

Pratt Burnerd High Speed Quick Change 3 Jaw Power Chucks

Constant Grip Open Centre Power Chucks Sizes 6" (160mm) through 24" (610mm)



Shown with optional jaw setting fixture and hard reversible top jaws.

Jaw presetting fixture order number 1009-07090 for use with 160mm to 610mm sizes Standard Bore and Large Bore High Speed Quick Change Jaw Power Chucks.

① Insert last two digits for Master Jaw type.
Example 9131-21723...Indicates 1.5mm x 60° Master Jaw Required
Use 23 for 1.5mm x 60° Japanese type.**
Use 07 for Am. Std Tongue & Groove.
Use 10 for 1/16 X 90° Serrations.*
Use 26 for Acme Serration.
Use 27 for Square Serration.

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

- ±.12µm repeatability
- 3-Point adjusting feature in the chuck body permits indicating in to zero. Increase soft jaw life by using adjustment feature. Reduce or eliminate re-boring of soft jaws
- High RPM ... up to 6,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design
- Quick change base jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job reducing traditional setup time by 95%
- SAFE visual Indicator shows when master jaws are in the unlocked mode
- Utilise existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16 x 90, Am. Std. Acme, Am. Std tongue & groove and square serrations or substitute mono block jaws. Sets can be mixed styles
- Doubles as collet chuck as master jaws have keyed radius in front that accept standard W & S collet pads. Eliminate time wasted on switching over to collet chuck.
- Large Bore Capacity (Bore can be sealed for VTL use... page 38 and 39)
- Quick conversion to an expanding mandrel, ref. page 30
- Utilize the machine's existing actuating cylinder - does not require long stroke cylinder.
- Easy installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube or drawbar. PBI can supply chuck sleeve pre-threaded on request, at a nominal charge
- Optional jaw setting fixture (as shown) for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- Sizes 160mm to 610mm diameters
- Twelve month warranty

Chuck Size	Mount (D)Direct (I)ndirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Bore	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force kN	Grip Force kN	Wt (Kg)
160	A2-4(I)	6000	9131-217__	3.5	16	43	38	5/16" UNC	24	47	14
160	A2-5(D)	6000	9131-317__	3.5	16	43	38	5/16" UNC	24	47	14
160	A2-6(I)	6000	9131-417__	3.5	16	43	38	5/16" UNC	24	47	14
210	A2-5(I)	5500	9131-321__	3.5	16	52	51	5/16" UNC	24	66	24
210	A2-6(D)	5500	9131-421__	3.5	16	52	51	5/16" UNC	24	66	24
210	A2-8(I)	5500	9131-521__	3.5	16	52	51	5/16" UNC	24	66	24
254	A2-6(I)	5000	9131-426__	4	18.5	66	63	3/8" UNC	32	88	82
254	A2-8(D)	5000	9131-526__	4	18.5	66	63	3/8" UNC	32	88	82
305	A2-8(I)	4200	9131-531__	4	18.5	90	76	3/8" UNC	44	121	37
305	A2-11(D)	4200	9131-631__	4	18.5	90	76	3/8" UNC	44	121	37
380	A2-8(I)	3000	9131-538__	5	20	126	114	3/8" UNC	60	139	127
380	A2-11(D)	3000	9131-638__	5	20	126	114	3/8" UNC	60	139	127
460	A2-8(I)	2500	9131-546__	6	25	142	139	1/2" UNC	69	170	170
460	A2-11(I)	2500	9131-646__	6	25	142	139	1/2" UNC	69	170	170
500	A2-11(I)	2500	9131-650__	6	25	142	139	1/2" UNC	69	170	250
610	A2-11(I)	1800	9131-660__	8	25	160	158	1/2" UNC	92	170	345
610	A2-15(D)	1800	9131-760__	8	25	160	158	1/2" UNC	92	170	345

Big Bore Quick-Change Chucks

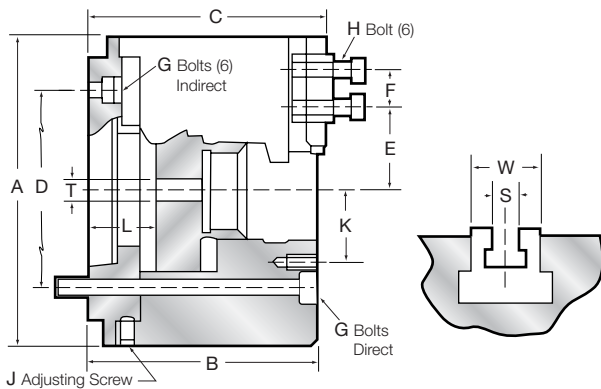
210	A2-6(D)	5500	9171-421__	3.5	16	66	63	5/16" UNC	24	66	53
265	A2-6(I)	5000	9171-426__	4	18.5	77	76	3/8" UNC	32	88	82
265	A2-8(D)	5000	9171-526__	4	18.5	77	76	3/8" UNC	32	88	82

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

Dimensional and Performance Data

Chuck Size A	mtg	B	C	D	F	E		G	H	J	K	L			
						Max	Min					Min	Max	S	W
165mm	A4	119	122	82.5	20	54	34	M10x25(6)	M10x25	5/16 UNFx1/2	76	24	40	12	31
165mm	A5	123	126	104.8	20	54	34	M10x130(3)	M10x25	5/16 UNFx1/2	76	28	44	12	31
165mm	A6	129	132	133.4	20	54	34	M12x30(6)	M10x25	5/16 UNFx1/2	76	38	54	12	31
210mm	A5	130	134	104.8	25	67	44	M10x30(6)	M12x35	3/8 UNFx3/4	100	25	41	14	40
210mm	A6	136	140	133.4	25	67	44	M12x130(3)	M12x35	3/8 UNFx3/4	100	30	46	14	40
210mm	A8	145	149	171.5	25	67	44	M16x30(6)	M12x35	3/8 UNFx3/4	100	51	45	14	40
254mm	A6	140	144	133.4	30	83	53	M12x35(6)	M12x35	1/2 UNFx3/4	115	26	55	16	40
254mm	A8	150	154	171.5	30	83	53	M16x150(3)	M12x35	1/2 UNFx3/4	115	36	52	16	40
305mm	A8	168	172	171.5	30	109	60	M16x40(6)	M14x45	1/2 UNFx3/4	145	33	52	18	46
305mm	A11	168	172	235.0	30	109	60	M20x160(3)	M14x45	1/2 UNFx3/4	145	33	52	18	46
380mm	A8	176	180	171.5	43	127	82	M16x35(6)	M20x55	1/2 UNFx3/4	180/300	35	55	22	60
380mm	A11	176	180	235.0	43	127	82	M20x180(6)	M20x55	1/2 UNFx3/4	180/300	35	60	22	60
460mm	A8	196	198	171.5	43	172	115	M16x40(6)	M20x55	1/2 UNFx3/4	220/320	35	60	25	60
460mm	A11	196	198	235.0	43	172	115	M20x35(6)	M20x55	1/2 UNFx3/4	220/320	35	60	25	60
500mm	A11	187	191	235.0	60	205	129	M20x45(6)	M20x35	1/2 UNFx3/4	220/310	35	60	25	60
610mm	A11	192	196	235.0	60	256	146	M20x45(6)	M20x35	1/2 UNFx3/4	***	40	65	25	60
610mm	A15	192	196	330.2	60	256	146	7/8-9x8(6)	M20x35	1/2 UNFx3/4	***	40	65	25	60

***240mm/330mm/420mm/510mm



(T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service Mono block jaws are made from a nitride hardening material to allow hardening after forming without major distortion.

Mono Block Jaws
See page 46 for Dimensions.

Extra Sets of Master Jaws for Quick Change Power Chucks

	6"	8"	10"	12"	15"	18"	20"	24"
Master Jaw Type - 1.5mm x 60° Fine Serration (Japanese Type)	8130-17623	8130-21623	8130-26623	8130-31623	8130-40623	8130-46623	8130-50623**	8130-61623**
1/16 x 90° Fine serration (European Type)	8130-17610	8130-21610	8130-26610	8130-31610	8130-38610*	8130-46610*	8130-50610*	8130-61610*
Acme Serration	N/A	8130-21626	8130-26626	8130-31626	8130-40626	8130-46626	8130-50626	8130-61626
American Std. Tongue & Groove	8130-17607	8130-21607	8130-26607	8130-31607	8130-38607	8130-46607	8130-50607	8130-61607
Square Serration	N/A	8130-21627	8130-26627	8130-31627	8130-38627	8130-46627	8130-50627	8130-61627
Mono Block Jaw***	8130-17601P	8130-21601	8130-26601	8130-31601	8130-38601	8130-46601	8130-50601	8130-61601

**500mm & 610mm diameter chucks supplied with 3mm x 60° serrations
*** Also available in longer pointed design

* 380mm to 610mm diameter chucks supplied with 3/32" x 90° serrations