

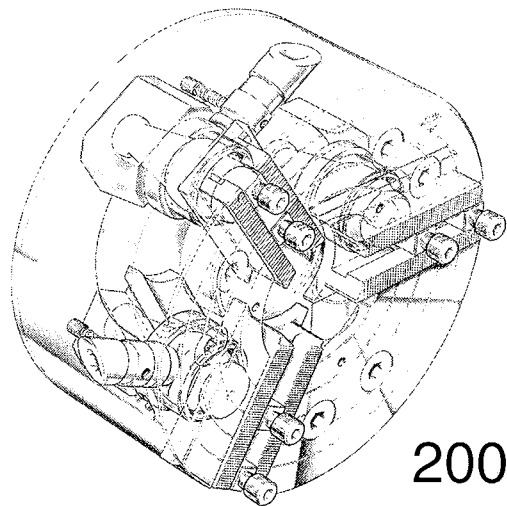
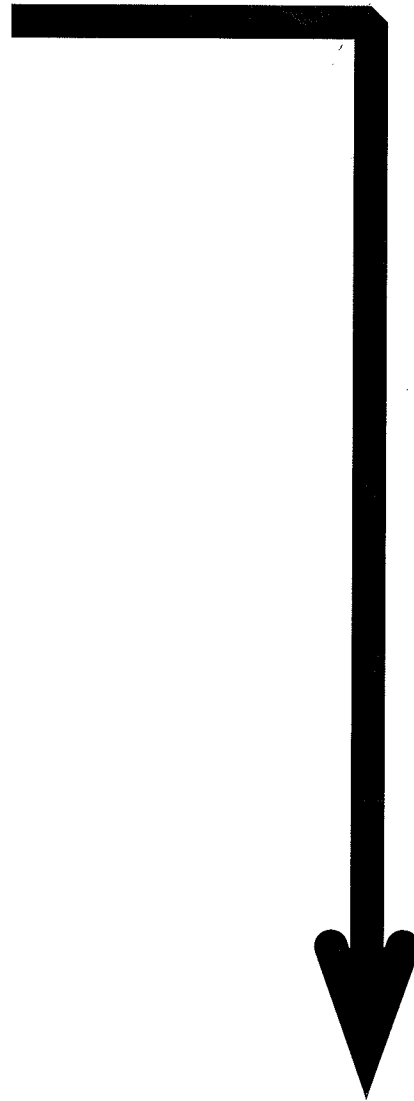
1914

The HANDBOOK

Technical, dimensional
and general information
through the years.

OCTOBER 2002

Please use 'Catalogue Numbers'
publication for chuck identification.



Pratt Burnerd International

2002

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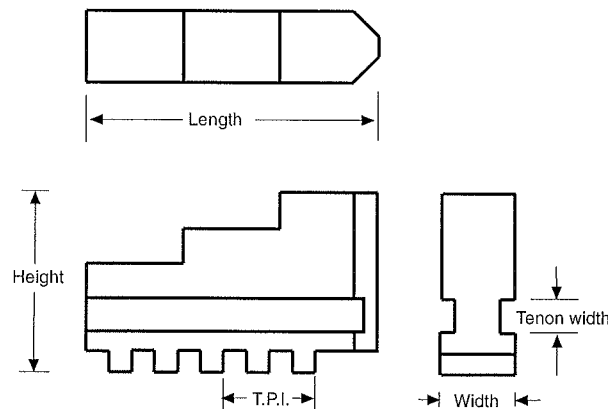
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Please note - chuck catalogue numbers are now published in a separate booklet.

INSIDE JAWS (1)

Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / Notes
31/32"	5/8"	3/8"	1/8"	12	3	2460-05603	2.75" Lever Scroll. Obs.
1 3/16"	1"	3/8"	3/16"	6	3	2580-06603	2.75" Lever Scroll. Obs.
1 3/16"	1"	3/8"	1/8"	6	3	2460-07603	3" Lever Scroll. Obsolete
1 7/32"	1 1/16"	7/16"	3/16"	6	3 or 4	-	(3" Pratt) obsolete.
1 1/8"	1 1/8"	3/8"	3/16"	6	3	2580-08603	80mm / 3" Burnerd
1 1/8"	1 1/8"	3/8"	3/16"	6	4	2590-08603	80mm / 3" Burnerd. Obsolete
1 5/8"	1 3/8"	9/16"	3/16"	4	3	2588-14071	5" Hardinge 30AHC
1 7/16"	1 7/32"	9/16"	3/16"	5	3	2580-10603	100mm / 4" Burnerd
1 7/16"	1 7/32"	9/16"	3/16"	5	4	2590-10603	100mm / 4" Burnerd. Obsolete
1 5/8"	1 1/4"	9/16"	3/16"	6	3	2460-10603	4" Lever Scroll. Obsolete
1 23/32"	1 7/16"	9/16"	7/32"	4	3 or 4	-	(4" Pratt) obsolete.
1 7/8"	1 1/2"	5/8"	5/16"	4	3	2210-13603	125mm / 5"
1 7/8"	1 1/2"	5/8"	5/16"	4	4	2230-13603	125mm / 5"
1 7/8"	1 1/2"	5/8"	5/16"	4	6	2260-13603	125mm / 5", Obsolete
1 29/32"	1 9/16"	19/32"	7/32"	4	3 or 4	-	(5" Pratt) obsolete.
2"	1 5/8"	5/8"	5/16"	4	3	2580-14603	5" BP. Use 2210-13603
2"	1 5/8"	5/8"	5/16"	4	4	2590-14603	5" BP. Use 2230-13603
2"	1 5/8"	5/8"	5/16"	4	6	2640-14603	5" BP. Use 2260-13603
2 3/8"	1 25/32"	23/32"	5/16"	3	3 or 4	-	5" Pratt. Obsolete
2 15/32"	1 3/4"	3/4"	5/16"	4	3	2580-16603	6" BP. Use 2210-17603
2 15/32"	1 3/4"	3/4"	5/16"	4	4	2590-16603	6" BP. Use 2230-17603
2 15/32"	1 3/4"	3/4"	5/16"	4	6	2640-16603	6" BP. Use 2260-17603
2 1/4"	1 11/16"	3/4"	5/16"	4	3	2210-17603	160mm / 6"
2 1/4"	1 11/16"	3/4"	5/16"	4	4	2230-17603	160mm / 6". Obsolete
2 1/4"	1 11/16"	3/4"	5/16"	4	6	2260-17603	160mm / 6". Obsolete
2 15/16"	2 7/32"	.9845"	.3816"	3	3,4 or 6	2580-19603	7.5"/8" BP. Obsolete
2 15/16"	2 7/32"	13/16"	3/8"	3	3	2780-19603	7.5" Pratt. Use 2210-20603
2 15/16"	2 7/32"	13/16"	3/8"	3	4	2790-19603	7.5" Pratt. Use 2230-20603
2 13/16"	2 1/16"	13/16"	3/8"	3	3	2210-20603	200mm / 8"
2 13/16"	2 1/16"	13/16"	3/8"	3	4	2230-20603	200mm / 8". Obsolete
2 13/16"	2 1/16"	13/16"	3/8"	3	6	2260-20603	200mm / 8"
3 1/2"	2 7/32"	.9845"	.3816"	3	3 or 4	2580-23603	9" BP. Obsolete

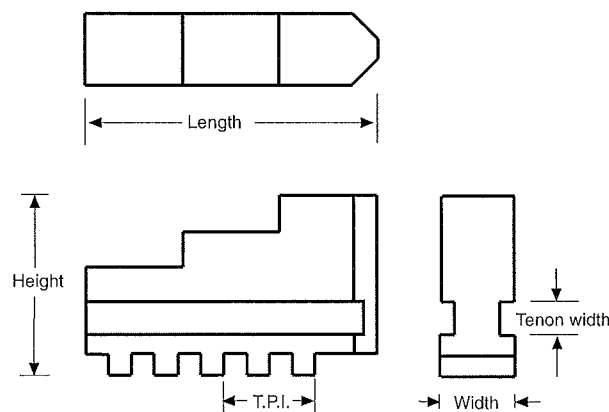
Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length will differ slightly.



INSIDE JAWS (2)

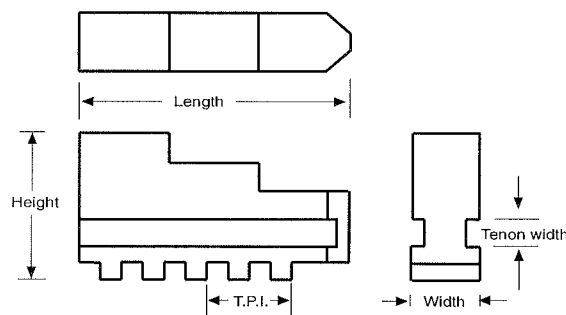
Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / Notes
3 1/2"	2 7/16"	1"	3/8"	3	3	2780-23603	9" 78 Pratt. Obsolete
3 1/2"	2 7/16"	1"	3/8"	3	4	2790-23603	9" 79 Pratt. Obsolete
3 3/8"	2 5/16"	1"	7/16"	3	3	2210-25603	250mm / 10"
3 3/8"	2 5/16"	1"	7/16"	3	4	2230-25603	250mm / 10". Obsolete
3 3/8"	2 5/16"	1"	7/16"	3	6	2260-25603	250mm / 10"
3 29/32"	2 3/4"	1"	7/16"	3	3	2780-27603	10.5" use 2210-25603
3 29/32"	2 3/4"	1"	7/16"	3	4	2790-27603	10.5" use 2230-25603
4"	2 15/16"	1 1/4"	1/2"	3	3, 4 or 6	2580-27603	10.5" / 12" BP. Obsolete
4 1/8"	2 31/32"	1 3/16"	15/32"	3	3	2780-31603	12" 78 Pratt. Obsolete
4 1/8"	2 31/32"	1 3/16"	15/32"	3	4	2790-31603	12" 79 Pratt. Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	3	2210-32603	315mm / 12"
4 1/8"	2 11/16"	1 1/8"	1/2"	3	4	2230-32603	315mm / 12". Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	6	2260-32603	315mm / 12". Obsolete
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	3	2580-38603	15" 58/78 Pratt. Obsolete
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	4	2590-38603	15" 58/78 Pratt. Obsolete
5 7/8"	3 7/16"	1 1/2"	9/16"	2	3	2580-46603	18"- 24" 58/78 Pratt
5 7/8"	3 7/16"	1 1/2"	9/16"	2	4	2590-46603	18"- 24" 59/79 Pratt
Metric SP & Standard Accuracy (1991)				Teeth Pitch			
35.5mm	27mm	10mm	5.1mm	6mm	3	8210-08603	80mm
35.5mm	34mm	14mm	7.1mm	6mm	3	8210-10603	100mm
51.5mm	36mm	16mm	7.1mm	6mm	3	8210-13603	125mm
66.0mm	42mm	18mm	7.1mm	6mm	3	8210-17603	160mm
83.0mm	54mm	22mm	8.1mm	8mm	3	8210-20603	200mm
97.5mm	58mm	25mm	8.1mm	8mm	3	8210-25603	250mm
123.0mm	71mm	32mm	12.1mm	10mm	3	8210-32603	315mm
152.5mm	86mm	32mm	12.1mm	12mm	3	8210-40603	400mm
188.5mm	95mm	42mm	15mm	12mm	3	8580-50603	500mm

Manufacturing dimensions may have been amended on some old style jaws.
In these instances the height and length will differ slightly.



Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / notes
31/32"	5/8"	3/8"	1/8"	12	3	2460-05602	2.75" Lever scroll. Obs.
1 3/16"	1"	3/8"	3/16"	6	3	2580-06602	2.75" . Obsolete
1 3/16"	1"	3/8"	1/8"	6	3	2460-07602	3" Lever Scroll
1 7/32"	1 1/16"	7/16"	3/16"	6	3 or 4	-	3" Pratt. Obsolete
1 1/8"	1 1/8"	3/8"	3/16"	6	3	2580-08602	80mm / 3"
1 1/8"	1 1/8"	3/8"	3/16"	6	4	2590-08602	80mm / 3". Obsolete
1 5/8"	1 3/8"	9/16"	3/16"	4	3	2588-14070	5" Hardinge 30AHC
1 7/16"	1 7/32"	9/16"	3/16"	5	3	2580-10602	100mm / 4"
1 7/16"	1 7/32"	9/16"	3/16"	5	4	2590-10602	100mm / 4". Obsolete
1 5/8"	1 1/4"	9/16"	3/16"	6	3	2460-10602	4" Lever Scroll
1 23/32"	1 7/16"	9/16"	7/32"	4	3 or 4	-	4" Pratt. Obsolete
1 7/8"	1 1/2"	5/8"	5/16"	4	3	2210-13602	125mm / 5"
1 7/8"	1 1/2"	5/8"	5/16"	4	4	2230-13602	125mm / 5"
1 7/8"	1 1/2"	5/8"	5/16"	4	6	2260-13602	125mm / 5"
1 29/32"	1 9/16"	19/32"	7/32"	4	3 or 4	-	5" Pratt. Obsolete
2"	1 5/8"	5/8"	5/16"	4	3	2580-14606	5" Use 2210-13602
2"	1 5/8"	5/8"	5/16"	4	4	2590-14606	5" Use 2230-13602
2"	1 5/8"	5/8"	5/16"	4	6	2640-14606	6" Use 2260-13602
2 3/8"	1 25/32"	23/32"	5/16"	3	3 or 4	-	6" Pratt. Obsolete
2 15/32"	1 3/4"	3/4"	5/16"	4	3	2580-16602	6" BP. Use 2210-17602
2 15/32"	1 3/4"	3/4"	5/16"	4	4	2590-16602	6" BP. Use 2230-17602
2 15/32"	1 3/4"	3/4"	5/16"	4	6	2640-16602	6" BP. Use 2260-17602
2 1/4"	1 11/16"	3/4"	5/16"	4	3	2210-17602	160mm / 6"
2 1/4"	1 11/16"	3/4"	5/16"	4	4	2230-17602	160mm / 6"
2 1/4"	1 11/16"	3/4"	5/16"	4	6	2260-17602	160mm / 6"
2 15/16"	2 7/32"	.9845"	.3816"	3	3,4 or 6	2580-19602	7.5" /8" BP. Obsolete
2 15/16"	2 7/32"	13/16"	3/8"	3	3	2780-19602	7.5" 78 use 2210-20602
2 15/16"	2 7/32"	13/16"	3/8"	3	4	2790-19602	7.5" 79 use 2230-20602
2 13/16"	2 1/16"	13/16"	3/8"	3	3	2210-20602	200mm / 8"
2 13/16"	2 1/16"	13/16"	3/8"	3	4	2230-20602	200mm / 8"
2 13/16"	2 1/16"	13/16"	3/8"	3	6	2260-20602	200mm / 8"
3 1/2"	2 7/32"	.9845"	.3816"	3	3 or 4	2580-23602	9" BP. Obsolete

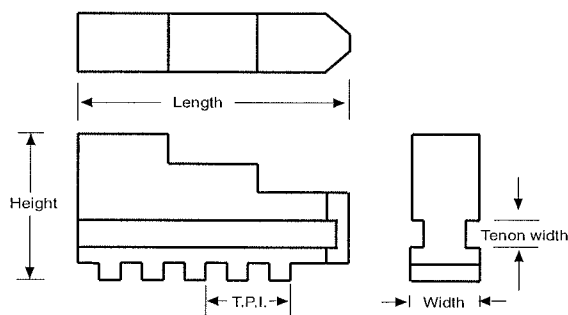
Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length will differ slightly.



OUTSIDE JAWS (2)

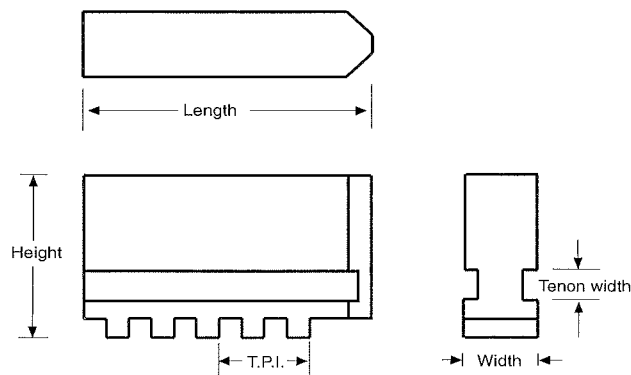
Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / notes
3 1/2"	2 7/16"	1"	3/8"	3	3	2780-23602	9" 78 Pratt. Obsolete
3 1/2"	2 7/16"	1"	3/8"	3	4	2790-23602	9" 79 Pratt. Obsolete
3 3/8"	2 5/16"	1"	7/16"	3	3	2210-25602	250mm / 10"
3 3/8"	2 5/16"	1"	7/16"	3	4	2230-25602	250mm / 10". Obsolete
3 3/8"	2 5/16"	1"	7/16"	3	6	2260-25602	250mm / 10"
3 29/32"	2 3/4"	1"	7/16"	3	3	2780-27602	10.5" (use 2210-25602)
3 29/32"	2 3/4"	1"	7/16"	3	4	2790-27602	10.5" (use 2230-25602)
4"	2 15/16"	1 1/4"	1/2"	3	3,4 or 6	2580-27602	10.5" / 12" BP. Obs.
4 1/8"	2 31/32"	1 3/16"	15/32"	3	3	2780-31602	12" 78 Pratt. Obsolete
4 1/8"	2 31/32"	1 3/16"	15/32"	3	4	2790-31602	12" 79 Pratt. Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	3	2210-32602	315mm / 12"
4 1/8"	2 11/16"	1 1/8"	1/2"	3	4	2230-32602	315mm / 12". Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	6	2260-32602	315mm / 12"
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	3	2580-38602	15" 58 / 78 Pratt. Obs.
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	4	2590-38602	15" 59 / 79 Pratt. Obs.
5 7/8"	3 7/16"	1 1/2"	9/16"	2	3	2580-46602	18"-24" 58 / 78 Pratt
5 7/8"	3 7/16"	1 1/2"	9/16"	2	4	2590-46602	18"-24" 59 / 79 Pratt
Metric SP & Standard Accuracy (1991)				Teeth Pitch			
35.5mm	27mm	10mm	5.1mm	6mm	3	8210-08602	80mm
35.5mm	34mm	14mm	7.1mm	6mm	3	8210-10602	100mm
51.5mm	36mm	16mm	7.1mm	6mm	3	8210-13602	125mm
66.0mm	42mm	18mm	7.1mm	6mm	3	8210-17602	160mm
83.0mm	54mm	22mm	8.1mm	8mm	3	8210-20602	200mm
97.5mm	58mm	25mm	8.1mm	8mm	3	8210-25602	250mm
123.0mm	71mm	32mm	12.1mm	10mm	3	8210-32602	315mm
152.5mm	86mm	32mm	12.1mm	12mm	3	8210-40602	400mm
188.5mm	95mm	42mm	15mm	12mm	3	8580-50602	500mm

Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length will differ slightly.



Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / notes
31/32"	5/8"	3/8"	1/8"	12	3	2460-05606	2.5". Obsolete
1 3/16"	1"	3/8"	3/16"	6	3	2580-06606	2.75" . Obsolete
1 3/16"	1"	3/8"	1/8"	6	3	2460-07606	2.75" Lever Scr. Obsolete
1 1/4"	1 1/8"	7/16"	3/16"	6	3 or 4	-	3" Pratt. Obsolete
1 7/32"	1 1/8"	3/8"	3/16"	6	3	2580-08606	80mm / 3"
1 7/32"	1 1/8"	3/8"	3/16"	6	4	2590-08606	80mm / 3". Obsolete
1 5/8"	1 3/8"	9/16"	3/16"	4	3	2588-14066	Hardinge 30AHC
1 7/16"	1 7/32"	9/16"	3/16"	5	3	2580-10606	100mm / 4"
1 7/16"	1 7/32"	9/16"	3/16"	5	4	2590-10606	100mm / 4". Obsolete
1 5/8"	1 1/4"	9/16"	3/16"	6	3	2460-10606	4" Lever Scroll. Obsolete
1 3/16"	1 1/2"	9/16"	7/32"	4	3 or 4	-	4" Pratt. Obsolete
1 7/8"	1 1/2"	5/8"	5/16"	4	3	2210-13606	125mm / 5"
1 7/8"	1 1/2"	5/8"	5/16"	4	4	2230-13606	125mm / 5". Obsolete
1 7/8"	1 1/2"	5/8"	5/16"	4	6	2260-13606	125mm / 5"
1 29/32"	1 9/16"	19/32"	7/32"	4	3 or 4	-	5" Pratt. Obsolete
2"	1 5/8"	5/8"	5/16"	4	3	2580-14606	5" BP. Use 2210-13606
2"	1 5/8"	5/8"	5/16"	4	4	2590-14606	5" BP. Use 2230-13606
2"	1 5/8"	5/8"	5/16"	4	6	2640-14606	5" BP. Use 2260-13606
2 7/16"	1 27/32"	23/32"	5/16"	3	3 or 4	-	6" Pratt Obsolete
2 15/32"	1 3/4"	3/4"	5/16"	4	3	2580-16606	6" BP. Use 2210-17606
2 15/32"	1 3/4"	3/4"	5/16"	4	4	2590-16606	6" BP. Use 2230-17606
2 15/32"	1 3/4"	3/4"	5/16"	4	6	2640-16606	6" BP. Use 2260-17606
2 1/4"	1 3/4"	3/4"	5/16"	4	3	2210-17606	160mm / 6"
2 1/4"	1 3/4"	3/4"	5/16"	4	4	2230-17606	160mm / 6". Obsolete
2 1/4"	1 3/4"	3/4"	5/16"	4	6	2260-17606	160mm / 6"
2 15/16"	2 7/32"	.9845"	.3816"	3	3,4 or 6	2580-19606	7.5" / 8" BP Obsolete
2 15/16"	2 9/32"	13/16"	3/8"	3	3	2780-19606	7.5" Pratt Use 2210-20606
2 15/16"	2 9/32"	13/16"	3/8"	3	4	2790-19606	7.5" Pratt Use 2230-20606
2 13/16"	2 1/8"	13/16"	3/8"	3	3	2210-20606	7.5" Pratt. 200mm / 8"
2 13/16"	2 1/8"	13/16"	3/8"	3	4	2230-20606	200mm / 8". Obsolete
2 13/16"	2 1/8"	13/16"	3/8"	3	6	2260-20606	200mm / 8"

Manufacturing dimensions may have been amended on some old style jaws.
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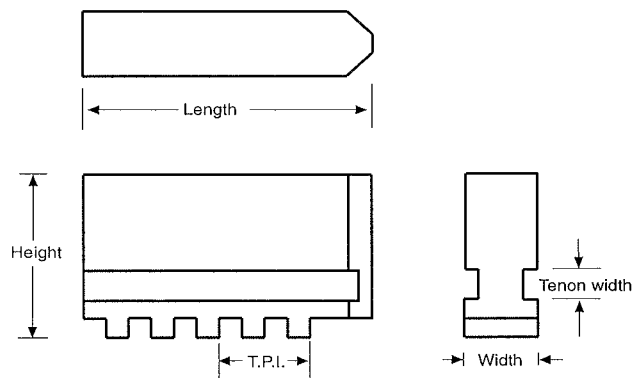




SOFT JAWS (2) SCROLL CHUCKS

Length	Height	Width	Tenon Width	Teeth per inch	Jaws per set	Cat. No.	Chuck size / notes
3 1/2"	2 7/32"	.9845"	.3816"	3	3 or 4	2580-23606	9" BP. Obsolete
3 9/16"	2 1/2"	1"	3/8"	3	3	2780-23606	9" 78 Pratt. Obsolete
3 9/16"	2 1/2"	1"	3/8"	3	4	2790-23606	9" 79 Pratt. Obsolete
3 3/8"	2 3/8"	1"	7/16"	3	3	2210-25606	250mm / 10"
3 3/8"	2 3/8"	1"	7/16"	3	4	2230-25606	250mm / 10". Obsolete
3 3/8"	2 3/8"	1"	7/16"	3	6	2260-25606	250mm / 10"
3 29/32"	2 13/16"	1"	7/16"	3	3	2780-27606	Use 2210-25606
3 29/32"	2 13/16"	1"	7/16"	3	4	2790-27606	Use 2230-25606
4"	2 15/16"	1 1/4"	1/2"	3	3,4 or 6	2580-27606	10.5"/12" BP Obsolete
4 3/16"	3"	1 3/16"	15/32"	3	3	2780-31606	12" 78 Pratt. Obsolete
4 3/16"	3"	1 3/16"	15/32"	3	4	2790-31606	12" 79 Pratt. Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	3	2210-32606	315mm / 12"
4 1/8"	2 11/16"	1 1/8"	1/2"	3	4	2230-32606	315mm / 12". Obsolete
4 1/8"	2 11/16"	1 1/8"	1/2"	3	6	2260-32606	315mm / 12"
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	3	2580-38606	15" 58 / 78 Pratt. Obsolete
4 7/8"	3 3/32"	1 3/16"	15/32"	2.5	4	2590-38606	15" 59 / 79 Pratt. Obsolete
5 7/8"	3 7/16"	1 1/2"	9/16"	2	3	2580-46606	18"-24" 58 / 78 Pratt
5 7/8"	3 7/16"	1 1/2"	9/16"	2	4	2590-46606	18"-24" 59 / 79 Pratt
Metric SP & Standard Accuracy (1991)				Teeth Pitch			
37.2mm	27mm	10mm	5.1mm	6mm	3	8210-08606	80mm
43.2mm	34mm	14mm	7.1mm	6mm	3	8210-10606	100mm
53.2mm	36mm	16mm	7.1mm	6mm	3	8210-13606	125mm
67.9mm	42mm	18mm	7.1mm	6mm	3	8210-17606	160mm
75.9mm	54mm	22mm	8.1mm	8mm	3	8210-20606	200mm
99.4mm	58mm	25mm	8.1mm	8mm	3	8210-25606	250mm
124.0mm	71mm	32mm	12.1mm	10mm	3	8210-32606	315mm
153.5mm	86mm	32mm	12.1mm	12mm	3	8210-40606	400mm
190mm	95mm	42mm	15mm	12mm	3	8580-50606	500mm

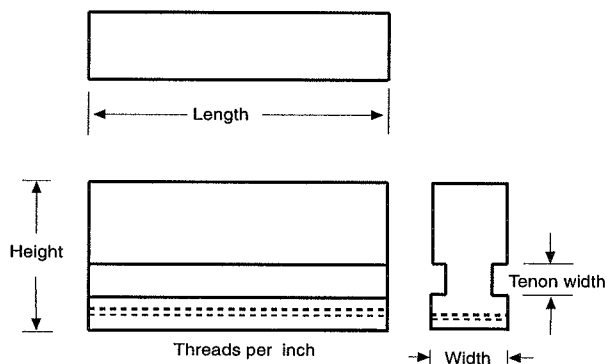
Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length will differ slightly.



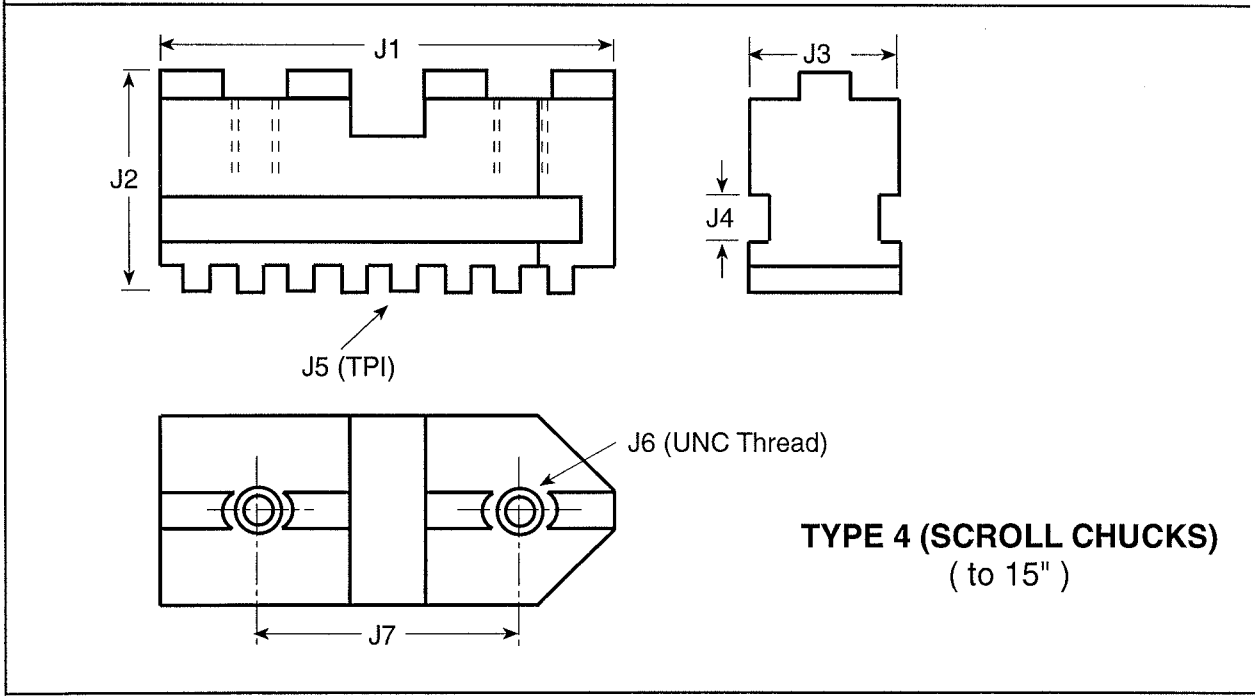
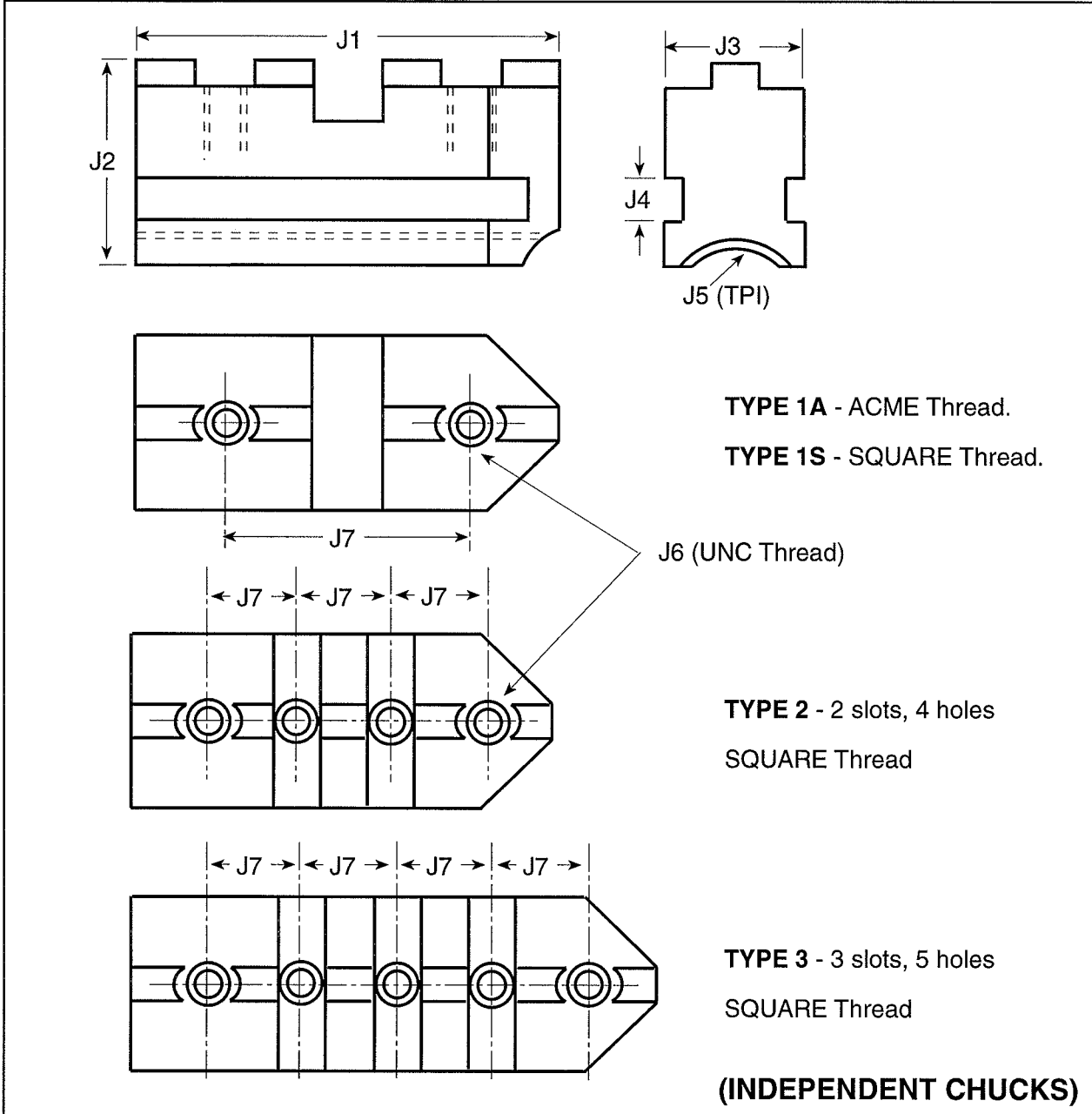
SOFT JAWS (3) INDEPENDENT CHUCKS

Length	Height	Width	Tenon Width	Threads per inch	Cat. No.	Chuck size / notes
1 3/8"	1 7/32"	3/8"	1/8"	11 (whit)	2520-08606	3" / 4" Light Type
1 15/16"	1 5/8"	3/4"	9/32"	8	2550-12606	Obsolete
2"	1 3/8"	5/8"	3/16"	8	2540-14606	5" / 6" Light Type
2 3/16"	1 31/32"	15/16"	5/16"	8	2550-16606	6" 55 Acme *
2 15/32"	1 23/32"	3/4"	5/16"	8	2540-21606	8" Light Type
3 1/4"	2 9/32"	1 3/16"	3/8"	6	2550-21606	8" 55 Acme *
3 1/4"	2"	1"	3/8"	6	2540-26606	10" Light Type
3 7/16"	2 5/8"	1 3/8"	3/8"	6	2550-26606	10" 55 Acme *
4"	3"	1 1/2"	7/16"	5	2550-31606 #	12" 55 Acme *
4 3/8"	3 1/16"	1 11/16"	1/2"	5	2350-31606	12" 1935 St. Ind.
4 7/16"	3 1/4"	1 1/2"	7/16"	5	2550-35606 #	14" 55 Acme *
5 3/16"	3 9/16"	1 11/16"	1/2"	5	2550-46606	18" - 20" 55
5 11/16"	4 1/16"	1 15/16"	9/16"	5	2350-40606 §	16" / 18" 1935
6 15/16"	4 3/4"	1 15/16"	9/16"	5	2550-76606 §	24" - 28" 55
6 15/16"	4 7/8"	2 1/4"	5/8"	5	2350-56606 †	(1 1/2" dia. screws)
7"	4 7/8"	2 1/4"	5/8"	5	2350-51606 ††	(1 3/4" dia. screws)
7 15/16"	5 1/4"	2 1/4"	5/8"	5	2550-92606 †	(1 1/2" dia. screws)
7 15/16"	5 1/4"	2 1/4"	5/8"	5	2550-94606 ††	(1 3/4" dia. screws)
7 15/16"	5 15/16"	2 3/4"	7/8"	5	2350-81606	32" 1935
METRIC INDEPENDENT JAWS				Pitch		
47mm	40mm	24mm	10.5mm	3mm	2500-17606	160mm
75mm	54mm	32mm	12.5mm	4mm	2500-20606	200mm/250mm
100mm	63mm	36mm	15.5mm	4mm	2500-32606	315mm/400mm
§ Interchangeable		# Interchangeable		† and †† can be interchanged on same dia. screws.		
* Earlier jaws manufactured in square thread. These are no longer available. To service chucks still fitted with square thread parts, ACME thread JAWS AND SCREWS will be required.						

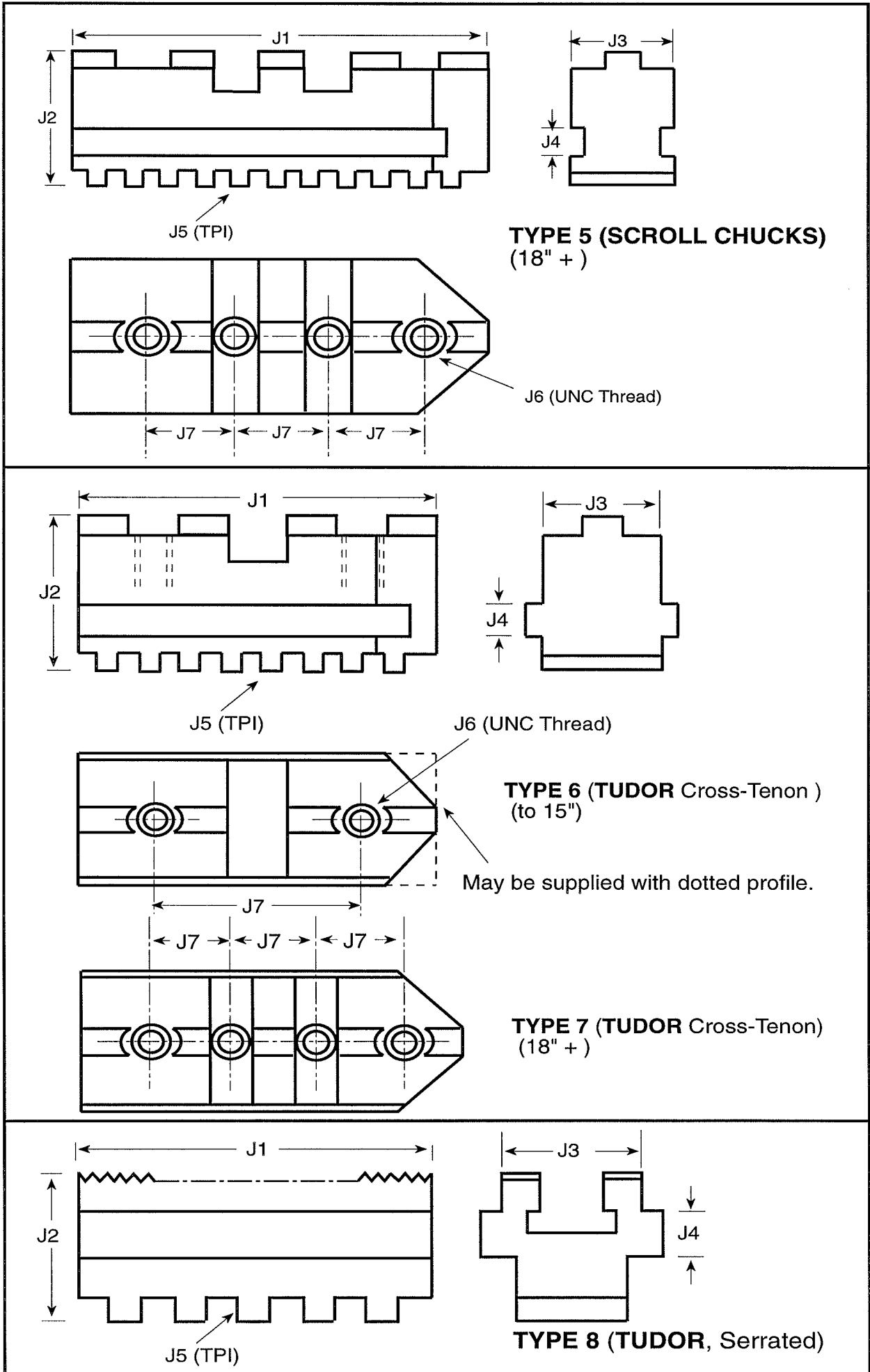
Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length will differ slightly.



BASE JAWS - TYPES 1 to 4



BASE JAWS - TYPES 5 to 8



Chuck type	J1 Length	J2 Height	J3 Width	J4 Tenon	J5 TPI	J6 Hole	J7 Hole Centres	Jaws per set	TYPE	Cat. No.
6" 55	2 17/32"	1 3/16"	15/16"	5/16"	8	3/8"unc	1 1/2"	4	1A	2550-16607
8" 55	3"	1 1/8"	1 3/16"	3/8"	6	3/8"unc	1 3/4"	4	1A	2550-21607
9" 1935	3"	1 3/8"	1 3/8"	3/8"	6	3/8"unc	1 3/4"	4	1A	2350-23607
10" 55	3 19/32"	1 5/8"	1 3/8"	3/8"	6	1/2"unc	2 1/8"	4	1A	2550-26607
12" 55	4 3/16"	1 11/16"	1 1/2"	7/16"	5	1/2"unc	2 1/2"	4	1A	2550-31607
12" 1935	4 3/16"	1 3/4"	1 11/16"	1/2"	5	1/2"unc	2 1/2"	4	1S	2350-31607
14"/16"	4 15/16"	1 3/4"	1 1/2"	7/16"	5	5/8"unc	3"	4	1A	2550-35607
15" 1935	4 15/16"	2 1/8"	1 11/16"	1/2"	5	3/4"unc	3"	4	1S	2350-38607
16"/30"	5"	2 3/16"	1 15/16"	9/16"	5	3/4"unc	3"	4	1S	2350-40607
18" 55	6 7/16"	2 1/8"	1 11/16"	1/2"	5	3/4"unc	1 1/2"	4	2	2550-46607
20" 56	6 7/16"	2 3/16"	1 15/16"	9/16"	5	3/4"unc	1 1/2"	4	2	2560-51607
20" 1935	6 7/16"	2 3/8"	2 1/4"	5/8"	5	3/4"unc	1 1/2"	4	2	2350-51607 (for 1 3/4" dia.screw)
25" 1935	6 7/16"	2 3/8"	2 1/4"	5/8"	5	3/4"unc	1 1/2"	4	2	2350-63607 (for 1 1/2" dia.screw)
22"/30"	7 15/16"	2 3/16"	1 15/16"	9/16"	5	3/4"unc	1 1/2"	4	3	2550-76607
36" 55	7 15/16"	2 3/8"	2 1/4"	5/8"	5	3/4"unc	1 1/2"	4	3	2550-92607 (for 1 1/2" dia. screw)
26" 1935	7 15/16"	2 3/8"	2 1/4"	5/8"	5	3/4"unc	1 1/2"	4	3	2350-66607 (for 1 3/4" dia. screw)
32" 1935	7 15/16"	3"	2 3/4"	7/8"	5	3/4"unc	1 1/2"	4	3	2350-81607
SCROLL CHUCKS										
4" 30	1 3/4"	11/16"	9/16"	3/16"	5	1/4"unc	3/4"	3	4	2580-10607
4"30Y	1 3/4"	11/16"	9/16"	3/16"	5	1/4"unc	3/4"	4	4	2590-10607
125mm	2 1/8"	29/32"	5/8"	5/16"	4	5/16"unc	7/8"	3	4	2210-13607
125mm	2 1/8"	29/32"	5/8"	5/16"	4	5/16"unc	7/8"	4	4	2230-13607
7.5" 78	2 17/32"	1 3/32"	13/16"	3/8"	3	3/8"unc	1 1/2"	3	4	2780-19607



BASE JAWS (2) SCROLL CHUCKS

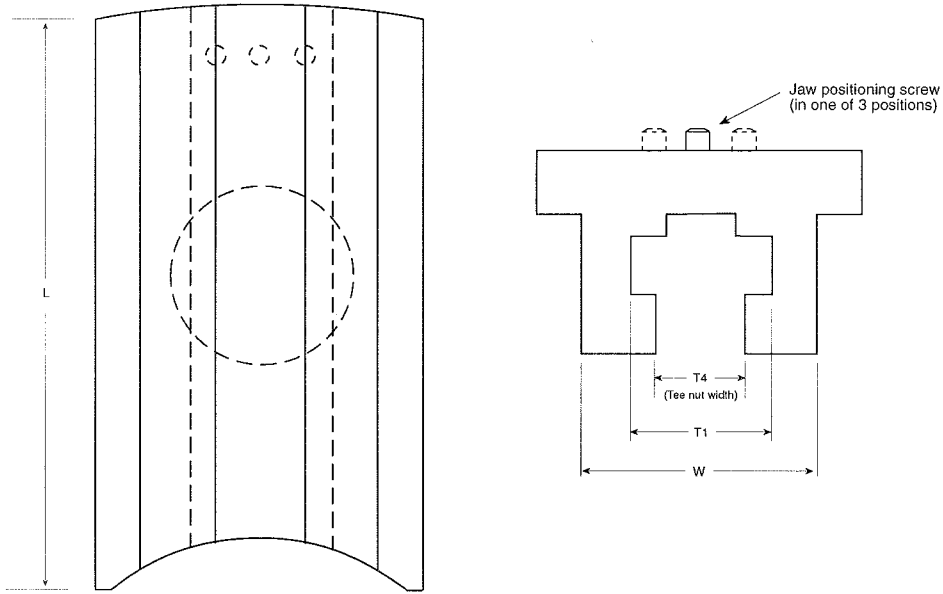
Chuck type	J1 Length	J2 Height	J3 Width	J4 Tenon	J5 TPI	J6 Hole	J7 Hole Centres	Jaws per set	TYPE	Cat. No.
Scroll chucks continued										
7.5" 79	2 17/32"	1 3/32"	13/16"	3/8"	3	3/8"unc	1 1/2"	4	4	2790-19607
7.5" BP	3"	1.3"	.9845	3/8"	3	3/8"unc	1 3/4"	3	4	2580-19607
160mm	2 1/4"	1"	3/4"	5/16"	4	3/8"unc	1 1/2"	3	4	2210-17607
160mm	2 1/4"	1"	3/4"	5/16"	4	3/8"unc	1 1/2"	4	4	2230-17607
200mm	3 1/16"	1 1/8"	13/16"	3/8"	3	3/8"unc	1 3/4"	3	4	2210-20607
200mm	3 1/16"	1 1/8"	13/16"	3/8"	3	3/8"unc	1 3/4"	4	4	2230-20607
9" 78	3 19/32"	1 1/4"	1"	3/8"	3	1/2"unc	2 1/8"	3	4	2780-23607
9" 79	3 19/32"	1 1/4"	1"	3/8"	3	1/2"unc	2 1/8"	4	4	2790-23607
9" BP	3"	1.3"	.985	3/8"	3	3/8"unc	1 3/4"	3	4	2580-23607
10.5" 78	3 19/32"	1 1/4"	1"	7/16"	3	1/2"unc	2 1/8"	3	4	2780-27607
10.5" 79	3 19/32"	1 1/4"	1"	7/16"	3	1/2"unc	2 1/8"	4	4	2790-27607
250mm	3 3/8"	1 1/4"	1"	7/16"	3	1/2"unc	2 1/8"	3	4	2210-25607
250mm	3 3/8"	1 1/4"	1"	7/16"	3	1/2"unc	2 1/8"	4	4	2230-25607
10.5"BP	3 5/8"	1 11/32"	1 1/4"	1/2"	3	1/2"unc	2 1/8"	3/4	4	2580-27607
12" 78	4 7/32"	1 5/16"	1 3/16"	15/32"	3	1/2"unc	2 1/2"	3	4	2780-31607
12" 79	4 7/32"	1 5/16"	1 3/16"	15/32"	3	1/2"unc	2 1/2"	4	4	2790-31607
315mm	4 1/8"	1 3/8"	1 1/8"	1/2"	3	1/2"unc	2 1/2"	3	4	2210-32607
315mm	4 1/8"	1 3/8"	1 1/8"	1/2"	3	1/2"unc	2 1/2"	4	4	2230-32607
12" BP	4 1/4"	1 13/32"	1 1/4"	1/2"	3	1/2"unc	2 1/2"	3/4	4	2580-31607
15" 58	4 15/16"	1 15/32"	1 3/16"	15/32"	2 1/2	5/8"unc	3"	3	4	2580-38607
15" 59	4 15/16"	1 15/32"	1 3/16"	15/32"	2 1/2	5/8"unc	3"	4	4	2590-38607
18" 58	6 7/16"	1 15/16"	1 1/2"	9/16"	2	3/4"unc	1 1/2"	3	5	2580-46607
18" 59	6 7/16"	1 15/16"	1 1/2"	9/16"	2	3/4"unc	1 1/2"	4	5	2590-46607



BASE JAWS (AMER.) SCROLL & TUDOR CHUCKS (3)

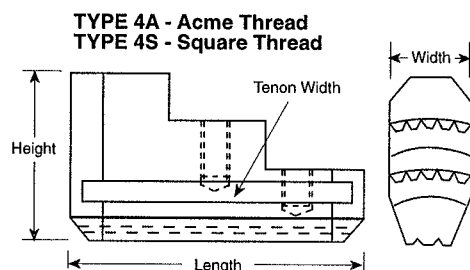
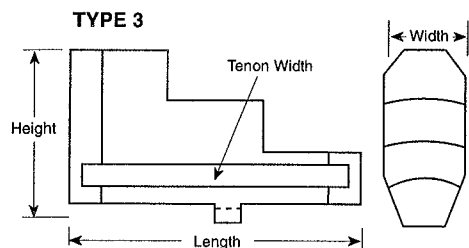
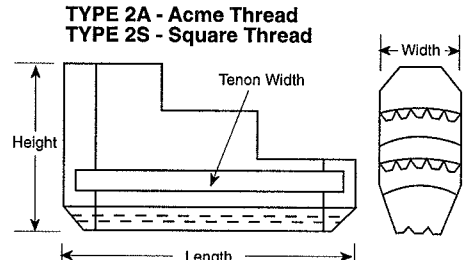
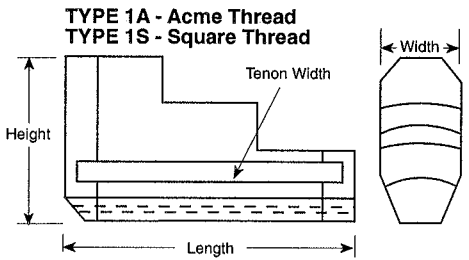
Chuck type	J1 Length	J2 Height	J3 Width	J4 Tenon	J5 pitch	J6 Hole	J7 Hole Centres	Jaws per set	TYPE	Cat. No.
100mm SP	44mm		14mm	7.1mm	6mm	1/4" unc	19.02mm	3	4	8210-10607
125mm SP	52.5mm	28mm	16mm	7.1mm	6mm	5/16" unc	22.2mm	3	4	8210-13607
160mm SP	65.5mm	32mm	18mm	7.1mm	6mm	3/8" unc	38.08mm	3	4	8210-17607
200mm SP	75.6mm	40mm	22mm	8.1mm	8mm	3/8" unc	44.4mm	3	4	8210-20607
250mm SP	90.5mm	40mm	25mm	8.1mm	8mm	1/2" unc	53.96mm	3	4	8210-25607
315mm SP	125mm	42mm	32mm	12.1mm	10mm	1/2" unc	63.48mm	3	4	8210-32607
400mm SP	127mm	54mm	32mm	12.1mm	12mm	5/8" unc	76.18mm	3	4	8210-40607
6.5" Tudor	2 1/2"	1 7/16"	1 1/16"	5/16"	-	3/8"unc	1 1/2"	3	6	2980-17607
6.5" Tudor	2 1/2"	1 7/16"	1 1/16"	5/16"	-	3/8"unc	1 1/2"	2	6	2990-17607
7.5" Tudor	2 13/16"	1 19/32"	1 3/16"	11/32"	-	3/8"unc	1 3/4"	3	6	2980-19607
7.5" Tudor	2 13/16"	1 19/32"	1 3/16"	11/32"	-	3/8"unc	1 3/4"	2	6	2990-19607
9.5" Tudor	3 3/8"	1 25/32"	1 3/8"	3/8"	-	1/2"unc	2 1/8"	3	6	2980-24607
9.5" Tudor	3 3/8"	1 25/32"	1 3/8"	3/8"	-	1/2"unc	2 1/8"	2	6	2990-24607
12" Tudor	4"	2 3/32"	1 9/16"	1/2"	-	1/2"unc	2 1/2"	3	6	2980-31607
12" Tudor	4"	2 3/32"	1 9/16"	1/2"	-	1/2"unc	2 1/2"	2	6	2990-31607
15" Tudor	4 3/4"	2 3/16"	1 13/16"	1/2"	-	1/2"unc	3"	3	6	2980-38607
15" Tudor	4 3/4"	2 3/16"	1 13/16"	1/2"	-	1/2"unc	3"	2	6	2990-38607
18" Tudor	5 7/8"	2 11/16"	2 3/16"	5/8"	-	3/4"unc	1 1/2"	3	7	2980-46607
18" Tudor	5 7/8"	2 11/16"	2 3/16"	5/8"	-	3/4"unc	1 1/2"	2	7	2990-46607
21" Tudor	6 3/4"	2 11/16"	2 3/16"	5/8"	-	3/4"unc	1 1/2"	3	7	2980-53607
21" Tudor	6 3/4"	2 11/16"	2 3/16"	5/8"	-	3/4"unc	1 1/2"	2	7	2990-53607
25" Tudor	7 3/4"	2 23/32"	2 3/8"	5/8"	-	3/4"unc	1 1/2"	3	7	2980-63607
25" Tudor	7 3/4"	2 23/32"	2 3/8"	5/8"	-	3/4"unc	1 1/2"	2	7	2990-63607

BASE JAWS (5) POWER (H.S.Q.C.)

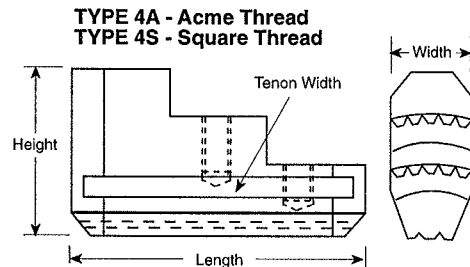
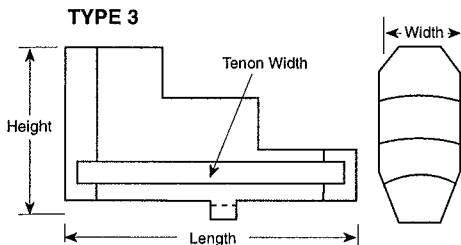
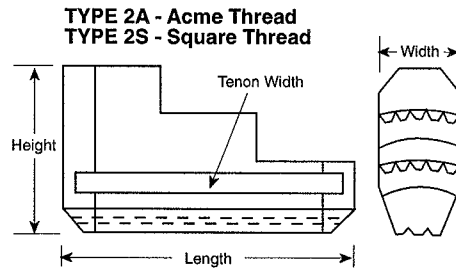
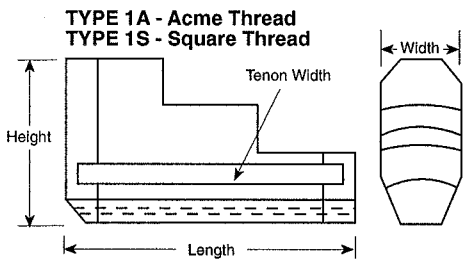


Cat. No.	Serrations	Chuck size	Length (L)	Width (W)	Tee nut slot (T4)	T1
8130-17610	90° x 1/16"	165mm	68mm	31mm	12mm	18.5/19mm
8130-21610	90° x 1/16"	210mm	87mm	39.6mm	17mm	23.5/24mm
8130-22610	90° x 1/16"	210mm BB	76mm	39.6mm	17mm	23.5/24mm
8130-26610	90° x 1/16"	254mm	100mm	39.6mm	17mm	23.5/24mm
8130-27610	90° x 1/16"	265mm	96mm	39.6mm	17mm	23.5/24mm
8130-31610	90° x 1/16"	305mm	120mm	46mm	21mm	29.5/30mm
8130-38610	90° x 3/32"	380mm	137mm	60mm	25.5mm	37.5/38mm
8130-50610	90° x 3/32"	500mm	167mm	60mm	25.5mm	37.5/38mm
8130-61610	90° x 3/32"	610mm	212mm	60mm	25.5mm	37.5/38mm
8130-17623	60° x 1.5mm	165mm	68mm	31mm	12mm	18.5/19mm
8130-21623	60° x 1.5mm	210mm	87mm	39.6mm	14mm	21.5/22mm
8130-22623	60° x 1.5mm	210mm BB	76mm	39.6mm	14mm	22.8/23.3mm
8130-26623	60° x 1.5mm	254mm	100mm	39.6mm	16mm	22.8/23.3mm
8130-27623	60° x 1.5mm	265mm	96mm	39.6mm	16mm	22.8/23.3mm
8130-31623	60° x 1.5mm	305mm	120mm	46mm	18mm	27.5/28mm
8130-40623	60° x 1.5mm	380mm	137mm	60mm	22mm	34.5/35mm
8130-46623	60° x 3mm	460mm	147mm	60mm	25mm	35/35.6mm
8130-50623	60° x 3mm	500mm	167mm	60mm	25mm	35/35.6mm
8130-61623	60° x 3mm	610mm	212mm	60mm	25mm	37.5/38.1mm
8130-17626	Acme 5/32"	165mm	68mm	31mm	12mm	18.5/19mm
8130-21626	Acme 5/32"	210mm	87mm	39.6mm	17mm	25.4/26.2mm
8130-26626	Acme 1/4"	254mm	100mm	39.6mm	19mm	25.4/26.2mm
8130-27626	Acme 1/4"	265mm	96mm	39.6mm	19mm	25.4/26.2mm
8130-31626	Acme 1/4"	305mm	120mm	46mm	22.2mm	28.5/29.5mm
8130-40626	Acme 1/4"	380mm	137mm	60mm	25.4mm	1.2"/1.3"
8130-50626		500mm	n/a			
8130-61626	Acme 1/4"	610mm	212mm	60mm	25.4mm	32.5/34.1mm
8130-26627	Square 1/4"	254mm	100mm	39.6mm	16mm	22.8/23.3mm
8130-27627	Square 1/4"	265mm	96mm	39.6mm	16mm	22.8/23.3mm
8130-31627	Square 1/4"	305mm	120mm	46mm	19.13mm	28.75/29mm
8130-40627	Square 1/4"	380mm	137mm	60mm	25.4mm	34/35.5mm
8130-50627	Square 1/4"	500mm	197mm	60mm	25.4mm	34/35.5mm

Original Chuck Type	Length	Height	Width	Tenon Width	Teeth per inch	Type	Cat. No.	Notes
3" & 4" L/Type	1 3/8"	1 7/32"	3/8"	1/8"		3	2520-08601	Obsolete
4.5" 55 acme	1 15/16"	1 9/16"	3/4"	9/32"	8	1A	2550-12601	Obsolete
4.5" 55 square	1 15/16"	1 9/16"	3/4"	9/32"	8	1S	0045-55601	Obsolete
4.5", 5", 6" L/T	2"	1 3/8"	5/8"	3/16"	8	1A	2540-14601	Obsolete
6" 55 acme	2 1/8"	1 29/32"	15/16"	5/16"	8	1A	2550-16601	Obsolete
6" 55 square	2 1/8"	1 29/32"	15/16"	5/16"	8	1S	0006-55601	Obsolete
8" L/Type	2 15/32"	1 23/32"	3/4"	5/16"	8	1A	2540-21601	Obsolete
8" 55 acme	3 1/8"	2 1/4"	1 3/16"	3/8"	6	1A	2550-21601	Obsolete
8" 55 square	3 1/8"	2 1/4"	1 3/16"	3/8"	6	1S	0008-55601	Obsolete
8" 1935 acme	3 1/8"	2 1/4"	1 3/16"	3/8"	6	2A	2350-21601	Obsolete
8" 1935 square	3 1/8"	2 1/4"	1 3/16"	3/8"	6	2S	0008-35601	Obsolete
9" 1935	3 1/8"	2 9/16"	1 3/8"	3/8"	6	2A	2350-23601	Obsolete
Faceplate Jaws	3 1/8"	2 9/16"	1 3/8"	3/8"	6	2A	2680-26601	Obsolete
10" Light Type	3 1/4"	2"	1"	3/8"	6	1A	2540-26601	Obsolete
10" 55 acme	3 3/8"	2 9/16"	1 3/8"	3/8"	6	1A	2550-26601	Obsolete
12" 55 acme	3 7/8"	2 15/16"	1 1/2"	7/16"	5	1A	2550-31601†	Obsolete
12" 55 square	3 7/8"	2 15/16"	1 1/2"	7/16"	5	1S	0012-55601	Obsolete
12" 1935	4 1/8"	3"	1 11/16"	1/2"	5	2S	2350-31601	Obsolete
14" - 16" 55	4 3/8"	3 3/16"	1 1/2"	7/16"	5	1A	2550-35601†	Obsolete
14" 55 square	4 3/8"	3 3/16"	1 1/2"	7/16"	5	1S	0014-55601	Obsolete
18" - 20" 55	5 1/8"	3 1/2"	1 11/16"	1/2"	5	1S	2550-46601#	Obsolete
	5 1/8"	3 1/2"	1 11/16"	1/2"	5	4S	7559-46007#	Obsolete
15" 1935	5 1/8"	3 1/2"	1 11/16"	1/2"	5	2S	2350-38601#	Obsolete

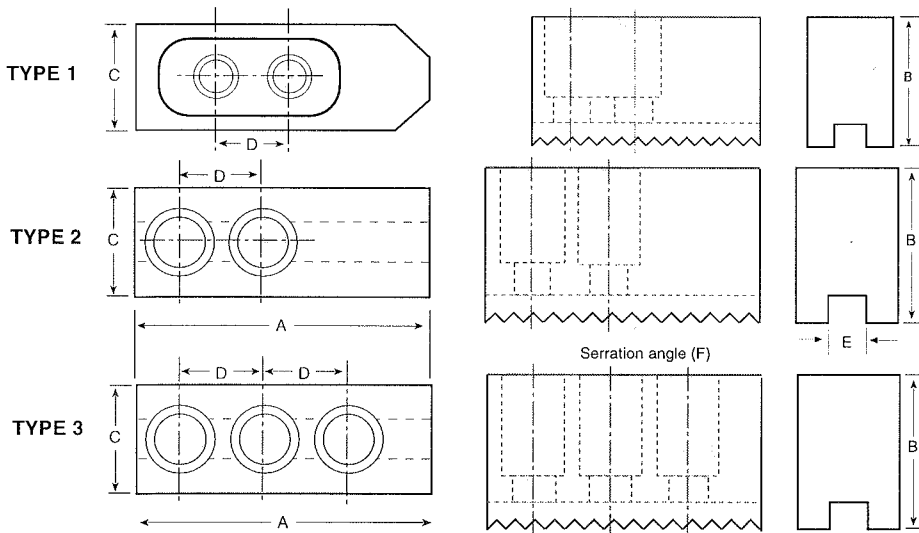


Original Chuck Type	Length	Height	Width	Tenon Width	Teeth per inch	Type	Cat. No.	Notes
22" - 26" 55	5 1/2"	4"	1 15/16"	9/16"	5	1S	2550-61601 §	Use 2350-40601
16" - 20" 1935	5 1/2"	4"	1 15/16"	9/16"	5	2S	2350-40601 §	Use 2350-40601
24" 56	6 9/16"	4 1/4"	1 15/16"	9/16"	5	2S	2560-61601 §	Use 2350-40601
	6 9/16"	4 1/4"	1 15/16"	9/16"	5	4S	7579-61013 §	Use 2350-40601
	6"	7 1/2"	1 15/16"	9/16"		1S	7579-56002	
20" 1935	6 5/8"	4 13/16"	2 1/4"	5/8"	5	2S	2350-51601	(For 1 3/4" screws)
22" 1935	6 5/8"	4 13/16"	2 1/4"	5/8"	5	2S	2350-56601 ‡	(For 1 1/2" screws)
36" 55	7 3/4"	5 3/8"	2 1/4"	5/8"	5	2S	2550-92601 ‡	(For 1 1/2" screws)
	7 3/4"	5 3/8"	2 1/4"	5/8"	5	4S	7559-92007 ‡	Use 2550-92601
	6 3/4"	4 13/16"	2 1/4"	5/8"	5	4S	7359-56006 ‡	Use 2550-92601
26" - 28" 1935	7 3/4"	5 3/8"	2 1/4"	5/8"	5	2S	2350-66601	
	8"	6 9/16"	2 1/4"	5/8"	5	4S	7579-76012	(26" 57, DSG)
32" 1935	7 3/4"	5 7/8"	2 3/4"	7/8"	5	2S	2350-81601	
METRIC INDEPENDENT CHUCKS					Pitch			
160mm	47mm	40mm	24mm	10.5mm	3mm	1	2500-17601	Trapezoidal thread
200mm	75mm	54mm	32mm	12.5mm	4mm	1	2500-20601	Trapezoidal thread
315 - 400mm	100mm	63mm	36mm	15.5mm	4mm	1	2500-32601	Trapezoidal thread
§ Interchangeable		† Interchangeable						
# Interchangeable		‡ Interchangeable						



Cat.no.	Type	A	B	C	D	E (Tee slot)	F	Retaining Screws	Origin Chuck
8820-13512	1	52mm	38mm	25mm	14mm	12mm	90° x 1/16"	M8	125mm Int.
8820-13525	1	52mm	38mm	25mm	14mm	12mm	60° x 1.5mm	M8	125mm Int.
8820-17512	3	70mm	30mm	30mm	14mm	12mm	90° x 1/16"	CAM8x20	165mm Int & HSQC
8820-17525	2	70mm	30mm	30mm	17mm	12mm	60° x 1.5mm	CAM10X25	165mm Int & HSQC
2980-17512	2	2 1/8"	1 1/4"	1"	1/2"	1/2" (12.7mm)	90° x 1/16"	CA0.313BSW0.750	6.5" Tudor
2160-17512	2	2 7/16"	1 3/8"	1 1/8"	11/16"	1/2" (12.7mm)	90° x 1/16"	CA0.313BSW0.750	160mm CCWT
2980-17513	2	2 5/8"	1 15/16"	1"	1/2"	1/2" (12.7mm)	90° x 1/16"	CA0.313BSW0.750	6.5" Tudor
2740-17512	2	61.5mm	39mm	28mm	18mm	13mm	90° x 1/16"	CAM8X30	160mm S.C.P.C.
8820-21525	2	80mm	35mm	35mm	19mm	14mm	60° x 1.5mm	CAM12X30	210mm Int & HSQC
2980-19512	2	2 1/2"	1 3/8"	1 1/8"	11/16"	9/16" (14.28mm)	90° x 1/16"	CA0.375BSW1.000	7.5" Tudor
2160-21512	2	2 13/16"	1 39/64"	1 5/16"	13/16"	9/16" (14.28mm)	90° x 1/16"	CA0.375BSW1.000	200mm CCWT
2980-19513	2	3"	2 1/8"	1 1/8"	11/16"	9/16" (14.28mm)	90° x 1/16"	CA0.375BSW1.000	7.5" Tudor
2770-17512	2	50mm	35mm	33mm	20.6mm	15mm	90° x 1/16"	CAM10X20	160mm C. GRIP
2980-24512	2	2 3/4"	1 5/8"	1 5/16"	5/8"	5/8" (15.87mm)	90° x 1/16"	CA0.438BSW1.000	9.5" Tudor
2980-24513	2	3 1/4"	2 3/4"	1 5/16"	5/8"	5/8" (15.87mm)	90° x 1/16"	CA0.438BSW1.000	9.5" Tudor
2160-26512	2	3 1/2"	1 15/16"	1 1/2"	15/16"	5/8" (15.87mm)	90° x 1/16"	CA0.438BSW1.000	250mm CCWT
8820-26525	3	100mm	40mm	40mm	24mm	16mm	60° x 1.5mm	CAM12X25	254mm Int & HSQC
2770-21512	2	64mm	38mm	38mm	25.4mm	17mm	90° x 1/16"	CAM12X25	200mm C.GRIP
2860-17512	2	68mm	40.25mm	33.3mm	21mm	17mm	90° x 1/16"	CAM12X25	160mm Int.
2740-21512	2	75mm	45mm	33mm	22mm	17mm	90° x 1/16"	CAM10X30	200mm S.C.P.C.
2770-26512	2	78mm	49mm	38mm	25.4mm	17mm	90° x 1/16"	CAM12X25	250mm C. GRIP
8820-21512	2	80mm	35mm	35mm	19mm	17mm	90° x 1/16"	CAM12X30	210mm Int & HSQC
2860-21512	2	81mm	48.25mm	38.1mm	25.4mm	17mm	90° x 1/16"	CAM12X25	200mm Int.
8820-26512	3	100mm	40mm	40mm	24mm	17mm	90° x 1/16"	CAM12X25	254mm Int & HSQC

Note that standards for Int. & HSQC (jaws 8820-) have changed. The above information was correct at September 1998.

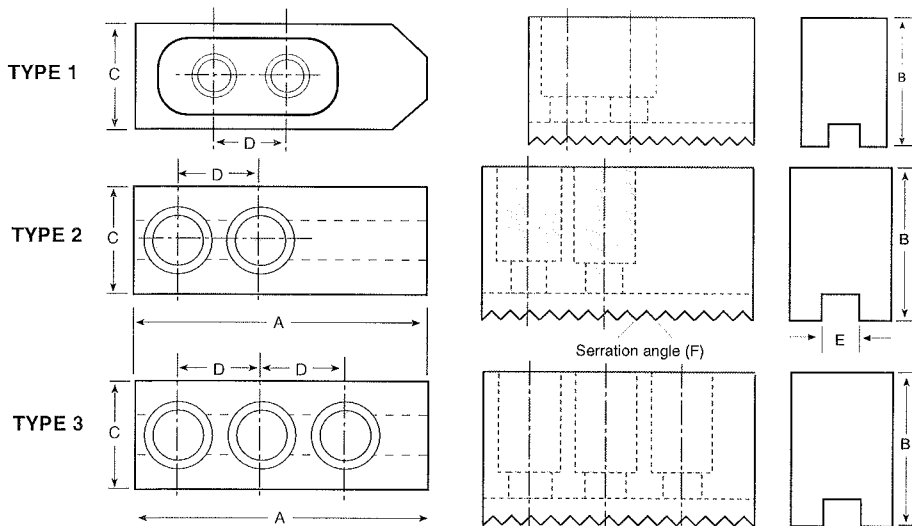


The catalogue numbers above refer to the SINGLE jaw code. As many of our brochures/catalogues identify jaws as sets, please note the above dimensions obviously apply to either number. Please see page 59a for soft top jaw alternatives.

If single teenuts are used on a chuck the dimension 'D' is not critical as long as the minimum distance between the tee nuts is satisfied.

Cat.no.	Type	A	B	C	D	E (Tee slot)	F	Retaining Screws	Origin Chuck
2980-31512	2	3"	1 15/16"	1 1/2"	29/32"	11/16" (17.46mm)	90° x 1/16"	CA0.500BSW1.250	12" Tudor
2980-31513	2	4"	3"	1 1/2"	29/32"	11/16" (17.46mm)	90° x 1/16"	CA0.500BSW1.250	12" Tudor
2160-32512	2	4 1/4"	2 1/4"	1 3/4"	1 1/4"	11/16" (17.46mm)	90° x 1/16"	CA0.500BSW1.000	315mm CCWT
8820-31525	3	120mm	50mm	50mm	28mm	18mm	60° x 1.5mm	CAM14X40	305mm Int. & HSQC
2980-38512	2	3 3/4"	2 1/4"	1 3/4"	1 3/16"	13/16" (20.63mm)	90° x 1/16"	CA0.625BSW1.250	15" Tudor
2980-38513	2	4 3/4"	3 1/4"	1 3/4"	1 3/16"	13/16" (20.63mm)	90° x 1/16"		15" Tudor
2160-40512	2	4 7/8"	2 31/64"	2 1/8"	1 1/2"	13/16" (20.63mm)	90° x 1/16"	CA0.625BSW1.250	400mm CCWT
2740-26512	2	88mm	55mm	40mm	25mm	21mm	90° x 1/16"	CAM12X35	250mm S.C.P.C.
2860-26512	2	101mm	63.5mm	44mm	31.8mm	21mm	90° x 1/16"	CAM16X35	250mm Int.
2740-32512	2	105mm	55mm	40mm	30mm	21mm	90° x 1/16"	CAM12X35	315mm S.C.P.C.
8820-31512	3	120mm	50mm	50mm	27.5mm	21mm	90° x 1/16"	CAM16X35	305mm Int. & HSQC
2860-32512	2	116mm	62.5mm	54mm	31.8mm	21mm	90° x 1/16"	CAM16X35	315mm Int.
2770-40512	2	124mm	63mm	55mm	38.1mm	21mm	90° x 3/32"	CAM16X35	380mm C. GRIP
8830-38525	3	150mm	60mm	60mm	31mm	22mm	60° x 1.5mm	CAM20X50	380mm Int. & HSQC
2980-46512	2	4 1/4"	2 1/2"	2 1/8"	1 3/8"	25.4mm (1")	90° x 3/32"	CA0.750BSW1.500	18" Tudor
2980-46513	2	5 1/2"	3 1/2"	2 1/8"	1 3/8"	25.4mm (1")	90° x 3/32"		18" Tudor
2980-53512	2	5 5/8"	2 3/4"	2 1/8"	1 5/8"	25.4mm (1")	90° x 3/32"	CA0.750BSW1.750	21" Tudor
2160-51512	2	5 3/4"	2 61/64"	2 3/8"	1 3/4"	25.4mm (1")	90° x 3/32"	CA0.750BSW1.750	500/630mm CCWT
8830-38512	3	150mm	60mm	60mm	31mm	25.4mm (1")	90° x 3/32"	CAM20X35	380mm Int. & HSQC
2860-40512	2	152mm	75mm	2 3/8"	1 3/4"	25.4mm (1")	90° x 1/16"	CAM20X35	400mm Int.
2980-63512	2	6 1/4"	2 15/16"	2 1/4"	2 1/8"	25.4mm (1")	90° x 3/32"	CA0.750BSW2.000	25" Tudor
2980-53513	2	6 3/4"	4 1/4"	2 1/8"	1 5/8"	25.4mm (1")	90° x 3/32"	CA0.750BSW1.750	21" Tudor
2980-63513	2	7 3/4"	4 3/4"	2 1/4"	2 1/8"	25.4mm (1")	90° x 3/32"	CA0.750BSW2.000	25" Tudor

Note that standards for Int. & HSQC (jaws 8820-) have changed. The above information was correct at September 1998.



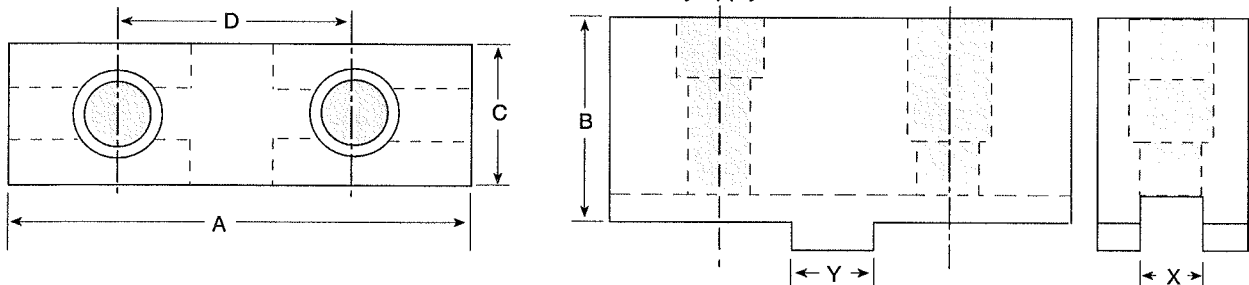
The catalogue numbers above refer to the SINGLE jaw code. As many of our brochures/catalogues identify jaws as sets, please note the above dimensions obviously apply to either number. Please see page 59a for soft top jaw alternatives.

If single teenuts are used on a chuck dimension 'D' is not critical as long as the minimum distance between the tee nuts is satisfied.

Cat.no.	A	B	C	D (centres)	X	Y	Fixing screw (s)	Chuck Type
2580-10509	1 13/16"	1 1/16"	5/8"	3/4"	1/4"	3/8"	1/4" unc x 1/2" & 3/4"	4" 3 jaw GS
2210-13509	2 3/16"	1 1/4"	3/4"	7/8"	1/4"	3/8"	5/16" unc x 5/8" & 7/8"	125mm 3 jaw GS
2860-17532	75mm	36mm	33mm	25mm	10mm	16mm	(2)	160mm Int.
2160-17509	2 9/16"	1 3/8"	1 1/8"	1 3/16"	5/16"	1/2"	5/16" unc x 3/4" (2)	160mm CCWT
2160-21509	3 5/16"	1 5/8"	1 5/16"	1 1/2"	5/16"	1/2"	7/16" unc x 1" (2)	200mm CCWT
2210-17509	2 5/8"	1 7/16"	7/8"	1 1/2"	5/16"	1/2"	3/8" unc x 3/4" & 1.0"	160mm 3 jaw GS
2980-19509	2 3/4"	1 1/2"	15/16"	1 1/2"			3/8" unc x 3/4" & 1.0"	7.5" Tudor
2980-17509	2 7/8"	1 19/32"	7/8"	1 1/2"			3/8" unc x 7/8" & 1.125"	6.5" Tudor
2770-21509	84mm	35mm	38mm	38.1mm	8mm	12.6mm	7/16" unc x 1" (2)	200mm C. GRIP
8130-21509	82mm	49mm	38mm	44.45mm	8mm	12.6mm		200mm HSQC (Old)
2210-20509	3 1/8"	1 9/16"	1 5/16"	1 3/4"	5/16"	1/2"	3/8" unc x 7/8" & 1.00"	200mm 3 jaw GS
2780-22509	3 1/4"	1 23/32"	1 3/16"	1 3/4"			3/8" unc x 7/8" & 1.25"	8 1/4" 78
2350-23509	3 1/4"	1 23/32"	1 3/8"	1 3/4"			3/8" unc x 7/8" & 1.25"	9" 1935 4 jaw
2160-26509	4 1/4"	1 15/16"	1 1/2"	1 3/4"	5/16"	1/2"	1/2" unc x 1.25" (2)	250mm CCWT
2210-25509	3 1/2"	1 15/16"	1 3/16"	2 1/8"	1/2"	3/4"	1/2" unc x 1" & 1.25"	250mm 3 jaw GS
2780-23509	3 7/8"	2 1/16"	1 3/16"	2 1/8"			1/2" unc x 1" & 1.75"	9" Steel scroll
2980-24509	3 7/8"	2 3/16"	1 3/8"	2 1/8"			1/2" unc x 1" & 1.5"	9.5" Tudor
2770-26509	107mm	46mm	38mm	53.9mm	12.7mm (1/2")	19mm	5/8" unc x 1 1/2" (2)	250mm HSQC (old)
2210-32509	4 1/4"	2 1/16"	1 5/16"	2 1/2"	1/2"	3/4"	1/2" unc x 1" & 1.5"	315mm 3 jaw GS
2980-31509	4 7/16"	2 5/32"	1 1/2"	2 1/2"	1/2"	3/4"	1/2" unc x 1" & 1.5"	12" Tudor
2350-31509	4 7/16"	2 5/32"	1 11/16"	2 1/2"			1/2" unc x 1" & 1.5"	12" 1935 4 jaw
2160-32509	5 1/4"	2 1/4"	1 3/4"	2 1/2"	1/2"	3/4"	5/8" unc x 1.5" (2)	315mm CCWT
2770-32509	135mm	54mm	45mm	63.5mm	12.7mm (1/2")	19mm	5/8" unc x 1 3/4" (2)	315mm C. GRIP
2580-38509	5 1/8"	2 1/2"	1 1/2"	3"	1/2"	3/4"	5/8" unc x 1.0" & 1.75"	15" 3 jaw GS
2980-38509	5 1/8"	2 3/4"	1 11/16"	3"	1/2"	3/4"	3/4" unc x 1.125" & 2.0"	15" Tudor
2350-40509	5 1/8"	3 3/16"	1 15/16"	3"			3/4" unc x 1.125" & 2.25"	16" 1935 4 jaw
2980-46509	5 1/4"	3 1/4"	2 1/4"	3"	1/2"	3/4"	3/4" unc x 1.50" & 2.50"	18" Tudor
2350-81509	5 5/16"	3 5/16"	2 3/4"	3"			3/4" unc x 1.50" & 2.50"	32" 1935 4 jaw
2160-40509	6 3/4"	2 1/2"	2 1/8"	3"	1/2"	3/4"	3/4" unc x 1.75" (2)	400mm CCWT
2160-51509	7 1/8"	3"	2 3/8"	3"	1/2"	3/4"	3/4" unc x 2" (2)	630mm CCWT
2770-38509	167mm	57mm	55mm	76.2mm	12.7mm	19mm	3/4" unc x 1 3/4" (2)	380mm C. GRIP

Manufacturing dimensions may have been amended on some old style jaws. In these instances the height and length may differ slightly. Note also jaws with a female cross-tenon were manufactured for the extra-heavy range of scroll chucks (models 95 & 96). These are no longer available. Note some jaws take different length screws.

The catalogue numbers above refer to the SINGLE jaw code. As many of our brochures/catalogues identify jaws as sets, please note the above dimensions obviously apply to either number.

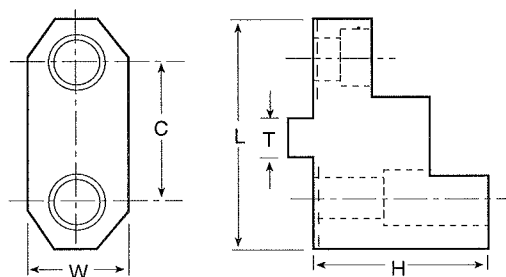




HARD TOP JAWS (Manual chucks) 1.

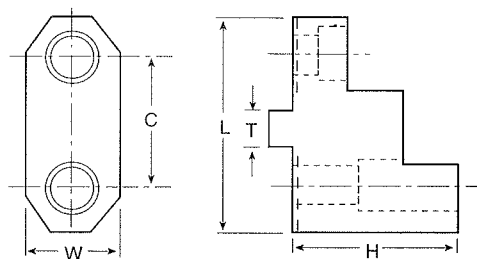
Length (L)	Height (H)	Width (W)	(C) Hole Centres	Jaws per set	Cat. No. (set)	Fixing Screw (s)	Tenon (T)	Chuck size & type	Notes
1 13/16"	1 1/16"	5/8"	3/4"	3	2580-10608	1/4"unc x 1/2" & 3/4"	3/8"	4" 3 jaw	Use 8210-10608
1 13/16"	1 1/16"	5/8"	3/4"	4	2590-10608	1/4"unc x 1/2" & 3/4"	3/8"	4" 4 jaw	Use 8210-10608 ?
2 3/16"	1 1/4"	3/4"	7/8"	3	2210-13608	5/16"unc x 5/8" & 7/8"	3/8"	125mm 3 jaw	Use 8210-13608
2 3/16"	1 1/4"	3/4"	7/8"	4	2230-13608	5/16"unc x 5/8" & 7/8"	3/8"	125mm 4 jaw	Use 8210-13608 ?
2 5/8"	1 7/16"	7/8"	1 1/2"	3	2210-17608	3/8"unc x 3/4" & 1"	1/2"	160mm 3 jaw	Use 8210-17608
2 5/8"	1 7/16"	7/8"	1 1/2"	4	2230-17608	3/8"unc x 3/4" & 1"	1/2"	160mm 4 jaw	Use 8210-17608 ?
2 5/8"	1 7/16"	1"	1 1/2"	3	2580-16608			6" BP model 31	OBSOLETE (BP)
2 21/32"	1 15/32"	15/16"	1 1/2"	3	2980-19608	3/8" unc x		7.5" Tudor	OBSOLETE
2 3/4"	1 21/32"	7/8"	1 1/2"	3	2980-17608	3/8" unc x		6.5" Tudor	OBSOLETE
3"	1 9/16"	15/16"	1 3/4"	3	2210-20608	3/8"unc x 7/8" & 1 1/4"	1/2"	200mm 3 jaw	Use 8210-20608
3"	1 9/16"	15/16"	1 3/4"	4	2230-20608	3/8"unc x 7/8" & 1 1/4"	1/2"	200mm 4 jaw	Use 8210-20608 ?
3 1/8"	1 9/16"	1 1/4"	1 3/4"	3	2580-19608			7.5" BP model 52	OBSOLETE (BP)
3 1/8"	1 21/32"	1 3/16"	1 3/4"	3	2780-22608			8.25" 78	OBSOLETE
3 1/8"	1 21/32"	1 3/8"	1 3/4"	4	2350-23608			9" 1935	OBSOLETE
3 1/8"	1 11/16"	1 1/4"	1 3/4"	3	2580-23608			9" BP model 53	OBSOLETE (BP)
3 11/16"	1 15/16"	1 3/16"	2 1/8"	3	2210-25608	1/2"unc x 1" & 1 1/4"	3/4"	250mm 3 jaw	Use 8210-25608
3 11/16"	1 15/16"	1 3/16"	2 1/8"	4	2230-25608	1/2"unc x 1" & 1 1/4"	3/4"	250mm 4 jaw	Use 8210-25608 ?
3 3/4"	2"	1 15/32"	2 1/8"	3	2580-27608			10.5" model 54	OBSOLETE (BP)
3 25/32"	2"	1 3/16"	2 1/8"	3	2780-23608			9" 78	OBSOLETE
3 25/32"	2 5/32"	1 3/8"	2 1/8"	3	2980-24608	1/2" unc x		9.5" Tudor	OBSOLETE
4 5/16"	2 1/16"	1 5/16"	2 1/2"	3	2210-32608	1/2"unc x 1" & 1 1/2"	3/4"	315mm 3 jaw	Use 8210-32608
4 5/16"	2 1/16"	1 5/16"	2 1/2"	4	2230-32608	1/2"unc x 1" & 1 1/2"	3/4"	315mm 4 jaw	Use 8210-32608 ?
4 5/16"	2 1/16"	1 15/32"	2 1/2"	3	2580-31608			12" model 55	OBSOLETE (BP)
4 11/32"	2 3/32"	1 1/2"	2 1/2"	3	2980-31608	1/2" unc x		12" Tudor	OBSOLETE
4 11/32"	2 3/32"	1 11/16"	2 1/2"	4	2350-31608			12" 1935	OBSOLETE
5 1/16"	2 7/16"	1 1/2"	3"	3	2580-38608		3/4"	15" 58/78	Use 8210-40608
5 1/16"	2 7/16"	1 1/2"	3"	4	2590-38608	3/4"unc x 1.125" & 2.0"	3/4"	15" 59/79	Use 8210-40608
5 1/16"	2 11/16"	1 11/16"	3"	3	2980-38608		3/4"	15" Tudor	
5 1/16"	2 11/16"	1 11/16"	3"	4	2970-38608	1/2" unc x	3/4"	18"	Use 8210-40608 ?
5 1/16"	3 3/16"	1 15/16"	3"	4	2350-40608		3/4"	16" - 30"	OBSOLETE
5 1/16"	3 3/16"	2 1/4"	3"	3	2980-46608		3/4"	18" Tudor	
5 1/16"	3 3/16"	2 1/4"	3"	4	2970-46608		3/4"	36"	
5 1/16"	3 3/16"	2 3/4"	3"	4	2350-81608			32" 1935	OBSOLETE
5 1/16"	2 11/16"	1 11/16"	3"	6	2260-38608		3/4"	15" Setrite	

STANDARD HARD TOP JAW (-- 608)

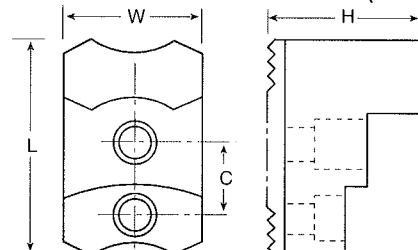


(Note different screw length)

Length (L)	Height (H)	Width (W)	(C) Hole Centres	Serrations	Cat. No. (set 3)	Fixing Screw(s) cat. no.	Fixing Screw(s) size	Chuck Size
TUDOR TYPE SERRATED HARD TOP								
1 25/32"	1 1/8"	1"	1/2"	90° x 1/16"	2980-17611	CA0.313BSW0.750	5/16" whit x 3/4"	6.5"
2 1/8"	1 23/64"	1 1/8"	11/16"	90° x 1/16"	2980-19611	CA0.375BSW1.000	3/8" whit x 1"	7.5"
2 5/16"	1 39/64"	1 5/16"	5/8"	90° x 1/16"	2980-24611	CA0.438BSW1.000	7/16" whit x 1"	9.5"
2 15/16"	1 15/16"	1 1/2"	29/32"	90° x 1/16"	2980-31611	CA0.500BSW1.250	1/2" whit x 1.25"	12"
3 19/32"	2 3/16"	1 3/4"	1 3/16"	90° x 1/16"	2980-38611	CA0.625BSW1.250	5/8" whit x 1.25"	15" (380mm)
4 1/4"	2 31/64"	2 1/8"	1 3/8"	90° x 3/32"	2980-46611	CA0.750BSW1.500	3/4" whit x 1.5"	18" (460mm)
5 3/8"	2 47/64"	2 1/8"	1 5/8"	90° x 3/32"	2980-53611	CA0.750BSW1.750	3/4" whit x 1.75"	21" (535mm)
6 1/4"	2 15/16"	2 1/4"	2 1/8"	90° x 3/32"	2980-63611	CA0.750BSW2.000	3/4" whit x 2"	25" (635mm)
6 7/8"	3 5/16"	2 1/4"	2 1/8"	90° x 3/32"	2980-73611	CA0.750BSW2.000	3/4" whit x 2"	29" (735mm)
SUPER PRECISION & STANDARD ACCURACY (1995)								
Length (L)	Height (H)	Width (W)	(C) Hole Centres	Tenon (T)	Cat. No. (set 3)	Fixing Screw(s) cat. no.	Fixing Screw(s) size	Chuck Size
46mm	26mm	15.75mm	19.02mm (3/4")	9.5mm (3/8")	8210-10608	CA0.250UNC0.500 CA0.250UNC0.750	1/4" unc x 1/2" 1/4" unc x 3/4"	100mm
55.6mm	30mm	18.8mm	22.2mm (7/8")	9.5mm (3/8")	8210-13608	CA0.313UNC0.625 CA0.313UNC0.875	5/16" unc x 5/8" 5/16" unc x 7/8"	125mm
66.7mm	37mm	24.8mm	38.08mm (1 1/2")	12.67mm (1/2")	8210-17608	CA0.375UNC0.750 CA0.375UNC1.000	3/8" unc x 3/4" 3/8" unc x 1.0"	160mm
77mm	37mm	24.8mm	44.4mm (1 3/4")	12.67mm (1/2")	8210-20608	CA0.375UNC0.875 CA0.375UNC1.250	3/8" unc x 7/8" 3/8" unc x 1.125"	200mm
91mm	50mm	30mm	53.96mm (2 1/8")	19.02mm (3/4")	8210-25608	CA0.500UNC1.000 CA0.500UNC1.250	1/2" unc x 1" 1/2" unc x 1.25"	250mm
110mm	53mm	33mm	63.48mm (2 1/2")	19.02mm (3/4")	8210-32608	CA0.500UNC1.000 CA0.500UNC1.500	1/2" unc x 1" 1/2" unc x 1.5"	315mm
122mm	62mm	38mm	76.2mm (3")	19.02mm (3/4")	8210-40608	CA0.625UNC1.250 CA0.625UNC1.750	5/8" unc x 1.25" 5/8" unc x 1.75"	400mm
								500mm

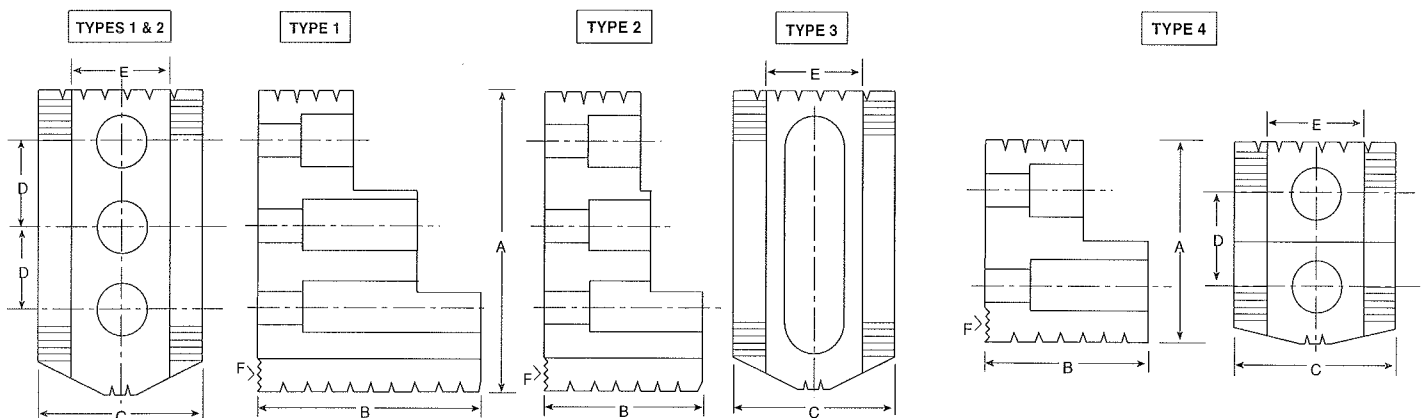
STANDARD HARD TOP JAW (-- 608)


(Note different screw length)

TUDOR SERRATED HARD TOP (-- 611)


Cat.no.	Type	A	B	C	D	E	F	Fixing Screw
8820-13611	3	50mm	36mm	25mm	-	12mm	90° x 1/16"	
8130-17611	1	65mm	40mm	30mm	17mm	12mm	90° x 1/16"	
8130-21611	1	80mm	50mm	40mm	19mm	17mm	90° x 1/16"	
8130-31611	1	125mm	60mm	60mm	25mm	21mm	90° x 1/16"	
8130-40611	1	125mm	75mm	60mm	31mm	25.5mm	90° x 3/32"	
8820-13624	3	50mm	36mm	25mm	-	12mm	60° x 1.5mm	
8130-17624	1	65mm	40mm	30mm	17mm	12mm	60° x 1.5mm	M8X20
8130-21624	1	75mm	50mm	40mm	19mm	14mm	60° x 1.5mm	M10X20
8130-26624	1	80mm	50mm	40mm	19mm	16mm	60° x 1.5mm	
8130-31624	1	115mm	60mm	50mm	25mm	18mm	60° x 1.5mm	
8130-40624	1	125mm	60mm	60mm	25mm	21mm	60° x 1.5mm	
2160-17611	2	2 1/4"	1 5/16"	1 1/8"	11/16"	1/2"	90° x 1/16"	5/16" unc x 3/4"
2160-21611	2	2 11/16"	1 1/2"	1 5/16"	13/16"	9/16"	90° x 1/16"	3/8" unc x 1"
2160-26611	2	3 1/16"	1 5/8"	1 1/2"	15/16"	5/8"	90° x 1/16"	7/16" unc x 1"
2160-32611	2	4 1/16"	2"	1 3/4"	1 1/4"	11/16"	90° x 1/16"	1/2" unc x 1"
2160-40611	2	4 11/16"	2 3/8"	2 1/8"	1 1/2"	13/16"	90° x 1/16"	5/8" unc x 1.25"
2160-51611	2	5 9/16"	2 7/8"	2 3/8"	1 3/4"	1"	90° x 3/32"	3/4" unc x 1.75"
2740-17611 *	1	61.5mm	39mm	28mm	18mm	13mm	90° x 1/16"	M8X30
2740-21611	1	75mm	45mm	33mm	22mm	17mm	90° x 1/16"	M10X30
2740-26611	1	88mm	55mm	40mm	25mm	21mm	90° x 1/16"	M12X35
2740-32611	1	105mm	55mm	40mm	30mm	21mm	90° x 1/16"	M12X35
2770-17611	4	43mm	35mm	33mm	20.6mm	15mm	90° x 1/16"	M10X20
2770-26611	4	53.5mm	40mm	38mm	25.4 (1")	17mm	90° x 1/16"	M12X25
2770-32611	4	68mm	49mm	45mm	31.8mm	21mm	90° x 1/16"	M16X35
2770-40611 *	4	79mm	51mm	55mm	31.8mm	21mm	90° x 3/32"	M16X35
2870-17611 §	1	70mm	50mm	39.5mm	19mm	17mm	90° x 1/16"	M12X25
2870-26611 #	1	100mm	60mm	49.5mm	25mm	21mm	90° x 1/16"	M16X35
2870-40611 †	1	123mm	74.5mm	59.5mm	31mm	25.5mm	90°	M20X35
§ Use 8130-21611		# Use 8130-31611			† Use 8130-40611			

* No alternatives available

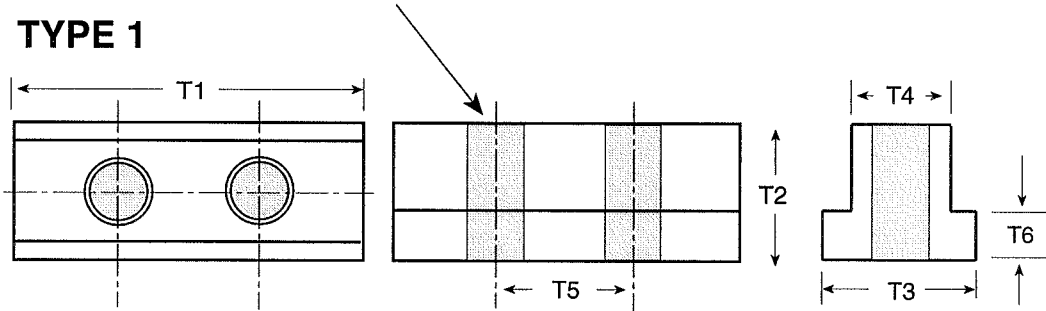


TEE NUTS (1)

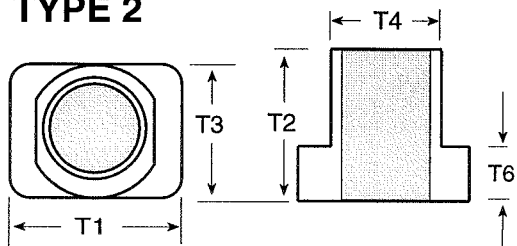
Dimension T4 is the critical dimension to match the chuck tee-slot width.

Dimension T7 is the tapped hole(s) for all tee nuts.

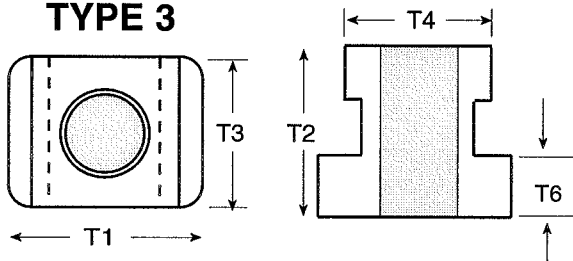
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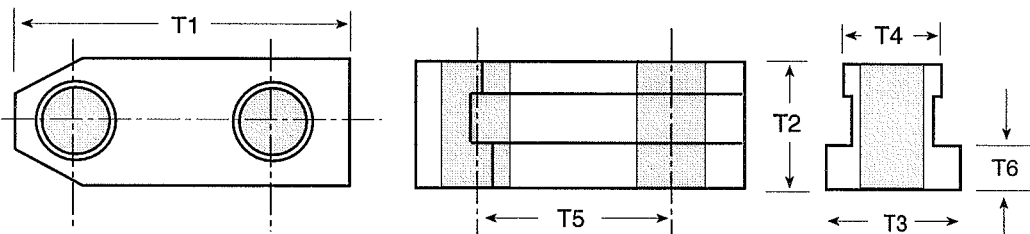
TYPE 2



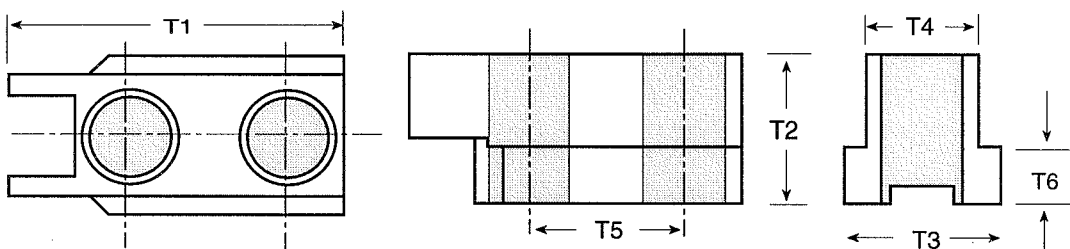
TYPE 3



TYPE 4



TYPE 5

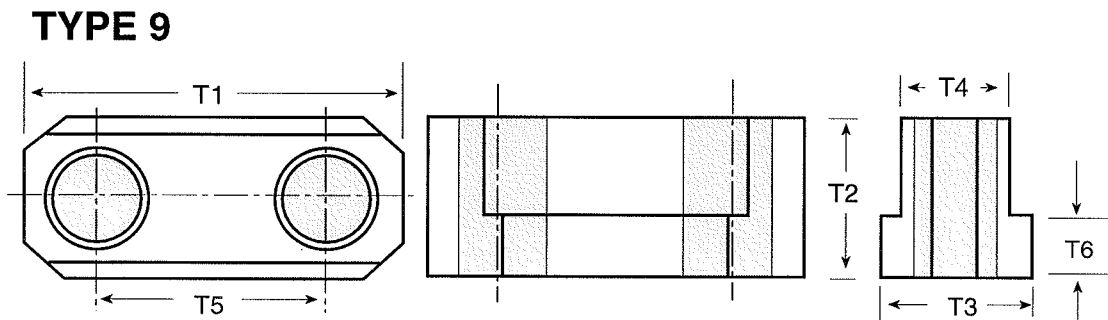
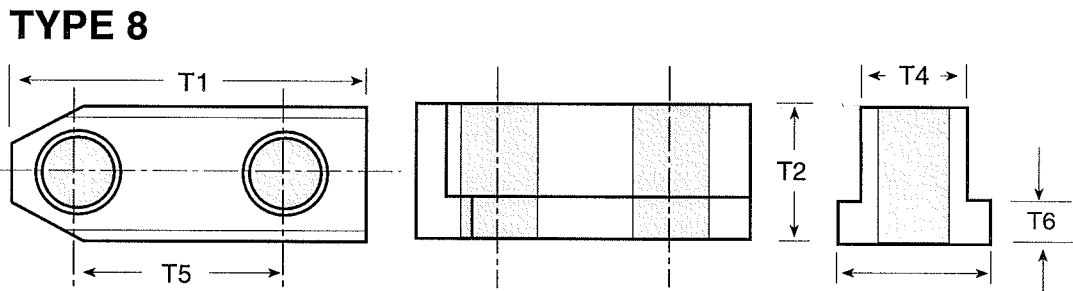
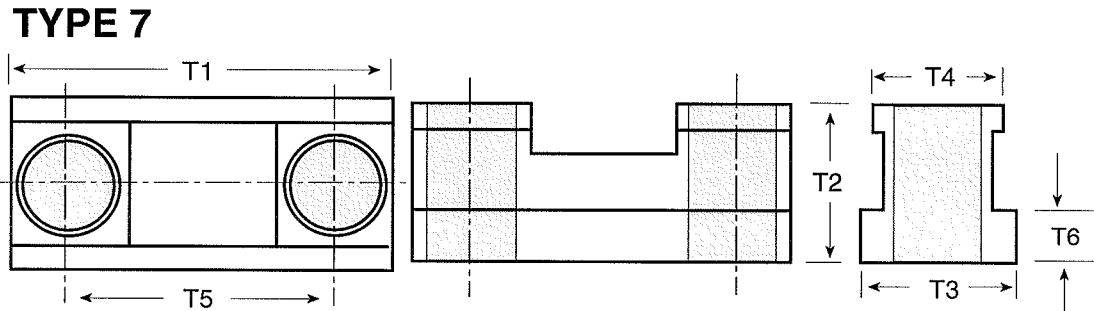
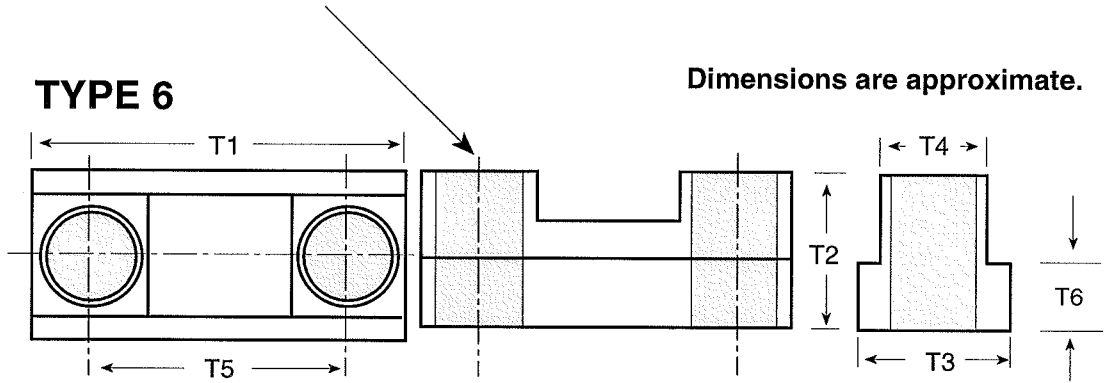


Dimensions are approximate.

TEE NUTS (2)

Dimension T4 is the critical dimension to match the chuck tee-slot width.

Dimension T7 is the tapped hole(s) for all tee nuts.



TEE NUTS (3)

CAT.NO.	Type	Origin Chuck	T1	T2	T3	T4 *	T5	T6	T7 & screw length
8380-17590	1	160mm Tudor	1 1/4"	.580"	11/16"	.498"	33/64"	.205"	M8
2980-17590	1	6.5" Tudor	1 1/4"	37/64"	11/16"	1/2"	1/2"	13/64"	5/16"whit
8380-20590	1	200mm Tudor	1 1/2"	.704"	3/4"	.560"	11/16"	.236"	M10
2770-17591	1	160mm CG	35mm	18.05mm	20mm	15.0mm	13/16"	8.5mm	M10
8380-25590	1	250mm Tudor	1 5/8"	3/4"	.845"	.623"	41/64"	.264"	M10
2980-19590	1	7.5" Tudor	1 1/2"	45/64"	3/4"	9/16"	11/16"	15/64"	3/8"whit
2980-24590	1	9.5" Tudor	1 5/8"	3/4"	27/32"	5/8"	41/64"	17/64"	7/16"whit
8380-32590	1	315mm Tudor	2 1/8"	.955"	1"	.685"	29/32"	.314"	M12
2980-31590	1	12" Tudor	2 1/8"	61/64"	1"	11/16"	29/32"	5/16"	1/2"whit
2749-02417	1	254mm FE	66.5mm	15.8mm	23.8mm	17.2mm	44.5mm	9.5mm	1/2"unc
2749-02427	1	315mm FE	74.2mm	19mm	26.9mm	20.45mm	50.8mm	11mm	5/8"unc
8380-40590	1	400mm Tudor	2 5/8"	7/8"	1 1/8"	.810"	1 3/16"	.314"	M16
2980-38590	1	15" Tudor	2 5/8"	7/8"	1 1/8"	13/16"	1 3/16"	5/16"	5/8"whit
8130-40531	1	380mm QC	95.5mm	15/16"	1 1/4"	.925"	63.5mm	9/16"	3/4"unc
2980-46590	1	18" Tudor	3"	1 5/64"	1 11/32"	1"	1 3/8"	21/64"	3/4"whit
2980-53590	1	21" Tudor	3 3/8"	1 5/64"	1 11/32"	1"	1 5/8"	21/64"	3/4"whit
2980-63590	1	25"/29" Tudor	4 3/8"	1 19/64"	1 11/32"	1"	2 1/8"	7/16"	3/4"whit
8820-17591	2	165mm HSQC/Int.	11.98mm	20.8mm	17.5mm	12mm	-		M8 x 20mm
8130-17590	2	165mm HSQC/Int.	17.5mm	20.8mm	16mm	12mm	-		M10 x 25mm
8130-21590	2	210mm HSQC/Int.	20.5mm	25mm	18.5mm	14mm	-		M12 x 30mm
8130-26590	2	254mm HSQC/Int.	21.8mm	25mm	18.5mm	16mm	-		M12 x 30mm
2870-17591	2	160mm Int.(old)	22.5mm	23mm	18.5mm	17mm	-	9mm	M12 x 30mm
2850-17591	2	160mm C. Grip	22.5mm	20mm	19mm	17mm	-	9.5mm	M12
8130-31590	2	305mm HSQC/Int.	26.4mm	33mm	24.5mm	18mm	-		M14 x 40mm
2870-26591	2	250mm Int.(old)	28.5mm	27mm	24mm	21mm	-	11mm	M16 x 35mm
8130-40590	2	380mm HSQC/Int.	33.5mm	43mm	30.5mm	22mm	-	16.5mm	M20 x 50mm
8130-50590	2	500mm HSQC	33.5mm	43mm	30.5mm	25mm	-	16.5mm	M20 x 50mm
2870-40591	2	400mm Int.(old)	36mm	29mm	28mm	25.4mm	-	11mm	M20 x 35mm

This table is presented in TYPE and tee nut width (T4) sequence. Some tee nuts are used in more than one chuck.

TEE NUTS (4)

CAT.NO.	TYPE	Origin chuck	T1	T2	T3	T4	T5	T6	T7 & screw length
8740-21591	3	200mm SCPC	21.5mm	24mm	18.9mm	17mm	-	9.5mm	M12
8740-32591	3	315mm SCPC	25.5mm	29mm	24mm	21mm	-	11.5mm	M16
2740-17590	4	160mm SCPC	34mm	22mm	17.5mm	17mm	18mm	9.5mm	M8 x 30mm
2740-21590	4	200mm SCPC	40mm	24mm	21.5mm	17mm	22mm	9.5mm	M10 x 30mm
2740-26590	4	250mm SCPC	49mm	29mm	25.5mm	21mm	25mm	11.5mm	M12 x 35mm
2740-32590	4	315mm SCPC	58mm	29mm	25.5mm	21mm	30mm	11.5mm	M12 x 35mm
2770-26591	5	250mm C.G.	50mm	20mm	23mm	17mm	1"	9.45mm	M12
2770-32591	5	315mm C.G.	66mm	28mm	29mm	21mm	1 1/4"	12.45mm	M16
2770-40591	5	400mm C.G.	82mm	28mm	29mm	21mm	1 1/2"	12.45mm	M16
2749-02407	6	FE/HSQC acme	50mm	26mm	25mm	17mm	31.8mm	12mm	1/2"unc
8130-26528	7	254mm HSQC	64mm	28.7mm	21.8mm	19.05mm	44.45mm		1/2"unc
8130-31528	7	305mm HSQC	64mm	25mm	26mm	19.06mm	44.45mm	9mm	1/2"unc
2160-17590	8	160mm CCWT	1 3/16"	5/8"	11/16"	1/2"	11/16"	13/64"	5/16"unc x 3/4"
2160-21590	8	200mm CCWT	1 7/16"	23/32"	3/4"	9/16"	13/16"	15/64"	3/8"unc x 1"
2160-26590	8	250mm CCWT	1 9/16"	27/32"	27/32"	5/8"	15/16"	17/64"	7/16"unc x 1"
2160-32590	8	315mm CCWT	2"	15/16"	1"	11/16"	1 1/4"	5/16"	1/2"unc x 1"
2160-40590	8	400mm CCWT	2 3/8"	1 3/64"	1 1/8"	13/16"	1 1/2"	5/16"	5/8"unc x 1.25"
2160-51590	8	500mm CCWT	2 3/4"	1 5/16"	1 11/32"	1"	1 3/4"	7/16"	3/4"unc x 1.75"
2160-17591	8	160mm CCWT	1 3/16"	5/8"	11/16"	1/2"	11/16"	13/64"	M8 x 20mm
2160-21591	8	200mm CCWT	1 7/16"	23/32"	3/4"	9/16"	13/16"	15/64"	M10 x 25mm
2160-26591	8	250mm CCWT	1 9/16"	27/32"	27/32"	5/8"	15/16"	17/64"	M12 x 25mm
2160-32591	8	315mm CCWT	2"	15/16"	1"	11/16"	1 1/4"	5/16"	M14 x 25mm
2160-40591	8	400mm CCWT	2 3/8"	1 3/64"	1 1/8"	13/16"	1 1/2"	5/16"	M16 x 30mm
2160-51591	8	500mm CCWT	2 3/4"	1 5/16"	1 11/32"	1"	1 3/4"	7/16"	M20 x 45mm
8130-21591	8	210mm HSQC	48mm	25.4mm	20.5mm	14mm	25.4mm	9.5mm	M12
8130-26591	8	254mm HSQC	55mm	25.4mm	21.8mm	16mm	30mm	9.5mm	M12
8130-31591	8	305mm HSQC	55.6mm	33.5mm	26.4mm	18mm	30mm	13.5mm	M14
8130-40591	8	380mm HSQC	80mm	43mm	33.5mm	22mm	43mm	16.5mm	M20
8820-13590	9	125mm Int.	26mm	16.7mm	15.9mm	12mm	14mm	7.5mm	M8
8820-46524	9	460mm Int.							
8820-61524	9	530/610 Int.	80mm	33.3mm	34.2mm	24.95mm	50mm	11mm	M20 * WATCH *

This table is presented by type and tee nut width (T4) sequence.

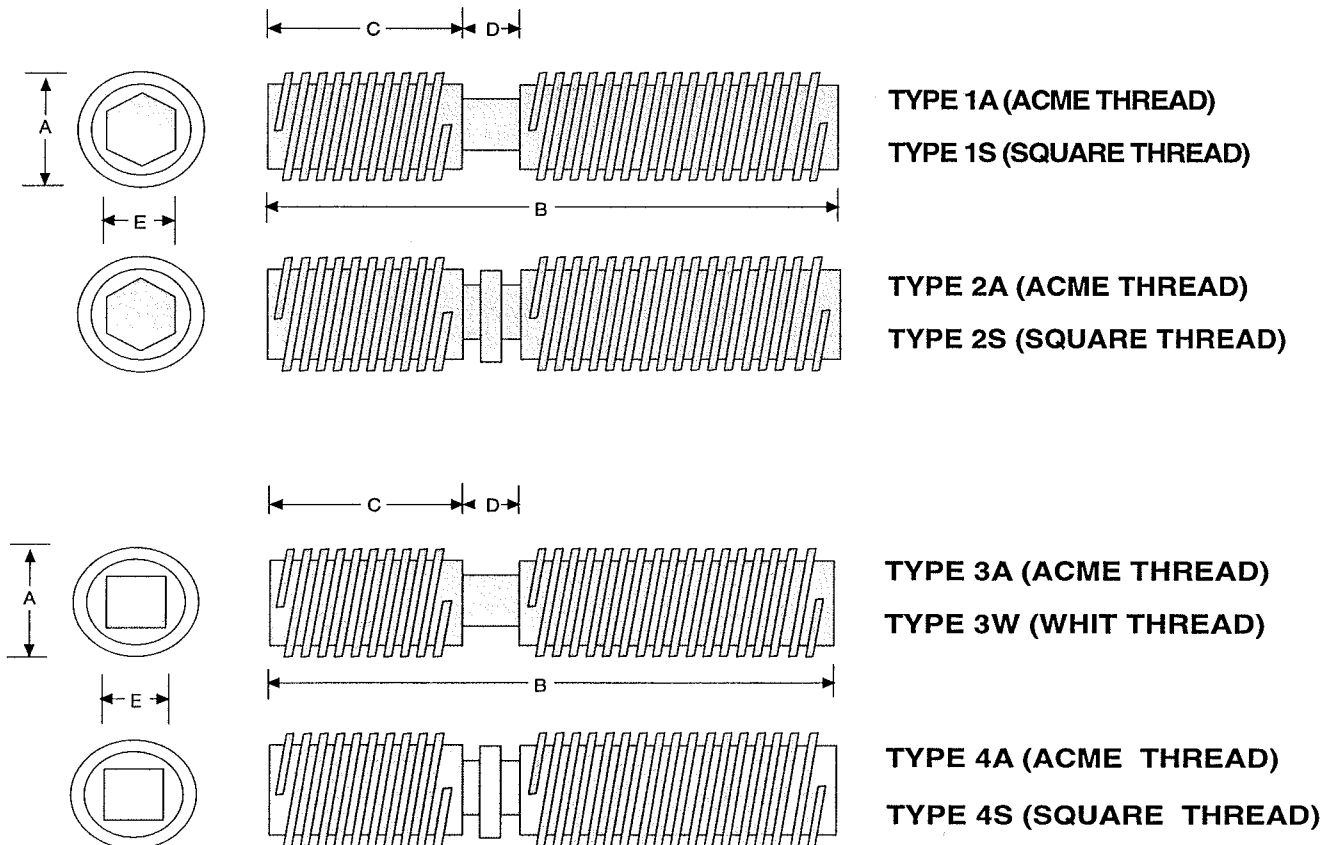
Some tee nuts are used in more than one chuck.



SCREWS (SQUARE THREAD) to 1.5" dia.

Cat.no.	Chuck Size & Type	A Dia.	B Length	C Bearing Position	D Bearing Width	E Hex. / Square	TPI	Type	Notes
0045-55365	4.5" 55sq	11/16"	1 11/16"	11/16"	5/16"	5/16"	8	1S	Obsolete
0005-55365	5" 55 sq	11/16"	1 15/16"	7/8"	5/16"	5/16"	8	1S	Obsolete
0006-55365	6" 55 sq	11/16"	2 1/8"	7/8"	3/8"	5/16"	8	1S	Obsolete
0006-35365	6" 1935 sq	13/16"	2 1/32"	7/8"	3/8"	5/16"	8	1S	Obsolete
0008-35365	8" 1935sq	15/16"	2 29/32"	3/4"	3/8"	3/8"	6	1S	Obsolete
0008-55365	8" 55 sq	15/16"	3 1/32"	3/4"	3/8"	3/8"	6	1S	Obsolete
0009-55365	9" 55 sq	15/16"	3 17/32"	1"	21/32"	3/8"	6	2S	Obsolete
0009-35365	9" 1935sq	1"	3 1/8"	1 1/2"	3/4"	1/2"	6	2S	Obsolete
0010-35365	10" 1935 sq.	1"	3 17/32"	2"	3/4"	1/2"	6	2S	Obsolete
0010-55365	10" 55 sq.	1"	3 29/32"	15/16"	21/32"	1/2"	6	2S	Obsolete
0012-60365	12" Com.sq.	1 1/8"	3 13/16"	1 11/16"	13/16"	1/2"	5	4S	Obsolete
0012-55365	12" 55 sq.	1 1/8"	4 17/32"	1 5/32"	13/16"	9/16"	5	2S/4S	Obsolete
0014-55365	14" 55 sq.	1 1/8"	5 9/32"	2 1/32"	13/16"	9/16"	5	2S	Obsolete
0015-55365	15" 55 sq.	1 1/8"	5 25/32"	1 9/32"	13/16"	9/16"	5	2S	Obsolete
2350-31365	12" 1935	1 1/4"	4 9/32"	1 1/2"	15/16"	5/8"	5	2S	Obsolete
2600-38365	15" Comb.	1 1/4"	4 9/16"	1 23/32"	15/16"	5/8"	5	2S	Obsolete
2570-38365	15" 57	1 1/4"	5 9/32"	1 7/32"	15/16"	5/8"	5	2S	Obsolete
2350-38365	15" 1935	1 1/4"	5 7/16"	1 3/32"	15/16"	5/8"	5	2S	Obsolete
2560-40365	16" 56	1 1/4"	5 25/32"	1 23/32"	15/16"	5/8"	5	2S	
2550-43365	17" 55 / 57	1 1/4"	6 9/32"	1 23/32"	15/16"	5/8"	5	2S	Short 2550-46365
2550-46365	18" 55	1 1/4"	6 25/32"	1 23/32"	15/16"	5/8"	5	2S	
Model 45	18" Burnerd	1 1/4"	6 29/32"	1 23/32"	15/16"	5/8"	5	2S	Obsolete
Model 46	20" Burnerd	1 1/4"	7 29/32"	1 23/32"	15/16"	5/8"	5	2S	Obsolete
2550-51365	20" 55	1 1/4"	7 25/32"	1 23/32"	15/16"	5/8"	5	2S	
2600-46365	18" Comb.	1 1/2"	5 7/16"	2 11/32"	15/16"	3/4"	5	2S	Obsolete
2350-40365	16" 1935	1 1/2"	5 5/8"	1 15/32"	15/16"	3/4"	5	2S	
2578-66994	26" A1-20	1 1/2"	7 1/4"	2 1/4"	15/16"	3/4"	5	2S	For 1578-66991
2350-46365	18" 1935	1 1/2"	6 1/8"	2 11/32"	15/16"	3/4"	5	2S	(from 8350-46365)
2579-03001	30" 57 Big bore	1 1/2"	6 5/8"	2 25/32"	15/16"	3/4"	5	2S	
8350-46365	460mm	1 1/2"	6 11/16"	2 11/32"	15/16"	3/4"	5	2S	(from 8350-52365)
2579-00002	30" 55 Special	1 1/2"	7 9/32"	2 15/32"	15/16"	3/4"	5	2S	Mod. 2550-56365
8350-52365	510mm	1 1/2"	7 11/16"	2 11/32"	15/16"	3/4"	5	2S	
2350-56365	22" 1935	1 1/2"	7 21/32"	2 9/32"	15/16"	3/4"	5	2S	Obsolete
2560-51365	20" 56	1 1/2"	7 25/32"	2 15/32"	15/16"	3/4"	5	2S	Use 2550-56365
2550-56365	22" 55 / 56	1 1/2"	8 9/32"	2 15/32"	15/16"	3/4"	5	2S	
Model 47	22" Burnerd	1 1/2"	8 13/32"	2 15/32"	15/16"	3/4"	5	2S	Obsolete
2350-63365	25" 1935	1 1/2"	8 9/16"	2 7/16"	15/16"	3/4"	5	2S	Obsolete
2550-61365	24" 55	1 1/2"	9 9/32"	3 15/32"	15/16"	3/4"	5	2S	
2550-66365	26" 55	1 1/2"	10 1/32"	2 11/32"	15/16"	3/4"	5	2S	
2550-71365	28" 55	1 1/2"	11 1/32"	3 11/32"	15/16"	3/4"	5	2S	
2550-76365	30" 55	1 1/2"	12 1/32"	4 11/32"	15/16"	3/4"	5	2S	
2550-81365	32" 55	1 1/2"	12 17/32"	5 15/32"	15/16"	3/4"	5	2S	
2550-92365	36" 55	1 1/2"	14 7/32"	5 15/32"	15/16"	3/4"	5	2S	

Cat.no.	Chuck Size & Type	A Dia.	B Length	C Bearing Position	D Bearing Width	E Hex.	TPI	Type	Notes
Model 48	24" Burnerd	1 1/2"	9 13/32"	3 15/32"	.937"	3/4"	5	2S	Obsolete
Model 49	26" Burnerd	1 1/2"	10 5/32"	2 11/32"	.937"	3/4"	5	2S	Obsolete
Model 50	28" Burnerd	1 1/2"	11 5/32"	3 11/32"	.937"	3/4"	5	2S	Obsolete
2350-51365	20" 1935	1 3/4"	7 3/32"	2 15/32"	1 1/8"	3/4"	5	2S	10" recess
2350-51367	20" 1935	1 3/4"	7 3/32"	4 1/32"	1 1/8"	3/4"	5	2S	Obsolete
2350-61367	24" 1935	1 3/4"	7 9/32"	2 3/16"	1 1/8"	3/4"	5	2S	mod. 2350-61365
2350-66365	26" 1935	1 3/4"	8 7/32"	2 27/32"	1 1/8"	3/4"	5	2S	Obsolete
2350-61365	24" 1935	1 3/4"	9 5/32"	2 3/16"	1 1/8"	3/4"	5	2S	10" recess
8350-61365	610mm steel	1 3/4"	8 7/8"	2 27/32"	1 1/8"	3/4"	5	2S	from 8350-71365
2350-71365	28" 1935	1 3/4"	9 7/32"	2 27/32"	1 1/8"	3/4"	5	2S	from 8350-71365
8350-71365	710mm steel	1 3/4"	11"	2 27/32"	1 1/8"	3/4"	5	2S	from 8350-81365
8350-81365	810mm steel	1 3/4"	12"	2 27/32"	1 1/8"	3/4"	5	2S	
2550-93365	42" 55	1 3/4"	17 1/2"	8 11/32"	1 1/8"	3/4"	5	2S	Obsolete
2550-94365	48" 55	1 3/4"	19 7/8"	11 11/32"	1 1/8"	3/4"	5	2S	
2350-81365	32" 1935	2 1/4"	11 3/16"	3 7/8"	1 1/2"	1"	5	2S	
2560-93365	42" 56	2 1/4"	17 1/2"	5 5/32"	1 1/2"	1"	5	2S	
2560-94365	48" 56	2 1/4"	19 3/4"	8 3/16"	1 1/2"	1"	5	2S	Obsolete





SCREWS (ACME THREAD)

Cat.no.	Chuck Size & Type	A Dia.	B Length	C Bearing Position	D Bearing Width	E Hex. / Square	TPI	Type	Notes
2520-08365	3" L / Type	1/2"	1 3/16"	21/32"	15/64"	3/16"	12	3W	RH whit thread
2540-14365	5" / 6" L/Type	11/16"	1 5/8"	5/8"	1/4"	9/32"	8	3A	
2540-16365	6" L/Type	11/16"	1 3/4"	5/8"	1/4"	9/32"	8	3A	Use 2540-14365
2540-18365	7" L/Type	11/16"	2 1/8"	1 1/8"	1/4"	9/32"	8	3A	(Boxford)
2550-12365	4.5" 55 Iron	11/16"	1 9/16"	11/16"	5/16"	5/16"	8	1A	Obsolete
2550-14365	5" 55 Iron ind.	11/16"	1 13/16"	7/8"	5/16"	5/16"	8	1A	Obsolete
2550-16365	6" 55 Iron ind.	11/16"	2 1/8"	7/8"	3/8"	5/16"	8	1A	
2550-17365	6.5" 55 Iron	11/16"	2 3/8"	3/4"	3/8"	5/16"	8	1A	Obsolete
2548-21016	8" Atlas Sears	11/16"	2 7/8"	13/16"	1/4"	9/32"	8	3A	Obsolete
2540-21365	8" L/Type	3/4"	2 3/4"	25/32"	5/16"	9/32"	8	3A	
2550-21365	8" 55 Iron ind.	15/16"	2 29/32"	3/4"	3/8"	3/8"	6	1A	
2550-23365	9" 55 Iron ind.	15/16"	3 13/32"	1"	21/32"	3/8"	6	2A	(& 3.5" F/P)
2350-23365	9" 1935 St. ind	1"	3 1/8"	1 1/2"	3/4"	1/2"	6	2A	Obsolete
2600-24365	9.5" Comb.	1"	3 3/16"	15/16"	21/32"	1/2"	6	2A	Obsolete
2540-26365	10" L/Type	1"	3 3/8"	1 3/16"	3/8"	11/32"	6	3A	
2350-26365	10" 1935	1"	3 17/32"	2"	3/4"	1/2"	6	2A	Obsolete
2550-26365	10" 55 Iron	1"	3 25/32"	15/16"	21/32"	1/2"	6	2A	
2600-31365	12" Comb.	1 1/8"	3 13/16"	1 11/16"	13/16"	9/16"	5	2A	Obsolete
2550-31365	12" 55 Iron	1 1/8"	4 13/32"	1 5/32"	13/16"	9/16"	5	2A	
2550-35365	14" 55	1 1/8"	5 9/32"	2 1/32"	13/16"	9/16"	5	2A	
2550-35366	14" Mitchell	1 1/8"	5 9/32"	1 3/16"	13/16"	9/16"	5	2A	Obsolete
2550-38365	15" 55 Iron	1 1/8"	5 25/32"	1 9/32"	13/16"	9/16"	5	2A	Obsolete
2550-40365	16" 55 Iron	1 1/8"	6 9/32"	1 21/32"	13/16"	9/16"	5	2A	Now 2568-40201
2568-40201	16" 56 D1-	1 1/8"	6 1/32"	1 21/32"	13/16"	9/16"	5	2A	
METRIC INDEPENDENT:							Pitch		
2500-17365	160mm	18mm	56mm	24mm	8mm	8mm	3mm	1A	Trapezoidal
2500-20365	200mm	24mm	73mm	45mm	12mm	12mm	4mm	1A	Trapezoidal
2500-20366	200mm D1-4	24mm	73mm	33mm	12mm	12mm	4mm	1A	Obsolete
2500-25365	250mm	24mm	93mm	34mm	12mm	12mm	4mm	1A	Trapezoidal
2500-32365	315mm	27mm	117mm	65mm	12mm	14mm	4mm	1A	Trapezoidal
2500-32366	315mm D1-	27mm	117mm	40mm	12mm	14mm	4mm	1A	Obsolete
8500-35366	350mm	27mm	135mm	37mm	12mm	14mm	4mm	1A	Trapezoidal
8500-40366	400mm	27mm	160mm	62mm	12mm	14mm	4mm	1A	Trapezoidal
8507-40001	400mm LB	27mm	152mm	62mm	12mm	14mm	4mm	1A	3 9/16" bore
8507-40021	400mm LB	27mm	145mm	62mm	12mm	14mm	4mm	1A	105mm bore
BURNERD INDEPENDENT:							TPI		
Model 39	6" Burnerd	.993"	2 1/16"	13/16"	.376"	1/2"	6	3A	Obsolete
Model 40	8" Burnerd	1.16"	2 3/4"	31/32"	.440"	7/16"	5	3A	Obsolete
Model 41	10" Burnerd	1.16"	3 5/16"	1"	.752"	1/2"	5	4A	Obsolete
Model 42	12" Burnerd	1.16"	4"	1 5/32"	.752"	1/2"	5	4A	Obsolete
Model 43	14" Burnerd	1.16"	4 15/16"	1 21/32"	.752"	1/2"	5	4A	Obsolete
Model 44	16" Burnerd	1.16"	5 11/16"	1 11/16"	.752"	1/2"	5	4A	Obsolete



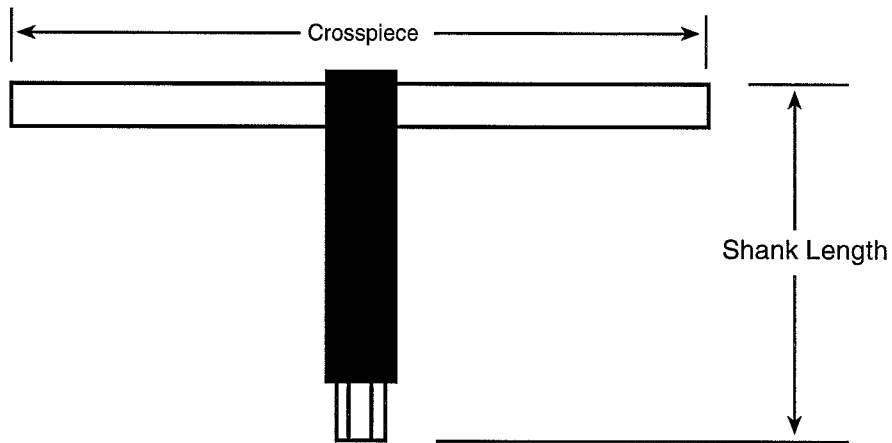
Square	Length	Crosspiece	dia.	Code No.
3/16"	2 3/4"	3 1/8"	3/16"	2520-08395
3/16"	2 3/4"	4 1/2"	3/16"	2520-10395
6mm	65mm	100mm	5mm	8580-08395
6mm	90mm	140mm	5mm	8580-10395
9/32"	2 3/8"	4 1/4"	1/4"	2580-08395
9/32"	2 3/8"	4 1/4"	1/4"	2630-08395
9/32"	4"	6 1/2"	1/4"	2540-21395
8mm	95mm	170mm		8580-13395
5/16"	3 1/4"	5 1/4"	5/16"	2580-10395
5/16"	3 1/4"	5 1/4"	5/16"	2630-10395
5/16"	6"	5 1/4"	5/16"	2587-10010/A
11/32"	4 1/8"	8"	3/8"	2540-26395
9mm	3"	6 1/2"	5/16"	2210-13395
9mm	6"	156mm	5/16"	2218-13208
9mm	115mm	200mm	10mm	8580-17395
3/8"	4"	6 3/4"	3/8"	2580-16395
10mm	3 1/2"	8"	3/8"	2210-17395
13/32"	3 9/16"	8"	7/16"	2980-17395
13/32"	6 1/2"	8"	7/16"	2987-17015
11mm	6 1/4"	10 1/2"	1/2"	2218-20208
11mm	8"	10 1/2"	1/2"	2217-21020/A
11mm	140mm	280mm		8580-20395
11mm	315mm	280mm	(Ajax)	2219-20395-A
11mm	14" (J & S)	10.5"	1/2"	8217-20060
12mm	6 1/2"	13"	5/8"	2218-25208
12mm	165mm	320mm	26mm	8580-25395
12mm	14"			8217-25060
12mm	315mm	320mm	(Ajax)	2219-25395-A
1/2"	3 7/8"	12"	1/2"	2980-26395
1/2"	7"	9 1/4"		2988-26991
14mm	7 1/4"	16"	5/8"	2218-32208
14mm	185mm	360mm		8580-32395
9/16"	3 7/8"	12"	1/2"	2780-27395
9/16"	4 3/4"	16"	5/8"	2580-38395
9/16"	7 3/4"	8"	1/2"	2987-24060
9/16"	8 1/4"	16"	5/8"	2987-31010/A
17mm	250mm	450mm		8580-40395
17mm	120mm	16"	5/8"	8271-40395
11/16"	5 1/8"	18"	5/8"	2980-38395
11/16"	10"			2788-38994
13/16"	5 3/8"	23 1/2"	7/8"	2980-63395



KEYS - HEXAGONAL



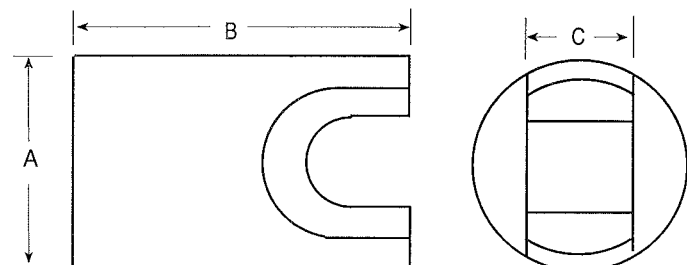
HEXAGONAL	Shank Length	Crosspiece	Crosspiece dia.	Code No.
5/16"	3 7/16"	6"	5/16"	2550-16395 *
8mm	130mm	150mm	8mm	2500-17395 *
3/8"	4 13/16"	9 1/2"	7/16"	2550-21395
12mm	165mm	200mm	10mm	2500-20395
12mm	165mm	250mm	10mm	2500-25395
1/2"	6 1/4"	10"	1/2"	2550-26395
14mm	180mm	300mm	12mm	2500-32395
14mm	14"	300mm		2507-32395
9/16"	7"	12"	5/8"	2550-31395
5/8"	6 7/8"	16"	5/8"	2350-38395
3/4"	7 3/8"	16"	5/8"	2350-40395
3/4"	10 3/8"	23 1/2"	7/8"	2550-92395
3/4"	5 1/8"			2660-16395
3/4"	5 3/8"	20"	7/8"	2680-26395
1"	10 3/8"	23 1/2"	7/8"	2350-81395
* Interchangeable, but different shank lengths.				



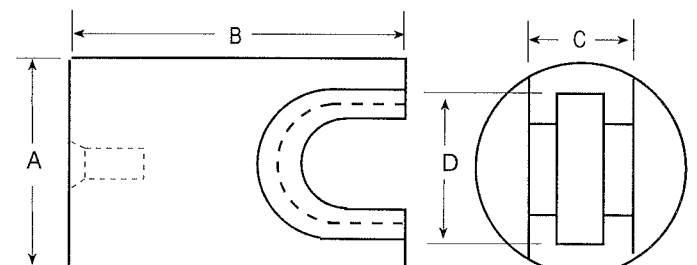
Cat No.	Chuck size & type	A	B	C	D (Screw dia.)	Type
2540-14370	5" / 6" L/Type	1 1/16"	1 1/16"	1/4"	1 1/16"	1
2550-12370	4.5" 55 Iron	1 1/16"	1 1/8"	5/16"	1 1/16"	1
2540-21370	8" L/Type	3/4"	1 3/32"	5/16"	3/4"	1
2550-16370	6" 55 Iron	3/4"	1 5/32"	3/8"	1 1/16"	1
2550-17370	6.5" Iron	3/4"	1 19/32"	3/8"	1 1/16"	1
2350-16370	6" 1935 Steel	13/16"	1 13/32"	3/8"	1"	1
2540-26370	10" L/Type	7/8"	1 3/4"	3/8"	1"	1
2550-21370	8" 55 Iron	7/8"	2 1/16"	3/8"	15/16"	1
2350-26370	10" 1935 Steel	1"	1 15/16"	3/4"	1"	2
2550-26370	10" 55 Iron	1"	2 1/16"	21/32"	1"	2
2550-31370 ◊	12" 55 Iron	1 1/4"	2 3/16"	13/16"	1 1/8"	2
2550-40370 ◊	16" 55 Iron	1 1/4"	2 3/8"	13/16"	1 1/8"	2
2350-31370 †	12" 1935 Steel	1 3/8"	2 1/8"	15/16"	1 1/4"	2
2560-40370 †	16" 56 SG Iron	1 3/8"	2 11/32"	15/16"	1 1/4"	2
2550-46370 †	18" 55 Iron	1 3/8"	2 5/8"	15/16"	1 1/4"	2
2350-38370 †	15" 1935 Steel	1 3/8"	2 23/32"	15/16"	1 1/4"	2
2550-51370 †	20" 55 Iron	1 3/8"	2 7/8"	15/16"	1 1/4"	2
2350-46373 ‡	18" 1935 (14.25" rec)	1 5/8"	2 3/16"	15/16"	1 1/2"	2
2550-61370 ‡	24" 55 Iron	1 5/8"	2 23/32"	15/16"	1 1/2"	2
2560-76370 ‡	30" 56 SG Iron	1 5/8"	2 7/8"	15/16"	1 1/2"	2
2350-46370 ‡	18" 1935 Steel	1 5/8"	3"	15/16"	1 1/2"	2
2550-76370 ‡	30" 55 Iron	1 5/8"	3 3/32"	15/16"	1 1/2"	2
2550-92370 ‡	36" 55 Iron	1 5/8"	3 7/32"	15/16"	1 1/2"	2
2350-56370 ‡	22" 1935 Steel	1 5/8"	3 3/4"	15/16"	1 1/2"	2
2350-51373 §	20" 1935 (13" rec)	2"	2 15/16"	1 1/8"	1 3/4"	2
2350-51370 §	20" 1935 Steel	2"	3 17/32"	1 1/8"	1 3/4"	2
2350-61370 §	24" 1935 Steel	2"	3 25/32"	1 1/8"	1 3/4"	2
2550-93370 §	42" 55 Iron	2"	3 31/32"	1 1/8"	1 3/4"	2
2350-66370 §	26" 1935 Steel	2"	4 7/32"	1 1/8"	1 3/4"	2
2560-93370	42" 56 SG Iron	2 1/2"	3 11/16"	1 1/2"	2 1/4"	2
2350-81370	32" 1935 Steel	2 1/2"	4 1/2"	1 1/2"	2 1/4"	2
METRIC IND.						
2500-17370	160mm	18mm	28mm	8mm		1
2500-20370	200mm & 250mm	24mm	38mm	12mm		1
2500-32370	315mm to 400mm	27mm	42mm	12mm		1

Many of these bearings are no longer manufactured. It is possible, on the types marked †, ‡, § and ◊ to use a longer bearing, if available, and machine to the required size but it may be necessary to re-drill and tap the bearing extraction hole. If utilising a bearing which is shorter than the specified length, it is possible to deepen the bearing retaining screw and re-tap to secure the bearing.

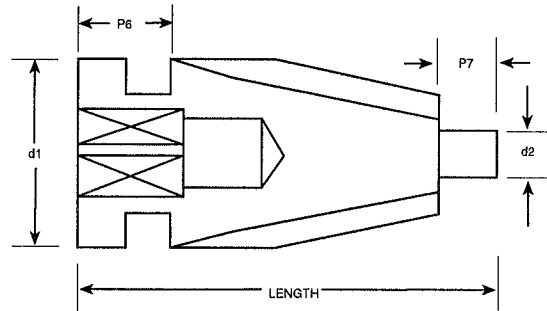
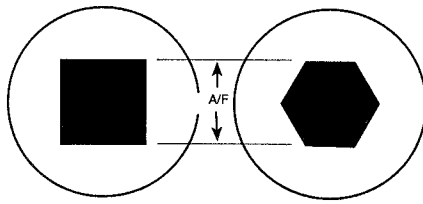
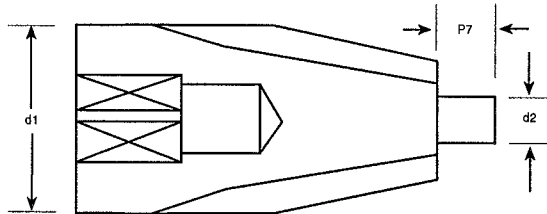
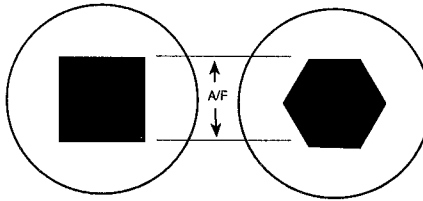
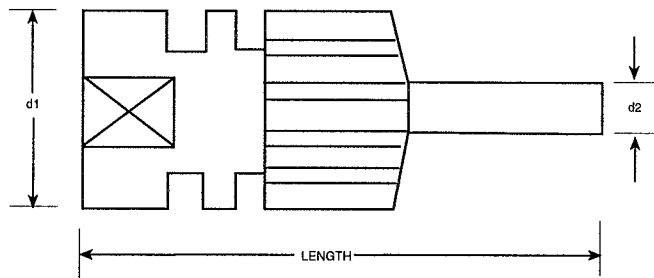
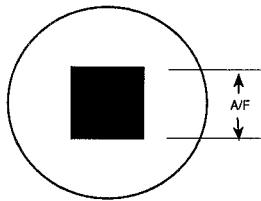
SINGLE THRUST BEARING (TYPE 1)



DOUBLE THRUST BEARING (TYPE 2)



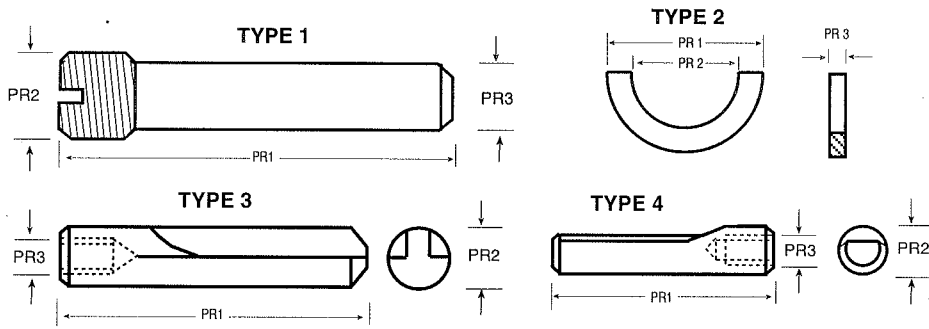
PINIONS (1)

TYPE 1 (Pinion pin retention)

TYPE 2 (Circlip retention)

TYPE 3 (Standard Accuracy)


Cat.no.	Origin chuck	Length	d1	d2	A/F	Hole	Type	Teeth	Notes
8580-08350	80mm Standard Accuracy	29.5mm	20.5mm	7.92mm	6mm	Square	3	10	
2580-08350	3" / 80mm Burnerd model 29	1 1/8"	13/16"	5/16"	9/32"	Square	1	10	
8580-10350	100mm Standard Accuracy	34.0mm	22mm	7.98mm	6mm	Square	3	10	
2580-10350	4" / 100mm Burnerd mod.30	1 5/16"	13/16"	5/16"	5/16"	Square	1	10	
2588-14063	5" Hardinge 30AHC/X	1 9/16"	13/16"	5/16"	5/16"	Square	1	9	
2580-14350	5" Burnerd model 30A	1 5/8"	13/16"	5/16"	5/16"	Square	1	9	Obsolete
8580-13350	125mm Standard Accuracy	41.7mm	27mm	7.91mm	8mm	Square	3	10	
2210-13350	125mm Iron & SP	1 21/32"	1 1/16"	5/16"	.354"	Square	1	10	
2380-17350	6.5" Tudor (1980-1987)	1 3/4"	1 1/8"	3/8"	13/32"	Square	1	9	Obsolete
0006-58350	6" Pratt Iron 58	1 25/32"	1 1/8"	3/8"	13/32"	Square	1	9	Obsolete
2580-16350	6" Burnerd model 31	1 27/32"	1"	1/2"	3/8"	Square	1	12	Obsolete
2980-17350	6.5" Tudor (Pre 1966)	1 15/16"	1 1/8"	3/8"	13/32"	Square	1	9	Obsolete
2980-17351	6.5" Tudor (1966-1980)	1 15/16"	1 1/8"	3/8"	13/32"	Square	2	9	P7 = 1/2" Obs.
2980-19351	7.5" Tudor (1966-1980)	1 15/16"	1 1/8"	3/8"	13/32"	Square	2	9	P7 = 7/16" Obs.
2380-19350	7.5" Tudor (1980-1987)	1 31/32"	1 1/8"	3/8"	13/32"	Square	1	9	Obsolete
8580-17350	160mm Standard Accuracy	51.0mm	28.5mm	9.51mm	9mm	Square	3	10	
2980-19350	7.5" Tudor (Pre 1966)	2 1/32"	1 1/8"	3/8"	13/32"	Square	1	9	P6 = 5/16" Obs.
2780-19350	7.5" Pratt 58 / 78	2 1/32"	1 1/8"	3/8"	13/32"	Square	1	9	P6 = 13/32" Obs.
2210-17350	160mm Iron & SP	2 1/16"	1 1/8"	3/8"	10mm	Square	1	10	
2980-26350	10" Tudor	2 1/8"	1 5/16"	1/2"	1/2"	Square	1	9	Obsolete

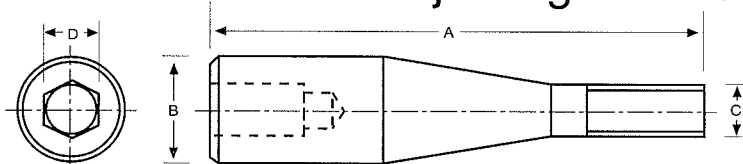
Cat.no.	Origin chuck	Length	d1	d2	A/F	Hole	Type	Teeth	Notes
2380-24350	9.5" Tudor (1980-1987)	2 3/16"	1 5/16"	1/2"	9/16"	Square	1	9	Obsolete
2780-23350	9" Pratt 58 / 78	2 3/16"	1 5/16"	1/2"	9/16"	Square	1	11	Obsolete
2600-24351	9.5" Combination	2 3/16"	1 5/16"	1/2"	1/2"	Hex.	2	9	Interchangeable except for key. Both obsolete.
2980-24351	9.5" Tudor (1963-1980)	2 3/16"	1 5/16"	1/2"	9/16"	Square	2	9	
2380-31350	12" Tudor (1980-1987)	2 5/16"	1 5/16"	1/2"	9/16"	Square	1	9	
2980-24350	9.5" Tudor (Pre 1963)	2 11/32"	1 5/16"	1/2"	9/16"	Square	1	9	Obsolete
2780-27350	10.5" Pratt 58 / 78	2 11/32"	1 5/16"	1/2"	9/16"	Square	1	11	Obsolete
2780-31350	12" Pratt 58 / 78	2 13/32"	1 5/16"	1/2"	9/16"	Square	1	11	
2980-31351	12" Tudor (1964-1980)	2 13/32"	1 5/16"	1/2"	9/16"	Square	2	9	Interchangeable except for key. Both obsolete.
2600-31351	12" Combination	2 13/32"	1 5/16"	1/2"	9/16"	Hex.	2	9	
2580-19350	7.5" Burnerd model 52	2 13/32"	1 1/8"	3/8"	13/32"	Square	1	10	Obsolete
2580-21350	8" Burnerd model 51	2 17/32"	1 5/16"	3/8"	1/2"	Square	1	11	Obsolete
8580-20350	200mm Standard Accuracy	65.0mm	30.1mm	9.52mm	11mm	Square	3	9	
0012-60350	12" Combination (old)	2 9/16"	1 5/16"	1/2"	1/2"	Square	1	9	Obsolete
2980-31350	12" Tudor (Pre 1964)	2 9/16"	1 5/16"	1/2"	9/16"	Square	1	9	Interchangeable except for key. Both obsolete.
2600-31350	12" Combination	2 9/16"	1 5/16"	1/2"	9/16"	Hex.	1	9	
2580-38350	15" Pratt 58 / 78	2 9/16"	1 5/16"	1/2"	9/16"	Square	1	11	Obsolete
2210-20350	200mm Iron & SP	2 5/8"	1 3/16"	3/8"	.433"	Square	1	10	
2250-20350	200mm Griptru	2 5/8"	1 3/16"	3/8"	.433"	Square	1	10	Pilot Hole Obs.
2580-23350	9" Burnerd model 53	2 25/32"	1 5/16"	3/8"	9/16"	Square	1	11	Obsolete
2219-00372	8" / 200mm Setricite	2 13/16"	2 5/8"	1 3/16"	3/8"	Square	1	10	Pilot Hole Obs.
8580-25350	250mm Standard Accuracy	77.7mm	33.3mm	12.68mm	12mm	Square	3	10	
2600-38351	15" Combination	3 1/32"	1 5/8"	9/16"	5/8"	Hex.	2	10	Interchangeable except for key. Both obsolete.
2980-38351	15" Tudor (1966-1980)	3 1/32"	1 5/8"	9/16"	11/16"	Square	2	10	
2210-25350	250mm Iron & SP	3 1/16"	1 5/16"	1/2"	.472"	Square	1	11	
2250-25350	250mm Griptru	3 1/16"	1 5/16"	1/2"	.472"	Square	1	11	Pilot Hole Obs.
2580-27350	10.5" Burnerd model 54	3 1/16"	1 5/16"	3/8"	9/16"	Square	1	11	Obsolete
2380-38350	15" Tudor (1980-1987)	3 11/64"	1 5/8"	9/16"	11/16"	Square	1	10	Obsolete
2600-38350	15" Combination	3 7/32"	1 5/8"	9/16"	5/8"	Hex.	1	10	Interchangeable except for key.
2980-38350	15" Tudor (Pre 1966)	3 7/32"	1 5/8"	9/16"	11/16"	Square	1	10	
2380-46350	18" / 21" Tudor (1980-1987)	3 9/32"	1 5/8"	9/16"	11/16"	Square	1	10	
2980-46351	18" / 21" Tudor (1966-1980)	3 9/32"	1 5/8"	9/16"	11/16"	Square	2	10	Interchangeable except for key.
2600-46351	18" / 21" Combination	3 9/32"	1 5/8"	9/16"	3/4"	Hex.	2	10	
2980-46350	18" / 21" Tudor (Pre 1966)	3 15/32"	1 5/8"	9/16"	11/16"	Square	1	10	Interchangeable except for key.
2600-46350	18" / 21" Combination	3 15/32"	1 5/8"	9/16"	3/4"	Hex.	1	10	
2580-46350	18" Pratt 58 / 78	3 1/2"	1 7/16"	5/8"	11/16"	Square	1	12	
8580-32350	315mm Standard Accuracy	92.0mm	40.0mm	13.98mm	14mm	Square	3	11	
2210-32350	315mm Iron & SP	3 19/32"	1 3/8"	1/2"	.551"	Square	1	12	
2250-32350	315mm Griptru	3 19/32"	1 3/8"	1/2"	.551"	Square	1	12	Pilot Hole Obs.
2580-31350	12" Burnerd BP	3 5/8"	1 5/16"	1/2"	9/16"	Square	1	11	Obsolete
2380-63350	25" Tudor (1980-1987)	3 3/4"	1 7/8"	3/4"	13/16"	Square	1	12	
2580-53350	21" Pratt 58 / 78	3 3/4"	1 7/16"	5/8"	11/16"	Square	1	12	
2980-63351	25" Tudor (1966-1980)	3 3/4"	1 7/8"	3/4"	13/16"	Square	2	12	Obsolete
2980-63350	25" Tudor (Pre 1966)	3 31/32"	1 7/8"	3/4"	13/16"	Square	1	12	
2219-00412	380mm Setricite	4 1/8"	1 5/8"	.560"	9/16"	Square	1	10	
2380-73350	29" Tudor (1980-1987)	4 13/16"	1 7/8"	3/4"	13/16"	Square	1	12	
8580-40350	400mm Standard Accuracy	122mm	44.0mm	15.97mm	17mm	Square	3	12	
2980-73351	29" Tudor (1966-1980)	4 7/8"	1 7/8"	3/4"	13/16"	Square	2	12	Obsolete
8270-40350	400mm Super Precision	125mm	42mm	12.8	17mm	Square	1	11	
2980-73350	29" Tudor (Pre 1966)	5 1/16"	1 7/8"	3/4"	13/16"	Square	1	12	
2580-61350	24" Pratt 58 / 78	5 7/32"	1 7/16"	5/8"	11/16"	Square	1	12	

PINION RETAINERS



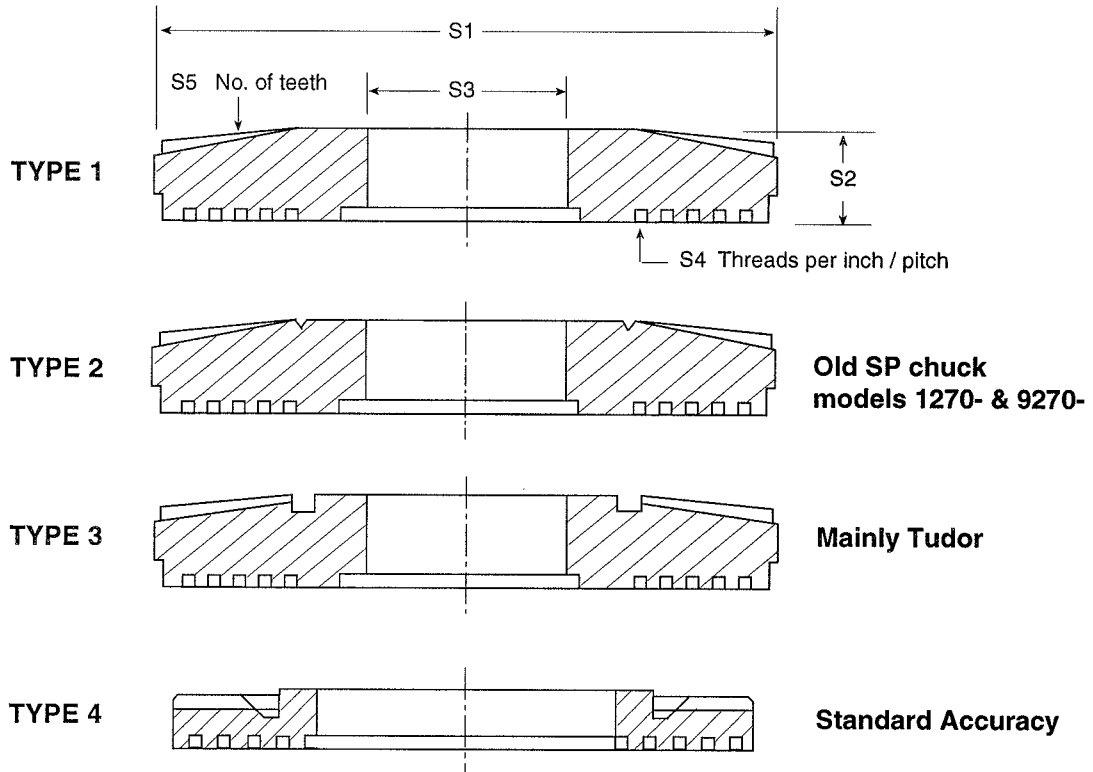
Cat.no.	Type	PR1	PR2	PR3
2580-08356	1	1 1/4"	10-32UNF	.155"
2580-14356	1	1 3/16"	1/4" UNC	.187"
2588-14065	1	1 3/16"	1/4" UNC	.200"
2210-13356	1	1 15/32"	5/16" UNF	.25"
2580-16356	1	1 1/2"	5/16" UNC	.255"
2210-20356	1	1 13/16"	3/8" UNF	.31"
2580-27356	1	1 7/8"	5/16" UNC	.255"
8580-08356	1	34mm		3mm
8580-13356	1	40mm		4mm
8580-25356	1	46mm		5mm
8580-32356	1	60mm		6mm
8580-40356	1	66mm		8mm
2780-19359	2	1 5/16"	15/16"	.155"
2780-23359	2	1 5/8"	1 3/32"	.186"
2980-17355	3	1 1/4"	1/4"	5/32" whit
2980-31355	3	1 17/32"	5/16"	3/16" whit
2980-46355	3	1 3/4"	5/16"	3/16" whit
2980-73355	3	2 5/16"	5/16"	3/16" whit
2310-20356	4	1 1/2"	.3115" (5/16")	M 4

GRIPTRU Micro adjusting screws



Cat.no.	A	B	C	D
2630-08360	1 9/32"	5/16"	7/32" whit	5/32"
2630-10360	1 5/8"	7/16"	1/4" unc	3/16"
2630-14360	1 27/32"	7/16"	5/16" unc	3/16"
2630-16360	2"	7/16"	5/16" unc	7/32"
2250-20360	3"	9/16"	5/16" unc	9/32"
2630-21360	3 7/16"	5/8"	3/8" unc	5/16"
2630-27360	4 1/16"	11/16"	7/16" unc	3/8"

SCROLLS (1)



* = Hardened and ground		S1	S2	S3	S4	S5		
Cat.no.	Chuck Size & Type	Dia.	Width	Bore	Threads per inch	Number of teeth	Type	Notes
2580-06300	2.75" Burnerd	2 5/32"	7/16"	1 1/8"	6	40	1	
8210-08300	80mm Super Prec.	2 5/32"	7/16"	1 1/8"	6mm pitch	36	1	Metric pitch
-	3" Pratt Iron	2 21/64"	25/64"	1 1/4"	6	40	1	
2580-08300	3" Burnerd model 29	2 15/32"	7/16"	1 1/4"	6	36	1	
8580-08300	80mm Std. Accuracy	62mm	13mm	32mm	6mm pitch	32	4	Metric pitch
2580-10300	100mm model 30	2 21/32"	15/32"	1 5/8"	5	37	1	
2270-10330 *	100mm SP (Old)	2 21/32"	15/32"	1 5/8"	5	37	2	Use 2580-10300
8210-10300G	100mm Super Prec.	2 21/32"	15/32"	1 5/8"	6mm pitch	37	1	Metric pitch
8580-10300	100mm Std. Accuracy	74mm	13mm	41mm	6mm pitch	33	4	Metric pitch
-	4" Pratt Iron	3 1/4"	9/16"	1 5/8"	4	37	1	Obsolete
2210-13300	125mm Iron	3 23/32"	5/8"	2 1/8"	4	38	1	
2270-13330 *	125mm SP (Old)	3 23/32"	5/8"	2 1/8"	4	38	2	Use 2210-13300
8210-13300G	125mm Super Prec.	3 23/32"	5/8"	2 1/8"	6mm pitch	38	1	Metric pitch
2580-14300	5" Burnerd model 30A	3 31/32"	5/8"	2 11/32"	4	53 (48 on old type)	1	Obsolete
-	5" Hardinge 30A2	3 31/32"	15/32"	2 11/32"	4	48	1	Obsolete
2588-14062	5" Hardinge 30 AHC	3 31/32"	15/32"	2 11/32"	4	53	1	Obsolete
-	5" Pratt Iron	4"	21/32"	1 7/8"	4	44	1	Obsolete
8580-13300	125mm Std. Accuracy	94mm	17mm	54mm	6mm pitch	42	4	Metric pitch

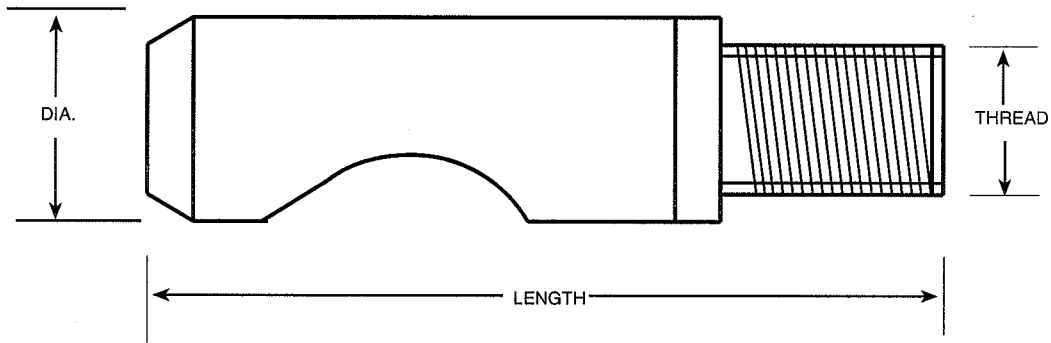
SCROLLS (2)

* = Hardened and ground		S1	S2	S3	S4	S5		
Cat.no.	Chuck Size & Type	Dia.	Width	Bore	Threads per inch	Number of teeth	Type	Notes
2210-17300	160mm Iron	4 29/32"	11/16"	2 3/4"	4	50	1	
2270-17330 *	160mm SP (Old)	4 29/32"	11/16"	2 3/4"	4	50	2	Use 2210-17300
-	6" Pratt Iron	4 31/32"	5/8"	2 13/32"	3	50	1	Obsolete
2580-16300	6" Burnerd model 31	4 31/32"	5/8"	3"	4	61	1	
8210-17300G	160mm Super Prec.	4 29/32"	11/16"	2 3/4"	6mm pitch	50	1	Metric pitch
8580-17300	160mm Std. Accuracy	122mm	17mm	70mm	6mm pitch	52	4	Metric pitch
8219-00363	160mm / 6" Setrite	124.3mm	17.47mm	70mm	6mm pitch	50	2	Metric pitch
2980-17300	6.5" Tudor	5"	5/8"	2 17/32"	3	48	3	Obsolete
2980-17303	6.5" Tudor A1-5	5"	5/8"	3 1/32"	3	48	3	Obsolete
2580-19300	7.5" Burnerd model 52	5 7/8"	23/32"	3 1/4"	3	62	1	Obsolete
2780-19300	7.5" Pratt 58/78	5 7/8"	23/32"	3 9/32"	3	61	1	Obsolete
2980-19300	7.5" Tudor	5 7/8"	23/32"	3 9/32"	3	59	3	Obsolete
2980-19304	7.5" Tudor A1-6	5 7/8"	23/32"	3 15/16"	3	59	3	Obsolete
2210-20300	200mm Iron	6 9/32"	3/4"	3 3/8"	3	59	1	
2270-20330 *	200mm SP	6 9/32"	3/4"	3 3/8"	3	59	2	Use 2210-20300
2580-21300	8" Burnerd model 51	6 7/16"	11/16"	3 15/16"	3	65	1	Obsolete
8210-20300G	200mm Super Prec.	6 9/32"	3/4"	3 3/8"	8mm pitch	59	1	Metric pitch
8580-20300	200mm Std. Accuracy	158mm	20mm	85mm	8mm pitch	58	4	Metric pitch
8219-00373	200mm / 8" Setrite	159.2mm	19.07mm	85.72mm	8mm pitch	59	2	Metric pitch
2780-22303	8.25" 78 D1-5	6 3/4"	23/32"	3 1/2"	3	59	3	Obsolete
2780-22304	8.25" 78 A1-6	6 3/4"	23/32"	3 5/16"	3	59	3	Obsolete
2580-23300	9" Burnerd model 53	7 7/16"	23/32"	4 3/8"	3	76	1	Obsolete
2780-23300	9" Pratt 78	7 9/16"	23/32"	4 3/8"	3	76	1	Obsolete
2980-24300	9.5" Tudor	7 9/16"	23/32"	4 3/8"	3	66	3	Obsolete
2210-25300	250mm Iron	7 25/32"	25/32"	4 3/4"	3	74	1	
2270-25330 *	250mm SP (Old)	7 25/32"	25/32"	4 3/4"	3	74	2	Use 2210-25300
2780-26304	10" Pratt 78 A1-6	8 7/16"	23/32"	4 3/4"	3	74	3	Obsolete
2780-26303	10" Pratt 78 A1-5	8 7/16"	23/32"	4 7/8"	3	74	3	Obsolete
2980-26305	10" Pratt 98 A1-8	8 7/16"	23/32"	5 3/16"	3	74	3	Obsolete
2980-26304	10" Pratt 98 A1-6	8 7/16"	23/32"	5 7/8"	3	74	3	Obsolete
8210-25300G	250mm Super Prec.	7 25/32"	25/32"	4 3/4"	8mm pitch	74	1	Metric pitch
8580-25300	250mm Std. Accuracy	196mm	23.4mm	120mm	8mm pitch	66	4	Metric pitch
2219-00381	10" Setrite (old)	7 25/32"	25/32"	5 1/8"	3	74	1	Hardened
8219-00383	250mm / 10" Setrite	198.1mm	20.65mm	130mm	8mm pitch	74	2	Metric pitch
2580-27300	10.5" Burn. model 54	8 13/16"	3/4"	5 1/2"	3	90	1	Obsolete
2780-27300	10.5" Pratt 78	8 7/8"	3/4"	5 1/4"	3	91	1	Obsolete

SCROLLS (3)

* = Hardened and ground		S1	S2	S3	S4	S5		
Cat.no.	Chuck Size & Type	Dia.	Width	Bore	Threads per inch	Number of teeth	Type	Notes
2980-31300	12" Tudor	9 5/16"	7/8"	5 7/8"	3	87	3	Obsolete
2780-31304	12" Pratt 78 A1-6	9 5/16"	7/8"	6"	3	87	3	Obsolete
2580-31300	12" Burnerd model 55	10 3/16"	7/8"	5 7/8"	3	104/105	1	Obsolete
2210-32300	315mm Iron	10 7/32"	15/16"	6 1/8"	3	98	1	
2270-32330 *	315mm SP (old)	10 7/32"	15/16"	6 1/8"	3	98	2	Use 2210-32300
2780-31300	12" Pratt 58/78	10 5/16"	7/8"	5 7/8"	3	105	1	Obsolete
8210-32300G	315mm Super Prec.	10 7/32"	15/16"	6 1/8"	10mm pitch	98	1	Metric pitch
8580-32300	315mm Std. Accuracy	258mm	25mm	155mm	10mm pitch	74	4	Metric pitch
8219-00393	315mm / 12" Setrite	259mm	23.8mm	155mm	8mm pitch	98	2	Metric pitch
2980-38300	15" Tudor	12 7/16"	7/8"	6 5/8"	2.5	105	3	Obsolete
2980-38305	15" Tudor A1-8	12 7/16"	7/8"	7 5/8"	2.5	105	3	Obsolete
2780-38306	15" Pratt 78 A1-11	12 7/16"	7/8"	7 3/4"	2.5	105	3	Obsolete
2580-38300	15" Pratt 58/78	12 15/16"	7/8"	5 7/8"	2.5	130	1	
2580-38304	15" Pratt 58 A1-6	12 15/16"	7/8"	6"	2.5	130	1	Obsolete
2580-38306	15" Pratt 58 A1-11	12 15/16"	7/8"	7 1/2"	2.5	130	1	Obsolete
2219-00403	15" Setrite (old)	12.45"	.856"	7 3/4"	2.5	105	1	
8219-00403	380mm / 15" Setrite	316.2mm	21.8mm	197mm	10mm pitch	105	1	Metric pitch
8210-40300G	400mm Super Prec.	328mm	22mm	180mm	12mm pitch	130	1	Metric pitch
8580-40300	400mm Std. Accuracy	326mm	31mm	180mm	12mm pitch	93	4	Metric pitch
8270-40300	400mm SP (Old)	328mm	22mm	180mm	2.5	130	1	
2980-46300	18" Tudor	14 15/16"	15/16"	7 7/8"	2	126	3	
2580-46300	18" Pratt 58/78	15 1/2"	7/8"	7 3/8"	2	154	1	Obsolete
2580-46305	18" Pratt 58 A1-8	15 1/2"	7/8"	7 7/8"	2	154	1	Obsolete
8270-47300	460mm / 18"	15 1/2"	7/8"	8 3/4"	2	154	1	
8270-53300	530mm / 21"	18"	7/8"	8 1/2"	2	180	1	
2980-53300	21" Tudor	17 25/32"	15/16"	8 1/2"	2	150	3	
2980-53307	21" Tudor A1-15	17 25/32"	15/16"	11"	2	150	3	Obsolete
2580-53300	21" & 24" Pratt 58/78	18"	7/8"	7 3/8"	2	180	1	Obsolete
2580-53305	21" Pratt 58 A1-8	18"	7/8"	7 7/8"	2	180	1	Obsolete
2580-53307	21" Pratt 58 A1-15	18"	7/8"	11"	2	180	1	Obsolete
2980-63300	25" Tudor	21 11/32"	15/16"	11 1/2"	2	180	3	
2980-63307	25" Tudor A1-15	21 11/32"	15/16"	14 1/4"	2	180	3	Obsolete
2980-73300	29" Tudor	23 15/32"	1 1/16"	13 1/4"	2	198	3	
2980-73307	29" Tudor A1-15	23 15/32"	1 1/16"	14 1/4"	2	198	3	Obsolete
2980-73308	29" Tudor A1-20	23 15/32"	1 1/16"	16 5/8"	2	198	3	Obsolete
2920-73300	29" Titan	23 1/2"	1 13/16"	13 1/4"	2	141	3 (spec)	Obsolete

CAMLOCK STUD



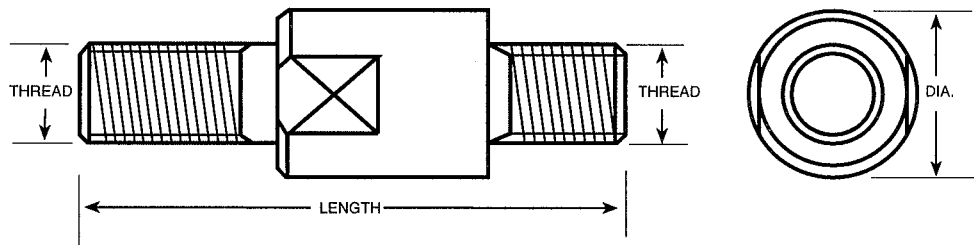
CAMLOCK STUD DIMENSIONS ARE IN INCHES

Cat No. (UNF)	Type	Length	Diameter	Thread (unf)	Retaining screw (cat. no.)
2550-12403	D1-2	1 29/32"	7/16"	3/8" unf	
2550-16403	D1-3	2 1/8"	9/16"	7/16" unf	CA0.250UNC0.500
2550-21403	D1-4	2 3/16"	5/8"	7/16" unf	CA0.250UNC0.500
2550-26403	D1-5	2 9/16"	3/4"	1/2" unf	CA0.250UNC0.500
2550-31403	D1-6	3"	7/8"	5/8" unf	CA0.313UNC0.625
2550-40403	D1-8	3 3/8"	1"	3/4" unf	CA0.313UNC0.625
2550-51403	D1-11	4"	1 3/16"	7/8" unf	CA0.313UNC0.625
2550-76403	D1-15	4 9/16"	1 3/8"	1"-14 anf	CA0.313UNC0.625
2550-93403	D1-20	5 1/4"	1 5/8"	1 1/8" unf	

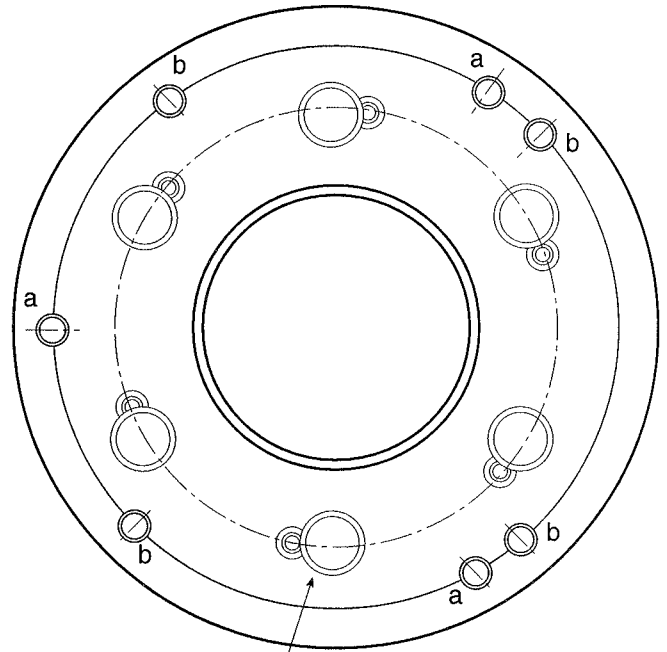
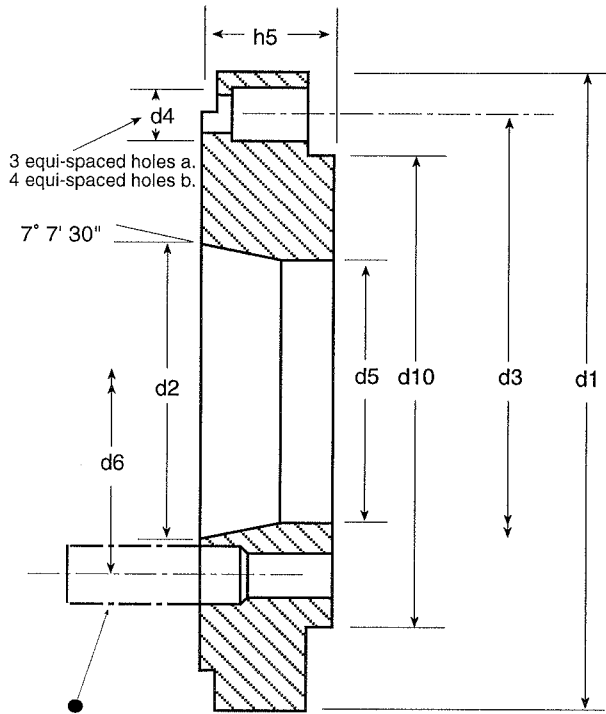
Special note - Metric camlock studs introduced by PBI in May 1998 :

Cat No. (Metric)	Type	Length	Diameter	Thread (metric fine)	Retaining screw (cat. no.)
2550-16403M	D1-3	2 1/8"	9/16"	M10 x 1	CAM6X12
2550-21403M	D1-4	2 3/16"	5/8"	M10 x 1	CAM6X12
2550-26403M	D1-5	2 9/16"	3/4"	M12 x 1	CAM6X12
2550-31403M	D1-6	3"	7/8"	M16 x 1.5	CAM8X16
2550-40403M	D1-8	3 3/8"	1"	M20 x 1.5	CAM8X16
2550-51403M	D1-11	4"	1 3/16"	M22 x 1.5	CAM8X16

DIN STUD



Cat No.	Type	Length	Diameter	Thread
2550-16404	DIN 3	46mm	19.5mm	M10
2550-21404	DIN 4	51mm	19.5mm	M10
2550-26404	DIN 5	55mm	19.5mm	M10
2550-31404	DIN 6	65mm	21.5mm	M12
2550-40404	DIN 8	80mm	27mm	M16
2550-51404	DIN 11	100mm	34mm	M20
2550-71404	DIN 15	113mm	34mm	M20 / M24



The diameter of camlock studs is a main identifying feature:

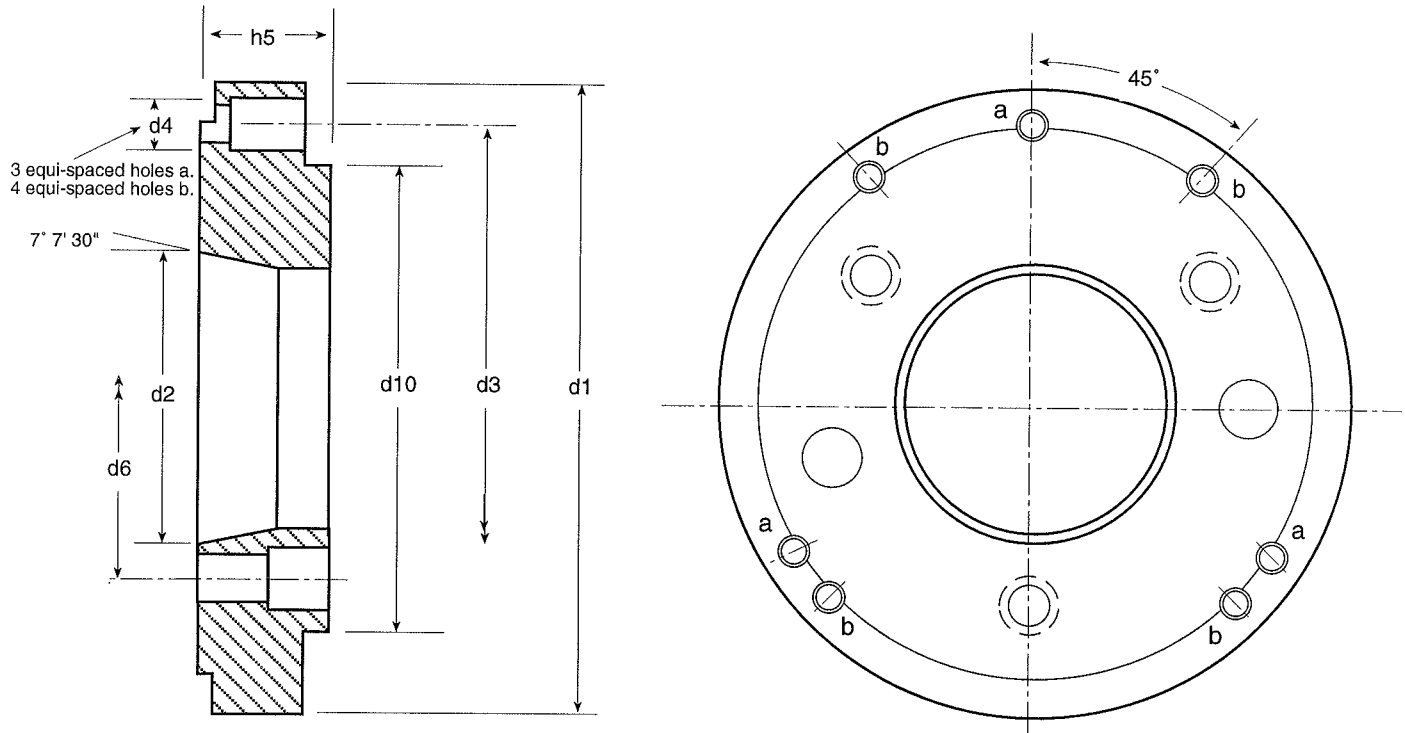
- D1-2 = 7/16"
- D1-3 = 9/16"
- D1-4 = 5/8"
- D1-5 = 3/4"
- D1-6 = 7/8"
- D1-8 = 1"
- D1-11 = 1 3/16"

D1-3 & D1-4 have 3 equi-spaced holes.

D1-5, 6, 8, 11 & 15 have 6 equi-spaced holes.

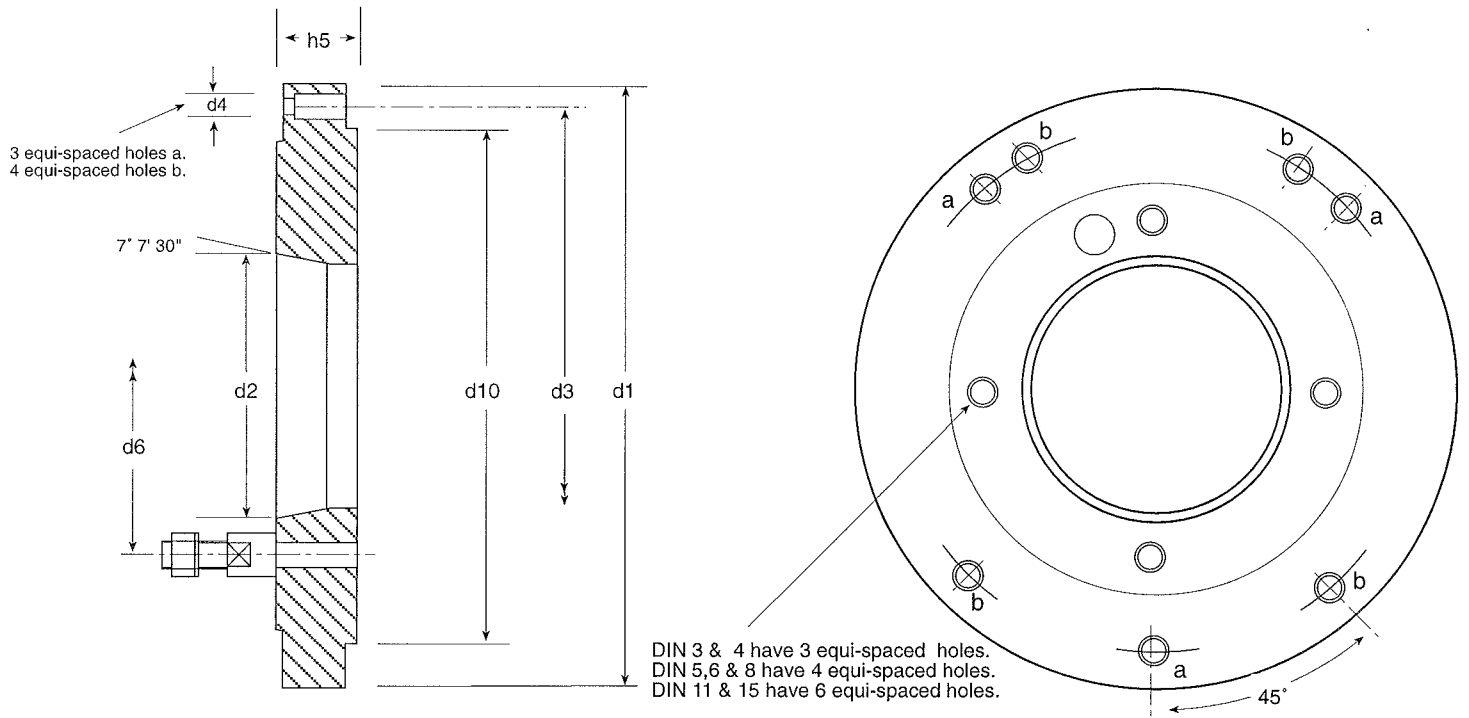
Drawings above are representative only.

NOMINAL SIZE	SPINDLE	CAT.NO.	d1	d2	d3	d4	d5	d6	d10	h5	
100mm	D1-3	8271-10222	101mm	54mm	89mm	M6	51mm	70.6mm	76.2mm	28.7mm	
125mm	D1-3	8271-13222	124mm	54mm	108mm	M8	51mm	70.6mm	95mm	25.7mm	
125mm	D1-4	8271-13223	125mm	63.5mm	108mm	M8	61mm	82.55mm	95mm	31.75mm	
160mm	D1-3	8271-17222	160mm	54mm	140mm	M10	51mm	70.6mm	125mm	25.4mm	
160mm	D1-4	8271-17223	160mm	63.5mm	140mm	M10	61mm	82.55mm	125mm	27.8mm	
160mm	D1-5	8271-17224	160mm	82.55mm	140mm	M10	79.4mm	104.6mm	125mm	29.7mm	
160mm	D1-6	8271-17225	This part does not have 4 holes b.								
160mm	D1-8	8271-17226	220mm	139.7mm		M10 (3 only)			125mm	52.5mm	
200mm	D1-3	8271-20222	198mm	54mm			50mm	70.6mm	160mm	28.7mm	
200mm	D1-4	8271-20223	198.4mm	63.5mm	176mm	M10	60.7mm	82.55mm	160mm	27.8mm	
200mm	D1-5	8271-20224	198.4mm	82.55mm	176mm	M10	79.4mm	104.6mm	160mm	29.7mm	
200mm	D1-6	8271-20225	198.4mm	106.36mm	176mm	M10	102.8mm	133.35mm	160mm	34.8mm	
200mm	D1-11	8271-20227	280mm	196.85mm		M10 (6 only)	130mm	235.15mm	160mm	49mm	
250mm	D1-4	8271-25223	250mm	63.5mm	224mm	M12	61mm	82.55mm	200mm	29.7mm	
250mm	D1-5	8271-25224	248.4mm	82.55mm	224mm	M12	79.4mm	104.6mm	200mm	29.7mm	
250mm	D1-6	8271-25225	248.4mm	106.36mm	224mm	M12	102.8mm	133.35mm	200mm	34.8mm	
250mm	D1-8	8271-25226	248.4mm	139.7mm	224mm	M12	135.7mm	171.4mm	200mm	37.8mm	
250mm	D1-11	8271-25227	280mm	196.85mm		M12	160mm	235.15mm	200mm	48mm	
315mm	D1-6	8271-32225	308.4mm	106.36mm	286mm	M12	102.8mm	133.35mm	260mm	37.8mm	
315mm	D1-8	8271-32226	308.4mm	139.7mm	286mm	M12	135.7mm	171.4mm	260mm	37.8mm	
315mm	D1-11	8271-32227	308mm	196.85mm	286mm	M12	192.5mm	235.15mm	260mm	49mm	
400mm	D1-6	8271-40225	398mm	106.36mm	362mm	M16	102mm	133.35mm	330mm	38mm	
400mm	D1-8	8271-40226	398mm	139.7mm	362mm	M16	136mm	171.4mm	330mm	37.5mm	
400mm	D1-11	8271-40227	398mm	196.85mm	362mm	M16	193mm	235.15mm	330mm	44.5mm	



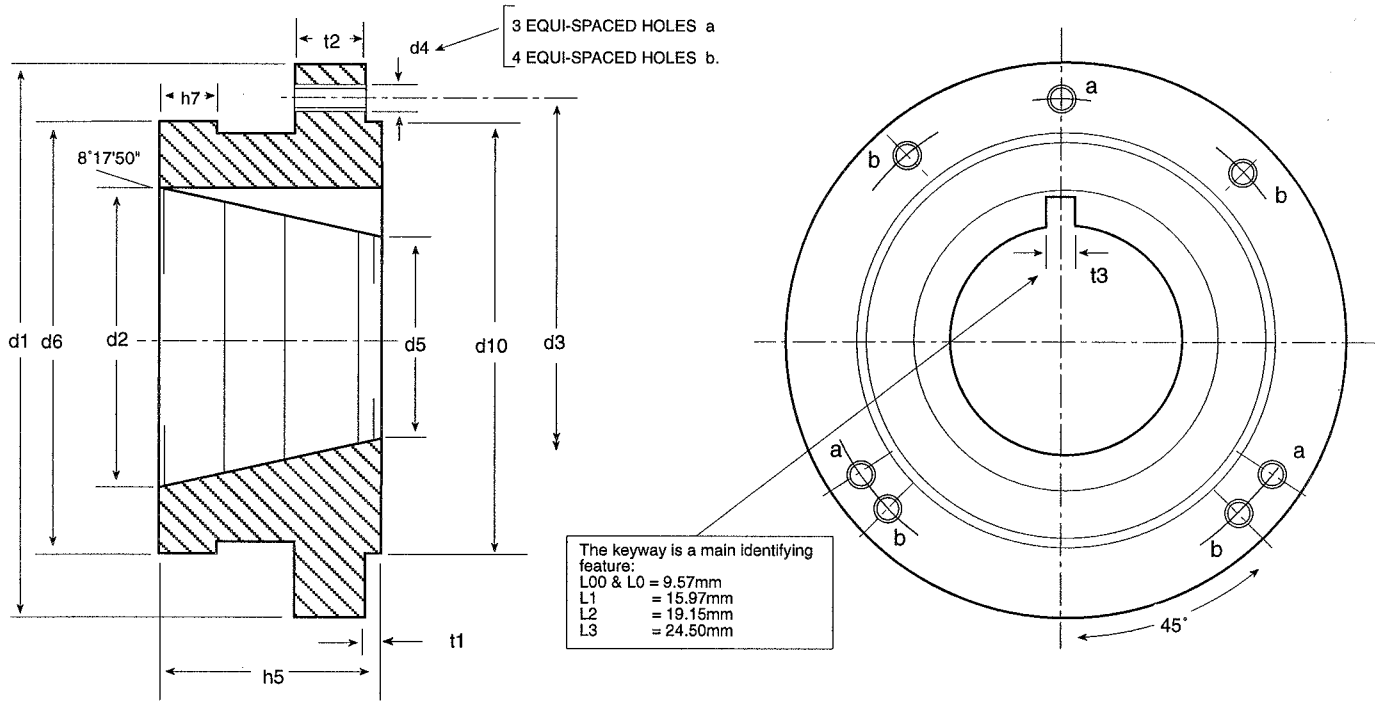
Drawings above are representative only.

NOMINAL SIZE	SPINDLE	CAT.NO.	d1	d2	d3	d4	d6	d10	h5
100mm	A2-3	8271-10211	101mm	54mm	89mm	M6	70.6mm	76.2mm	24.7mm
125mm	A2-3	8271-13211	124mm	54mm	108mm	M8	70.6mm	95mm	21.7mm
125mm	A2-4	8271-13212	124mm	63.5mm	108mm	M8	82.55mm	95mm	22.7mm
160mm	A2-3	8271-17211	160mm	54mm	140mm	M10	70.6mm	125mm	21.7mm
160mm	A2-4	8271-17212	160mm	63.5mm	140mm	M10	82.55mm	125mm	21.7mm
160mm	A2-5	8271-17213	160mm	82.55mm	140mm	M10	104.6mm	125mm	21.7mm
160mm	A2-6	8271-17214	170mm	106.36mm	140mm	M10		125mm	26mm
200mm	A2-4	8271-20212	198.4mm	63.5mm	176mm	M10	82.55mm	160mm	21.8mm
200mm	A2-5	8271-20213	198.4mm	82.55mm	176mm	M10	104.6mm	160mm	21.8mm
200mm	A2-6	8271-20214	198.4mm	106.36mm	176mm	M10	133.35mm	160mm	21.7mm
250mm	A2-4	8271-25212	250mm	63.5mm	224mm	M12	82.55mm	200mm	22.7mm
250mm	A2-5	8271-25213	248mm	82.55mm	224mm	M12	104.6mm	200mm	21.7mm
250mm	A2-6	8271-25214	248mm	106.36mm	224mm	M12	133.35mm	200mm	21.7mm
250mm	A2-8	8271-25215	248mm	139.7mm	224mm	M12	171.4mm	200mm	23.7mm
315mm	A2-6	8271-32214	308mm	106.36mm	286mm	M12	133.35mm	260mm	23.8mm
315mm	A2-8	8271-32215	308mm	139.7mm	286mm	M12	171.4mm	260mm	23.7mm
315mm	A2-11	8271-32216	308mm	196.85mm	286mm	M12	235.15mm	260mm	31.5mm
400mm	A2-6	8271-40214	398mm	106.36mm	362mm	M16	133.35mm	330mm	26.5mm
400mm	A2-8	8271-40215	398mm	139.7mm	362mm	M16	171.4mm	330mm	26.5mm
400mm	A2-11	8271-40216	398mm	196.85mm	362mm	M16	235mm	330mm	31.5mm
400mm	A2-15A *	8271-40217	398mm	285.76mm	362mm	M16	330.2mm	330mm	42.5mm
400mm	A2-15D *	8271-40267	398mm	285.76mm	362mm	M16	330.2mm	330mm	42.5mm
* A - For ASAS Spindles only; D - For DIN 55027 Spindles only.									



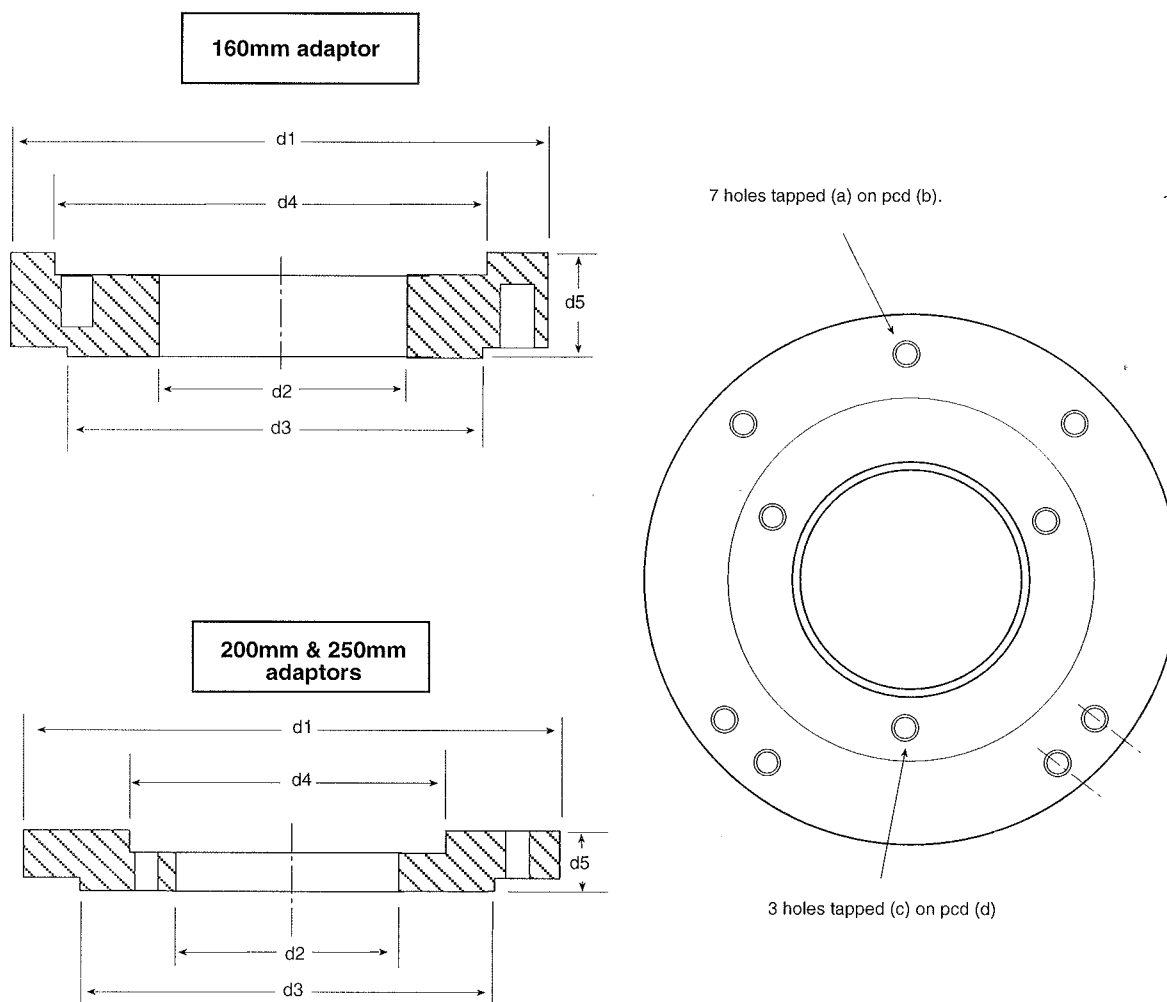
Drawings are representative only.

NOMINAL SIZE	SPINDLE	CAT.NO.	d1	d2	d3	d4	d6	d10	h5
100mm	DIN 3	8271-10241	102.4mm	54mm	89mm	M6	75mm	76.2mm	24.7mm
125mm	DIN 3	8271-13241	124mm	54mm	108mm	M8	75mm	95mm	21.7mm
125mm	DIN 4	8271-13242	124mm	63.5mm	108mm	M8	85mm	95mm	22.7mm
160mm	DIN 3	8271-17241	160mm	53.9mm	140mm	M10	75mm	125mm	21.7mm
160mm	DIN 4	8271-17242	160mm	63.5mm	140mm	M10	85mm	125mm	21.7mm
160mm	DIN 5	8271-17243	160mm	82.55mm	140mm	M10	104.8mm	125mm	21.7mm
160mm	DIN 6	8271-17244	170mm	106.37mm		M10	133.3mm	125mm	29mm
160mm	DIN 8	8271-17245	210mm	139.7mm	140mm	M10	171.4mm	125mm	48mm
200mm	DIN 4	8271-20242	200mm	63.5mm	176mm	M10	85mm	160mm	21.7mm
200mm	DIN 5	8271-20243	198.4mm	82.55mm	176mm	M10	104.8mm	160mm	21.7mm
200mm	DIN 6	8271-20244	198mm	106.3mm	176mm	M10	133.3mm	160mm	21.7mm
200mm	DIN 8	8271-20245	210mm	139.7mm		M10	171.4mm	160mm	28mm
250mm	DIN 4	8271-25242	250mm	63.5mm	224mm	M12	85mm	200mm	22.7mm
250mm	DIN 5	8271-25243	248mm	82.55mm	224mm	M12	104.8mm	200mm	22.7mm
250mm	DIN 6	8271-25244	248mm	106.36mm	224mm	M12	133.3mm	200mm	22.7mm
250mm	DIN 8	8271-25245	248mm	139.7mm	224mm	M12	171.4mm	200mm	24.7mm
315mm	DIN 6	8271-32244	308mm	106.37mm	286mm	M12	133.3mm	260mm	24.7mm
315mm	DIN 8	8271-32245	308mm	139.7mm	286mm	M12	171.4mm	260mm	24.7mm
315mm	DIN 11	8271-32246	308mm	196.85mm	286mm	M12	235mm	260mm	31.7mm
400mm	DIN 6	8271-40244	398mm	106.37mm		M16	133.3mm	330mm	26.5mm
400mm	DIN 8	8271-40245	398mm	139.7mm	362mm	M16	171.4mm	330mm	26.7mm
400mm	DIN 11	8271-40246	398mm	196.85mm	362mm	M16	235mm	330mm	31.7mm
400mm	DIN 15 *	8271-40247	398mm	285.76mm	362mm	M16	330.2mm	330mm	42.7mm
* DIN 15 is DIN 55027.									



NOMINAL SIZE	SPINDLE	CAT.NO.	d1	d2	d3	d4	d5	
125mm	L00	8271-13231	124mm	69.85mm	108mm	M8	55.9mm	
160mm	L00	8271-17231	159mm	69.85mm	140mm	M10	55.9mm	
160mm	L0	8271-17232	159mm	82.55mm	140mm	M10	65.9mm	
200mm	L00	8271-20231	198mm	69.80mm	176mm	M10	55.9mm	
200mm	L0	8271-20232	198mm	82.55mm	176mm	M10	65.9mm	
200mm	L1	8271-20233	198mm	104.77mm	176mm	M10	83.5mm	
250mm	L00	8271-25231	248mm	69.80mm	224mm	M12	55.9mm	
250mm	L0	8271-25232	248mm	82.55mm	224mm	M12	65.9mm	
250mm	L1	8271-25233	248mm	104.77mm	224mm	M12	83.5mm	
250mm	L2	8271-25234	248mm	133.35mm	224mm	M12	109mm	
315mm	L1	8271-32233	308mm	104.77mm	286mm	M12	83.5mm	
315mm	L2	8271-32234	308mm	133.35mm	286mm	M12	109mm	
400mm	L2	8271-40234	398mm	133.35mm	362mm	M12	109mm	
400mm	L3	8271-40235	398mm	165.1mm	362mm	M16	136.5mm	
NOMINAL SIZE	SPINDLE	d6	d10	h5	h7	t1	t2	t3
125mm	L00	3.745"-6UNS3	95mm	51mm	14mm	3.5mm	18mm	9.57mm
160mm	L00	3.745"-6UNS3	125mm	51mm	14mm	3.5mm	18mm	9.57mm
160mm	L0	4.495"-6UNS3	125mm	61mm	14mm	3.5mm	20mm	9.57mm
200mm	L00	3.745"-6UNS3	160mm	51mm	14mm	3.5mm	21.5mm	9.57mm
200mm	L0	4.495"-6UNS3	160mm	61mm	14mm	3.5mm	18mm	9.57mm
200mm	L1	5.995"-6UNS3	160mm	77mm	16mm	3.5mm	18mm	15.97mm
250mm	L00	3.745"-6UNS3	200mm	51mm	14mm	4.5mm	55.9mm	9.57mm
250mm	L0	4.495"-6UNS3	200mm	61mm	14mm	4.5mm	65.9mm	9.57mm
250mm	L1	5.995"-6UNS3	200mm	77mm	16mm	4.5mm	22mm	15.97mm
250mm	L2	7.745"-5UNS3	200mm	90mm	22mm	4.5mm	22mm	19.15mm
315mm	L1	5.995"-6UNS3	260mm	77mm	16mm	4.5mm	23mm	15.97mm
315mm	L2	7.745"-5UNS3	260mm	90mm	22mm	4.5mm	23mm	19.15mm
400mm	L2	7.745"-5UNS3	330mm	90mm	22mm	4.5mm	31mm	19.15mm
400mm	L3	10.37"-4UNS3	330mm	102mm	24mm	4.5mm	31mm	24.50mm

BRITISH STANDARD (BS) ADAPTOR PLATES



Drawings are representative only.

NOMINAL SIZE	SPINDLE	CAT.NO.	d1	d2	d3	d4	d5	a	b	c	d
160mm	BS 5.25"	8271-17202	159mm	80mm	125mm	5.25"	35.0mm	M10	140mm	3/8" unc	119.1mm
200mm	BS 5.25"	8271-20202	198mm	54.8mm	160mm	5.25"	21.5mm	M10	176mm	3/8" unc	119.1mm
250mm	BS 5.25"	8271-25202	248mm	100mm	200mm	5.25"	23.7mm	M12	224mm	3/8" unc	119.1mm
250mm	BS 7.5"	8271-25203	248mm	75.9mm	200mm	7.5"	26.5mm	M12	224mm	1/2" unc *	158.7mm
315mm	BS 7.5"	8271-32203	308mm	103mm	260mm	7.5"	27.5mm	M12	286mm	1/2" unc *	158.7mm
315mm	BS 10"	8271-32204									
400mm	BS 10"	8271-40204									

* Special note (Feb. 2001).

The standard tapping for thread 'c' was changed for the BS 7.5" mount. In earlier chucks (and possibly adaptors) the thread was originally 1/2" whitworth; records do not show when the unc thread became effective.

CHUCK & ADAPTOR COMPATIBILITY

42b

DIRECT MOUNTING CHUCK

A chuck in which the lathe spindle nose mounting is directly machined into the back body of the chuck. These chucks cannot be used for any other than their intended mount without major modification.

Up to the late 1980's / 1990 most chucks were manufactured by this method and adaptors can be used with some of them if the original chuck was of a recess mount design.

In general, most of the adaptor recess chucks prior to the 9270- and 9210- ranges (with the exception of Tudor and the original Pratt and Burnerd ranges) will accept the current 8271- series of adaptors. Full details of compatible chucks are given on the following pages 43 - 45.

INDIRECT MOUNTING CHUCK

One common chuck is manufactured for each size, with a separate adaptor being located and screwed into the rear of the chuck.

These ranges (9270- and 9210- series) were introduced in the late 1980's with the complementary range of 8271- adaptors and therefore one chuck may be used with several adaptors depending on the lathe spindle nose.

MANUAL CHUCK ADAPTORS

The 8271- range of adaptors was introduced in 1989 to complement the Super Precision chuck range (9270-) and Independent range (9500-).

While the SP range of chucks has changed in design and Standard Accuracy chucks have been introduced, the 8271- adaptors will fit all these ranges and also some chucks of earlier design.

It may also be possible to utilize these adaptors for other purposes and to fit other chucks by modification as necessary.

Nov 2001

ADAPTORS (8271- range)

Compatibility with old & new chuck ranges.

Chuck size & type	Basic chuck cat. no.	Recess diameter	Mounting holes pcd	✓ X	Compatible Non-compatible
100mm SP 3 jaw, recess	1270-01005	76.2mm	89mm	✓	
100mm SP mounted	127x-xxxxx			X	(Mount integral with back body).
100mm SP 4 jaw, recess	1280-01005	76.2mm	89mm	✓	* With modification
4" 58 3 jaw Iron, recess	1580-01005	76.2mm	89mm	✓	
4" 3 jaw Griptru 3 jaw	1630-01005	76.2mm	89mm	✓	* With modification
4" 78 3 jaw Steel, recess	1780-01005	76.2mm	89mm	✓	
100mm SP 3 jaw, recess	9210-01005	76.2mm	89mm	✓	
100mm SP 3 jaw, recess	9270-01005	76.2mm	89mm	✓	
100mm SP, mounted	927x-xxxxx			✓	
100mm Standard Accy.	9580-01005	76.2mm	89mm	✓	
125mm 3 jaw Iron, recess	1210-01305	95mm	108mm	✓	
125mm 3 jaw mounted	121x-xxxxx			X	(Mount integral with back body).
125mm 4 jaw Iron, recess	1230-01305	95mm	108mm	✓	* With modification
125mm Griptru 3 jaw	1250-01305	95mm	108mm	✓	* With modification
125mm Griptru 6 jaw	1260-01305	95mm	108mm	✓	* With modification
125mm SP 3 jaw, recess	1270-01305	95mm	108mm	✓	
125mm SP, mounted	127x-xxxxx			X	(Mount integral with back body).
125mm SP 4 jaw, recess	1280-01705	95mm	108mm	✓	* With modification
125mm SP 3 jaw, recess	9210-01305	95mm	108mm	✓	
125mm Griptru 3 jaw	9250-01305	95mm	108mm	✓	* With modification
125mm Griptru 6 jaw	9260-01305	95mm	108mm	✓	* With modification
125mm SP 3 jaw, recess	9270-01305	95mm	108mm	✓	
125mm SP mounted	927x-xxxxx	95mm	108mm	✓	
125mm Standard Accy.	9580-01305	95mm	108mm	✓	
160mm 3 jaw Iron, recess	1210-01705	125mm	140mm	✓	
160mm 3 jaw, mounted	121x-xxxxx			X	(Mount integral with back body).
160mm 4 jaw Iron, recess	1230-01705	125mm	140mm	✓	* With modification
160mm Griptru 3 jaw	1250-01705	125mm	140mm	✓	* With modification
160mm Griptru 6 jaw	1260-01705	125mm	140mm	✓	* With modification
160mm SP 3 jaw, recess	1270-01705	125mm	140mm	✓	
160mm SP, mounted	127x-xxxxx			X	(Mount integral with back body).
160mm SP 4 jaw, recess	1280-01705	125mm	140mm	✓	* With modification
160mm Tudor 3 jaw	1380-21721	BS 5.25"	119.1mm	X	
160mm Ind. 4 jaw	1500-01701	125mm	140mm	✓	
160mm Ind. 4 jaw	150x-xxxxx			X	(Mount integral with back body).
160mm 3 jaw SP, recess	9210-01705	125mm	140mm	✓	
160mm 3 jaw Griptru	9250-01705	125mm	140mm	✓	* With modification
160mm 6 jaw Griptru	9260-01705	125mm	140mm	✓	* With modification
160mm SP 3 jaw, recess	9270-01705	125mm	140mm	✓	
160mm SP, mounted	927x-xxxxx	125mm	140mm	✓	
160mm Tudor 3 jaw	9380-01721	125mm	140mm	✓	
160mm Ind. 4 jaw	9500-01701	125mm	140mm	✓	
160mm Standard Accy.	9580-01705	125mm	140mm	✓	

ADAPTORS (8271- range)

Compatibility with old & new chuck ranges.

Chuck size & type	Basic chuck cat. no.	Recess diameter	Mounting holes pcd	✓ X	Compatible Non-compatible
200mm 3 jaw Iron, recess	1210-02005	160mm	176mm	✓	
200mm 3 jaw, mounted	121x-xxxxx			X	(Mount integral with back body).
200mm 4 jaw Iron, recess	1230-02005	160mm	176mm	✓	* With modification
200mm Griptru 3 jaw	1250-02005	160mm	176mm	✓	* With modification
200mm Griptru 6 jaw	1260-02005	160mm	176mm	✓	* With modification
200mm SP 3 jaw, recess	1270-02005	160mm	176mm	✓	
200mm SP, mounted	127x-xxxxx			X	(Mount integral with back body).
200mm SP 4 jaw, recess	1280-02005	160mm	176mm	✓	* With modification
200mm Tudor 3 jaw	1380-21921	BS 5.25"	119.1mm	X	
200mm Ind. 4 jaw, recess	1500-02001	125mm	140mm	✓	(Note - uses 160mm adaptors)
200mm Ind. 4 jaw	150x-xxxxx			X	(Mount integral with back body).
200mm SP 3 jaw, recess	9210-02005	160mm	176mm	✓	
200mm 3 jaw Griptru	9250-02005	160mm	176mm	✓	* With modification
200mm 6 jaw Griptru	9260-02005	160mm	176mm	✓	* With modification
200mm SP 3 jaw, recess	9270-02005	160mm	176mm	✓	
200mm SP, 3 mounted	927x-xxxxx	160mm	176mm	✓	
200mm Tudor 3 jaw	9380-02021	160mm	176mm	✓	
200mm Ind. 4 jaw	9500-02001	125mm	140mm	✓	(Note - uses 160mm adaptors)
200mm Standard Accy.	9580-02005	160mm	176mm	✓	
250mm 3 jaw Iron, recess	1210-02505	200mm	224mm	✓	
250mm 3 jaw, mounted	121x-xxxxx			X	(Mount integral with back body).
250mm 4 jaw Iron, recess	1230-02505	200mm	224mm	✓	* With modification
250mm Griptru 3 jaw	1250-02505	200mm	224mm	✓	* With modification
250mm Griptru 6 jaw	1260-02505	200mm	224mm	✓	* With modification
250mm SP 3 jaw, recess	1270-02505	200mm	224mm	✓	
250mm SP, mounted	127x-xxxxx			X	(Mount integral with back body).
250mm SP 4 jaw, recess	1280-02505	200mm	224mm	✓	* With modification
250mm Tudor 3 jaw	1380-32421	BS 7.5"	158.7mm	X	
250mm Ind. 4 jaw, recess	1500-02501	200mm	224mm	✓	
250mm Ind. 4 jaw	150x-xxxxx			X	(Mount integral with back body).
250mm SP 3 jaw, recess	9210-02505	200mm	224mm	✓	
250mm 3 jaw Griptru	9250-02505	200mm	224mm	✓	* With modification
250mm 6 jaw Griptru	9260-02505	200mm	224mm	✓	* With modification
250mm SP 3 jaw, recess	9270-02505	200mm	224mm	✓	
250mm SP, mounted	927x-xxxxx	200mm	224mm	✓	
250mm Tudor 3 jaw	9380-02521	200mm	224mm	✓	
250mm Ind. 4 jaw	9500-02501	200mm	224mm	✓	
250mm Standard Accy.	9580-02505	200mm	224mm	✓	
Tudor scroll chucks (old type):					
6.5" 3 jaw Tudor	1980-21721	BS 5.25"	119.1mm	X	
7.5" 3 jaw Tudor	1980-21921	BS 5.25"	119.1mm	X	
9.5" 3 jaw Tudor	1980-32421	BS 7.5"	158.7mm	X	
12" 3 jaw Tudor	1980-33121	BS 7.5"	158.7mm	X	
15" 3 jaw Tudor	1980-43821	BS 10"	203.2mm	X	

ADAPTORS (8271- range)

Compatibility with old & new chuck ranges.

Chuck size & type	Basic chuck cat. no.	Recess diameter	Mounting holes pcd	✓ X	Compatible Non-compatible
315mm 3 jaw Iron, recess	1210-03205	260mm	286mm	✓	
315mm 3 jaw, mounted	121x-xxxxx			X	(Mount integral with back body).
315mm 4 jaw Iron, recess	1230-03205	260mm	286mm	✓	* With modification
315mm 3 jaw Griptru	1250-03205	260mm	286mm	✓	* With modification
315mm 6 jaw Griptru	1260-03205	260mm	286mm	✓	* With modification
315mm SP 3 jaw, recess	1270-03205	260mm	286mm	✓	
315mm SP, mounted	127x-xxxxx			X	(Mount integral with back body).
315mm SP 4 jaw, recess	1280-03205	260mm	286mm	✓	* With modification
315mm 3 jaw Tudor	1380-33121	BS 7.5"	158.7mm	X	
315mm Ind. 4 jaw, recess	1500-03201	200mm	224mm	✓	(Note - uses 250mm adaptors)
315mm Ind. 4 jaw	150x-xxxxx			X	(Mount integral with back body).
315mm SP 3 jaw, recess	9210-03205	260mm	286mm	✓	
315mm 3 jaw Griptru	9250-03205	260mm	286mm	✓	* With modification
315mm 6 jaw Griptru	9260-03205	260mm	286mm	✓	* With modification
315mm SP 3 jaw, recess	9270-03205	260mm	286mm	✓	
315mm SP, mounted	927x-xxxxx	260mm	286mm	✓	
315mm Tudor 3 jaw	9380-03221	260mm	286mm	✓	
315mm Ind. 4 jaw	9500-03201	200mm	224mm	✓	(Note - uses 250mm adaptors)
315mm Std. Accuracy	9580-03205	260mm	286mm	✓	
350mm Ind. 4 jaw	9500-03501	260mm	286mm	✓	(Note - uses 315mm adaptors)
400mm SP 3 jaw, recess	9210-04005	330mm	362mm	✓	
400mm SP, mounted	927x-xxxxx	330mm	362mm	✓	
400mm 3 jaw Tudor	9380-04021	330mm	362mm	✓	
400mm Ind. 4 jaw	9500-04001	260mm	286mm	✓	(Note - uses 315mm adaptors)
400mm Ind. 4 jaw	9500-04101	260mm	286mm	✓	(Note - uses 315mm adaptors)
400mm Std. Accuracy	9580-04005	330mm	362mm	✓	

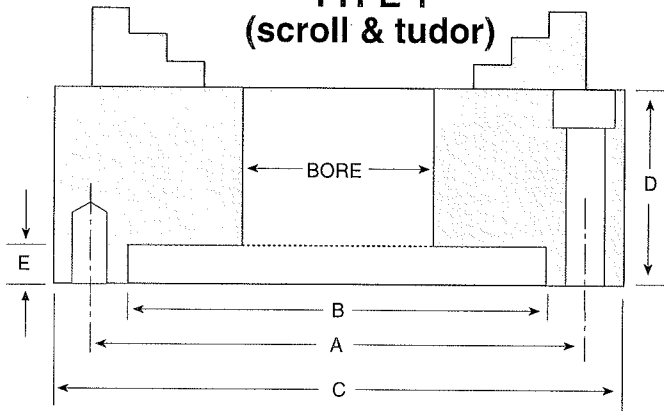
Pratt & Burnerd old style recess mount scroll chucks:

4" 58 (Burnerd) 3 jaw	1580-01005	3"	3.5"	✓	(Model 30)
4" 78 (Burnerd) 3 jaw	1780-01005	3"	3.5"	✓	
5" 58 (Burnerd) 3 jaw	1580-01405	4"	4.5"	X	(Model 30A)
5" 78 (Burnerd) 3 jaw	1780-01405	4"	4.5"	X	
6" 58 (Burnerd) 3 jaw	1580-01605	5"	5.5"	X	(Model 31)
6" 78 (Burnerd) 3 jaw	1780-01605	5"	5.5"	X	
7.5" (Burnerd) 3 jaw	No cat. no.	6"	6.5"	X	(Model 52)
7.5" 78 (Pratt) 3 jaw Steel	1780-01905	4.75"	6.125"	X	
8" (Burnerd) 3 jaw	No cat. no.	6.5"	7.375"	X	(Model 51)
9" (Burnerd) 3 jaw	1580-02305	7.5"	8.25"	X	(Model 53)
9" 78 (Pratt) 3 jaw Steel	1780-02305	5.625"	6.75"	X	
10.5" (Burnerd) 3 jaw	No cat. no.	8.875"	9.75"	X	(Model 54)
10.5" 78 (Pratt) 3 jaw St.	1780-02705	5.625"	6.75"	X	
12" (Burnerd) 3 jaw	1580-03105	10.25"	11.125"	X	(Model 55)
12" 78 (Pratt) 3 jaw Steel	1780-03205	7"	9.25"	X	
15" 78 (Pratt) 3 jaw Steel	1780-03805	7"	10"	X	

MANUAL CHUCKS (generally from 1930's)

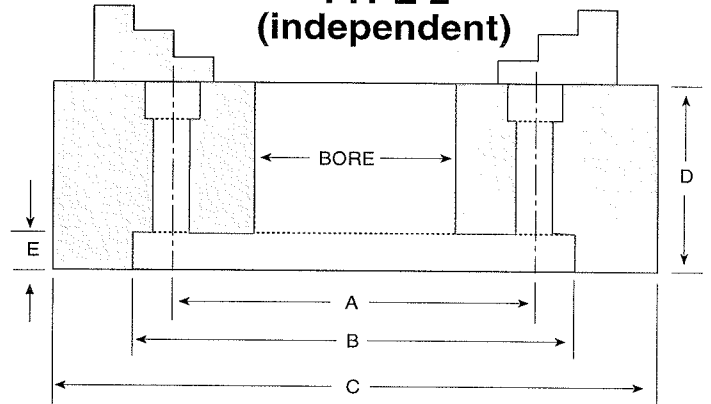
See following pages for dimensions of
Recess
Bore
Mounting holes
Overall chuck sizes.

TYPE 1
(scroll & tudor)

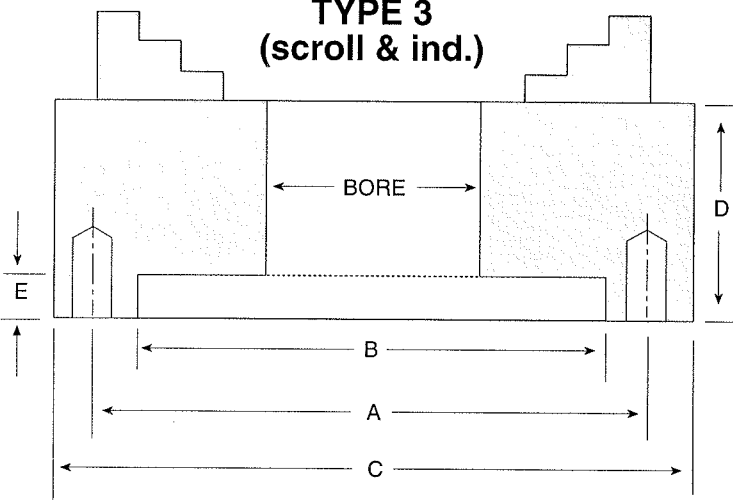


(In some instances the rear bolt holes & through bolt holes may be on a different pcd)

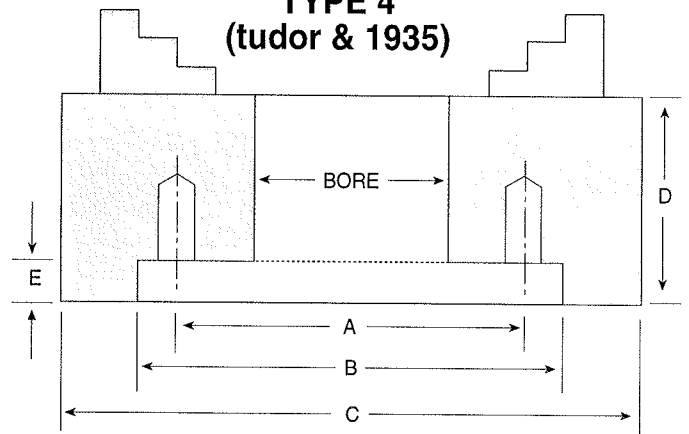
TYPE 2
(independent)



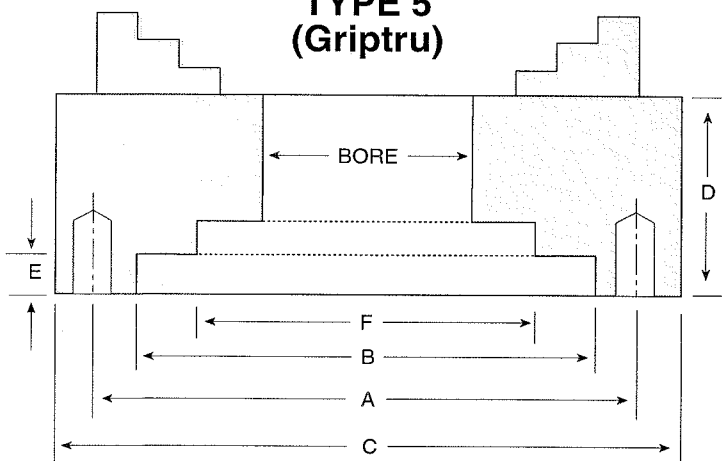
TYPE 3
(scroll & ind.)



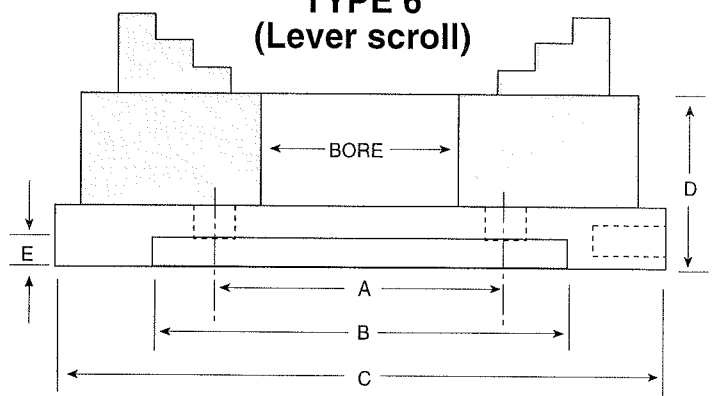
TYPE 4
(tudor & 1935)



TYPE 5
(Griptru)



TYPE 6
(Lever scroll)





SCROLL CHUCKS (1) - MAJOR DIMENSIONS

CAT.NO.	TYPE	BORE	A (hole pcd)	B (recess)	C (diameter)	D (height)	E (recess depth)
BURNERD PATTERN old type 3 jaw							
Model 29	3	3/4"	2 13/16"	2 1/2"	3 1/4"	1 21/32"	5/64"
Model 30	3	1"	3 1/2"	3"	4"	1 29/32"	3/32"
Model 30A	3	1 1/2"	4 1/2"	4"	5"	2 5/32"	1/8"
Model 31	3	1 7/8"	5 1/2"	5"	6"	2 7/16"	1/8"
Model 52	3	2"	6 1/8"	4 3/4"	7 1/2"	2 23/32"	5/32"
Model 51	3	2"	7 3/8"	6 1/2"	8"	2 7/8"	1/8"
Model 53	3	2 1/2"	6 3/4"	5 5/8"	9"	2 21/32"	3/16"
Model 54	3	3"	9 3/4"	8 7/8"	10 1/2"	3 5/16"	3/16"
Model 55	3	3 1/8"	11 1/8"	10 1/4"	12"	3 1/2"	1/4"
IRON SCROLL 3 jaw							
1210-01305	1	35mm	108mm	95mm	125mm	58.7mm	3.96mm
1210-01705	1	46mm	140mm	125mm	160mm	64.3mm	3.96mm
1210-02005	1	55mm	176mm	160mm	200mm	73mm	3.96mm
1210-02505	1	76mm	224mm	200mm	250mm	84.1mm	4.98mm
1210-03205	1	103mm	286mm	260mm	310mm	90.5mm	4.98mm
1230- (4 jaw) dimensions as 1210- above except 4 mounting holes.							
1580-00805	1	3/4"	2 13/16"	2 1/2"	3 1/4"	1 21/32"	5/64"
1580-01005	1	1"	3 1/2"	3"	4"	1 29/32"	3/32"
1580-01405	3	1 1/2"	4 1/2"	4"	5"	2 5/32"	1/8"
1580-02305	3	2 1/2"	6 3/4"	5 5/8"	9"	2 21/32"	3/16"
1580-03805	1	82.5mm	254mm	177.8mm	15"	88.1mm	12.7mm
1580-04605	1	108mm	330.2mm	241.3mm	18"	94.4mm	15.9mm
1580-05305	1	114.3mm	355.6mm	241.3mm	21"	94.4mm	15.9mm
1580-06105	1	114.3mm	355.6mm	241.3mm	24"	94.4mm	15.9mm
1590- (4 jaw) dimensions as 1580- above except 4 mounting holes.							
STEEL SCROLL 3 jaw							
1780-01005	1	1"	3.5"	3"	4"	1 29/32"	3/32"
1780-01405	1	1.5"	4.5"	4"	5"	2 5/32"	1/8"
1780-01605	1	1 7/8"	5.5"	5"	6"	2 7/16"	1/8"
1780-01905	3	2"	6 1/8"	4 3/4"	7.5"	2 47/64"	5/32"
1780-02305	3	2.5"	6 3/4"	5 5/8"	9"	2 31/32"	3/16"
1780-02705	3	3"	6 3/4"	5 5/8"	10.5"	3 1/8"	3/16"
1780-03105	3	3"	9 1/4"	7"	12"	3 15/32"	1/2"
1780-03805	3	3.25"	10"	7"	15"	3.47"	0.50"
1780-04605	3	4"	13"	9.5"	18"	3.72"	0.625"
1780-05305	3	4.5"	14"	9.5"	21"	3.72"	0.625"
1780-06105	3	4.5"	14"	9.5"	24"	3.72"	0.625"
1790- (4 jaw) dimensions as 1780- above except 4 mounting holes.							
9780-04705	1	100mm	190mm (6 holes)	330mm	460mm	94.4mm	6mm
9780-05305	1	100mm	190mm (6 holes)	330mm	535mm	94.4mm	6mm
9780-06105	1	100mm	190mm (6 holes)	330mm	610mm	94.4mm	6mm



SCROLL CHUCKS (2) - MAJOR DIMENSIONS

CAT.NO.	TYPE	BORE	A (hole pcd)	B (recess)	C (diameter)	D (height)	E (recess depth)
SUPER PRECISION (For identification purposes old SP chucks (1270-) have a 'v' groove machined in the front face of the chuck)							
1270-01305	1	35mm	108mm	95mm	125mm	58.7mm	3.96mm
1270-01705	1	46mm	140mm	125mm	160mm	64.3mm	3.96mm
1270-02005	1	55mm	176mm	160mm	200mm	73mm	3.96mm
1270-02505	1	76mm	224mm	200mm	250mm	84.1mm	4.98mm
1270-03205	1	103mm	286mm	260mm	310mm	90.5mm	4.98mm
1280- (4 jaw) dimensions as 1270- above except 4 mounting holes.							
9210-00805	1	19mm	71.3mm	63.5mm	82.5mm	45mm	3mm
9210-01005	1	25.4mm	89mm	76.2mm	102.4mm	51.3mm	3mm
9210-01305	1	35mm	108mm	95mm	125mm	57mm	4mm
9210-01705	1	45.9mm	140mm	125mm	160mm	63.9mm	4mm
9210-02005	1	54.8mm	176mm	160mm	200mm	74.2mm	4mm
9210-02505	1	75.9mm	224mm	200mm	250mm	82.2mm	5mm
9210-03205	1	102.8mm	286mm	260mm	310mm	91mm	5mm
9210-04005	1	136mm	362mm	330mm	400mm	100.7mm	5mm
9270-00805	1	19.1mm	71.4mm	63.5mm	82.5mm	42mm	2mm
9270-01005	1	25.4mm	88.9mm	76.2mm	106.3mm	48.4mm	2.3mm
9270-01305	1	35mm	108mm	95mm	125mm	58.7mm	3.96mm
9270-01705	1	46mm	140mm	125mm	160mm	64.3mm	3.96mm
9270-02005	1	55mm	176mm	160mm	200mm	73mm	3.96mm
9270-02505	1	76mm	224mm	200mm	250mm	84.1mm	4.98mm
9270-03205	1	103mm	286mm	260mm	310mm	90.5mm	4.98mm
9270-04005	1	136mm	362mm	330mm	400mm	100.7mm	5mm
9270-03805	1	113.5mm			381mm	105.2mm	
9270-04605	1	138.9mm			457.2mm	113.1mm	
9270-05305	1	138.9mm			533.4mm	113.1mm	
9270-06305	1	138.9mm			635mm	121.7mm	
9280- (4 jaw) dimensions as 9270- above except 4 mounting holes.							
STANDARD ACCURACY (For identification purposes these chucks have a 'v' groove machined in the chuck outside diameter).							
9580-00805	1	19mm	71.3mm	63.5mm	82.5mm	45mm	3mm
9580-01005	1	25.4mm	89mm	76.2mm	102.4mm	51.3mm	3mm
9580-01305	1	35mm	108mm	95mm	125mm	57mm	4mm
9580-01705	1	45.9mm	140mm	125mm	160mm	63.9mm	4mm
9580-02005	1	54.8mm	176mm	160mm	200mm	74.2mm	4mm
9580-02505	1	75.9mm	224mm	200mm	250mm	82.2mm	5mm
9580-03205	1	102.8mm	286mm	260mm	310mm	91mm	5mm
9580-04005	1	136mm	362mm	330mm	400mm	100.7mm	5mm
9580-05105	1	190mm	458mm	420mm	500mm	120mm	8mm



TUDOR / LIGHT TYPE IND. - MAJOR DIMENSIONS

CAT.NO.	TYPE	BORE	A (hole pcd)	B (recess)	C (diameter)	D (height)	E (recess depth)
TUDOR							
1380-21721	4	42.1mm	119.1mm	BS 5.25"	6.5"	2.78"	5.5mm
1380-21921	4	52mm	119.1mm	BS 5.25"	7.5"	3.03"	5.5mm
1380-32421	4	69mm	158.7mm	BS 7.5"	9.5"	3.56"	7.8mm
1380-33121	4	94.4mm	158.7mm	BS 7.5"	12"	4"	12.7mm
1380-43821	4	113.5mm	203.2mm	BS10"	15"	4.44"	15.7mm
1380-44621	4	138.9mm	203.2mm	BS 10"	18"	5.25"	22.1mm
1380-45321	4	168.9mm	307.8mm	BS 14.25"	18"	5.25"	22.1mm
1380-55321	4	138.9mm	203.2mm	BS 10"	21"	5.25"	22.1mm
1380-56321	4	138.9mm	285.7mm	BS 13"	21"	5.25"	22.1mm
1380-64621	4	138.9mm	307.8mm	BS 14.25"	21"	5.25"	22.1mm
1380-65321	4	138.9mm	285.7mm	BS 13"	25"	5.62"	22.1mm
1380-66321	4	234.1mm	307.8mm	BS 14.25"	25"	5.62"	31.7mm
1380-76321	4	234.1mm	349.2mm	BS 16"	25"	5.62"	31.7mm
1380-77321	4	234.1mm	349.2mm	BS 16"	29"	6.37"	31.7mm
1390- dimensionally as 1380-							
1980- dimensionally as 1380-							
1990- dimensionally as 1380-							
9380-01721	1	45.9mm	140mm	125mm	160mm	72.5mm	4mm
9380-02021	1	54.8mm	176mm	160mm	200mm	81.5mm	4mm
9380-02521	1	75.9mm	224mm	200mm	250mm	95mm	5mm
9380-03221	1	102.8mm	286mm	260mm	310mm	106mm	5mm
9380-04021	1	136mm	362mm	330mm	400mm	111mm	5mm
9380-04621	1 ?	139mm	420mm	254mm	460mm	133mm	
9380-07321	1	234mm			735mm	161mm	
9390- dimensionally as 9380-							
LIGHT TYPE INDEPENDENT							
1520-10801	2	3/4"	2 9/64"	2 3/4"	3 1/4"	1 1/8"	1/16"
1520-11001	2	1"	2 9/64"	2 3/4"	4"	1 1/8"	1/16"
1520-11201	2	1"	2 9/64"	2 3/4"	4 1/2"	1 1/8"	1/16"
1540-11401	2	1"	2 1/8"	2 3/4"	5"	1 11/16"	3/32"
1540-11601	2	1 39/64"	2 3/4"	3 1/4"	6"	1 11/16"	3/32"
1540-12101	2	1 5/8"	3 1/4"	3 3/4"	8"	1 15/16"	1/8"
1540-12601	2	1 7/8"	4 3/8"	5"	10"	2 11/16"	3/16"



INDEPENDENT CHUCKS - MAJOR DIMENSIONS

CAT.NO.	TYPE	BORE	A (hole pcd)	B (recess)	C (diameter)	D (height)	E (recess depth)
INDEPENDENT							
1350-21601	4	1 3/4"	4 11/16"	BS 5.25"	6"	2 1/2"	3/16"
1350-22101	4	2 1/32"	4 11/16"	BS 5.25"	8"	3 1/8"	9/32"
1350-32301	4	2 9/16"	6 1/4"	BS 7.5"	9"	3 3/8"	11/32"
1350-32601	4	2 23/32"	6 1/4"	BS 7.5"	10"	3 3/8"	11/32"
1350-33101	4	3 7/32"	6 1/4"	BS 7.5"	12"	3 7/8"	1/2"
1350-43801	4	5 1/4"	8"	BS 10"	15"	4"	5/8"
1350-44001	4	4 15/32"	8"	BS 10"	16"	4 1/4"	5/8"
1350-44601	4	5 15/32"	8"	BS 10"	18"	4 1/2"	7/8"
1350-64601	4	5 15/32"	8"	BS 14.25"	18"	4 1/2"	7/8"
1350-55101	4	5 15/32"	11 1/4"	BS 13"	20"	5 1/4"	5/8"
1350-65601	4	6 1/2"	12 1/8"	BS 14.25"	22"	5 1/2"	1"
1350-56101	4	5 15/32"	11 1/4"	BS 13"	24"	5 1/2"	7/8"
1350-66301	4	7 5/16"	12 1/8"	BS 14.25"	25"	5 1/2"	1"
1350-76601	4	9 7/32"	13 3/4"	BS 16"	26"	6"	1 7/16"
1350-78101	4	9 7/32"	12 1/8"	BS 14.25"	32"	7 1/4"	1 1/4"
1350-88101	4	9 7/32"	13 3/4"	BS 16"	32"	7 1/4"	1 1/4"
1500-01701	3	45mm	140mm	125mm	160mm	54mm	4mm
1500-02001	3	50mm	140mm	125mm	200mm	72mm	4mm
1500-02501	3	60mm	224mm	200mm	250mm	72mm	5mm
1500-03201	3	75mm	224mm	200mm	315mm	80mm	5mm
1550-11601	2	1 9/16"	4 1/8"	5"	6"	2 1/4"	3/16"
1550-12101	2	1 3/4"	3 7/8"	4 3/4"	8"	3 1/8"	1/4"
1550-12601	2	2"	5 1/8"	6"	10"	3 1/4"	5/16"
1550-13101	2	2 3/4"	5 7/8"	7"	12"	3 1/2"	1/2"
1550-13501	2	3"	5 7/8"	7"	14"	3 1/2"	1/2"
1550-14001	2	3"	8 3/16"	9 1/2"	16"	3 11/16"	5/8"
1550-14601	2	4"	8 3/16"	9 1/2"	18"	4"	5/8"
1550-15101	2	4"	9 7/16"	11"	20"	4 1/4"	5/8"
1550-16101	2	5"	9 7/16"	11"	24"	4 1/4"	5/8"
1550-17101	2	5 1/2"	13"	15"	28"	5"	1 3/8"
1550-17601	2	5 1/2"	13"	15"	30"	5"	1 3/8"
1550-19201	2	6 1/2"	15"	17 3/4"	36"	5 3/8"	1 3/8"
1550-19301	2	6 1/2"	15"	17 3/4"	42"	5 3/4"	1 3/8"
1560- DIMENSIONS AS ABOVE							
9350-04001	1	113.5mm			405mm	107.9mm	
9350-04601	1	Specify		Specify	460mm	114.3mm	Specify
9350-05101	1	Specify		Specify	510mm	115mm	Specify
9350-06101	1	Specify		Specify	610mm	140mm	Specify
9350-06601	1	234.2mm			660mm	152.4mm	
9350-07101	1	Specify		Specify	710mm	140mm	Specify
9350-08101	1	Specify		Specify	810mm	140mm	Specify
9500-01701	1	45mm	140mm	125mm	160mm	54mm	4mm
9500-02001	1	50mm	140mm	125mm	200mm	72mm	4mm
9500-02501	1	60mm	224mm	200mm	250mm	72mm	5mm
9500-03201	1	75mm	224mm	200mm	315mm	80mm	5mm
9500-03501	1	75mm	286mm	260mm	350mm	91mm	5mm
9500-04001	1	75mm	286mm	260mm	400mm	91mm	5mm

GENERAL SPECS. (SUPER PRECISION, STANDARD ACCURACY and GRIPTRU chucks)

Size	Cat.No.	Max.RPM *	BORE (max.)	INSIDE JAWS						OUTSIDE JAWS				
				A		B		C		D		E		h
				MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	Jaw Height
80mm	9210-00805	5000	19	1	32	24	44	50	78	28	50	50	76	13
80mm	9580-00805	4000	19	1	32	24	44	50	78	28	50	50	76	13
80mm	9250-00805	5000	19	1	32	24	44	50	78	28	50	50	76	13
100mm	9210-01005	5000	25	1	32	25	56	56	90	28	60	60	98	17
100mm	9580-01005	3800	25	1	32	25	56	56	90	28	60	60	98	17
100mm	9250-01005	5000	25	1	32	25	56	56	90	28	60	60	98	17
125mm	9210-01305	5000	35	1.5	52	28	78	70	120	38	84	78	124	19
125mm	9580-01305	3700	35	1.5	52	28	78	70	120	38	84	78	124	19
125mm	9250-01305	5000	35	1.5	52	28	78	70	120	38	84	78	124	19
160mm	9210-01705	4900	45	1.5	56	42	98	84	152	48	106	90	160	23
160mm	9580-01705	3500	45	1.5	56	42	98	84	152	48	106	90	160	23
160mm	9250-01705	4900	45	1.5	56	42	98	84	152	48	106	90	160	23
200mm	9210-02005	4200	55	2	76	56	126	115	186	54	128	114	200	29
200mm	9580-02005	3200	55	2	76	56	126	115	186	54	128	114	200	29
200mm	9250-02005	4200	55	2	76	56	126	115	186	54	128	114	200	29
250mm	9210-02505	3300	75	3	114	60	168	148	250	64	162	150	250	33
250mm	9580-02505	2800	75	3	114	60	168	148	250	64	162	150	250	33
250mm	9250-02505	3300	75	3	114	60	168	148	250	64	162	150	250	33
315mm	9580-03205 9210-03205 9250-03205	2300	105	6	120	70	184	184	298	76	190	190	304	40
400mm	9580-04005 9210-04005	2000	136	10	187	90	268	223	400	92	270	224	406	50
500mm	9580-05105	1100	190	10	232	122	372	262	500	118	362	258	502	54

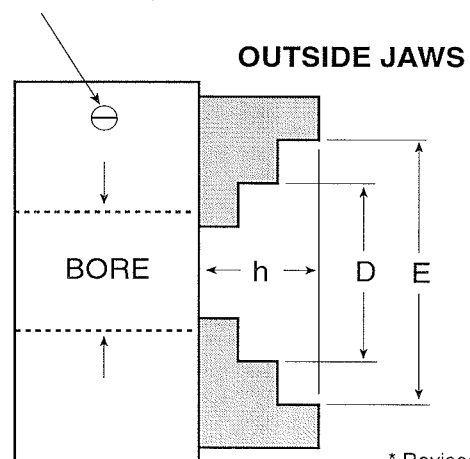
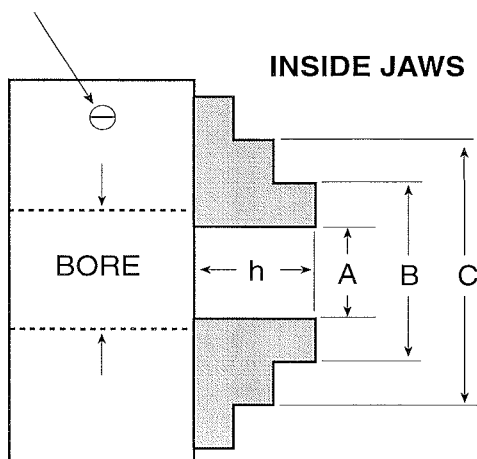
All dimensions in mm. n.b. The above bores CANNOT be increased. Speed rating of 6 jaw Griptru chucks is 70% of 3 jaw.

AT MAXIMUM, THE JAWS WILL PROTRUDE BEYOND THE CHUCK BODY BUT WITH TEETH IN FULL ENGAGEMENT WITH THE SCROLL. THIS LIMIT SHOULD NOT BE EXCEEDED.

GRIPPING DIMENSIONS FOR 6 JAW GRIPTRU CHUCKS ARE AS 3 JAW GRIPTRU CHUCKS.

Lifting plug-hole M16 (cat. no. 2000-16422)
(400mm & 500mm only)

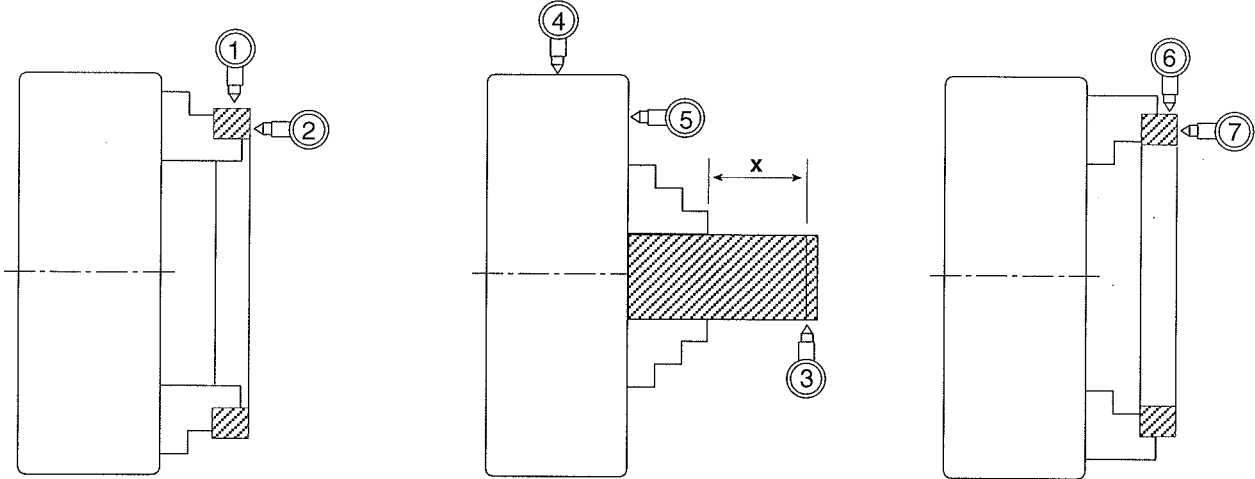
Lifting plug-hole M16 (cat. no. 2000-16422)
(400mm & 500mm only)



* Revised May 2000

ACCURACY LIMITS

METRIC SUPER PRECISION & STANDARD ACCURACY CHUCKS



25µm = .001" approx.

Standard Accuracy chucks conform to, or are superior than ISO 3089 class II. Gripping accuracy tests are with each pinion (SP chucks only). Accuracy applies to both two-piece and single piece jaws.

	SUPER PRECISION	F.I.M.	STANDARD ACCURACY	F.I.M.
	Chuck diameter	µm	Chuck diameter	µm
① CONCENTRICITY - Test Ring (internal grip)	80mm - 250mm	75	80mm - 250mm	75
	315mm & 400mm	100	315mm - 400mm	100
② LATERAL RUN-OUT Internal Test Ring	80mm - 400mm	20	80mm - 250mm	50
			315mm - 400mm	75
③ CONCENTRICITY - Test Bar (nominated pinion)	80mm - 250mm	30	-	
	315 & 400mm	50	-	
③ CONCENTRICITY - Test Bar (other pinions)	80mm - 250mm	70	80mm - 160mm	100
	315 & 400mm	100	200mm - 250mm	150
			315mm - 400mm	200
④ CONCENTRICITY - Outside diameter of chuck	80mm - 125mm	25	80mm - 125mm	30
	160mm - 400mm	30	160mm - 250mm	40
			315mm & 400mm	60
⑤ LATERAL RUN-OUT (Chuck face)	80mm - 400 mm	20	80mm - 160mm	30
			200mm & 250mm	40
			315mm & 400mm	60
⑥ CONCENTRICITY - Test Ring (external grip, nominated pinion).	80mm - 315mm	40	-	
	400mm	50	-	
⑥ CONCENTRICITY - External Test Ring, other pinions	80mm - 250mm	75	80mm - 250mm	75
	315 & 400mm	100	400mm	100
⑦ LATERAL RUN-OUT (External Test Ring)	80mm - 400mm	20	80mm - 250mm	50
			315mm & 400mm	75
Dimension 'x' mm (Test bar stand-out)	80mm - 160mm	60	80mm - 250mm	50
F.I.M. = Full indicator movement	200 & 250mm	75	315mm & 400mm	75
	315 & 400mm	100		



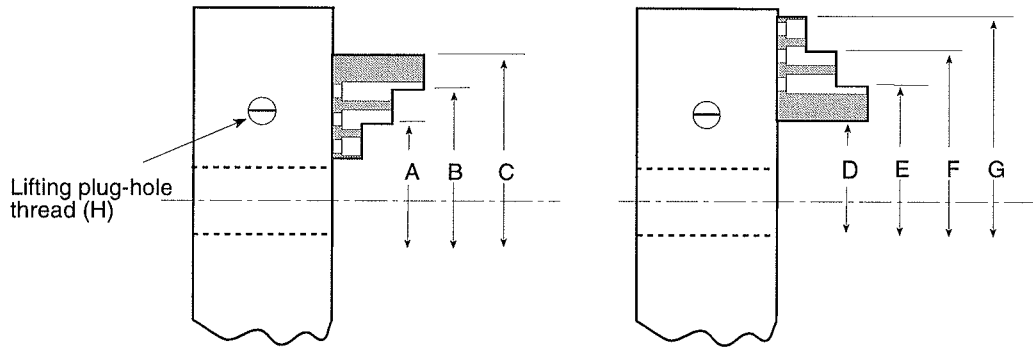
MANUAL CHUCKS SPEED CHART & GRIPPING FORCES

53a

Chuck size	Cat. no.	Max. Input Torque	Static Grip (per jaw)	Maximum recommended speed
3 jaw Metric Super Precision		Revised May 2000		
80mm	9210-00805	28Nm	580daN	5000 rpm
100mm	9210-01005	38Nm	715daN	5000 rpm
125mm	9210-01305	52Nm	805daN	5000 rpm
160mm	9210-01705	75Nm	1115daN	4900 rpm
200mm	9210-02005	115Nm	1560daN	4200 rpm
250mm	9210-02505	156Nm	1865daN	3300 rpm
315mm	9210-03205	203Nm	2230daN	2300 rpm
400mm	9210-04005	203Nm	2450daN	2000 rpm
3 jaw Metric Standard Accuracy				
80mm	9580-00805	28Nm	580daN	4000 rpm
100mm	9580-01005	38Nm	715daN	3800 rpm
125mm	9580-01305	52Nm	805daN	3700 rpm
160mm	9580-01705	75Nm	1115daN	3500 rpm
200mm	9580-02005	115Nm	1560daN	3200 rpm
250mm	9580-02505	156Nm	1865daN	2800 rpm
315mm	9580-03205	203Nm	2230daN	2300 rpm
400mm	9580-04005	203Nm	2450daN	2000 rpm
500mm	9580-05105			1100 rpm
3 jaw Medium duty steel scroll chucks				
460mm	9780-04705	235Nm	2670daN	1500 rpm
535mm	9780-05305	235Nm	2800daN	1200 rpm
610mm	9780-06105	235Nm	2800daN	1000 rpm
3 jaw Tudor scroll chucks				
160mm	9380-01721	75Nm	1115daN	2800 rpm
200mm	9380-02021	115Nm	1560daN	2400 rpm
250mm	9380-02521	156Nm	1865daN	2100 rpm
315mm	9380-03221	203Nm	2230daN	1800 rpm
400mm	9380-04021	235Nm	2750daN	1500 rpm
460mm	9380-04621	235Nm	2890daN	1200 rpm
535mm	9380-05321	235Nm	3025daN	1000 rpm
635mm	9380-06321	300Nm	3200daN	800 rpm
735mm	9380-07321	300Nm	3330daN	600 rpm
4 jaw Metric Independent chucks				
160mm	9500-01701	40Nm	1025daN	3000 rpm
200mm	9500-02001	66Nm	2050daN	2300 rpm
250mm	9500-02501	81Nm	2360daN	1700 rpm
315mm	9500-03201	96Nm	3340daN	1500 rpm
400mm	9500-04001	96Nm	3340daN	1300 rpm

INTERNATIONAL & HIGH SPEED QUICKCHANGE

Basic specs. and gripping ranges



INTERNATIONAL POWER CHUCKS SERIES 9821-xxxxx										
Size	BORE	RPM	A	B	C	D	E	F	G	H
125mm	27mm	8000	18-65mm	48-95mm	81-128mm	6-60mm	50-104mm	82-136mm	108-162mm	-
150mm KB	43mm	6000	34-89mm	64-119mm	97-152mm	22-84mm	66-128mm	98-160mm	124-186mm	-
165mm	43mm	6000	21-87mm	70-134mm	118-184mm	14-80mm	53-115mm	100-164mm	146-212mm	-
170mm KB	52mm	6000	29-89mm	78-136mm	126-186mm	22-82mm	61-117mm	108-166mm	154-214mm	-
210mm	52mm	5000	38-119mm	94-176mm	145-225mm	22-104mm	72-152mm	121-203mm	175-258mm	1/2" unc
210mm KB	65mm	5000	54-123mm	110-180mm	161-229mm	38-108mm	88-156mm	137-207mm	191-262mm	1/2" unc
254mm	65mm	4200	56-159mm	110-214mm	162-266mm	38-144mm	87-190mm	136-241mm	190-298mm	1/2" unc
265mm KB	77mm	4200	68-171mm	122-226mm	174-278mm	50-156mm	99-202mm	148-253mm	202-310mm	1/2" unc
305mmKB	90mm	3300	60-190mm	142-272mm	203-356mm	28-160mm	80-204mm	160-288mm	238-370mm	1/2" unc
380mm	126mm	2500	94-235mm	195-335mm	295-433mm	60-202mm	112-250mm	213-350mm	306-447mm	5/8" unc
460mm	141mm	2000	136-317mm	237-417mm	337-515mm	102-284mm	154-332mm	255-432mm	348-529mm	5/8" unc
530mm	141mm	1800	146-387mm	247-487mm	347-585mm	112-354mm	164-402mm	265-502mm	358-599mm	5/8" unc
610mm	166mm	1500	170-467mm	271-567mm	371-665mm	136-434mm	188-482mm	289-582mm	382-679mm	5/8" unc

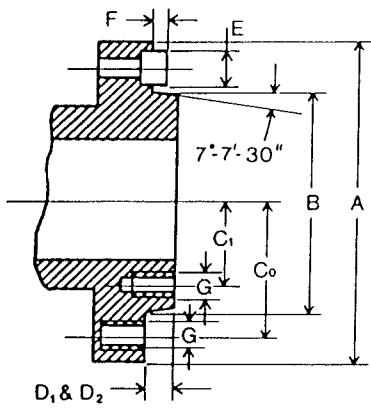
HIGH SPEED QUICKCHANGE POWER CHUCKS SERIES 9121-xxxxx & 9131-xxxxx										
Size	BORE	RPM	A	B	C	D	E	F	G	H
165mm	43mm	6000	18-87mm	68-134mm	116-184mm	7-80mm	46-115mm	92-164mm	136-212mm	None
210mm	52mm	5500	25-119mm	84-176mm	136-225mm	10-104mm	60-152mm	108-203mm	164-258mm	1/2" unc
210mm KB	66mm	5500	39-119mm	98-176mm	150-225mm	24-104mm	74-152mm	122-203mm	178-258mm	1/2" unc
254mm	66.5mm	5000	30-159mm	89-214mm	140-266mm	17-144mm	70-190mm	117-241mm	173-288mm	1/2" unc
265mm KB	77mm	5000	41-170mm	100-225mm	151-277mm	28-155mm	81-201mm	128-251mm	184-209mm	1/2" unc
305mmKB	90mm	4200	26-190mm	110-272mm	190-356mm	16-160mm	70-204mm	146-288mm	223-270mm	1/2" unc
380mm	126mm	3200	58-235mm	160-335mm	260-433mm	24-202mm	86-250mm	180-350mm	274-447mm	5/8" unc
460mm	142mm	2500	98-317mm	200-417mm	300-515mm	64-284mm	126-332mm	220-432mm	314-595mm	5/8" unc
530mm	142mm	2500	102-353mm	204-453mm	304-551mm	68-320mm	130-368mm	224-468mm	318-565mm	5/8" unc

IDENTIFICATION OF STANDARD SPINDLE NOSES

British and DIN Standard Spindle Noses

Short Taper with Bolt Fixing

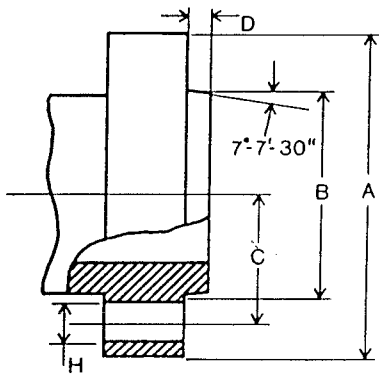
Types A1 and A2, BS4442 Part 1, DIN55021, DIN55026



SPINDLE NOSE SIZE			3"	4"	5"	6"	8"	11"	15"	20"
Outside diameter	A	mm	92	108	133	165	210	280	380	520
Max taper diameter	B	mm	53.975	63.513	82.563	106.375	139.719	196.869	285.775	412.775
P.C.R. Outer bolts	C ₀	mm	35.3	41.3	52.4	66.7	85.7	117.5	165.1	231.8
P.C.R. Inner bolts, (A1)	C ₁	mm	—	—	30.95	41.30	55.55	82.55	123.80	184.15
Spigot height (A1)	D ₁	in	—	—	14.29	15.88	17.46	19.05	20.64	22.23
Spigot height (A2)	D ₂	mm	11	11	13	14	16	18	19	21
Driving stud diameter	E	mm	—	14.25	15.90	19.05	23.80	28.60	34.90	41.30
Driving stud height	F	mm	—	5	5	5	6	8	8	8
Bolt hole size	G		M10	M10	M10	M12	M16	M20	M24	M24

Short Taper with Camlock Fixing

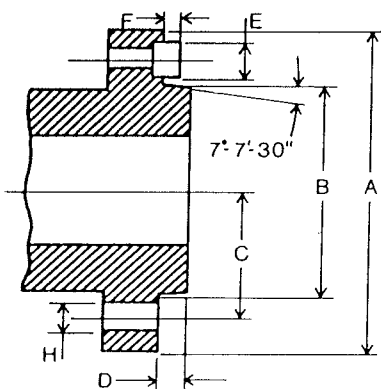
BS4442 Part 1, DIN55029



SPINDLE NOSE SIZE			3"	4"	5"	6"	8"	11"	15"
Outside diameter	A	mm	92	117	146	181	225	298	403
Max taper diameter	B	mm	53.975	63.513	82.563	106.375	139.719	196.869	285.775
P.C.R. Stud holes	C	mm	35.33	41.3	52.4	66.7	85.7	117.5	165.1
Spigot height	D	mm	11	11	13	14	16	18	19
Stud hole diameter	H	mm	15.1	16.7	19.8	23.0	26.2	31.0	35.7
Number of studs			3	3	6	6	6	6	6

Short Taper with Bayonet Ring Fixing

BS4442 Part 2, DIN55022, DIN55027



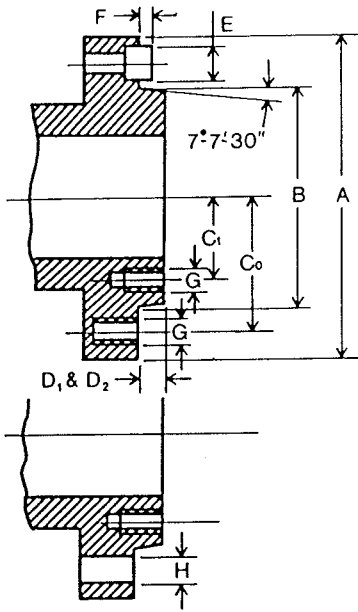
SPINDLE NOSE SIZE			3"	4"	5"	6"	8"	11"	15"
Outside diameter	A	mm	102	112	135	170	220	290	400
Max taper diameter	B	mm	53.975	63.513	82.563	106.375	139.719	196.869	285.775
P.C.R. Stud holes	C	mm	37.5	42.5	52.4	66.7	85.7	117.5	165.1
Spigot height	D	mm	11	11	13	14	16	18	19
Driving stud diameter	E	mm	—	14.25	15.90	19.05	23.80	28.60	34.90
Driving stud height	F	mm	—	5	5	5	6	8	8
Stud hole diameter	H	mm	21	21	21	23	29	36	43
Number of studs			3	3	4	4	4	6	6

IDENTIFICATION OF STANDARD SPINDLE NOSES

American Standard Spindle Noses, USAS B5.9

Short Taper with Bolt or Stud Fixing

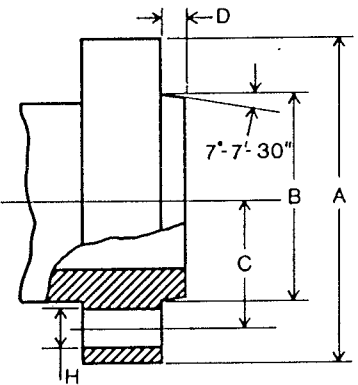
Types A1, A2, B1 and B2



SPINDLE NOSE SIZE			3"	4"	5"	6"	8"	11"	15"	20"
Outside diameter	A	in mm	3.625 92.08	4.250 107.95	5.250 133.35	6.500 165.10	8.250 209.55	11.00 279.40	15.00 381.00	20.50 520.70
Max taper diameter	B	in mm	2.1250 53.975	2.5005 63.513	3.2505 82.563	4.1880 106.375	5.50075 139.719	7.75075 196.869	11.2510 285.775	16.251 412.775
P.C.R. Outer bolts	C ₀	in mm	1.391 35.32	1.625 41.28	2.063 52.39	2.625 66.68	3.375 85.73	4.625 117.48	6.500 165.10	9.125 231.78
P.C.R. Inner bolts (A1 & B1 only)	C ₁	in	—	—	1.219 30.96	1.625 41.28	2.188 55.56	3.250 82.55	4.875 123.83	7.250 184.15
Spigot height (A1 & B1 only)	D ₁	in mm	— —	— —	0.56 14.3	0.63 15.9	0.69 17.5	0.75 19.1	0.81 20.6	0.88 22.2
Spigot height (A2 & B2 only)	D ₂	in mm	0.44 11.1	0.44 11.1	0.50 12.7	0.56 14.3	0.63 15.9	0.69 17.5	0.75 19.1	0.81 20.6
Driving stud diameter	E	in mm	— —	0.562 14.29	0.625 15.88	0.750 19.05	0.937 23.81	1.125 28.58	1.375 34.93	1.625 41.28
Driving stud height	F	in	—	0.19 4.8	0.19 4.8	0.19 4.8	0.25 6.4	0.31 7.9	0.31 7.9	0.31 7.9
Bolt hole size	G	UNC	7/16"-14	7/16"-14	7/16"-14	1/2"-13	5/8"-11	3/4"-10	7/8"-9	1"-8
Stud hole diameter (B1 and B2 only)	H	in mm	0.469 11.91	0.469 11.91	0.469 11.91	0.531 13.49	0.656 16.67	0.797 20.24	0.922 23.42	1.050 26.60

Short Taper with Camlock Fixing

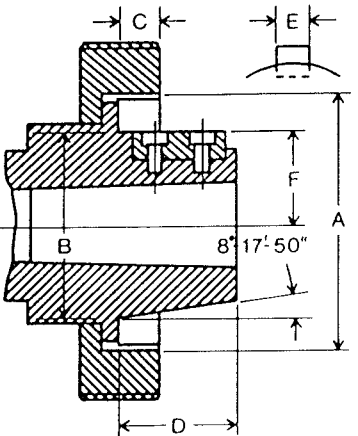
Type D1



SPINDLE NOSE SIZE			3"	4"	5"	6"	8"	11"	15"
Outside diameter	A	in mm	3.625 92.08	4.625 117.48	5.750 146.05	7.125 180.98	8.875 225.43	11.750 298.45	15.875 403.23
Max taper diameter	B	in mm	2.1250 53.975	2.5005 63.513	3.2505 82.563	4.1880 106.375	5.50075 139.719	7.75075 196.869	11.2510 285.775
P.C.R. Stud holes	C	in mm	1.391 35.32	1.625 41.28	2.063 52.39	2.625 66.68	3.375 85.73	4.625 117.48	6.500 165.10
Spigot height	D	in mm	0.44 11.1	0.44 11.1	0.50 12.7	0.56 14.3	0.63 15.9	0.69 17.5	0.75 19.1
Stud hole diameter	H	in mm	0.5937 15.081	0.6562 16.669	0.78125 19.844	0.90625 23.019	1.03125 26.194	1.21875 30.956	1.40625 35.719
Number of studs			3	3	6	6	6	6	6

Long Taper with Drive Key and Drawnut

Type L



SPINDLE NOSE SIZE			LOO	LO	L1	L2	L3
Drawnut thread	A	UNS	3 3/4"x6	4 1/2"x6	6"x6	7 3/4"x5	10 3/8"x4
Max taper diameter	B	in mm	2.750 69.85	3.250 82.55	4.125 104.78	5.250 133.35	6.500 165.10
Nut face to flange face	C	in mm	0.66 16.7	0.69 17.5	0.75 19.1	1.00 25.4	1.06 27.0
Length of taper nose	D	in mm	2.000 50.80	2.375 60.33	2.875 73.03	3.375 85.73	3.875 98.43
Width of key	E	in mm	0.375 9.53	0.375 9.53	0.625 15.88	0.750 19.05	1.000 25.40
Height of key	F	in mm	1.370 34.80	1.620 41.15	2.0575 52.26	2.620 66.55	3.245 82.42



We have records of many other spindle noses in addition to those below. Please contact us for details.

MODEL	Spindle Nose	MODEL	Spindle Nose	MODEL	Spindle Nose	MODEL	Spindle Nos
DEAN SMITH & GRACE (UK)		GILDEMEISTER		HARRISON (UK)		HERBERT (UK)	
36LD	D1-11"	Hamburg 250	DIN 5	M350	D1-6" Camlock	3A Auto	BS 7 1/2"
36XS	D1-11"	Hanseal 350	DIN 5	M390	D1-6" Camlock	3m Robot	A2-6"
165B	D1-6" camlock	NEF 280	DIN 5	M400	D1-8" Camlock	4	BS 7 1/2"
500TC	D1-8" Camlock	NEF 360	DIN 55021-5	M450	D1-8" Camlock	4 Auto	BS 10"
1307	D1-6" camlock	NEF 480	DIN 6	M460	D1-8" Camlock	4 Senior	BS 7 1/2"
1609	D1-6" camlock	NEF 660	BDIN 11/DI-11	M500	D1-8" Camlock	4B	BS 7 1/2"
1609CT	D1-6" camlock	NEF 840	DIN 11	M540	D1-11" Camlock	4M Auto	A2-8"
1709	D1-8" camlock	NEF 1020	DIN 11	M550	D1-11" Camlock	4SE Capstan	BS 7 1/2"
1910	D1-8" camlock	MD10, MD13	DIN 11	M600	D1-11" Camlock	5 Auto	BS 10"
1910T	D1-8" camlock	MD20, MD23	DIN 11	M750	A2-11"	5A	BS 7 1/2"
2112	D1-8" camlock	MD30, Md 33	DIN55021-15	M750LB	A2-11"	5A Auto (Post '59)	BS 14 1/4"
2112CT	D1-8" camlock			M790	A2-11"	5A Auto (Pre '59)	BS 10"
2112SB	D1-8" camlock	GRAZIANO (Italy)		TU.150U	A2-3"	5A/33 Auto	BS 14 1/4"
2415	D1-11"	HARDINGE		TU.150P	A2-3"	5B	BS 7 1/2"
CNC 50	A2-8"	HARRISON (UK)		TU.150E	A2-3"	5 Senior	BS 7 1/2"
CNC 2110	D1-8" or A2-8"	ALPHA 330 & 330S	D1-4" camlock	TU 360	A2-6"	6" Smallpiece	BS 5 1/4"
CNC 2413	D1-11" or A2-8"	ALPHA VS 330		Trainer 280	D1-3" Camlock	9" Smallpiece	BS 7 1/2"
CNC 2817	D1-11" or A2-8"	ALPHA 400 & 400S	D1-6" Camlock	V280		7 Comb.Turret	BS 7 1/2"
CNC 3220	A2-11"	ALPHA 400T & 400U	D1-6" Camlock	V350	D1-4" Camlock	7 Junior	BS 7 1/2"
CNC 3220P	B1-20"	ALPHA 460 & 460S	D1-8" Camlock	V380	D1-6" Camlock	7 Pre-Op.	BS 7 1/2"
CNC 3624	A2-11"	ALPHA 550 & 550S	D1-11" Camlock	V390	D1-6" Camlock	7A Comb.Turret	BS 7 1/2"
CNC 3624P	B2-20"			V450	D1-8" Camlock	8 Comb.Turret	BS 10"
CNC 4432	A2-11"	7"	Screwed	V460	D1-8" Camlock	8 Pre-Op Comb.	BS 10"
Pioneer	D1-6" or A2-6"	7.5" Swing	Screwed	V530	D1-8" Camlock	9 Comb.Turret	BS 10"
Series 3000	A2-8"	9" L5	Screwed or L00	V550	D1-11" Camlock	9A Comb.Turret	BS 10"
TC1 Monarch	A2-8"	11" Swing L5A	Screwed or L00	Union Graduate	1.5" x 6 bsw	9B Comb.Turret	BS 10"
TC2 Monarch	A2-8" or A2-11"	11" Swing H.D.	D1-5" Camlock	Union Jubilee	1" x 10 bsf	9B/30 (Post '54)	BS 14 1/4"
TC3 Monarch	A2-8" or A2-11"	12" Swing L6	Screwed or L00	HYDRO-HARRISON (UK)		9B/30 (Pre '54)	BS 10"
TC4 Monarch }	A1-15" or A2-15"	13" Swing H.Duty	D1-5" Camlock	CNC 500	D1-6" Camlock	9C Combination	BS 14 1/4"
TC4 Monarch }	or A2-20"	15" Swing	D1-6" Camlock	CNC 540	D1-11" Camlock	9C/30	BS 14 1/4"
DE MOOR (Belgium)		17" Sw. (1960-70)	L2	HARTLE-STEDALL (UK)		10 Comb. Turret	BS 10"
DENFORD (UK)		17" Swing (1970-)	D1-8" Camlock	HERCUS (Australia)		12 Comb.Turret	BS 14 1/4"
DENHAM (UK)		15" Swing L21	3.75" x 6 tpi	HERBERT (UK)		12B Comb.Turret	BS 16"
DRUMMOND		L5	Screwed or L00	0 Capstan	1.5" x 12 tpi	20 Combination	BS 14 1/4"
ELLIOTT		L5A	Screwed or L00	1 Capstan	2.25" x 12 tpi	21 Combination	BS 14 1/4"
Emco Unimat 3	M12 x 1mm	L6	Screwed or L00	2	BS 5 1/4"	22 Combination	BS 14 1/4"
Emco Unimat SL	M14 x 1mm	L16	L0	2 Flashcap	BS 5 1/4"	AL 10	A2-5"
Maximat V13	DIn 4 or D1-4	L17	L2 or D1-8	2 Senior	BS 5 1/4"	AL 20	A2-6"
EMI-MEC		L21	3.75" x 6 tpi	3 Capstan	BS 5 1/4"	AL 30	A2-8"
ERNAULT-SOMUA (France)		140		2B	BS 5 1/4"	AL 40	A1-11"
GEORGE FISCHER (Switzerland)		165	D1-5" Camlock	2D	BS 5 1/4"	AL 60	A2-8"
		M250	D1-3" Camlock	2S	BS 5 1/4"	Batchmatic M350	A2-11"
		M300	D1-4" Camlock	2A Auto	BS 7 1/2"	Batchmatic M75/250	A1-8"
		M325	D1-4" Camlock	3 Auto Junior	BS 5 1/4"	Cridan B (pre 67)	BS 5.25"
		M340	D1-4" Camlock	3 Auto	BS 7 1/2"	Cridan B (post 67)	A1-5
						Cridan C	A1-8
						Husky 500	A2-8"
						Husky 1000	A2-8"
						Husky 1500	A2-8"



We have records of many other spindle noses in addition to those below. Please contact us for details.

MODEL	Spindle Nose	MODEL	Spindle Nose	MODEL	Spindle Nose	MODEL	Spindle Nose
HEYLIGENSTAEDT (Germany)		MORI-SEIKI		SUGA		WARNER SWASEY (UK)	
HITACHI SEIKI		SL6A	A1-11	SMT (Swedish Machine Tools)		1SC250/M-5000	A2-6"
HOLBROOK (UK)		SL6B	A2-11	TOS (Czechoslovakia)		1SC315/M-5020	A2-8"
Minor	D1-4	SL7A	A1-11	SN32 & SN32C	D1-6 Camlock	2SC315/M-5060	A2-8"
Major	D1-5	SL7B	A2-11	SN40C	D1-6 Camlock	2SC400/M-5060	A1-11"
Marquis	D1-6	SL8	A1-20	SN50C	D1-6 Camlock	2SC500/M-5090	A1-11"
Magna	D1-6	SL8A	A2-15	SN63C	D1-8 Camlock	315 Universal	A2-8"
Universal H15	D1-6	SL8B	A1-20	SN71C	D1-8 Camlock	QCM-6	A2-5"
Universal H17	D1-6	SL8C	A1-20	SN710S	DIN 8"	WSC-8	A2-6"
Universal H20	D1-8	SL8F	A2-15	SUI 40A	Morse/Camlock	WICKMAN LANG (UK)	
Universal U17	D1-6	TL2A	A2-6	SUI 50A	Morse/Camlock	X Y Z	
Model B7	D1-6	TL2B	A2-8	TYZACK		XYZ 1400	Camlock D1-4
Model B13	D1-5	TL3A, TL3B	A2-8	ZYTO 12	7/8" x 9 BSW	XYZ 1600	Camlock D1-6
Model B17	D1-6	TL5A, TL5B	A2-8	ZYTO 16	7/8" x 9 BSW	XYZ 2000	Camlock D1-8
Model B21	D1-8	MYFORD (UK)		VDF BOEHRINGER (Germany)		XYZ 2200	Camlock D1-11
Model C10	D1-4	C7	1 1/8" x 12tpi	H.W.WARD (UK)		XYZ 350VS	Camlock D1-6
Model C13	D1-5	ML2	7/8" Whit	2, 2A Capstan	BS 5 1/4"	XYZ 410VS	Camlock D1-8
Model C16	D1-6	M4, ML4	1 1/8" x 12tpi	2C, 2CA Capstan	BS 5 1/4"	PROTURN 350	Camlock D1-6
Model CB-8	D1-2	ML7-R	1 1/8" x 12tpi	2DS, 2DB Capstan	BS 5 1/4"	PROTURN 410	Camlock D1-8
Model D13	D1-5	SUPER 7, ML7	1 1/8" x 12tpi	3, 3A Capstan	BS 5 1/4"	YAMAZAKI	
Model D18	D1-6	ML8	1" x 12tpi	3C & 3CA Capstan	BS 5 1/4"	Mazakmate	A2-5/D1-5
Model R9	D1-8	ML10	1 1/8" x 12tpi	3DB / 3DS Capstan	BS 5 1/4"	Mazak Ace 1000	A1-6/D1-6
6.5" Lathe	2.25" x 6 tpi	280	D1-3"	7 Comb. Turret	BS 7 1/2"	Mazak 860	D1-8
7.5" Lathe	3" x 5 tpi	NAKAMURA		7 & 7DS Capstan	BS 7 1/2"	Mazak Rex	A1-11/D1-11
T15	2.75" x 6 tpi	OKUMA		7 Preselect	BS 7 1/2"	Mk II	A2-8 / D1-8
IKEGAI		LC10	A2-5	7C Prelector	BS 7 1/2"	Microturn	A2-5
INDEX		LC20	A2-6	7D Prelector	BS 7 1/2"	Powermaster	A2-11/D1-11
JONES & LAMSON (USA)		LC30	A2-8	*7D Prelector 5 1/4" bore spindle		Slant 15	A2-6
JONES & SHIPMAN (UK)		LC40	A2-8	*7E Prelector 5 1/4" bore spindle		Slantmaster	A2-8/D1-8
KERRY (UK)		LSN4/6	A1-6	* Special spindle nose		Mazak M3	A1-8
LE BLOND (USA)		LSN10	A2-8	8 Comb. Turret	BS 10"	Mazak M4	A2-8
D. MITCHELL (UK)		LH50-N	A2-15	10 Comb. Turret	BS 10"	Mazak M5	A1-11/D1-11
MONDIALE (Belgium)		LF30-M	A1-6/A2-8	10C/10D Prelector	BS 13"	4 Dynamicturn	A2-6
MORI-SEIKI		RAGLAN (UK)		10CR Prelector	BS 13"	5 Dynamicturn	A2-8
SL1		SCHAUBLIN (Switzerland)		10DR Prelector	BS 13"	6 Dynamicturn	A2-8
SL2A	A1-6 modified	SMART & BROWN		10/13 Comb(Post '51)	BS 13"	2L Dynaturn	A2-6
SL2B	A2-8	SOUTHBEND (USA)		13 Comb. Turret	BS 16"	3L Dynaturn	A2-8
SL3A	A1-6 modified	STANLEY (UK)		16 Comb. Turret	BS 16"	4L Dynaturn	A1-8
SL3B	A2-8	WARNER SWASEY (UK)				5L Dynaturn	A1-11
SL4	A2-8	0AC	A2-5"	0AC	A2-5"	Hi-Proturn 3622	A1-15
SL5	A2-8	1AC	A2-6"	1AC	A2-6"	Hi-Proturn 4227	A1-15
		2AC	A2-8"	2AC	A2-8"	Hi-Proturn 4930	A1-15
		3AC	A2-11"	3AC	A2-11"	Hi-Proturn 5435	A1-15
		4AC	A2-15"	4AC	A2-15"	Hi-Proturn 6540	A1-20
						Hi-Proturn 7550	A1-20



Lathe model Toolpost Cat. No.

AJAX		
AJ150 & AJ165E	S0	S110D0015
AJ210	S2	S112D0001
AJ225	S2T	S112D0011
AJ310	S3	S113D1002

BINNS & BERRY		
Trident TV25	S4	S114D0013

BOXFORD		
'A'	S0	S110D0015
160TCL	S00	S100D0011
250B & 250F	S00	S100D0011
280 Manual	S0	S110D0015
9" Swing	S0	S110D0015
280 Turnmaster	S1	S111D0001

BRIDGEPORT		
EZ Path	S2T	S112D0011

BUTLER		
Concord 460	S3	S113D1002

COLNE		
Robotic	S00	S100D0012

COLCHESTER LATHE		
Bantam VS 3500	S0	S110D0015
Bantam 2000	S0 or S1/X	S110D0015
Bantam	S1	S111D0001
Chipmaster	S1	S111D0001
Colt	S1/X	S111D0011
Student 1600	None available.	
Student 1800	S2	S112D0001
Student 2500	S1	S111D0001
Student VS 3000	S1	S111D0001
Student 3100	S2	S112D0001
Master 2500	S2	S112D0001
Master VS	S2	S112D0001
Triumph 7.5"	S2T	S112D0001
Triumph 2000	S2T	S112D0001
Triumph VS2500	S2T	S112D0001
Mascot (all models)	S3	S113D0001
Mastiff GH	S3	S113D0001
Mastiff 1400	S3X	S113D0019
Mastiff VS1800	S3	S113D0001
CNC 500	S3	S113D0001
4000	S3	S113D0001
Magnum	S4	S114D0013
Magnum LB	S4	S114D0013

Lathe model Toolpost Cat. No.

CONNECT		
121	S00	S100D0012

CROWTHORNE		
7.5" & 8.5"	S3	S113D1002

CVA		
1A	S2	S112D0001

DEAN SMITH & GRACE		
13/1	S2/T	S112D0011
1307	S2/T	S112D0011
1309	S2/T	S112D0011
1709	S2/T	S112D0011
8.5"	S3	S113D1002
15 & 17	S3	S113D1002
21"	S3	S113D1002

DENFORD		
9" Viceroy	S0	S110D0015

EDGEWICK		
Mark 2	S2	S112D0001

ELLIOTT		
Concorde	S3	S113D1002
M16	S3	S113D1002
M15	S2T	S112D0011
Omnispeed	S2T	S112D0011

EMCO		
Emcomat	S00	S100D0012

EXCEL		
XL32	S4	S114D0013
XL43	S4	S114D0013
XL320	S1	S111D0001
XL440	S3	S133D1002
XL500	S3	S133D1002
XL580	S3	S133D1002
XL640	S4	S114D0013
XL1640	S2T	S112D0011
XL1860	S2T	S112D0011
XL1440GE	S1	S111D0001

FEELER		
FTL618EM	S0	S110D0015

Lathe model Toolpost Cat. No.

GORATTI		
180	S2	S112D0001

GURUIZPE		
SUPER M	S3	S113D1002

HARDINGE		
HLV	S0	S110D0015

T.S.HARRISON		
Trainer	S0	S110D0015
9" Swing	S1	S111D0001
11" Swing	S1	S111D0001
13" Swing	S2	S112D0001
15" Swing	S3	S112D0001
17" Swing	S3	S113D0001
21"	S3X	S113D0019
140	S1	S111D0001
165	S0	S110D0015
190	S1 or S3	S113D0001
(Confirm with customer)		
L5	S2	S112D0001
L6	S2	S112D0001
Alpha 330	S1	S111D0001
Alpha 400	S2T	S112D0011
Alpha 460	S3	S113D1002
Alpha 550	S3	S113D1002
M250	S0	S110D0015
M300	S1	S111D0001
M350	S2T	S112D0011
M390	S2T	S112D0011
M400	S3	S113D0001
M450	S3X	S113D0019
M460	S3	S113D0001
M500	S3X	S113D0019
M540	S3X	S113D0019
M550	S3X	S113D0019
M600	S4	S114D0013
M750	S4	S114D0013
V280	S0	S110D0015
V330	S1	S111D0001
V350	S2	S112D0001
V390	S2T	S112D0011
V460	S3	S113D0001
V550	S3	S113D0001
VS330	S1	S111D0001



Lathe model Toolpost Cat. No.

HERBERT		
No. 4 SENIOR	S2	S112D0001
No. 7	S3	S113D1002
Edgewick MKII	S2	S112D0001

HOLBROOK		
Minor	S0	S110D0015
15 & 17	S2	S112D0001
Magna	S2	S112D0001
Major	S3	S113D1002
C10	S2T	S112D0011

KEARNEY & TRECKER		
CVA 1A	S2	S112D0001

KERRY		
11" Type AG	S1	S111D0001

LANG		
882	S3	S113D1002

MAXIMAT		
	S00	S100D0012

MITCHELL		
6.5" Centre	S2	S112D0001
7.5" & 8.5"	S2T	S112D0011
10.5"	S3	S113D1002

MONARCH		
9"	S2	S112D0001

MYFORD		
254 plus	S00	S100D0012
254 V plus	S00	S100D0012

QUALTERS & SMITH		
8.5"	S3	S113D1002

RAGLAN		
Littlejohn	S1	S111D0001

Lathe model Toolpost Cat. No.

REGAL		
15"	S2T	S112D0020
19"	S3	S113D1002

RIGIDTURN		
400	S2T	S112D0020
280mm centre	S4	S114D0013
560	S3X	S113D0019

SMART & BROWN		
'A'	S0	S110D0015
4.5"	S1	S111D0001
11" (1024)	S1	S111D0001
Sable	S1	S111D0001

STANLEY		
8.5"	S3	S113D1002

STURDITURN		
	S2	S112D0001

TOS		
S32	S2	
SN32C	S2	S112SK765
SN40B	S3	S113D0031
SN40C	S3	S113D0031
SN 50	S3	S113D0031
SN50C	S3	S113D0031
SN 55B	S3/X	S113D0019
SN 63	S3/X	S113D0019
SN63C	S4	S114SK769
SN 71B	S3/X	S113D0019
SN71C	S4	S114SK769
SN500	S3	S113D0001
SU 50	S3	S113D0031
SUI 32	S2	S112SK765
SUI 40	S3	S113D0031
SUI 50	S3	S113D0031
SUI 63	S5	S115SK768
SUI 80	S5	S115SK768
710	S4	S114D0013

ALL TOS LATHES REQUIRE
NON-STANDARD TOOLPOSTS

Lathe model Toolpost Cat. No.

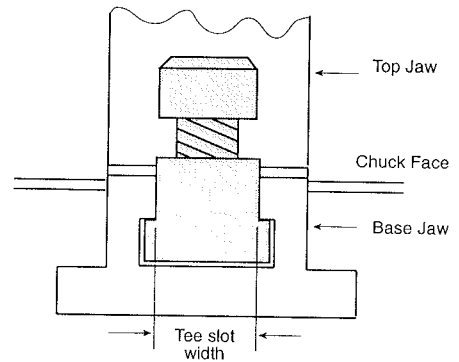
TOWN WOODHOUSE		
70 Junior 7"	S2	S112D0001
8.5"	S3	S113D1002

WARD		
7	S3	S113D1002

WILSON		
6.5" Centre	S2	S112D0001
8.5" & 9.5"	S3	S113D1002

X Y Z		
350	S2T	S112D0011
410	S2T	S112D0011
410VS	S2T	S112D0011
Proturm 410	S3	S113D0031
420	S3	S113D1002
560	S3	S113D1002
1400	S2T	S112D0011
1600	S2T	S112D0011
2200	S3	S113D1002

Jaw cat. no. (single jaw code)	Serrations	Tee slot Width	Hole Centres	Alternative 1	Alternative 2
2160-17512	90° x 1/16"	.5"	11/16"	No alternative.	
2160-21512	90° x 1/16"	.5625"	13/16"	No alternative.	
2160-26512	90° x 1/16"	.625"	15/16"	No longer available	
2160-32512	90° x 1/16"	.6875"	1 1/4"	No alternative.	
2160-40512	90° x 1/16"	.8125"	1 1/2"	No longer available	
2160-51512	90° x 3/32"	1.0"	1 3/4"	No longer available	
2740-17512	90° x 1/16"	13mm	18mm	No alternative.	
2740-21512	90° x 1/16"	17mm	22mm	** 8820-26612	
2740-26512	90° x 1/16"	21mm	25mm	** 2740-32512	8820-31612
2740-32512	90° x 1/16"	21mm	30mm	** 2740-26512	8820-31612
2770-17512	90° x 1/16"	15mm	20.6mm	No alternative.	
2770-21512	90° x 1/16"	17mm	25.4mm	** 8820-21612	8820-26612
2770-26512	90° x 1/16"	17mm	25.4mm	** 8820-21612	8820-26612
2860-17512	90° x 1/16"	17mm	21mm	** 8820-21612	8820-26612
2860-21512	90° x 1/16"	17mm	25.4mm	** 8820-26612	8820-21612
2860-26512	90° x 1/16"	21mm	31.8mm	** 8820-31612	
2860-32512	90° x 1/16"	21mm	31.8mm	** 8820-31612	
2860-40512	90° x 1/16"	1.0"	1 3/4"	** 8820-38612	
2980-17512	90° x 1/16"	.5"	1/2"	No longer available	
2980-19512	90° x 1/16"	.5625"	1/2"	No longer available	
2980-24512	90° x 1/16"	.625"	5/8"	No longer available	
2980-31512	90° x 1/16"	.6875"	29/32"	No longer available	
2980-38512	90° x 1/16"	.8125"	1 3/16"	No longer available	
2980-46512	90° x 3/32"	1.0"	1 3/8"	** 8820-38612	
2980-53512	90° x 3/32"	1.0"	1 5/8"	No longer available	
2980-63512	90° x 3/32"	1.0"	2 1/8"	No longer available	
8140-17512	90° x 1/16"	12mm	20mm	8820-17612	
8140-17525	60° x 1.5mm	12mm	20mm	8820-17625	
8140-21525	60° x 1.5mm	14mm	25mm	8820-21625	
8140-26525	60° x 1.5mm	16mm	25mm	8820-26625	
8140-31525	60° x 1.5mm	18mm	32mm	8820-31625	
8140-40525	60° x 1.5mm	22mm	44.5mm	8820-38625	
8830-13512 †	90° x 1/16"	12mm	14mm	2749-03350	† Sold as set (3) 8820-13612
8830-17512 †	90° x 1/16"	12mm	17mm	8820-13612	† Sold as set (3) 8820-17612
8830-21512 †	90° x 1/16"	17mm	19mm	8820-26612	† Sold as set (3) 8820-21612
8830-26512 †	90° x 1/16"	17mm	19mm	8820-21612	† Sold as set (3) 8820-26612
8830-31512 †	90° x 1/16"	21mm	25mm	No alternative.	† Sold as set (3) 8820-31612
8830-38512 †	90° x 3/32"	25.4mm	31mm	No alternative.	† Sold as set (3) 8820-38612
8830-13525 †	60° x 1.5mm	12mm	14mm	8830-17525	† Sold as set (3) 8820-13625
8830-17525 †	60° x 1.5mm	12mm	17mm	No alternative.	† Sold as set (3) 8820-17625
8830-21525 †	60° x 1.5mm	14mm	19mm	No alternative.	† Sold as set (3) 8820-21625
8830-26525 †	60° x 1.5mm	16mm	19mm	No alternative.	† Sold as set (3) 8820-26625
8830-31525 †	60° x 1.5mm	18mm	25mm	8140-31525	† Sold as set (3) 8820-31625
8830-38525 †	60° x 1.5mm	22mm	31mm	8140-40525	† Sold as set (3) 8820-38625



** Alternatives only suitable if tee nuts are split.

NOTE - alternative jaws may be of different height, length and width.



CHUCKS

Size Code no. kg

INDEPENDENT

160mm	9500-01701	6
200mm	9500-02001	14
250mm	9500-02501	20
315mm	9500-03201	32
350mm	9500-03501	46
400mm	9500-04001	60
460mm (18")	9350-04601	124
510mm (20")	9350-05101	182
610mm (24")	9350-06101	278
710mm (28")	9350-07101	405
810mm (32")	9350-08101	645

SCROLL

80mm	9210-00805	2
100mm	9210-01005	3
125mm	9210-01305	5
160mm	9210-01705	9
200mm	9210-02005	16
250mm	9210-02505	30
315mm	9210-03205	45
315mm	9212-73205	70
400mm	9210-04005	83
460mm	9780-04705	116
535mm	9780-05305	165
610mm	9780-06105	212

TUDOR

460mm	9380-04621	145
535mm	9380-05321	195
635mm	9380-06321	305

GRIPTRU 3 JAW

200mm	9250-02005	17
250mm	9250-02505	32
315mm	9250-03205	47

GRIPTRU 6 JAW

200mm	9260-02005	19
250mm	9260-02505	37
315mm	9260-03205	53

ADAPTORS

160mm D1-3	8271-17222	3.5
200mm D1-4	8271-20223	5.5
250mm D1-6	8271-25225	10
315mm D1-6	8271-32227	24
400mm D1-8	8271-40226	26

Size Code no. kg

HIGH SPEED QUICKCHANGE

165mm	9131-31710	16
210mm	9131-32110	28
254mm	9131-42610	42
265mm	9131-52710	51
305mm	9131-53110	68
380mm	9131-53810	135

INTERNATIONAL POWER

165mm	9821-21723	14
170mm	9827-18140	14
210mm	9827-21160	22
254mm	9827-26100	36
305mm	9827-31150	57
380mm	9821-53823	98

O.C. HYD.CYLINDERS

27/70	1910-02707	14
42/90	1910-04209	15
52/125	1910-05212	21
66/170	1910-06617	26
77/185	1910-07718	32
90/210	1910-09021	40
126/320	1910-12632	77

SELF CONTAINED

160mm	9760-01710	23
200mm	9760-22110	31
250mm	9760-32610	45
315mm	9760-33210	65
350mm	9760-43510	91

HYDRAULIC FRONT-END

165mm	1749-02940	14
210mm	1749-03000	28
254mm	1749-02780	47
305mm	1749-02760	77

LEVER SCROLL

70mm	9460-00705	1.1
110mm	9460-01005	2

TOOLHOLDER ASSEMBLIES

ST2	T112D0143	1
S3	T113D0151	2
S4	T114D0143	4.25

TOOLPOST BODY ASSEMBLIES

S0	A110D0007	2
S1	A111D0001	2
S2	A112D0002	5.5
S3	A113D0001	10

Size Code no. kg

MULTISIZE CHUCKS

KC15	6010-01300	5
KC15 D3	6012-21300	6
KC15D8	6012-61300	13
KC20	6010-01700	15
KC20D8	6012-61700	22
KC25	6010-02100	9
KC25D8	6012-62100	16
LC15	6020-01300	8
LC15D3	6022-21300	9
LC15D6	6022-51300	13
LC20	6020-01700	16
LC20D6	6022-51700	19
LC25	6020-02100	14
LC25D8	6022-52100	22

PC

PC15AP	3030-21300	24
PC20AP	3030-21700	38
PC25AP	3030-22100	36

COLLETS

E	0.15kg	
EA	0.15 to 0.28kg	
EB	0.28 to 0.5kg	
EC	0.5 to 1.0kg	
EC Set	10kg	
ED	0.7 to 1.7kg	
EE	1.3 to 2.9kg	

SPARES

KEYS

Size	Code no.	Kg	Per
6" Ind.	2550-16395	0.5	Ea.
10" Ind.	2550-26395	0.6	Ea.
16" Ind.	2550-31395	1	Ea.
20" Ind.	2550-38395	1.3	Ea.
30" Ind.	2550-92395	3.25	Ea.
4" 3 jaw	2580-10395	0.2	Ea.
200mm 3j	2218-20208	0.6	Ea.
315mm 3j	2218-32208	1.25	Ea.
18" 3 jaw	2980-38395	1.2	Ea.

Above keys include crosspieces.

SOFT TOP JAWS

210mm	8820-21625	Set
315mm	8820-31625	Set
380mm	8820-38625	10 Set

INSIDE JAWS

Size	Code no.	kg	Per
4"	2580-10603	0.3	Set
125mm	2210-13603	0.5	Set
160mm	2210-17603	0.75	Set
200mm	2210-20603	1.1	Set
250mm	2210-25603	2	Set
315mm	2210-32603	2.75	Set
18"	2580-46603	7.25	Set

SOFT JAWS

4"	2580-10606	0.4	Set
125mm	2210-13606	0.6	Set
160mm	2210-17606	1	Set
200mm	2210-20606	1.75	Set
250mm	2210-25606	2.75	Set
315mm	8210-32606	6	Set
400mm	8210-40606	10	Set

SCROLLS

4"	2580-10300	0.2	Ea.
160mm	2210-17300	0.75	Ea.
200mm	2210-20300	1.25	Ea.
315mm	2210-32300	5	Ea.
18"	2580-46300	12	Ea.

PINIONS

4"	2580-10350		Ea.
160mm	2210-17350	0.1	Ea.
200mm	2210-20350	0.15	Ea.
250mm	2210-25350	0.25	Ea.
315mm	2210-32350	0.26	Ea.
18"	2580-46350	0.4	Ea.

INDEPENDENT JAWS

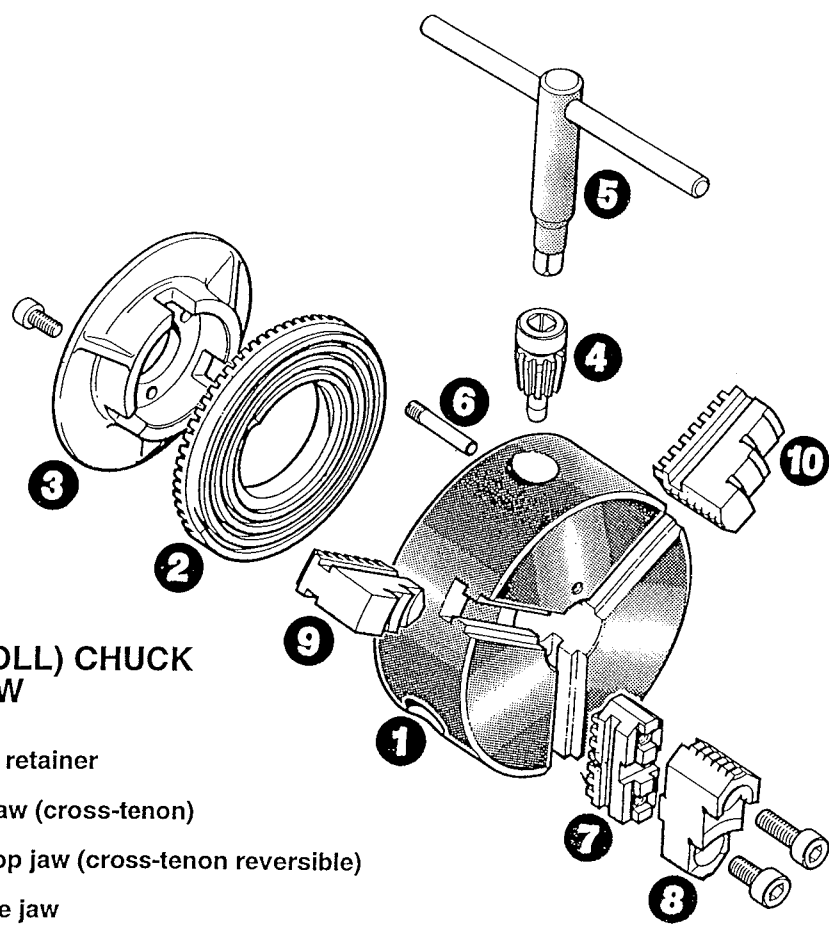
200mm	2500-20601	2.5	Set
315mm	2500-32601	4.5	Set
16"	2350-40601	13	Set
30"	2550-92601	28	Set

SCREWS

10"	2550-26365	1	4
16"	2568-40201	2.5	4
20"	2550-51365	4	4
24"	2550-61365	6.5	4
30"	2550-76365	9	4

BEARINGS

16"	2550-40370	0.9	4
20"	2550-51370	1.5	4
24"	2550-61370	2.5	4
30"	2550-76370	2.8	4

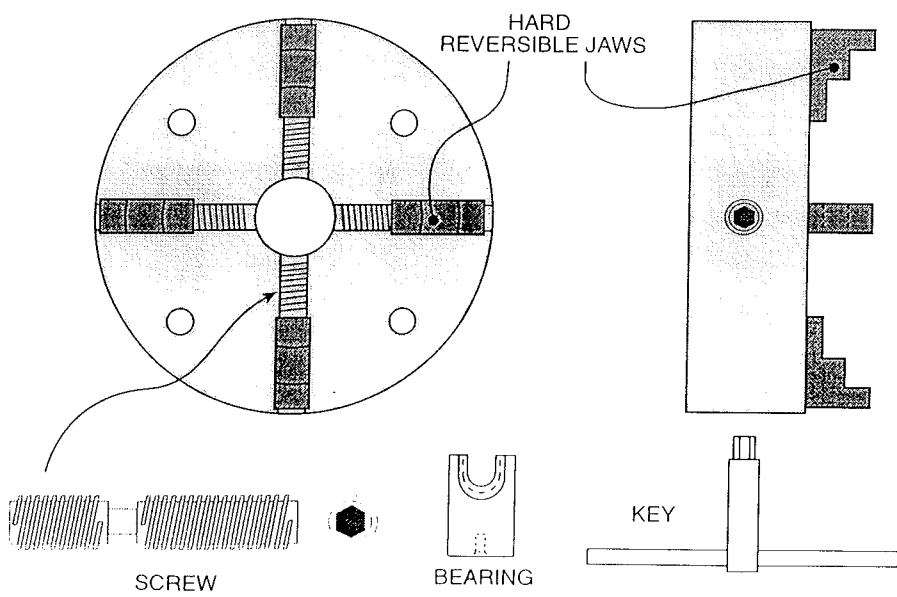


**SELF CENTRING (SCROLL) CHUCK
EXPLODED VIEW**

- 1** Chuck body
- 2** Scroll
- 3** Retaining plate
- 4** Pinion
- 5** Key
- 6** Pinion retainer
- 7** Base jaw (cross-tenon)
- 8** Hard top jaw (cross-tenon reversible)
- 9** Outside jaw
- 10** Inside jaw

Soft blank jaws (to fit on scroll) and soft top jaws (cross-tenon reversible) are also available.

INDEPENDENT 4 JAW CHUCK



While independent chucks are most commonly fitted with hard reversible jaws, note that they may have soft blank jaws or two-piece jaws (base and hard top) fitted as standard.

Bearings are, in most chucks, also retained by a screw or bearing clip.

Imperial (Inches)	Decimal (Inches)	Metric (mm)
1/16"	0.0625"	1.58
3/32"	0.09375"	2.38
1/8"	0.125"	3.17
5/32"	0.15625"	3.96
3/16"	0.1875"	4.76
13/64"	0.203125"	5.16
7/32"	0.21875"	5.55
15/64"	0.234375"	5.95
1/4"	0.25"	6.35
9/32"	0.28125"	7.14
5/16"	0.3125"	7.93
21/64"	0.328125"	8.33
11/32"	0.34375"	8.73
3/8"	0.375"	9.52
	0.3816"	9.70
7/16"	0.4375"	11.11
15/32"	0.46875"	11.90
1/2"	0.5"	12.70
33/64"	0.515625"	13.09
9/16"	0.5625"	14.28
19/32"	0.59375"	15.08
5/8"	0.625"	15.87
41/64"	0.640625"	16.27
21/32"	0.65625"	16.67
11/16"	0.6875"	17.46
23/32"	0.71875"	18.25
3/4"	0.75"	19.05
25/32"	0.78125"	19.84
13/16"	0.8125"	20.63
7/8"	0.875"	22.22
31/32"	0.96875"	24.60
	0.9845"	25.00
Dimensions above 1" are approximated.		
1"		25.4
3"		75
4"		100
5"		125
6"		160
8"		200
10"		250
12"		315
15"		380
16"		400
18"		460
20"		500
21"		525
24"		610
30"		760