NO.K002408001

FUERDA
LATHE CHUCKS

Instruction Manual

Please read and keep this manual for future reference

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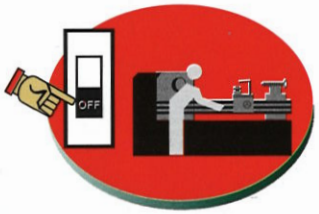
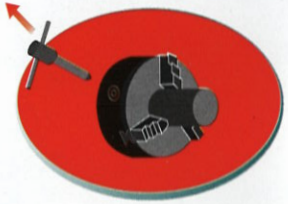
FUERDA
LATHE CHUCKS

CONTENTS

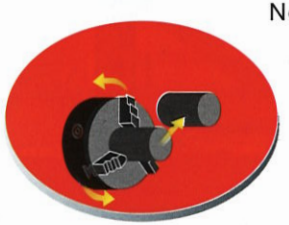
DANGER



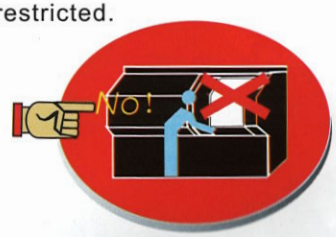
- Always disconnect the machine from power source before installation, inspection or lubrication of chuck.



- Remove the chuck key (handle) immediately after tightening withspecified torque. Never use chuck key without safety spring.



- The chuck max. Revolutions are restricted. Never exceed the max.speed.

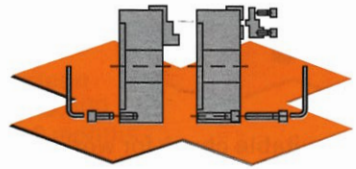


- Do not start the machine with safety door opened.

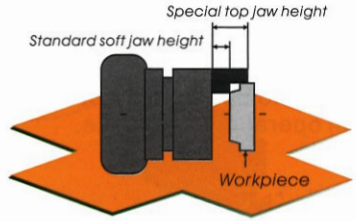
WARNING

- Be sure to use chuck wrench correctly (with safety spring only).

- Clean and lubricate chuck frequently.It will extend chuck life significantly.Never use compressed air to clean the chuck.



- **Secure clamp bolts with specified torque.**

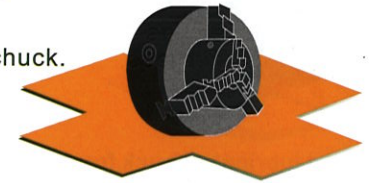


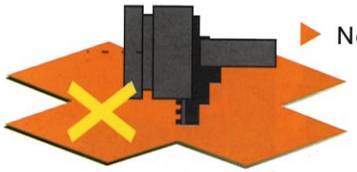
- The height of jaw should be within the maximum gripping forcelimits.

⚠ WARNING

▶ When machining a long work piece, support it with a center,tailstock or steady rest.

▶ Do not attempt to modify chuck.





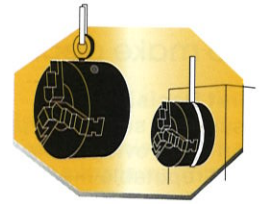
▶ Never grip another chuck with the chuck.

▶ Use most suitable chuck for workpiece.

▶ Gloves and ties should not be worn when operating a machine.

▶ When machining a long work piece, support it with a center, tailstock or steady rest.

⚠ CAUTION



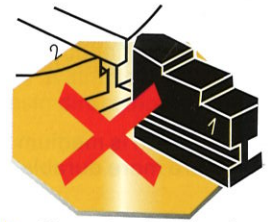
▶ When lifting chuck, use eyebolt or lifting belt.

▶ When gripping workpiece, make sure your hand is out of gripping area.

▶ Never hammer chuck, jaws or gripped workpiece.

▶ Disassemble the chuck to clean and lubricate it once every20,000 times of clamping or every 6 months.

▶ Do not apply extreme start and stop without gripping workpiece.



▶ Do not mistake the numbers marked on jaw.

How to make decision for lathe chuck selection

The First Decision :
Make sure you select a supplier that produces to a standard chucks.This decision will provide some early assurances of quality, durability and safety. The most reputable manufacturers of manual lathe chucks produce to the standard, Fuerda being one of them.

1) SCROLL or INDEPENDENT CHUCKS

Once you know the size of the chuck you are looking for. and you have settled on a standard producer.you need to decide on a SCROLL or INDEPENDENT Chuck.This decision will be based upon the material to be machined,tolerance requirements and convenience.

SCROLL Chucks -The chuck jaws are engaged to a scroll and the scroll to a pinion.As the pinion isturned all of the jaws move simultaneously and will self -center around the work piece.A scroll chuck offers accuracy and convenience for jobs using round bar stock and requiring frequent changeovers.

INDEPENDENT Chucks are different. The chuck jaws are individually engaged to an operating screw.The jaws are moved individually and typically indepen -dent chucks are used in applications where the work piece is irregular in shape.

2) BODY MATERIAL

After you have selected the type of manual chuck you want/need it is time to determine what chuck body material type you need.You typically have 3 choices.

Semi-Steel (Cast Iron) - A semi-steel body is selected when the application is medium or maintenance duty and for some production applications.Semi -Steel is also selected when cost is a factor as it is typically 30%- 40% less expensive than an equivalent forged steel body chuck. Semi-Steel bodied chucks are less durable than cast or forged steel and will lose accuracy more quicklythan cast or forged steel over time.

Cast Steel- A cast steel body chuck is selected when the application is for medium duty and some production applications. Cast steel chucks are typically available in the independent series only. Cast-Steel bodied chucks are more durable than semi-steel and not as durable as forged steel bodied chucks.

Forged Steel - Forged steel is selected when the application is medium to heavy duty and production based.Forged steel chucks are more durable and will hold their accuracy longer than Semi-steel chucks.

3) JAW TYPE

You have two choices,Two-Piece Reversible or Hard Solid.
Two-piece reversible jaws offer more versatility and convenience.Changing from ID to OD application is as simple as unbolting the top jaws fromthe master jaws, inverting them and reapplying the bolts.Two-piece jaws also provide more versatility allowing you to use a variety of soft or specially jaws. Be sure to purchase a chuck produced with ANSI standard tongue and groove jaws. Hard Solid Jaws are just that, they are solid and one piece and require a second set of jaws to convert from ID to OD.Converting from ID to OD requires that you remove the jaws completely andinsert OD jaws.Hard solid jaws provide more rigidity and thus more accuracy.

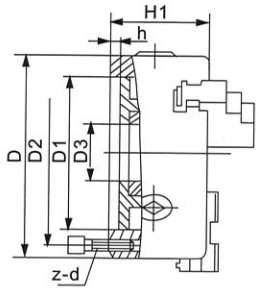
4) MOUNTING

Last but not least, you need to determine your lathe spindle type so you can mount the chuck on your machine. Consult your lathe manual for this information. The most popular spindle types are A /DIN55026 (short tapered), C/DIN55027(DIN),D/DIN 55029 (camlock). Here you do not have options; your machine will make the decision for you.Once you determine your spindle type you now need to determine if you will use a Plain Back chuck with an Adapter(back plate) or go with a Direct Mount chuck option.

Plain Back- A plain back chuck provides some flexibility and in certain instances may allow you to use the same chuck on a number of machines by unbolting the chuck from the adapter and remounting it on a different mach -ine.In most cases, the adapter for plain back chucks must be machined to match the counterbore on the back of the chuck and in some cases (semi -machined adapters) you will have to drill andthread the mounting holes. Adjustable body chucks are the exception. Adjustable chucks utilize Fully Finished adapters and the chuck and adapters can be pulled from the box and mounted directly on the machine.

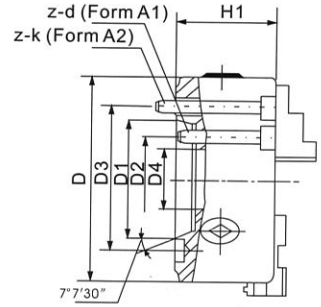
Direct Mount- Direct mount chucks provide convenience as the adapter is integrated into the chuck and can be mounted directly on the machine requiring NO additional machining. You may run into some limitations on the spindle types available for direct mount. Most producers will offer popular spindle typesin direct mount but may not offer some of the less popular types.

PLAIN BACK
Self-Centering Chucks

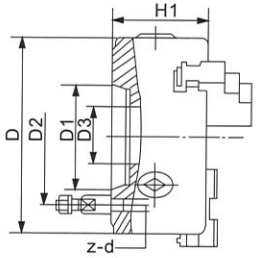


SIZE D	D1	D2	D3	H1	h	Z-d
80	55	66	16	50	4	3-M6
100	72	84	22	55	4	3-M8
125	95	108	30	58	4	3-M8
130	100	115	30	60	4	3-M8
160	130	142	45	65	5	3-M8
165	130	145	45	65	5	3-M8
180	145	160	50	75	6	3-M10
190	155	172	55	75	6	3-M10
200	165	180	65	75	6	3-M10
230	190	210	70	80	8	3-M12
240	195	215	70	80	8	3-M12
250	206	226	80	80	6	3-M12
315	260	285	100	90	6	3-M16
320	270	290	100	90	6	3-M16
325	272	296	100	90	6	3-M16
380	325	350	130	100	6	3-M16
400	340	368	130	100	6	3-M16
500	440	465	210	115	6	6-M16
630	560	595	260	135	7	6-M16

DIRECT MOUNTING
Form A Mounting from Front
Self-Centering Chucks



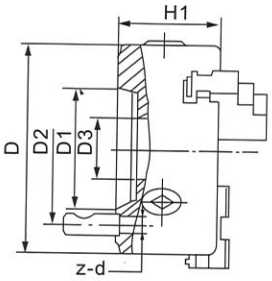
SIZE D	Short Taper	D1	D2	D3	D4	H1	z-d Form A1	z-k Form A2
160	5	82.563	61.9	-	40	73	3-M10	-
200	4	63.513	-	82.6	50	86	-	3-M10
	5	82.563	61.9	-	50	86	3-M10	-
	6	106.375	82.6	-	50	86	3-M12	-
250	5	82.563	-	104.8	80	95	-	3-M10
	6	106.375	82.6	-	55	98	6-M12	-
	8	139.719	111.1	-	80	98	6-M16	-
315 320 325	6	106.375	-	133.4	100	104	-	6-M12
	8	139.719	111.1	-	80	104	6-M16	-
380 400	6	106.375	-	133.4	103	118	-	6-M12
	8	139.719	-	171.4	136	118	-	6-M16
	11	196.869	165.1	-	130	118	6-M20	-
500	8	139.719	-	171.4	136	135	-	6-M16
	11	196.869	-	235	190	135	-	6-M20
630	11	196.869	-	235	190	155	-	6-M20
	15	285.772	-	330.2	252	155	-	6-M24



DIRECT MOUNTING(Bayonet)
Form C Mounting
With studs and locknuts
Self-Centering Chucks

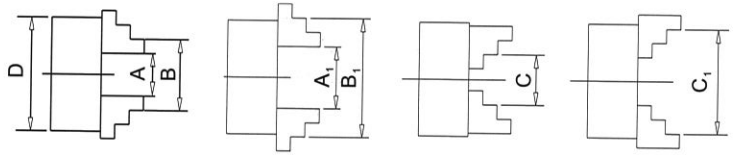
SIZE D	short taper	D1	D2	D3	H1	z-d
100	3	53.975	75	20	60	3-M10
125	3	53.975	75	25	63	3-M10
	4	63.513	85	25	63	3-M10
160	3	53.975	75	40	76	3-M10
	4	63.513	85	40	70	3-M10
	5	82.563	104.8	40	73	4-M10
	6	106.375	133.4	40	73	4-M12
200	3	53.975	75	50	84	3-M10
	4	63.513	85	50	84	3-M10
	5	82.563	104.8	50	84	4-M10
	6	106.375	133.4	50	84	4-M12
250	5	82.563	104.8	70	95	4-M10
	6	106.375	133.4	70	95	4-M12
	8	139.719	171.4	80	95	4-M16
315	6	106.375	133.4	100	106	4-M12
320	8	139.719	171.4	100	106	4-M16
325	11	196.869	235	100	106	6-M20
380	6	106.375	133.4	100	118	4-M12
	8	139.719	171.4	130	118	4-M16
400	11	196.869	235	135	118	6-M20
500	8	139.719	171.4	135	135	4-M16
	11	196.869	235	190	135	6-M20
630	8	139.719	-	135	155	4-M16
	11	196.869	235	190	155	6-M20
	15	285.775	330.2	252	155	6-M24

DIRECT MOUNTING(Camlock)
Form D Mounting
With studs and camlocks
Self-Centering Chucks



SIZE D	short taper	D1	D2	D3	H1	z-d
100	3	53.975	70.6	20	60	3-M10x1
125	3	53.975	70.6	25	63	3-M10x1
	4	63.513	82.6	25	63	3-M10x1
160	3	53.975	70.6	40	76	3-M10x1
	4	63.513	82.6	40	70	3-M10x1
	5	82.563	104.8	40	73	6-M12x1
	6	106.375	133.4	40	73	6-M16x1.5
200	3	53.975	70.6	50	84	3-M10x1
	4	63.513	82.6	50	84	3-M10x1
	5	82.563	104.8	50	84	6-M12x1
	6	106.375	133.4	50	84	6-M16x1.5
250	5	82.563	104.8	70	95	6-M12x1
	6	106.375	133.4	70	95	6-M16x1.5
	8	139.719	171.4	80	95	6-M20x1.5
315	6	106.375	133.4	100	106	6-M16x1.5
320	8	139.719	171.4	100	106	6-M20x1.5
325	11	196.869	235	100	106	6-M22x1.5
380	6	106.375	133.4	100	118	6-M16x1.5
	8	139.719	171.4	130	118	6-M20x1.5
400	11	196.869	235	135	118	6-M22x1.5
500	8	139.719	171.4	135	135	6-M20x1.5
	11	196.869	235	190	135	6-M22x1.5
630	8	139.719	171.4	135	155	6-M20x1.5
	11	196.869	235	190	155	6-M22x1.5
	15	285.775	330.2	252	155	6-M24x1.5

Clamping Range

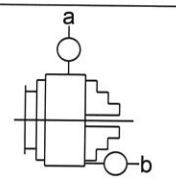
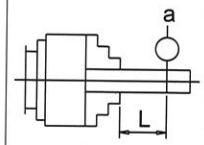
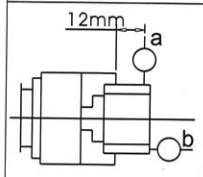
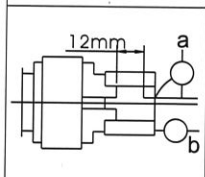


Unit:mm

SIZE D	Outside jaw		Inside jaw
	A-A1	B-B1	C-C1
80	2-22	25-70	22-63
100	2-30	30-90	30-80
125	2.5-40	38-125	38-110
130	3-40	40-130	40-120
160	3-55	50-160	55-145
165	4-60	52-165	55-150
180	4-65	65-180	65-180
190	4-70	65-190	65-190
200	4-85	65-200	65-200
230	6-90	80-230	90-230
240	6-100	80-240	90-240
250	6-110	80-250	90-250
315	10-140	95-315	100-315
320	11.5-145	95-320	110-320
325	11.5-165	95-350	110-340
380	11.5-210	95-400	120-380
400	15-210	120-400	120-400
500	25-280	150-500	150-500
630	50-350	170-630	170-630

Chucks Accuracy

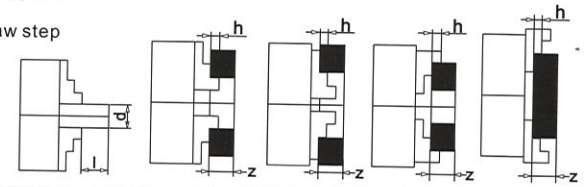
Unit:mm

Inspection Item		Chuck Dia.			
		80 100 125 130 160 165	180 190 200 230 240 250	315 320 325 380 400	500 630
	a	0.040	0.055	0.070	0.085
	b	0.040	0.060	0.075	0.100
	a	0.060 L=50	0.080 L=50/75	0.100 L=75	0.140 L=100
	a	0.075	0.075	0.100	0.125
	b	0.040	0.050	0.060	0.080
	a	0.075	0.075	0.100	0.125
	b	0.040	0.050	0.060	0.080

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	80	100	125	160	200	250	315	400	500	630	800
l	1.2 x d						1.5 x d			1 x d	
z	4 x h										

Total Gripping Force Of All Self-Centering Chucks (daN)

Chuck Diameter	80	100	125	160	200	250	315	400	500	630	800
Steel & Cast Iron Body Chucks	800	1300	1900	2400	3000	3700	4400	5200	5800	6500	8000

Recommended Maximum Speeds for Self-Centering Chucks(RPM)

Chuck Diameter	80	100	125	160	200	250	315	400	500	630	800
Cast Iron body	4000	3500	3000	2500	2000	1600	1200	1000	800	800	300
Steel body	5500	4700	4300	4000	3500	3000	2300	1800	1200	1200	450

Value of Balancing For Steel Body Self-Centering Chucks Only.

Chuck Diameter	80	100	125	160	200	250	315	400	500	630
Balancing (gcm)	11	16	23	32	45	63	90	140	300	640

Lathe Chuck Safety Conditions

Due to chuck rotating speeds and cutting forces during machining, care should be taken to insure the proper after 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.

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.

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.

Spare Part Listing

■ Hard Outside Jaw

■ Hard Inside Jaw

■ Soft solid Jaw

■ Hard Master Jaw

■ Hard Top Jaw

■ Soft Top Jaw

■ Soft Two-Piece Jaw

■ Hard Two-Piece Jaw

■ Scroll Plate

■ Pinion

■ Wrench

■ Stud and Locknut

■ Stud for camlock

■ Pinion holder

Adapter for Chuck

We supply Fully machined adapter and Semi-machined adapter.
Fully Machined Adapter - do not require any addtional machining.
Semi-machined adapter- face for spindle be ready,and face for chuckneed to drill holes accordingly.

The most popular spindle types are A /DIN55026 (short tapered), C/DIN55027(DIN),D/DIN 55029 (camlock).

- **DIN55026,Spindle Type A1&A2**

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

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

- **DIN55027,Spindle Type C**

- **DIN55029,Camlock Spindle Type D1**

Packing list for Self-centering Chucks

No	Description	QTY.	Note
1	Chuck	1 pc.	
2	Inside jaws-set	1 set	For Solid jaws
3	Chuck wrench	1 pc.	With spring
4	Mounting Screw	3pcs(≤400) 6pcs (≥500)	
5	Hex Wrench	1 pc.	
6	Instruction Manual	1	

K72 series
4-jaw independent chuck

4 Jaw Independent Chucks

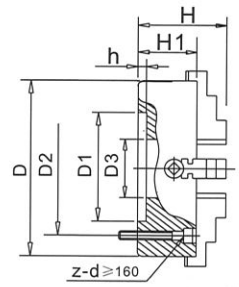
The chuck jaws are individually engaged to an operating screw. The jaws are moved individually and typically independent chucks are used in applications where the work piece is irregular in shape.

The most popular spindle types are A /DIN55026 (short tapered), C/DIN55027(DIN),D/DIN 55029 (camlock). your machine will make the decision for you.Once you determine your spindle type you now need to determine if you will use a Plain Back chuck with an Adapter(back plate) or go with a Direct Mount chuck option.

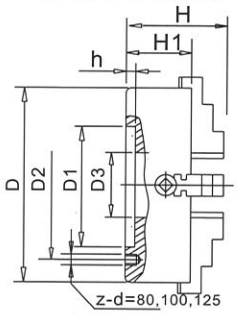
We supply 4 jaw independent chucks as follows,
1. Plain back - K72 series
2. Direct mount Type A - K72/A
3. Direct mount Type C - K72/C
4. Direct mount Type D - K72/D

PLAIN BACK

Drawing II
for 160mm and upper

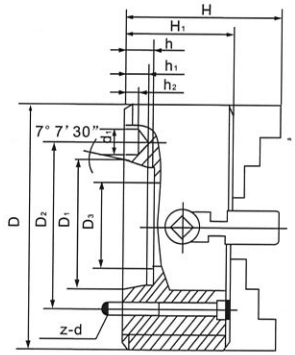


Drawing I
for 80/100/125mm

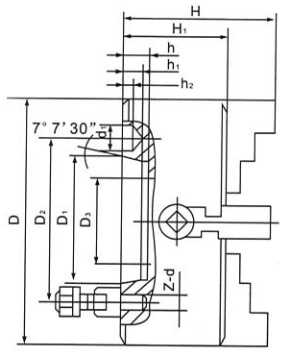


SIZE D	D1	D2	D3	H1	h	Z-d	H
80	55	66	22	42	3.5	4-M6	56
100	72	84	25	54	3.5	4-M8	73
125	95	108	30	56	4.5	4-M8	78
160	130	142	40	65	5	4-M10	96.5
200	125	104.8	50	75	6	4-M12	110
250	100	120	65	82	6	4-M12	117.5
300	152	130	75	85	6	4-M12	128.5
320	140	165	95	90	6	4-M16	134
350	130	168	80	95	8	4-M16	145
400	160	185	125	95	8	4-M16	143
450	180	205	140	100	8	4-M16	147
500	200	236	160	106	8	4-M20	161
630	220	258	180	115	10	4-M20	180
800	250	300	210	135	12	8-M20	210
1000	320	370	260	150	15	8-M20	250
1250	400	500	305	165	15	8-M20	256

DIRECT MOUNTING
Form A2 Mounting from Front
Independent Chucks



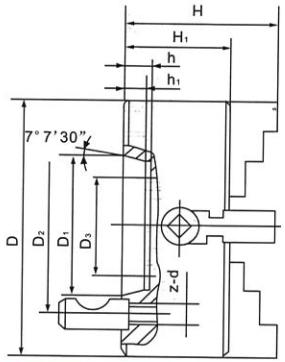
Chuck Size	Short-tape No.	D1	D2	D3	H	H1	h	h1	h2	d1	z-d
200	4	63.513	82.6	56	110	75	13	10	6.5	14.7	4-M10
250	4	63.513	82.6	56	115.5	80	13	10	6.5	14.7	4-M10
200	5	82.563	104.8	56	110	75	15	12	6.5	16.3	4-M10
250	5	82.563	104.8	75	115.5	80	15	12	6.5	16.3	4-M10
320	5	82.563	104.8	75	134	90	15	12	6.5	16.3	4-M10
250	6	106.375	133.4	75	115.5	80	16	13	6.5	19.5	4-M12
320	6	106.375	133.4	75	134	90	16	13	6.5	19.5	4-M12
350	6	106.375	133.4	95	141	90	16	13	6.5	19.5	4-M12
400	6	106.375	133.4	95	143	95	16	13	6.5	19.5	4-M12
250	8	139.719	171.4	75	115.5	80	18	14	8.0	24.2	4-M16
320	8	139.719	171.4	95	134	90	18	14	8.0	24.2	4-M16
400	8	139.719	171.4	125	143	95	18	14	8.0	24.2	4-M16
450	8	139.719	171.4	125	147	100	18	14	8.0	24.2	4-M16
500	8	139.719	171.4	130	161	106	18	14	8.0	24.2	4-M16
630	8	139.719	171.4	130	180	115	18	14	8.0	24.2	4-M16
800	8	139.719	171.4	130	210	135	18	14	8.0	24.2	4-M16
400	11	196.869	235.0	160	143	95	20	16	10.0	29.4	4-M20
500	11	196.869	235.0	160	161	106	20	16	10.0	29.4	4-M20
630	11	196.869	235.0	180	180	115	20	16	10.0	29.4	4-M20
800	11	196.869	235.0	180	210	135	20	16	10.0	29.4	8-M20
1000	11	196.869	235.0	180	241	150	20	16	10.0	29.4	8-M20
1250	11	196.869	235.0	180	256	165	20	16	10.0	29.4	8-M20
630	15	285.775	330.2	241	180	115	21	17	10.0	35.7	8-M22
800	15	285.775	330.2	180	210	135	21	17	10.0	35.7	8-M22
1000	15	285.775	330.2	280	241	150	21	17	10.0	35.7	8-M22
1000T	15	285.775	330.2	280	241	150	21	17	20.0	35.7	8-M20
1250T	15	285.775	330.2	280	256	165	21	17	20.0	35.7	8-M20
1250	15	285.775	330.2	280	256	165	21	17	20.0	35.7	8-M22
1400D	15	285.775	330.2	280	246	155	21	17	20.0	35.7	8-M20
1600D	15	285.775	330.2	280	266	175	21	17	20.0	35.7	8-M20
2000	15	285.775	330.2	280	290	190	21	17	20.0	35.7	8-M20
1000	20	412.775	463.6	305	241	150	23	19	10.0	42.1	8-M24
1250	20	412.775	463.6	305	256	165	23	19	10.0	42.1	8-M24
1600	20	412.775	463.6	305	266	175	23	19	10.0	42.1	8-M24
2000	20	412.775	463.6	305	290	190	23	19	10.0	42.1	8-M24



DIRECT MOUNTING(Bayonet)
Form C Mounting
With studs and locknuts
Independent Chucks

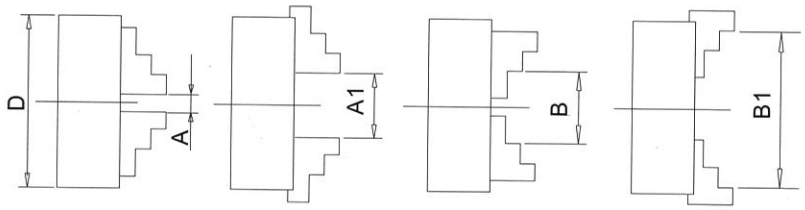
Chuck Size	Short-tape No.	D1	D2	D3	H	H1	h	h1	h2	d1	z-d
160	3	53.975	75.0	45	96.5	65	13	10	—	—	3-M10
160	4	63.513	85.0	56	96.5	65	13	10	6.5	14.7	3-M10
200	4	63.513	85.0	56	110	75	13	10	6.5	14.7	3-M10
250	4	63.513	85.0	56	115.5	80	13	10	6.5	14.7	3-M10
200	5	82.563	104.8	56	110	75	15	12	6.5	16.3	4-M10
250	5	82.563	104.8	56	115.5	80	15	12	6.5	16.3	4-M10
300	5	82.563	104.8	56	128.5	85	15	12	6.5	16.3	4-M10
320	5	82.563	104.8	56	134	90	15	12	6.5	16.3	4-M10
250	6	106.375	133.4	75	115.5	80	16	13	6.5	19.5	4-M12
300	6	106.375	133.4	75	128.5	85	16	13	6.5	19.5	4-M12
320	6	106.375	133.4	75	134	90	16	13	6.5	19.5	4-M12
350	6	106.375	133.4	75	141	90	16	13	6.5	19.5	4-M12
400	6	106.375	133.4	75	143	95	16	13	6.5	19.5	4-M12
500	6	106.375	133.4	75	161	106	16	13	6.5	19.5	4-M12
250	8	139.719	171.4	95	115.5	80	18	14	8.0	24.2	4-M16
320	8	139.719	171.4	95	134	90	18	14	8.0	24.2	4-M16
400	8	139.719	171.4	125	143	95	18	14	8.0	24.2	4-M16
500	8	139.719	171.4	125	161	106	18	14	8.0	24.2	4-M16
630	8	139.719	171.4	130	180	115	18	14	8.0	24.2	4-M16
400	11	196.869	235.0	125	143	95	20	16	10.0	29.4	6-M20
500	11	196.869	235.0	160	161	106	20	16	10.0	29.4	6-M20
630	11	196.869	235.0	180	180	115	20	16	10.0	29.4	6-M20
800	11	196.869	235.0	180	210	135	20	16	10.0	29.4	6-M20
1000	11	196.869	235.0	180	241	150	20	16	10.0	29.4	6-M20
1250	11	196.869	235.0	180	256	165	20	16	10.0	29.4	6-M20
630	15	285.775	330.2	180	180	115	21	17	10.0	35.7	6-M24
800	15	285.775	330.2	180	210	135	21	17	10.0	35.7	6-M24
1000	15	285.775	330.2	280	241	150	21	17	10.0	35.7	6-M24
1250	15	285.775	330.2	280	256	165	21	17	10.0	35.7	6-M24
1600	15	285.775	330.2	280	266	175	21	17	10.0	35.7	6-M24

DIRECT MOUNTING(Camlock)
Form D Mounting
With studs and camlocks
Independent Chucks



Chuck Size	Short-tape No.	D1	D2	D3	H	H1	h	h1	z-d
160	3	53.975	70.6	45	96.5	65	13	10	3-M10×1
160	4	63.513	82.6	56	96.5	65	13	10	3-M10×1
200	4	63.513	82.6	56	110	75	13	10	3-M10×1
250	4	63.513	82.6	56	115.5	80	13	10	3-M10×1
200	5	82.563	104.8	56	110	75	15	12	6-M12×1
250	5	82.563	104.8	56	115.5	80	15	12	6-M12×1
300	5	82.563	104.8	56	128.5	85	15	12	6-M12×1
320	5	82.563	104.8	56	134	90	15	12	6-M12×1
250	6	106.375	133.4	75	115.5	80	16	13	6-M16×1.5
300	6	106.375	133.4	75	128.5	85	16	13	6-M16×1.5
320	6	106.375	133.4	75	134	90	16	13	6-M16×1.5
350	6	106.375	133.4	75	141	90	16	13	6-M16×1.5
400	6	106.375	133.4	75	143	95	16	13	6-M16×1.5
320	8	139.719	171.4	95	134	90	18	14	6-M20×1.5
350	8	139.719	171.4	95	141	90	18	14	6-M20×1.5
400	8	139.719	171.4	125	143	95	18	14	6-M20×1.5
450	8	139.719	171.4	125	147	100	18	14	6-M20×1.5
500	8	139.719	171.4	125	161	106	18	14	6-M20×1.5
400	11	196.869	235.0	160	143	95	20	16	6-M22×1.5
500	11	196.869	235.0	160	161	106	20	16	6-M22×1.5
630	11	196.869	235.0	180	180	115	20	16	6-M22×1.5
800	11	196.869	235.0	180	210	135	20	16	6-M22×1.5
1000	11	196.869	235.0	180	241	150	20	16	6-M22×1.5
630	15	285.775	330.2	180	180	115	21	17	6-M24×1.5
800	15	285.775	330.2	180	210	135	21	17	6-M24×1.5
1000	15	285.775	330.2	280	241	150	21	17	6-M24×1.5
1250	15	285.775	330.2	280	256	165	21	17	6-M24×1.5
1600	15	285.775	330.2	280	266	175	21	17	6-M24×1.5

Clamping Range

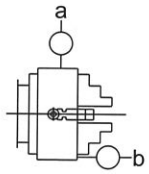
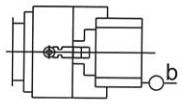
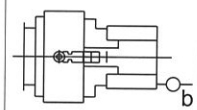


Unit:mm

SIZE D	Internal Jaw	External Jaw
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-25
300	20-156	100-300
320	20-170	100-315
350	20-206	100-350
400	25-250	118-400
500	35-300	125-500
630	50-400	160-630
800	70-540	200-800
1000	100-680	250-1000

Accuracy for 4 Jaw Independent Chuck

Unit:mm

Inspection Item		Chuck Dia. 80 100 125 160	200 250	300 320 350 400	450 500 630 800
	a	0.040	0.055	0.070	0.085
	b	0.040	0.060	0.075	0.100
	b	0.040	0.050	0.060	0.080
	b	0.040	0.050	0.060	0.080

Packing list for 4 Jaw Independent Chuck

No.		Description	QTY.
1		Chuck	1 pc.
2		Chuck wrench	1 pc.
3	Plain back	Mounting Screw	4 pieces
	Direct Mount Type A	Mounting Screw	4 pices
	Direct Mount Type C	Stud Locknut	C3 C4 3pcs C5 C6 C8 4pcs C11 C15 6pcs
	Direct Mount Type D	Camlock Pin	D3 D4 3pcs D5 D6 D8 6pcs D11 D15 6pcs
4		Instruction Manual	1

TEST CERTIFICATE

Model & Size: K72-250/c5

This chuck has been tested and be qualified for delivery.

Director: Alan

Chief of Inspection Dept.: Maria

Inspector: 2

Packer: 2

No.: 2025年 3月 8日