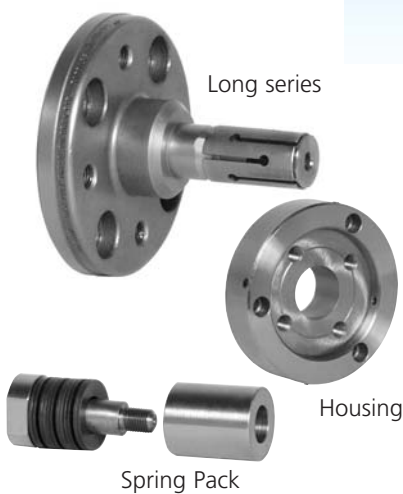
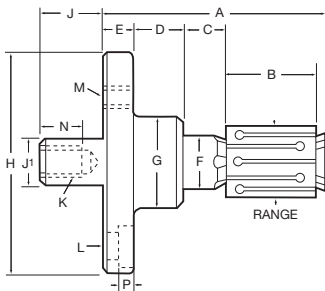


Pratt Burnerd Expanding Mandrel Attachment

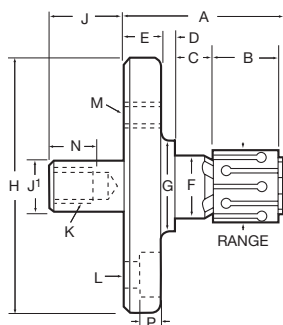
Imperial Design for Quick Change Jaw Chucks and Constant Grip Power Chucks



Spring Pack and Housing are design to fit individual chuck and lathe drawbar set-up. Give chuck model and drawbar set-up specification when ordering.



Long Series Drawing



Short Series Drawing

Convert your Pratt Burnerd 3-Jaw Power Chuck into an expanding Mandrel in minutes.

- Bolts directly onto existing PBI chuck using existing fixturing holes
- No drawtube or drawbar connection required
- Saves time, no need to change chucks or buy an additional chuck
- Size range available 12mm through to 113mm I.D. work pieces
- Available in long or short nose
- Ideal for second operation and twin spindle machines
- System uses high accuracy tork-lok, collets by ITW Woodworth
- Setrite®, feature allows adjustment for zero run-out
- Reference page 23, 25 and page 27 for PBI chucks that this mandrel will adapt to

Long Series

Model	Range	A	B	C	D	E	F	G	H	J	J ¹	K	L
AC-2110	500-.655 10 Collets	2.49	.88	.39	.66	.50	.4702 .4692	1.25	3.3755 3.3750	.750	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-2210	.593-.780 12 Collets	2.69	1.06	.41	.66	.50	.5796 .5786	1.25	3.3755 3.3750	.750	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-2310	.718-.999 18 Collets	2.96	1.25	.49	.66	.50	.7046 .7036	1.25	3.3755 3.3750	.750	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-2410	.875-1.249 12 Collets	3.58	1.44	.56	.90	.56	.8452 .8442	1.75	4.1255 4.1250	1.220	.750	1/2 - 20	Four (4) 1/2 S.H.S. on 3.12 B.C.
AC-2510	1.125-1.624 16 Collets	3.89	1.62	.69	.90	.56	1.0796 1.0786	1.75	4.1255 4.1250	1.220	.750	1/2 - 20	Four (4) 1/2 S.H.S. on 3.12 B.C.
AC-2610	1.468-2.092 20 Collets	4.14	1.81	.82	.72	.68	1.4077 1.4067	2.50	4.8755 4.8750	1.590	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 3.75 B.C.
AC-2710	1.937-2.843 29 Collets	4.46	2.00	1.00	.66	.68	1.8452 1.8442	2.50	4.8755 4.8750	1.590	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 3.75 B.C.
AC-2810	2.563-3.593 33 Collets	4.83	2.25	1.12	.66	.68	2.4390 2.4385	3.00	5.5005 5.5000	1.590	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 4.50 B.C.
AC-2910	3.312-4.467 33 Collets	4.97	2.50	1.11	.56	.68	3.1885 3.1880	3.62	5.5005 5.5000	1.590	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 4.50 B.C.

Short Series

Model	Range	A	B	C	D	E	F	G	H	J	J ¹	K	L
AC-8100	500-.655 10 Collets	1.81	.59	.42	.25	.50	.4702 .4692	.88	3.3755 3.3750	.762	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-8200	.593-.797 20 Collets	1.97	.72	.45	.25	.50	.5796 .5786	1.00	3.3755 3.3750	.781	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-8300	.718-1.000 28 Collets	2.15	.84	.51	.25	.50	.7046 .7036	1.12	3.3755 3.3750	.781	.562	3/8 - 24	Four (4) 3/8 S.H.S. on 2.50 B.C.
AC-8400	.875-1.299 20 Collets	2.35	.94	.59	.18	.56	.8452 .8442	1.38	4.1255 4.1250	1.250	.750	1/2 - 20	Four (4) 1/2 S.H.S. on 3.12 B.C.
AC-8500	1.125-1.642 24 Collets	2.59	1.125	.65	.18	.56	1.0796 1.0786	1.56	4.1255 4.1250	1.250	.750	1/2 - 20	Four (4) 1/2 S.H.S. on 3.12 B.C.
AC-8600	1.468-2.104 30 Collets	2.93	1.22	.83	.12	.68	1.4077 1.4067	1.88	4.8755 4.8750	1.625	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 3.75 B.C.
AC-8700	1.937-2.821 42 Collets	2.98	1.31	.79	.12	.68	1.8452 1.8442	2.38	4.8755 4.8750	1.625	.968	3/4 - 16	Four (4) 1/2 S.H.S. on 3.75 B.C.