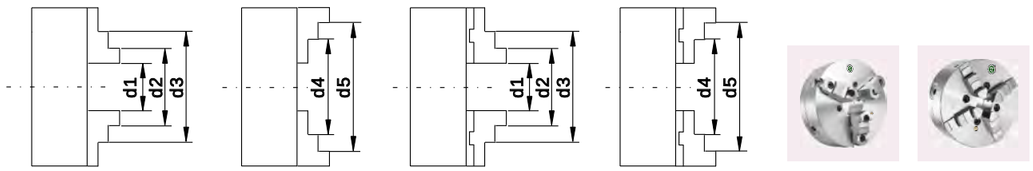



- 1. Chuck Body
- 2. Back Cover
- 3. Scroll Plate
- 4. Pinion
- 5. Pinion Half Ring
- 6. Pinion Sleeve
- 7. Hard Master Jaws
- 8. Hard Top Jaws
- 9. Grease Nipple
- 10. Back Cover Mounting Bolts
- 11. Chuck Mounting Bolts
- 12. Back Cover Mounting Pin
- 13. Back Cover Mounting Bolts
- 14. Chuck Wrench
- 15.&16.Jaw mounting bolts

## Clamping Ranges

### PO Series 3 & 4-Jaw Precision Scroll Chucks

- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.




| Chuck Dia. D | | d1 | | d2 | | d3 max. | | d4 max. | | d5 max. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | JAWS | | | | | | | | | |
| mm | Inch | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible |
| 80 | 3-1/4 | .08-1.06 | - | .87-1.81 | - | 1.77-2.72 | - | .98-1.97 | - | 1.89-2.80 | - |
| 100 | 4 | .12-1.30 | - | .98-2.20 | - | 2.20-3.43 | - | 1.26-2.44 | - | 2.44-3.27 | - |
| 125 | 5 | .12-1.97 | .12-1.97 | 1.37-2.91 | 1.34-2.99 | 2.83-4.53 | 2.95-4.65 | 1.54-3.27 | 2.05-3.78 | 3.15-4.92 | 3.74-4.92 |
| 160 | 6-1/4 | .12-2.52 | .12-2.52 | 1.65-3.94 | 1.65-3.82 | 3.70-6.06 | 3.46-5.75 | 1.97-4.21 | 2.44-4.76 | 3.86-6.30 | 4.53-6.30 |
| 200 | 8 | .16-3.54 | .16-3.54 | 2.05-5.31 | 1.97-5.12 | 4.72-7.95 | 4.13-7.48 | 2.36-5.71 | 2.83-6.14 | 5.12-7.87 | 5.24-7.87 |
| 250 | 10 | .20-4.65 | .20-4.65 | 2.44-6.85 | 2.28-6.50 | 5.70-10.43 | 4.92-9.25 | 3.03-7.40 | 3.38-7.75 | 6.30-9.84 | 6.30-9.84 |
| 315 | 12-1/2 | .39-5.16 | .20-5.16 | 3.07-7.87 | 2.56-7.16 | 6.77-11.77 | 5.70-10.43 | 3.54-8.46 | 4.06-8.90 | 7.48-12.40 | 7.48-12.40 |
| 400 | 15-3/4 | .39-7.09 | .39-7.09 | 3.35-9.92 | 2.83-8.98 | 8.27-14.96 | 6.50-12.95 | 4.05-10.71 | 5.00-11.57 | 9.05-15.75 | 9.05-15.75 |
| 500 | 20 | .79-9.25 | .79-9.25 | 4.72-13.19 | 4.72-16.14 | 9.65-18.74 | 7.87-19.10 | 5.51-14.06 | 4.33-15.75 | 10.87-19.69 | 7.48-19.69 |
| 630 | 25 | 1.18-13.19 | 1.18-13.19 | 6.30-18.31 | 5.51-23.23 | 12.80-24.80 | 8.27-26.18 | 7.09-19.17 | 4.72-22.44 | 13.58-24.80 | 7.88-24.80 |
| 800 | 31-1/2 | 5.9-18.89 | 5.9-18.89 | 11.10-24.17 | 9.92-28.99 | 17.64-30.71 | 12.91-31.97 | 11.89-24.96 | 9.45-28.50 | 18.43-31.50 | 12.44-31.50 |
| 1000 | 40 | - | 9.84-23.62 | - | 14.02-42.52 | - | 16.93-45.28 | - | 16.73-42.13 | - | 19.69-45.28 |
| 1250 | 50 | - | 12.60-27.56 | - | 16.54-45.67 | - | 19.29-48.62 | - | 22.52-49.61 | - | 25.20-52.17 |

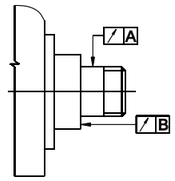




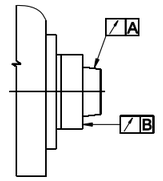
## Permissible Spindle Runout

**To obtain the specified clamping accuracy of a chuck mounted on a machine tool, it is necessary to:**

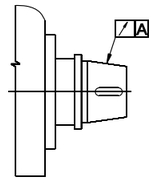
1. Reduce play in the spindle bearings to allowable minimum.
2. Ensure the machine spindle nose does not exceed the values specified.
3. Meet the basic requirements for correct mounting of the chuck on the spindle nose.
4. Follow the chuck manual.




Threaded




Short Taper




Long Taper

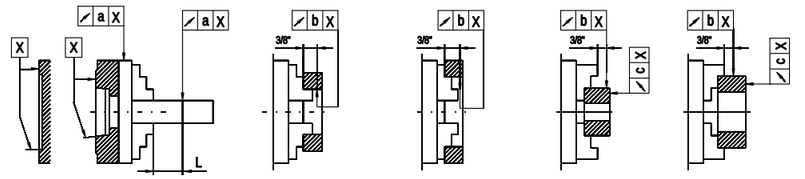
| Chuck Dia. | Spindle Runout |
|---|---|
| PO Series Steel Body Chucks | |
| 3" - 16" | .00012"max. |
| 20" - 25" | .0002"max. |

## Safe Operating Parameters

Conditions:
l&z=maximum length of workpiece
d=workpiece diameter
h=height of the clamping jaw step
workpiece is clamped into the chuck jaws without additional support.

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| l | 1.2 x d | | | | | | 1.5 x d | | | 1 x d | | | |
| z | 4 x h | | | | | | | | | | | | |

## Chuck Accuracy




| Chuck Size | | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | | 1.57 | 1.57 | 2.36 | 2.36 | 3.15 | 3.15 | 4.72 | 4.72 | 6.3 | 6.3 | 6.3 | 6.3 | 6.3 |
| Radial Runout | a | 0.0008 | 0.0008 | 0.0012 | 0.0012 | 0.0016 | 0.0016 | 0.002 | 0.0024 | 0.004 | 0.004 | 0.0059 | 0.0071 | 0.0071 |
| | b | 0.001 | 0.001 | 0.0014 | 0.0014 | 0.0018 | 0.0018 | 0.0022 | 0.0025 | 0.004 | 0.004 | 0.0059 | 0.0071 | 0.0071 |
| Axial Runout | c | 0.0006 | 0.0006 | 0.0008 | 0.0008 | 0.001 | 0.001 | 0.0012 | 0.0012 | 0.002 | 0.002 | 0.0024 | 0.0031 | 0.0031 |

# Chuck Selection Guide

## Total Gripping Force of all Self-Centering Chucks (lbs.)

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Total Gripping Force | 2,200 | 3,750 | 5,300 | 6,800 | 8,200 | 10,000 | 12,000 | 14,300 | 16,000 | 17,700 | 19,800 |

Note:
The gripping force is the total of all jaw force acting radially on the stationary workpiece.
The specified gripping forces are approximate value. They apply to the chucks in perfect mechanical condition and properly lubricated.
There is a solid relation between chuck RPM and gripping power; the higher chuck RPM the lower chuck gripping power.

## Recommended Maximum Speeds for Self-Centering Chucks(RPM)

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Max.RPM | 6000 | 5200 | 4800 | 4500 | 4000 | 3500 | 2800 | 2000 | 1200 | 1000 | 450 |

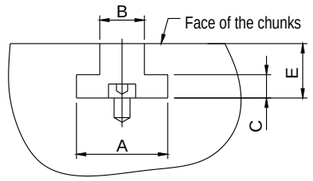
Note:
Permissible chuck max. RPM's are calculated for the chucks in perfect condition and having factory original jaws and depends on many different machining factors such as cutting parameters (depth of cut & feeds), weight and balancing of workpiece, machining conditions like; smooth or interrupted cut. Workpiece material and surface finishing should be also taken into the consideration.

## Value of Balancing for Precision Self-Centering Chucks Only.

| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" |
|---|---|---|---|---|---|---|---|---|---|---|
| Balancing (ounce-inch) | 0.15 | 0.22 | 0.32 | 0.44 | 0.62 | 0.87 | 1.25 | 1.94 | 4.16 | 8.88 |

Note:
Fine chuck balancing extends its life and increases significantly machining quality at high RPM.

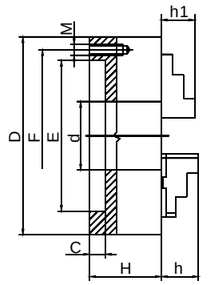
## T-Slot Dimensions for 20" & 25" 3-Jaw Chucks




| Chuck Dia. | A | B | C | E | T-Slot Length |
|---|---|---|---|---|---|
| 20" | .9055 | .5512 | .3937 | .8268 | 4.5276 |
| 25" | 1.2598 | .7087 | .5118 | 1.0236 | 5.1181 |
| 31-1/2" | 1.2598 | .7087 | .5118 | 1.0236 | 7.0866 |

# Plain Back Scroll Chucks

Medium Duty
3 & 4-Jaw Precision Self-Centering Scroll Chucks.
Forged Steel Body



## Principal Dimensions

| Chuck Dia.D | F | E | d | C | H | 2-Pc Jaws h | Solid Jaws h1 | Adapter Mounting Bolts | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread M | L | No. Of Bolts |
| 3-1/4" | 2.6378 | 2.2047 | 0.6299 | .1181 | 1.732 | - | 0.512 | M6 x 1 | 0.98 | 3 |
| 4" | 3.2677 | 2.7599 | 0.7874 | .1181 | 1.969 | - | 0.669 | M8 x 1.25 | 0.98 | 3 |
| 5" | 4.2520 | 3.7402 | 1.2598 | .1575 | 2.343 | 1.575 | 0.787 | M8 x 1.25 | 0.98 | 3 |
| 6-1/4" | 5.5118 | 4.9213 | 1.6535 | .1575 | 2.677 | 1.693 | 1.260 | M10 x 1.5 | 0.98 | 6 |
| 8" | 6.9291 | 6.2992 | 2.1654 | .1575 | 3.071 | 1.831 | 1.142 | M10 x 1.5 | 0.98 | 6 |
| 10" | 8.8189 | 7.8740 | 2.9921 | .1969 | 3.504 | 2.146 | 1.339 | M12 x 1.75 | 1.18 | 6 |
| 12-1/2" | 11.2598 | 10.2362 | 4.0551 | .1969 | 3.787 | 2.362 | 1.693 | M16 x 2 | 1.18 | 6 |
| 15-3/4" | 14.2519 | 12.9921 | 5.3545 | .1969 | 4.252 | 2.854 | 2.165 | M16 x 2 | 1.57 | 6 |
| 20" | 18.0314 | 16.5354 | 7.4803 | .1969 | 4.685 | 3.602 | 2.205 | M16 x 2 | 1.57 | 6 |
| 25" | 23.0709 | 21.4567 | 9.9213 | .2756 | 5.079 | 3.622 | 2.756 | M16 x 2 | 1.97 | 6 |
| 31-1/2" | 14.5000 | 17.7170 | 10.5118 | .7874 | 5.906 | 3.622 | - | 1"-8 | 5.96 | 6 |
| 40" | 37.4016 | 35.8268 | 18.1102 | .3543 | 7.087 | 4.409 | - | 1"-8 | 7.87 | 6 |
| 50" | 43.3071 | 39.3701 | 21.6535 | .3543 | 7.087 | 4.409 | - | 1"-8 | 7.87 | 6 |

# Plain Back Scroll Chucks

## 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Forged Steel Body
- Lathe Chuck Manual

| Chuck Dia. | Hole | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 4800 | 11 | PO3-5"A | 1-105-0500 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.6535 | 4500 | 22 | PO3-6"A | 1-105-0600 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | W-P-200 |
| 8" | 2.1654 | 4000 | 39 | PO3-8"A | 1-105-0800 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | W-P-200 |
| 10" | 2.9921 | 3500 | 55 | PO3-10"A | 1-105-1000 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | W-P-315 |
| 12-1/2" | 4.0551 | 2800 | 110 | PO3-12"A | 1-105-1200 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.3543 | 2000 | 187 | PO3-16"A | 1-105-1600 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | W-P-400 |
| 20" | 7.4803 | 1200 | 320 | PO3-20"A | 1-105-2000 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | W-P-630 |
| 25" | 9.9213 | 1000 | 551 | PO3-25"A | 1-105-2500 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | W-P-630 |
| 31-1/2" | 10.5118 | 450 | 886 | PO3-32"A | 1-105-3200 | TJ-PS3-630 | MJ-PS3-800 | STJ-PS3-630 | W-P-800 |
| 40" | 18.1100 | 400 | 1727 | PO3-40"A | 1-105-4000 | TJ-PS3-1000 | MJ-PS3-1000 | STJ-PS3-1000 | W-P-1000 |
| 50" | 21.6535 | 300 | | PO3-50"A | 1-105-5000 | TJ-PS3-1250 | MJ-PS3-1250 | STJ-PS3-1250 | W-P-1250 |

**W-SP-Extended Wrenches available from stock.
See Page 66

## 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Forged Steel Body
- Lathe Chuck Manual

| Chuck Dia. | Hole | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | ID-Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|
| 3" | 0.6299 | 6000 | 3.3 | PO3-3" | 1-106-0300 | OJ-PS3-80 | IJ-PS3-80 | SJ-PS3-80 | W-P-080 |
| 4" | 0.7874 | 5200 | 6.2 | PO3-4" | 1-106-0400 | OJ-PS3-100 | IJ-PS3-100 | SJ-PS3-100 | W-P-100 |
| 5" | 1.2598 | 4800 | 11 | PO3-5" | 1-106-0500 | OJ-PS3-125 | IJ-PS3-125 | SJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.6535 | 4500 | 22 | PO3-6" | 1-106-0600 | OJ-PS3-160 | IJ-PS3-160 | SJ-PS3-160 | W-P-200 |
| 8" | 2.1654 | 4000 | 39 | PO3-8" | 1-106-0800 | OJ-PS3-200 | IJ-PS3-200 | SJ-PS3-200 | W-P-200 |
| 10" | 2.9921 | 3500 | 55 | PO3-10" | 1-106-1000 | OJ-PS3-250 | IJ-PS3-250 | SJ-PS3-250 | W-P-315 |
| 12-1/2" | 4.0551 | 2800 | 110 | PO3-12" | 1-106-1200 | OJ-PS3-315 | IJ-PS3-315 | SJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.3543 | 2000 | 187 | PO3-16" | 1-106-1600 | OJ-PS3-400 | IJ-PS3-400 | SJ-PS3-400 | W-P-400 |
| 20" | 7.4803 | 1200 | 320 | PO3-20" | 1-106-2000 | OJ-PS3-500 | IJ-PS3-500 | SJ-PS3-500 | W-P-630 |

**W-SP-Extended Wrenches available from stock.
See Page 66



Plain Back Scroll Chucks

## 4-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Forged Steel Body
- Lathe Chuck Manual

| Chuck Dia. | Hole | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 4800 | 11 | PO4-5"A | 1-107-0500 | TJ-PS4-125 | MJ-PS4-125 | STJ-PS4-125 | W-P-125 |
| 6-1/4" | 1.6535 | 4500 | 22 | PO4-6"A | 1-107-0600 | TJ-PS4-160 | MJ-PS4-160 | STJ-PS4-160 | W-P-200 |
| 8" | 2.1654 | 4000 | 39 | PO4-8"A | 1-107-0800 | TJ-PS4-200 | MJ-PS4-200 | STJ-PS4-200 | W-P-200 |
| 10" | 2.9921 | 3500 | 55 | PO4-10"A | 1-107-1000 | TJ-PS4-250 | MJ-PS4-250 | STJ-PS4-250 | W-P-315 |
| 12-1/2" | 4.0551 | 2800 | 110 | PO4-12"A | 1-107-1200 | TJ-PS4-315 | MJ-PS4-315 | STJ-PS4-315 | W-P-315 |
| 15-3/4" | 5.3543 | 2000 | 187 | PO4-16"A | 1-107-1600 | TJ-PS4-400 | MJ-PS4-400 | STJ-PS4-400 | W-P-400 |
| 20" | 7.4803 | 1200 | 320 | PO4-20"A | 1-107-2000 | TJ-PS4-500 | MJ-PS4-500 | STJ-PS4-500 | W-P-630 |
| 25" | 9.9213 | 1000 | 551 | PO4-25"A | 1-107-2500 | TJ-PS4-630 | MJ-PS4-630 | STJ-PS4-630 | W-P-630 |
| 31-1/2" | 10.5118 | 450 | 886 | PO4-32"A | 1-107-3200 | TJ-PS4-630 | MJ-PS4-800 | STJ-PS4-630 | W-P-800 |

**W-SP-Extended Wrenches available from stock.
See Page 66

## 4-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Forged Steel Body
- Lathe Chuck Manual

| Chuck Dia. | Hole | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | ID-Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|
| 4" | 0.7874 | 3500 | 6.2 | PS4-4" | 1-108-0400 | OJ-PS4-100 | IJ-PS4-100 | SJ-PS4-100 | W-P-100 |
| 5" | 1.2598 | 3200 | 11 | PS4-5" | 1-108-0500 | OJ-PS4-125 | IJ-PS4-125 | SJ-PS4-125 | W-P-125 |
| 6-1/4" | 1.6535 | 3000 | 22 | PS4-6" | 1-108-0600 | OJ-PS4-160 | IJ-PS4-160 | SJ-PS4-160 | W-P-200 |
| 8" | 2.1654 | 2500 | 39 | PS4-8" | 1-108-0800 | OJ-PS4-200 | IJ-PS4-200 | SJ-PS4-200 | W-P-200 |
| 10" | 2.9921 | 2000 | 55 | PS4-10" | 1-108-1000 | OJ-PS4-250 | IJ-PS4-250 | SJ-PS4-250 | W-P-315 |
| 12-1/2" | 4.0551 | 1500 | 110 | PS4-12" | 1-108-1200 | OJ-PS4-315 | IJ-PS4-315 | SJ-PS4-315 | W-P-315 |
| 15-3/4" | 5.3543 | 1000 | 187 | PS4-16" | 1-108-1600 | OJ-PS4-400 | IJ-PS4-400 | SJ-PS4-400 | W-P-400 |

**W-SP-Extended Wrenches available from stock.
See Page 66



gator chucks BY TIGERCA
PO Series - Forged Steel Body Precision Scroll Chucks

# Type A1/A2 Direct Mount Scroll Chucks

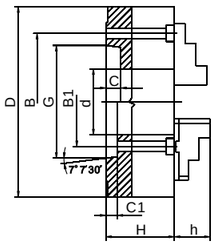
## 3-Jaw Type A1/A2 Direct Mount Scroll Chucks with Two-Piece Hard Reversible Jaws

Type A1 spindle has a 2 bolt hole pattern, inside (size B1) and outside the taper (size B). Either an A1 or A2 chuck will fit on it.
Type A2 spindle has 1 bolt pattern, outside the taper (size B). only an A2 chuck will fit on it.

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Forged Steel Body
- Lathe Chuck Manual

Type A1 / A2




Forged Steel Body

| Chuck Dia. | Taper Size | Hole Dia.(d) | RPM max. | B (A2) | B1 (A1) | G | C/C1 | H | h | wt. lbs. | Chuck Mounting Bolts Thread | L | Qty. | Model | Chuck Part No . |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | A1-5 | 1.6535 | 4500 | - | 2.4374 | 3.2505 | .563 | 2.6772 | 1.693 | 22 | 7/16-14 | 2-3/4 | 3 | PO3-6"A/A1-5 | 1-115-0605 |
| 8" | A1-5 | 1.6535 | 4000 | - | 2.4374 | 3.2505 | .563 | 3.0709 | 1.831 | 42 | 7/16-14 | 3-1/8 | 3 | PO3-8"A/A1-5 | 1-115-0805 |
| | A1-6 | 2.1653 | | - | 3.2500 | 4.1880 | .625 | | | | 1/2-13 | | | PO3-8"A/A1-6 | 1-115-0806 |
| 10" | A2-5 | 2.9921 | 3500 | 4.1260 | - | 3.2505 | .563 | 3.5039 | 2.146 | 71 | 7/16-14 | 4-1/8 | 6 | PS3-10"A/A2-5 | 1-115-1005 |
| | A1-6 | 2.1635 | | - | 3.2500 | 4.1880 | .625 | | | | 1/2-13 | 3-1/2 | | PO3-10"A/A1-6 | 1-115-1006 |
| | A1-8 | 2.9921 | | - | 4.3750 | 5.5007 | .688 | | | | 5/8-11 | 3-1/2 | | PO3-10"A/A1-8 | 1-115-1008 |
| 12-1/2" | A2-6 | 4.0551 | 2800 | 5.2520 | - | 4.1880 | .630 | 3.7874 | 2.362 | 121 | 1/2-13 | 4-3/4 | 6 | PO3-12"A/A2-6 | 1-115-1206 |
| | A1-8 | 3.1496 | | - | 4.3750 | 5.5007 | .688 | | | | 5/8-11 | 4-3/16 | | PO3-12"A/A1-8 | 1-115-1208 |
| 15-3/4" | A2-6 | 4.0551 | 2000 | 5.2520 | - | 4.1880 | .630 | 4.2520 | 2.854 | 203 | 1/2-13 | 5 | 6 | PO3-16"A/A2-6 | 1-115-1606 |
| | A2-8 | 5.3543 | | 6.7480 | - | 5.5007 | .709 | | | | 5/8-11 | 5 | | PO3-16"A/A2-8 | 1-115-1608 |
| | A1-11 | 5.1181 | | - | 6.5000 | 7.7507 | .750 | | | | 3/4-10 | 4-1/4 | | PO3-16"A/A1-11 | 1-115-1611 |
| 20" | A2-8 | 5.3543 | 1200 | 6.7480 | - | 5.5007 | .709 | 4.6850 | 3.602 | 353 | 5/8-11 | 5 | 6 | PO3-20"A/A2-8 | 1-115-2008 |
| | A2-11 | 7.4803 | | 9.2520 | - | 7.7507 | .787 | | | | 3/4-10 | 5-7/8 | 6 | PO3-20"A/A2-11 | 1-115-2011 |
| 25" | A2-11 | 7.4803 | 1000 | 9.2520 | - | 7.7507 | .787 | 5.0787 | 3.622 | 628 | 3/4-10 | 7-3/32 | 6 | PO3-25"A/A2-11 | 1-115-2511 |
| | A2-15 | 9.9213 | | 13.000 | - | 11.251 | .813 | | | | 7/8-9 | 6 | | PO3-25"A/A2-15 | 1-115-2515 |

*C-C1, depth of counterbore.
All chucks with A1 mount can be mounted on A1 spindles only.
All chucks with A2 mount can be mounted on either A1 and A2 spindles.

## Spare Parts

| Chuck Dia. | Taper Size | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Pinions | Scroll Plates | Pinion Screws | Wrenchs* | Chuck Mounting Bolts Thread | L | Qty. | Part No |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | A1-5 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | PI-PS-160 | SC-PS-160 | PH-P-160 | W-P-160 | 7/16-14 | 2-3/4 | 3 | BA-06-05 |
| 8" | A1-5 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | PI-PS-200 | SC-PS-200 | PH-P-200 | W-P-200 | 7/16-14 | 3-1/8 | | BA-08-05 |
| | A1-6 | | | | | | | | 1/2-13 | | | BA-08-06 |
| 10" | A2-5 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | PI-PS-250 | SC-PS-250 | PH-P-250 | W-P-250 | 7/16-14 | 4-1/8 | 6 | BA-10-05 |
| | A1-6 | | | | | | | | 1/2-13 | 3-1/2 | | BA-10-06 |
| | A1-8 | | | | | | | | 5/8-11 | 3-1/2 | | BA-10-08 |
| 12-1/2" | A2-6 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | PI-PS-315 | SC-PS-315 | PH-P-315 | W-P-315 | 1/2-13 | 4-3/4 | | BA-12-06 |
| | A1-8 | | | | | | | | 5/8-11 | 4-3/16 | | BA-12-08 |
| 15-3/4" | A2-6 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | PI-PS-400 | SC-PS-400 | PH-P-400 | W-P-400 | 1/2-13 | 5 | | BA-16-06 |
| | A2-8 | | | | | | | | 5/8-11 | 5 | | BA-16-08 |
| | A1-11 | | | | | | | | 3/4-10 | 4-1/4 | | BA-16-11 |
| 20" | A2-8 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | PI-PS-500 | SC-PS-500 | PH-P-500 | W-P-500 | 5/8-11 | 5 | | BA-20-08 |
| | A2-11 | | | | | | | | 3/4-10 | 5-7/8 | | BA-20-11 |
| 25" | A2-11 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | PI-PS-630 | SC-PS-630 | PH-P-630 | W-P-630 | 3/4-10 | 7-3/32 | | BA-25-11 |
| | A2-15 | | | | | | | | 7/8-9 | 6 | | BA-25-15 |

**W-SP-Extended Wrenches available from stock, See Page 66.



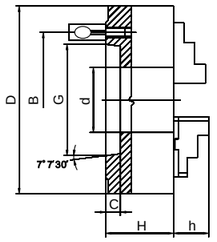
# Type D1 Direct Mount Scroll Chucks

## 3-Jaw Type D1 Direct Mount Scroll Chucks with Two-Piece Hard Reversible Jaws

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Forged Steel Body
- Lathe Chuck Manual

Type D1




Forged Steel Body

| Chuck Dia. | Taper Size | Hole Dia.(d) | RPM max. | B | G | C | H | h | wt. lbs. | Model | Chuck Part No . | Camlock Studs Dia. | Thread | Qty. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | D1-4 | 1.2598 | 4800 | 3.2520 | 2.5005 | .5118 | 2.3425 | 1.575 | 11 | PO3-5"A/D1-4 | 1-125-0504 | 5/8 | M10x1 | 6 |
| 6-1/4" | D1-3 | 1.6535 | 4500 | 2.7795 | 2.1250 | .5118 | 2.6672 | 1.693 | 20 | PO3-6"A/D1-3 | 1-125-0603 | 9/16 | M10x1 | 3 |
| | D1-4 | | | 3.2520 | 2.5005 | | | | | PO3-6"A/D1-4 | 1-125-0604 | 5/8 | | |
| 8" | D1-4 | 2.1654 | 4000 | 3.2520 | 2.5005 | .5118 | 3.0709 | 1.831 | 42 | PO3-8"A/D1-4 | 1-125-0804 | 5/8 | M10x1 | |
| | D1-5 | | | 4.1260 | 3.2505 | .5629 | | | | PO3-8"A/D1-5 | 1-125-0805 | 3/4 | M12x1 | 6 |
| | D1-6 | | | 5.2520 | 4.1880 | | | | | PO3-8"A/D1-6 | 1-125-0806 | 7/8 | M16x1.5 | |
| 10" | D1-5 | 2.9921 | 3500 | 4.1260 | 3.2505 | .5629 | 3.5039 | 2.146 | 71 | PO3-10"A/D1-5 | 1-125-1005 | 3/4 | M12x1 | |
| | D1-6 | | | 5.2520 | 4.1880 | .6299 | | | | PO3-10"A/D1-6 | 1-125-1006 | 7/8 | M16x1.5 | |
| | D1-8 | | | 6.7480 | 5.5007 | .7087 | | | | PO3-10"A/D1-8 | 1-125-1008 | 1 | M20x1.5 | |
| 12-1/2" | D1-6 | 4.0551 | 2800 | 5.2520 | 4.1880 | .6299 | 3.7874 | 2.362 | 112 | PO3-12"A/D1-6 | 1-125-1206 | 7/8 | M16x1.5 | |
| | D1-8 | | | 6.7480 | 5.5007 | .7087 | 3.7874 | | | PO3-12"A/D1-8 | 1-125-1208 | 1 | M20x1.5 | |
| | D1-11 | | | 9.2520 | 7.7507 | .7874 | 4.6339 | | | PO3-12"A/D1-11 | 1-125-1211 | 1-3/16 | M22x1.5 | |
| 15-3/4" | D1-6 | 4.0551 | 2000 | 5.2520 | 4.1880 | .6299 | 4.2520 | 2.854 | 223 | PO3-16"A/D1-6 | 1-125-1606 | 7/8 | M16x1.5 | |
| | D1-8 | 5.3543 | | 6.7480 | 5.5007 | .7087 | | | | PO3-16"A/D1-8 | 1-125-1608 | 1 | M20x1.5 | |
| | D1-11 | 5.3543 | | 9.2520 | 7.7507 | .7874 | | | | PO3-16"A/D1-11 | 1-125-1611 | 1-3/16 | M22x1.5 | |
| 20" | D1-8 | 5.3543 | 1200 | 6.7480 | 5.5007 | .7087 | 4.6850 | 3.602 | 331 | PO3-20"A/D1-8 | 1-125-2008 | 1 | M20x1.5 | |
| | D1-11 | 7.4803 | | 9.2520 | 7.7507 | .7874 | | | | PO3-20"A/D1-11 | 1-125-2011 | 1-3/16 | M22x1.5 | |
| 25" | D1-11 | 7.4803 | 1000 | 9.2520 | 7.7507 | .7874 | 5.0787 | 3.622 | 604 | PO3-25"A/D1-11 | 1-125-2511 | 1-3/16 | M22x1.5 | |

## Spare Parts

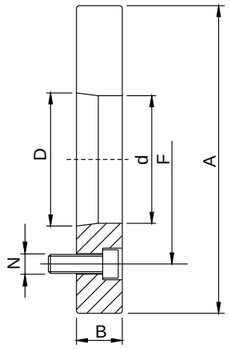
| Chuck Dia. | Taper Size | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Pinions | Scroll Plates | Pinion Screws | Wrenchs* | Camlock Studs Dia. | Thread | Qty. | Camlock Stud |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | D1-4 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | PI-PS-125 | SC-PS-125 | PH-P-125 | W-P-125 | 5/8 | M10x1 | 3 | CA-D-04 |
| 6-1/4" | D1-3 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | PI-PS-160 | SC-PS-160 | PH-P-160 | W-P-160 | 9/16 | M10x1 | | CA-D-03 |
| | D1-4 | | | | | | | | 5/8 | | | CA-D-04 |
| 8" | D1-4 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | PI-PS-200 | SC-PS-200 | PH-P-200 | W-P-200 | 5/8 | M10x1 | | CA-D-04 |
| | D1-5 | | | | | | | | 3/4 | M12x1 | 6 | CA-D-05 |
| | D1-6 | | | | | | | | 7/8 | M16x1.5 | | CA-D-06 |
| 10" | D1-5 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | PI-PS-250 | SC-PS-250 | PH-P-250 | W-P-250 | 3/4 | M12x1 | | CA-D-05 |
| | D1-6 | | | | | | | | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| 12-1/2" | D1-6 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | PI-PS-315 | SC-PS-315 | PH-P-315 | W-P-315 | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 15-3/4" | D1-6 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | PI-PS-400 | SC-PS-400 | PH-P-400 | W-P-400 | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 20" | D1-8 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | PI-PS-500 | SC-PS-500 | PH-P-500 | W-P-500 | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 25" | D1-11 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | PI-PS-630 | SC-PS-630 | PH-P-630 | W-P-630 | 1-3/16 | M22x1.5 | | CA-D-011 |

**W-SP-Extended Wrenches available from stock, See Page 66.

# SM Series Semi-machined Adapter Plate

## Type A1/A2 Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on A1 & A2 spindle noses,
Can be used after machining for scroll or independent chucks, see page 59
Spindle side of adapter is fully finished.
Provided with the set of spindle mounting bolts & hex key.
All below listed adapters can be mounted eather on A1 or A2 spindle noses.
All adapters are made of steel for longer life.



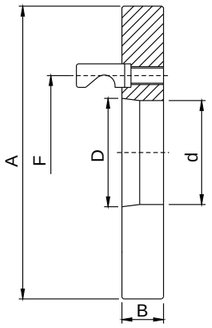

| Chuck Dia. | Taper Size | A | B | Hole d | F | D | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | N | QTY | | |
| 6-1/4" | A5 | 6.38 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 14.4 | SM-160/A5 |
| 8" | A4 | 7.99 | 0.98 | 2.40 | 3.252 | 2.5005 | 7/16-14 | 4 | 14.5 | SM-200/A4 |
| | A5 | 7.99 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 23.6 | SM-200/A5 |
| | A6 | 7.99 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 23.7 | SM-200/A6 |
| 10" | A5 | 9.96 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 37.7 | SM-250/A5 |
| | A6 | 9.96 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 38.9 | SM-250/A6 |
| | A8 | 9.96 | 1.97 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 41.6 | SM-250/A8 |
| 12-1/2" | A6 | 12.52 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 63.6 | SM-315/A6 |
| | A8 | 12.52 | 2.16 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 64.4 | SM-315/A8 |
| | A11 | 12.52 | 2.56 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 83.2 | SM-315/A11 |
| 15-3/4" | A6 | 15.94 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 6 | 105.7 | SM-400/A6 |
| | A8 | 15.94 | 1.93 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 116.5 | SM-400/A8 |
| | A11 | 15.94 | 2.95 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 137 | SM-400/A11 |
| 20" | A8 | 19.88 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 193 | SM-500/A8 |
| | A11 | 19.88 | 2.68 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 206 | SM-500/A11 |
| | A15 | 19.88 | 2.68 | 5.35 | 13.000 | 11.2509 | 7/8-9 | 6 | 228 | SM-500/A15 |
| 25" | A8 | 25.00 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 311 | SM-630/A8 |
| | A11 | 25.00 | 2.60 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 391 | SM-630/A11 |
| | A15 | 25.00 | 2.52 | 7.48 | 13.000 | 11.2509 | 7/8-9 | 6 | 350 | SM-630/A15 |



SM Series Semi-machined Adapter Plate

## Type D1 Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on CAMLOCK D1 spindle noses,
After machining can be used with scroll or independent chucks, see page 59
Spindle side of adapter is fully finished,
Provided with the set of Camlock studs, set screws & hex key.
All adapters are made of steel for longer life.

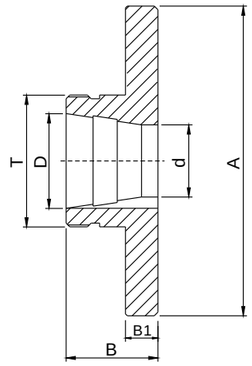



| Chuck Dia. | Taper Size | A | B | Hole d | F | D | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | OD | QTY | | |
| 5" | D1-3 | 5.00 | 1.024 | 1.5 | 2.78 | 2.1250 | 9/16" | 3 | 5.7 | SM-125/D3 |
| | D1-4 | 5.00 | 1.024 | 1.5 | 3.252 | 2.5005 | 5/8" | 3 | 5.5 | SM-125/D4 |
| 6-1/4" | D1-3 | 6.38 | 1.26 | 2.03 | 2.78 | 2.1250 | 9/16" | 3 | 11.7 | SM-160/D3 |
| | D1-4 | 6.38 | 1.26 | 2.03 | 3.252 | 2.5005 | 5/8" | 3 | 11.5 | SM-160/D4 |
| | D1-5 | 6.38 | 1.38 | 2.03 | 4.126 | 3.2505 | 3/4" | 6 | 12.1 | SM-160/D5 |
| 8" | D1-4 | 7.99 | 1.732 | 2.40 | 3.252 | 2.5005 | 5/8" | 3 | 25.6 | SM-200/D4 |
| | D1-5 | 7.99 | 1.97 | 2.40 | 4.126 | 3.2505 | 3/4" | 6 | 22.3 | SM-200/D5 |
| | D1-6 | 7.99 | 1.77 | 2.40 | 5.252 | 4.1880 | 7/8" | 6 | 24.3 | SM-200/D6 |
| 10" | D1-5 | 9.96 | 1.93 | 3.13 | 4.126 | 3.2505 | 3/4" | 6 | 32.6 | SM-250/D5 |
| | D1-6 | 9.96 | 1.93 | 3.13 | 5.252 | 4.1880 | 7/8" | 6 | 34.5 | SM-250/D6 |
| | D1-8 | 9.96 | 1.93 | 3.13 | 6.748 | 5.5005 | 1" | 6 | 40.4 | SM-250/D8 |
| 12-1/2" | D1-6 | 12.52 | 2.76 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 66 | SM-315/D6 |
| | D1-8 | 12.52 | 2.16 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 59.3 | SM-315/D8 |
| | D1-11 | 12.52 | 2.16 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 68.8 | SM-315/D11 |
| 15-3/4" | D1-6 | 15.94 | 1.65 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 100 | SM-400/D6 |
| | D1-8 | 15.94 | 2.76 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 116 | SM-400/D8 |
| | D1-11 | 15.94 | 1.97 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 102 | SM-400/D11 |
| 20" | D1-8 | 19.88 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 165 | SM-500/D8 |
| | D1-11 | 19.88 | 2.83 | 5.36 | 9.252 | 7.7507 | 1-3/16" | 6 | 188 | SM-500/D11 |
| | D1-15 | 19.88 | 2.36 | 5.36 | 13.00 | 11.2509 | 1-3/8" | 6 | 173 | SM-500/D15 |
| 25" | D1-8 | 25.00 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 269 | SM-630/D8 |
| | D1-11 | 25.00 | 2.83 | 7.79 | 9.252 | 7.7507 | 1-3/16" | 6 | 278 | SM-630/D11 |
| | D1-15 | 25.00 | 2.36 | 7.48 | 13.00 | 11.2509 | 1-3/8" | 6 | 270 | SM-630/D15 |

# SM Series Semi-machined Adapter Plate

## Type L Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on long taper L spindle noses,
Can be used after machining for scroll or independent chucks, see page 59
Spindle side of adapter is fully finished,
All adapters are made of steel for longer life.



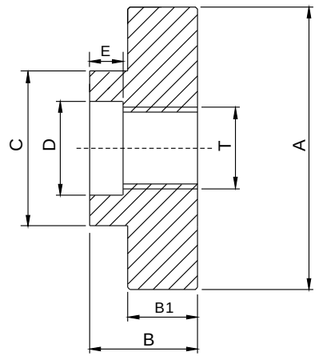

| Chuck Dia. | A | Taper Size | Thread T - UNS3 | D | Thru Hole d | B1 | B | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 6.38 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.063 | 2.342 | 12.7 | SM-160/L00 |
| 6-1/4" | 6.38 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.063 | 2.736 | 15 | SM-160/L0 |
| 8" | 7.99 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.083 | 2.362 | 19.2 | SM-200/L00 |
| 8" | 7.99 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.083 | 2.756 | 21.5 | SM-200/L0 |
| 8" | 7.99 | L1 | 6 - 6 | 4.125 | 3.35 | 1.083 | 2.992 | 26.5 | SM-200/L1 |
| 10" | 9.96 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.338 | 2.618 | 35.2 | SM-250/L00 |
| 10" | 9.96 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.338 | 2.52 | 35.5 | SM-250/L0 |
| 10" | 9.96 | L1 | 6 - 6 | 4.125 | 3.35 | 1.338 | 3.307 | 42.4 | SM-250/L1 |
| 12-1/2" | 12.52 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.40 | 2.64 | 57.8 | SM-315/L0 |
| 12-1/2" | 12.52 | L1 | 6 - 6 | 4.125 | 3.35 | 1.40 | 3.11 | 62.7 | SM-315/L1 |
| 12-1/2" | 12.52 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.45 | 3.50 | 72.8 | SM-315/L2 |
| 15-3/4" | 15.94 | L1 | 6 - 6 | 4.125 | 3.35 | 1.50 | 3.23 | 103 | SM-400/L1 |
| 15-3/4" | 15.94 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 113 | SM-400/L2 |
| 15-3/4" | 15.94 | L3 | 10-3/8 - 4 | 6.500 | 5.43 | 1.50 | 4.18 | 139 | SM-400/L3 |
| 20" | 19.88 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 167 | SM-500/L2 |



SM Series Semi-machined Adapter Plate

## Type Threaded Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on a threaded spindle noses,
Can be used after machining with scroll or independent chucks, see page 59
Spindle side of adapter is fully finished,
All adapters are made of steel for longer life.

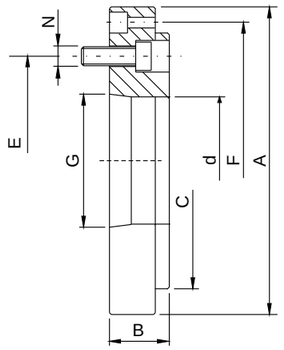



| Chuck Dia. | Thread T | A | D | E | C | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 4" | 1-10 UNS-2B | 4.09 | 1.0150 | 0.50 | 2.165 | 1.535 | 0.709 | 4.85 | SM-100/T1 |
| | 1-1/2 - 8 UN-2B | 4.09 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 5.29 | SM-100/T2 |
| 5" | 1-1/8 - 12 W | 5.08 | 1.2496 | 0.50 | 2.165 | 1.535 | 0.709 | 4.05 | SM-125/T3 |
| | 1-1/2 - 8 UN-2B | 5.08 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 6.61 | SM-125/T2 |
| | 2-3/16 - 10 Hardinge | 5.08 | 2.1889 | 0.626 | 3.11 | 1.772 | 0.709 | 7.05 | SM-125/T4 |
| | 2-1/4 - 8 UN-2B | 5.08 | 2.2600 | 0.626 | 3.18 | 1.83 | 0.709 | 6.80 | SM-125/T5 |
| 6-1/4" | 1-1/2 - 8 UN-2B | 6.535 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.787 | 7.05 | SM-160/T2 |
| | 2-3/16 - 10 Hardinge | 6.535 | 2.1889 | 0.50 | 3.11 | 1.85 | 0.787 | 7.50 | SM-160/T4 |
| | 2-1/4 - 8 UN-2B | 6.535 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.787 | 7.94 | SM-160/T5 |
| 8" | 1-1/2 - 8 UN-2B | 8.11 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.866 | 9.92 | SM-200/T2 |
| | 2-1/4 - 8 UN-2B | 8.11 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.866 | 11.46 | SM-200/T5 |
| | 2-3/8 - 6 UN-2B | 8.11 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.866 | 13.89 | SM-200/T6 |
| 10" | 2-3/8 - 6 UN-2B | 10.08 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.984 | 30 | SM-250/T6 |
| 12-1/2" | 2-3/8 - 6 UN-2B | 12.64 | 2.3850 | 0.626 | 4.33 | 2.047 | 1.102 | 50 | SM-315/T6 |

# FM Series Pre-machined Adapter Plate

## Type A1/A2 Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 59
All adapters come with the set of spindle mounting bolts & hex key
All below listed adapters can be mounted eather on A1 or A2 spindle noses.
All adapters are made of steel for longer life.



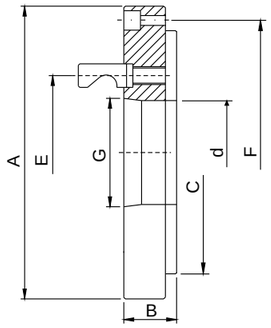

| Chuck Dia. | Taper Size | A | B | C | Hole d | E | F | G | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | N | QTY | | |
| 6-1/4" | A5 | 6.30 | .83 | 5 | 3.13 | 4.126 | 5.5118 | 3.2505 | 7/16-14 | 6 | 6.5 | FM-160/A5 |
| 8" | A4 | 7.87 | .83 | 6.378 | 2.40 | 3.252 | 6.9291 | 2.5005 | 7/16-14 | 6 | 11.8 | FM-200/A4 |
| | A5 | 7.87 | .83 | 6.378 | 3.13 | 4.126 | 6.9291 | 3.2505 | 7/16-14 | 6 | 11 | FM-200/A5 |
| | A6 | 7.87 | .83 | 6.378 | 4.06 | 5.252 | 6.9291 | 4.1880 | 1/2-13 | 6 | 9.6 | FM-200/A6 |
| 10" | A5 | 9.84 | 1.02 | 7.9527 | 3.13 | 4.126 | 8.8189 | 3.2505 | 7/16-14 | 6 | 22.7 | FM-250/A5 |
| | A6 | 9.84 | 1.02 | 7.9527 | 4.06 | 5.252 | 8.8189 | 4.1880 | 1/2-13 | 6 | 21 | FM-250/A6 |
| | A8 | 9.84 | 1.02 | 7.9527 | 5.36 | 6.748 | 8.8189 | 5.5005 | 5/8-11 | 6 | 17.8 | FM-250/A8 |
| 12-1/2" | A6 | 12.40 | 1.30 | 10.315 | 4.06 | 5.252 | 11.2598 | 4.1880 | 1/2-13 | 6 | 45.5 | FM-315/A6 |
| | A8 | 12.40 | 1.30 | 10.315 | 5.36 | 6.748 | 11.2598 | 5.5005 | 5/8-11 | 6 | 41 | FM-315/A8 |
| | A11 | 12.40 | 1.38 | 10.315 | 7.59 | 9.252 | 11.2598 | 7.7507 | 3/4-10 | 6 | 34 | FM-315/A11 |
| 15-3/4" | A6 | 15.75 | 1.30 | 13.11 | 4.06 | 5.252 | 14.2519 | 4.1880 | 1/2-13 | 6 | 76.7 | FM-400/A6 |
| | A8 | 15.75 | 1.30 | 13.11 | 5.36 | 6.748 | 14.2519 | 5.5005 | 5/8-11 | 6 | 72.6 | FM-400/A8 |
| | A11 | 15.75 | 1.30 | 13.11 | 7.59 | 9.252 | 14.2519 | 7.7507 | 3/4-10 | 6 | 63.2 | FM-400/A11 |
| 20" | A8 | 19.96 | 1.34 | 16.6535 | 5.36 | 6.748 | 18.0314 | 5.5005 | 5/8-11 | 6 | 122 | FM-500/A8 |
| | A11 | 19.96 | 1.34 | 16.6535 | 7.59 | 9.252 | 18.0314 | 7.7507 | 3/4-10 | 6 | 112 | FM-500/A11 |
| | A15 | 19.96 | 1.54 | 16.6535 | 11.08 | 13.000 | 18.0314 | 11.2509 | 7/8-9 | 6 | 103 | FM-500/A15 |
| 25" | A8 | 24.80 | 1.65 | 21.575 | 5.36 | 6.748 | 23.0709 | 5.5005 | 5/8-11 | 6 | 247 | FM-630/A8 |
| | A11 | 24.80 | 1.65 | 21.575 | 7.59 | 9.252 | 23.0709 | 7.7507 | 3/4-10 | 6 | 235 | FM-630/A11 |
| | A15 | 24.80 | 1.65 | 21.575 | 11.08 | 13.000 | 23.0709 | 11.2509 | 7/8-9 | 6 | 207 | FM-630/A15 |



FM Series Pre-machined Adapter Plate

## Type D1 Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 59
All adapters come with the Camlock Studs, set screws & hex key.
All adapters are made of steel for longer life.

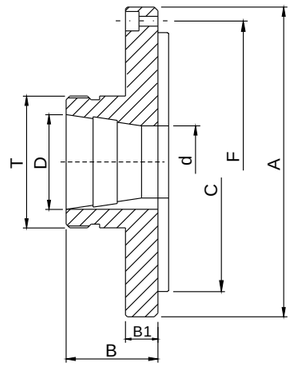



| Chuck Dia. | Taper Size | A | B | C | Hole d | E | F | G | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | OD | QTY | | |
| 5" | D1-3 | 4.92 | 1.024 | 3.82 | 2.03 | 2.78 | 4.2520 | 2.1250 | 9/16" | 3 | 5.2 | FM-125/D3 |
| | D1-4 | 4.92 | 1.024 | 3.82 | 2.40 | 3.252 | 4.2520 | 2.5005 | 5/8" | 3 | 4.8 | FM-125/D4 |
| 6-1/4" | D1-3 | 6.30 | 1.06 | 5 | 2.03 | 2.78 | 5.5118 | 2.1250 | 9/16" | 3 | 9.6 | FM-160/D3 |
| | D1-4 | 6.30 | 1.06 | 5 | 2.40 | 3.252 | 5.5118 | 2.5005 | 5/8" | 3 | 9.1 | FM-160/D4 |
| | D1-5 | 6.30 | 1.18 | 5 | 3.13 | 4.126 | 5.5118 | 3.2505 | 3/4" | 6 | 9.0 | FM-160/D5 |
| 8" | D1-4 | 7.87 | 1.06 | 6.378 | 2.40 | 3.252 | 6.9291 | 2.5005 | 5/8" | 3 | 15.2 | FM-200/D4 |
| | D1-5 | 7.87 | 1.18 | 6.378 | 3.13 | 4.126 | 6.9291 | 3.2505 | 3/4" | 6 | 15.5 | FM-200/D5 |
| | D1-6 | 7.87 | 1.44 | 6.378 | 4.06 | 5.252 | 6.9291 | 4.1880 | 7/8" | 6 | 16.7 | FM-200/D6 |
| 10" | D1-5 | 9.84 | 1.18 | 7.9527 | 3.13 | 4.126 | 8.8189 | 3.2505 | 3/4" | 6 | 26.2 | FM-250/D5 |
| | D1-6 | 9.84 | 1.44 | 7.9527 | 4.06 | 5.252 | 8.8189 | 4.1880 | 7/8" | 6 | 29.4 | FM-250/D6 |
| | D1-8 | 9.84 | 1.54 | 7.9527 | 5.36 | 6.748 | 8.8189 | 5.5005 | 1" | 6 | 26.7 | FM-250/D8 |
| 12-1/2" | D1-6 | 12.40 | 1.56 | 10.315 | 4.06 | 5.252 | 11.2598 | 4.1880 | 7/8" | 6 | 54.4 | FM-315/D6 |
| | D1-8 | 12.40 | 1.65 | 10.315 | 5.36 | 6.748 | 11.2598 | 5.5005 | 1" | 6 | 52.7 | FM-315/D8 |
| | D1-11 | 12.40 | 2.05 | 10.315 | 7.59 | 9.252 | 11.2598 | 7.7507 | 1-3/16" | 6 | 50.1 | FM-315/D11 |
| 15-3/4" | D1-6 | 15.75 | 1.56 | 13.11 | 4.06 | 5.252 | 14.2519 | 4.1880 | 7/8" | 6 | 91.1 | FM-400/D6 |
| | D1-8 | 15.75 | 1.54 | 13.11 | 5.36 | 6.748 | 14.2519 | 5.5005 | 1" | 6 | 85.8 | FM-400/D8 |
| | D1-11 | 15.75 | 1.85 | 13.11 | 7.59 | 9.252 | 14.2519 | 7.7507 | 1-3/16" | 6 | 89.8 | FM-400/D11 |
| 20" | D1-8 | 19.69 | 1.54 | 16.6535 | 5.36 | 6.748 | 18.0314 | 5.5007 | 1" | 6 | 140.4 | FM-500/D8 |
| | D1-11 | 19.69 | 1.85 | 16.6535 | 7.59 | 9.252 | 18.0314 | 7.7507 | 1-3/16" | 6 | 155.5 | FM-500/D11 |
| | D1-15 | 19.69 | 1.97 | 16.6535 | 11.08 | 13.00 | 18.0314 | 11.2509 | 1-3/8" | 6 | 132.8 | FM-500/D15 |
| 25" | D1-8 | 24.80 | 1.54 | 21.575 | 5.36 | 6.748 | 23.0709 | 5.5007 | 1" | 6 | 229.5 | FM-630/D8 |
| | D1-11 | 24.80 | 1.85 | 21.575 | 7.59 | 9.252 | 23.0709 | 7.7507 | 1-3/16" | 6 | 263 | FM-630/D11 |
| | D1-15 | 24.80 | 1.97 | 21.575 | 11.08 | 13.00 | 23.0709 | 11.2509 | 1-3/8" | 6 | 247 | FM-630/D15 |

# FM Series Pre-machined Adapter Plate

## Type L Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 59.
All adapters are made of steel for longe life.




| Chuck Dia. | A | Taper Size | Thread T - UNS3 | B | B1 | C | Thru Hole d | D | F | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 6.30 | L00 | 3-3/4 - 6 | 2.126 | 0.7283 | 5 | 2.20 | 2.750 | 5.5118 | 9.76 | FM-160/L00 |
| 6-1/4" | 6.30 | L0 | 4-1/2 - 6 | 2.52 | 0.7283 | 5 | 2.60 | 3.250 | 5.5118 | 12.3 | FM-160/L0 |
| 8" | 7.87 | L00 | 3-3/4 - 6 | 2.126 | 0.7086 | 6.378 | 2.20 | 2.750 | 6.9291 | 13.6 | FM-200/L00 |
| 8" | 7.87 | L0 | 4-1/2 - 6 | 2.52 | 0.7086 | 6.378 | 2.60 | 3.250 | 6.9291 | 16.2 | FM-200/L0 |
| 8" | 7.87 | L1 | 6 - 6 | 2.99 | 0.7086 | 6.378 | 3.35 | 4.125 | 6.9291 | 23.5 | FM-200/L1 |
| 10" | 9.87 | L00 | 3-3/4 - 6 | 2.126 | 0.827 | 7.9527 | 2.20 | 2.750 | 8.8189 | 22.5 | FM-250/L00 |
| 10" | 9.87 | L0 | 4-1/2 - 6 | 2.52 | 0.827 | 7.9527 | 2.60 | 3.250 | 8.8189 | 24.9 | FM-250/L0 |
| 10" | 9.87 | L1 | 6 - 6 | 2.99 | 0.827 | 7.9527 | 3.35 | 4.125 | 8.8189 | 31.8 | FM-250/L1 |
| 12-1/2" | 12.40 | L0 | 4-1/2 - 6 | 2.52 | 1.102 | 10.315 | 2.60 | 3.250 | 11.2598 | 46.1 | FM-315/L0 |
| 12-1/2" | 12.40 | L1 | 6 - 6 | 2.99 | 1.102 | 10.315 | 3.35 | 4.125 | 11.2598 | 51.9 | FM-315/L1 |
| 12-1/2" | 12.40 | L2 | 7-3/4 - 5 | 3.504 | 1.102 | 10.315 | 4.29 | 5.250 | 11.2598 | 63.5 | FM-315/L2 |
| 15-3/4" | 15.83 | L1 | 6 - 6 | 2.99 | 1.102 | 13.11 | 3.35 | 4.125 | 14.2519 | 79 | FM-400/L1 |
| 15-3/4" | 15.83 | L2 | 7-3/4 - 5 | 3.504 | 1.102 | 13.11 | 4.29 | 5.250 | 14.2519 | 90 | FM-400/L2 |
| 15-3/4" | 15.83 | L3 | 10-3/8 - 4 | 3.937 | 1.102 | 13.11 | 5.43 | 6.500 | 14.2519 | 118 | FM-400/L3 |
| 20" | 19.80 | L2 | 7-3/4 - 5 | 3.504 | 1.142 | 16.6535 | 4.29 | 5.250 | 18.0314 | 133 | FM-500/L2 |

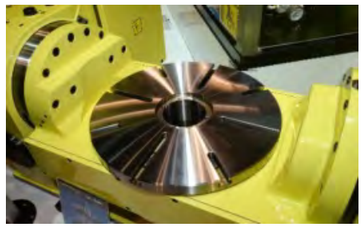


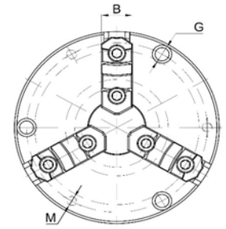


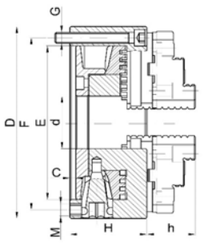
# BPD Series Base Plate

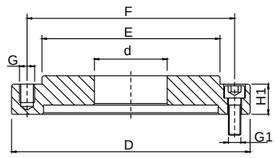
## BPD Base Plate for PO Series & PS Series 3 & 4 Jaw Plain Back Front Mount Scroll Chucks

Designed for use with 3 & 4 jaw scroll front mount plain back chucks
Ideal for use on a CNC or manual rotay tables and indexers with the 3, 4, 6 and 8 T-Slots
Base plates are provided with mounting bolts with T-Nuts and hex key.
All base plates are made of steel for longer life.
Full front mount chuck specification see on the Page 115.



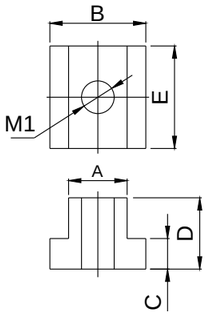


| Chuck Dia. | D | E | F | d | H1 | Chuck Mounting Bolts | | Base Plate Mounting Bolts | | H | | h 2-Pc Jaws | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | G (UNC) | No . Of Bolts | G1 | No . Of Bolts | PS | PO | | |
| 5" | 4.921 | 3.740 | 4.252 | 1.875 | 0.551 | 5/16"-18 | 3 | M6 | 4 | 2.205 | 2.422 | 1.575 | BPD-125 |
| 6-1/4" | 6.299 | 4.921 | 5.512 | 1.850 | 0.636 | 3/8"-16 | 3 | M8 | 4 | 2.539 | 2.756 | 1.693 | BPD-160 |
| 8" | 7.874 | 6.299 | 6.929 | 2.362 | 0.709 | 3/8"-16 | 3 | M8 | 4 | 2.953 | 3.150 | 1.772 | BPD-200 |
| 10" | 9.843 | 7.874 | 8.819 | 3.189 | 0.787 | 1/2"-13 | 3 | M10 | 4 | 3.347 | 3.543 | 2.087 | BPD-250 |
| 12-1/2" | 12.402 | 10.236 | 11.260 | 4.252 | 0.984 | 5/8"-11 | 3 | M10 | 4 | 3.701 | 3.937 | 2.244 | BPD-315 |
| 15-3/4" | 15.748 | 12.992 | 14.252 | 5.551 | 1.063 | 5/8"-11 | 3 | M12 | 4 | 4.134 | 4.331 | 2.693 | BPD-400 |
| 20" | 19.685 | 16.535 | 18.031 | 7.677 | 1.181 | 3/4"-10 | 3 | M16 | 4 | 4.527 | 4.685 | 3.150 | BPD-500 |

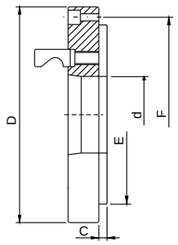
| Chuck Dia. | M1 | A | B | C | D | E |
|---|---|---|---|---|---|---|
| 5" | M6 | .3150 | .5118 | .1969 | .3543 | .5118 |
| 6-1/4" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 8" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 10" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 12-1/2" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 15-3/4" | M12 | .5512 | .8661 | .3150 | .6299 | .8661 |
| 20" | M16 | .7087 | 1.1024 | .3937 | .7874 | 1.1024 |

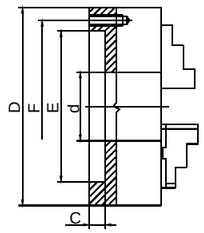


# Adapter Plate Installation Recommendations

## For SM & FM Adapter Plate

Note: All Gator Adapter Plates are made of steel.




| Chuck Dia.D | SM & FM Adapter mounting dimensions after machining | | | | Chuck mounting dimension | | | |
|---|---|---|---|---|---|---|---|---|
| | Required Boss Dia. E | F | C | D | Counter bore Dia E H7 | F | C | D |
| 4" | 2.7567 | 3.2677 | 0.0984 | 3.9370 | 2.7571 | 3.2677 | 0.1181 | 3.9370 |
| | 2.7560 | | | | 2.7559 | | | |
| 5" | 3.7411 | 4.2520 | 0.1378 | 4.9213 | 3.7415 | 4.2520 | 0.1575 | 4.9213 |
| | 3.7403 | | | | 3.7402 | | | |
| 6-1/4" | 4.9224 | 5.5118 | 0.1378 | 6.2992 | 4.9228 | 5.5118 | 0.1575 | 6.2992 |
| | 4.9214 | | | | 4.9213 | | | |
| 8" | 6.3003 | 6.9291 | 0.1378 | 7.8740 | 6.3008 | 6.9291 | 0.1575 | 7.8740 |
| | 6.2993 | | | | 6.2992 | | | |
| 10" | 7.8753 | 8.8189 | 0.1772 | 9.8425 | 7.8758 | 8.8189 | 0.1969 | 9.8425 |
| | 7.8742 | | | | 7.8740 | | | |
| 12-1/2" | 10.2376 | 11.2598 | 0.1772 | 12.4016 | 10.2383 | 11.2598 | 0.1969 | 12.4016 |
| | 10.2364 | | | | 10.2362 | | | |
| 15-3/4" | 12.9937 | 14.2519 | 0.1772 | 15.7480 | 12.9944 | 14.2519 | 0.1969 | 15.7480 |
| | 12.9923 | | | | 12.9921 | | | |
| 20" | 16.5372 | 18.0314 | 0.1772 | 19.6850 | 16.5379 | 18.0314 | 0.1969 | 19.6850 |
| | 16.5356 | | | | 16.5354 | | | |
| 25" | 21.4584 | 23.0709 | 0.2362 | 24.8031 | 21.4594 | 23.0709 | 0.2756 | 24.8031 |
| | 21.4577 | | | | 21.4567 | | | |

1/ Before adapter installation using dial indicator verify spindle nose radial & face run outs. Go to page 44 to verify spindle nose accuracy requirements.

2/ Be sure that spindle nose and adapter plate mounting surfaces are properly cleaned up.

3/ For Camlock mount be sure that all Camlock studs and set screws are mounted correctly.

4/ After selecting suitable back plate , mount it onto the lathe spindle nose.

5/ Proper adapter installation is very important in order to secure concentricity between the lathe's spindle nose and the chuck.

6/ The chuck counterbore diameter is finished by manufacturer to H7 Class, with depth, C.

7/ Prior to machining the adapter, accurately measure the chuck's counterbore diameter, E and depth, C.

8/ A good press fit, H7/k6, is most desirable. See chart above.

9/ To insure very good chuck concentricity, it is important that this procedure is done accurately.

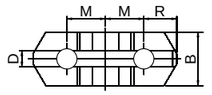
10/ After the installation check chuck face & radial run outs and using a precision ground stock mount it in a chuck jaws and check its radial run out. See page 44

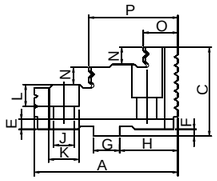




## Hard Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



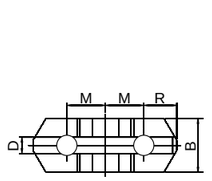
5" to 12-1/2"

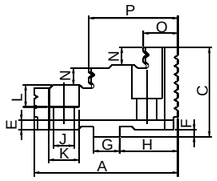
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS3-1000 |

## Hard Top Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



5" to 12-1/2"

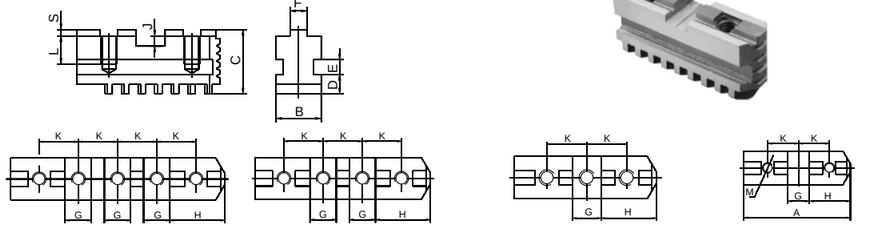
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS4-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS4-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS4-1000 |

# Jaws - Hard Master Jaws

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

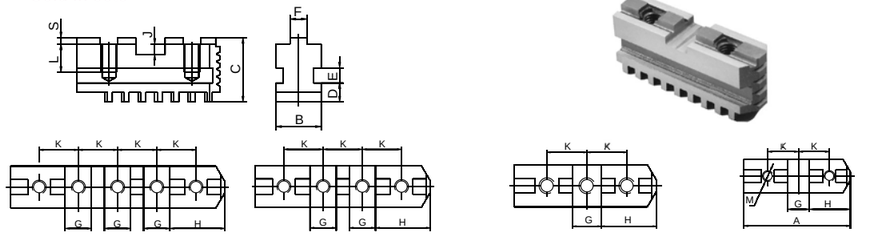


■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-8 | 0.93 | MJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS3-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS3-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS3-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS3-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS3-1250 |

## Hard Master Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

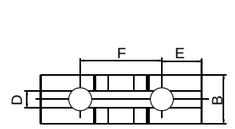
| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-8 | 0.93 | MJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS4-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS4-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS4-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS4-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS4-1250 |



# Jaws - Soft Top Jaws

## Soft Top Jaws, For 3-Jaw & 4-Jaw Chucks

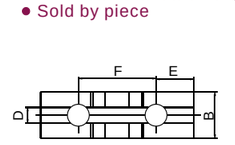
- American Standard Tongue & Groove Jaws
- Sold by piece



| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS1-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS1-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS1-630 |

## Soft Top Jaws, For 2-Jaw Chucks

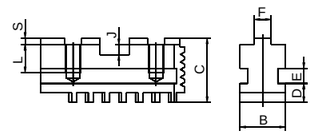
- American Standard Tongue & Groove Jaws
- Sold by piece



| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | K | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 3.071 | 1.575 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 1.14 | 3/8-16 | 1.35 | STJ-PS2-160 |
| 8" | 3.543 | 1.575 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 1.22 | 3/8-16 | 1.85 | STJ-PS2-200 |
| 10" | 4.173 | 1.850 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1.50 | 1/2-13 | 3.00 | STJ-PS2-250 |
| 12-1/2" | 4.724 | 2.047 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1.57 | 1/2-13 | 4.00 | STJ-PS2-315 |
| 15-3/4" | 5.512 | 2.047 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 1.79 | 5/8-11 | 5.50 | STJ-PS2-400 |

## Hard Master Jaws, For 2-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



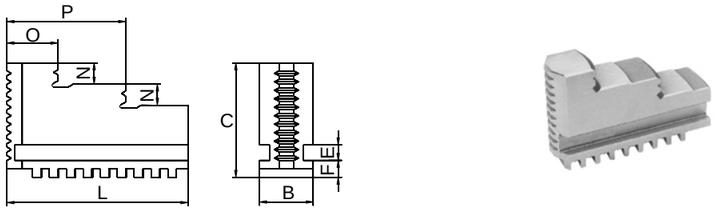
■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS2-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS2-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS2-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS2-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS2-400 |

# Jaws - ID Jaws

## ID Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

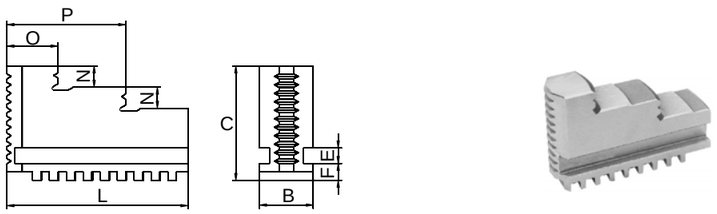





| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS3-500 |

## ID Hard Solid Jaws, For 4-Jaw Chucks

- Sold in sets





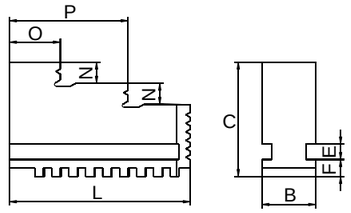

| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS4-500 |

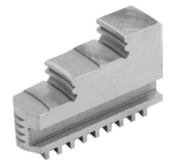


# Jaws - OD Jaws

## OD Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

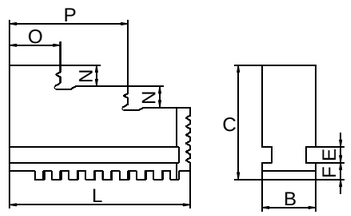


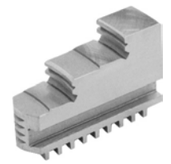



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS3-500 |

## OD Hard Solid Jaws, For 4-Jaw Chucks

- Sold in sets



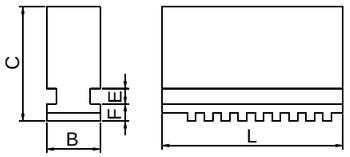



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS4-500 |

# Jaws - Soft Solid Jaws

## Soft Solid Jaws, For 3-Jaw Chucks

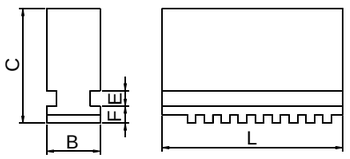
- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS3-500 |

## Soft Solid Jaws, For 4-Jaw Chucks

- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS4-500 |



# Spare Parts

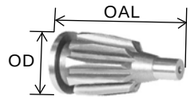
## Scroll Plates

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 3" | SC-PS-080 | 2.1575 |
| 4" | SC-PS-100 | 2.7323 |
| 5" | SC-PS-125 | 3.7008 |
| 6-1/4" | SC-PS-160 | 4.8819 |
| 8" | SC-PS-200 | 6.2598 |
| 10" | SC-PS-250 | 7.7953 |
| 12-1/2" | SC-PS-315 | 10.1575 |
| 15-3/4" | SC-PS-400 | 12.9134 |
| 20" | SC-PS-500 | 16.4173 |
| 25" | SC-PS-630 | 21.3386 |
| 31-1/2" | SC-PS-800 | 27.4106 |

## Pinions

- Sold by piece




| Chuck Dia. | Part No. | OD | OAL |
|---|---|---|---|
| 3" | PI-PS-080 | .7480 | 1.0315 |
| 4" | PI-PS-100 | .9843 | 1.3976 |
| 5" | PI-PO-125 | .9843 | 1.3268 |
| 6-1/4" | PI-PO-160 | 1.1024 | 1.6063 |
| 8" | PI-PO-200 | 1.1811 | 1.9882 |
| 10" | PI-PO-250 | 1.3583 | 2.2638 |
| 12-1/2" | PI-PO-315 | 1.4764 | 2.8543 |
| 15-3/4" | PI-PO-400 | 1.7323 | 3.6614 |
| 20" | PI-PO-500 | 1.9685 | 3.8780 |
| 25" | PI-PO-630 | 2.0472 | 4.7087 |
| 31-1/2" | PI-PO-800 | 2.0472 | 7.0078 |

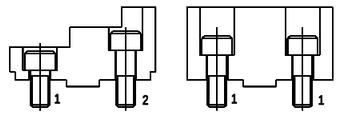
## Pinion Sleeves

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 3" | - |
| 4" | - |
| 5" | PS-P-125 |
| 6-1/4" | PS-P-160 |
| 8" | PS-P-200 |
| 10" | PS-P-250 |
| 12-1/2" | PS-P-315 |
| 15-3/4" | PS-P-400 |
| 20" | PS-P-500 |
| 25" | PS-P-630 |
| 31-1/2" | PS-P-800 |

## Jaw Mounting Bolts

- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 5" | 5/16-18 | MT-J1-5 | 0.79 | MT-J2-5 | 1.00 |
| 6-1/4" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 8" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 10" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 12-1/2" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 15-3/4" | 5/8-11 | MT-J1-16 | 1.00 | MT-J2-16 | 1.57 |
| 20" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 25" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 31-1/2" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |

## Half Ring

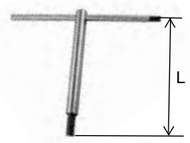
- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 3" | - |
| 4" | - |
| 5" | HR-P-125 |
| 6-1/4" | HR-P-160 |
| 8" | HR-P-200 |
| 10" | HR-P-250 |
| 12-1/2" | HR-P-315 |
| 15-3/4" | HR-P-400 |
| 20" | HR-P-500 |
| 25" | HR-P-630 |
| 31-1/2" | HR-P-800 |

## Wrenches (Standard & Extended)

- Sold by piece

Standard Wrench



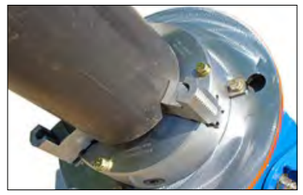

Extended Wrench

| Chuck Dia. | Square Size | Standard | | Extended | |
|---|---|---|---|---|---|
| | | L | Part No. | L | Part No. |
| 3" | .2344 | 2.36 | W-P-080 | - | - |
| 4" | .3543 | 3.15 | W-P-100 | - | - |
| 5" | .3543 | 3.15 | W-P-125 | - | - |
| 6-1/4" | .4331 | 3.90 | W-P-160 | 7.87 | W-SP-160 |
| 8" | .4331 | 3.90 | W-P-200 | 10.02 | W-SP-200 |
| 10" | .5512 | 4.78 | W-P-250 | 8.74 | W-SP-250 |
| 12-1/2" | .5512 | 4.76 | W-P-315 | 10.87 | W-SP-315 |
| 15-3/4" | .6693 | 5.51 | W-P-400 | 10.75 | W-SP-400 |
| 20" | .7480 | 9.06 | W-P-500 | 18.11 | W-SP-500 |
| 25" | .7480 | 9.06 | W-P-630 | - | - |
| 31-1/2" | .7480 | 9.06 | W-P-800 | - | - |

# PS SERIES

## Medium Duty Semi-Steel Body Universal Self-Centering Scroll Chucks

PS Universal Scroll Chucks provide high accuracy and durability for tool room and quality control applications. For use on lathes, grinders, rotary tables, CNC indexers in a variety of turning and milling medium duty applications. They are also very useful for welding, inspections and laser markings.





gator chucks BY FUERDA
PS Series - Semi-Steel Body Universal Scroll Chucks

# PS Series Semi-Steel Body Universal Scroll Chucks

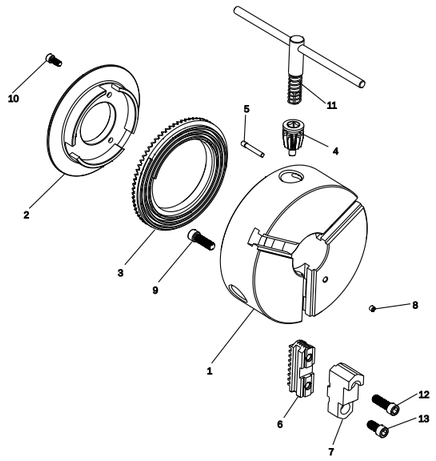
Medium Duty
2 , 3 & 4-Jaw Universal Self-Centering Scroll Chucks.
Semi-Steel Body

## Features and Benefits

- Along with large selection of the adapter plates, Gator provides a full complement of spare parts.
- All PS chucks come with either American Standard two-piece tongue and groove jaws, or two sets of hard solid ID & OD Jaws.
- Chuck Body is made of high quality cast iron. All jaw guideways and bearing surfaces are precisely machined.
- Scroll plate is drop forged of fine alloy steel, hardened and ground.
- Hardened jaws and pinions increase life of the chuck.
- PS chucks are available with Plain Back, Camlock, A & L Mounts.
- All Gator chucks with diameters from 3" thru 10" are being
- Shipped in a high quality strong cardboard boxes.
- All Gator chucks with the diameters from 12-1/2" & UP are being shipped in a high quality strong wooden crates.

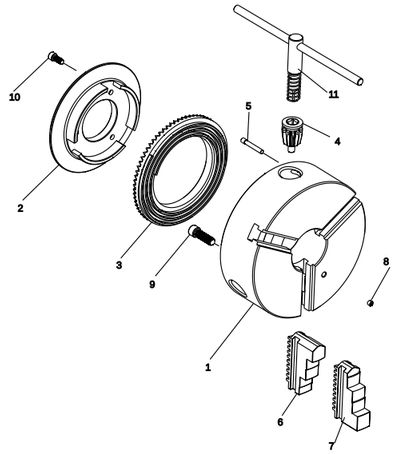
# Chuck Part Listing

## Chucks with Two-Piece Reversible Jaws




1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Screw
6. Hard Master Jaws
7. Hard Top Jaws
8. Grease Nipple
9. Chuck Mounting Bolts
10. Back Cover Mounting Bolts
11. Chuck Wrench
12 & 13. Jaw Mounting Bolts

## Chucks with Two Sets of OD & ID Hard Solid Jaws

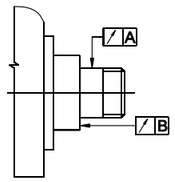



1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Screw
6. Hard Solid ID Jaws
7. Hard Solid OD Jaws
8. Grease Nipple
9. Chuck Mounting Bolts
10. Back Cover Mounting Bolts
11. Chuck Wrench

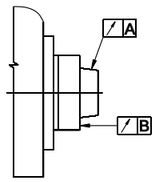
# Permissible Spindle Runout

**To obtain the specified clamping accuracy of a chuck mounted on a machine tool, it is necessary to:**

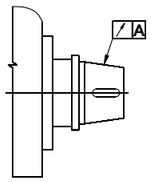
1. Reduce play in the spindle bearings to allowable minimum.
2. Ensure the machine spindle nose does not exceed the values specified.
3. Meet the basic requirements for correct mounting of the chuck on the spindle nose.
4. Follow the chuck manual.




Threaded




Short Taper




Long Taper

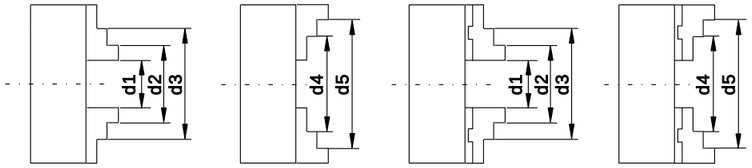
| Chuck Dia. | Spindle Runout |
|---|---|
| PS Series Semi-Steel Body | |
| 3" - 6" | .00012"max. |
| 8" - 32" | .0002"max. |



# Clamping Ranges

## PS Series 3 & 4-Jaw Universal Scroll Chucks

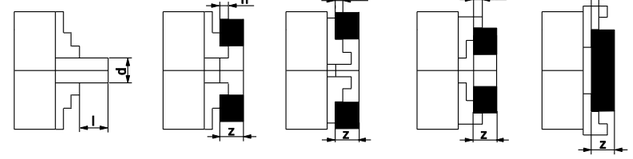
- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.



| Chuck Dia. D | d1 | | d2 | | d3 max. | | d4 max. | | d5 max. | |
|---|---|---|---|---|---|---|---|---|---|---|
| | JAWS | | | | | | | | | |
| mm | Inch | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible |
| 80 | 3-1/4 | .08-1.06 | - | .87-1.81 | - | 1.77-2.72 | - | .98-1.97 | - | 1.89-2.80 | - |
| 100 | 4 | .12-1.30 | - | .98-2.20 | - | 2.20-3.43 | - | 1.26-2.44 | - | 2.44-3.27 | - |
| 125 | 5 | .12-1.97 | .12-1.97 | 1.37-2.91 | 1.34-2.99 | 2.83-4.53 | 2.95-4.65 | 1.54-3.27 | 2.05-3.78 | 3.15-4.92 | 3.74-4.92 |
| 160 | 6-1/4 | .12-2.52 | .12-2.52 | 1.65-3.94 | 1.65-3.82 | 3.70-6.06 | 3.46-5.75 | 1.97-4.21 | 2.44-4.76 | 3.86-6.30 | 4.53-6.30 |
| 200 | 8 | .16-3.54 | .16-3.54 | 2.05-5.31 | 1.97-5.12 | 4.72-7.95 | 4.13-7.48 | 2.36-5.71 | 2.83-6.14 | 5.12-7.87 | 5.24-7.87 |
| 250 | 10 | .20-4.65 | .20-4.65 | 2.44-6.85 | 2.28-6.50 | 5.70-10.43 | 4.92-9.25 | 3.03-7.40 | 3.38-7.75 | 6.30-9.84 | 6.30-9.84 |
| 315 | 12-1/2 | .39-5.16 | .20-5.16 | 3.07-7.87 | 2.56-7.16 | 6.77-11.77 | 5.70-10.43 | 3.54-8.46 | 4.06-8.90 | 7.48-12.40 | 7.48-12.40 |
| 400 | 15-3/4 | .39-7.09 | .39-7.09 | 3.35-9.92 | 2.83-8.98 | 8.27-14.96 | 6.50-12.95 | 4.05-10.71 | 5.00-11.57 | 9.05-15.75 | 9.05-15.75 |
| 500 | 20 | .79-9.25 | .79-9.25 | 4.72-13.19 | 4.72-16.14 | 9.65-18.74 | 7.87-19.10 | 5.51-14.06 | 4.33-15.75 | 10.87-19.69 | 7.48-19.69 |
| 630 | 25 | 1.18-13.19 | 1.18-13.19 | 6.30-18.31 | 5.51-23.23 | 12.80-24.80 | 8.27-26.18 | 7.09-19.17 | 4.72-22.44 | 13.58-24.80 | 7.88-24.80 |
| 800 | 31-1/2 | 5.9-18.89 | 5.9-18.89 | 11.10-24.17 | 9.92-28.99 | 17.64-30.71 | 12.91-31.97 | 11.89-24.96 | 9.45-28.50 | 18.43-31.50 | 12.44-31.50 |
| 1000 | 40 | - | 9.84-23.62 | - | 14.02-42.52 | - | 16.93-45.28 | - | 16.73-42.13 | - | 19.69-45.28 |
| 1250 | 50 | - | 12.60-27.56 | - | 16.54-45.67 | - | 19.29-48.62 | - | 22.52-49.61 | - | 25.20-52.17 |

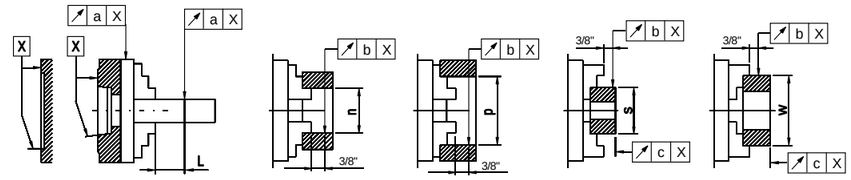
# Safe Operating Parameters

Conditions:
l&z=maximum length of workpiece
d=workpiece diameter
h=height of the clamping jaw step
workpiece is clamped into the chuck jaws with out additional support.




| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| l | 1.2 x d | | | | | | 1.5 x d | | | 1 x d | | | |
| z | 4 x h | | | | | | | | | | | | |

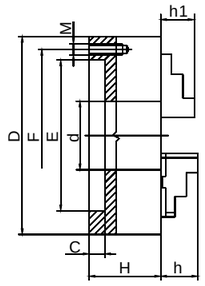
# Chuck Accuracy




| Chuck Size | | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| L | | 1.57 | 1.57 | 2.36 | 2.36 | 3.15 | 3.15 | 4.72 | 4.72 | 6.3 | 6.3 | 6.3 | 6.3 | 6.3 |
| Radial Runout | a | 0.0008 | 0.0008 | 0.0012 | 0.0012 | 0.0016 | 0.0016 | 0.002 | 0.0024 | 0.004 | 0.004 | 0.0059 | 0.0071 | 0.0071 |
| | b | 0.001 | 0.001 | 0.0014 | 0.0014 | 0.0018 | 0.0018 | 0.0022 | 0.0025 | 0.004 | 0.004 | 0.0059 | 0.0071 | 0.0071 |
| Axial Runout | c | 0.0006 | 0.0006 | 0.0008 | 0.0008 | 0.001 | 0.001 | 0.0012 | 0.0012 | 0.002 | 0.002 | 0.0024 | 0.0031 | 0.0031 |

# Plain Back Scroll Chucks

## 2 , 3 & 4-Jaw Universal Self-Centering Scroll Chucks
## Principal Dimensions




| Chuck Dia.D | F | E | d | C | H | 2-Pc Jaws h | Solid Jaws h1 | Adapter Mounting Bolts | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread M | L | No. Of Bolts |
| 3-1/4" | 2.6378 | 2.2047 | 0.6299 | .1181 | 1.732 | - | 0.512 | M6 x 1 | 0.98 | 3 |
| 4" | 3.2677 | 2.7599 | 0.7874 | .1181 | 1.969 | - | 0.669 | M8 x 1.25 | 0.98 | 3 |
| 5" | 4.2520 | 3.7402 | 1.2598 | .1575 | 2.205 | 1.575 | 0.787 | M8 x 1.25 | 0.98 | 3 |
| 6-1/4" | 5.5118 | 4.9213 | 1.6535 | .1575 | 2.539 | 1.693 | 1.260 | M10 x 1.5 | 0.98 | 6 |
| 8" | 6.9291 | 6.2992 | 2.1654 | .1575 | 2.953 | 1.831 | 1.142 | M10 x 1.5 | 0.98 | 6 |
| 10" | 8.8189 | 7.8740 | 2.9921 | .1969 | 3.347 | 2.146 | 1.339 | M12 x 1.75 | 1.18 | 6 |
| 12-1/2" | 11.2598 | 10.2362 | 4.0551 | .1969 | 3.701 | 2.362 | 1.693 | M16 x 2 | 1.18 | 6 |
| 15-3/4" | 14.2519 | 12.9921 | 5.3545 | .1969 | 4.134 | 2.854 | 2.165 | M16 x 2 | 1.57 | 6 |
| 20" | 18.0314 | 16.5354 | 7.4803 | .1969 | 4.724 | 3.602 | 2.205 | M16 x 2 | 1.57 | 6 |
| 25" | 23.0709 | 21.4567 | 9.9213 | .2756 | 5.315 | 3.622 | 2.756 | M16 x 2 | 1.97 | 6 |
| 31-1/2" | 14.5000 | 17.7170 | 12.5984 | .7874 | 6.260 | 3.622 | - | 1"-8 | 5.96 | 6 |
| 40" | 37.4016 | 35.8268 | 18.1102 | .3543 | 7.087 | 4.409 | - | 1"-8 | 7.87 | 6 |
| 50" | 43.3071 | 39.3701 | 21.6535 | .3543 | 7.087 | 4.409 | - | 1"-8 | 7.87 | 6 |

## 2-Jaw Scroll Chucks with Soft Top Reversible Jaws, Plain Back

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of soft top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Master Jaws | Soft Top Jaws | Scroll Plate | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS2-6"S | 1-205-0600 | MJ-PS2-160 | STJ-PS2-160 | SC-PS-160 | W-P-200 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS2-8"S | 1-205-0800 | MJ-PS2-200 | STJ-PS2-200 | SC-PS-200 | W-P-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS2-10"S | 1-205-1000 | MJ-PS2-250 | STJ-PS2-250 | SC-PS-250 | W-P-315 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS2-12"S | 1-205-1200 | MJ-PS2-315 | STJ-PS2-315 | SC-PS-315 | W-P-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS2-16"S | 1-205-1600 | MJ-PS2-400 | STJ-PS2-400 | SC-PS-400 | W-P-400 |

**W-SP-Extended Wrenches available from stock.
See Page 92



Plain Back Scroll Chucks

## 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS3-5"A | 1-201-0500 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS3-6"A | 1-201-0600 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | W-P-200 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS3-8"A | 1-201-0800 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | W-P-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS3-10"A | 1-201-1000 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | W-P-315 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS3-12"A | 1-201-1200 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS3-16"A | 1-201-1600 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | W-P-400 |
| 20" | 7.4803 | 8.3465 | 700 | 320 | PS3-20"A | 1-201-2000 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | W-P-630 |
| 25" | 9.9213 | 11.6140 | 500 | 551 | PS3-25"A | 1-201-2500 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | W-P-630 |
| 31-1/2" | 12.5984 | 12.5984 | 300 | 886 | PS3-32"A | 1-201-3200 | TJ-PS3-630 | MJ-PS3-800 | STJ-PS3-630 | W-P-800 |
| 40" | 18.1100 | 20.0787 | 300 | 1727 | PS3-40"A | 1-201-4000 | TJ-PS3-1000 | MJ-PS3-1000 | STJ-PS3-1000 | W-P-1000 |
| 50" | 21.6535 | 21.6535 | 200 | 3258 | PS3-50"A | 1-201-5000 | TJ-PS3-1250 | MJ-PS3-1250 | STJ-PS3-1250 | W-P-1250 |

**W-SP-Extended Wrenches available from stock.
See Page 92

## 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | ID-Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 3" | 0.6299 | 0.7087 | 4000 | 3.3 | PS3-3" | 1-202-0300 | OJ-PS3-80 | IJ-PS3-80 | SJ-PS3-80 | W-P-080 |
| 4" | 0.7874 | 0.9055 | 3500 | 6.2 | PS3-4" | 1-202-0400 | OJ-PS3-100 | IJ-PS3-100 | SJ-PS3-100 | W-P-100 |
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS3-5" | 1-202-0500 | OJ-PS3-125 | IJ-PS3-125 | SJ-PS3-125 | W-P-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS3-6" | 1-202-0600 | OJ-PS3-160 | IJ-PS3-160 | SJ-PS3-160 | W-P-200 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS3-8" | 1-202-0800 | OJ-PS3-200 | IJ-PS3-200 | SJ-PS3-200 | W-P-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS3-10" | 1-202-1000 | OJ-PS3-250 | IJ-PS3-250 | SJ-PS3-250 | W-P-315 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS3-12" | 1-202-1200 | OJ-PS3-315 | IJ-PS3-315 | SJ-PS3-315 | W-P-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS3-16" | 1-202-1600 | OJ-PS3-400 | IJ-PS3-400 | SJ-PS3-400 | W-P-400 |
| 20" | 7.4803 | 8.3465 | 700 | 320 | PS3-20" | 1-202-2000 | OJ-PS3-500 | IJ-PS3-500 | SJ-PS3-500 | W-P-630 |

**W-SP-Extended Wrenches available from stock.
See Page 92

# Plain Back Scroll Chucks

## 4-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS4-5"A | 1-203-0500 | TJ-PS4-125 | MJ-PS4-125 | STJ-PS4-125 | W-P-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS4-6"A | 1-203-0600 | TJ-PS4-160 | MJ-PS4-160 | STJ-PS4-160 | W-P-200 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS4-8"A | 1-203-0800 | TJ-PS4-200 | MJ-PS4-200 | STJ-PS4-200 | W-P-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS4-10"A | 1-203-1000 | TJ-PS4-250 | MJ-PS4-250 | STJ-PS4-250 | W-P-315 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS4-12"A | 1-203-1200 | TJ-PS4-315 | MJ-PS4-315 | STJ-PS4-315 | W-P-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS4-16"A | 1-203-1600 | TJ-PS4-400 | MJ-PS4-400 | STJ-PS4-400 | W-P-400 |
| 20" | 7.4803 | 8.3465 | 700 | 320 | PS4-20"A | 1-203-2000 | TJ-PS4-500 | MJ-PS4-500 | STJ-PS4-500 | W-P-630 |
| 25" | 9.9213 | 11.6140 | 500 | 551 | PS4-25"A | 1-203-2500 | TJ-PS4-630 | MJ-PS4-630 | STJ-PS4-630 | W-P-630 |
| 31-1/2" | 12.5984 | 12.5984 | 300 | 886 | PS4-32"A | 1-203-3200 | TJ-PS4-630 | MJ-PS4-800 | STJ-PS4-630 | W-P-800 |

**W-SP-Extended Wrenches available from stock.
See Page 92

## 4-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | ID-Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Wrech** |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 0.7874 | 0.9055 | 3500 | 6.2 | PS4-4" | 1-204-0400 | OJ-PS4-100 | IJ-PS4-100 | SJ-PS4-100 | W-P-100 |
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS4-5" | 1-204-0500 | OJ-PS4-125 | IJ-PS4-125 | SJ-PS4-125 | W-P-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS4-6" | 1-204-0600 | OJ-PS4-160 | IJ-PS4-160 | SJ-PS4-160 | W-P-200 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS4-8" | 1-204-0800 | OJ-PS4-200 | IJ-PS4-200 | SJ-PS4-200 | W-P-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS4-10" | 1-204-1000 | OJ-PS4-250 | IJ-PS4-250 | SJ-PS4-250 | W-P-315 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS4-12" | 1-204-1200 | OJ-PS4-315 | IJ-PS4-315 | SJ-PS4-315 | W-P-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS4-16" | 1-204-1600 | OJ-PS4-400 | IJ-PS4-400 | SJ-PS4-400 | W-P-400 |

**W-SP-Extended Wrenches available from stock.
See Page 92

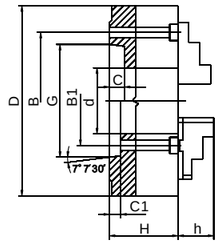


# Type A1/A2 Direct Mount Scroll Chucks

## 3-Jaw Type A1/A2 Direct Mount Scroll Chucks with Two-Piece Hard Reversible Jaws

Type A1 spindle has a 2 bolt hole pattern, inside (size B1) and outside the taper (size B). Either an A1 or A2 chuck will fit on it.
Type A2 spindle has 1 bolt pattern, outside the taper (size B), and only an A2 chuck will fit on it.

Type A1 / A2




**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of chuck mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Taper Size | Hole Dia.(d) | RPM max. | B (A2) | B1 (A1) | G | C/C1 | H | h | wt. lbs. | Chuck Mounting Bolts | | | Model | Chuck Part No . |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | | Thread | L | Qty. | | |
| 6-1/4" | A1-5 | 1.6535 | 3000 | - | 2.4374 | 3.2505 | .563 | 3.2087 | 1.693 | 22 | 7/16-14 | 2-3/4 | 3 | PS3-6"A/A1-5 | 1-211-0605 |
| 8" | A1-5 | 1.6535 | 2500 | - | 2.4374 | 3.2505 | .563 | 3.5827 | 1.831 | 42 | 7/16-14 | 3-1/8 | 3 | PS3-8"A/A1-5 | 1-211-0805 |
| | A1-6 | 2.1653 | | - | 3.2500 | 4.1880 | .625 | | | | 1/2-13 | | | PS3-8"A/A1-6 | 1-211-0806 |
| 10" | A2-5 | 2.9921 | 2000 | 4.1260 | - | 3.2505 | .563 | 4.0748 | 2.146 | 71 | 7/16-14 | 4-1/8 | 6 | PS3-10"A/A2-5 | 1-211-1005 |
| | A1-6 | 2.1635 | | - | 3.2500 | 4.1880 | .625 | | | | 1/2-13 | 3-1/2 | | PS3-10"A/A1-6 | 1-211-1006 |
| | A1-8 | 2.9921 | | - | 4.3750 | 5.5007 | .688 | | | | 5/8-11 | 3-1/2 | | PS3-10"A/A1-8 | 1-211-1008 |
| 12-1/2" | A2-6 | 4.0551 | 1500 | 5.2520 | - | 4.1880 | .630 | 4.6338 | 2.362 | 121 | 1/2-13 | 4-3/4 | 6 | PS3-12"A/A2-6 | 1-211-1206 |
| | A1-8 | 3.1496 | | - | 4.3750 | 5.5007 | .688 | | | | 5/8-11 | 4-3/16 | | PS3-12"A/A1-8 | 1-211-1208 |
| 15-3/4" | A2-6 | 4.0551 | 1000 | 5.2520 | - | 4.1880 | .630 | 5.0591 | 2.854 | 203 | 1/2-13 | 5 | 6 | PS3-16"A/A2-6 | 1-211-1606 |
| | A2-8 | 5.3543 | | 6.7480 | - | 5.5007 | .709 | | | | 5/8-11 | 5 | | PS3-16"A/A2-8 | 1-211-1608 |
| | A1-11 | 5.1181 | | - | 6.5000 | 7.7507 | .750 | | | | 3/4-10 | 4-1/4 | | PS3-16"A/A1-11 | 1-211-1611 |
| 20" | A2-11 | 7.4803 | 700 | 9.2520 | - | 7.7507 | .787 | 5.6693 | 3.602 | 353 | 3/4-10 | 5-7/8 | 6 | PS3-20"A/A2-11 | 1-211-2011 |
| 25" | A2-11 | 7.4803 | 500 | 9.2520 | - | 7.7507 | .787 | 6.4961 | 3.622 | 628 | 3/4-10 | 7-3/32 | 6 | PS3-25"A/A2-11 | 1-211-2511 |
| | A2-15 | 9.9213 | | 13.000 | - | 11.251 | .813 | | | | 7/8-9 | 6 | | PS3-25"A/A2-15 | 1-211-2515 |

*C-C1, depth of counterbore.
All chucks with A1 mount can be mounted on A1 spindles only.
All chucks with A2 mount can be mounted on either A1 and A2 spindles.

## Spare Parts

| Chuck Dia. | Taper Size | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Pinions | Scroll Plates | Pinion Screws | Wrenchs* | Chuck Mounting Bolts | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Thread | L | Qty. | Part No |
| 6-1/4" | A1-5 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | PI-PS-160 | SC-PS-160 | PH-P-160 | W-P-160 | 7/16-14 | 2-3/4 | 3 | BA-06-05 |
| 8" | A1-5 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | PI-PS-200 | SC-PS-200 | PH-P-200 | W-P-200 | 7/16-14 | 3-1/8 | | BA-08-05 |
| | A1-6 | | | | | | | | 1/2-13 | | | BA-08-06 |
| 10" | A2-5 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | PI-PS-250 | SC-PS-250 | PH-P-250 | W-P-250 | 7/16-14 | 4-1/8 | 6 | BA-10-05 |
| | A1-6 | | | | | | | | 1/2-13 | 3-1/2 | | BA-10-06 |
| | A1-8 | | | | | | | | 5/8-11 | 3-1/2 | | BA-10-08 |
| 12-1/2" | A2-6 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | PI-PS-315 | SC-PS-315 | PH-P-315 | W-P-315 | 1/2-13 | 4-3/4 | | BA-12-06 |
| | A1-8 | | | | | | | | 5/8-11 | 4-3/16 | | BA-12-08 |
| 15-3/4" | A2-6 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | PI-PS-400 | SC-PS-400 | PH-P-400 | W-P-400 | 1/2-13 | 5 | | BA-16-06 |
| | A2-8 | | | | | | | | 5/8-11 | 5 | | BA-16-08 |
| | A1-11 | | | | | | | | 3/4-10 | 4-1/4 | | BA-16-11 |
| 20" | A2-11 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | PI-PS-500 | SC-PS-500 | PH-P-500 | W-P-500 | 3/4-10 | 5-7/8 | | BA-20-11 |
| 25" | A2-11 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | PI-PS-630 | SC-PS-630 | PH-P-630 | W-P-630 | 3/4-10 | 7-3/32 | | BA-25-11 |
| | A2-15 | | | | | | | | 7/8-9 | 6 | | BA-25-15 |

**W-SP-Extended Wrenches available from stock, See Page 92.

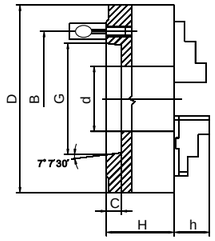
# Type D1 Direct Mount Scroll Chucks

## 3-Jaw Type D1 Direct Mount Scroll Chucks with Two-Piece Hard Reversible Jaws

Type D1

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of Camlock studs and set screws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual




| Chuck Dia. | Taper Size | Hole Dia.(d) | Max.Hole Enlargement | RPM max. | B | G | C | H | h | wt. lbs. | Model | Chuck Part No . | Camlock Studs Dia. | Camlock Studs Thread | Qty. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | D1-4 | 1.2598 | 1.2598 | 3200 | 3.2520 | 2.5005 | .5118 | 2.7559 | 1.575 | 11 | PS3-5"A/D1-4 | 1-221-0504 | 5/8 | M10x1 | 3 |
| 6-1/4" | D1-3 | 1.6535 | 1.9685 | 3000 | 2.7795 | 2.1250 | .5118 | 3.2087 | 1.693 | 20 | PS3-6"A/D1-3 | 1-221-0603 | 9/16 | M10x1 | |
| | D1-4 | | | | 3.2520 | 2.5005 | | | | | PS3-6"A/D1-4 | 1-221-0604 | 5/8 | | |
| 8" | D1-3 | 2.0275 | 2.0275 | 2500 | 2.7795 | 2.1250 | .5118 | 3.5827 | 1.831 | 42 | PS3-8"A/D1-3 | 1-221-0803 | 9/16 | M10x1 | |
| | D1-4 | 2.1653 | 2.3622 | | 3.2520 | 2.5005 | | | | | PS3-8"A/D1-4 | 1-221-0804 | 5/8 | | |
| | D1-5 | | 2.6378 | | 4.1260 | 3.2505 | .5629 | | | | PS3-8"A/D1-5 | 1-221-0805 | 3/4 | M12x1 | 6 |
| | D1-6 | | 2.6378 | | 5.2520 | 4.1880 | | | | | PS3-8"A/D1-6 | 1-221-0806 | 7/8 | M16x1.5 | |
| 10" | D1-5 | 2.9921 | 2.9922 | 2000 | 4.1260 | 3.2505 | .5629 | 4.0748 | 2.146 | 71 | PS3-10"A/D1-5 | 1-221-1005 | 3/4 | M12x1 | |
| | D1-6 | | 3.7402 | | 5.2520 | 4.1880 | .6299 | | | | PS3-10"A/D1-6 | 1-221-1006 | 7/8 | M16x1.5 | |
| | D1-8 | | 3.7402 | | 6.7480 | 5.5007 | .7087 | | | | PS3-10"A/D1-8 | 1-221-1008 | 1 | M20x1.5 | |
| 12-1/2" | D1-6 | 4.0551 | 4.0551 | 1500 | 5.2520 | 4.1880 | .6299 | 4.6338 | 2.362 | 112 | PS3-12"A/D1-6 | 1-221-1206 | 7/8 | M16x1.5 | |
| | D1-8 | | 4.5276 | | 6.7480 | 5.5007 | .7087 | | | | PS3-12"A/D1-8 | 1-221-1208 | 1 | M20x1.5 | |
| | D1-11 | | 4.500 | | 9.2520 | 7.7507 | .7874 | 5.5118 | | | PS3-12"A/D1-11 | 1-221-1211 | 1-3/16 | M22x1.5 | |
| 15-3/4" | D1-6 | 4.0551 | 4.0551 | 1000 | 5.2520 | 4.1880 | .6299 | 5.0591 | 2.854 | 223 | PS3-16"A/D1-6 | 1-221-1606 | 7/8 | M16x1.5 | |
| | D1-8 | 5.3543 | 5.3543 | | 6.7480 | 5.5007 | .7087 | | | | PS3-16"A/D1-8 | 1-221-1608 | 1 | M20x1.5 | |
| | D1-11 | 5.3543 | 5.9055 | | 9.2520 | 7.7507 | .7874 | | | | PS3-16"A/D1-11 | 1-221-1611 | 1-3/16 | M22x1.5 | |
| 20" | D1-8 | 5.3543 | 5.3543 | 700 | 6.7480 | 5.5007 | .7087 | 5.7480 | 3.602 | 331 | PS3-20"A/D1-8 | 1-221-2008 | 1 | M20x1.5 | |
| | D1-11 | 7.5905 | 7.5984 | | 9.2520 | 7.7507 | .7874 | | | | PS3-20"A/D1-11 | 1-221-2011 | 1-3/16 | M22x1.5 | |
| 25" | D1-11 | 7.5905 | 7.5984 | 500 | 9.2520 | 7.7507 | .7874 | 6.4961 | 3.622 | 604 | PS3-25"A/D1-11 | 1-221-2511 | 1-3/16 | M22x1.5 | |

## Spare Parts

| Chuck Dia. | Taper Size | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Pinions | Scroll Plates | Pinion Screws | Wrenchs* | Camlock Studs Dia. | Camlock Studs Thread | Qty. | Camlock Stud |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | D1-4 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | PI-PS-125 | SC-PS-125 | PH-P-125 | W-P-125 | 5/8 | M10x1 | 3 | CA-D-04 |
| 6-1/4" | D1-3 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | PI-PS-160 | SC-PS-160 | PH-P-160 | W-P-160 | 9/16 | M10x1 | | CA-D-03 |
| | D1-4 | | | | | | | | 5/8 | | | CA-D-04 |
| 8" | D1-3 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | PI-PS-200 | SC-PS-200 | PH-P-200 | W-P-200 | 9/16 | M10x1 | | CA-D-03 |
| | D1-4 | | | | | | | | 5/8 | | | CA-D-04 |
| | D1-5 | | | | | | | | 3/4 | M12x1 | 6 | CA-D-05 |
| | D1-6 | | | | | | | | 7/8 | M16x1.5 | | CA-D-06 |
| 10" | D1-5 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | PI-PS-250 | SC-PS-250 | PH-P-250 | W-P-250 | 3/4 | M12x1 | | CA-D-05 |
| | D1-6 | | | | | | | | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| 12-1/2" | D1-6 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | PI-PS-315 | SC-PS-315 | PH-P-315 | W-P-315 | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 15-3/4" | D1-6 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | PI-PS-400 | SC-PS-400 | PH-P-400 | W-P-400 | 7/8 | M16x1.5 | | CA-D-06 |
| | D1-8 | | | | | | | | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 20" | D1-8 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | PI-PS-500 | SC-PS-500 | PH-P-500 | W-P-500 | 1 | M20x1.5 | | CA-D-08 |
| | D1-11 | | | | | | | | 1-3/16 | M22x1.5 | | CA-D-011 |
| 25" | D1-11 | TJ-PS3-630 | MJ-PS3-630 | STJ-PS3-630 | PI-PS-630 | SC-PS-630 | PH-P-630 | W-P-630 | 1-3/16 | M22x1.5 | | CA-D-011 |

**W-SP-Extended Wrenches available from stock, See Page 92.



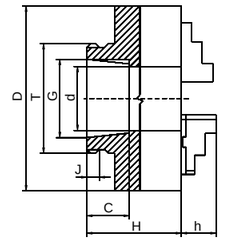
# Type L Direct Mount Scroll Chucks

## 3-Jaw Type L Direct Mount Scroll Chucks with Two-Piece Hard Reversible Jaws

Type L

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual




| Chuck Dia.(D) | Taper Size | Hole Dia.(d) | RPM max* | Thread T | G | J | C | H | h | wt. lbs. | Model | Chuck Part No . |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | L00 | 1.6535 | 3000 | 3-3/4" - 6 | 2-3/4 | .5512 | 2.1260 | 4.0551 | 1.693 | 23 | PS3-6"A/L00 | 1-241-0601 |
| | L0 | | | 4-1/2" - 6 | 3-1/4 | .5906 | 2.5197 | 4.4488 | | | PS3-6"A/L0 | 1-241-0602 |
| 8" | L00 | 2.1654 | 2500 | 3-3/4" - 6 | 2-3/4 | .5512 | 2.1260 | 4.3701 | 1.831 | 42 | PS3-8"A/L00 | 1-241-0801 |
| | L0 | | | 4-1/2" - 6 | 3-1/4 | .5906 | 2.5197 | 4.7638 | | | PS3-8"A/L0 | 1-241-0802 |
| | L1 | | | 6" - 6 | 4-1/8 | .6299 | 2.9921 | 5.2362 | | | PS3-8"A/L1 | 1-241-0803 |
| 10" | L0 | 2.9921 | 2000 | 4-1/2" - 6 | 3-1/4 | .5906 | 2.5197 | 5.0394 | 2.146 | 64 | PS3-10"A/L0 | 1-241-1002 |
| | L1 | | | 6" - 6 | 4-1/8 | .6299 | 2.9921 | 5.5118 | | | PS3-10"A/L1 | 1-241-1003 |
| | L2 | | | 7-3/4" - 5 | 5-1/4 | .8661 | 3.5039 | 6.0236 | | | PS3-10"A/L2 | 1-241-1004 |
| 12-1/2" | L0 | 4.0551 | 1500 | 4-1/2" - 6 | 3-1/4 | .5906 | 2.5197 | 5.3937 | 2.362 | 134 | PS3-12"A/L0 | 1-241-1202 |
| | L1 | | | 6" - 6 | 4-1/8 | .6299 | 2.9921 | 5.8661 | | | PS3-12"A/L1 | 1-241-1203 |
| | L2 | | | 7-3/4" - 5 | 5-1/4 | .8661 | 3.5039 | 6.3780 | | | PS3-12"A/L2 | 1-241-1204 |
| 15-3/4" | L1 | 4.0551 | 1000 | 6" - 6 | 4-1/8 | .6299 | 2.9921 | 6.1811 | 2.854 | 251 | PS3-16"A/L1 | 1-241-1603 |
| | L2 | | | 7-3/4" - 5 | 5-1/4 | .8661 | 3.5039 | 6.6929 | | | PS3-16"A/L2 | 1-241-1604 |

## Spare Parts

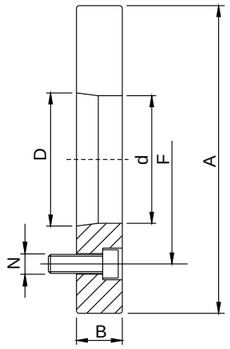
| Chuck Dia. | Taper Size | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Pinions | Scroll Plates | Pinion Screws | Wrenchs* |
|---|---|---|---|---|---|---|---|---|
| 6-1/4" | L00 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | PI-PS-160 | SC-PS-160 | PH-P-160 | W-P-160 |
| | L0 | | | | | | | |
| 8" | L00 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | PI-PS-200 | SC-PS-200 | PH-P-200 | W-P-200 |
| | L0 | | | | | | | |
| | L1 | | | | | | | |
| 10" | L0 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | PI-PS-250 | SC-PS-250 | PH-P-250 | W-P-250 |
| | L1 | | | | | | | |
| | L2 | | | | | | | |
| 12-1/2" | L0 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | PI-PS-315 | SC-PS-315 | PH-P-315 | W-P-315 |
| | L1 | | | | | | | |
| | L2 | | | | | | | |
| 15-3/4" | L1 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | PI-PS-400 | SC-PS-400 | PH-P-400 | W-P-400 |
| | L2 | | | | | | | |

**W-SP-Extended Wrenches available from stock, See Page 92.

# SM Series Semi-machined Adapter Plate

## Type A1/A2 Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on A1 & A2 spindle noses,
Can be used after machining for scroll or independent chucks, see page 85
Spindle side of adapter is fully finished.
Provided with the set of spindle mounting bolts & hex key.
All below listed adapters can be mounted eather on A1 or A2 spindle noses.
All adapters are made of steel for longer life.




| Chuck Dia. | Taper Size | A | B | Hole d | F | D | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | N | QTY | | |
| 6-1/4" | A5 | 6.38 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 14.4 | SM-160/A5 |
| 8" | A4 | 7.99 | 0.98 | 2.40 | 3.252 | 2.5005 | 7/16-14 | 4 | 14.5 | SM-200/A4 |
| | A5 | 7.99 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 23.6 | SM-200/A5 |
| | A6 | 7.99 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 23.7 | SM-200/A6 |
| 10" | A5 | 9.96 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 37.7 | SM-250/A5 |
| | A6 | 9.96 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 38.9 | SM-250/A6 |
| | A8 | 9.96 | 1.97 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 41.6 | SM-250/A8 |
| 12-1/2" | A6 | 12.52 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 63.6 | SM-315/A6 |
| | A8 | 12.52 | 2.16 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 64.4 | SM-315/A8 |
| | A11 | 12.52 | 2.56 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 83.2 | SM-315/A11 |
| 15-3/4" | A6 | 15.94 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 6 | 105.7 | SM-400/A6 |
| | A8 | 15.94 | 1.93 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 116.5 | SM-400/A8 |
| | A11 | 15.94 | 2.95 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 137 | SM-400/A11 |
| 20" | A8 | 19.88 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 193 | SM-500/A8 |
| | A11 | 19.88 | 2.68 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 206 | SM-500/A11 |
| | A15 | 19.88 | 2.68 | 5.35 | 13.000 | 11.2509 | 7/8-9 | 6 | 228 | SM-500/A15 |
| 25" | A8 | 25.00 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 311 | SM-630/A8 |
| | A11 | 25.00 | 2.60 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 391 | SM-630/A11 |
| | A15 | 25.00 | 2.52 | 7.48 | 13.000 | 11.2509 | 7/8-9 | 6 | 350 | SM-630/A15 |

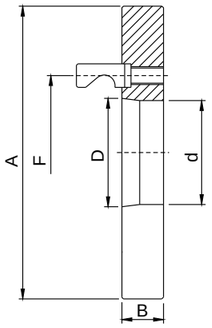


gator chucks BY FUJIDENZA
PS Series - Semi-Steel Body Universal Scroll Chucks

# SM Series Semi-machined Adapter Plate

## Type D1 Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on CAMLOCK D1 spindle noses,
After machining can be used with scroll or independent chucks, see page 85
Spindle side of adapter is fully finished,
Provided with the set of Camlock studs, set screws & hex key.
All adapters are made of steel for longer life.

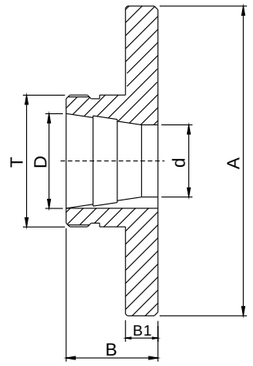



| Chuck Dia. | Taper Size | A | B | Hole d | F | D | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | OD | QTY | | |
| 5" | D1-3 | 5.00 | 1.024 | 1.5 | 2.78 | 2.1250 | 9/16" | 3 | 5.7 | SM-125/D3 |
| | D1-4 | 5.00 | 1.024 | 1.5 | 3.252 | 2.5005 | 5/8" | 3 | 5.5 | SM-125/D4 |
| 6-1/4" | D1-3 | 6.38 | 1.26 | 2.03 | 2.78 | 2.1250 | 9/16" | 3 | 11.7 | SM-160/D3 |
| | D1-4 | 6.38 | 1.26 | 2.03 | 3.252 | 2.5005 | 5/8" | 3 | 11.5 | SM-160/D4 |
| | D1-5 | 6.38 | 1.38 | 2.03 | 4.126 | 3.2505 | 3/4" | 6 | 12.1 | SM-160/D5 |
| 8" | D1-4 | 7.99 | 1.732 | 2.40 | 3.252 | 2.5005 | 5/8" | 3 | 25.6 | SM-200/D4 |
| | D1-5 | 7.99 | 1.97 | 2.40 | 4.126 | 3.2505 | 3/4" | 6 | 22.3 | SM-200/D5 |
| | D1-6 | 7.99 | 1.77 | 2.40 | 5.252 | 4.1880 | 7/8" | 6 | 24.3 | SM-200/D6 |
| 10" | D1-5 | 9.96 | 1.93 | 3.13 | 4.126 | 3.2505 | 3/4" | 6 | 32.6 | SM-250/D5 |
| | D1-6 | 9.96 | 1.93 | 3.13 | 5.252 | 4.1880 | 7/8" | 6 | 34.5 | SM-250/D6 |
| | D1-8 | 9.96 | 1.93 | 3.13 | 6.748 | 5.5005 | 1" | 6 | 40.4 | SM-250/D8 |
| 12-1/2" | D1-6 | 12.52 | 2.76 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 66 | SM-315/D6 |
| | D1-8 | 12.52 | 2.16 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 59.3 | SM-315/D8 |
| | D1-11 | 12.52 | 2.16 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 68.8 | SM-315/D11 |
| 15-3/4" | D1-6 | 15.94 | 1.65 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 100 | SM-400/D6 |
| | D1-8 | 15.94 | 2.76 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 116 | SM-400/D8 |
| | D1-11 | 15.94 | 1.97 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 102 | SM-400/D11 |
| 20" | D1-8 | 19.88 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 165 | SM-500/D8 |
| | D1-11 | 19.88 | 2.83 | 5.36 | 9.252 | 7.7507 | 1-3/16" | 6 | 188 | SM-500/D11 |
| | D1-15 | 19.88 | 2.36 | 5.36 | 13.00 | 11.2509 | 1-3/8" | 6 | 173 | SM-500/D15 |
| 25" | D1-8 | 25.00 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 269 | SM-630/D8 |
| | D1-11 | 25.00 | 2.83 | 7.79 | 9.252 | 7.7507 | 1-3/16" | 6 | 278 | SM-630/D11 |
| | D1-15 | 25.00 | 2.36 | 7.48 | 13.00 | 11.2509 | 1-3/8" | 6 | 270 | SM-630/D15 |

# SM Series Semi-machined Adapter Plate

## Type L Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on long taper L spindle noses,
Can be used after machining for scroll or independent chucks, see page 85
Spindle side of adapter is fully finished,
All adapters are made of steel for longer life.



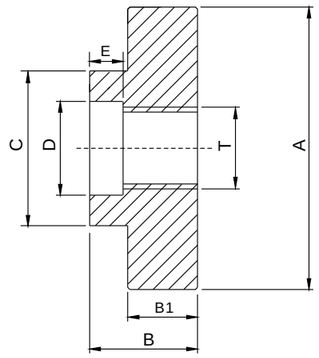

| Chuck Dia. | A | Taper Size | Thread T - UNS3 | D | Thru Hole d | B1 | B | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 6.38 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.063 | 2.342 | 12.7 | SM-160/L00 |
| 6-1/4" | 6.38 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.063 | 2.736 | 15 | SM-160/L0 |
| 8" | 7.99 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.083 | 2.362 | 19.2 | SM-200/L00 |
| 8" | 7.99 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.083 | 2.756 | 21.5 | SM-200/L0 |
| 8" | 7.99 | L1 | 6 - 6 | 4.125 | 3.35 | 1.083 | 2.992 | 26.5 | SM-200/L1 |
| 10" | 9.96 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.338 | 2.618 | 35.2 | SM-250/L00 |
| 10" | 9.96 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.338 | 2.52 | 35.5 | SM-250/L0 |
| 10" | 9.96 | L1 | 6 - 6 | 4.125 | 3.35 | 1.338 | 3.307 | 42.4 | SM-250/L1 |
| 12-1/2" | 12.52 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.40 | 2.64 | 57.8 | SM-315/L0 |
| 12-1/2" | 12.52 | L1 | 6 - 6 | 4.125 | 3.35 | 1.40 | 3.11 | 62.7 | SM-315/L1 |
| 12-1/2" | 12.52 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.45 | 3.50 | 72.8 | SM-315/L2 |
| 15-3/4" | 15.94 | L1 | 6 - 6 | 4.125 | 3.35 | 1.50 | 3.23 | 103 | SM-400/L1 |
| 15-3/4" | 15.94 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 113 | SM-400/L2 |
| 15-3/4" | 15.94 | L3 | 10-3/8 - 4 | 6.500 | 5.43 | 1.50 | 4.18 | 139 | SM-400/L3 |
| 20" | 19.88 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 167 | SM-500/L2 |



SM Series Semi-machined Adapter Plate

## Type Threaded Semi-machined Adapters for PO Series & PS Series chucks

Designed for direct mounting on a threaded spindle noses,
Can be used after machining with scroll or independent chucks, see page 85
Spindle side of adapter is fully finished,
All adapters are made of steel for longer life.

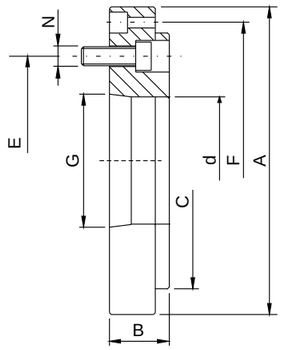



| Chuck Dia. | Thread T | A | D | E | C | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 4" | 1-10 UNS-2B | 4.09 | 1.0150 | 0.50 | 2.165 | 1.535 | 0.709 | 4.85 | SM-100/T1 |
| | 1-1/2 - 8 UN-2B | 4.09 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 5.29 | SM-100/T2 |
| 5" | 1-1/8 - 12 W | 5.08 | 1.2496 | 0.50 | 2.165 | 1.535 | 0.709 | 4.05 | SM-125/T3 |
| | 1-1/2 - 8 UN-2B | 5.08 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 6.61 | SM-125/T2 |
| | 2-3/16 - 10 Hardinge | 5.08 | 2.1889 | 0.626 | 3.11 | 1.772 | 0.709 | 7.05 | SM-125/T4 |
| | 2-1/4 - 8 UN-2B | 5.08 | 2.2600 | 0.626 | 3.18 | 1.83 | 0.709 | 6.80 | SM-125/T5 |
| 6-1/4" | 1-1/2 - 8 UN-2B | 6.535 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.787 | 7.05 | SM-160/T2 |
| | 2-3/16 - 10 Hardinge | 6.535 | 2.1889 | 0.50 | 3.11 | 1.85 | 0.787 | 7.50 | SM-160/T4 |
| | 2-1/4 - 8 UN-2B | 6.535 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.787 | 7.94 | SM-160/T5 |
| 8" | 1-1/2 - 8 UN-2B | 8.11 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.866 | 9.92 | SM-200/T2 |
| | 2-1/4 - 8 UN-2B | 8.11 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.866 | 11.46 | SM-200/T5 |
| | 2-3/8 - 6 UN-2B | 8.11 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.866 | 13.89 | SM-200/T6 |
| 10" | 2-3/8 - 6 UN-2B | 10.08 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.984 | 30 | SM-250/T6 |
| 12-1/2" | 2-3/8 - 6 UN-2B | 12.64 | 2.3850 | 0.626 | 4.33 | 2.047 | 1.102 | 50 | SM-315/T6 |

# FM Series Pre-machined Adapter Plate

## Type A1/A2 Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 85
All adapters come with the set of spindle mounting bolts & hex key
All below listed adapters can be mounted either on A1 or A2 spindle noses.
All adapters are made of steel for longer life.



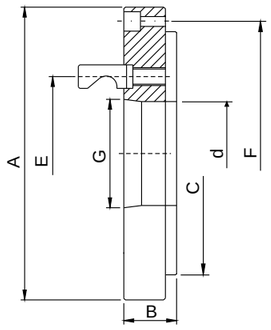

| Chuck Dia. | Taper Size | A | B | C | Hole d | E | F | G | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | N | QTY | | |
| 6-1/4" | A5 | 6.30 | .83 | 5 | 3.13 | 4.126 | 5.5118 | 3.2505 | 7/16-14 | 6 | 6.5 | FM-160/A5 |
| 8" | A4 | 7.87 | .83 | 6.378 | 2.40 | 3.252 | 6.9291 | 2.5005 | 7/16-14 | 6 | 11.8 | FM-200/A4 |
| | A5 | 7.87 | .83 | 6.378 | 3.13 | 4.126 | 6.9291 | 3.2505 | 7/16-14 | 6 | 11 | FM-200/A5 |
| | A6 | 7.87 | .83 | 6.378 | 4.06 | 5.252 | 6.9291 | 4.1880 | 1/2-13 | 6 | 9.6 | FM-200/A6 |
| 10" | A5 | 9.84 | 1.02 | 7.9527 | 3.13 | 4.126 | 8.8189 | 3.2505 | 7/16-14 | 6 | 22.7 | FM-250/A5 |
| | A6 | 9.84 | 1.02 | 7.9527 | 4.06 | 5.252 | 8.8189 | 4.1880 | 1/2-13 | 6 | 21 | FM-250/A6 |
| | A8 | 9.84 | 1.02 | 7.9527 | 5.36 | 6.748 | 8.8189 | 5.5005 | 5/8-11 | 6 | 17.8 | FM-250/A8 |
| 12-1/2" | A6 | 12.40 | 1.30 | 10.315 | 4.06 | 5.252 | 11.2598 | 4.1880 | 1/2-13 | 6 | 45.5 | FM-315/A6 |
| | A8 | 12.40 | 1.30 | 10.315 | 5.36 | 6.748 | 11.2598 | 5.5005 | 5/8-11 | 6 | 41 | FM-315/A8 |
| | A11 | 12.40 | 1.38 | 10.315 | 7.59 | 9.252 | 11.2598 | 7.7507 | 3/4-10 | 6 | 34 | FM-315/A11 |
| 15-3/4" | A6 | 15.75 | 1.30 | 13.11 | 4.06 | 5.252 | 14.2519 | 4.1880 | 1/2-13 | 6 | 76.7 | FM-400/A6 |
| | A8 | 15.75 | 1.30 | 13.11 | 5.36 | 6.748 | 14.2519 | 5.5005 | 5/8-11 | 6 | 72.6 | FM-400/A8 |
| | A11 | 15.75 | 1.30 | 13.11 | 7.59 | 9.252 | 14.2519 | 7.7507 | 3/4-10 | 6 | 63.2 | FM-400/A11 |
| 20" | A8 | 19.96 | 1.34 | 16.6535 | 5.36 | 6.748 | 18.0314 | 5.5005 | 5/8-11 | 6 | 122 | FM-500/A8 |
| | A11 | 19.96 | 1.34 | 16.6535 | 7.59 | 9.252 | 18.0314 | 7.7507 | 3/4-10 | 6 | 112 | FM-500/A11 |
| | A15 | 19.96 | 1.54 | 16.6535 | 11.08 | 13.000 | 18.0314 | 11.2509 | 7/8-9 | 6 | 103 | FM-500/A15 |
| 25" | A8 | 24.80 | 1.65 | 21.575 | 5.36 | 6.748 | 23.0709 | 5.5005 | 5/8-11 | 6 | 247 | FM-630/A8 |
| | A11 | 24.80 | 1.65 | 21.575 | 7.59 | 9.252 | 23.0709 | 7.7507 | 3/4-10 | 6 | 235 | FM-630/A11 |
| | A15 | 24.80 | 1.65 | 21.575 | 11.08 | 13.000 | 23.0709 | 11.2509 | 7/8-9 | 6 | 207 | FM-630/A15 |



FM Series Pre-machined Adapter Plate

## Type D1 Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 85
All adapters come with the Camlock Studs, set screws & hex key.
All adapters are made of steel for longer life.

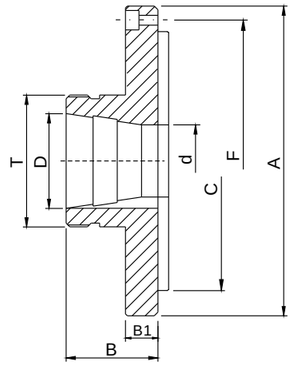



| Chuck Dia. | Taper Size | A | B | C | Hole d | E | F | G | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | OD | QTY | | |
| 5" | D1-3 | 4.92 | 1.024 | 3.82 | 2.03 | 2.78 | 4.2520 | 2.1250 | 9/16" | 3 | 5.2 | FM-125/D3 |
| | D1-4 | 4.92 | 1.024 | 3.82 | 2.40 | 3.252 | 4.2520 | 2.5005 | 5/8" | 3 | 4.8 | FM-125/D4 |
| 6-1/4" | D1-3 | 6.30 | 1.06 | 5 | 2.03 | 2.78 | 5.5118 | 2.1250 | 9/16" | 3 | 9.6 | FM-160/D3 |
| | D1-4 | 6.30 | 1.06 | 5 | 2.40 | 3.252 | 5.5118 | 2.5005 | 5/8" | 3 | 9.1 | FM-160/D4 |
| | D1-5 | 6.30 | 1.18 | 5 | 3.13 | 4.126 | 5.5118 | 3.2505 | 3/4" | 6 | 9.0 | FM-160/D5 |
| 8" | D1-4 | 7.87 | 1.06 | 6.378 | 2.40 | 3.252 | 6.9291 | 2.5005 | 5/8" | 3 | 15.2 | FM-200/D4 |
| | D1-5 | 7.87 | 1.18 | 6.378 | 3.13 | 4.126 | 6.9291 | 3.2505 | 3/4" | 6 | 15.5 | FM-200/D5 |
| | D1-6 | 7.87 | 1.44 | 6.378 | 4.06 | 5.252 | 6.9291 | 4.1880 | 7/8" | 6 | 16.7 | FM-200/D6 |
| 10" | D1-5 | 9.84 | 1.18 | 7.9527 | 3.13 | 4.126 | 8.8189 | 3.2505 | 3/4" | 6 | 26.2 | FM-250/D5 |
| | D1-6 | 9.84 | 1.44 | 7.9527 | 4.06 | 5.252 | 8.8189 | 4.1880 | 7/8" | 6 | 29.4 | FM-250/D6 |
| | D1-8 | 9.84 | 1.54 | 7.9527 | 5.36 | 6.748 | 8.8189 | 5.5005 | 1" | 6 | 26.7 | FM-250/D8 |
| 12-1/2" | D1-6 | 12.40 | 1.56 | 10.315 | 4.06 | 5.252 | 11.2598 | 4.1880 | 7/8" | 6 | 54.4 | FM-315/D6 |
| | D1-8 | 12.40 | 1.65 | 10.315 | 5.36 | 6.748 | 11.2598 | 5.5005 | 1" | 6 | 52.7 | FM-315/D8 |
| | D1-11 | 12.40 | 2.05 | 10.315 | 7.59 | 9.252 | 11.2598 | 7.7507 | 1-3/16" | 6 | 50.1 | FM-315/D11 |
| 15-3/4" | D1-6 | 15.75 | 1.56 | 13.11 | 4.06 | 5.252 | 14.2519 | 4.1880 | 7/8" | 6 | 91.1 | FM-400/D6 |
| | D1-8 | 15.75 | 1.54 | 13.11 | 5.36 | 6.748 | 14.2519 | 5.5005 | 1" | 6 | 85.8 | FM-400/D8 |
| | D1-11 | 15.75 | 1.85 | 13.11 | 7.59 | 9.252 | 14.2519 | 7.7507 | 1-3/16" | 6 | 89.8 | FM-400/D11 |
| 20" | D1-8 | 19.69 | 1.54 | 16.6535 | 5.36 | 6.748 | 18.0314 | 5.5007 | 1" | 6 | 140.4 | FM-500/D8 |
| | D1-11 | 19.69 | 1.85 | 16.6535 | 7.59 | 9.252 | 18.0314 | 7.7507 | 1-3/16" | 6 | 155.5 | FM-500/D11 |
| | D1-15 | 19.69 | 1.97 | 16.6535 | 11.08 | 13.00 | 18.0314 | 11.2509 | 1-3/8" | 6 | 132.8 | FM-500/D15 |
| 25" | D1-8 | 24.80 | 1.54 | 21.575 | 5.36 | 6.748 | 23.0709 | 5.5007 | 1" | 6 | 229.5 | FM-630/D8 |
| | D1-11 | 24.80 | 1.85 | 21.575 | 7.59 | 9.252 | 23.0709 | 7.7507 | 1-3/16" | 6 | 263 | FM-630/D11 |
| | D1-15 | 24.80 | 1.97 | 21.575 | 11.08 | 13.00 | 23.0709 | 11.2509 | 1-3/8" | 6 | 247 | FM-630/D15 |

# FM Series Pre-machined Adapter Plate

## Type L Pre-machined Adapters for PO Series & PS Series chucks

Note:
Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore, see page 85
All adapters are made of steel for long life.



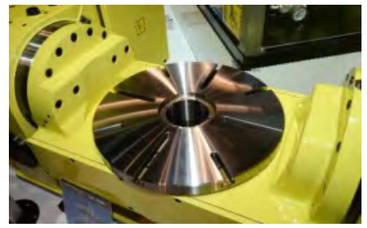

| Chuck Dia. | A | Taper Size | Thread T - UNS3 | B | B1 | C | Thru Hole d | D | F | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 6.30 | L00 | 3-3/4 - 6 | 2.126 | 0.7283 | 5 | 2.20 | 2.750 | 5.5118 | 9.76 | FM-160/L00 |
| 6-1/4" | 6.30 | L0 | 4-1/2 - 6 | 2.52 | 0.7283 | 5 | 2.60 | 3.250 | 5.5118 | 12.3 | FM-160/L0 |
| 8" | 7.87 | L00 | 3-3/4 - 6 | 2.126 | 0.7086 | 6.378 | 2.20 | 2.750 | 6.9291 | 13.6 | FM-200/L00 |
| 8" | 7.87 | L0 | 4-1/2 - 6 | 2.52 | 0.7086 | 6.378 | 2.60 | 3.250 | 6.9291 | 16.2 | FM-200/L0 |
| 8" | 7.87 | L1 | 6 - 6 | 2.99 | 0.7086 | 6.378 | 3.35 | 4.125 | 6.9291 | 23.5 | FM-200/L1 |
| 10" | 9.87 | L00 | 3-3/4 - 6 | 2.126 | 0.827 | 7.9527 | 2.20 | 2.750 | 8.8189 | 22.5 | FM-250/L00 |
| 10" | 9.87 | L0 | 4-1/2 - 6 | 2.52 | 0.827 | 7.9527 | 2.60 | 3.250 | 8.8189 | 24.9 | FM-250/L0 |
| 10" | 9.87 | L1 | 6 - 6 | 2.99 | 0.827 | 7.9527 | 3.35 | 4.125 | 8.8189 | 31.8 | FM-250/L1 |
| 12-1/2" | 12.40 | L0 | 4-1/2 - 6 | 2.52 | 1.102 | 10.315 | 2.60 | 3.250 | 11.2598 | 46.1 | FM-315/L0 |
| 12-1/2" | 12.40 | L1 | 6 - 6 | 2.99 | 1.102 | 10.315 | 3.35 | 4.125 | 11.2598 | 51.9 | FM-315/L1 |
| 12-1/2" | 12.40 | L2 | 7-3/4 - 5 | 3.504 | 1.102 | 10.315 | 4.29 | 5.250 | 11.2598 | 63.5 | FM-315/L2 |
| 15-3/4" | 15.83 | L1 | 6 - 6 | 2.99 | 1.102 | 13.11 | 3.35 | 4.125 | 14.2519 | 79 | FM-400/L1 |
| 15-3/4" | 15.83 | L2 | 7-3/4 - 5 | 3.504 | 1.102 | 13.11 | 4.29 | 5.250 | 14.2519 | 90 | FM-400/L2 |
| 15-3/4" | 15.83 | L3 | 10-3/8 - 4 | 3.937 | 1.102 | 13.11 | 5.43 | 6.500 | 14.2519 | 118 | FM-400/L3 |
| 20" | 19.80 | L2 | 7-3/4 - 5 | 3.504 | 1.142 | 16.6535 | 4.29 | 5.250 | 18.0314 | 133 | FM-500/L2 |

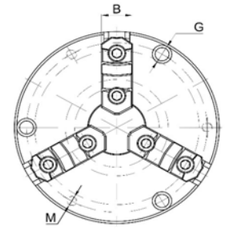


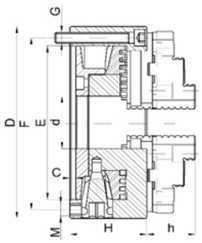


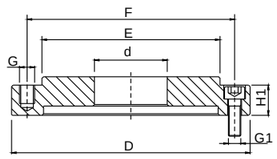
## BPD Base Plate for PO Series & PS Series 3 & 4 Jaw Plain Back Front Mount Scroll Chucks

Designed for use with 3 & 4 jaw scroll front mount plain back chucks
Ideal for use on a CNC or manual rotary tables and indexers with the 3, 4, 6 and 8 T-Slots
Base plates are provided with mounting bolts with T-Nuts and hex key.
All base plates are made of steel for longer life.
Full front mount chuck specification see on the page 115



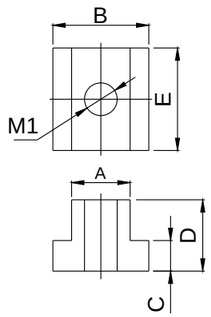


| Chuck Dia. | D | E | F | d | H1 | Chuck Mounting Bolts | | Base Plate Mounting Bolts | | H | | h 2-Pc Jaws | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | G (UNC) | No . Of Bolts | G1 | No . Of Bolts | PS | PO | | |
| 5" | 4.921 | 3.740 | 4.252 | 1.875 | 0.551 | 5/16"-18 | 3 | M6 | 4 | 2.205 | 2.422 | 1.575 | BPD-125 |
| 6-1/4" | 6.299 | 4.921 | 5.512 | 1.850 | 0.636 | 3/8"-16 | 3 | M8 | 4 | 2.539 | 2.756 | 1.693 | BPD-160 |
| 8" | 7.874 | 6.299 | 6.929 | 2.362 | 0.709 | 3/8"-16 | 3 | M8 | 4 | 2.953 | 3.150 | 1.772 | BPD-200 |
| 10" | 9.843 | 7.874 | 8.819 | 3.189 | 0.787 | 1/2"-13 | 3 | M10 | 4 | 3.347 | 3.543 | 2.087 | BPD-250 |
| 12-1/2" | 12.402 | 10.236 | 11.260 | 4.252 | 0.984 | 5/8"-11 | 3 | M10 | 4 | 3.701 | 3.937 | 2.244 | BPD-315 |
| 15-3/4" | 15.748 | 12.992 | 14.252 | 5.551 | 1.063 | 5/8"-11 | 3 | M12 | 4 | 4.134 | 4.331 | 2.693 | BPD-400 |
| 20" | 19.685 | 16.535 | 18.031 | 7.677 | 1.181 | 3/4"-10 | 3 | M16 | 4 | 4.527 | 4.685 | 3.150 | BPD-500 |

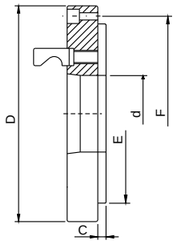
| Chuck Dia. | M1 | A | B | C | D | E |
|---|---|---|---|---|---|---|
| 5" | M6 | .3150 | .5118 | .1969 | .3543 | .5118 |
| 6-1/4" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 8" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 10" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 12-1/2" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 15-3/4" | M12 | .5512 | .8661 | .3150 | .6299 | .8661 |
| 20" | M16 | .7087 | 1.1024 | .3937 | .7874 | 1.1024 |

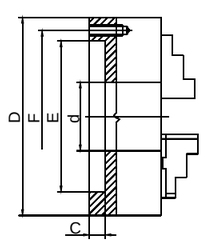


# Adapter Plate Installation Recommendations

## For SM & FM Adapter Plate

Note: All Gator Adapter Plates are made of steel.




| Chuck Dia.D | SM & FM Adapter mounting dimensions after machining | | | | Chuck mounting dimension | | | |
|---|---|---|---|---|---|---|---|---|
| | Required Boss Dia. E | F | C | D | Counter bore Dia E H7 | F | C | D |
| 4" | 2.7567 | 3.2677 | 0.0984 | 3.9370 | 2.7571 | 3.2677 | 0.1181 | 3.9370 |
| | 2.7560 | | | | 2.7559 | | | |
| 5" | 3.7411 | 4.2520 | 0.1378 | 4.9213 | 3.7415 | 4.2520 | 0.1575 | 4.9213 |
| | 3.7403 | | | | 3.7402 | | | |
| 6-1/4" | 4.9224 | 5.5118 | 0.1378 | 6.2992 | 4.9228 | 5.5118 | 0.1575 | 6.2992 |
| | 4.9214 | | | | 4.9213 | | | |
| 8" | 6.3003 | 6.9291 | 0.1378 | 7.8740 | 6.3008 | 6.9291 | 0.1575 | 7.8740 |
| | 6.2993 | | | | 6.2992 | | | |
| 10" | 7.8753 | 8.8189 | 0.1772 | 9.8425 | 7.8758 | 8.8189 | 0.1969 | 9.8425 |
| | 7.8742 | | | | 7.8740 | | | |
| 12-1/2" | 10.2376 | 11.2598 | 0.1772 | 12.4016 | 10.2383 | 11.2598 | 0.1969 | 12.4016 |
| | 10.2364 | | | | 10.2362 | | | |
| 15-3/4" | 12.9937 | 14.2519 | 0.1772 | 15.7480 | 12.9944 | 14.2519 | 0.1969 | 15.7480 |
| | 12.9923 | | | | 12.9921 | | | |
| 20" | 16.5372 | 18.0314 | 0.1772 | 19.6850 | 16.5379 | 18.0314 | 0.1969 | 19.6850 |
| | 16.5356 | | | | 16.5354 | | | |
| 25" | 21.4584 | 23.0709 | 0.2362 | 24.8031 | 21.4594 | 23.0709 | 0.2756 | 24.8031 |
| | 21.4577 | | | | 21.4567 | | | |

1/ Before adapter installation using dial indicator verify spindle nose radial & face run outs. Go to page 44 to verify spindle nose accuracy requirements.

2/ Be sure that spindle nose and adapter plate mounting surfaces are properly cleaned up.

3/ For Camlock mount be sure that all Camlock studs and set screws are mounted correctly.

4/ After selecting suitable back plate , mount it onto the lathe spindle nose.

5/ Proper adapter installation is very important in order to secure concentricity between the lathe's spindle nose and the chuck.

6/ The chuck counterbore diameter is finished by manufacturer to H7 Class, with depth, C.

7/ Prior to machining the adapter, accurately measure the chuck's counterbore diameter, E and depth, C.

8/ A good press fit, H7/k6, is most desirable. See chart above.

9/ To insure very good chuck concentricity, it is important that this procedure is done accurately.

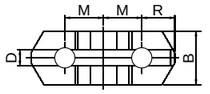
10/ After the installation check chuck face & radial run outs and using a precision ground stock mount it in a chuck jaws and check its radial run out. See page 70

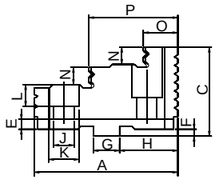




## Hard Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



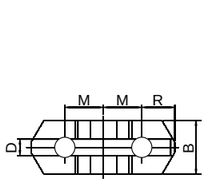
5" to 12-1/2"

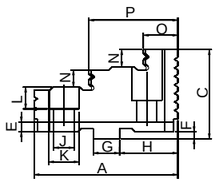
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS3-1000 |

## Hard Top Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



5" to 12-1/2"

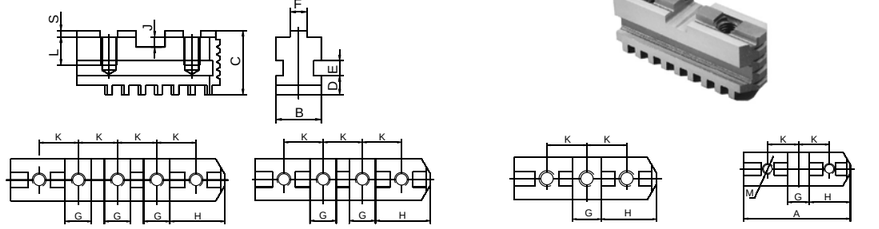
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS4-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS4-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS4-1000 |

# Jaws - Hard Master Jaws

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

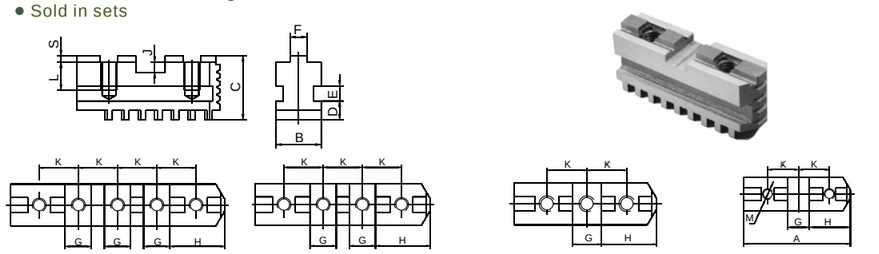


■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 0.93 | MJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS3-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS3-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS3-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS3-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS3-1250 |

## Hard Master Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets






■ 25" to 32" Diameter ■ 20" Diameter ■ 12" to 16" Diameter ■ 5" to 10" Diameter

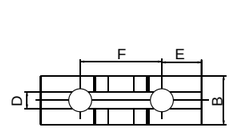
| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-18 | 0.93 | MJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS4-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS4-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS4-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS4-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS4-1250 |



# Jaws - Soft Top Jaws

## Soft Top Jaws, For 3-Jaw & 4-Jaw Chucks

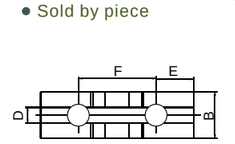
- American Standard Tongue & Groove Jaws
- Sold by piece



| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS1-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS1-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 25"&32" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | . 406 | 3/4-10 | 9.26 | STJ-PS1-630 |

## Soft Top Jaws, For 2-Jaw Chucks

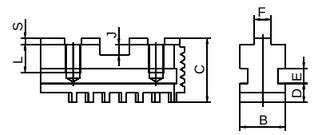
- American Standard Tongue & Groove Jaws
- Sold by piece



| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | K | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 3.071 | 1.575 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 1.14 | 3/8-16 | 1.35 | STJ-PS2-160 |
| 8" | 3.543 | 1.575 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 1.22 | 3/8-16 | 1.85 | STJ-PS2-200 |
| 10" | 4.173 | 1.850 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1.50 | 1/2-13 | 3.00 | STJ-PS2-250 |
| 12-1/2" | 4.724 | 2.047 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1.57 | 1/2-13 | 4.00 | STJ-PS2-315 |
| 15-3/4" | 5.512 | 2.047 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 1.79 | 5/8-11 | 5.50 | STJ-PS2-400 |

## Hard Master Jaws, For 2-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets



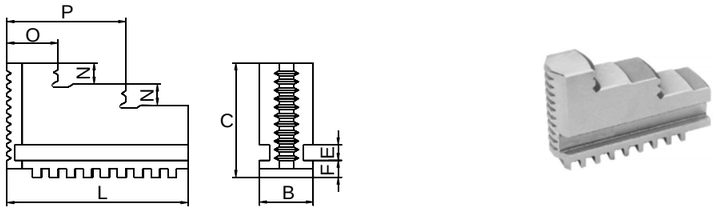
■ 12" to 16" Diameter ■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS2-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS2-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS2-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS2-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS2-400 |

# Jaws - ID Jaws

## ID Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

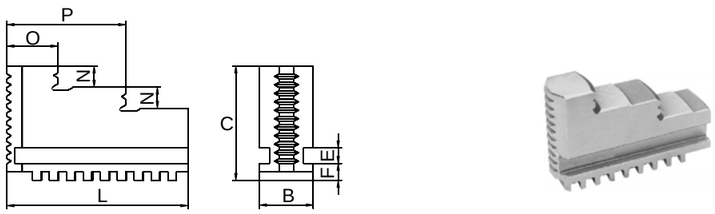





| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS3-500 |

## ID Hard Solid Jaws, For 4-Jaw Chucks

- Sold in sets





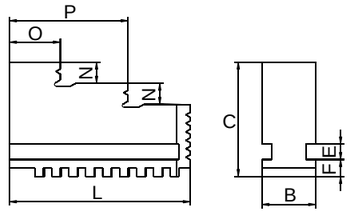

| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS4-500 |

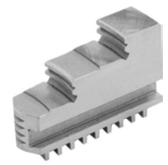




## OD Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets

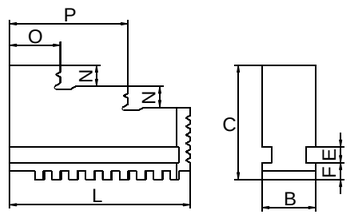


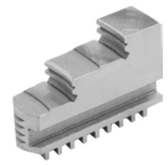



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS3-500 |

## OD Hard Solid Jaws, For 4-Jaw Chucks

- Sold in sets



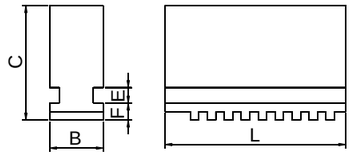



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS4-500 |

# Jaws - Soft Solid Jaws

## Soft Solid Jaws, For 3 Jaw-Chucks

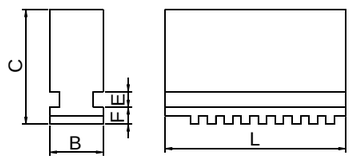
- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS3-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS3-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS3-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS3-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS3-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS3-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS3-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS3-500 |

## Soft Solid Jaws, For 4-Jaw Chucks

- Sold in sets



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS6-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS6-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS6-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS6-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS6-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS6-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS6-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS6-500 |



# Spare Parts

## Scroll Plates

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 3" | SC-PS-080 | 2.1575 |
| 4" | SC-PS-100 | 2.7323 |
| 5" | SC-PS-125 | 3.7008 |
| 6-1/4" | SC-PS-160 | 4.8819 |
| 8" | SC-PS-200 | 6.2598 |
| 10" | SC-PS-250 | 7.7953 |
| 12-1/2" | SC-PS-315 | 10.1575 |
| 15-3/4" | SC-PS-400 | 12.9134 |
| 20" | SC-PS-500 | 16.4173 |
| 25" | SC-PS-630 | 21.3386 |
| 31-1/2" | SC-PS-800 | 27.4106 |

## Pinions

- Sold by piece

| Chuck Dia. | Part No. | OD | OAL |
|---|---|---|---|
| 3" | PI-PS-080 | .7480 | 1.03 |
| 4" | PI-PS-100 | .9843 | 1.40 |
| 5" | PI-PS-125 | .9843 | 1.63 |
| 6-1/4" | PI-PS-160 | 1.1024 | 1.87 |
| 8" | PI-PS-200 | 1.1811 | 2.30 |
| 10" | PI-PS-250 | 1.3583 | 2.72 |
| 12-1/2" | PI-PS-315 | 1.4764 | 3.60 |
| 15-3/4" | PI-PS-400 | 1.7323 | 4.41 |
| 20" | PI-PS-500 | 1.9685 | 5.3 |
| 25" | PI-PS-630 | 2.0472 | 5.87 |
| 31-1/2" | PI-PS-800 | 2.0472 | 8.07 |

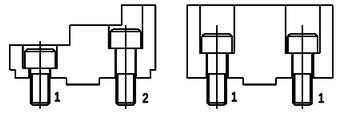
## Pinion Screws

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 3" | PH-P-080 |
| 4" | PH-P-100 |
| 5" | PH-P-125 |
| 6-1/4" | PH-P-160 |
| 8" | PH-P-200 |
| 10" | PH-P-250 |
| 12-1/2" | PH-P-315 |
| 15-3/4" | PH-P-400 |
| 20" | PH-P-500 |
| 25" | PH-P-630 |
| 31-1/2" | PH-P-800 |

## Jaw Mounting Bolts

- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 5" | 5/16-18 | MT-J1-5 | 0.79 | MT-J2-5 | 1.00 |
| 6-1/4" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 8" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 10" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 12-1/2" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 15-3/4" | 5/8-11 | MT-J1-16 | 1.00 | MT-J2-16 | 1.57 |
| 20" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 25" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 31-1/2" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |

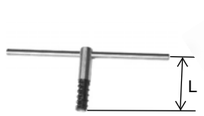
## Chuck Mounting Bolts

- Sold by piece

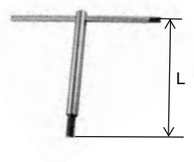
| Chuck Dia. | Part No. | Thread Size |
|---|---|---|
| 3" | MB-BS-080 | M6 x 1 |
| 4" | MB-BS-100 | M8 x 1.25 |
| 5" | MB-BS-125 | M8 x 1.25 |
| 6-1/4" | MB-BS-160 | M10 x 1.5 |
| 8" | MB-BS-200 | M10 x 1.5 |
| 10" | MB-BS-250 | M12 x 1.75 |
| 12-1/2" | MB-BS-315 | M16 x 2 |
| 15-3/4" | MB-BS-400 | M16 x 2 |
| 20" | MB-BS-500 | M16 x 2 |
| 25" | MB-BS-630 | M16 x 2 |
| 31-1/2" | MB-BS-800 | 1"-8 |

## Wrenches (Standard & Extended)

- Sold by piece




Standard Wrench



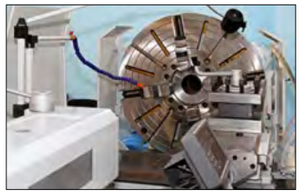

Extended Wrench

| Chuck Dia. | Square Size | Standard | | Extended | |
|---|---|---|---|---|---|
| | | L | Part No. | L | Part No. |
| 3" | .2344 | 2.36 | W-P-080 | - | - |
| 4" | .3543 | 3.15 | W-P-100 | - | - |
| 5" | .3543 | 3.15 | W-P-125 | - | - |
| 6-1/4" | .4331 | 3.90 | W-P-160 | 7.87 | W-SP-160 |
| 8" | .4331 | 3.90 | W-P-200 | 10.02 | W-SP-200 |
| 10" | .5512 | 4.78 | W-P-250 | 8.74 | W-SP-250 |
| 12-1/2" | .5512 | 4.76 | W-P-315 | 10.87 | W-SP-315 |
| 15-3/4" | .6693 | 5.51 | W-P-400 | 10.75 | W-SP-400 |
| 20" | .7480 | 9.06 | W-P-500 | 18.11 | W-SP-500 |
| 25" | .7480 | 9.06 | W-P-630 | - | - |
| 31-1/2" | .7480 | 9.06 | W-P-800 | - | - |

# PI SERIES

## Medium Duty Independent Chucks Semi-Steel and Cast Steel Body

PI Series Gator 4-Jaw cast iron and cast steel body chucks can be used for machining operations were scroll chucks are used and for variety operations where odd shape workpieces have to be machined. Accurate round workpiece requires the use of a dial indicator. High accuracy, high gripping power and durability make them very useful on a variety medium duty turning, milling or grinding operations.



gator chucks BY FUERDA
PI Series - Semi-Steel & Cast Steel Body Independent Chucks

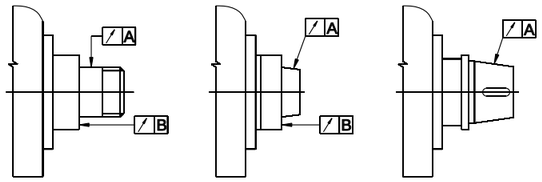
# PI Series 4-Jaw Independent Chucks

Medium Duty
Semi-Steel Body and Cast Steel Body

## Features and Benefits

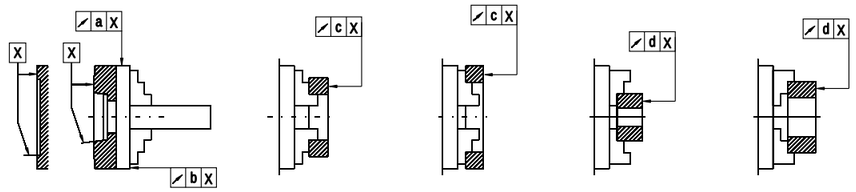
- PI Chucks are provided with 2-Pc Hard Reversible Jaws or Hard Solid Jaws.
- The jaws are made of high quality alloy steel and hardened.
- Thrust bearings and operating screws are made of case hardened steel.
- Chucks 10" and up are provided with T-slots .
- Plain Back Chucks with large selection of Adapter Plates (A, D-1, L & Threaded) and Direct ( A & D-1) mounts secure a large variety of the Spindle mounting options.
- High quality cast steel body construction allows for higher lathe speeds.
- All PI chuck adapter plates are made of steel for long life.
- Chucks 40" & up are cast steel body

# Permissible Spindle Runout For PI Chucks



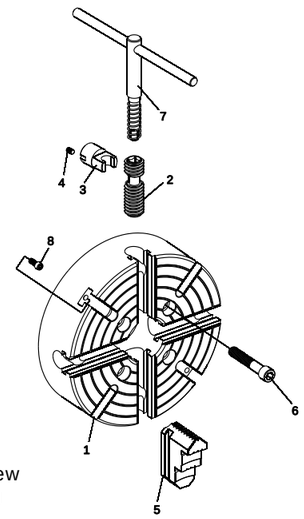

| Chuck Dia. | Spindle Runout |
|---|---|
| 3" - 6" | .00012"max. |
| 8" - 32" | .0002"max. |
| 40" - 50" | .0004"max. |

# Chuck Accuracy



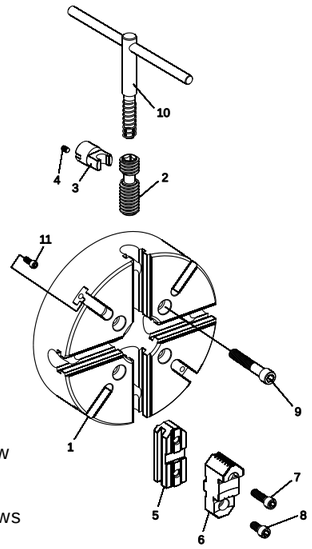

| Chuck Size | | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| a | Radial Runout | 0.0008 | 0.0008 | 0.0012 | 0.0012 | 0.0016 | 0.0016 | 0.0020 | 0.0024 | 0.0040 | 0.0040 | 0.0059 | 0.0071 | 0.0071 |
| b | Face Runout | 0.0006 | 0.0006 | 0.0008 | 0.0008 | 0.0010 | 0.0010 | 0.0012 | 0.0012 | 0.0020 | 0.0020 | 0.0024 | 0.0031 | 0.0040 |
| c | Solid Jaws | 0.0008 | 0.0008 | 0.0008 | 0.0008 | 0.0012 | 0.0012 | 0.0012 | 0.0012 | 0.0020 | 0.0020 | 0.0024 | 0.0031 | 0.0040 |
| c | 2-Pc Jaws | - | - | - | - | 0.0016 | 0.0016 | 0.0016 | 0.0016 | 0.0024 | 0.0024 | 0.0024 | 0.0031 | 0.0040 |
| d | Solid Jaws | 0.0008 | 0.0008 | 0.0008 | 0.0008 | 0.0012 | 0.0012 | 0.0012 | 0.0012 | 0.0020 | 0.0020 | 0.0024 | 0.0031 | 0.0040 |
| d | 2-Pc Jaws | - | - | - | - | 0.0016 | 0.0016 | 0.0016 | 0.0016 | 0.0024 | 0.0024 | 0.0024 | 0.0031 | 0.0040 |

## Chuck with Hard Solid Reversible Jaws




1. Chuck Body
2. Operating Screw
3. Thrust Bearing
4. Set Screw
5. Hard Solid Reversible Jaws
6. Chuck Mounting Bolts
7. Chuck Wrench
8. T-Slot Screw

## Chuck with Hard Two-Piece Reversible Jaws



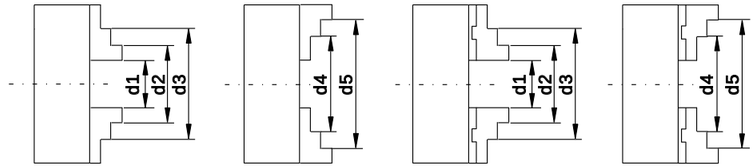

1. Chuck Body
2. Operating Screw
3. Thrust Bearing
4. Set Screw
5. Hard Master Jaws
6. Hard Top Jaws
7 & 8. Jaw Mounting Bolts
9. Chuck Mounting Bolts
10. Chuck Wrench
11. T-Slot Screw



# Clamping Ranges

## PI Series 4-Jaw Independent Chucks

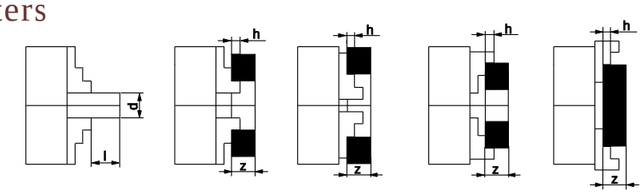
- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and operating screws should be in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.




| Chuck Dia. D | | d1 | | d2 | | d3 max. | | d4 max. | | d5 max. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | JAWS | | | | | | | | | |
| mm | Inch | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible |
| 80 | 3-1/4 | .157-1.53 | - | .984-2.17 | - | 1.97-3.15 | - | .945-2.32 | - | 1.89-3.15 | - |
| 100 | 4 | .197-1.575 | - | 1.38-2.76 | - | 2.48-3.86 | - | 1.30-2.83 | - | 2.40-3.94 | - |
| 125 | 5 | .276-1.97 | - | 1.77-3.46 | - | 3.19-4.80 | - | 1.61-3.46 | - | 3.03-4.92 | - |
| 160 | 6-1/4 | .315-2.87 | - | 1.97-4.53 | - | 3.54-5.71 | - | 1.97-4.69 | - | 3.58-6.30 | - |
| 200 | 8 | .394-3.43 | .394-3.78 | 2.87-5.91 | 2.05-5.43 | 5.04-7.87 | 4.61-7.87 | 2.52-5.71 | 3.15-5.31 | 4.69-7.87 | 5.71-7.87 |
| 250 | 10 | .394-4.80 | .394-4.41 | 2.87-7.28 | 2.28-6.30 | 5.63-9.84 | 5.31-9.45 | 2.48-7.09 | 3.58-6.77 | 5.24-9.84 | 6.61-9.84 |
| 315 | 12-1/2 | .591-5.75 | .591-5.47 | 2.68-7.68 | 2.68-7.56 | 5.91-10.83 | 6.22-11.22 | 4.06-9.25 | 4.13-8.86 | 7.20-12.40 | 7.68-12.40 |
| 400 | 15-3/4 | .787-8.03 | .787-7.87 | 3.46-10.63 | 2.76-9.84 | 7.09-14.37 | 7.01-14.17 | 4.96-12.13 | 5.16-11.50 | 8.58-15.75 | 9.41-15.75 |
| 500 | 20 | 1.77-10.43 | 1.77-11.89 | 4.65-13.31 | 4.65-14.76 | 9.25-17.91 | 8.66-18.82 | 6.46-15.12 | 5.43-15.63 | 11.02-19.69 | 9.49-19.69 |
| 630 | 25 | 1.97-14.37 | 1.97-17.87 | 5.59-17.99 | 4.80-20.71 | 10.63-23.03 | 8.66-24.80 | 7.32-19.76 | 5.67-20.67 | 12.40-24.80 | 8.90-24.80 |
| 800 | 31-1/2 | 1.97-19.06 | 1.97-24.53 | 5.59-22.68 | 5.20-27.75 | 11.61-28.70 | 9.06-31.50 | 8.27-25.39 | 11.42-27.56 | 14.37-31.50 | 15.55-31.50 |
| 1000 | 40 | 6.69-25.20 | 6.69-32.87 | 12.21-30.71 | 13.19-39.37 | 19.69-38.19 | - | 12.99-31.50 | - | 20.67-39.37 | 12.99-39.37 |
| 1250 | 50 | 6.69-35.43 | 6.69-47.72 | 12.21-40.94 | 13.19-49.21 | 19.69-48.43 | - | 13.19-41.34 | - | 20.87-49.21 | 12.99-49.21 |

# Safe Operating Parameters

Conditions:
l&z=maximum length of workpiece
d=workpiece diameter
h=height of the clamping jaw step
workpiece is clamped into the chuck
jaws without additional support.




| Chuck Diameter | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| l | 1.2 x d | | | | | | 1.5 x d | | | 1 x d | | | |
| z | 4 x h | | | | | | | | | | | | |

## Recommended Maximum Speeds ( RPM )

| Chuck Size | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Semi-Steel Body | 4000 | 4000 | 3500 | 3200 | 1800 | 1500 | 1200 | 800 | 500 | 400 | 300 | - | - |
| Cast Steel Body | - | - | - | - | - | - | - | 1100 | 700 | 550 | 450 | 200 | 150 |

## Max. Load Capacity for Supported Workpieces ( lbs.)

| Chuck Size | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Semi-Steel Body | 33 | 110 | 330 | 550 | 1320 | 2200 | 3300 | 6600 | 9900 | 14300 | 18700 | - | - |
| Cast Steel Body | - | - | - | - | - | - | - | 8600 | 12900 | 18600 | 24300 | 32900 | 37600 |

Note: Max. load capacity is rated per one PI chuck. Max. load capacity has been calculated for symmetrical workpiece SUPPORDED with the live center, steady rest or being gripped in two chucks. For the odd shape workpieces the RPM should be reduced significantly.

## Recommended Torques on a Chuck Wrench

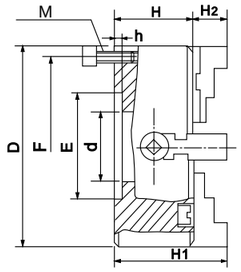
| Chuck Size | 3-1/4" | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Nm | 25 | 30 | 50 | 70 | 100 | 150 | 180 | 280 | 350 | 400 | 450 | 550 | 600 |
| lb.ft. | 18.5 | 22.2 | 37 | 52 | 74 | 111 | 133 | 207 | 258 | 295 | 332 | 406 | 443 |

# 4-Jaw Independent Chucks , Plain Back
# Solid Reversible Jaws

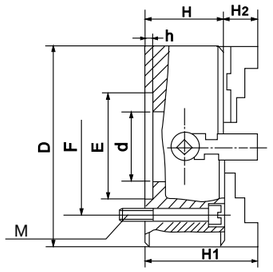
Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

**Chuck with solid jaw provided with:**

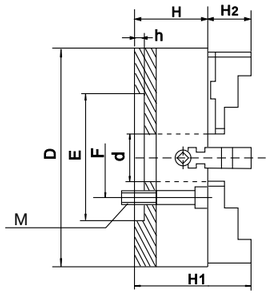
- 1 Set of hard solid reversible jaws
- 1 Set adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual




3", 4", 5"




6", 8", 32",40", 50"




10", 12", 16",20", 25"

| Chuck Dia.(D) | E | F | Hole(d) | H | H1 | h | M | | Wt. Lbs. | Solid Jaws | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Thread | Qty. | | Model | Part No . |
| 3-1/4" | 2.165 | 2.598 | 0.866 | 1.654 | 2.283 | 0.138 | M6 | 4 | 4 | PI4-3" | 1-302-0300 |
| 4" | 2.835 | 3.307 | 0.984 | 2.126 | 3.031 | 0.157 | M8 | 4 | 7 | PI4-4" | 1-302-0400 |
| 5" | 3.740 | 4.252 | 1.181 | 2.205 | 3.071 | 0.177 | M8 | 4 | 11 | PI4-5" | 1-302-0500 |
| 6-1/4" | 2.559 | 3.740 | 1.772 | 2.559 | 3.799 | 0.196 | M10 | 4 | 16 | PI4-6" | 1-302-0600 |
| 8" | 2.953 | 3.740 | 2.205 | 2.953 | 4.331 | 0.236 | M10 | 4 | 22 | PI4-8" | 1-302-0800 |
| 10" | 5.906 | 4.126 | 2.559 | 3.347 | 4.700 | 0.276 | M12 | 4 | 55 | PI4-10" | 1-302-1000 |
| 12-1/2" | 6.890 | 5.252 | 3.150 | 3.740 | 5.701 | 0.276 | M16 | 4 | 86 | PI4-12" | 1-302-1200 |
| 15-3/4" | 7.874 | 6.748 | 3.937 | 4.134 | 6.095 | 0.394 | M16 | 4 | 134 | PI4-16" | 1-302-1600 |
| 20" | 10.630 | 9.252 | 4.921 | 4.724 | 7.070 | 0.472 | M20 | 4 | 231 | PI4-20" | 1-302-2000 |
| 25" | 10.630 | 9.252 | 6.299 | 5.512 | 7.866 | 0.472 | M20 | 4 | 359 | PI4-25" | 1-302-2500 |
| 32" | 9.843 | 11.811 | 8.268 | 5.709 | 8.268 | 0.472 | M20 | 8 | 703 | PI4-32" | 1-302-3200 |
| 40" * | 12.598 | 14.567 | 10.236 | 5.906 | 9.488 | 0.591 | M20 | 8 | 816 | PI4-40" | 1-302-4000 |
| 50" * | 15.748 | 19.685 | 7.087 | 6.496 | 10.074 | 0.591 | M20 | 8 | 1543 | PI4-50" | 1-302-5000 |

* Cast steel body

## Spare Parts

| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 3-1/4" | RJ-PI-080 | - | - | - | OS-PI-080 | TB-PI-080 | W-PI-080 |
| 4" | RJ-PI-100 | - | - | - | OS-PI-100 | TB-PI-100 | W-PI-100 |
| 5" | RJ-PI-125 | - | - | - | OS-PI-125 | TB-PI-125 | W-PI-125 |
| 6-1/4" | RJ-PI-160 | - | - | - | OS-PI-160 | TB-PI-160 | W-PI-160 |
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

* Cast steel body

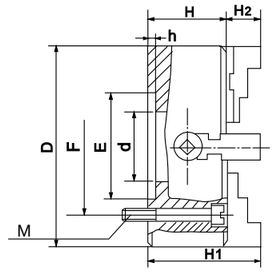


# 4-Jaw Independent Chucks , Plain Back
# Two Piece Hard Reversible Jaws

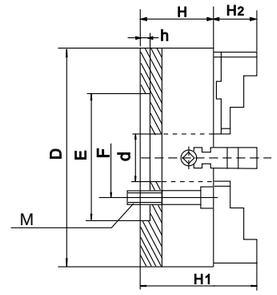
Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

**Chuck with solid jaw provided with:**

- 1 Set of hard top jaws
- 1 Set of hard master jaws
- 1 Set adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual




8", 32",40", 50"




10", 12", 16",20", 25"

| Chuck Dia.(D) | E | F | Hole(d) | Hole Enlargement | H | H2 | h | M | | Wt. Lbs. | Two-Piece Jaws | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread | Qty. | | Model | Part No . |
| 8" | 2.953 | 3.740 | 2.205 | 2.283 | 2.953 | 1.8268 | 0.236 | M10 | 4 | 22 | PI4-8"A | 1-301-0800 |
| 10" | 5.906 | 4.126 | 2.559 | 2.653 | 3.347 | 2.3780 | 0.276 | M12 | 4 | 55 | PI4-10"A | 1-301-1000 |
| 12-1/2" | 6.890 | 5.252 | 3.150 | 3.858 | 3.740 | 2.3980 | 0.276 | M16 | 4 | 86 | PI4-12"A | 1-301-1200 |
| 15-3/4" | 7.874 | 6.748 | 3.937 | 4.621 | 4.134 | 2.8465 | 0.394 | M16 | 4 | 134 | PI4-16"A | 1-301-1600 |
| 20" | 10.630 | 9.252 | 4.921 | 6.266 | 4.724 | 3.5551 | 0.472 | M20 | 4 | 231 | PI4-20"A | 1-301-2000 |
| 25" | 10.630 | 9.252 | 6.299 | 7.087 | 5.512 | 3.8504 | 0.472 | M20 | 4 | 359 | PI4-25"A | 1-301-2500 |
| 32" | 9.843 | 11.811 | 8.268 | - | 5.709 | 3.6929 | 0.472 | M20 | 8 | 703 | PI4-32"A | 1-301-3200 |
| 40" * | 12.598 | 14.567 | 10.236 | - | 5.906 | 4.6850 | 0.591 | M20 | 8 | 816 | PI4-40"A | 1-301-4000 |
| 50" * | 15.748 | 19.685 | 7.087 | - | 6.496 | 4.6850 | 0.591 | M20 | 8 | 1543 | PI4-50"A | 1-301-5000 |

* Cast steel body

## Spare Parts

| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

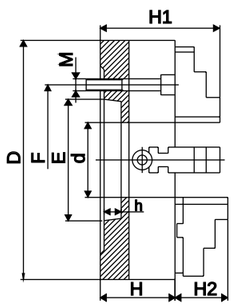
* Cast steel body

# 4-Jaw Independent Chucks , Type A1/A2
# Solid Reversible Jaws

Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

**Chuck with solid jaw provided with:**

- 1 Set of hard solid reversible jaws
- 1 Set chuck mounting bolts
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual



Type A

| Chuck Dia.(D) | Taper No. | E | F | d | H1 | H | h | M | | | Wt. Lbs. | Model | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread | L | Qty. | | | |
| 8" | A2-5 | 3.251 | 4.125 | 2.205 | 4.331 | 2.953 | 0.512 | 7/16"-14 | 3-1/8 | 4 | 38 | PI4-8"/A2-5 | 1-312-0805 |
| 10" | A2-5 | 3.251 | 4.125 | 2.559 | 4.700 | 3.347 | 0.512 | 7/16"-14 | 3-1/8 | 4 | 55 | PI4-10"/A2-5 | 1-312-1005 |
| | A2-6 | 4.188 | 5.250 | | | | 0.591 | 1/2"-13 | 3-1/8 | 4 | | PI4-10"/A2-6 | 1-312-1006 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | 3-3/8 | 4 | | PI4-10"/A2-8 | 1-312-1008 |
| 12-1/2" | A2-5 | 3.251 | 4.125 | 3.091 | 5.701 | 3.740 | 0.512 | 7/16"-14 | 3-1/2 | 4 | 86 | PI4-12"/A2-5 | 1-312-1205 |
| | A2-6 | 4.188 | 5.250 | 3.150 | | | 0.591 | 1/2"-13 | 3-1/2 | 4 | | PI4-12"/A2-6 | 1-312-1206 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | 3-1/4 | 4 | | PI4-12"/A2-8 | 1-312-1208 |
| 15-3/4" | A2-6 | 4.188 | 5.250 | 3.937 | 6.095 | 4.134 | 0.591 | 1/2"-13 | 4 | 4 | 140 | PI4-16"/A2-6 | 1-312-1606 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | | 4 | | PI4-16"/A2-8 | 1-312-1608 |
| | A2-11 | 7.751 | 9.252 | | | | 0.787 | 3/4"-10 | | 4 | | PI4-16"/A2-11 | 1-312-1611 |
| 20" | A2-8 | 5.501 | 6.750 | 4.921 | 7.070 | 4.724 | 0.709 | 5/8"-11 | 4-1/2 | 4 | 245 | PI4-20"/A2-8 | 1-312-2008 |
| | A2-11 | 7.751 | 9.252 | | | | 0.787 | 3/4"-10 | | 4 | | PI4-20"/A2-11 | 1-312-2011 |
| 25" | A2-11 | 7.751 | 9.252 | 6.299 | 7.866 | 5.512 | 0.787 | 3/4"-10 | 5-5/16 | 4 | 358 | PI4-25"/A2-11 | 1-312-2511 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | | 4 | | PI4-25"/A2-15 | 1-312-2515 |
| 32" | A2-11 | 7.751 | 9.252 | 7.087 | 8.268 | 5.315 | 0.787 | 3/4"-10 | 5-7/8 | 8 | 672 | PI4-32"/A2-11 | 1-312-3211 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | 6-1/8 | 8 | | PI4-32"/A2-15 | 1-312-3215 |
| 40" * | A2-11 | 7.751 | 9.252 | 7.087 | 9.488 | 5.906 | 0.787 | 3/4"-10 | 7-3/32 | 8 | 780 | PI4-40"/A2-11 | 1-312-4011 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | 7-3/32 | 8 | | PI4-40"/A2-15 | 1-312-4015 |

* Cast steel body
40" with A2-20 (Part No.1-312-4020) is available ; 50" with A2-11,A2-15,A220 are available.

## Spare Parts

| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

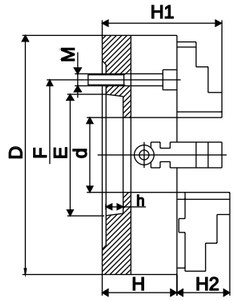


# 4-Jaw Independent Chucks , Type A1/A2
# Two Piece Hard Reversible Jaws

Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

**Chuck with solid jaw provided with:**

- 1 Set of hard top jaws
- 1 Set of hard master jaws
- 1 Set adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual



Type A

| Chuck Dia.(D) | Taper No. | E | F | d | H2 | H | h | M | | | Wt. Lbs. | Model | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread | L | Qty. | | | |
| 8" | A2-5 | 3.251 | 4.125 | 2.205 | 1.8268 | 2.953 | 0.512 | 7/16"-14 | 3-1/8 | 4 | 38 | PI4-8"A/A2-5 | 1-311-0805 |
| 10" | A2-5 | 3.251 | 4.125 | 2.559 | 2.3780 | 3.347 | 0.512 | 7/16"-14 | 3-1/8 | 4 | 55 | PI4-10"A/A2-5 | 1-311-1005 |
| | A2-6 | 4.188 | 5.250 | | | | 0.591 | 1/2"-13 | 3-1/8 | 4 | | PI4-10"A/A2-6 | 1-311-1006 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | 3-3/8 | 4 | | PI4-10"A/A2-8 | 1-311-1008 |
| 12-1/2" | A2-5 | 3.251 | 4.125 | 3.091 | 2.3980 | 3.740 | 0.512 | 7/16"-14 | 3-1/2 | 4 | 86 | PI4-12"A/A2-5 | 1-311-1205 |
| | A2-6 | 4.188 | 5.250 | 3.150 | | | 0.591 | 1/2"-13 | 3-1/2 | 4 | | PI4-12"A/A2-6 | 1-311-1206 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | 3-1/4 | 4 | | PI4-12"A/A2-8 | 1-311-1208 |
| 15-3/4" | A2-6 | 4.188 | 5.250 | 3.937 | 2.8465 | 4.134 | 0.591 | 1/2"-13 | 4 | 4 | 140 | PI4-16"A/A2-6 | 1-311-1606 |
| | A2-8 | 5.501 | 6.750 | | | | 0.709 | 5/8"-11 | | 4 | | PI4-16"A/A2-8 | 1-311-1608 |
| | A2-11 | 7.751 | 9.252 | | | | 0.787 | 3/4"-10 | | 4 | | PI4-16"A/A2-11 | 1-311-1611 |
| 20" | A2-8 | 5.501 | 6.750 | 4.921 | 3.5551 | 4.724 | 0.709 | 5/8"-11 | 4-1/2 | 4 | 245 | PI4-20"A/A2-8 | 1-311-2008 |
| | A2-11 | 7.751 | 9.252 | | | | 0.787 | 3/4"-10 | | 4 | | PI4-20"A/A2-11 | 1-311-2011 |
| 25" | A2-11 | 7.751 | 9.252 | 6.299 | 3.8504 | 5.512 | 0.787 | 3/4"-10 | 5-5/16 | 4 | 358 | PI4-25"A/A2-11 | 1-311-2511 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | | 4 | | PI4-25"A/A2-15 | 1-311-2515 |
| 32" | A2-11 | 7.751 | 9.252 | 7.087 | 3.6929 | 5.315 | 0.787 | 3/4"-10 | 5-7/8 | 8 | 672 | PI4-32"A/A2-11 | 1-311-3211 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | 6-1/8 | 8 | | PI4-32"A/A2-15 | 1-311-3215 |
| 40" * | A2-11 | 7.751 | 9.252 | 7.087 | 4.6850 | 5.906 | 0.787 | 3/4"-10 | 7-3/32 | 8 | 780 | PI4-40"A/A2-11 | 1-311-4011 |
| | A2-15 | 11.251 | 13.00 | | | | 0.827 | 7/8"-9 | 7-3/32 | 8 | | PI4-40"A/A2-15 | 1-311-4015 |

* Cast steel body
40" with A2-20 (Part No.1-311-4020) is available ; 50" with A2-11,A2-15,A2-20 are available.

## Spare Parts

| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

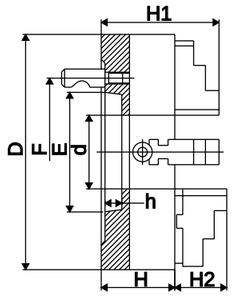
# 4-Jaw Independent Chucks , Type D1
## Solid Reversible Jaws

Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

Type D1

**Chuck with solid jaw provided with:**

- 1 Set of hard solid reversible jaws
- 1 set of Camlock Studs
- 1 Set of Camlock Stud Set Screws
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual




| Chuck Dia.(D) | Taper No. | E | F | d | H1 | H | h | Camlock Studs | | | Wt. Lbs. | Model | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread | L | Qty. | | | |
| 8" | D1-4 | 2.501 | 3.252 | 2.205 | 4.331 | 2.953 | 0.5118 | 5 /8 | M10x1 | 3 | 22 | PI4-8"/D1-4 | 1-322-0804 |
| | D1-5 | 3.251 | 4.126 | | | | 0.5906 | 3 /4 | M12x1 | 6 | | PI4-8"/D1-5 | 1-322-0805 |
| 10" | D1-4 | 2.501 | 3.252 | 2.362 | 4.700 | 3.347 | 0.5118 | 5 /8 | M10x1 | 3 | 60 | PI4-10"/D1-4 | 1-322-1004 |
| | D1-5 | 3.251 | 4.126 | 2.559 | | | 0.5906 | 3 /4 | M12x1 | 6 | | PI4-10"/D1-5 | 1-322-1005 |
| | D1-6 | 4.188 | 5.252 | | | | 0.6299 | 7 /8 | M16x1.5 | | | PI4-10"/D1-6 | 1-322-1006 |
| 12-1/2" | D1-6 | 4.188 | 5.252 | 3.150 | 5.701 | 3.740 | 0.6299 | 7 /8 | M16x1.5 | 6 | 87 | PI4-12"/D1-6 | 1-322-1206 |
| | D1-8 | 5.501 | 6.748 | | | | 0.7087 | 1 | M20x1.5 | | | PI4-12"/D1-8 | 1-322-1208 |
| 15-3/4" | D1-6 | 4.188 | 5.252 | 3.937 | 6.095 | 4.134 | 0.6299 | 7 /8 | M16x1.5 | 6 | 132 | PI4-16"/D1-6 | 1-322-1606 |
| | D1-8 | 5.501 | 6.748 | | | | 0.7087 | 1 | M20x1.5 | | | PI4-16"/D1-8 | 1-322-1608 |
| | D1-11 | 7.751 | 9.252 | | | | 0.7874 | 1-3 /16 | M22x1.5 | | | PI4-16"/D1-11 | 1-322-1611 |
| 20" | D1-8 | 5.501 | 6.750 | 4.921 | 7.070 | 4.724 | 0.7087 | 1 | M20x1.5 | 6 | 211 | PI4-20"/D1-8 | 1-322-2008 |
| | D1-11 | 7.751 | 9.252 | | | | 0.7874 | 1-3 /16 | M22x1.5 | | | PI4-20"/D1-11 | 1-322-2011 |
| 25" | D1-11 | 7.751 | 9.252 | 6.299 | 7.866 | 5.512 | 0.7874 | 1-3 /16 | M22x1.5 | 6 | 364 | PI4-25"/D1-11 | 1-322-2511 |

32" with D1-11 is available.Part No.: 1-322-3211.

* Cast steel body

## Spare Parts

| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

* Cast steel body



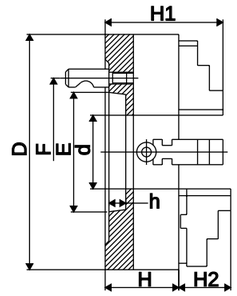
# 4-Jaw Independent Chucks , Type D1
## Two Piece Hard Reversible Jaws

Semi-Steel Body 3" to 32"
Cast-Steel Body 40" to 50"

Type D1

**Chuck with solid jaw provided with:**

- 1 Set of hard top jaws
- 1 Set of hard master jaws
- 1 set of Camlock Studs
- 1 Set of Camlock Stud Set Screws
- 1 Spring loaded chuck T - wrench
- 1 Hex keys
- Eye bolts for chucks 10" and larger
- 10" chucks & larger have T-Slot
- Lathe Chuck Manual




| Chuck Dia.(D) | Taper No. | E | F | d | H2 | H | h | Camlock Studs | | | Wt. Lbs. | Model | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Thread | L | Qty. | | | |
| 8" | D1-4 | 2.501 | 3.252 | 2.205 | 1.8268 | 2.953 | 0.5118 | 5 /8 | M10x1 | 3 | 22 | PI4-8"A/D1-4 | 1-321-0804 |
| | D1-5 | 3.251 | 4.126 | | | | 0.5906 | 3 /4 | M12x1 | 6 | | PI4-8"A/D1-5 | 1-321-0805 |
| 10" | D1-4 | 2.501 | 3.252 | 2.362 | 2.3780 | 3.347 | 0.5118 | 5 /8 | M10x1 | 3 | 60 | PI4-10"A/D1-4 | 1-321-1004 |
| | D1-5 | 3.251 | 4.126 | 2.559 | | | 0.5906 | 3 /4 | M12x1 | 6 | | PI4-10"A/D1-5 | 1-321-1005 |
| | D1-6 | 4.188 | 5.252 | | | | 0.6299 | 7 /8 | M16x1.5 | | | PI4-10"A/D1-6 | 1-321-1006 |
| 12-1/2" | D1-6 | 4.188 | 5.252 | 3.150 | 2.3980 | 3.740 | 0.6299 | 7 /8 | M16x1.5 | 6 | 87 | PI4-12"A/D1-6 | 1-321-1206 |
| | D1-8 | 5.501 | 6.748 | | | | 0.7087 | 1 | M20x1.5 | | | PI4-12"A/D1-8 | 1-321-1208 |
| 15-3/4" | D1-6 | 4.188 | 5.252 | 3.937 | 2.8465 | 4.134 | 0.6299 | 7 /8 | M16x1.5 | 6 | 132 | PI4-16"A/D1-6 | 1-321-1606 |
| | D1-8 | 5.501 | 6.748 | | | | 0.7087 | 1 | M20x1.5 | | | PI4-16"A/D1-8 | 1-321-1608 |
| | D1-11 | 7.751 | 9.252 | | | | 0.7874 | 1-3 /16 | M22x1.5 | | | PI4-16"A/D1-11 | 1-321-1611 |
| 20" | D1-8 | 5.501 | 6.750 | 4.921 | 3.5551 | 4.724 | 0.7087 | 1 | M20x1.5 | 6 | 211 | PI4-20"A/D1-8 | 1-321-2008 |
| | D1-11 | 7.751 | 9.252 | | | | 0.7874 | 1-3 /16 | M22x1.5 | | | PI4-20"A/D1-11 | 1-321-2011 |
| 25" | D1-11 | 7.751 | 9.252 | 6.299 | 3.8504 | 5.512 | 0.7874 | 1-3 /16 | M22x1.5 | 6 | 364 | PI4-25"A/D1-11 | 1-321-2511 |

32" with D1-11 is available.Part No.: 1-321-3211.

* Cast steel body

## Spare Parts

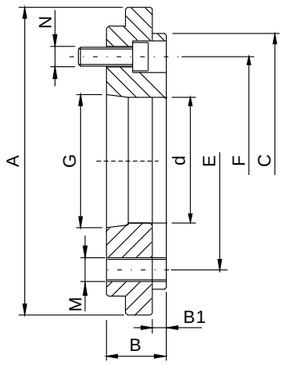
| Chuck Dia.(D) | Hard Solid Reversible Jaw | Hard Top Jaw | Soft Top Jaw | Hard Master Jaw | Operating Screw | Thrust Bearing | Wrench |
|---|---|---|---|---|---|---|---|
| 8" | RJ-PI-200 | TJ-PI-200 | STJ-PI-200 | MJ-PI-200 | OS-PI-200 | TB-PI-200 | W-PI-250 |
| 10" | RJ-PI-250 | TJ-PI-250 | STJ-PI-250 | MJ-PI-250 | OS-PI-250 | TB-PI-250 | W-PI-250 |
| 12-1/2" | RJ-PI-315 | TJ-PI-315 | STJ-PI-315 | MJ-PI-315 | OS-PI-315 | TB-PI-315 | W-PI-400 |
| 15-3/4" | RJ-PI-400 | TJ-PI-400 | STJ-PI-400 | MJ-PI-400 | OS-PI-400 | TB-PI-400 | W-PI-400 |
| 20" | RJ-PI-500 | TJ-PI-500 | STJ-PI-500 | MJ-PI-500 | OS-PI-500 | TB-PI-500 | W-PI-630 |
| 25" | RJ-PI-630 | TJ-PI-630 | STJ-PI-630 | MJ-PI-630 | OS-PI-630 | TB-PI-630 | W-PI-630 |
| 32" | RJ-PI-800 | TJ-PI-800 | STJ-PI-800 | MJ-PI-800 | OS-PI-800 | TB-PI-800 | W-PI-800 |
| 40" * | RJ-PI-1000 | TJ-PI-1000 | STJ-PI-1000 | MJ-PI-1000 | OS-PI-1000 | TB-PI-1000 | W-PI-1000 |
| 50" * | RJ-PI-1250 | TJ-PI-1250 | STJ-PI-1250 | MJ-PI-1250 | OS-PI-1250 | TB-PI-1250 | W-PI-1250 |

* Cast steel body

# FLI Series Fully Machined Adapter Plate

## Type A1/A2 Steel Adapters, Fully Machined for PI Series Plain Back Independent Chucks

Note:
No machining required
All adapters come with the set of spindle mounting bolts and hex key
All below listed adapters can be mounted either on A1 or A2 spindle noses
All adapters are made of steel for long life



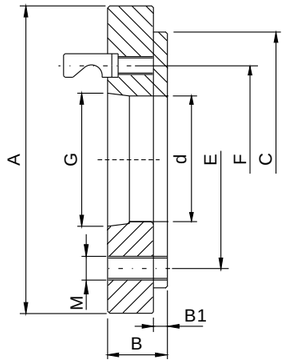

| Chuck Dia. | Taper Size | A | G Taper Dia. | d | C | E | M Chuck Mounting Bolts | F | Spindle Mounting Bolts | | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | N | QTY | | | | |
| 6-1/4" | A5 | 6.378 | 3.2505 | 1.772 | 2.559 | 3.740 | M10 | 4.125 | 7/16-14 | 4 | 1.260 | 0.177 | 7.8 | FLI-160/A5 |
| 8" | A5 | 7.874 | 3.2505 | 2.205 | 2.953 | 3.740 | M10 | 4.125 | 7/16-14 | 4 | 1.378 | 0.2165 | 12.3 | FLI-200/A5 |
| | A6 | 7.874 | 4.1880 | 2.205 | 2.953 | 3.740 | M10 | 5.250 | 1/2-13 | 4 | 1.890 | 0.2165 | 22.4 | FLI-200/A6 |
| 10" | A6 | 8.661 | 4.1880 | 2.559 | 5.906 | 4.126 | M12 | 5.250 | 1/2-13 | 4 | 1.771 | 0.3543 | 20.1 | FLI-250/A6 |
| 12-1/2" | A6 | 8.268 | 4.1880 | 3.150 | 6.890 | 5.252 | M16 | 5.250 | 1/2-13 | 4 | 1.378 | 0.315 | 15.2 | FLI-315/A6 |
| | A8 | 11.22 | 5.5005 | 3.150 | 6.890 | 5.252 | M16 | 6.750 | 5/8-11 | 4 | 2.165 | 0.315 | 40.3 | FLI-315/A8 |
| 15-3/4" | A6 | 7.874 | 4.1880 | 3.937 | 7.874 | 6.748 | M16 | 5.250 | 1/2-13 | 6 | 1.575 | - | 18.3 | FLI-400/A6 |
| | A8 | 10.236 | 5.5005 | 3.937 | 7.874 | 6.748 | M16 | 6.750 | 5/8-11 | 6 | 1.850 | 0.394 | 28.5 | FLI-400/A8 |
| | A11 | 13.386 | 7.7507 | 3.937 | 7.874 | 6.748 | M16 | 9.250 | 3/4-10 | 6 | 1.969 | 0.394 | 50.8 | FLI-400/A11 |
| 20" | A8 | 12.40 | 5.5005 | 4.921 | 10.63 | 9.252 | M20 | 6.750 | 5/8-11 | 6 | 1.969 | 0.551 | 42.7 | FLI-500/A8 |
| | A11 | 12.78 | 7.7507 | 4.921 | 10.63 | 9.252 | M20 | 9.250 | 3/4-10 | 6 | 1.969 | 0.551 | 48.7 | FLI-500/A11 |
| 25" | A8 | 12.40 | 5.5005 | 4.921 | 10.63 | 9.252 | M20 | 6.750 | 5/8-11 | 6 | 1.969 | 0.551 | 42.7 | FLI-630/A8 |
| | A11 | 12.27 | 7.7507 | 4.921 | 10.63 | 9.252 | M20 | 9.250 | 3/4-10 | 6 | 1.969 | 0.551 | 48.7 | FLI-630/A11 |
| 31-1/2" | A15 | 15.75 | 11.2509 | 8.268 | 9.843 | 11.811 | M20 | 13.000 | 7/8-9 | 6 | 3.071 | 0.394 | 115 | FLI-800/A15 |



FLI Series Fully Machined Adapter Plate

## Type D1 Steel Adapters, Fully Machined for PI Series Plain Back Independent Chucks

Note:
No machining required
All adapters come with the set of Camlock Studs and set screws
All adapters are made of steel for long life

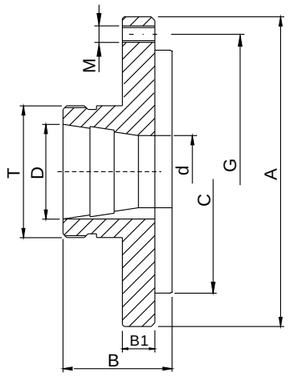



| Chuck Dia. | Taper Size | A | G Taper Dia. | d | C | E | M Chuck Mounting Bolts | F | Camlock Stud | | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | N | QTY | | | | |
| 6-1/4" | D1-4 | 6.378 | 2.5005 | 1.772 | 2.559 | 3.740 | M10 | 3.250 | 5/8 | 3 | 1.693 | 0.77 | 14.25 | FLI-160/D4 |
| 8" | D1-4 | 6.378 | 2.5005 | 2.205 | 2.953 | 3.740 | M10 | 3.250 | 5/8 | 3 | 1.575 | 0.2165 | 9.3 | FLI-200/D4 |
| | D1-6 | 7.126 | 4.1880 | 2.205 | 2.953 | 3.740 | M10 | 5.250 | 7/8 | 6 | 1.969 | 0.2165 | 18.7 | FLI-200/D6 |
| 10" | D1-6 | 7.992 | 4.1880 | 2.559 | 5.906 | 4.126 | M12 | 5.250 | 7/8 | 6 | 1.890 | 0.3543 | 23.2 | FLI-250/D6 |
| | D1-8 | 8.858 | 5.5005 | 2.559 | 5.906 | 4.126 | M12 | 6.750 | 1 | 6 | 1.929 | 0.3543 | 27.4 | FLI-250/D8 |
| 12-1/2" | D1-6 | 8.858 | 4.1880 | 3.150 | 6.890 | 5.252 | M16 | 5.250 | 7/8 | 6 | 2.756 | 0.3150 | 34.1 | FLI-315/D6 |
| | D1-8 | 8.858 | 5.5005 | 3.150 | 6.890 | 5.252 | M16 | 6.750 | 1 | 6 | 2.165 | 0.3150 | 31.8 | FLI-315/D8 |
| 15-3/4" | D1-6 | 7.874 | 4.1880 | 3.937 | 7.874 | 6.748 | M16 | 5.250 | 7/8 | 6 | 1.575 | - | 17.8 | FLI-400/D6 |
| | D1-11 | 11.73 | 7.7507 | 4.900 | 7.874 | 6.748 | M16 | 9.252 | 1-3/16 | 6 | 2.165 | 0.394 | 51.5 | FLI-400/D11 |
| 20" | D1-8 | 12.40 | 5.5005 | 4.921 | 10.63 | 9.252 | M20 | 6.750 | 1 | 6 | 1.969 | 0.551 | 49.1 | FLI-500/D8 |
| | D1-11 | 11.73 | 7.7507 | 4.921 | 10.63 | 9.252 | M20 | 13.000 | 1-3/16 | 6 | 2.165 | 0.551 | 52.6 | FLI-500/D11 |
| 25" | D1-8 | 10.63 | 5.5005 | 5.315 | 10.63 | 9.252 | M20 | 6.750 | 1 | 6 | 1.772 | - | 38 | FLI-630/D8 |
| | D1-11 | 11.73 | 7.7507 | 6.300 | 10.63 | 9.252 | M20 | 13.000 | 1-3/16 | 6 | 2.441 | 0.551 | 53.8 | FLI-630/D11 |

# FLI Series Fully Machined Adapter Plate

## Type L Steel Adapters, Fully Machined for PI Series Plain Back Independent Chucks

Note:
No machining required
All adapters are made of steel for long life



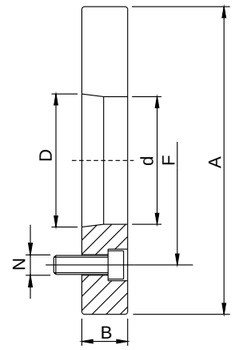

| Chuck Dia. | Taper Size | A | T Taper Thread | D Taper Dia. | d | C | M Chuck Mounting Bolts | G | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 31-1/2" | L2 | 15.748 | 7-3/4"-5 | 5.250 | 4.29 | 9.8425 | M20 | 11.811 | 3.724 | 1.102 | 92.2 | FLI-800/L2 |
| | L3 | 15.748 | 10-3/8"-4 | 6.500 | 5.433 | 9.8425 | M20 | 11.811 | 4.016 | 1.181 | 115.2 | FLI-800/L3 |



# SM Series Semi-machined Adapter Plate

## Type A1/A2 Semi-machined Adapters for PI Series chucks

Designed for direct mounting on A1 & A2 spindle noses,
Can be used after machining for scroll or independent chucks,
Spindle side of each adapter is fully finished.
Provided with the set of spindle mounting bolts & hex key.
All below listed adapters can be mounted eather on A1 or A2 spindle noses.
All adapters are made of steel for longer life.



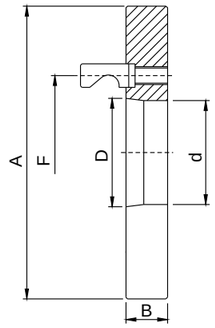

| Chuck Dia.* | Taper Size | A | B | Hole d | F | D | Spindle Mounting Bolts | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | N | QTY | | |
| 6-1/4" | A5 | 6.38 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 14.4 | SM-160/A5 |
| 8" | A4 | 7.99 | 0.98 | 2.40 | 3.252 | 2.5005 | 7/16-14 | 4 | 14.5 | SM-200/A4 |
| | A5 | 7.99 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 23.6 | SM-200/A5 |
| | A6 | 7.99 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 23.7 | SM-200/A6 |
| 10" | A5 | 9.96 | 1.57 | 1.57 | 4.126 | 3.2505 | 7/16-14 | 4 | 37.7 | SM-250/A5 |
| | A6 | 9.96 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 38.9 | SM-250/A6 |
| | A8 | 9.96 | 1.97 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 41.6 | SM-250/A8 |
| 12-1/2" | A6 | 12.52 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 4 | 63.6 | SM-315/A6 |
| | A8 | 12.52 | 2.16 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 4 | 64.4 | SM-315/A8 |
| | A11 | 12.52 | 2.56 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 83.2 | SM-315/A11 |
| 15-3/4" | A6 | 15.94 | 1.69 | 2.17 | 5.252 | 4.1880 | 1/2-13 | 6 | 105.7 | SM-400/A6 |
| | A8 | 15.94 | 1.93 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 116.5 | SM-400/A8 |
| | A11 | 15.94 | 2.95 | 4.06 | 9.252 | 7.7507 | 3/4-10 | 6 | 137 | SM-400/A11 |
| 20" | A8 | 19.88 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 193 | SM-500/A8 |
| | A11 | 19.88 | 2.68 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 206 | SM-500/A11 |
| | A15 | 19.88 | 2.68 | 5.35 | 13.000 | 11.2509 | 7/8-9 | 6 | 228 | SM-500/A15 |
| 25" | A8 | 25.00 | 2.01 | 3.13 | 6.748 | 5.5005 | 5/8-11 | 6 | 311 | SM-630/A8 |
| | A11 | 25.00 | 2.60 | 4.72 | 9.252 | 7.7507 | 3/4-10 | 6 | 391 | SM-630/A11 |
| | A15 | 25.00 | 2.52 | 7.48 | 13.000 | 11.2509 | 7/8-9 | 6 | 350 | SM-630/A15 |

*Please verify our adapter & your chuck mounting dimension before ordering.

# SM Series Semi-machined Adapter Plate

## Type D1 Semi-machined Adapters for PI Series chucks

Designed for direct mounting on CAMLOCK D1 spindle noses,
After machining can be used with scroll or independent chucks
Spindle side of each adapter is fully finished,
Provided with the set of Camlock studs, set screws & hex key.
All adapters are made of steel for longer life.




| Chuck Dia.* | Taper Size | A | B | Hole d | F | D | Camlock Stud | | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | OD | QTY | | |
| 5" | D1-3 | 5.00 | 1.024 | 1.5 | 2.78 | 2.1250 | 9/16" | 3 | 5.7 | SM-125/D3 |
| | D1-4 | 5.00 | 1.024 | 1.5 | 3.252 | 2.5005 | 5/8" | 3 | 5.5 | SM-125/D4 |
| 6-1/4" | D1-3 | 6.38 | 1.26 | 2.03 | 2.78 | 2.1250 | 9/16" | 3 | 11.7 | SM-160/D3 |
| | D1-4 | 6.38 | 1.26 | 2.03 | 3.252 | 2.5005 | 5/8" | 3 | 11.5 | SM-160/D4 |
| | D1-5 | 6.38 | 1.38 | 2.03 | 4.126 | 3.2505 | 3/4" | 6 | 12.1 | SM-160/D5 |
| 8" | D1-4 | 7.99 | 1.732 | 2.40 | 3.252 | 2.5005 | 5/8" | 3 | 25.6 | SM-200/D4 |
| | D1-5 | 7.99 | 1.97 | 2.40 | 4.126 | 3.2505 | 3/4" | 6 | 22.3 | SM-200/D5 |
| | D1-6 | 7.99 | 1.77 | 2.40 | 5.252 | 4.1880 | 7/8" | 6 | 24.3 | SM-200/D6 |
| 10" | D1-5 | 9.96 | 1.93 | 3.13 | 4.126 | 3.2505 | 3/4" | 6 | 32.6 | SM-250/D5 |
| | D1-6 | 9.96 | 1.93 | 3.13 | 5.252 | 4.1880 | 7/8" | 6 | 34.5 | SM-250/D6 |
| | D1-8 | 9.96 | 1.93 | 3.13 | 6.748 | 5.5005 | 1" | 6 | 40.4 | SM-250/D8 |
| 12-1/2" | D1-6 | 12.52 | 2.76 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 66 | SM-315/D6 |
| | D1-8 | 12.52 | 2.16 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 59.3 | SM-315/D8 |
| | D1-11 | 12.52 | 2.16 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 68.8 | SM-315/D11 |
| 15-3/4" | D1-6 | 15.94 | 1.65 | 4.06 | 5.252 | 4.1880 | 7/8" | 6 | 100 | SM-400/D6 |
| | D1-8 | 15.94 | 2.76 | 4.06 | 6.748 | 5.5005 | 1" | 6 | 116 | SM-400/D8 |
| | D1-11 | 15.94 | 1.97 | 4.06 | 9.252 | 7.7507 | 1-3/16" | 6 | 102 | SM-400/D11 |
| 20" | D1-8 | 19.88 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 165 | SM-500/D8 |
| | D1-11 | 19.88 | 2.83 | 5.36 | 9.252 | 7.7507 | 1-3/16" | 6 | 188 | SM-500/D11 |
| | D1-15 | 19.88 | 2.36 | 5.36 | 13.00 | 11.2509 | 1-3/8" | 6 | 173 | SM-500/D15 |
| 25" | D1-8 | 25.00 | 1.77 | 5.36 | 6.748 | 5.5007 | 1" | 6 | 269 | SM-630/D8 |
| | D1-11 | 25.00 | 2.83 | 7.79 | 9.252 | 7.7507 | 1-3/16" | 6 | 278 | SM-630/D11 |
| | D1-15 | 25.00 | 2.36 | 7.48 | 13.00 | 11.2509 | 1-3/8" | 6 | 270 | SM-630/D15 |

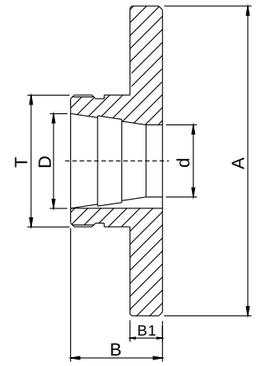
*Please verify our adapter & your chuck mounting dimension before ordering.



SM Series Semi-machined Adapter Plate

## Type L Semi-machined Adapters for PI Series chucks

Designed for direct mounting on long taper L spindle noses,
Can be used after machining for scroll or independent chucks,
Spindle side of each adapter is fully finished,
All adapters are made of steel for longer life.



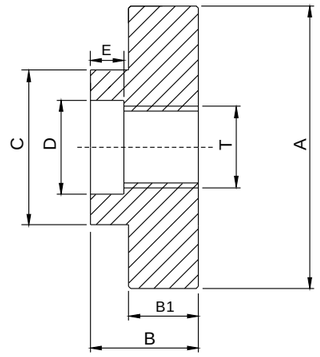

| Chuck Dia.* | A | Taper Size | Thread T - UNS3 | D | Thru Hole d | B1 | B | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 6-1/4" | 6.38 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.063 | 2.342 | 12.7 | SM-160/L00 |
| 6-1/4" | 6.38 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.063 | 2.736 | 15 | SM-160/L0 |
| 8" | 7.99 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.083 | 2.362 | 19.2 | SM-200/L00 |
| 8" | 7.99 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.083 | 2.756 | 21.5 | SM-200/L0 |
| 8" | 7.99 | L1 | 6 - 6 | 4.125 | 3.35 | 1.083 | 2.992 | 26.5 | SM-200/L1 |
| 10" | 9.96 | L00 | 3-3/4 - 6 | 2.750 | 2.20 | 1.338 | 2.618 | 35.2 | SM-250/L00 |
| 10" | 9.96 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.338 | 2.52 | 35.5 | SM-250/L0 |
| 10" | 9.96 | L1 | 6 - 6 | 4.125 | 3.35 | 1.338 | 3.307 | 42.4 | SM-250/L1 |
| 12-1/2" | 12.52 | L0 | 4-1/2 - 6 | 3.250 | 2.60 | 1.40 | 2.64 | 57.8 | SM-315/L0 |
| 12-1/2" | 12.52 | L1 | 6 - 6 | 4.125 | 3.35 | 1.40 | 3.11 | 62.7 | SM-315/L1 |
| 12-1/2" | 12.52 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.45 | 3.50 | 72.8 | SM-315/L2 |
| 15-3/4" | 15.94 | L1 | 6 - 6 | 4.125 | 3.35 | 1.50 | 3.23 | 103 | SM-400/L1 |
| 15-3/4" | 15.94 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 113 | SM-400/L2 |
| 15-3/4" | 15.94 | L3 | 10-3/8 - 4 | 6.500 | 5.43 | 1.50 | 4.18 | 139 | SM-400/L3 |
| 20" | 19.88 | L2 | 7-3/4 - 5 | 5.250 | 4.29 | 1.50 | 3.70 | 167 | SM-500/L2 |

*Please verify our adapter & your chuck mounting dimension before ordering.

# SM Series Semi-machined Adapter Plate

## Type Threaded Semi-machined Adapters for PI Series chucks

Designed for direct mounting on a threaded spindle noses,
Can be used after machining with scroll or independent chucks,
All adapters are made of steel for longer life.




| Chuck Dia.* | Thread T | A | D | E | C | B | B1 | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 4" | 1-10 UNS-2B | 4.09 | 1.0150 | 0.50 | 2.165 | 1.535 | 0.709 | 4.85 | SM-100/T1 |
| | 1-1/2 - 8 UN-2B | 4.09 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 5.29 | SM-100/T2 |
| 5" | 1-1/8 - 12 W | 5.08 | 1.2496 | 0.50 | 2.165 | 1.535 | 0.709 | 4.05 | SM-125/T3 |
| | 1-1/2 - 8 UN-2B | 5.08 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.709 | 6.61 | SM-125/T2 |
| | 2-3/16 - 10 Hardinge | 5.08 | 2.1889 | 0.626 | 3.11 | 1.772 | 0.709 | 7.05 | SM-125/T4 |
| | 2-1/4 - 8 UN-2B | 5.08 | 2.2600 | 0.626 | 3.18 | 1.83 | 0.709 | 6.80 | SM-125/T5 |
| 6-1/4" | 1-1/2 - 8 UN-2B | 6.535 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.787 | 7.05 | SM-160/T2 |
| | 2-3/16 - 10 Hardinge | 6.535 | 2.1889 | 0.50 | 3.11 | 1.85 | 0.787 | 7.50 | SM-160/T4 |
| | 2-1/4 - 8 UN-2B | 6.535 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.787 | 7.94 | SM-160/T5 |
| 8" | 1-1/2 - 8 UN-2B | 8.11 | 1.5150 | 0.50 | 2.68 | 1.535 | 0.866 | 9.92 | SM-200/T2 |
| | 2-1/4 - 8 UN-2B | 8.11 | 2.2600 | 0.626 | 3.18 | 1.79 | 0.866 | 11.46 | SM-200/T5 |
| | 2-3/8 - 6 UN-2B | 8.11 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.866 | 13.89 | SM-200/T6 |
| 10" | 2-3/8 - 6 UN-2B | 10.08 | 2.3850 | 0.626 | 4.33 | 2.047 | 0.984 | 30 | SM-250/T6 |
| 12-1/2" | 2-3/8 - 6 UN-2B | 12.64 | 2.3850 | 0.626 | 4.33 | 2.047 | 1.102 | 50 | SM-315/T6 |

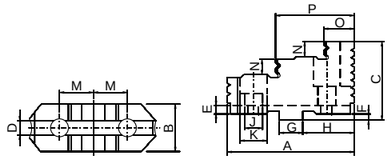
*Please verify our adapter & your chuck mounting dimension before ordering.



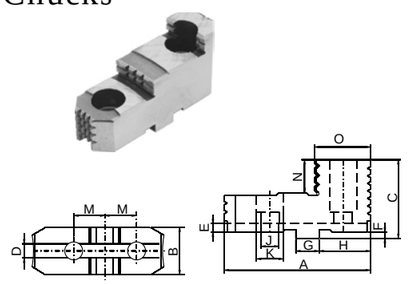
# Jaws - Hard Top Reversible Jaws

## Hard Top Jaws, For PI Series 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 96




■ 8" to 32" Diameter



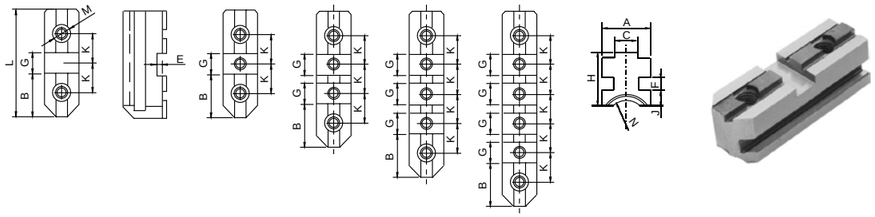

■ 40" to 50" Diameter

| Chuck Dia. | A | B | C | D | E | F | G | H | J | K | M | N | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8" | 3.2280 | 1.3386 | 1.7126 | .3130 | .1575 | .1260 | .4996 | 1.3858 | .4331 | .7087 | .8760 | .3740 | .8661 | 2.0866 | 1.65 | TJ-PI-200 |
| 10" | 3.7992 | 1.3386 | 2.0276 | .5004 | .1575 | .1260 | .7496 | 1.5748 | .5512 | .7874 | 1.0630 | .4724 | .9843 | 2.4409 | 2.25 | TJ-PI-250 |
| 12-1/2" | 4.4291 | 1.6535 | 2.1654 | .5004 | .1575 | .1260 | .7496 | 1.8858 | .5512 | .7874 | 1.2500 | .5118 | 1.0630 | 2.7756 | 3.40 | TJ-PI-315 |
| 15-3/4" | 5.0787 | 1.6535 | 2.5394 | .5004 | .1575 | .2480 | .7496 | 2.2598 | .7087 | 1.0236 | 1.5000 | .5315 | 1.0433 | 3.1102 | 4.50 | TJ-PI-400 |
| 20" | 5.3543 | 2.1260 | 2.9331 | .5004 | .1575 | .2480 | .7496 | 2.2835 | .8881 | 1.2992 | 1.5000 | .7087 | 1.4764 | 3.4252 | 7.00 | TJ-PI-500 |
| 25" | 5.3543 | 2.1260 | 3.2283 | .5004 | .1575 | .2480 | .7496 | 2.2835 | .8881 | 1.2992 | 1.5000 | .8268 | 1.4764 | 3.4252 | 7.60 | TJ-PI-630 |
| 31-1/2" | 5.3543 | 2.8346 | 3.4646 | .5004 | .1575 | .2480 | .7496 | 2.2835 | .8881 | 1.2992 | 1.5000 | .9449 | 1.5748 | 3.5039 | 11.0 | TJ-PI-800 |
| 40" | 6.2992 | 3.2283 | 4.0157 | .5004 | .1575 | .2480 | .7496 | 2.7748 | .8881 | 1.2992 | 1.5000 | 2.2441 | 3.1496 | - | 17.3 | TJ-PI-1000 |
| 50" | 6.2992 | 3.2283 | 4.0157 | .5004 | .1575 | .2480 | .7496 | 2.7748 | .8881 | 1.2992 | 1.5000 | 2.2441 | 3.1496 | - | 17.3 | TJ-PI-1250 |

# Jaws - Hard Master Jaws

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets



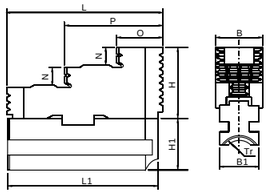

8" to 10" | 12" to 16" | 20" | 25" to 32" | 36" to 50"

| Chuck Dia. | A | B | G | E | F | C | H | J | K | L | M | N Thread | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8" | 1.0630 | 1.3071 | .4996 | .1575 | .3937 | .3125 | 1.2598 | .4528 | .8760 | 3.1102 | 3/8-16 | 24 x 4 sq. | 1.65 | MJ-PI-200 |
| 10" | 1.0630 | 1.4764 | .7496 | .1575 | .3937 | .5000 | 1.4961 | .4528 | 1.0630 | 3.7008 | 1/2-13 | 24 x 4 sq. | 2.25 | MJ-PI-250 |
| 12-1/2" | 1.5748 | 1.7874 | .7496 | .1575 | .4724 | .5000 | 1.5354 | .3819 | 1.2500 | 4.3307 | 1/2-13 | Tr32 x 6 | 3.40 | MJ-PI-315 |
| 15-3/4" | 1.5748 | 2.1614 | .7496 | .2835 | .4724 | .5000 | 1.7323 | .3819 | 1.5000 | 5.0787 | 5/8-11 | Tr32 x 6 | 4.50 | MJ-PI-400 |
| 20" | 2.0472 | 2.1850 | .7496 | .2835 | .5906 | .5000 | 2.3228 | .4606 | 1.5000 | 6.6142 | 3/4-10 | Tr36 x 6 | 7.00 | MJ-PI-500 |
| 25" | 2.0472 | 2.1850 | .7496 | .2835 | .7087 | .5000 | 2.3228 | .6181 | 1.5000 | 8.1102 | 3/4-10 | Tr40 x 6 | 7.60 | MJ-PI-630 |
| 31-1/2" | 2.7559 | 2.1850 | .7496 | .2835 | .7874 | .5000 | 2.3228 | .6181 | 1.5000 | 8.1102 | 3/4-10 | Tr44 x 8 | 11.0 | MJ-PI-800 |
| 40" | 3.1496 | 2.2732 | .7496 | .2835 | .9843 | .5000 | 3.1496 | .9843 | 1.5000 | 12.7953 | 3/4-10 | Tr55 x 8 | 17.3 | MJ-PI-1000 |
| 50" | 3.1496 | 2.2732 | .7496 | .2835 | .9843 | .5000 | 3.1496 | .9843 | 1.5000 | 12.7953 | 3/4-10 | Tr55 x 8 | 17.3 | MJ-PI-1250 |

# Jaws - Hard Two-Piece Reversible Jaws

## Hard Top and Master Jaw Set, For PI Series 4-Jaw Chucks

- Jaws are mounted and ground together Perfect as a replacement for PI chucks with solid or 2-pc Jaws.
- Sold in sets

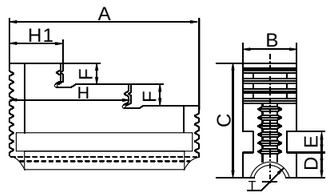


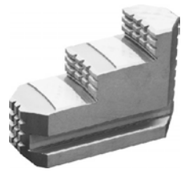

| Chuck Dia. | L | L1 | H | H1 | B | B1 | N | O | P | Tr | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 8" | 3.2280 | 3.1102 | 1.7126 | 1.2598 | 1.3386 | 1.0630 | .3740 | .8661 | 2.0866 | 24 x 4 sq. | RJA-PI-200 |
| 10" | 3.7992 | 3.7008 | 2.0276 | 1.4961 | 1.3386 | 1.0630 | .4724 | .9843 | 2.4409 | 24 x 4 sq. | RJA-PI-250 |
| 12-1/2" | 4.4291 | 4.3307 | 2.1654 | 1.5354 | 1.6535 | 1.5748 | .5118 | 1.0630 | 2.7756 | Tr32 x 6 | RJA-PI-315 |
| 15-3/4" | 5.0787 | 5.0787 | 2.5394 | 1.7323 | 1.6535 | 1.5748 | .5315 | 1.0433 | 3.1102 | Tr32 x 6 | RJA-PI-400 |
| 20" | 5.3543 | 6.6142 | 2.9331 | 2.3228 | 2.1260 | 2.0472 | .7087 | 1.4764 | 3.4252 | Tr36 x 6 | RJA-PI-500 |
| 25" | 5.3543 | 8.1102 | 3.2283 | 2.3228 | 2.1260 | 2.0472 | .8268 | 1.4764 | 3.4252 | Tr40 x 6 | RJA-PI-630 |
| 31-1/2" | 5.3543 | 8.1102 | 3.4646 | 2.3228 | 2.8346 | 2.7559 | .9449 | 1.5748 | 3.5039 | Tr44 x 8 | RJA-PI-800 |
| 40" | 6.2992 | 12.7953 | 4.0157 | 3.1496 | 3.2283 | 3.1496 | 2.2441 | 3.1496 | - | Tr55 x 8 | RJA-PI-1000 |
| 50" | 6.2992 | 12.7953 | 4.0157 | 3.1496 | 3.2283 | 3.1496 | 2.2441 | 3.1496 | - | Tr55 x 8 | RJA-PI-1250 |

# Jaws - Hard Solid Reversible Jaws

## Hard Solid Reversible Jaw Set, For PI Series 4-Jaw Chucks

- Hardened & Ground
- Designed for strong and rigid gripping
- Sold in sets
- Jaw clamping ranges see on page 96



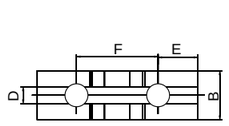
| Chuck Dia. | A | C | B | Thread T LH | E | D | H | H1 | F | Weight per jaw lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 3-1/4" | 1.2992 | 1.2992 | .5906 | 14 x 3 sq. | .3150 | .2362 | .8661 | .4724 | .2362 | .22 | RJ-PI-080 |
| 4" | 1.6535 | 1.6535 | .6299 | 16 x 3 sq. | .3150 | .2756 | 1.1024 | .5512 | .3150 | .33 | RJ-PI-100 |
| 5" | 2.0866 | 1.6535 | .7087 | 18 x 4 sq. | .3150 | .3150 | 1.4173 | .7087 | .3150 | .44 | RJ-PI-125 |
| 6-1/4" | 2.4213 | 2.0079 | .7874 | 22 x 4 sq. | .3937 | .3543 | 1.6142 | .7874 | .3937 | .77 | RJ-PI-160 |
| 8" | 3.3465 | 2.4213 | 1.0630 | 24 x 4 sq. | .3937 | .4528 | 2.2835 | 1.2009 | .4724 | 1.54 | RJ-PI-200 |
| 10" | 3.6220 | 2.4213 | 1.0630 | 24 x 4 sq. | .3937 | .4528 | 2.5787 | 1.2009 | .4724 | 1.65 | RJ-PI-250 |
| 12-1/2" | 4.3701 | 3.0118 | 1.5748 | Tr32 x 6 | .4724 | .3819 | 2.6380 | 1.0630 | .7097 | 3.31 | RJ-PI-315 |
| 15-3/4" | 5.0787 | 3.0118 | 1.5748 | Tr32 x 6 | .4724 | .3819 | 3.0906 | 1.2795 | .7097 | 3.97 | RJ-PI-400 |
| 20" | 6.0039 | 3.6811 | 2.0472 | Tr36 x 6 | .5906 | .4606 | 3.6614 | 1.3780 | .8661 | 7.5 | RJ-PI-500 |
| 25" | 6.9685 | 3.9567 | 2.0472 | Tr40 x 6 | .7087 | .6181 | 4.2913 | 1.7717 | .9843 | 8.8 | RJ-PI-630 |
| 31-1/2" | 7.9528 | 4.5079 | 2.7559 | Tr44 x 8 | .7874 | .6181 | 4.8031 | 1.7323 | .9843 | 18 | RJ-PI-800 |
| 40" | 9.4488 | 5.9055 | 3.1496 | Tr55 x 8 | .9843 | .9843 | 6.2992 | 2.5591 | 1.5748 | 28 | RJ-PI-1000 |
| 50" | 9.4488 | 5.9055 | 3.1496 | Tr55 x 8 | .9843 | .9843 | 6.2992 | 2.5591 | 1.5748 | 28 | RJ-PI-1250 |

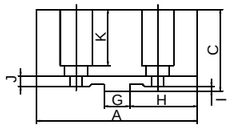


# Jaws - Soft Top Jaws

## Soft Top Jaw Set, For PI Series 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold by piece



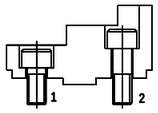



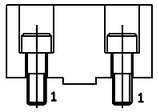
| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | K | Bolt Size | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .158 | 1.22 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .158 | 1.50 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .1260 | .158 | 1.57 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .158 | 1.79 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .158 | 2.20 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 25" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .158 | 2.52 | 3/4-10 | 9.26 | STJ-PS1-630 |
| 31-1/2" | 6.299 | 2.047 | 3.288 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .158 | 2.52 | 3/4-10 | 9.26 | STJ-PS1-630 |

# Jaw Mounting Bolts

- Sold by piece

| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.1 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 8" | 3/8-16 | MT-J1-8 | 0.79 | MT-J2-8 | 1.18 |
| 10" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 12-1/2" | 1/2-13 | MT-J1-12 | 1.00 | MT-J2-12 | 1.57 |
| 15-3/4" | 5/8-11 | MT-J1-16 | 1.18 | MT-J2-16 | 1.77 |
| 20" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.17 |
| 25" | 3/4-10 | MT-J1-25 | 1.57 | MT-J2-25 | 2.36 |
| 31-1/2" | 3/4-10 | MT-J1-32 | 1.57 | MT-J2-32 | 2.36 |
| 40" | 3/4-10 | MT-J1-40 | 1.97 | MT-J2-40 | 3.15 |
| 50" | 3/4-10 | MT-J1-50 | 1.97 | MT-J2-50 | 3.15 |

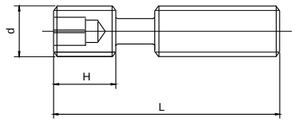



* Bolts are made in a Class B12.9

## Operating Screw

- Sold by piece




| Chuck Dia. | Thread Size d | H | L | Socket Square Size S | Part No. |
|---|---|---|---|---|---|
| 3-1/4" | 14 x 3 sq. | 0.650 | 1.142 | .236 | OS-PI-080 |
| 4" | 16 x 3 sq. | 0.770 | 1.476 | .276 | OS-PI-100 |
| 5" | 18 x 4 sq. | 0.866 | 1.811 | .276 | OS-PI-125 |
| 6-1/4" | 22 x 4 sq. | 0.770 | 2.205 | .394 | OS-PI-160 |
| 8" | 24 x 4 sq. | 0.965 | 2.756 | .394 | OS-PI-200 |
| 10" | 24 x 4 sq. | 0.984 | 3.345 | .394 | OS-PI-250 |
| 12-1/2" | Tr32 x 6 | 1.083 | 4.134 | .551 | OS-PI-315 |
| 15-3/4" | Tr32 x 6 | 1.673 | 5.315 | .551 | OS-PI-400 |
| 20" | Tr36 x 6 | 2.776 | 6.575 | .669 | OS-PI-500 |
| 25" | Tr40 x 6 | 3.346 | 8.740 | .669 | OS-PI-630 |
| 31-1/2" | Tr44 x 8 | 4.980 | 11.496 | .748 | OS-PI-800 |
| 40" | Tr55 x 8 | 6.358 | 14.488 | .866 | OS-PI-1000 |
| 50" | Tr55 x 8 | 6.555 | 18.701 | .866 | OS-PI-1250 |

## Thrust Bearing

- Sold by piece

| Chuck Dia. | OD | OAL | Part No. |
|---|---|---|---|
| 3-1/4" | 0.539 | 0.748 | TB-PI-080 |
| 4" | 0.630 | 1.083 | TB-PI-100 |
| 5" | 0.701 | 1.102 | TB-PI-125 |
| 6-1/4" | 0.866 | 1.417 | TB-PI-160 |
| 8" | 0.945 | 1.890 | TB-PI-200 |
| 10" | 0.945 | 2.126 | TB-PI-250 |
| 12-1/2" | 1.417 | 2.323 | TB-PI-315 |
| 15-3/4" | 1.417 | 2.520 | TB-PI-400 |
| 20" | 1.575 | 2.835 | TB-PI-500 |
| 25" | 1.772 | 3.307 | TB-PI-630 |
| 31-1/2" | 1.890 | 3.661 | TB-PI-800 |
| 40" | 2.165 | 3.386 | TB-PI-1000 |
| 50" | 2.165 | 3.898 | TB-PI-1250 |

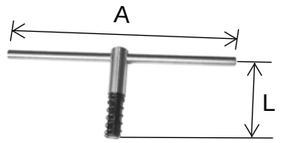
Note: After the installation every thrust bearing has to be secured with the set screw.

## Spring Loaded Chuck T-Wrench

- Sold by piece

| Chuck Dia. | L | A | Square Size mm | Square Size inch | Wrench Part No . |
|---|---|---|---|---|---|
| 3-1/4" | 2.56 | 3.54 | 6 | 0.236 | W-PI-080 |
| 4" | 2.76 | 4.33 | 7 | 0.276 | W-PI-100 |
| 5" | 3.94 | 5.51 | 7 | 0.276 | W-PI-125 |
| 6-1/4" | 3.94 | 5.91 | 10 | 0.394 | W-PI-160 |
| 8" | 4.72 | 8.46 | 10 | 0.394 | W-PI-200 |
| 10" | 4.72 | 8.46 | 10 | 0.394 | W-PI-250 |
| 12-1/2" | 6.50 | 12.20 | 14 | 0.551 | W-PI-315 |
| 15-3/4" | 6.50 | 12.20 | 14 | 0.551 | W-PI-400 |
| 20" | 9.06 | 17.72 | 17 | 0.669 | W-PI-500 |
| 25" | 9.06 | 17.72 | 17 | 0.669 | W-PI-630 |
| 31-1/2" | 9.84 | 19.69 | 19 | 0.748 | W-PI-800 |
| 40" | 10.43 | 19.69 | 22* | 0.866* | W-PI-1000 |
| 50" | 10.43 | 19.69 | 22* | 0.866* | W-PI-1250 |

* For Square Sockets




## Plain Back Chuck Mounting Bolts

- Sold by piece

| Chuck Dia. | Thread Size | L | Part No. |
|---|---|---|---|
| 3-1/4" | M6 | .6299 | MB-BI-080 |
| 4" | M8 | 2.1654 | MB-BI-100 |
| 5" | M8 | 2.1654 | MB-BI125 |
| 6-1/4" | M10 | 2.5591 | MB-BI-160 |
| 8" | M10 | 3.1496 | MB-BI-200 |
| 10" | M12 | 3.1496 | MB-BI-250 |
| 12-1/2" | M16 | 3.5433 | MB-BI-315 |
| 15-3/4" | M16 | 3.7402 | MB-BI-400 |
| 20" | M20 | 3.9370 | MB-BI-500 |
| 25" | M20 | 4.7244 | MB-BI-630 |
| 31-1/2" | M20 | 5.9055 | MB-BI800 |
| 40" | M20 | 6.2992 | MB-BI-1000 |
| 50" | M24 | 6.6929 | MB-BI-1250 |

* Bolts are made in a Class B12.9

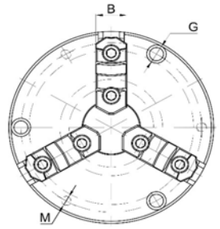
# Front Mounting

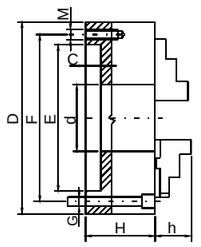
## PO & PS Series Front Mounting Scroll Chucks
## 3-Jaw & 4-Jaw , Plain Back,
## with Semi-Steel & Forged Steel Body

Gator Front Mounting Chucks are designed for use on T-Slot rotary tables, CNC indexers, lathe spindle noses, milling machine tables and other devices were back mounting chucks cannot be used. They can be mounted on 3/6 & 4/8 T-Slot rotary tables and indexers. Fully finished steel Base Plates are available for 5" thru 20" chucks

# Front Mounting Scroll Chucks

3 & 4-Jaw Medium Duty, Plain Back,
Front Mounting Scroll Chucks
with Semi-Steel Body & Forged Steel Body



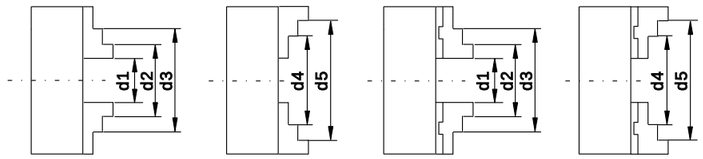



## Principal Dimensions

| Chuck Dia.D | F | E | d | C | H | | Top Jaws B | Solid Jaws B | 2 Pc. Jaws h | Solid Jaws h | Mounting Bolts | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | PS Semi-Steel | PO Forged Steel | | | | | Thread G | QTY. | Thread M | QTY. |
| 3-1/4" | 2.6378 | 2.2047 | 0.6299 | .1181 | 1.732 | 1.732 | - | .4331 | - | 0.512 | 1/4"-20 | 3 | M6 x 1 | 3 |
| 4" | 3.2677 | 2.7599 | 0.7874 | .1181 | 1.969 | 1.969 | - | .5906 | - | 0.669 | 5/16"-18 | 3 | M8 x 1.25 | 3 |
| 5" | 4.2520 | 3.7402 | 1.2598 | .1575 | 2.205 | 2.343 | .866 | .7874 | 1.575 | 0.787 | 5/16"-18 | 3 | M8 x 1.25 | 3 |
| 6-1/4" | 5.5118 | 4.9213 | 1.6535 | .1575 | 2.559 | 2.677 | .984 | .7874 | 1.693 | 1.260 | 3/8"-16 | 3 | M10 x 1.5 | 3 |
| 8" | 6.9291 | 6.2992 | 2.1654 | .1575 | 2.953 | 3.071 | 1.181 | .9843 | 1.772 | 1.142 | 3/8"-16 | 3 | M10 x 1.5 | 3 |
| 10" | 8.8189 | 7.8740 | 2.9921 | .1969 | 3.347 | 3.504 | 1.417 | 1.1024 | 2.087 | 1.339 | 1/2"-13 | 3 | M12 x 1.75 | 3 |
| 12-1/2" | 11.2598 | 10.2362 | 4.0551 | .1969 | 3.701 | 3.787 | 1.654 | 1.2598 | 2.244 | 1.693 | 5/8"-11 | 3 | M16 x 2 | 3 |
| 15-3/4" | 14.2519 | 12.9921 | 5.3545 | .1969 | 4.134 | 4.252 | 1.770 | 1.4173 | 2.639 | 2.165 | 5/8"-11 | 3 | M16 x 2 | 3 |
| 20" | 18.0314 | 16.5354 | 7.4803 | .1969 | 4.724 | 4.685 | 1.978 | 1.5748 | 3.504 | 2.205 | 3/4"-10 | 3 | M16 x 2 | 3 |

## Clamping Ranges

- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.




| Chuck Dia. D | | d1 | | d2 | | d3 max. | | d4 max. | | d5 max. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | JAWS | | | | | | | | | |
| mm | Inch | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible | Solid | Reversible |
| 80 | 3-1/4 | .08-1.06 | - | .87-1.81 | - | 1.77-2.72 | - | .98-1.97 | - | 1.89-2.80 | - |
| 100 | 4 | .12-1.30 | - | .98-2.20 | - | 2.20-3.43 | - | 1.26-2.44 | - | 2.44-3.27 | - |
| 125 | 5 | .12-1.97 | .12-1.97 | 1.37-2.91 | 1.34-2.99 | 2.83-4.53 | 2.95-4.65 | 1.54-3.27 | 2.05-3.78 | 3.15-4.92 | 3.74-4.92 |
| 160 | 6-1/4 | .12-2.52 | .12-2.52 | 1.65-3.94 | 1.65-3.82 | 3.70-6.06 | 3.46-5.75 | 1.97-4.21 | 2.44-4.76 | 3.86-6.30 | 4.53-6.30 |
| 200 | 8 | .16-3.54 | .16-3.54 | 2.05-5.31 | 1.97-5.12 | 4.72-7.95 | 4.13-7.48 | 2.36-5.71 | 2.83-6.14 | 5.12-7.87 | 5.24-7.87 |
| 250 | 10 | .20-4.65 | .20-4.65 | 2.44-6.85 | 2.28-6.50 | 5.70-10.43 | 4.92-9.25 | 3.03-7.40 | 3.38-7.75 | 6.30-9.84 | 6.30-9.84 |
| 315 | 12-1/2 | .39-5.16 | .20-5.16 | 3.07-7.87 | 2.56-7.16 | 6.77-11.77 | 5.70-10.43 | 3.54-8.46 | 4.06-8.90 | 7.48-12.40 | 7.48-12.40 |
| 400 | 15-3/4 | .39-7.09 | .39-7.09 | 3.35-9.92 | 2.83-8.98 | 8.27-14.96 | 6.50-12.95 | 4.05-10.71 | 5.00-11.57 | 9.05-15.75 | 9.05-15.75 |
| 500 | 20 | .79-9.25 | .79-9.25 | 4.72-13.19 | 4.72-16.14 | 9.65-18.74 | 7.87-19.10 | 5.51-14.06 | 4.33-15.75 | 10.87-19.69 | 7.48-19.69 |

## PS3 Series Semi-Steel Body Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

Semi- Steel Body

**Each chuck is provided with:**

- 1 Set of hard solid ID jaws
- 1 Set of hard solid OD jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- 3 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | ID-Hard Solid Jaws | OD - Hard Solid Jaws | Soft Solid Jaws | Base Plate Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 3" | 0.6299 | 0.7087 | 4000 | 3.3 | PS3-3"(F) | 1-202-0301 | OJ-PS3-80 | IJ-PS3-80 | SJ-PS3-80 | - |
| 4" | 0.7874 | 0.9055 | 3500 | 6.2 | PS3-4"(F) | 1-202-0401 | OJ-PS3-100 | IJ-PS3-100 | SJ-PS3-100 | - |
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS3-5"(F) | 1-202-0501 | OJ-PS3-125 | IJ-PS3-125 | SJ-PS3-125 | BPD-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS3-6"(F) | 1-202-0601 | OJ-PS3-160 | IJ-PS3-160 | SJ-PS3-160 | BPD-160 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS3-8"(F) | 1-202-0801 | OJ-PS3-200 | IJ-PS3-200 | SJ-PS3-200 | BPD-200 |

For Spare Parts See Page 124

## PS3 Series Semi-Steel Body Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

Semi- Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Base Plate Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS3-5"A(F) | 1-201-0501 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | BPD-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS3-6"A(F) | 1-201-0601 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | BPD-160 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS3-8"A(F) | 1-201-0801 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | BPD-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS3-10"A(F) | 1-201-1001 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | BPD-250 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS3-12"A(F) | 1-201-1201 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | BPD-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS3-16"A(F) | 1-201-1601 | TJ-PS3-400 | MJ-PS3-400 | STJ-PS3-400 | BPD-400 |
| 20" | 7.4803 | 8.3465 | 700 | 320 | PS3-20"A(F) | 1-201-2001 | TJ-PS3-500 | MJ-PS3-500 | STJ-PS3-500 | BPD-500 |

For Spare Parts See Page 124





## PS4 Series Semi-Steel Body Scroll Chucks with Two Sets of Hard Solid Jaws, Plain Back

Semi- Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 2 pinion design
- Lathe Chuck Manual

| Chuck Dia. | Hole | Max.Hole Permissible Enlargements | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Base Plate Part No. |
|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 1.3456 | 3200 | 11 | PS4-5"A(F) | 1-203-0501 | TJ-PS4-125 | MJ-PS4-125 | STJ-PS4-125 | BPD-125 |
| 6-1/4" | 1.6535 | 1.9252 | 3000 | 22 | PS4-6"A(F) | 1-203-0601 | TJ-PS4-160 | MJ-PS4-160 | STJ-PS4-160 | BPD-160 |
| 8" | 2.1654 | 2.8189 | 2500 | 39 | PS4-8"A(F) | 1-203-0801 | TJ-PS4-200 | MJ-PS4-200 | STJ-PS4-200 | BPD-200 |
| 10" | 2.9921 | 3.5827 | 2000 | 55 | PS4-10"A(F) | 1-203-1001 | TJ-PS4-250 | MJ-PS4-250 | STJ-PS4-250 | BPD-250 |
| 12-1/2" | 4.0551 | 4.4094 | 1500 | 110 | PS4-12"A(F) | 1-203-1201 | TJ-PS4-315 | MJ-PS4-315 | STJ-PS4-315 | BPD-315 |
| 15-3/4" | 5.3543 | 5.7480 | 1000 | 187 | PS4-16"A(F) | 1-203-1601 | TJ-PS4-400 | MJ-PS4-400 | STJ-PS4-400 | BPD-400 |

For Spare Parts See Page 124

## PO3 Series Forged Steel Body Scroll Chucks with Two-Piece Hard Reversible Jaws, Plain Back

Forged Steel Body

**Each chuck is provided with:**

- 1 Set of hard master jaws
- 1 Set of hard top reversible jaws
- 1 Set of adapter mounting bolts
- 1 Spring loaded chuck T - wrench
- 2 Hex keys
- Eye bolts for chucks 10" and larger
- 3 pinion design
- Lathe Chuck Manual

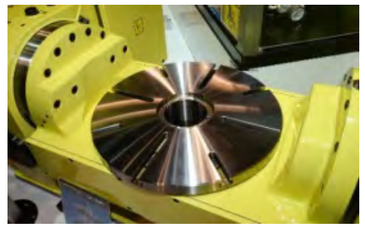
| Chuck Dia. | Hole | RPM Max | Weight lbs. | Chuck Model | Chuck Part No. | Hard Top Jaws | Hard Master Jaws | Soft Top Jaws | Base Plate Part No. |
|---|---|---|---|---|---|---|---|---|---|
| 5" | 1.2598 | 4800 | 11 | PO3-5"A(F) | 1-105-0501 | TJ-PS3-125 | MJ-PS3-125 | STJ-PS3-125 | BPD-125 |
| 6-1/4" | 1.6535 | 4500 | 22 | PO3-6"A(F) | 1-105-0601 | TJ-PS3-160 | MJ-PS3-160 | STJ-PS3-160 | BPD-160 |
| 8" | 2.1654 | 4000 | 39 | PO3-8"A(F) | 1-105-0801 | TJ-PS3-200 | MJ-PS3-200 | STJ-PS3-200 | BPD-200 |
| 10" | 2.9921 | 3500 | 55 | PO3-10"A(F) | 1-105-1001 | TJ-PS3-250 | MJ-PS3-250 | STJ-PS3-250 | BPD-250 |
| 12-1/2" | 4.0551 | 2800 | 110 | PO3-12"A(F) | 1-105-1201 | TJ-PS3-315 | MJ-PS3-315 | STJ-PS3-315 | BPD-315 |

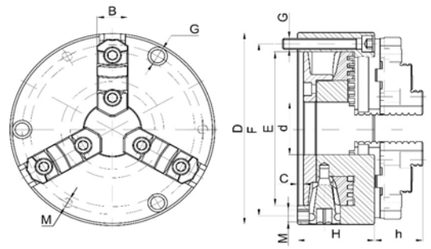
For Spare Parts See Page 124

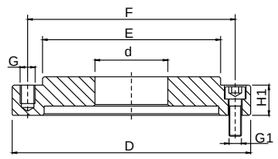
# BPD Series Base Plate

## BPD Base Plate
## for PO Series & PS Series 3 & 4 Jaw Plain Back Front Mount Scroll Chucks

Designed for use with 3 & 4 jaw scroll front mount plain back chucks
Ideal for use on a CNC or manual rotary tables and indexers with the 3, 4, 6 and 8 T-Slots
Base plates are provided with mounting bolts with T-Nuts and hex key.
All base plates are made of steel for longer life.
Full front mount chuck specification see on the Page xxx.

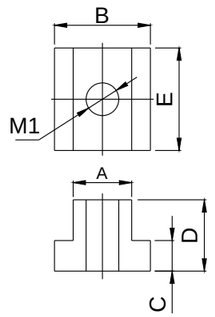




| Chuck Dia. | D | E | F | d | H1 | Chuck Mounting Bolts | | Base Plate Mounting Bolts | | H | | h 2-Pc Jaws | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | G (UNC) | No . Of Bolts | G1 | No . Of Bolts | PS | PO | | |
| 5" | 4.921 | 3.740 | 4.252 | 1.875 | 0.551 | 5/16"-18 | 3 | M6 | 4 | 2.205 | 2.422 | 1.575 | BPD-125 |
| 6-1/4" | 6.299 | 4.921 | 5.512 | 1.850 | 0.636 | 3/8"-16 | 3 | M8 | 4 | 2.539 | 2.756 | 1.693 | BPD-160 |
| 8" | 7.874 | 6.299 | 6.929 | 2.362 | 0.709 | 3/8"-16 | 3 | M8 | 4 | 2.953 | 3.150 | 1.772 | BPD-200 |
| 10" | 9.843 | 7.874 | 8.819 | 3.189 | 0.787 | 1/2"-13 | 3 | M10 | 4 | 3.347 | 3.543 | 2.087 | BPD-250 |
| 12-1/2" | 12.402 | 10.236 | 11.260 | 4.252 | 0.984 | 5/8"-11 | 3 | M10 | 4 | 3.701 | 3.937 | 2.244 | BPD-315 |
| 15-3/4" | 15.748 | 12.992 | 14.252 | 5.551 | 1.063 | 5/8"-11 | 3 | M12 | 4 | 4.134 | 4.331 | 2.693 | BPD-400 |
| 20" | 19.685 | 16.535 | 18.031 | 7.677 | 1.181 | 3/4"-10 | 3 | M16 | 4 | 4.527 | 4.685 | 3.150 | BPD-500 |

| Chuck Dia. | M1 | A | B | C | D | E |
|---|---|---|---|---|---|---|
| 5" | M6 | .3150 | .5118 | .1969 | .3543 | .5118 |
| 6-1/4" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 8" | M8 | .3937 | .5906 | .2362 | .4724 | .5906 |
| 10" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 12-1/2" | M10 | .4724 | .7087 | .2756 | .5512 | .7087 |
| 15-3/4" | M12 | .5512 | .8661 | .3150 | .6299 | .8661 |
| 20" | M16 | .7087 | 1.1024 | .3937 | .7874 | 1.1024 |



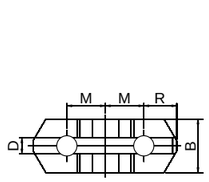


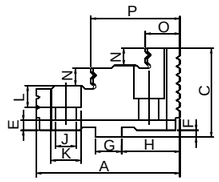



# Jaws - Hard Top Jaws

## Hard Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



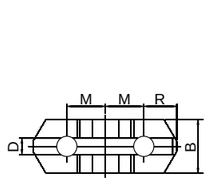
5" to 12-1/2"

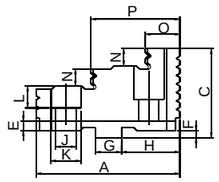
15-3/4" & up

| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS3-1000 |

## Hard Top Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 4



5" to 12-1/2"

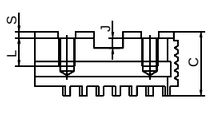
15-3/4" & up

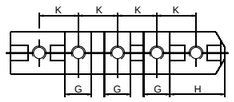
| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | .35 | .59 | .3129 | .157 | .126 | .315 | 1.516 | .866 | 2.205 | .571 | 1.38 | 0.93 | TJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .335 | 1.634 | .984 | 2.638 | .807 | 1.69 | 1.20 | TJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | .43 | .71 | .3129 | .157 | .126 | .413 | 1.772 | 1.181 | 3.347 | .984 | 2.09 | 2.10 | TJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | .55 | .78 | .5004 | .157 | .126 | .531 | 2.087 | 1.417 | 3.740 | 1.14 | 2.52 | 3.20 | TJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | .55 | .78 | .5004 | .157 | .126 | .689 | 2.283 | 1.654 | 4.252 | 1.22 | 3.01 | 5.10 | TJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | .157 | .248 | .689 | 2.756 | 1.772 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 1.654 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS4-500 |
| 25"&32" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS4-630 |
| 40"&50" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | .157 | .248 | .984 | 4.331 | 3.346 | 8.268 | 1.99 | 3.33 | 66.0 | TJ-PS4-1000 |

# Jaws - Hard Master Jaws

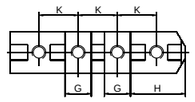
## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

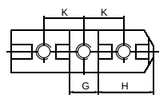




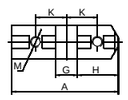

■ 25" to 32" Diameter




■ 20" Diameter




■ 12" to 16" Diameter

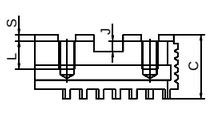


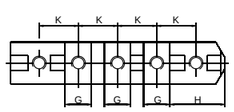

■ 5" to 10" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-8 | 0.93 | MJ-PS3-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS3-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS3-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS3-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS3-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS3-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS3-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS3-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS3-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS3-1250 |

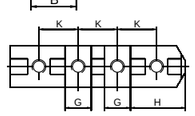
## Hard Master Jaws, For 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold in sets

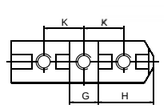




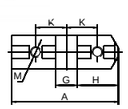

■ 25" to 32" Diameter




■ 20" Diameter




■ 12" to 16" Diameter




■ 5" to 10" Diameter

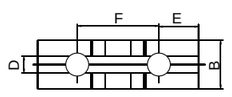
| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | C | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 5/8 | 57/64 | .4996 | 5/16 | .1575 | .1260 | .4724 | .3150 | .3150 | .7874 | 1.1024 | 2.1259 | 5/16-8 | 0.93 | MJ-PS4-125 |
| 6-1/4" | 3 /4 | 1-1/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3150 | .3150 | .7874 | 1.1416 | 2.5590 | 3/8-16 | 1.20 | MJ-PS4-160 |
| 8" | 7/8 | 1-3/8 | .4996 | 5/16 | .1575 | .1260 | .5511 | .3543 | .3937 | .9843 | 1.2992 | 3.1102 | 3/8-16 | 2.10 | MJ-PS4-200 |
| 10" | 1-1/16 | 1-9/16 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .4331 | .4724 | 1.1024 | 1.4173 | 3.6220 | 1/2-13 | 3.20 | MJ-PS4-250 |
| 12-1/2" | 1-1/4 | 1-7/8 | .7496 | 1 /2 | .1575 | .1260 | .6299 | .5000 | .4724 | 1.2598 | 1.5748 | 4.3307 | 1/2-13 | 5.10 | MJ-PS4-315 |
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | .8661 | .5906 | .5512 | 1.4173 | 1.9291 | 5.1181 | 5/8-11 | 7.30 | MJ-PS4-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.5748 | 2.1259 | 6.5351 | 3/4-10 | 14.4 | MJ-PS4-500 |
| 25" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.2677 | 3/4-10 | 27.1 | MJ-PS4-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 2.1457 | 8.8583 | 3/4-10 | 27.1 | MJ-PS4-800 |
| 40" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 12.593 | 3/4-10 | 105 | MJ-PS4-1000 |
| 50" | 1-1/2 | 2-1/4 | .7496 | 1 /2 | .2835 | .1260 | 1.5748 | .9843 | .9843 | 3.1496 | 3.0315 | 14.448 | 3/4-10 | 116 | MJ-PS4-1250 |

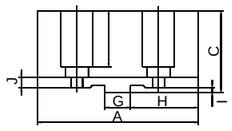


# Jaws - Soft Top Jaws

## Soft Top Jaws, For 3-Jaw & 4-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold by piece



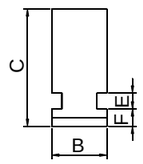



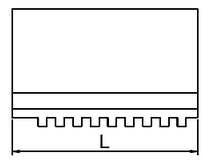
| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5" | 2.520 | 0.866 | 1.520 | .3129 | 0.5910 | 1-1/4 | .500 | 1.000 | .1260 | .283 | 5/16-18 | 0.66 | STJ-PS1-125 |
| 6-1/4" | 3.071 | 1.000 | 1.634 | .3129 | 0.8386 | 1-1/2 | .500 | 1.339 | .1260 | .283 | 3/8-16 | 1.01 | STJ-PS1-160 |
| 8" | 3.543 | 1.063 | 1.713 | .3129 | 0.9488 | 1-3/4 | .500 | 1.575 | .1260 | .283 | 3/8-16 | 1.43 | STJ-PS1-200 |
| 10" | 4.173 | 1.280 | 2.028 | .5000 | 1.0827 | 2-1/8 | .750 | 1.772 | .1260 | .283 | 1/2-13 | 2.54 | STJ-PS1-250 |
| 12-1/2" | 4.724 | 1.575 | 2.165 | .5000 | 1.2087 | 2-1/2 | .750 | 2.087 | .2480 | .283 | 1/2-13 | 3.53 | STJ-PS1-315 |
| 15-3/4" | 5.512 | 1.654 | 2.539 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .5000 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 3/4-10 | 5.29 | STJ-PS1-500 |

# Jaws - Soft Solid Jaws

## Soft Solid Jaws, For 3-Jaw Chucks

- Sold in sets



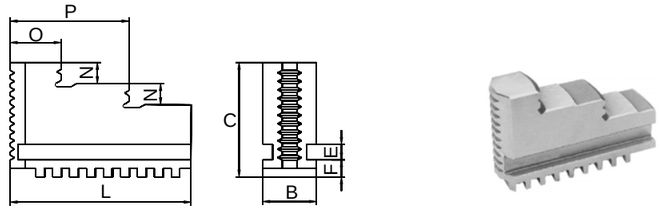



| Chuck Dia. | C | L | B | F | E | Wt./pc. Lbs. | Part No. | |
|---|---|---|---|---|---|---|---|---|
| | | | | | | | 3-Jaw | 4-Jaw |
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .19 | SJ-PS3-100 | SJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .40 | SJ-PS3-125 | SJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .80 | SJ-PS3-160 | SJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | 1.07 | SJ-PS3-200 | SJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | 1.73 | SJ-PS3-250 | SJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | 2.90 | SJ-PS3-315 | SJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | 5.20 | SJ-PS3-400 | SJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 7.33 | SJ-PS3-500 | SJ-PS4-500 |

# Jaws - ID Jaws

## ID Hard Solid Jaws, For 3-Jaw Chucks

- Sold in sets



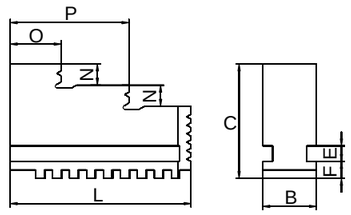


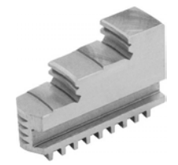

| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | 3-Jaw | 4-Jaw |
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | OJ-PS3-100 | OJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | OJ-PS3-125 | OJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | OJ-PS3-160 | OJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | OJ-PS3-200 | OJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | OJ-PS3-250 | OJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | OJ-PS3-315 | OJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | OJ-PS3-400 | OJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | OJ-PS3-500 | OJ-PS4-500 |

# Jaws - OD Jaws

## OD Hard Solid Jaws, For 4-Jaw Chucks

- Sold in sets



| Chuck Dia. | C | L | B | F | E | N | P | O | Wt./pc. Lbs. | Part No. | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | 3-Jaw | 4-Jaw |
| 4" | 1.2598 | 1.6535 | .5906 | .2362 | .2362 | .2756 | 1.063 | .433 | .19 | IJ-PS3-100 | IJ-PS4-100 |
| 5" | 1.5748 | 2.0079 | .7874 | .3150 | .3150 | .3150 | 1.313 | .512 | .40 | IJ-PS3-125 | IJ-PS4-125 |
| 6-1/4" | 2.0866 | 2.7559 | .7874 | .3150 | .3150 | .3937 | 1.772 | .748 | .80 | IJ-PS3-160 | IJ-PS4-160 |
| 8" | 2.1260 | 3.3459 | .9843 | .3543 | .3937 | .4724 | 2.244 | .906 | 1.07 | IJ-PS3-200 | IJ-PS4-200 |
| 10" | 2.4803 | 4.1339 | 1.1024 | .4331 | .4724 | .5512 | 2.736 | 1.102 | 1.73 | IJ-PS3-250 | IJ-PS4-250 |
| 12-1/2" | 2.9528 | 4.9213 | 1.2598 | .5000 | .4724 | .7087 | 3.268 | 1.358 | 2.90 | IJ-PS3-315 | IJ-PS4-315 |
| 15-3/4" | 3.6220 | 5.7087 | 1.4173 | .5906 | .5512 | .8661 | 3.898 | 1.417 | 5.20 | IJ-PS3-400 | IJ-PS4-400 |
| 20" | 3.9370 | 7.0866 | 1.5748 | .6299 | .5512 | 1.0236 | 4.705 | 1.969 | 7.33 | IJ-PS3-500 | IJ-PS4-500 |





## Scroll Plates

- Sold by piece

| Chuck Dia. | Part No. | OD |
|---|---|---|
| 3" | SC-PS-080 | 2.1575 |
| 4" | SC-PS-100 | 2.7323 |
| 5" | SC-PS-125 | 3.7008 |
| 6-1/4" | SC-PS-160 | 4.8819 |
| 8" | SC-PS-200 | 6.2598 |
| 10" | SC-PS-250 | 7.7953 |
| 12-1/2" | SC-PS-315 | 10.1575 |
| 15-3/4" | SC-PS-400 | 12.9134 |
| 20" | SC-PS-500 | 16.4173 |
| 25" | SC-PS-630 | 21.3386 |
| 31-1/2" | SC-PS-800 | 27.4106 |

## Pinions

- Sold by piece

| Chuck Dia. | OD | Part No. | |
|---|---|---|---|
| | | PO | PS |
| 3" | .7480 | PI-PS-080 | PI-PS-080 |
| 4" | .9843 | PI-PS-100 | PI-PS-100 |
| 5" | .9843 | PI-PO-125 | PI-PS-125 |
| 6-1/4" | 1.1024 | PI-PO-160 | PI-PS-160 |
| 8" | 1.1811 | PI-PO-200 | PI-PS-200 |
| 10" | 1.3583 | PI-PO-250 | PI-PS-250 |
| 12-1/2" | 1.4764 | PI-PO-315 | PI-PS-315 |
| 15-3/4" | 1.7323 | PI-PO-400 | PI-PS-400 |
| 20" | 1.9685 | PI-PO-500 | PI-PS-500 |
| 25" | 2.0472 | PI-PO-630 | PI-PS-630 |
| 31-1/2" | 2.0472 | PI-PO-800 | PI-PS-800 |

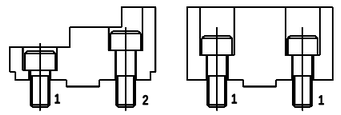
## Pinion Sleeves & Screw

- Sold by piece

| Chuck Dia. | Part No. | |
|---|---|---|
| | Pinion Sleeve | Pinion Screw |
| 3" | - | PH-P-080 |
| 4" | - | PH-P-100 |
| 5" | PS-P-125 | PH-P-125 |
| 6-1/4" | PS-P-160 | PH-P-160 |
| 8" | PS-P-200 | PH-P-200 |
| 10" | PS-P-250 | PH-P-250 |
| 12-1/2" | PS-P-315 | PH-P-315 |
| 15-3/4" | PS-P-400 | PH-P-400 |
| 20" | PS-P-500 | PH-P-500 |
| 25" | PS-P-630 | PH-P-630 |
| 31-1/2" | PS-P-800 | PH-P-800 |

## Jaw Mounting Bolts

- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 5" | 5/16-18 | MT-J1-5 | 0.79 | MT-J2-5 | 1.00 |
| 6-1/4" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 8" | 3/8-16 | MT-J1-6 | 0.79 | MT-J2-6 | 1.18 |
| 10" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 12-1/2" | 1/2-13 | MT-J1-10 | 1.00 | MT-J2-10 | 1.57 |
| 15-3/4" | 5/8-11 | MT-J1-16 | 1.00 | MT-J2-16 | 1.57 |
| 20" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 25" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 31-1/2" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |

## Half Ring

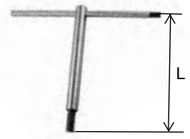
- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 3" | - |
| 4" | - |
| 5" | HR-P-125 |
| 6-1/4" | HR-P-160 |
| 8" | HR-P-200 |
| 10" | HR-P-250 |
| 12-1/2" | HR-P-315 |
| 15-3/4" | HR-P-400 |
| 20" | HR-P-500 |
| 25" | HR-P-630 |
| 31-1/2" | HR-P-800 |

## Wrenches (Standard & Extended)

- Sold by piece

Standard Wrench

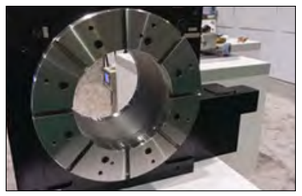
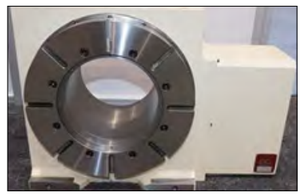



Extended Wrench

| Chuck Dia. | Square Size | Standard | | Extended | |
|---|---|---|---|---|---|
| | | L | Part No. | L | Part No. |
| 3" | .2344 | 2.36 | W-P-080 | - | - |
| 4" | .3543 | 3.15 | W-P-100 | - | - |
| 5" | .3543 | 3.15 | W-P-125 | - | - |
| 6-1/4" | .4331 | 3.90 | W-P-160 | 7.87 | W-SP-160 |
| 8" | .4331 | 3.90 | W-P-200 | 10.02 | W-SP-200 |
| 10" | .5512 | 4.78 | W-P-250 | 8.74 | W-SP-250 |
| 12-1/2" | .5512 | 4.76 | W-P-315 | 10.87 | W-SP-315 |
| 15-3/4" | .6693 | 5.51 | W-P-400 | 10.75 | W-SP-400 |
| 20" | .7480 | 9.06 | W-P-500 | 18.11 | W-SP-500 |
| 25" | .7480 | 9.06 | W-P-630 | - | - |
| 31-1/2" | .7480 | 9.06 | W-P-800 | - | - |

# PSL SERIES

## Medium Duty Forged Steel Body 3-Jaw Self-Centering Scroll Chucks Extra Large Thru Hole



# PSL Series Steel Body Large Thru Hole Chucks

Medium Duty
Forged Steel Body 3-Jaw Self-Centering Scroll Chucks.
Plain Back with Large Thru Hole

*Forged Steel, Medium Duty Body
*Large thru-holes
*American Standard two-piece tongue & groove jaws
*High Gripping Accuracy
*All chuck body & jaw working surfaces are hardened and ground
*Chucks can be installed on the lathes individually or in pairs
*All chucks are balanced
*ANSI, DIN & ISO Standards
*Perfect for pipe machining, welding operations or special applications
*Can be mounted on Lathes, VTL's and different kind of Indexers and welding fixtures
*Front mounting option is available on request

## Features and Benefits

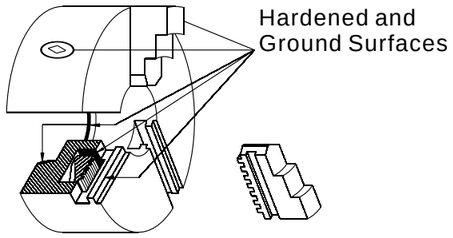
- **Chuck Body**
  *Forged Steel Body Construction
  *One piece body construction for 15-3/4", 20" & 26"
  *Two piece body construction for 31-1/2" & UP
  *All working surfaces are induction hardened and precisely ground.
  *Each chuck is balanced within fine limits for longer life
  *3 Pinion Design

- **Jaws**
  Made of high alloy steel,
  American Standard Tongue & Groove 2-Pc Jaws.
  Jaw teeth and guideways are hardened and fully ground on both sides.

- **Scroll Plate**
  *Drop forged of high quality alloy steel and hardened.
  *Thread flanks are ground on both sides.
  *Each scroll is individually balanced for chuck longer life and higher accuracy.

- **Pinions**
  *Hardened and ground.
  *Each pinion is inserted in a steel special bushing to secure precision engagement with the scroll and protect chuck body against worn out.

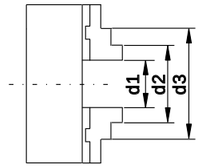
- **Bushings**
  Made of high grade alloy steel.
  Hardened and ground.
  Each bushing is pressed into pinion seat extending chuck life time.

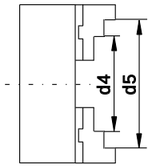


# Clamping Ranges

## PSL Series 3 -Jaw Large Thru Hole Scroll Chucks

- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.



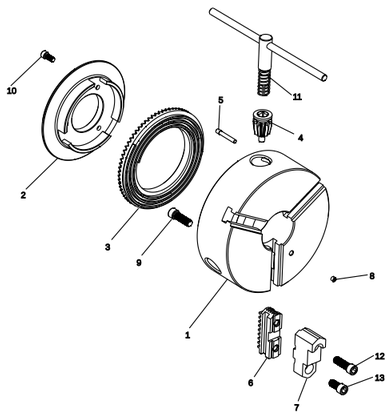



| Chuck Dia. D | | d1 | | d2 | | d3 | | d4 | | d5 | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| mm | Inch | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. | Min. | Max. |
| 400 | 15-3/4 | 5.12 | 10.36 | 9.06 | 13.78 | 11.81 | 15.75 | 8.86 | 13.39 | 11.81 | 15.75 |
| 500 | 20 | 9.84 | 14.96 | 12.99 | 17.72 | 15.16 | 19.69 | 12.52 | 17.72 | 14.96 | 19.69 |
| 630 | 25 | 14.80 | 18.50 | 17.91 | 22.64 | 20.28 | 25.00 | 18.11 | 23.62 | 19.69 | 25.00 |
| 800 | 31-1/2 | 10.24 | 22.28 | 14.17 | 29.53 | 16.54 | 31.50 | 13.78 | 29.53 | 16.93 | 31.50 |

# Chuck Part Listing

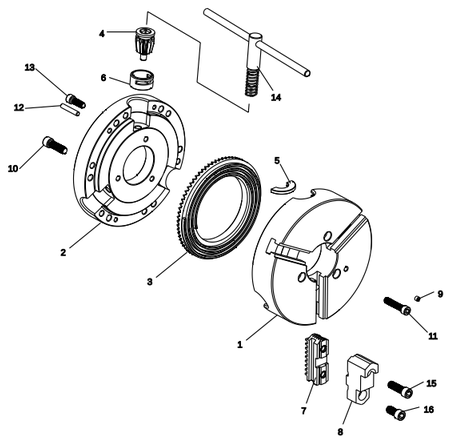
### 15-3/4", 20" & 26"
### One piece body construction

1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Screw
6. Hard Master Jaws
7. Hard Top Jaws
8. Grease Nipple
9. Chuck Mounting Bolts
10. Back Cover Mounting Bolts
11. Chuck Wrench
12 & 13. Jaw Mounting Bolts




### 31-1/2" & UP
### Two piece body construction

1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Half Ring
6. Pinion Sleeve
7. Hard Master Jaws
8. Hard Top Jaws
9. Grease Nipple
10. Back Cover Mounting Bolts
11. Chuck Mounting Bolts
12. Back Cover Mounting Pin
13. Back Cover Mounting Bolts
14. Chuck Wrench
15.&16. Jaw mounting bolts










# Large Thru Hole Scroll Chucks

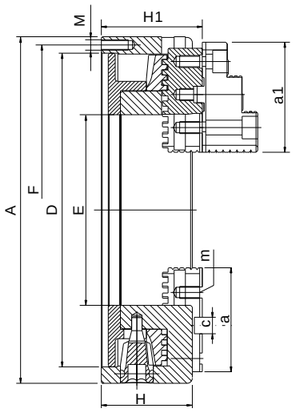
## Medium Duty
## Forged Steel Body 3-Jaw Self-Centering Scroll Chucks.
## Plain Back with Large Thru Hole

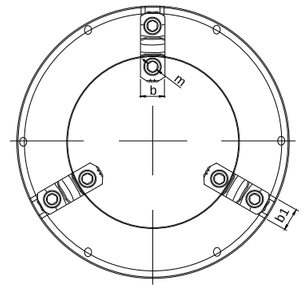
**Standard Accessories:**

1 set of hard master jaws
1 set of hard top reversible jaws
1 set of chuck mounting bolts
1 Spring loaded chuck T-wrench
2 hex keys
Eye bolts (10" and larger)
Lathe Chuck Manual

**Optional Accessories:**

Soft top jaws
Semi-Finished Adapter Plates
Base Plates for Indexers and Rotary Tables




| Chuck Dia. | Thru Hole E | H | H1 | F | D | a | a1 | b | b1 | c | Chuck Weight lbs. | Chuck Model | Chuck Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15-3/4" | 8.66 | 4.13 | 4.4685 | 15.000 | 14.252 | 4.72 | 5.000 | 1.770 | 1.4173 | .74996 | 128 | PSL3-16" | 1-207-1600 |
| 20" | 12.60 | 4.72 | 5.0394 | 18.957 | 18.189 | 4.72 | 5.157 | 1.978 | 1.8110 | .74996 | 168 | PSL3-20" | 1-207-2000 |
| 26" | 15.98 | 5.32 | 5.6023 | 24.409 | 22.835 | 5.00 | 5.157 | 2.047 | 1.9685 | .74996 | 258 | PSL3-26" | 1-207-2600 |
| 31-1/2" | 16.14 | 5.95 | 6.3386 | 18.110 | 27.953 | 8.86 | 5.157 | 2.047 | 1.9685 | .74996 | 468 | PSL3-32" | 1-207-3200 |

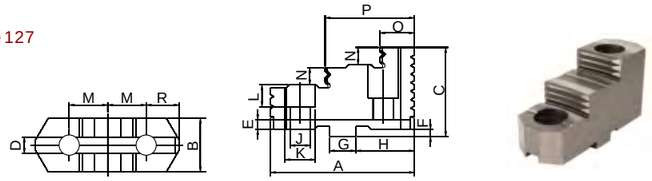
| Chuck Dia. | Max. RPM | Jaw Stroke | | Weight of Workpiece Max. | | Chuck Mounting Bolts M* | Jaw Mounting Bolts m* | Chuck Model | Chuck Part No. |
|---|---|---|---|---|---|---|---|---|---|
| | | Min. | Max. | Without Support lbs. | With Support lbs. | | | | |
| 15-3/4" | 500 | 6.614 | 11.34 | 110 | 3307 | M12 x 40 | M12 x 40 | PSL3-16" | 1-207-1600 |
| 20" | 350 | 9.874 | 14.96 | 177 | 5512 | M12 x 40 | M12 x 40 | PSL3-20" | 1-207-2000 |
| 26" | 250 | 14.80 | 19.57 | 265 | 7716 | M16 x 40 | M16 x 40 | PSL3-26" | 1-207-2600 |
| 31-1/2" | 200 | 7.402 | 22.28 | 441 | 8820 | M24 x 160 | M24 x 160 | PSL3-32" | 1-207-3200 |

**Spare parts**

| Chuck Dia. | Hard Master Jaws 3 pcs./set | Hard Top Jaws 3 pcs./set | Soft Top Jaw 1 pc | Scroll 1 pc | Pinion 1 pc | Wrench 1 pc | Pinion Screw 1 pc. | Pinion Half Ring 1 pc. | Chuck Mounting Bolts, 1 pc. |
|---|---|---|---|---|---|---|---|---|---|
| | Part No. | | | | | | | | |
| 15-3/4" | MJ-PSL-400 | TJ-PS3-400 | STJ-PS1-400 | SC-PL-400 | PI-PL-400 | W-PL-400 | PI-L-508 | - | MB-PL-400 |
| 20" | MJ-PSL-508 | TJ-PS3-500 | STJ-PS1-500 | SC-PL-508 | PI-PL-508 | W-PL-500 | PI-L-508 | - | MB-PL-508 |
| 26" | MJ-PSL-660 | TJ-PS3-630 | STJ-PS1-630 | SC-PL-660 | PI-PL-660 | W-PL-630 | PI-L-508 | - | MB-PL-660 |
| 31-1/2" | MJ-PSL-800 | TJ-PS3-630 | STJ-PS1-630 | SC-PL-800 | PI-PL-800 | W-PL-800 | - | HR-P-800 | MB-PL-800 |

## Hard Top Jaws, For 3-Jaw Chucks

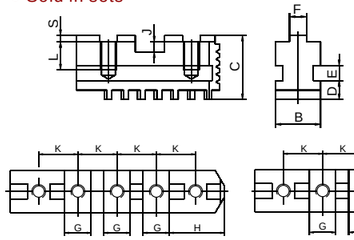
- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets
- Jaw clamping ranges see on page 127




| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .71 | 1.0 | .5004 | 1.57 | .2480 | .689 | 2.756 | 1.770 | 5.000 | 1.85 | 3.46 | 7.30 | TJ-PS3-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | 1.57 | .2480 | .787 | 3.425 | 1.978 | 5.157 | 2.05 | 3.23 | 14.4 | TJ-PS3-500 |
| 26" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | 1.57 | .2480 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | .87 | 1.3 | .5004 | 1.57 | .2480 | .787 | 3.425 | 2.047 | 5.157 | 2.05 | 3.23 | 27.1 | TJ-PS3-630 |

## Hard Master Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Hardened & Ground
- Sold in sets

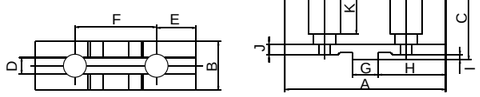



■ 26" to 32" Diameter ■ 20" Diameter ■ 15-3/4" Diameter

| Chuck Dia. | K | H | G | F | J | S | L | D | E | B | OAL A | Thread M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15-3/4" | 1-1/2 | 2-1/4 | .7496 | .50 | .2835 | .2480 | .8661 | .5315 | .5118 | 1.4173 | 4.7244 | 5/8-11 | 7.30 | MJ-PSL-400 |
| 20" | 1-1/2 | 2-1/4 | .7496 | .50 | .2835 | .2480 | 1.2598 | .6693 | .7087 | 1.811 | 4.7244 | 3/4-10 | 14.4 | MJ-PSL-508 |
| 26" | 1-1/2 | 2-1/4 | .7496 | .50 | .2835 | .2480 | 1.2598 | .6693 | .7087 | 1.811 | 5 | 3/4-10 | 27.1 | MJ-PSL-660 |
| 31-1/2" | 1-1/2 | 2-1/4 | .7496 | .50 | .2835 | .2480 | 1.2598 | .6299 | .5512 | 1.9685 | 8.8583 | 3/4-10 | 27.1 | MJ-PSL-800 |

## Soft Top Jaws, For 3-Jaw Chucks

- American Standard Tongue & Groove Jaws
- Sold by piece



| Chuck Dia. | A | B | C | D | E | F | G | H | I | J | K | Bolt Size M | Wt. Lbs. | Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15-3/4" | 5.512 | 1.654 | 2.539 | .500 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 1.7913 | 5/8-11 | 4.85 | STJ-PS1-400 |
| 20" | 5.512 | 1.969 | 2.933 | .500 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 2.1653 | 3/4-10 | 5.29 | STJ-PS1-500 |
| 26" | 6.299 | 2.047 | 3.288 | .500 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 2.5197 | 3/4-10 | 9.26 | STJ-PS1-630 |
| 31-1/2" | 6.299 | 2.047 | 3.288 | .500 | 1.3543 | 3 | .750 | 2.480 | .2480 | .406 | 2.5197 | 3/4-10 | 9.26 | STJ-PS1-630 |



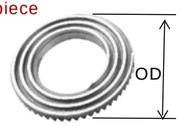




gator chucks BY KYOCERA
PSL Series - Forged Steel Body 3-Jaw Scroll Chucks with Large Thru Hole

## Scroll Plates

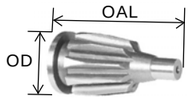
- Sold by piece




| Chuck Dia. | Part No. | OD |
|---|---|---|
| 15-3/4" | SC-PL-400 | 14.0945 |
| 20" | SC-PL-508 | 18.0315 |
| 26" | SC-PL-660 | 22.5980 |
| 31-1/2" | SC-PL-800 | 27.7559 |

## Pinions

- Sold by piece




| Chuck Dia. | Part No. | OD | OAL |
|---|---|---|---|
| 15-3/4" | PI-PL-400 | 1.4960 | 2.992 |
| 20" | PI-PL-508 | 1.7717 | 3.228 |
| 26" | PI-PL-660 | 1.8897 | 4.016 |
| 31-1/2" | PI-PL-800 | 2.0472 | 5.787 |

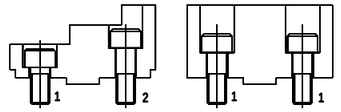
## Pinion Screw

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 15-3/4" | PH-L-508 |
| 20" | PH-L-508 |
| 26" | PH-L-508 |
| 31-1/2" | - |

## Jaw Mounting Bolts

- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 15-3/4" | 5/8-11 | MT-J1-16 | 1.00 | MT-J2-16 | 1.57 |
| 20" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 26" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |
| 31-1/2" | 3/4-10 | MT-J1-20 | 1.57 | MT-J2-20 | 2.95 |

## Chuck Mounting Bolts

- Sold by piece

| Chuck Dia. | Part No. | Thread Size |
|---|---|---|
| 15-3/4" | MB-PL-400 | M12 x 1.75 |
| 20" | MB-PL-508 | M16 x 2 |
| 26" | MB-PL-660 | M16 x 2 |
| 31-1/2" | MB-PL-800 | M24 x 3 |

## Pinion Sleeves

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 15-3/4" | - |
| 20" | - |
| 26" | - |
| 31-1/2" | PS-P-800 |

## Half Ring

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 15-3/4" | - |
| 20" | - |
| 26" | - |
| 31-1/2" | HR-P-800 |

## Wrenches (Standard & Extended)

- Sold by piece

Standard Wrench

| Chuck Dia. | Square Size | Standard | |
|---|---|---|---|
| | | L | Part No. |
| 15-3/4" | 0.5905 | 5.118 | W-PL-400 |
| 20" | 0.6693 | 9.055 | W-PL-508 |
| 26" | 0.7480 | 9.055 | W-PL-660 |
| 31-1/2" | 0.7480 | 9.055 | W-PL-800 |

# PEI & PEO SERIES

## Forged Steel Body
## Extra Heavy Duty Oil Country Chucks

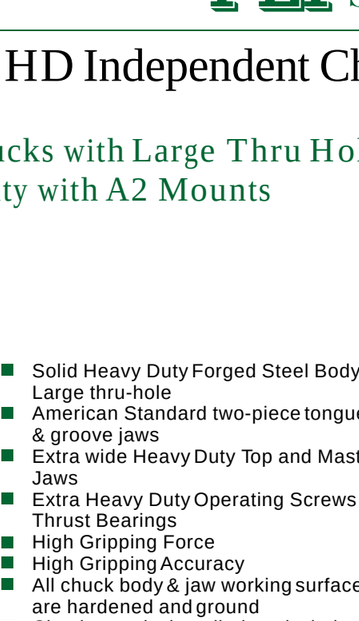
# HD Independent Chucks

## 4-Jaw Independent Oil Country Chucks with Large Thru Hole Forged Steel Body , Extra Heavy Duty with A2 Mounts

- Solid Heavy Duty Forged Steel Body Large thru-hole
- American Standard two-piece tongue & groove jaws
- Extra wide Heavy Duty Top and Master Jaws
- Extra Heavy Duty Operating Screws and Thrust Bearings
- High Gripping Force
- High Gripping Accuracy
- All chuck body & jaw working surfaces are hardened and ground
- Chucks can be installed on the lathes individually or in pairs
- All chucks are balanced

## Chuck Part Listing

1. Chuck Body
2. Operating Screw
3. Thrust Bearing
4. Set Screw
5. Hard Master Jaws
6. Hard Top Jaws
7 & 8. Jaw Mounting Bolts
9. Chuck Mounting Bolts
10. Chuck Wrench
11. T-Slot Screw



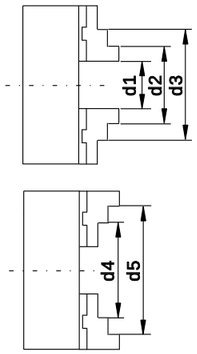
# HD Independent Chucks

## Clamping Ranges

### PEI Series 4-Jaw Independent Chucks

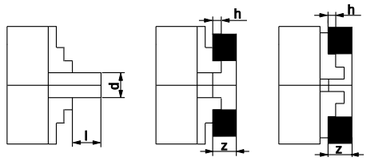
- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.

| Chuck Dia. | Spindle Nose Size | d1 | d2 | d3 | d4 | d5 |
|---|---|---|---|---|---|---|
| 20" | A2-11 | 1.77-9.96 | 5.87-17.05 | 8.50-19.69 | 5.75-17.05 | 8.39-19.69 |
| 20" | A2-15 | 1.77-9.96 | 5.87-17.05 | 8.50-19.69 | 5.75-17.05 | 8.39-19.69 |
| 25" | A2-15 | 1.97-12.05 | 6.06-22.17 | 8.70-24.80 | 5.91-22.17 | 8.54-24.80 |
| 25" | A2-20 | 3.94-12.05 | 8.03-22.17 | 10.67-24.80 | 7.87-22.17 | 10.51-24.80 |
| 28" | A2-15 | 2.95-15.20 | 7.05-25.31 | 9.69-27.95 | 6.89-25.31 | 9.53-27.95 |
| 28" | A2-20 | 3.94-15.20 | 8.03-25.31 | 10.67-27.95 | 7.87-25.31 | 10.51-27.95 |
| 31-1/2" | A2-15 | 2.95-18.90 | 7.05-28.86 | 9.69-31.50 | 6.89-28.86 | 9.53-31.50 |
| 31-1/2" | A2-20 | 4.52-18.90 | 8.62-28.86 | 11.26-31.50 | 8.46-28.86 | 11.10-31.50 |
| 40" | A2-28 | 13.78-20.87 | 18.50-36.61 | 21.26-39.37 | 18.90-36.61 | 21.65-39.37 |
| 50" | A2-15 | 3.98-25.59 | 8.86-46.46 | 11.81-49.21 | 10.04-46.46 | 12.79-49.21 |

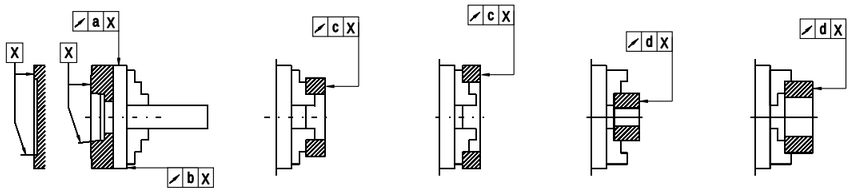



## Maximum Gripping Diameter Requirements For Unsupported Workpieces

| Chuck Diameter | 20" | 25" | 28" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|
| l max. | 1.5 x d | 1 x d | | | | |
| z max. | 4 x h | | | | | |



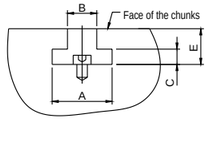

## Chuck Accuracy




| Chuck Size | | 20" | 25" | 28" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|
| a | Radial Runout | 0.0040 | 0.0040 | 0.0050 | 0.0050 | 0.0071 | 0.0071 |
| b | Face Runout | 0.0020 | 0.0020 | 0.0024 | 0.0024 | 0.0031 | 0.0040 |
| c | Jaws Face | 0.0024 | 0.0024 | 0.0024 | 0.0024 | 0.0031 | 0.0040 |
| d | Jaws Face | 0.0024 | 0.0024 | 0.0024 | 0.0024 | 0.0031 | 0.0040 |

## T-Slot Dimensions

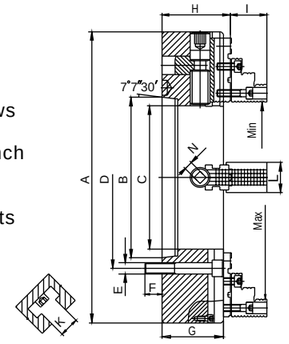
| Chuck Dia. | A | B | C | E | T-Slot Length |
|---|---|---|---|---|---|
| 20" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 5.807 |
| 25" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 6.102 |
| 28" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 7.677 |
| 31-1/2" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 9.449 |
| 40" | 1.8110 | 1.1024 | 0.7874 | 1.9685 | 9.252 |
| 50" | 1.8110 | 1.1024 | 0.7874 | 1.9685 | 14.173 |



HD Independent Chucks

**Each chuck is provided with:**

- 1 Set of HD hard master jaws
- 1 Set of HD hard top reversible jaws
- 1 Set of chuck mounting bolts
- 1 Spring loaded HD chuck T - wrench
- 2 Hex keys
- HD Eye bolts
- All chucks are provided with T-Slots
- Forged Steel Body
- Lathe Chuck Manual




## Chuck Dimensions

| Chuck Dia. A | Spindle Nose Mount | Thru Hole C | B | D | G | H | I | K | L | N | E | F | Chuck Model | Chuck Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | A2-11 | 6.5 | 7.7507 | 9.2500 | 5.71 | 6.067 | 2.981 | .886 | 2.362 | .748 | M20X2.5 | 1.118 | PEI4-20"A/A2-11 | 1-317-2011 |
| 20" | A2-15 | 8.0 | 11.251 | 13.000 | 5.71 | 6.067 | 2.981 | .886 | 2.362 | .748 | M24X3 | 1.34 | PEI4-20"A/A2-15 | 1-317-2015 |
| 25" | A2-15 | 10.5 | 11.251 | 13.000 | 6.10 | 6.067 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.34 | PEI4-25"A/A2-15 | 1-317-2515 |
| 25" | A2-20 | 12.55 | 16.251 | 18.252 | 6.10 | 6.579 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.5 | PEI4-25"A/A2-20 | 1-317-2520 |
| 28" | A2-15 | 10.5 | 11.251 | 13.000 | 6.10 | 6.579 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.34 | PEI4-28"A/A2-15 | 1-317-2815 |
| 28" | A2-20 | 12.55 | 16.251 | 18.252 | 6.10 | 6.579 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.5 | PEI4-28"A/A2-20 | 1-317-2820 |
| 31-1/2" | A2-15 | 10.5 | 11.251 | 13.000 | 6.50 | 6.972 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.34 | PEI4-32"A/A2-15 | 1-317-3215 |
| 31-1/2" | A2-20 | 12.55 | 16.251 | 18.252 | 6.50 | 6.972 | 3.571 | .886 | 2.953 | .866 | M24X3 | 1.5 | PEI4-32"A/A2-20 | 1-317-3220 |
| 40" | A2-28 | 20.86 | 23.001 | 25.500 | 6.89 | 7.366 | 3.571 | 1.10 | 2.953 | .866 | M30X3.5 | 1.53 | PEI4-40"A/A2-28 | 1-317-4028 |
| 50" | A2-15 | 11.00 | 11.251 | 13.000 | 6.89 | 7.366 | 3.571 | 1.10 | 2.953 | .866 | M24X3 | 1.34 | PEI4-50"A/A2-15 | 1-317-5015 |

## Chuck Parameters

| Chuck Dia. A | Spindle Nose Size | RPM* Max. | Load** Capacity lb. | Torque on the Wrench lb. Ft. | Gripping Force per Jaw lbf. | Clamping Capacity Min. - Max. | Chuck Weight lbs. | Top Jaw Mounting Bolt | Operating Screw Thread Size |
|---|---|---|---|---|---|---|---|---|---|
| 20" | A2-11 | 1000 | 14,900 | 259 | 7,190 | 1.77-19.68 | 450 | 3/4"-10 | Tr44 x 8LH |
| 20" | A2-15 | 1000 | 14,900 | 259 | 7,190 | 1.77-19.68 | 414 | 3/4"-10 | Tr44 x 8LH |
| 25" | A2-15 | 850 | 21,500 | 296 | 8,320 | 1.97-24.80 | 682 | 7/8"-9 | Tr50 x 8LH |
| 25" | A2-20 | 850 | 21,500 | 296 | 8,320 | 3.94-24.80 | 649 | 7/8"-9 | Tr50 x 8LH |
| 28" | A2-15 | 750 | 24,800 | 331 | 9,217 | 2.95-27.95 | 913 | 7/8"-9 | Tr50 x 8LH |
| 28" | A2-20 | 750 | 24,800 | 331 | 9,217 | 7.09-27.95 | 869 | 7/8"-9 | Tr50 x 8LH |
| 31-1/2" | A2-15 | 600 | 28,100 | 331 | 9,217 | 5.12-31.50 | 1,287 | 7/8"-9 | Tr50 x 8LH |
| 31-1/2" | A2-20 | 600 | 28,100 | 331 | 9,217 | 7.09-31.50 | 1,243 | 7/8"-9 | Tr50 x 8LH |
| 40" | A2-28 | 430 | 38,000 | 368 | 10,116 | 13.73-39.40 | 1,683 | 7/8"-9 | Tr50 x 8LH |
| 50" | A2-15 | 350 | 42,900 | 368 | 11,240 | 3.94-49.21 | 3,540 | 7/8"-9 | Tr50 x 8LH |

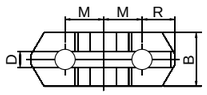
*Permissible chuck max. RPM's are calculated for the round and perfectly centered workpieces and the chucks in perfect condition having factory original jaws and depends on many different machining factors such as cutting parameters (depth of cut & feeds), weight and balancing of workpiece, machining conditions like; smooth or interrupted cut. Workpiece material and surface finishing should be also taken into the consideration.
*Max. load capacity is rated per one PEI chuck.
Max. load capacity has been calculated for symmetrical workpiece
SUPPORDED with the live center, steady rest or being gripped in two chucks.
For the odd shape workpieces the RPM should be reduced significantly.

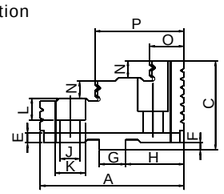
## Spare Parts

| Chuck Dia. A | Spindle Nose Size | Hard Top Reversible Jaws 1 pc. | Hard Master Jaws 1 pc. | Thrust Bearing 1 pc. | Heavy Duty Wrench 1 pc. | Heavy Duty Wrench 1 pc. |
|---|---|---|---|---|---|---|
| 20" | A2-11 | TJ-PEI-500 | MJ-PEI-500 | TB-PEI-500 | W-PEI-500 | OS-PEI-511 |
| 20" | A2-15 | TJ-PEI-500 | MJ-PEI-500 | TB-PEI-500 | W-PEI-500 | OS-PEI-515 |
| 25" | A2-15 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-630 | W-PEI-1000 | OS-PEI-631 |
| 25" | A2-20 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-630 | W-PEI-1000 | OS-PEI-632 |
| 28" | A2-15 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-630 | W-PEI-1000 | OS-PEI-715 |
| 28" | A2-20 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-630 | W-PEI-1000 | OS-PEI-720 |
| 31-1/2" | A2-15 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-800 | W-PEI-1000 | OS-PEI-815 |
| 31-1/2" | A2-20 | TJ-PEI-800 | MJ-PEI-800 | TB-PEI-800 | W-PEI-1000 | OS-PEI-820 |
| 40" | A2-28 | TJ-PEI-1000 | MJ-PEI-1000 | TB-PEI-1000 | W-PEI-1000 | OS-PEI-928 |
| 50" | A2-15 | TJ-PEI-1000 | MJ-PEI-1000 | TB-PEI-1000 | W-PEI-1000 | OS-PEI-1215 |

## HD Hard Reversible Top Jaw for PEI Independent Chucks

- American Standard Two-Piece Tongue & Groove Jaws
- Extra wide Heavy Duty Hard Top Jaws with heavy serration
- Hardened & Ground
- Sold per 1 pc.
- Jaw clamping ranges see on page 133

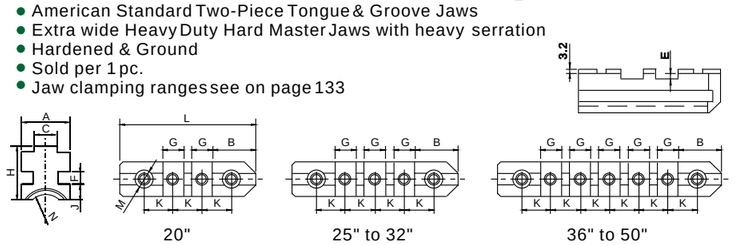


| Chuck Dia. | M | H | G | J | K | D | E | F | N | C | B | OAL A | O | P | Weight 1 set lbs. | Top Jaw Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | 1.5 | 2.248 | .7496 | .866 | 1.299 | .5004 | .1575 | .244 | .827 | 3.228 | 2.362 | 5.378 | 2.047 | 3.366 | 9.0 | TJ-PEI-500 |
| 25" | 1.5 | 2.248 | .7496 | .953 | 1.378 | .5004 | .1575 | .244 | 1.102 | 3.819 | 2.953 | 5.343 | 2.047 | 3.366 | 12.5 | TJ-PEI-800 |
| 28" | 1.5 | 2.248 | .7496 | .953 | 1.378 | .5004 | .1575 | .244 | 1.102 | 3.819 | 2.953 | 5.343 | 2.047 | 3.366 | 12.5 | TJ-PEI-800 |
| 31-1/2" | 1.5 | 2.248 | .7496 | .953 | 1.378 | .5004 | .1575 | .244 | 1.102 | 3.819 | 2.953 | 5.343 | 2.047 | 3.366 | 12.5 | TJ-PEI-800 |
| 40" | 1.5 | 2.248 | .7496 | .953 | 1.378 | .5004 | .1575 | .244 | 1.181 | 4.213 | 3.346 | 6.299 | 2.362 | 3.740 | 18.5 | TJ-PEI-1000 |
| 50" | 1.5 | 2.248 | .7496 | .953 | 1.378 | .5004 | .1575 | .244 | 1.181 | 4.213 | 3.346 | 6.299 | 2.362 | 3.740 | 18.5 | TJ-PEI-1000 |

## HD Hard Master Jaw for PEI Independent Chucks

- American Standard Two-Piece Tongue & Groove Jaws
- Extra wide Heavy Duty Hard Master Jaws with heavy serration
- Hardened & Ground
- Sold per 1 pc.
- Jaw clamping ranges see on page 133



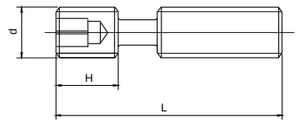
| Chuck Dia. | A | B | G | E | F | C | H | J | K | Overall Length L | M | N | Weight 1 set lbs. | Top Jaw Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | 2.047 | 2.248 | .7496 | .2835 | .7874 | .500 | 2.3228 | .618 | 1.5 | 6.693 | 3/4"-10 | Tr44 x 8LH | 8.50 | MJ-PEI-500 |
| 25" | 2.756 | 2.248 | .7496 | .2835 | .7874 | .500 | 2.4724 | .618 | 1.5 | 8.190 | 7/8"-9 | Tr50 x 8LH | 13.50 | MJ-PEI-800 |
| 28" | 2.756 | 2.248 | .7496 | .2835 | .7874 | .500 | 2.4724 | .618 | 1.5 | 8.190 | 7/8"-9 | Tr50 x 8LH | 13.50 | MJ-PEI-800 |
| 31-1/2" | 2.756 | 2.248 | .7496 | .2835 | .7874 | .500 | 2.4724 | .618 | 1.5 | 8.190 | 7/8"-9 | Tr50 x 8LH | 13.50 | MJ-PEI-800 |
| 40" | 3.149 | 2.248 | .7496 | .2835 | .9843 | .500 | 3.0354 | .984 | 1.5 | 11.81 | 7/8"-9 | Tr50 x 8LH | 30.00 | MJ-PEI-1000 |
| 50" | 3.149 | 2.248 | .7496 | .2835 | .9843 | .500 | 3.0354 | .984 | 1.5 | 11.81 | 7/8"-9 | Tr50 x 8LH | 30.00 | MJ-PEI-1000 |





## Operating Screw

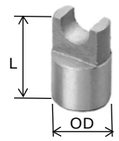
- Sold by piece




| Chuck Dia. | Taper Size | Chuck Thru Hole Dia. | Thread Size d | H | L | Socket Square Size S | Part No. |
|---|---|---|---|---|---|---|---|
| 20" | A2-11 | 6.50 | Tr44 x 8 | 2.340 | 6.457 | .748 | OS-PEI-511 |
| 20" | A2-15 | 8.00 | Tr44 x 8 | 2.340 | 5.669 | .866 | OS-PEI-515 |
| 25" | A2-15 | 10.50 | Tr50 x 8 | 2.362 | 6.988 | .866 | OS-PEI-631 |
| 25" | A2-20 | 12.55 | Tr50 x 8 | 2.362 | 5.925 | .866 | OS-PEI-632 |
| 28" | A2-15 | 10.50 | Tr50 x 8 | 2.953 | 8.563 | .866 | OS-PEI-715 |
| 28" | A2-20 | 12.55 | Tr50 x 8 | 2.953 | 7.500 | .866 | OS-PEI-720 |
| 31-1/2" | A2-15 | 10.50 | Tr50 x 8 | 3.543 | 10.335 | .866 | OS-PEI-815 |
| 31-1/2" | A2-20 | 12.55 | Tr50 x 8 | 3.543 | 9.252 | .866 | OS-PEI-820 |
| 31-1/2" | A2-20 | 14.50 | Tr50 x 8 | 3.543 | 8.268 | .866 | OS-PEI-821 |
| 40" | A2-28 | 20.86 | Tr55 x 8 | 3.225 | 9.646 | .866 | OS-PEI-928 |
| 50" | A2-15 | 11.00 | Tr55 x 8 | 3.445 | 8.386 | .866 | OS-PEI-1015 |

## Thrust Bearing

- Sold by piece




| Chuck Dia. | Taper Size | OD Dia. | L | Part No. |
|---|---|---|---|---|
| 20" | A2-11 | 1.7716 | 3.6614 | TB-PEI-500 |
| 20" | A2-15 | 1.7716 | 3.6614 | TB-PEI-500 |
| 25" | A2-15 | 1.9685 | 4.0945 | TB-PEI-630 |
| 25" | A2-20 | 1.9685 | 4.0945 | TB-PEI-630 |
| 28" | A2-15 | 1.9685 | 4.0945 | TB-PEI-630 |
| 28" | A2-20 | 1.9685 | 4.0945 | TB-PEI-630 |
| 31-1/2" | A2-15 | 1.9685 | 4.4882 | TB-PEI-800 |
| 31-1/2" | A2-20 | 1.9685 | 4.4882 | TB-PEI-800 |
| 31-1/2" | A2-20 | 1.9685 | 4.4882 | TB-PEI-800 |
| 40" | A2-28 | 2.3622 | 4.2913 | TB-PEI-1000 |
| 50" | A2-15 | 2.3622 | 4.2913 | TB-PEI-1000 |

Note: After the installation every thrust bearing has to be secured with the set screw.

## Chuck A2 Mounting Bolts

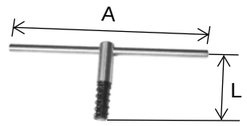
- Sold by piece

| Chuck Dia. | Taper Size | Thread Size | L | Part No. |
|---|---|---|---|---|
| 20" | A2-11 | M20 x 2.5 | 5.9055 | MB-PEI-511 |
| 20" | A2-15 | M24 x 3 | 5.9055 | MB-PEI-515 |
| 25" | A2-15 | M24 x 3 | 6.2992 | MB-PEI-615 |
| 25" | A2-20 | M24 x 3 | 6.6992 | MB-PEI-620 |
| 28" | A2-15 | M24 x 3 | 6.2992 | MB-PEI-715 |
| 28" | A2-20 | M24 x 3 | 6.6992 | MB-PEI-720 |
| 31-1/2" | A2-15 | M24 x 3 | 6.6992 | MB-PEI-815 |
| 31-1/2" | A2-20 | M24 x 3 | 7.0866 | MB-PEI-820 |
| 31-1/2" | A2-20 | M24 x 3 | 7.0866 | MB-PEI-821 |
| 40" | A2-28 | M30 x 3.5 | 7.0866 | MB-PEI-1028 |
| 50" | A2-15 | M24 x 3 | 7.0866 | MB-PEI-1215 |

* Bolts are made in a Class B12.9

## HD Spring Loaded Chuck T-Wrench

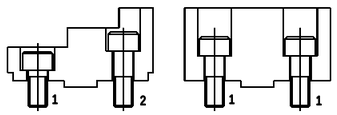
- Sold by piece




| Chuck Dia. | L | A | Square Size inch | Wrench Part No . |
|---|---|---|---|---|
| 20" | 10.27 | 15.35 | 0.748 | W-PEI-500 |
| 25" | 11.81 | 15.35 | 0.866 | W-PEI-800 |
| 28" | 11.81 | 15.35 | 0.866 | W-PEI-800 |
| 31-1/2" | 11.81 | 15.35 | 0.866 | W-PEI-800 |
| 40" | 17.72 | 15.35 | 0.866 | W-PEI-1000 |
| 50" | 17.72 | 15.35 | 0.866 | W-PEI-1000 |

## Jaw Mounting Bolts

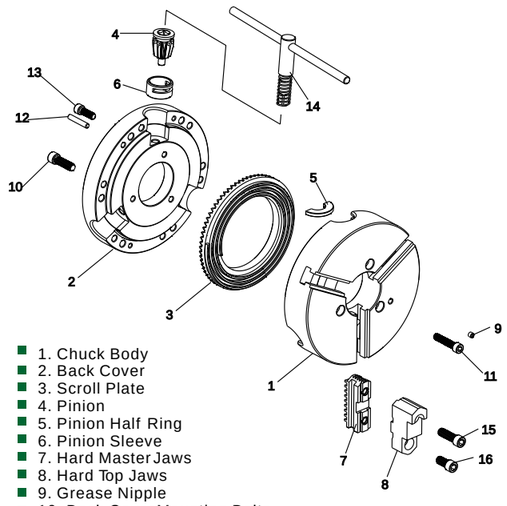
- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 20" | 3/4-10 | MTH-J1-20 | 1.57 | MTH-J2-20 | 2.37 |
| 25" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 28" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 31-1/2" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 40" | 7/8-9 | MTH-J1-40 | 1.75 | MTH-J2-40 | 2.75 |
| 50" | 7/8-9 | MTH-J1-40 | 1.75 | MTH-J2-40 | 2.75 |

# HD Scroll Chucks

## 3-Jaw Self-Centering Oil Country Chucks with Large Thru Hole
## Forged Steel Body , Extra Heavy Duty with A2 Mounts




- 1. Chuck Body
- 2. Back Cover
- 3. Scroll Plate
- 4. Pinion
- 5. Pinion Half Ring
- 6. Pinion Sleeve
- 7. Hard Master Jaws
- 8. Hard Top Jaws
- 9. Grease Nipple
- 10. Back Cover Mounting Bolts
- 11. Chuck Mounting Bolts
- 12. Back Cover Mounting Pin
- 13. Back Cover Mounting Bolts
- 14. Chuck Wrench
- 15.&16.Jaw mounting bolts

### Chuck Body

Two piece body construction made of drop forged high quality alloy steel.
PEO chuck forged steel body can handle heavy workpieces and heavy machining.
All working surfaces are induction hardened and precisely ground.
3 pinion design.

### HD Scroll Plate

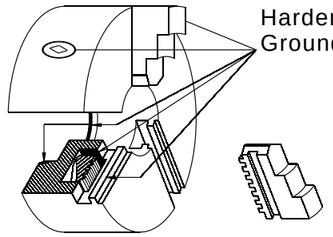
Thread flanks are ground on both sides.
Each scroll is individually balanced for chuck longer life and higher accuracy.

### Jaws

Made of high alloy steel, Extra wide HD Top & Master Jaws.
American Standard two-piece Tongue & Groove Jaws.
Jaw teeth and guideways are hardened and fully ground on both sides.
Top & Master Jaw HD execution allows for high gripping power.

### HD Pinions

Hardened and ground.
Each pinion is inserted in a steel special bushing to secure precision engagement with the scroll.



Hardened and Ground Surfaces

### Bushings

Made of high grade alloy steel.
Hardened and ground.
Each bushing is pressed into pinion seat and secured with the half ring.





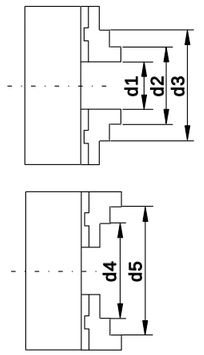
HD Scroll Chucks

## Clamping Ranges

### PEO Series 3-Jaw Self-Centering Chucks

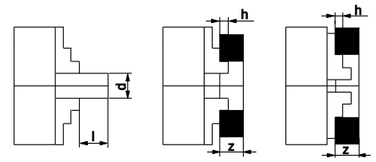
- Note:
  *Never exceed chuck gripping ranges.
  *Master jaws and scroll should be always in a full engagement.
  *Select jaws with the proper jaw gripping surfaces to fit your application.
  *Always Use proper jaws for rough and finishing machining.

| Chuck Dia. | Spindle Nose Size | d1 | d2 | d3 | d4 | d5 |
|---|---|---|---|---|---|---|
| 20" | A2-11 | 1.77-9.25 | 6.38-17.05 | 8.90-19.69 | 5.51-17.05 | 8.15-19.69 |
| 20" | A2-15 | 1.77-9.25 | 6.38-17.05 | 8.90-19.69 | 5.51-17.05 | 8.15-19.69 |
| 25" | A2-15 | 3.15-13.19 | 7.87-22.60 | 10.35-24.80 | 6.89-22.60 | 9.57-24.80 |
| 25" | A2-20 | 6.30-13.19 | 11.02-22.60 | 13.5-24.80 | 10.04-22.60 | 12.72-24.80 |
| 28" | A2-15 | 5.12-15.12 | 9.21-25.19 | 11.85-27.95 | 9.05-25.28 | 11.81-27.95 |
| 28" | A2-20 | 9.17-15.12 | 13.26-25.19 | 15.93-27.95 | 14.09-25.28 | 16.73-27.95 |
| 31-1/2" | A2-15 | 5.12-18.98 | 9.84-23.62 | 12.72-31.50 | 9.06-29.29 | 11.73-31.50 |
| 31-1/2" | A2-20 | 7.48-18.98 | 12.20-23.62 | 14.29-31.50 | 11.42-29.29 | 14.09-31.50 |
| 40" | A2-20 | 9.84-23.62 | 14.37-42.52 | 16.93-45.26 | 16.73-42.13 | 19.69-45.26 |
| 40" | A2-28 | 9.84-23.62 | 14.37-42.52 | 16.93-45.26 | 16.73-42.13 | 19.69-45.26 |

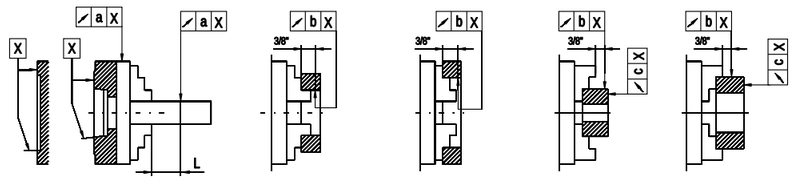



## Maximum Gripping Diameter Requirements For Unsupported Workpieces

| Chuck Diameter | 20" | 25" | 28" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|
| l max. | 1.5 x d | 1 x d | | | | |
| z max. | 4 x h | | | | | |



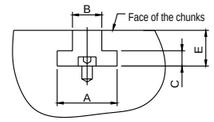

## Chuck Accuracy




| Chuck Size | | 20" | 25" | 28" | 31-1/2" | 40" | 50" |
|---|---|---|---|---|---|---|---|
| L | | 6.3 | 6.3 | 6.3 | 6.3 | 6.3 | 6.3 |
| a | Radial Runout | 0.0040 | 0.0040 | 0.0059 | 0.0059 | 0.0071 | 0.0071 |
| b | Radial Runout | 0.0040 | 0.0040 | 0.0059 | 0.0059 | 0.0071 | 0.0071 |
| c | Axial Runout | 0.0020 | 0.0020 | 0.0024 | 0.0024 | 0.0031 | 0.0031 |

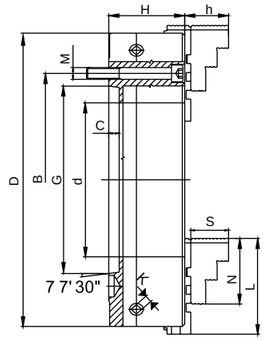
## T-Slot Dimensions

| Chuck Dia. | A | B | C | E | T-Slot Length |
|---|---|---|---|---|---|
| 20" | 0.9055 | 0.5512 | 0.3937 | 0.9055 | 5.9055 |
| 25" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 6.122 |
| 28" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 7.713 |
| 31-1/2" | 1.4763 | 0.8858 | 0.6299 | 1.3779 | 8.504 |
| 40" | 1.8110 | 1.1024 | 0.7874 | 1.9685 | 8.661 |
| 50" | 1.8110 | 1.1024 | 0.7874 | 1.9685 | 13.58 |



**Each chuck is provided with:**

- 1 Set of HD hard master jaws
- 1 Set of HD hard top reversible jaws
- 1 Set of chuck mounting bolts
- 1 Spring loaded HD chuck T - wrench
- 2 Hex keys
- HD Eye bolts
- All chucks are provided with T-Slots
- Forged Steel Body
- Lathe Chuck Manual




## Chuck Dimensions

| Chuck Dia. A | Spindle Nose Size | Type of Mounting | Thru Hole D | B | G | H | h | C | S | N | K | RPM** | Chuck Model | Chuck Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | A2-11 | Direct | 7.48 | 9.25 | 7.751 | 4.685 | 3.425 | .7500 | 2.980 | 5.315 | .748 | 1000 | PEO3-20"A/A2-11 | 1-119-2011 |
| 20" | A2-15 | Indirect* | 8.00 | 13.00 | 11.251 | 4.685 | 3.425 | .8125 | 2.980 | 5.315 | .748 | 1000 | PEO3-20"A/A2-15 | 1-119-2015 |
| 25" | A2-15 | Direct | 10.75 | 13.00 | 11.251 | 6.063 | 3.642 | .8125 | 3.295 | 5.315 | .866 | 850 | PEO3-25"A/A2-15 | 1-119-2515 |
| 25" | A2-20 | Indirect* | 12.55 | 18.25 | 16.251 | 6.063 | 3.642 | .8750 | 3.295 | 5.315 | .866 | 850 | PEO3-25"A/A2-20 | 1-119-2520 |
| 28" | A2-15 | Direct | 10.75 | 13.00 | 11.251 | 6.300 | 3.642 | .8125 | 3.295 | 5.315 | .866 | 750 | PEO3-28"A/A2-15 | 1-119-2815 |
| 28" | A2-20 | Direct | 12.55 | 18.25 | 16.251 | 6.300 | 3.642 | .8750 | 3.295 | 5.315 | .866 | 750 | PEO3-28"A/A2-20 | 1-119-2820 |
| 31-1/2" | A2-15 | Direct | 10.75 | 13.00 | 11.251 | 6.300 | 3.642 | .8125 | 3.295 | 5.315 | .866 | 600 | PEO3-32"A/A2-15 | 1-119-3215 |
| 31-1/2" | A2-20 | Direct | 12.55 | 18.25 | 16.251 | 6.300 | 3.642 | .8750 | 3.295 | 5.315 | .866 | 600 | PEO3-32"A/A2-20 | 1-119-3220 |
| 40" | A2-20 | Direct | 12.55 | 18.25 | 16.251 | 7.087 | 4.409 | .8750 | 4.081 | 8.628 | .866 | 430 | PEO3-40"A/A2-20 | 1-119-4020 |
| 40" | A2-28 | Direct | 20.86 | 25.50 | 23.001 | 7.087 | 4.409 | 1.1023 | 4.081 | 8.628 | .866 | 430 | PEO3-40"A/A2-28 | 1-119-4028 |

*Indirect chucks can be used as Plain Back as well

*Permissible chuck max. RPM's are calculated for the round and perfectly centered workpieces and the chucks in perfect condition having factory original jaws and depends on many different machining factors such as cutting parameters (depth of cut & feeds), weight and balancing of workpiece, machining conditions like; smooth or interrupted cut. Workpiece material and surface finishing should be also taken into the consideration.

## Chuck Parameters

| Chuck Dia. A | Spindle Nose Size | Hard Top Jaw Width | Master Jaw Width | Spindle Mounting Bolts (M) | Top Jaw Mounting Bolts | Max. Workpiece Weight* lbs. | Clamping Capacity Min. - Max. | Gripping Force lbf. |
|---|---|---|---|---|---|---|---|---|
| 20" | A2-11 | 2.559 | 2.362 | M20 x 2.5 | 3/4"-10 | 10,400 | 1.77-19.68 | 16,300 |
| 20" | A2-15 | 2.559 | 2.362 | M24 x 3 | 3/4"-10 | 10,400 | 1.77-19.68 | 16,300 |
| 25" | A2-15 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 15,600 | 3.15-24.80 | 18,040 |
| 25" | A2-20 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 15,600 | 6.30-24.80 | 18,040 |
| 28" | A2-15 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 18,000 | 5.12-27.95 | 18,650 |
| 28" | A2-20 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 18,000 | 9.17-27.95 | 18,650 |
| 31-1/2" | A2-15 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 20,800 | 5.12-31.50 | 19,140 |
| 31-1/2" | A2-20 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 20,800 | 7.09-31.50 | 19,140 |
| 40" | A2-20 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 23,800 | 9.84-45.26 | 20,150 |
| 40" | A2-28 | 3.346 | 3.150 | M24 x 3 | 7/8"-9 | 23,800 | 9.84-45.26 | 20,150 |

*Max. workpiece weight has been calculated for symmetrical workpiece SUPPORTED with the live center, steady rest or being gripped in two chucks. For the odd shape workpieces the RPM should be reduced significantly.



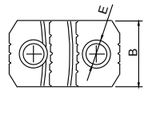


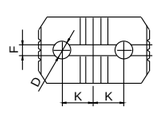
## Spare Parts

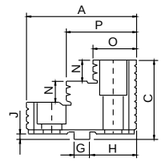
| Chuck Dia. A | Spindle Nose Size | Hard Top Reversible Jaws 1 set. | Hard Master Jaws 1 set. | Pinion 1 pc. | Scroll Plate 1 pc. | Heavy Duty Wrench 1 pc. |
|---|---|---|---|---|---|---|
| 20" | A2-11 | TJ-PEO-500 | MJ-PEO-500 | PI-PEO-500 | SC-PEO-500 | W-PEO-500 |
| 20" | A2-15 | TJ-PEO-500 | MJ-PEO-500 | PI-PEO-500 | SC-PEO-500 | W-PEO-500 |
| 25" | A2-15 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-631 | SC-PEO-631 | W-PEO-800 |
| 25" | A2-20 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-632 | SC-PEO-632 | W-PEO-800 |
| 28" | A2-15 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-715 | SC-PEO-715 | W-PEO-800 |
| 28" | A2-20 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-720 | SC-PEO-720 | W-PEO-800 |
| 31-1/2" | A2-15 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-815 | SC-PEO-815 | W-PEO-800 |
| 31-1/2" | A2-20 | TJ-PEO-800 | MJ-PEO-800 | PI-PEO-820 | SC-PEO-820 | W-PEO-800 |
| 40" | A2-20 | TJ-PEO-1000 | MJ-PEO-1000 | PI-PEO-1020 | SC-PEO-1020 | W-PEO-1000 |
| 40" | A2-28 | TJ-PEO-1000 | MJ-PEO-1000 | PI-PEO-1028 | SC-PEO-1028 | W-PEO-1000 |

## HD Hard Reversible Top Jaw for PEO Scroll Chucks

- American Standard Two-Piece Tongue & Groove Jaws
- Extra wide Heavy Duty Hard Top Jaws with heavy serration
- Hardened & Ground
- Sold in Set
- Jaw clamping ranges see on page 138



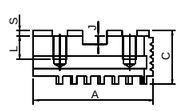



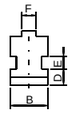



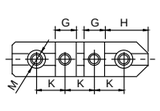
| Chuck Dia. | A | B | K | H | G | F | J | D | E | C | N | O | P | Weight 1 set lbs. | Top Jaw Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | 5.3425 | 2.559 | 1.50 | 2.248 | .7496 | .5004 | .244 | .866 | 1.299 | 3.229 | .827 | 2.047 | 3.366 | 7.28 | TJ-PEO-500 |
| 25" | 5.3543 | 3.346 | 1.50 | 2.248 | .7496 | .5004 | .244 | .945 | 1.378 | 3.819 | 1.102 | 2.047 | 3.366 | 11.16 | TJ-PEO-800 |
| 28" | 5.3543 | 3.346 | 1.50 | 2.248 | .7496 | .5004 | .244 | .945 | 1.378 | 3.819 | 1.102 | 2.047 | 3.366 | 11.16 | TJ-PEO-800 |
| 31-1/2" | 5.3543 | 3.346 | 1.50 | 2.248 | .7496 | .5004 | .244 | .945 | 1.378 | 3.819 | 1.102 | 2.047 | 3.366 | 11.16 | TJ-PEO-800 |
| 40" | 8.2677 | 3.346 | 1.50 | 2.248 | .7496 | .5004 | .246 | .945 | 1.378 | 4.330 | .984 | 1.992 | 3.330 | 18.74 | TJ-PEO-1000 |
| 50" | 8.2677 | 3.346 | 1.50 | 2.248 | .7496 | .5004 | .246 | .945 | 1.378 | 4.330 | .984 | 1.992 | 3.330 | 18.74 | TJ-PEO-1000 |

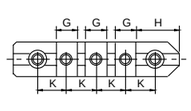
## HD Hard Master Jaw for PEO Scroll Chucks

- American Standard Two-Piece Tongue & Groove Jaws
- Extra wide Heavy Duty Hard Master Jaws with heavy serration
- Hardened & Ground
- Sold in Set
- Jaw clamping ranges see on page 138



| Chuck Dia. | A | B | G | E | D | C | H | J | K | F | L | S | M Thread | Weight 1 set lbs. | Top Jaw Part No. |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20" | 6.535 | 2.362 | .7496 | .787 | .787 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.417 | .126 | 3/4"-10 | 10.55 | MJ-PEO-500 |
| 25" | 8.858 | 3.150 | .7496 | .984 | .984 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.417 | .126 | 7/8"-9 | 21.52 | MJ-PEO-800 |
| 28" | 8.858 | 3.150 | .7496 | .984 | .984 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.299 | .126 | 7/8"-9 | 21.52 | MJ-PEO-800 |
| 31-1/2" | 8.858 | 3.150 | .7496 | .984 | .984 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.299 | .126 | 7/8"-9 | 21.52 | MJ-PEO-800 |
| 40" | 14.449 | 3.150 | .7496 | .984 | .984 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.299 | .126 | 7/8"-9 | 31.96 | MJ-PEO-1000 |
| 50" | 14.449 | 3.150 | .7496 | .984 | .984 | 2.992 | 2.248 | .283 | 1.5 | .50 | 1.299 | .126 | 7/8"-9 | 36.59 | MJ-PEO-1000 |

# PEO Series

## HD Scroll Chucks

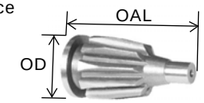
### Scroll Plates

- Sold by piece

| Chuck Dia. | Spindle Nose Size | OD | Part No. |
|---|---|---|---|
| 20" | A2-11 | 16.42 | SC-PEO-500 |
| 20" | A2-15 | 16.42 | SC-PEO-500 |
| 25" | A2-15 | 21.34 | SC-PEO-615 |
| 25" | A2-20 | 21.34 | SC-PEO-620 |
| 28" | A2-15 | 24.33 | SC-PEO-715 |
| 28" | A2-20 | 24.75 | SC-PEO-720 |
| 31-1/2" | A2-15 | 27.40 | SC-PEO-815 |
| 31-1/2" | A2-20 | 27.76 | SC-PEO-820 |
| 40" | A2-20 | 35.43 | SC-PEO-1020 |
| 40" | A2-28 | 35.43 | SC-PEO-1028 |

### Pinions

- Sold by piece




| Chuck Dia. | Spindle Nose Size | OD | OAL | Part No. |
|---|---|---|---|---|
| 20" | A2-11 | 1.97 | 3.88 | PI-PEO-500 |
| 20" | A2-15 | 1.97 | 3.88 | PI-PEO-500 |
| 25" | A2-15 | 2.047 | 4.71 | PI-PEO-615 |
| 25" | A2-20 | 2.047 | 4.71 | PI-PEO-620 |
| 28" | A2-15 | 2.047 | 5.79 | PI-PEO-715 |
| 28" | A2-20 | 2.047 | 5.79 | PI-PEO-720 |
| 31-1/2" | A2-15 | 2.047 | 7.01 | PI-PEO-815 |
| 31-1/2" | A2-20 | 2.047 | 5.79 | PI-PEO-820 |
| 40" | A2-20 | 2.76 | 6.3 | PI-PEO-1020 |
| 40" | A2-28 | 2.76 | 6.3 | PI-PEO-1028 |

### Pinion Sleeves

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 20" | PS-PEO-500 |
| 25" | PS-PEO-800 |
| 28" | PS-PEO-800 |
| 31-1/2" | PS-PEO-800 |
| 40" | PS-PEO-800 |

### Half Rings

- Sold by piece

| Chuck Dia. | Part No. |
|---|---|
| 20" | HR-PEO-500 |
| 25" | HR-PEO-800 |
| 28" | HR-PEO-800 |
| 31-1/2" | HR-PEO-800 |
| 40" | HR-PEO-800 |

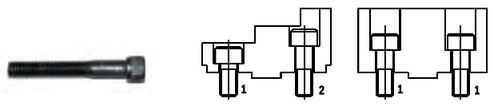
### HD Spring Loaded Chuck T-Wrench

- Sold by piece

| Chuck Dia. | Square Size | L | Part No. |
|---|---|---|---|
| 20" | 0.748 | 10.24 | W-PEI-500 |
| 25" | 0.866 | 11.81 | W-PEI-800 |
| 28" | 0.866 | 11.81 | W-PEI-800 |
| 31-1/2" | 0.866 | 11.81 | W-PEI-800 |
| 40" | 0.945 | 9.84 | W-PEI-800 |

### Jaw Mounting Bolts

- Sold by piece




| Chuck Dia. | Thread Size | Bolts No.1 Short | | Bolts No.2 Long | |
|---|---|---|---|---|---|
| | | Part No. | L | Part No. | L |
| 20" | 3/4-10 | MTH-J1-20 | 1.57 | MTH-J2-20 | 2.37 |
| 25" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 28" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 31-1/2" | 7/8-9 | MTH-J1-25 | 1.57 | MTH-J2-25 | 2.75 |
| 40" | 7/8-9 | MTH-J1-40 | 2.53 | MTH-J2-40 | 3.53 |
| 50" | 7/8-9 | MTH-J1-40 | 2.53 | MTH-J2-40 | 3.53 |

### Chuck A2 Mounting Bolts

- Sold by piece

| Chuck Dia. | Taper Size | Thread Size | L | Part No. |
|---|---|---|---|---|
| 20" | A2-11 | M20 x 2.5 | 5.118 | MB-PEO-511 |
| 20" | A2-15 | M24 x 3 | 5.165 | MB-PEO-515 |
| 25" | A2-15 | M24 x 3 | 6.299 | MB-PEO-615 |
| 25" | A2-20 | M24 x 3 | 5.165 | MB-PEO-620 |
| 28" | A2-15 | M24 x 3 | 7.087 | MB-PEO-715 |
| 28" | A2-20 | M24 x 3 | 5.165 | MB-PEO-720 |
| 31-1/2" | A2-15 | M24 x 3 | 7.087 | MB-PEO-815 |
| 31-1/2" | A2-20 | M24 x 3 | 7.480 | MB-PEO-820 |
| 40" | A2-20 | M24 x 3 | 7.874 | MB-PEO-1020 |
| 40" | A2-28 | M30 x 3.5 | 7.874 | MB-PEO-1028 |

* Bolts are made in a Class B12.9