



# **FORKARDT HARDINGE**



## **BUCK Chuck Product Catalog**

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# If a Chuck's a Chuck, Then Why a BUCK?



## **Depth. In Experience. In Heritage. In Product.**

How about 75 years. That's how long BUCK Chuck™ Company has engineered and built some of the finest chucks in the world. BUCK Chuck brings the depth of one of the world's most recognized workholding companies. Our legacy lines — the ATSC and AT Adjust-Tru® self-centering manual scroll chucks, as well as our Precision Power Chucks set new standards for quality, affordability and repeatability.

**That's why a BUCK.**

## **Service.**

BUCK Chuck Company has a dedicated team of customer service and sales representatives that have the technical knowledge to help make your BUCK experience as hassle-free as possible. We also work closely with some of the most-recognized industrial products distributors to provide you with the proper solution to any of your chuck needs. It's a commitment we make to each and every one of our customers. **That's why a BUCK.**

## **Price to performance.**

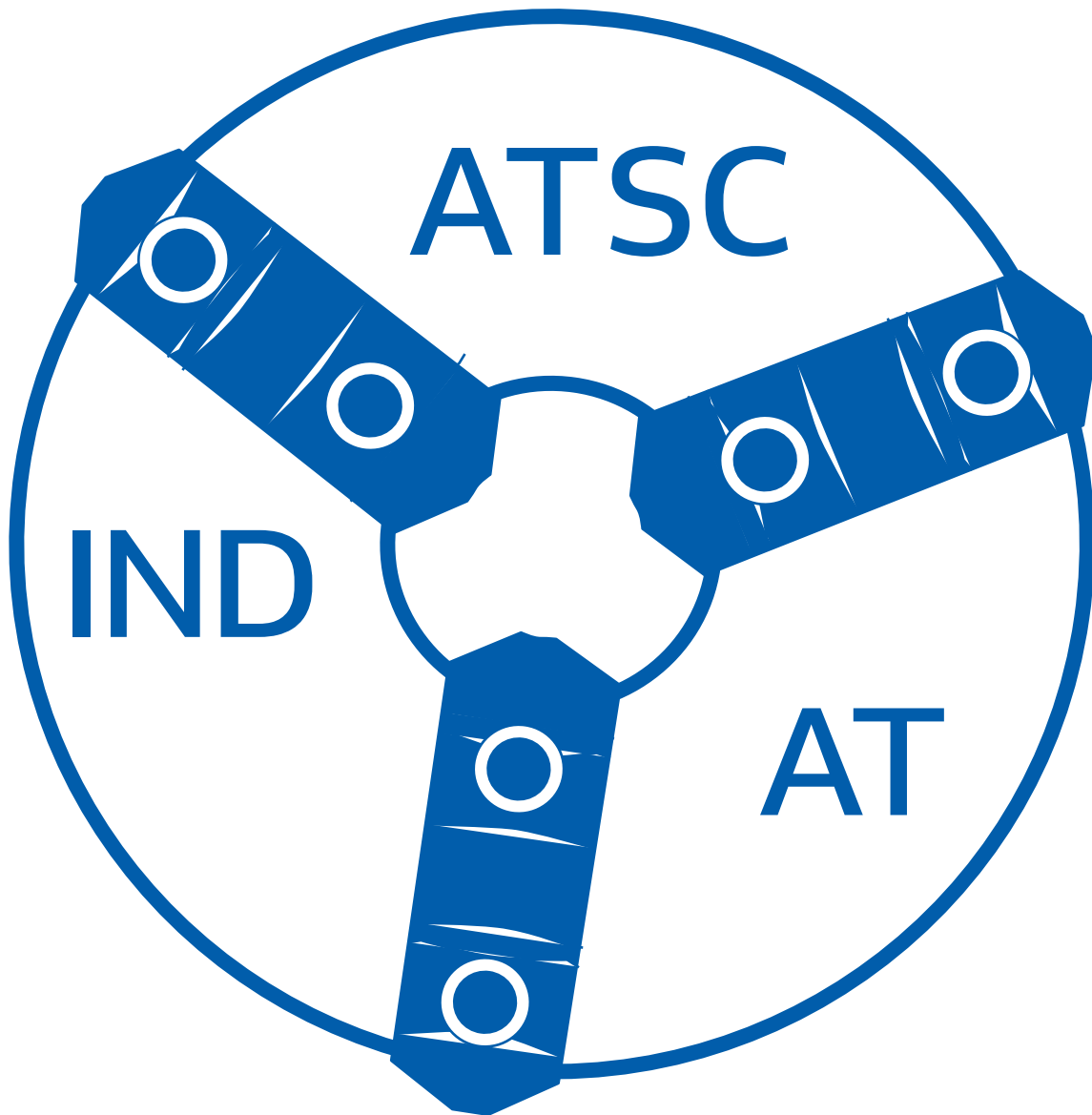
You can buy the cheapest chuck out there and here's what you'll get. You'll get cheap. A chuck that's not as repeatable or as accurate as you need. A chuck that takes too much of your machine operator's time to adjust and true. A chuck that isn't productive. It's the cost of that lost productivity that you need to consider. But not with BUCK Chuck. You'll get the most accurate and repeatable chucks on the market. **That's why a BUCK.**

## **Parts & Accessories.**

Not only does BUCK Chuck Company provide the benchmark in manual chucks, we also offer Power Chucks and Precision Chucks as well. Our chucks come in a variety of sizes and styles and are ideal for replacement of OEM manual and power chucks.

**That's why a BUCK.**

Whatever the workholding need, BUCK can help. **That's why a BUCK.**



# Manual Chuck Selection

ATSC, AT and 4-Jaw Independent



## How do you determine what type of chuck and mounting plate is required for the application?



### ATSC CHUCK APPLICATIONS:

- Precision machining
- Large quantity productions
- Higher RPM needs



### AT CHUCK APPLICATIONS:

- Tool room applications
- Grinding



### 4-JAW INDEPENDENT CHUCK APPLICATIONS:

- Tool room applications
- Grinding
- Odd-shaped parts

## What size of chuck?

- Do not exceed the swing of the diameter over the cross slide. Make sure the part will fit safely and securely within the envelope.

## What accuracy and repeatability is required?

- High precision – the ATSC chucks provide .0005 TIR on duplicate parts
- General I.D. or O.D. work – the AT chucks provide .001 TIR on duplicate parts

## How many jaws are required?

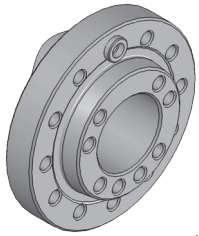
- 2-Jaw – special applications, can be used as a vice, ideal for squares, elbows, T's or other oddly shaped parts
- 3-Jaw – conventional machining, best choice for bar stock, rough castings, or any other parts with small irregularities
- 4-Jaw – square and offset work, can be used as a 2 jaw by removing two opposing jaws
- 6-Jaw – 2nd operation or thin wall parts, can be used as a 2 or 3 jaw chuck by removing jaws

## What type of jaw is needed?

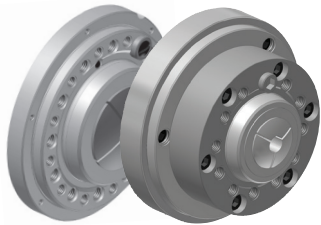
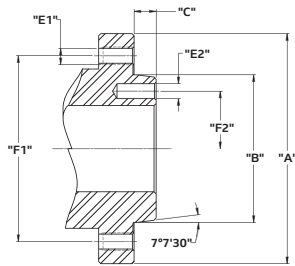
- The most common are the reversible top jaws. These can be used for both I.D. or O.D. work and production work
- 2-piece jaw chucks can be adapted to soft jaws or special top tooling
- Solid jaws are typically used for tool room applications, and due to elimination of top jaw mounting error, are ideal for second operation machining

## What mounting is needed?

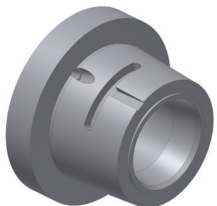
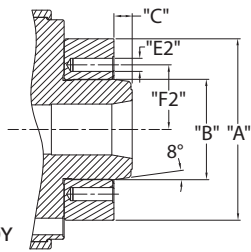
- Determine spindle type using the spindle identifier on page 6
- Measure the major diameter of the taper and match to the chart for the spindle type on page 6
- For threaded spindles, you will need to measure threads per inch



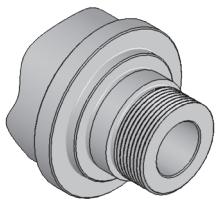
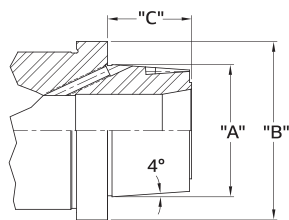
A1 / A2



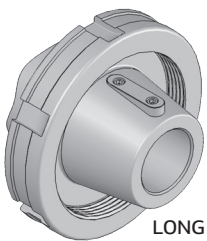
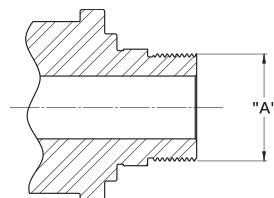
5C COLLET-READY



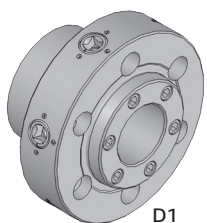
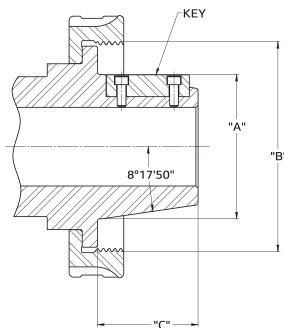
HARDINGE  
4-DEGREE



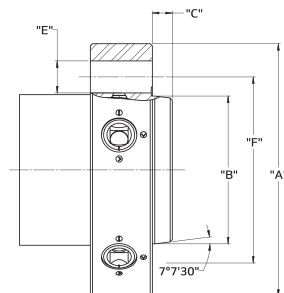
THREADED



LONG  
TAPER



D1  
CAMLOCK



## SPINDLE TYPE A1 & A2

| Spindle nose | A       | B      | C (MAX) | E1 & E2  | F1     | F2     |
|--------------|---------|--------|---------|----------|--------|--------|
| A-4          | 4 1/4"  | 2.500  | 0.437   | 7/16"-14 | 3.250  | -----  |
| A-5          | 5 1/4"  | 3.251  | 0.563   | 7/16"-14 | 4.125  | 2.437  |
| A-6          | 6 1/2"  | 4.188  | 0.625   | 1/2"-13  | 5.250  | 3.250  |
| A-8          | 8 1/4"  | 5.501  | 0.688   | 5/8"-11  | 6.750  | 4.375  |
| A-11         | 11"     | 7.751  | 0.750   | 3/4"-10  | 9.250  | 6.500  |
| A-15         | 15"     | 11.251 | 0.813   | 7/8"-9   | 13.000 | 9.750  |
| A-20         | 20 1/2" | 16.251 | 0.875   | 1"-8     | 18.250 | 14.500 |
| A-28         | 28 1/2" | 23.001 | 1.000   | 1-1/4"-7 | 25.500 | 10.438 |

## 5C COLLET-READY

| Spindle nose | A      | B     | C (MAX) | E2           | F2     |
|--------------|--------|-------|---------|--------------|--------|
| A-4          | 4.560" | 2.500 | 0.460   | M10-1.5x.75  | 1.625  |
| A-5          | 5.500" | 3.251 | 0.500   | M10-1.5x.76  | 2.0625 |
| A-5          | —      | 3.251 | 0.500   | M10-1.5x.75  | 2.0625 |
| A-6          | —      | 4.192 | 0.562   | M12-1.75x.88 | 2.6250 |

## HARDINGE 4 DEGREE SPINDLE

| Spindle nose | A     | B     | C (MAX) |
|--------------|-------|-------|---------|
| 4-Degree     | 2.316 | 3.126 | 1.472   |

## THREADED SPINDLE TYPE

Spindle nose thread  
A

|            |
|------------|
| 1"-8       |
| 1"-10      |
| 1 1/2"-8   |
| 1 3/4"-8   |
| 2 1/4"-8   |
| 2 3/8"-6   |
| 2 3/4"-8   |
| 2 3/16"-10 |

## L SPINDLE TYPE LONG TAPER KEY DRIVE

| Spindle nose | A      | Thread B  | C     | KEY                 |
|--------------|--------|-----------|-------|---------------------|
| L00          | 3 1/2" | 3-3/4"-6  | 2.000 | 3/8 x 3/8 x 1-1/2   |
| L0           | 4 1/8" | 4-1/2"-6  | 2.375 | 3/8 x 3/8 x 1-3/4   |
| L1           | 5 3/4" | 6"-6      | 2.875 | 5/8 x 5/8 x 2-3/8   |
| L2           | 7 3/8" | 7-3/4"-5  | 3.375 | 3/4 x 3/4 x 2-7/8   |
| L3           | 10"    | 10-3/8"-4 | 3.875 | 1.00 x 1.00 x 3-1/4 |

## D1 CAMLOCK SPINDLE TYPE

| Spindle nose | A       | B      | C (MAX) | CAMSTUD<br>DIA "E" | F      |
|--------------|---------|--------|---------|--------------------|--------|
| D1-3         | 3 5/8"  | 2.125  | 0.437   | 9/16               | 2.782  |
| D1-4         | 4 1/4"  | 2.500  | 0.437   | 5/8                | 3.250  |
| D1-5         | 5 3/4"  | 3.251  | 0.500   | 3/4                | 4.125  |
| D1-6         | 7 1/8"  | 4.188  | 0.625   | 7/8                | 5.250  |
| D1-8         | 8 7/8"  | 5.501  | 0.688   | 1                  | 6.750  |
| D1-11        | 11 3/4" | 7.751  | 0.750   | 1-3/16             | 9.250  |
| D1-15        | 15 7/8" | 11.251 | 0.813   | 1-3/8              | 13.000 |

## AT+ MODEL CHUCKS

The chart below refers to the replacement options for the obsolete AT+ model of chucks. The ATSC was designed as a replacement for this chuck – the components are not inter-changeable but the ATSC can be mounted to the existing adapter plate from your AT + chuck.

| AT+ MODELS - SOLID & 2 PIECE JAW |                 |          |                           |
|----------------------------------|-----------------|----------|---------------------------|
| Obsolete Model #                 | Obsolete Part # | Model #  | Direct Replacement Part # |
| 3AT+4                            | A100176977      | 3ATSC04S | B8043S                    |
| 6AT+4                            | A100211977      | 6ATSC04S | B8046S                    |
| 3AT+5                            | A100177977      | 3ATSC05S | B8053S                    |
| 6AT+5                            | A100212977      | 6ATSC05S | B8056S                    |
| 3AT+6                            | A100178977      | 3ATSC06S | B8063S                    |
| 6AT+6                            | A100213977      | 6ATSC06S | B8066S                    |
| 3AT+6R                           | A100178978      | 3ATSC06  | B8063                     |
| 6AT+6R                           | A100213978      | 6ATSC06  | B8066                     |
| 3AT+8                            | A100179977      | 3ATSC08S | B8083S                    |
| 6AT+8                            | A100214977      | 6ATSC08S | B8086S                    |
| 3AT+8R                           | A100179978      | 3ATSC08  | B8083                     |
| 6AT+8R                           | A100214978      | 6ATSC08  | B8086                     |
| 3AT+10                           | A100180977      | 3ATSC10S | B8103S                    |
| 6AT+10                           | A100215977      | 6ATSC10S | B8106S                    |
| 3AT+10R                          | A100180978      | 3ATSC10  | B8103                     |
| 6AT+10R                          | A100215978      | 6ATSC10  | B8106                     |
| 3AT+12                           | A100181977      | 3ATSC12S | B8123S                    |
| 6AT+12                           | A100216977      | 6ATSC12S | B8126S                    |
| 3AT+12R                          | A100181978      | 3ATSC12  | B8123                     |
| 6AT+12R                          | A100216978      | 6ATSC12  | B8126                     |
| 3AT+15R                          | A100182978      | 3ATSC15  | B8153                     |
| 6AT+15R                          | A100217978      | 6ATSC15  | B8156                     |
| 3AT+20R                          | A100225903      | 3ATSC20  | B8203                     |

Internal components not interchangeable between obsolete and replacement models.

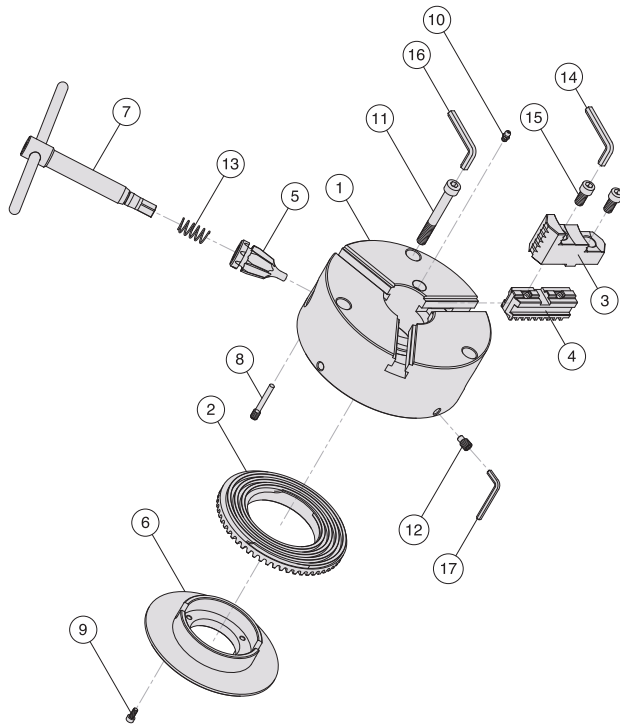
## AT MODEL CHUCKS

The chart below refers to the replacement options for the obsolete AT and BVC model of chucks. The new model of the AT was designed as a replacement for this chuck – the components are not interchangeable, but it can be mounted to the existing adapter plate from your obsolete AT chuck.

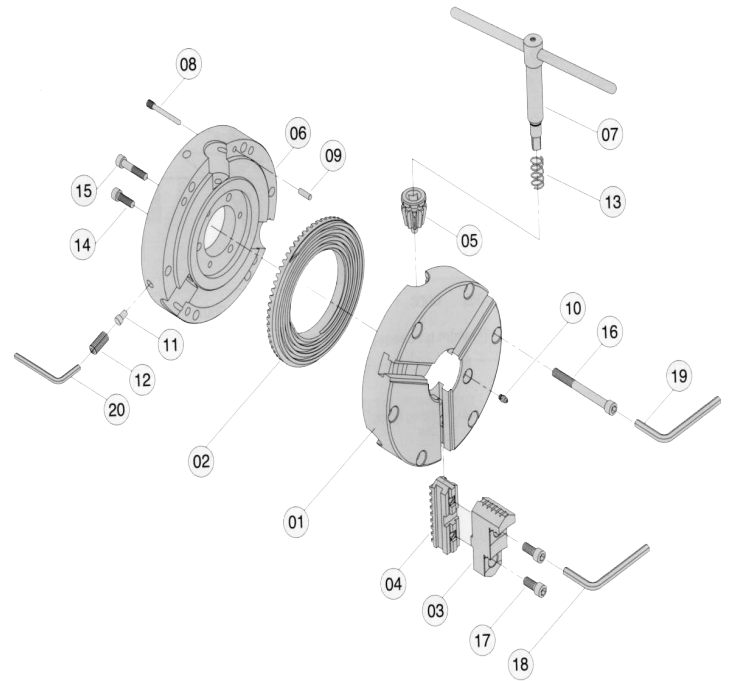
| AT TWO PIECE JAW MODELS |                      |                    |                     |                           |
|-------------------------|----------------------|--------------------|---------------------|---------------------------|
| Obsolete AT Model #     | Obsolete AT Serial # | Obsolete AT Part # | Obsolete BVC Part # | Direct Replacement Part # |
| 3AT6R                   | A0002063002          | 2063R              | B2063R              | AT063RC                   |
| 6AT6R                   | A0002066002          | 2066R              | B2066R              | AT066RC                   |
| 3AT8R                   | A0002083002          | 2083R              | B2083R              | AT083RC                   |
| 6AT8R                   | A0002086002          | 2086R              | B2086R              | AT086RC                   |
| 3AT10R                  | A0002103002          | 2103R              | B2103R              | AT103RC                   |
| 6AT10R                  | A0002106002          | 2106R              | B2106R              | AT106RC                   |
| 3AT12R                  | A0002124002          | 2124R              | B2124R              | AT123RC                   |
| 6AT12R                  | A0002127002          | 2127R              | B2127R              | AT126RC                   |
| 3AT15R                  | A0002154002          | 2154R              | B2154R              | B8153**                   |
| 6AT15R                  | A0002157002          | 2157R              | B2157R              | B8156**                   |

\*\*There is no direct replacement, a new chuck adapter will be needed

| AT/ATSC TWO-PIECE JAW MODELS |                      |                    |                                   |                                |
|------------------------------|----------------------|--------------------|-----------------------------------|--------------------------------|
| Replacement Options          |                      |                    |                                   |                                |
| Obsolete AT Model #          | Obsolete AT Serial # | Obsolete AT Part # | 2 Piece Jaws Use Existing Adapter | Solid Jaws Require New Adapter |
| 3AT4                         | A1434                | 1434               | N/A                               | B8043S                         |
| 6AT4                         | A1462                | 1462               | N/A                               | B8046S                         |
| 3AT5                         | A2535                | 2535               | N/A                               | B8053S                         |
| 6AT5                         | A2562                | 2562               | N/A                               | B8056S                         |
| 3AT6                         | A0002063003          | 3634               | AT063RC                           | B8063S                         |
| 6AT6                         | A0002063003          | 3662               | AT066RC                           | B8066S                         |
| 3AT8                         | A0002083003          | 4831               | AT083RC                           | B8083S                         |
| 6AT8                         | A0002086003          | 4862               | AT086RC                           | B8086S                         |
| 3AT10                        | A0002103003          | 5103               | AT103RC                           | B8103S                         |
| 6AT10                        | A0002106003          | 5106               | AT106RC                           | B8106S                         |
| 3AT12                        | A0002124003          | 5124               | AT123RC                           | B8123S                         |
| 6AT12                        | A0002127003          | 5127               | AT126RC                           | B8126S                         |



| ATSC |                               |
|------|-------------------------------|
| No.  | Part Description              |
| 1    | Chuck Body                    |
| 2    | Scroll Plate                  |
| 3    | Top Jaw                       |
| 4    | Master Jaw                    |
| 5    | Pinion                        |
| 6    | Back Cover                    |
| 7    | Chuck Wrench                  |
| 8    | Stud Bolt                     |
| 9    | Hexagon Socket Head Cap Screw |
| 10   | Grease Nipple                 |
| 11   | Chuck Mounting Bolt           |
| 12   | Adjust Screw                  |
| 13   | Safety Spring                 |
| 14   | Hex Wrench                    |
| 15   | Jaw Mounting Bolt             |
| 16   | Hex Wrench                    |
| 17   | Hex Wrench                    |



| AT  |                               |
|-----|-------------------------------|
| No. | Part Description              |
| 1   | Chuck Body                    |
| 2   | Scroll                        |
| 3   | Top Jaw                       |
| 4   | Master Jaw                    |
| 5   | Pinion                        |
| 6   | Back Cover                    |
| 7   | Chuck Wrench                  |
| 8   | Stud Bolt                     |
| 9   | Hollow Pin                    |
| 10  | Grease Nipple                 |
| 11  | Dowel Pin                     |
| 12  | Adjust Screw                  |
| 13  | Safety Spring                 |
| 14  | Hexagon Socket Head Cap Screw |
| 15  | Hexagon Socket Head Cap Screw |
| 16  | Chuck Mounting Bolt           |
| 17  | Jaw Mounting Bolt             |
| 18  | Hex Wrench                    |
| 19  | Hex Wrench                    |
| 20  | Hex Wrench                    |

# ATSC Forged Steel Body Scroll Chuck

Hardened Reversible Top Jaws

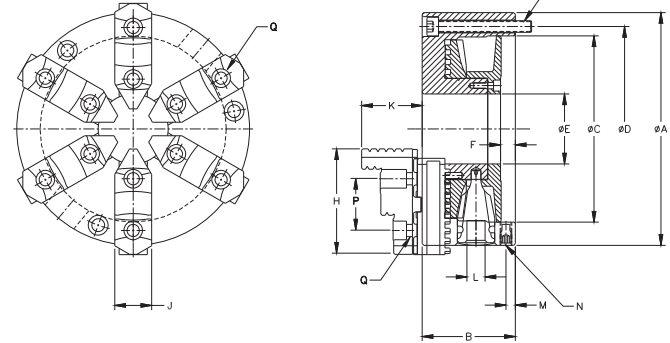
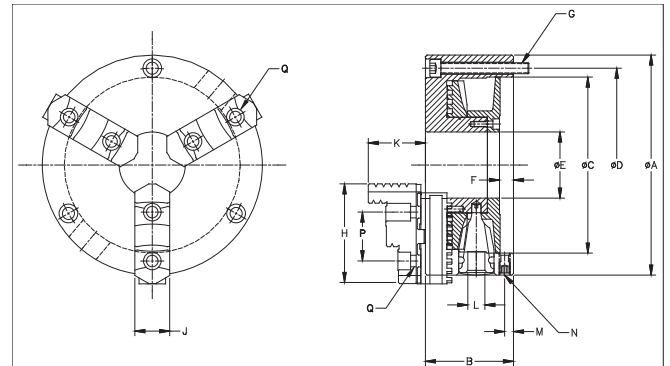


## FEATURES & BENEFITS:

- 4 micro-fine adjustment screws allow .0005" TIR repeatability
- High-quality forged steel body construction allows for higher lathe speeds
- Hardened and ground scroll is precision balanced, allowing longer life and greater accuracy
- Hardened jaws and pinions increase life of the chuck
- American standard tongue & groove master jaws allow for greater flexibility in choice of top tooling

## CHUCK INCLUDES:

- Master and hardened top reversible jaws
- Spring loaded T-wrench
- Allen wrench
- Mounting bolts



### 3-JAW

#### ATSC W/MASTER & HARDENED TOP REVERSIBLE JAWS

| Dia. | Part No. | A     | B    | C     | D     | E    | F    | G         | H    | J    | K    | L     | M    | N         | P    | Q    | Gripping Dia. (in.) |            | Max RPM | Wt. Lb. |
|------|----------|-------|------|-------|-------|------|------|-----------|------|------|------|-------|------|-----------|------|------|---------------------|------------|---------|---------|
|      |          |       |      |       |       |      |      |           |      |      |      |       |      |           |      |      | EXT.                | INT.       |         |         |
| *6"  | B8063    | 6.50  | 2.76 | 4.92  | 5.51  | 1.78 | 0.48 | M10x1.5P  | 2.58 | 1.00 | 1.54 | 23/64 | 0.31 | M10x1.5P  | 1.69 | 5/16 | 0.31-5.51           | 2.17-5.91  | 4600    | 23      |
| 8"   | B8083    | 7.87  | 3.15 | 6.30  | 6.93  | 2.37 | 0.48 | M10x1.5P  | 3.57 | 1.25 | 2.05 | 7/16  | 0.31 | M10x1.5P  | 1.75 | 3/8  | 0.39-7.87           | 2.17-7.09  | 4000    | 37      |
| 10"  | B8103    | 10.04 | 3.58 | 7.87  | 8.82  | 3.23 | 0.50 | M12x1.75P | 3.75 | 1.50 | 2.59 | 31/64 | 0.31 | M10x1.5P  | 2.13 | 1/2  | 0.47-9.45           | 3.35-8.86  | 3000    | 69      |
| 12"  | B8123    | 12.60 | 3.90 | 10.24 | 11.26 | 4.14 | 0.58 | M16x2P    | 4.41 | 1.75 | 2.57 | 9/16  | 0.35 | M12x1.75P | 2.50 | 1/2  | 0.71-11.22          | 4.92-11.22 | 2300    | 110     |
| 15"  | B8153    | 15.74 | 4.96 | 12.99 | 14.25 | 5.51 | 0.59 | M16x2P    | 5.55 | 2.50 | 3.61 | 2/3   | 0.35 | M12x1.75P | 3.00 | 3/4  | 0.79-14.17          | 5.12-14.17 | 1800    | 246     |
| 20"  | B8203    | 19.69 | 5.63 | 16.54 | 18.03 | 7.48 | 0.59 | M16X2P    | 5.55 | 2.50 | 3.61 | 3/4   | 0.35 | M12x1.75P | 3.00 | 3/4  | 1.57-19.69          | 5.12-19.69 | 1300    | 387     |

Measurements in inches unless otherwise indicated. 6" chuck jaws are not ANSI standard. Please note that these are SCROLL chucks. All jaws move together, NOT independently.

### 6-JAW

#### ATSC W/MASTER & HARDENED TOP REVERSIBLE JAWS

| Dia. | Part No. | A     | B    | C     | D     | E    | F    | G         | H    | J    | K    | L     | M    | N         | P    | Q    | Gripping Dia. (in.) |            | Max RPM | Wt. Lb. |
|------|----------|-------|------|-------|-------|------|------|-----------|------|------|------|-------|------|-----------|------|------|---------------------|------------|---------|---------|
|      |          |       |      |       |       |      |      |           |      |      |      |       |      |           |      |      | EXT.                | INT.       |         |         |
| *6"  | B8066    | 6.50  | 2.76 | 4.92  | 5.51  | 1.78 | 0.48 | M10x1.5P  | 2.58 | 1.00 | 1.54 | 23/64 | 0.31 | M10x1.5P  | 1.69 | 5/16 | 0.98-5.51           | 2.95-5.91  | 3450    | 23      |
| 8"   | B8086    | 7.87  | 3.15 | 6.30  | 6.93  | 2.37 | 0.48 | M10x1.5P  | 3.57 | 1.25 | 2.05 | 7/16  | 0.31 | M10x1.5P  | 1.75 | 3/8  | 0.79-7.87           | 2.56-7.09  | 3000    | 40      |
| 10"  | B8106    | 10.04 | 3.58 | 7.87  | 8.82  | 3.23 | 0.50 | M12x1.75P | 3.75 | 1.50 | 2.59 | 31/64 | 0.31 | M10x1.5P  | 2.13 | 1/2  | 0.98-9.45           | 3.54-8.86  | 2250    | 73      |
| 12"  | B8126    | 12.60 | 3.90 | 10.24 | 11.26 | 4.14 | 0.58 | M16x2P    | 4.41 | 1.75 | 2.57 | 9/16  | 0.35 | M12x1.75P | 2.50 | 1/2  | 1.57-11.22          | 4.53-11.22 | 1725    | 117     |
| 15"  | B8156    | 15.75 | 4.96 | 12.99 | 14.25 | 5.51 | 0.59 | M16x2P    | 5.55 | 2.50 | 3.61 | 2/3   | 0.35 | M12x1.75P | 3.00 | 3/4  | 1.57-14.17          | 5.12-14.17 | 1350    | 253     |

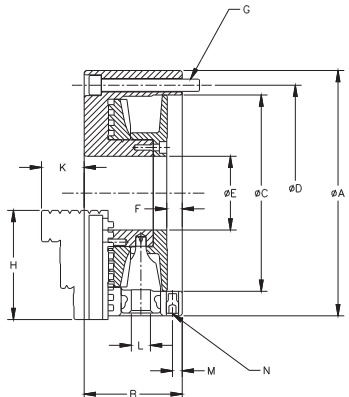
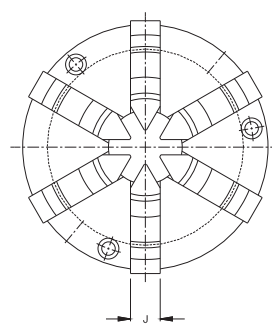
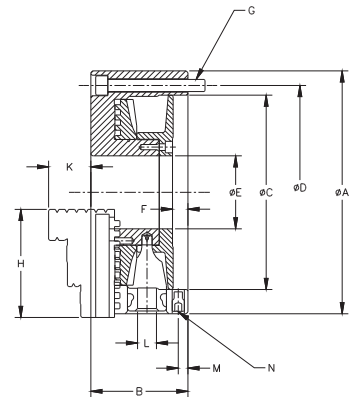
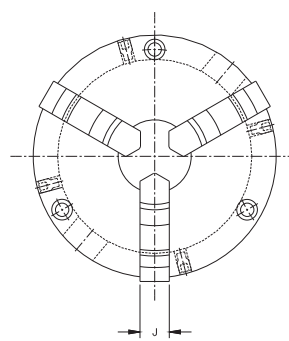
Please note that these are SCROLL chucks. All jaws move together, NOT independently.

## FEATURES & BENEFITS:

- 4 micro-fine adjustment screws allow .0005" TIR repeatability
- High-quality forged steel body construction allows for higher lathe speeds
- Hardened and ground scroll is precision balanced, allowing longer life and greater accuracy
- Hardened jaws and pinions increase life of the chuck
- Hardened solid jaws allow for smaller gripping ranges as opposed to 2-piece jaw chucks

## CHUCK INCLUDES:

- Inside and outside gripping solid jaws
- Spring loaded T-wrench
- Allen wrench
- Mounting bolts



### 3-JAW

#### ATSC W/INSIDE & OUTSIDE SOLID JAWS

| Dia. | Part No. | A     | B    | C     | D     | E    | F    | G         | H    | J    | K    | L     | M    | N         | Gripping Dia. (in.) |           | Max RPM | Wt. Lb. |
|------|----------|-------|------|-------|-------|------|------|-----------|------|------|------|-------|------|-----------|---------------------|-----------|---------|---------|
|      |          |       |      |       |       |      |      |           |      |      |      |       |      |           | EXT.                | INT.      |         |         |
| 4"   | B8043S   | 4.07  | 2.38 | 2.80  | 3.53  | 1.04 | 0.42 | M5x0.8P   | 1.62 | 0.44 | 0.75 | 1/4   | 0.24 | M8x1.25P  | 0.08-2.76           | 0.98-2.95 | 6300    | 9       |
| 5"   | B8053S   | 5.20  | 2.54 | 3.74  | 4.25  | 1.26 | 0.41 | M8x1.25P  | 1.88 | 0.63 | 0.80 | 5/16  | 0.26 | M8x1.25P  | 0.08-3.54           | 1.42-3.74 | 5500    | 13      |
| 6"   | B8063S   | 6.50  | 2.76 | 4.92  | 5.51  | 1.78 | 0.48 | M10x1.5P  | 2.52 | 0.74 | 0.96 | 23/64 | 0.31 | M10x1.5P  | 0.12-5.51           | 2.05-5.71 | 4600    | 23      |
| 8"   | B8083S   | 7.87  | 3.15 | 6.30  | 6.93  | 2.37 | 0.48 | M10x1.5P  | 3.50 | 0.95 | 1.37 | 7/16  | 0.31 | M10x1.5P  | 0.16-6.30           | 2.36-6.69 | 4000    | 39      |
| 10"  | B8103S   | 10.04 | 3.58 | 7.87  | 8.82  | 3.23 | 0.50 | M12x1.75P | 3.62 | 1.23 | 1.83 | 31/64 | 0.31 | M10x1.5P  | 0.24-8.27           | 2.95-8.66 | 3000    | 72      |
| 12"  | B8123S   | 12.60 | 3.90 | 10.24 | 11.26 | 4.14 | 0.58 | M16x2P    | 4.25 | 1.48 | 1.75 | 9/16  | 0.35 | M12x1.75P | 0.39-10.04          | 3.35-9.94 | 2300    | 115     |

### 6-JAW

#### ATSC W/INSIDE & OUTSIDE SOLID JAWS

| Dia. | Part No. | A     | B    | C     | D     | E    | F    | G         | H    | J    | K    | L     | M    | N         | Gripping Dia. (in.) |           | Max RPM | Wt. Lb. |
|------|----------|-------|------|-------|-------|------|------|-----------|------|------|------|-------|------|-----------|---------------------|-----------|---------|---------|
|      |          |       |      |       |       |      |      |           |      |      |      |       |      |           | EXT.                | INT.      |         |         |
| 4"   | B8046S   | 4.07  | 2.36 | 2.80  | 3.53  | 1.04 | 0.42 | M5x0.8P   | 1.62 | 0.41 | 0.75 | 1/4   | 0.24 | M8x1.25P  | 0.08-2.76           | 0.98-2.95 | 4725    | 9       |
| 5"   | B8056S   | 5.20  | 2.54 | 3.80  | 4.25  | 1.28 | 0.41 | M8x1.25P  | 1.88 | 0.63 | 0.80 | 5/16  | 0.26 | M8x1.25P  | 0.08-3.54           | 1.42-3.74 | 4125    | 14      |
| 6"   | B8066S   | 6.50  | 2.76 | 4.92  | 5.51  | 1.78 | 0.48 | M10x1.5P  | 2.52 | 0.74 | 0.96 | 23/64 | 0.31 | M10x1.5P  | 0.24-5.51           | 2.36-5.71 | 3450    | 25      |
| 8"   | B8086S   | 7.87  | 3.15 | 6.30  | 6.93  | 2.37 | 0.48 | M10x1.5P  | 3.50 | 0.95 | 1.37 | 7/16  | 0.31 | M10x1.5P  | 0.39-6.30           | 2.76-6.69 | 3000    | 44      |
| 10"  | B8106S   | 10.04 | 3.58 | 7.87  | 8.82  | 3.23 | 0.50 | M12x1.75P | 3.62 | 1.23 | 1.83 | 31/64 | 0.31 | M10x1.5P  | 0.59-8.27           | 2.76-8.66 | 2600    | 80      |
| 12"  | B8126S   | 12.60 | 3.90 | 10.24 | 11.26 | 4.14 | 0.58 | M16x2P    | 4.25 | 1.48 | 1.75 | 9/16  | 0.35 | M12x1.75P | 0.79-10.04          | 3.35-9.94 | 1725    | 117     |

Measurements in inches unless otherwise indicated. Please note that these are SCROLL chucks. All jaws move together, NOT independently.

# ATSC Forged Steel Body Scroll Chuck

Hardened Reversible Top Jaws

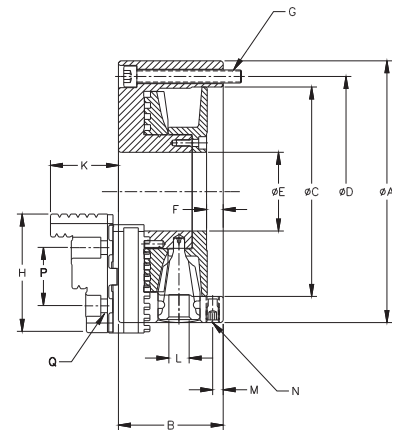
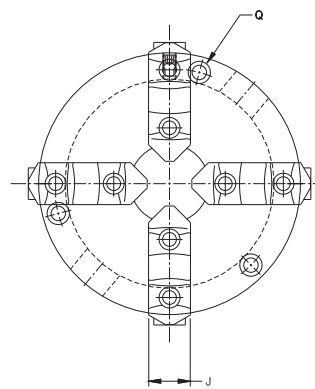


## FEATURES & BENEFITS:

- 4 micro-fine adjustment screws allow .0005" TIR repeatability
- High-quality forged steel body construction allows for higher lathe speeds
- Hardened and ground scroll is precision balanced, allowing longer life and greater accuracy
- Hardened jaws and pinions increase life of the chuck
- American standard tongue & groove master jaws allow for greater flexibility in choice of top tooling

## CHUCK INCLUDES:

- Master and hardened top reversible jaws
- Spring loaded T-wrench
- Allen wrench
- Mounting bolts



6" Chuck Jaws are Not ANSI Standard, 6" Chuck has a 4 Bolt Pattern instead of 3. Please note that these are SCROLL chucks. All jaws move together, NOT independently.

### 4-JAW

#### ATSC W/MASTER & HARDENED TOP REVERSIBLE JAWS

| Dia. | Part No. | A     | B    | C     | D     | E    | F    | G         | H    | J    | K    | L     | M    | N         | P    | Q    | Gripping Dia. (in.) | Max RPM    | Wt. Lb.  |
|------|----------|-------|------|-------|-------|------|------|-----------|------|------|------|-------|------|-----------|------|------|---------------------|------------|----------|
|      |          |       |      |       |       |      |      |           |      |      |      |       |      |           |      |      | EXT.                | INT.       |          |
| 6"   | B8064    | 6.50  | 2.76 | 4.92  | 5.51  | 1.78 | 0.48 | M10x1.5P  | 2.58 | 1.00 | 1.54 | 23/64 | 0.31 | M10x1.5P  | 1.69 | 5/16 | 0.31-5.51           | 2.17-5.91  | 4600 23  |
| 8"   | B8084    | 7.87  | 3.15 | 6.30  | 6.93  | 2.37 | 0.48 | M10x1.5P  | 3.57 | 1.25 | 2.05 | 7/16  | 0.31 | M10x1.5P  | 1.75 | 3/8  | 0.39-7.87           | 2.17-7.09  | 4000 38  |
| 10"  | B8104    | 10.04 | 3.58 | 7.87  | 8.82  | 3.23 | 0.50 | M12x1.75P | 3.75 | 1.50 | 2.59 | 31/64 | 0.31 | M10x1.5P  | 2.13 | 1/2  | 0.47-9.45           | 3.35-8.86  | 3000 71  |
| 12"  | B8124    | 12.60 | 3.90 | 10.24 | 11.26 | 4.14 | 0.58 | M16x2P    | 4.41 | 1.75 | 2.57 | 9/16  | 0.35 | M12x1.75P | 2.50 | 3/4  | 0.71-11.22          | 4.92-11.22 | 2300 130 |



## FEATURES & BENEFITS:

- 4 micro-fine adjustment screws allow .0005" TIR repeatability
- High-quality forged steel body construction allows for higher lathe speeds
- Adapter does not rotate

- Hardened and ground scroll is precision balanced, allowing longer life and greater accuracy
- Hardened jaws and pinions increase life of the chuck
- Used in tail stocks for jobs where centers cannot be used

## CHUCK SHIPS COMPLETE WITH:

- Jaws
- 5C adapter
- Spring loaded T-wrench
- Allen wrench
- Mounting bolts

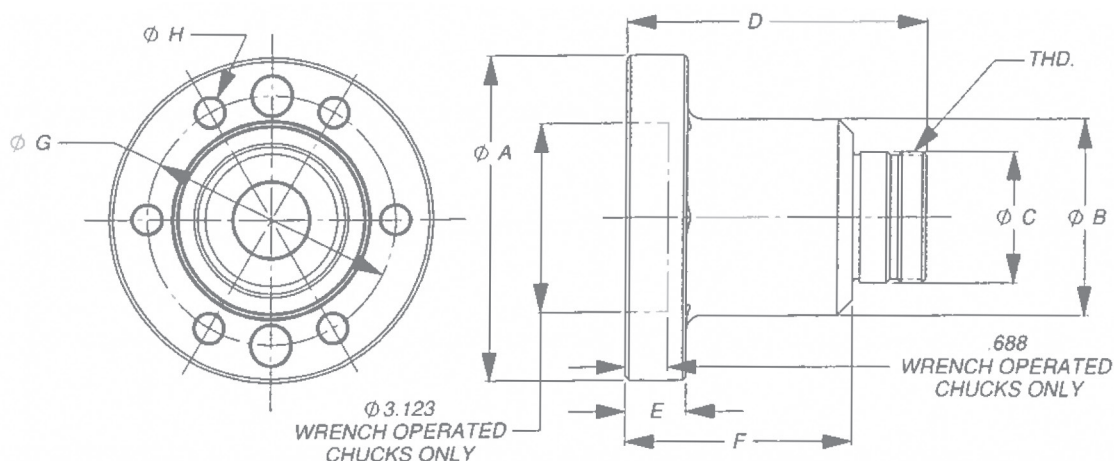
### 3/6-JAW

#### 5C ADAPTED AJUST-TRU® CHUCKS

| Part #    | Jaw Style   | Chuck Dia. (in.) | Chuck Body Height (in.) | Shank | Flange (in.) | Adapter Hole Dia (in.) | Adapter Length (in.) | Thread   |
|-----------|-------------|------------------|-------------------------|-------|--------------|------------------------|----------------------|----------|
| B8043S-5C | Solid 3-Jaw | 4.07             | 2.38                    | 5C    | 4            | 0.866                  | 4.41                 | 1 1/4-20 |
| B8053S-5C | Solid 3-Jaw | 5.20             | 2.54                    | 5C    | 5            | 0.866                  | 4.41                 | 1 1/4-20 |
| B8063S-5C | Solid 3-Jaw | 6.50             | 2.76                    | 5C    | 6            | 0.866                  | 4.41                 | 1 1/4-20 |
| B8046S-5C | Solid 6-Jaw | 4.07             | 2.38                    | 5C    | 4            | 0.866                  | 4.41                 | 1 1/4-20 |
| B8056S-5C | Solid 6-Jaw | 5.20             | 2.54                    | 5C    | 5            | 0.866                  | 4.41                 | 1 1/4-20 |
| B8066S-5C | Solid 6-Jaw | 6.50             | 2.76                    | 5C    | 6            | 0.866                  | 4.41                 | 1 1/4-20 |
| *B8063-5C | 2 pc 3-Jaw  | 6.50             | 2.76                    | 5C    | 6            | 0.866                  | 4.41                 | 1 1/4-20 |
| *B8066-5C | 2 pc 6-Jaw  | 6.50             | 2.76                    | 5C    | 6            | 0.866                  | 4.41                 | 1 1/4-20 |
| *B8064-5C | 2 pc 4-Jaw  | 6.50             | 2.76                    | 5C    | 6            | 0.866                  | 4.41                 | 1 1/4-20 |

Measurements in inches unless otherwise indicated. 6" chuck jaws are not ANSI standard. Please note that these are SCROLL chucks. All jaws move together, NOT independently.

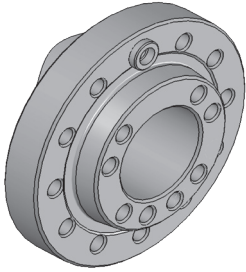
| ATSC W/INSIDE & OUTSIDE SOLID JAWS |                        |             |                   |            |                   |                    |         |         |                 |                        |
|------------------------------------|------------------------|-------------|-------------------|------------|-------------------|--------------------|---------|---------|-----------------|------------------------|
| PART #                             | DESCRIPTION            | MASTER JAWS | HARDENED TOP JAWS | SOFT JAWS  | INSIDE SOLID JAWS | OUTSIDE SOLID JAWS | PINION  | SCROLL  | T-HANDLE WRENCH | FINE ADJUSTMENT SCREWS |
| B8043S                             | 4" 3-JAW SOLID JAWS    | NA          | NA                | NA         | A043ISJ           | A043OSJ            | ATSC04P | ATSC04S | ATSC04W         | AT05FAS                |
| B8046S                             | 4" 6-JAW SOLID JAWS    | NA          | NA                | NA         | A046ISJ           | A046OSJ            | ATSC04P | ATSC04S | ATSC04W         | AT05FAS                |
| B8053S                             | 5" 3-JAW SOLID JAWS    | NA          | NA                | NA         | A053ISJ           | A053OSJ            | ATSC05P | ATSC05S | ATSC05W         | AT05FAS                |
| B8056S                             | 5" 6-JAW SOLID JAWS    | NA          | NA                | NA         | A056ISJ           | A056OSJ            | ATSC05P | ATSC05S | ATSC05W         | AT05FAS                |
| B8063                              | 6" 3-JAW 2 PIECE JAWS  | A063MJ      | A063HTJ           | A06STJ     | NA                | NA                 | ATSC06P | ATSC06S | ATSC06W         | A10FAS                 |
| B8063S                             | 6" 3-JAW SOLID JAWS    | NA          | NA                | NA         | A063ISJ           | A063OSJ            | ATSC06P | ATSC06S | ATSC06W         | A10FAS                 |
| B8064                              | 6" 4-JAW 2 PIECE JAWS  | A064MJ      | A066HTJ           | A06STJ X 2 | NA                | NA                 | ATSC06P | ATSC06S | ATSC06W         | A10FAS                 |
| B8066                              | 6" 6-JAW 2 PIECE JAWSS | A066MJ      | A066HTJ           | A06STJ X 2 | NA                | NA                 | ATSC06P | ATSC06S | ATSC06W         | A10FAS                 |
| B8066S                             | 6" 6-JAW SOLID JAWS    | NA          | NA                | NA         | A066ISJ           | A066OSJ            | ATSC06P | ATSC06S | ATSC06W         | A10FAS                 |
| B8083                              | 8" 3-JAW 2 PIECE JAWS  | A083MJ      | A083HTJ           |            | NA                | NA                 | ATSC08P | ATSC08S | ATSC08W         | A10FAS                 |
| B8083S                             | 8" 3-JAW SOLID JAWS    | NA          | NA                | NA         | A083ISJ           | A083OSJ            | ATSC08P | ATSC08S | ATSC08W         | A10FAS                 |
| B8084                              | 8" 4-JAW 2 PIECE JAWS  | A084MJ      | A084HTJ           | A08STJ X 2 | NA                | NA                 | ATSC08P | ATSC08S | ATSC08W         | A10FAS                 |
| B8086                              | 8" 6-JAW 2 PIECE JAWS  | A086MJ      | A086HTJ           | A08STJ X 2 | NA                | NA                 | ATSC08P | ATSC08S | ATSC08W         | A10FAS                 |
| B8086S                             | 8" 6-JAW SOLID JAWS    | NA          | NA                | NA         | A086ISJ           | A086OSJ            | ATSC08P | ATSC08S | ATSC08W         | A10FAS                 |
| B8103                              | 10" 3-JAW 2 PIECE JAWS | A103MJ      | A103HTJ           | A10STJ     | NA                | NA                 | ATSC10P | ATSC10S | ATSC10W         | A10FAS                 |
| B8103S                             | 10" 3-JAW SOLID JAWS   | NA          | NA                | NA         | A103ISJ           | A103OSJ            | ATSC10P | ATSC10S | ATSC10W         | A10FAS                 |
| B8104                              | 10" 4-JAW 2 PIECE JAWS | A104MJ      | A106HTJ           | A10STJ X 2 | NA                | NA                 | ATSC10P | ATSC10S | ATSC10W         | A10FAS                 |
| B8106                              | 10" 6-JAW 2 PIECE JAWS | A106MJ      | A106HTJ           | A10STJ X 2 | NA                | NA                 | ATSC10P | ATSC10S | ATSC10W         | A10FAS                 |
| B8106S                             | 10" 6-JAW SOLID JAWS   | NA          | NA                | NA         | A106ISJ           | A106OSJ            | ATSC10P | ATSC10S | ATSC10W         | A10FAS                 |
| B8123                              | 12" 3-JAW 2 PIECE JAWS | A123MJ      | A123HTJ           | A12STJ     | NA                | NA                 | ATSC12P | ATSC12S | ATSC12W         | AT08FAS                |
| B8123S                             | 12" 3-JAW SOLID JAWS   | NA          | NA                | NA         | A123ISJ           | A123OSJ            | ATSC12P | ATSC12S | ATSC12W         | AT08FAS                |
| B8124                              | 12" 4-JAW 2 PIECE JAWS | A124MJ      | A126HTJ           | A12STJ X 2 | NA                | NA                 | ATSC12P | ATSC12S | ATSC12W         | AT08FAS                |
| B8126                              | 12" 6-JAW 2 PIECE JAWS | A126MJ      | A126HTJ           | A12STJ X 2 | NA                | NA                 | ATSC12P | ATSC12S | ATSC12W         | AT08FAS                |
| B8126S                             | 12" 6-JAW SOLID JAWS   | NA          | NA                | NA         | A126ISJ           | A126OSJ            | ATSC12P | ATSC12S | ATSC12W         | AT08FAS                |
| B8153                              | 15" 3-JAW 2 PIECE JAWS | A153MJ      | A153HTJ           | A15STJ     | NA                | NA                 | ATSC15P | ATSC15S | ATSC15W         | AT08FAS                |
| B8156                              | 15" 6-JAW 2 PIECE JAWS | A156MJ      | A156HTJ           | AT5STJ X 2 | NA                | NA                 | ATSC15P | ATSC15S | ATSC15W         | AT08FAS                |
| B8203                              | 20" 3-JAW 2 PIECE JAWS | A203MJ      | A203HTJ           | A20STJ     | NA                | NA                 | ATSC20P | ATSC20S | ATSC20W         | AT08FAS                |



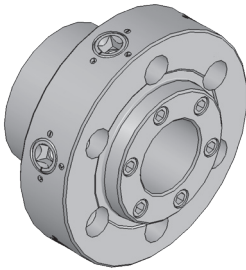
| WRENCH OPERATED COLLET CHUCK |         |       |       |       |       |       |       |       |       |           |
|------------------------------|---------|-------|-------|-------|-------|-------|-------|-------|-------|-----------|
| TYPE                         | PC. NO. | A     | B     | C     | D     | E     | F     | G     | H     | THD.      |
| 5C                           | 72125   | 5.950 | 2.625 | 2.210 | 4.719 | 2.625 | 3.516 | 5.343 | 0.344 | –         |
| 5C                           | 72125-2 | 5.950 | 2.625 | 2.188 | 4.719 | 2.625 | 3.500 | 5.343 | 0.344 | 2 3/16-10 |
| 16C                          | 72149   | 5.950 | 3.312 | –     | 5.719 | 2.750 | –     | 5.343 | 0.344 | –         |
| 3J                           | 72160   | 5.950 | 3.344 | –     | 5.156 | 2.625 | –     | 5.343 | 0.344 | –         |
| 22J                          | 73050   | 5.950 | 3.906 | –     | 5.344 | 2.625 | –     | 5.343 | 0.344 | –         |

| BUCK Part #  |                          |                    |
|--------------|--------------------------|--------------------|
| B721255C     | 5C collet                |                    |
| B721255CTHD  | 5C collet / step chucks  | 2-3/16" 10 spindle |
| B7214916C    | 16C collet               |                    |
| B7214916CA25 | 16C collet / step chucks | A2-5 spindle       |
| B721603J     | 3J collet                |                    |
| B7305022J    | 22J collet               |                    |

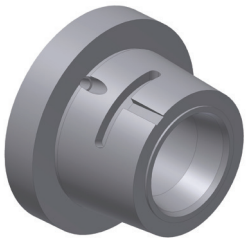
|           |                    |  |
|-----------|--------------------|--|
| BAS301A24 | A2-4 adapter plate |  |
| BAS302A25 | A2-5 adapter plate |  |
| BAS303A26 | A2-6 adapter plate |  |
| BAS336A28 | A2-8 adapter plate |  |
| BCD203D3  | D1-3 adapter plate |  |
| BCD201D4  | D1-4 adapter plate |  |
| BCD202D5  | D1-5 adapter plate |  |
| BCD206D6  | D1-6 adapter plate |  |
| BCD247D8  | D1-8 adapter plate |  |



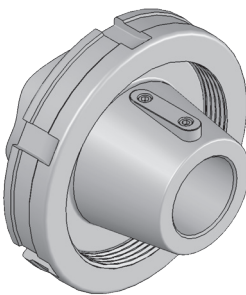
| AMERICAN STANDARD • STYLE A1 & A2 |            |       |       |       |        |         |         |         |
|-----------------------------------|------------|-------|-------|-------|--------|---------|---------|---------|
| Spindle Size                      | Chuck Size |       |       |       |        |         |         |         |
|                                   | 4          | 5     | 6     | 8     | 10     | 12      | 15      | 20      |
| 3                                 | A4-A3      | A5-A3 | A6-A3 | -     | -      | -       | -       | -       |
| 4                                 | -          | A5-A4 | A6-A4 | A8-A4 | -      | -       | -       | -       |
| 5                                 | -          | A5-A5 | A6-A5 | A8-A5 | A10-A5 | -       | -       | -       |
| 6                                 | -          | -     | A6-A6 | A8-A6 | A10-A6 | A12-A6  | -       | -       |
| 8                                 | -          | -     | A6-A8 | A8-A8 | A10-A8 | A12-A8  | A15-A8  | A20-A8  |
| 11                                | -          | -     | -     | -     | -      | A12-A11 | A15-A11 | A20-A11 |
| 15                                | -          | -     | -     | -     | -      | -       | -       | A20-A15 |



| AMERICAN STANDARD • STYLE D1 CAMLOCK |            |       |       |       |        |         |         |         |
|--------------------------------------|------------|-------|-------|-------|--------|---------|---------|---------|
| Spindle Size                         | Chuck Size |       |       |       |        |         |         |         |
|                                      | 4          | 5     | 6     | 8     | 10     | 12      | 15      | 20      |
| 3                                    | A4-D3      | A5-D3 | A6-D3 | A8-D3 | -      | -       | -       | -       |
| 4                                    | -          | A5-D4 | A6-D4 | A8-D4 | A10-D4 | -       | -       | -       |
| 5                                    | -          | -     | A6-D5 | A8-D5 | A10-D5 | -       | -       | -       |
| 6                                    | -          | -     | A6-D6 | A8-D6 | A10-D6 | A12-D6  | -       | -       |
| 8                                    | -          | -     | A6-D8 | A8-D8 | A10-D8 | A12-D8  | A15-D8  | -       |
| 11                                   | -          | -     | -     | -     | -      | A12-D11 | A15-D11 | A20-D11 |
| 15                                   | -          | -     | -     | -     | -      | -       | -       | A20-D15 |



| HARDINGE 4-DEGREE TAPER MOUNTING PLATES |         |         |
|-----------------------------------------|---------|---------|
| Chuck Size                              | 5       | 6       |
| Id #                                    | A5-4DEG | A6-4DEG |

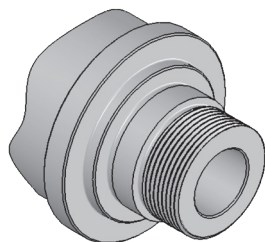


| AMERICAN STANDARD • LONG TAPER STYLE L |            |        |         |        |        |        |
|----------------------------------------|------------|--------|---------|--------|--------|--------|
| Spindle Size                           | Chuck Size |        |         |        |        |        |
|                                        | 6          | 8      | 10      | 12     | 15     | 20     |
| L-00                                   | A6-L00     | A8-L00 | A10-L00 | -      | -      | -      |
| L-0                                    | A6-L0      | A8-L0  | A10-L0  | A12-L0 | -      | -      |
| L-1                                    | -          | A8-L1  | A10-L1  | A12-L1 | A15-L1 | A20-L1 |
| L-2                                    | -          | -      | -       | A12-L2 | A15-L2 | A20-L2 |
| L-3                                    | -          | -      | -       | -      | A15-L3 | A20-L3 |

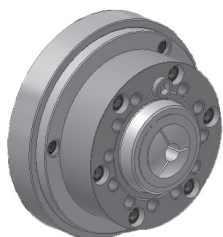
Buck Chuck can also custom design adapter plates.  
See Spindle Identification on page 6 to determine the correct mounting plate needed.

# ATSC Scroll Chuck Mounting Plates

Adapt to all 3, 6 & 4-Jaw ATSC Models

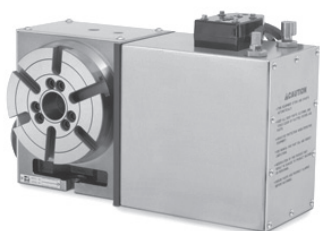


| THREADED MOUNTING PLATES |            |            |            |            |            |    |
|--------------------------|------------|------------|------------|------------|------------|----|
| Spindle Size             | Chuck Size |            |            |            |            |    |
|                          | 4          | 5          | 6          | 8          | 10         | 12 |
| 1-1/2"-8                 | A100433000 | A100434000 | A100435000 | –          | –          | –  |
| 1-3/4"-8                 | –          | A100437000 | A100438000 | –          | –          | –  |
| 2-1/4"-8                 | –          | –          | A100439000 | A100440000 | A100441000 | –  |
| 2-3/16"-10               | –          | A100451000 | A100452000 | –          | –          | –  |



| 5C MOUNTING PLATES |          |       |        |           |        |          |
|--------------------|----------|-------|--------|-----------|--------|----------|
| Chuck Size         | Part No. | Shank | Flange | Hole Dia. | Length | Thread   |
| 4                  | A04-5C   | 5C    | 4"     | 0.866     | 4.41   | 1 1/4-20 |
| 5                  | A05-5C   | 5C    | 5"     | 0.866     | 4.41   | 1 1/4-20 |
| 6                  | A06-5C   | 5C    | 6"     | 0.866     | 4.41   | 1 1/4-20 |

Measurements in inches unless otherwise indicated. See Spindle Identification on page 6 to determine the correct mounting plate needed.



| HRT ROTARY TABLE PLATES |            |             |
|-------------------------|------------|-------------|
| Spindle                 | Chuck Size | Part Number |
| HRT110                  | 4"         | A4-HRT110   |
| HRT160                  | 6"         | A6-HRT160   |
| HRT210                  | 8"         | A8-HRT210   |
| HRT310                  | 10"        | A10-HRT310  |

Buck Chuck can also custom design adapter plates. Adapters available for other Rotary Table models.



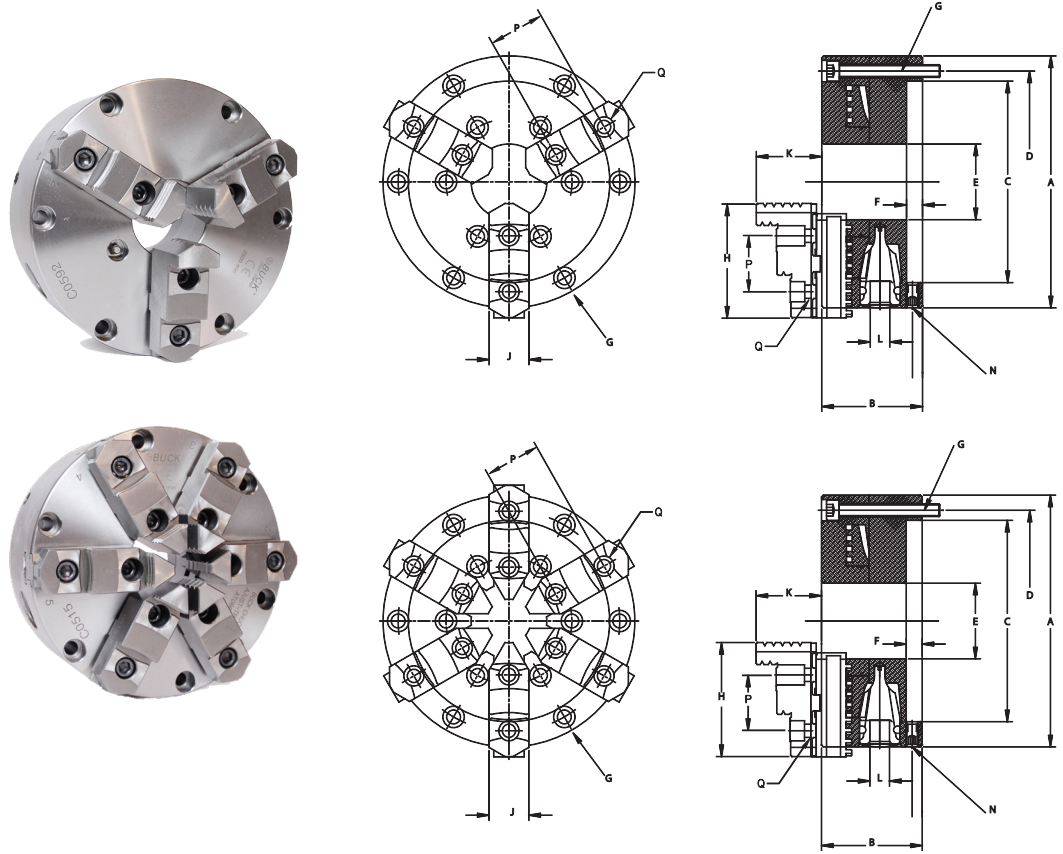
ALL BUCK HRT ADAPTER PLATES ARE MADE IN THE USA!

## FEATURES & BENEFITS:

- .001" repeatability on duplicate parts due to .020" of clearance between the chuck cavity and mounting plate hub
- Cast iron body allows for a more affordable but high quality chuck
- Hardened and ground scroll is balanced for higher accuracy
- Jaws are hardened and ground for longer life

## CHUCK INCLUDES:

- Master and hardened top reversible jaws
- Spring loaded T-wrench
- Mounting bolts



### 3-JAW

#### AT HARDENED TOP REVERSIBLE JAWS

| Dia. | Part No. | A     | B    | C    | D    | E    | F    | G       | H    | J    | K    | L     | N         | P    | Q    | Gripping Dia. (in) |            | Max RPM | Wt. lb. |
|------|----------|-------|------|------|------|------|------|---------|------|------|------|-------|-----------|------|------|--------------------|------------|---------|---------|
|      |          |       |      |      |      |      |      |         |      |      |      |       |           |      |      | EXT.               | INT.       |         |         |
| 5"   | AT053RC  | 5.00  | 2.20 | 2.38 | 4.44 | 1.30 | 0.66 | 1/4-20  | 2.11 | 0.79 | 1.56 | 5/16  | M12X1.75P | 1.25 | 5/16 | 0.12-5.00          | 1.58-4.72  | 3300    | 15      |
| 6"   | AT063RC  | 6.30  | 2.76 | 3.13 | 5.34 | 1.69 | 0.69 | 1/4-20  | 2.58 | 1.00 | 1.54 | 23/64 | M12X1.75P | 1.69 | 5/16 | 0.32-6.30          | 2.16-5.71  | 3000    | 18      |
| 8"   | AT083RC  | 8.27  | 3.36 | 4.75 | 7.50 | 2.29 | 0.75 | 3/8-16  | 3.57 | 1.25 | 2.05 | 7/16  | M12X1.75P | 1.75 | 3/8  | 0.39-8.27          | 2.17-7.48  | 2500    | 46      |
| 10"  | AT103RC  | 9.84  | 3.82 | 6.39 | 4.42 | 3.00 | 0.80 | 7/16-14 | 3.75 | 1.50 | 2.58 | 15/32 | M12X1.75P | 2.13 | 1/2  | 0.47-9.84          | 3.35-9.06  | 2000    | 72      |
| 12"  | AT123RC  | 12.20 | 3.98 | 7.91 | 5.25 | 4.06 | 0.80 | 1/2-13  | 4.41 | 1.75 | 2.56 | 35/64 | M12X1.75P | 2.50 | 1/2  | 0.70-12.20         | 4.92-10.83 | 1500    | 118     |

Measurements in inches unless otherwise indicated. . 6" jaws are not ANSI Standard- please contact us for details.

Use inner bolt circle for 10" to 15" chuck sizes. Please note that these are SCROLL chucks. All jaws move together, NOT independently.

### 6-JAW

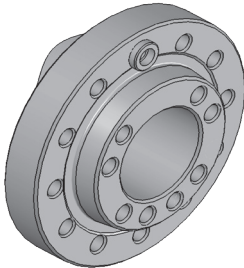
#### AT HARDENED TOP REVERSIBLE JAWS

| Dia. | Part No. | A     | B    | C    | D    | E    | F    | G       | H    | J    | K    | L     | N         | P    | Q    | Gripping Dia. (in) |             | Max RPM | Wt. lb. |
|------|----------|-------|------|------|------|------|------|---------|------|------|------|-------|-----------|------|------|--------------------|-------------|---------|---------|
|      |          |       |      |      |      |      |      |         |      |      |      |       |           |      |      | EXT.               | INT.        |         |         |
| 6"   | AT066RC  | 6.30  | 2.76 | 3.13 | 5.34 | 1.69 | 0.69 | 1/4-20  | 2.58 | 1.00 | 1.54 | 23/64 | M12X1.75P | 1.69 | 5/16 | 0.98-6.30          | 2.95-5.71   | 1600    | 19      |
| 8"   | AT086RC  | 8.27  | 3.36 | 4.75 | 7.50 | 2.29 | 0.75 | 3/8-16  | 3.57 | 1.25 | 2.05 | 7/16  | M12X1.75P | 1.75 | 3/8  | 0.78-8.27          | 2.56-7.48   | 1600    | 50      |
| 10"  | AT106RC  | 9.84  | 3.82 | 6.39 | 4.42 | 3.00 | 0.80 | 7/16-14 | 3.75 | 1.50 | 2.58 | 15/32 | M12X1.75P | 2.13 | 1/2  | 0.47-9.84          | 3.54-9.06   | 1600    | 70      |
| 12"  | AT126RC  | 12.20 | 3.98 | 7.91 | 5.25 | 4.06 | 0.80 | 1/2-13  | 4.41 | 1.75 | 2.56 | 35/64 | M12X1.75P | 2.50 | 1/2  | 1.57-12.20         | 4.53-10.831 | 1100    | 116     |

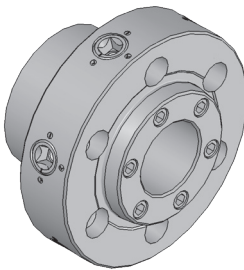
Please note that these are SCROLL chucks. All jaws move together, NOT independently.

# AT Scroll Chuck Mounting Plates

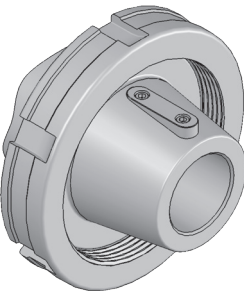
Adapt to all Current and Previous AT Models



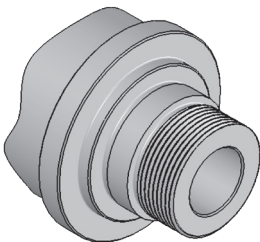
| AMERICAN STANDARD • STYLE A1 & A2 |            |       |        |         |
|-----------------------------------|------------|-------|--------|---------|
| Spindle Size                      | Chuck Size |       |        |         |
|                                   | 6          | 8     | 10     | 12      |
| A-5                               | B6-A5      | B8-A5 | B10-A5 | –       |
| A-6                               | B6-A6      | B8-A6 | B10-A6 | B12-A6  |
| A-8                               | –          | B8-A8 | B10-A8 | B12-A8  |
| A-11                              | –          | –     | –      | B12-A11 |



| AMERICAN STANDARD • STYLE D1 CAMLOCK |            |       |        |         |
|--------------------------------------|------------|-------|--------|---------|
| Spindle Size                         | Chuck Size |       |        |         |
|                                      | 6          | 8     | 10     | 12      |
| D-3                                  | B6-D3      | –     | –      | –       |
| D-4                                  | B6-D4      | B8-D4 | B10-D4 | –       |
| D-5                                  | B6-D5      | B8-D5 | B10-D5 | B12-D5  |
| D-6                                  | B6-D6      | B8-D6 | B10-D6 | B12-D6  |
| D-8                                  | –          | B8-D8 | B10-D8 | B12-D8  |
| D-11                                 | –          | –     | –      | B12-D11 |

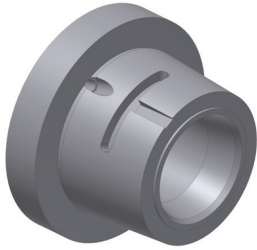


| AMERICAN STANDARD • LONG TAPER STYLE L |            |       |        |        |
|----------------------------------------|------------|-------|--------|--------|
| Spindle Size                           | Chuck Size |       |        |        |
|                                        | 6          | 8     | 10     | 12     |
| L-0                                    | B6-L0      | B8-L0 | B10-L0 | B12-L0 |
| L-1                                    | –          | –     | B10-L1 | B12-L1 |
| L-2                                    | –          | –     | –      | B12-L2 |



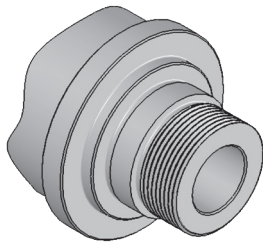
| THREADED MOUNTING PLATES |        |        |    |    |
|--------------------------|--------|--------|----|----|
| Spindle Size             |        |        |    |    |
|                          | 6      | 8      | 10 | 12 |
| 1-1/2"-8                 | AT-950 | –      | –  | –  |
| 1-3/4"-8                 | AT-951 | –      | –  | –  |
| 2-1/4"-8                 | AT-955 | AT-978 | –  | –  |

Buck Chuck can also custom design adapter plates. Adapters available for other Rotary Table models.



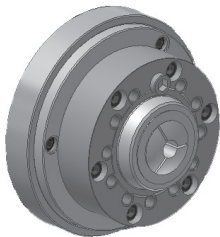
## HARDINGE 4 DEGREE TAPER MOUNTING PLATES

|            |      |
|------------|------|
| Chuck Size | 6"   |
| Id #       | B6-4 |



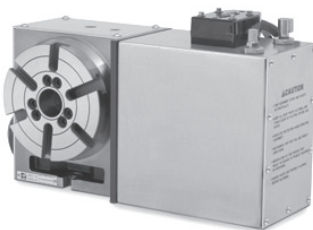
## HARDINGE 2 3/16"-10 THREADED MOUNTING PLATES

|            |               |
|------------|---------------|
| Chuck Size | 6"            |
| Id #       | B6-2 3/16"-10 |



## 5C MOUNTING PLATE

| Chuck Size | Part No. | Shank | (D) Flange | Hole Dia. | Length | Thread     |
|------------|----------|-------|------------|-----------|--------|------------|
| 6"         | B6-5C    | 5C    | 6"         | 0.866     | 4.41   | 1.24" x 20 |



## HRT ROTARY TABLE PLATES

| Spindle | Chuck Size | Part Number |
|---------|------------|-------------|
| HRT160  | 6"         | B6-HRT160   |
| HRT210  | 8"         | B8-HRT210   |
| HRT310  | 10"        | B10-HRT310  |

Buck Chuck can also custom design adapter plates.  
Adapters available for other Rotary Table models.

# AT Scroll Chuck Mounting Plates

## Part List



| PART #  | DESCRIPTION            | MASTER JAWS | HARDENED TOP JAWS | SOFT JAWS  | INSIDE SOLID JAWS | OUTSIDE SOLID JAWS | PINION | SCROLL | T-HANDLE WRENCH | FINE ADJUSTMENT SCREWS |
|---------|------------------------|-------------|-------------------|------------|-------------------|--------------------|--------|--------|-----------------|------------------------|
| AT063RC | 6" 3-JAW 2 PIECE JAWS  | A063MJ      | A063HTJ           | A06STJ     | NA                | NA                 | AT06P  | AT06S  | AT06W           | AT08FAS                |
| AT066RC | 6" 6-JAW 2 PIECE JAWS  | A066MJ      | A066HTJ           | A06STJ X 2 | NA                | NA                 | AT06P  | AT06S  | AT06W           | AT08FAS                |
| AT083RC | 8" 3-JAW 2 PIECE JAWS  | A083MJ      | A083HTJ           | A08STJ     | NA                | NA                 | AT08P  | AT08S  | AT08W           | AT08FAS                |
| AT086RC | 8" 6-JAW 2 PIECE JAWS  | A086MJ      | A083HTJ           | A08STJ X 2 | NA                | NA                 | AT08P  | AT08S  | AT08W           | AT08FAS                |
| AT103RC | 10" 3-JAW 2 PIECE JAWS | A103MJ      | A103HTJ           | A10STJ     | NA                | NA                 | AT10P  | AT10S  | AT10W           | AT08FAS                |
| AT106RC | 10" 6-JAW 2 PIECE JAWS | A106MJ      | A106HTJ           | A10STJ X 2 | NA                | NA                 | AT10P  | AT10S  | AT10W           | AT08FAS                |
| AT123RC | 12" 3-JAW 2 PIECE JAWS | A123MJ      | A123HTJ           | A12STJ     | NA                | NA                 | AT12P  | AT12S  | AT12W           | AT08FAS                |
| AT126RC | 12" 6-JAW 2 PIECE JAWS | A126MJ      | A126HTJ           | A12STJ X 2 | NA                | NA                 | AT12P  | AT12S  | AT12W           | AT08FAS                |



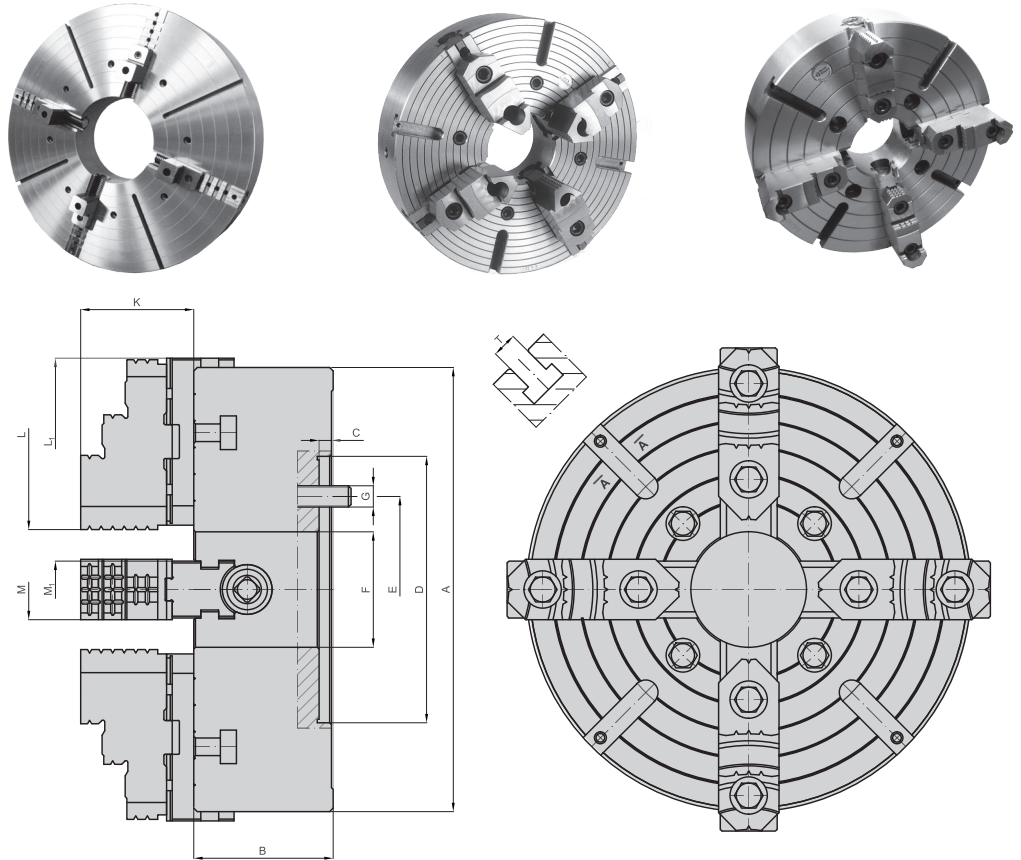
ALL BUCK HRT ADAPTER  
PLATES ARE MADE IN THE USA!

## FEATURES & BENEFITS:

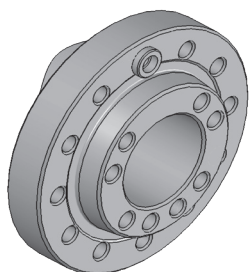
- Forged steel body
- Heavy-duty
- Four independently moving jaws allow for gripping irregular shapes
- Adapter plates are available to fit most common spindles
- 5" and 6" available with solid jaws only
- 8" through 20" available with two piece jaws only. All sizes available in solid jaw

## CHUCK INCLUDES:

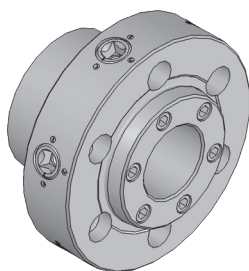
- One set of hard top jaws and master jaws or
- One set of solid reversible jaws
- One T-handle wrench
- Eye bolt for 16" and 20" chucks
- 10" to 20" chucks are provided with T-Slots



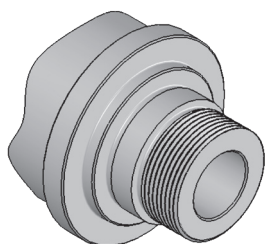
| Dimensions                    | Chuck Size inch (millimeter) |               |               |               |                |                |                |
|-------------------------------|------------------------------|---------------|---------------|---------------|----------------|----------------|----------------|
|                               | IND1005T                     | IND1006ST     | IND1008RT     | IND1010RT     | IND1012RT      | IND1016RT      | IND1020RT      |
| A                             | 5.12 (130.04)                | 6.14 (155.96) | 7.87 (199.90) | 9.84 (249.94) | 12.40 (314.96) | 15.75 (400.05) | 19.68 (499.87) |
| B                             | 1.69 (42.93)                 | 1.69 (42.93)  | 2.85 (72.39)  | 3.09 (78.49)  | 3.42 (86.87)   | 3.62 (91.95)   | 4.21 (106.93)  |
| C                             | 0.10 (2.54)                  | 0.10 (2.54)   | 0.19 (4.83)   | 0.27 (6.86)   | 0.27 (6.86)    | 0.39 (9.91)    | 0.47 (11.94)   |
| D                             | 2.75 (69.85)                 | 3.25 (82.55)  | 4.33 (109.98) | 5.90 (149.86) | 6.89 (175.01)  | 7.87 (199.90)  | 10.63 (270)    |
| E                             | 2.12 (53.85)                 | 2.75 (69.85)  | 3.25 (82.55)  | 4.12 (104.65) | 5.25 (133.35)  | 6.75 (171.45)  | 9.25 (234.95)  |
| F                             | 1.02 (25.91)                 | 1.65 (41.91)  | 1.97 (50.04)  | 2.56 (65.02)  | 3.15 (80.01)   | 3.93 (99.82)   | 4.92 (124.97)  |
| G                             | 4xM8                         | 4xM10         | 4xM10         | 4xM12         | 4xM16          | 4xM16          | 4xM20          |
| K                             | 0.78 (19.81)                 | 0.78 (19.81)  | 1.82 (46.23)  | 2.38 (60.45)  | 2.40 (60.96)   | 2.84 (72.14)   | 3.85 (97.79)   |
| L                             | 2.01 (51.05)                 | 2.01 (51.05)  | 3.23 (82.04)  | 3.80 (96.52)  | 4.43 (112.52)  | 5.08 (129.03)  | 5.35 (135.89)  |
| L1                            | _____                        | _____         | 3.11 (78.99)  | 3.70 (93.98)  | 4.33 (109.98)  | 5.08 (129.03)  | 6.61 (167.89)  |
| M                             | 0.63 (16)                    | 0.63 (16)     | 1.34 (34.04)  | 1.34 (34.04)  | 1.65 (41.91)   | 1.65 (41.91)   | 2.12 (53.85)   |
| M1                            | _____                        | _____         | 1.26 (32)     | 1.26 (32)     | 1.57 (39.88)   | 1.57 (39.88)   | 2.04 (51.82)   |
| T                             | _____                        | _____         | _____         | 0.55 (13.97)  | 0.71 (18.03)   | 0.71 (18.03)   | 0.86 (21.84)   |
| Weight [lbs]                  | 10.5                         | 11.0          | 37.5          | 57.5          | 105.5          | 187            | 330            |
| RPM max.                      | 3500                         | 3200          | 2500          | 2000          | 1500           | 1100           | 700            |
| Clamping Range Min - Max [in] | 0.31 - 4.92                  | 0.31 - 6.30   | 0.39 - 7.87   | 0.39 - 9.84   | 0.59 - 12.40   | 0.79 - 15.75   | 1.77 - 19.69   |



| AMERICAN STANDARD • STYLE A1 & A2 |            |           |            |            |            |             |    |
|-----------------------------------|------------|-----------|------------|------------|------------|-------------|----|
| Spindle Size                      | Chuck Size |           |            |            |            |             |    |
|                                   | 6          | 8         | 10         | 12         | 16         | 20          | 25 |
| 5                                 | INDF6-A5T  | INDF8-A5T | –          | –          | –          | –           | –  |
| 6                                 | –          | INDF8-A6T | INDF10-A6T | INDF12-A6T | INDF16-A6T | –           | –  |
| 8                                 | –          | –         | INDF10-A8T | INDF12-A8T | INDF16-A8T | INDF20-A8T  | –  |
| 11                                | –          | –         | –          | –          | –          | INDF20-A11T | –  |

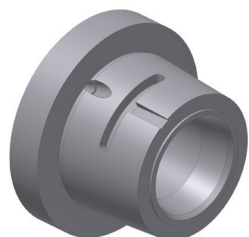


| AMERICAN STANDARD • STYLE D CAMLOCK |            |           |            |             |             |            |    |
|-------------------------------------|------------|-----------|------------|-------------|-------------|------------|----|
| Spindle Size                        | Chuck Size |           |            |             |             |            |    |
|                                     | 6          | 8         | 10         | 12          | 16          | 20         | 25 |
| 4                                   | INDF6-D4T  | INDF8-D4T | –          | –           | –           | –          | –  |
| 5                                   | –          | INDF8-D5T | INDF10-D5T | –           | –           | –          | –  |
| 6                                   | –          | INDF8-D6T | INDF10-D6T | INDF12-D6T  | INDF16-D6T  | –          | –  |
| 8                                   | –          | –         | INDF10-D8T | INDF12-D8T  | –           | INDF20-D8T | –  |
| 11                                  | –          | –         | –          | INDF12-D11T | INDF16-D11T | –          | –  |



Plates unfinished only.

| THREADED MOUNTING PLATES |            |            |            |   |    |    |
|--------------------------|------------|------------|------------|---|----|----|
| Spindle Size             | Chuck Size |            |            |   |    |    |
|                          | 4          | 5          | 6          | 8 | 10 | 12 |
| 2 3/16"-10               | –          | IND5-2316T | IND6-2316T | – | –  | –  |



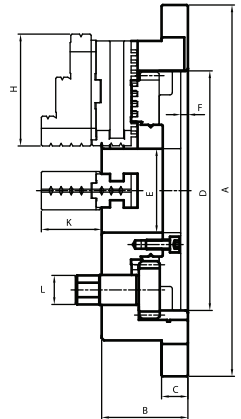
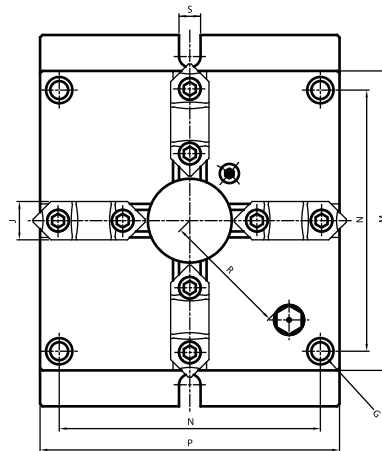
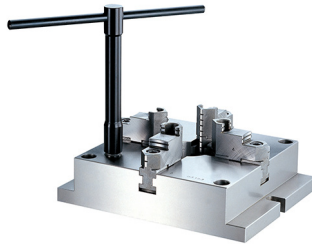
Plates unfinished only.

| 4 DEGREE TAPER • FULLY FINISHED |            |
|---------------------------------|------------|
| 5"                              | IND5-4DEGT |
| 6"                              | IND6-4DEGT |

See Spindle Identification on page 6 to determine the correct mounting plate needed.

### FEATURES:

- Precision ground, tolerances within 0.05mm
- Soft jaws can be used, allowing for versatility in machining
- Repeatability of 0.02mm with the standard hard jaws
- Parallel gripping accuracy with hard jaws can be controlled within 0.05mm after aligning sides of chucks



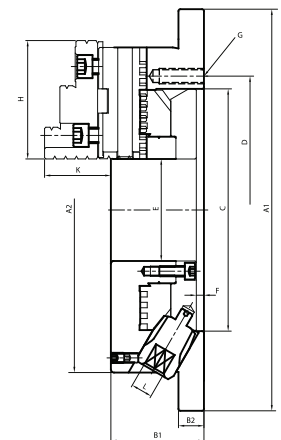
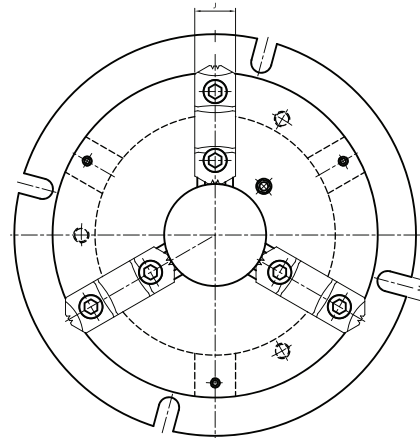
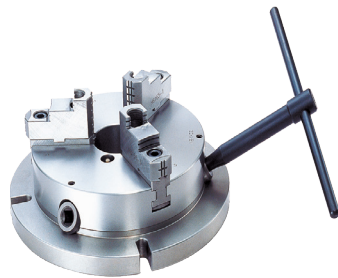
### 4-JAW

#### 4-Jaw Square Chuck

|     | Part No. | A     | B    | C    | D     | E    | F    | G             | H    | J    | K    | L    | M     | N     | P     | R    | S    | Gripping Dia. (mm) |        | Wt. Lbs. |
|-----|----------|-------|------|------|-------|------|------|---------------|------|------|------|------|-------|-------|-------|------|------|--------------------|--------|----------|
|     |          |       |      |      |       |      |      |               |      |      |      |      |       |       |       |      |      | EXT.               | INT.   |          |
| 6"  | MC-06    | 8.46  | 2.24 | 0.71 | 5.12  | 1.57 | 0.22 | (4) M10x1.5P  | 2.68 | 1.02 | 0.55 | .551 | 6.50  | 5.67  | 6.50  | 2.60 | 0.71 | 4-128              | 55-128 | 25       |
| 8"  | MC-08    | 9.84  | 2.56 | 0.79 | 6.30  | 2.17 | 0.24 | (4) M12x1.75P | 3.23 | 1.10 | 0.67 | .669 | 7.87  | 6.85  | 7.87  | 3.27 | 0.71 | 5-162              | 62-162 | 41       |
| 10" | MC-10    | 12.20 | 2.83 | 0.87 | 7.87  | 2.76 | 0.24 | (4) M14x2P    | 3.66 | 1.26 | 0.83 | .826 | 9.84  | 8.58  | 9.84  | 4.09 | 0.71 | 6-200              | 72-200 | 71       |
| 12" | MC-12    | 14.96 | 3.35 | 0.98 | 10.24 | 3.94 | 0.28 | (4) M16x2P    | 4.65 | 1.57 | 0.91 | .905 | 12.20 | 10.79 | 12.20 | 5.31 | 0.87 | 10-265             | 90-265 | 126      |

### FEATURES:

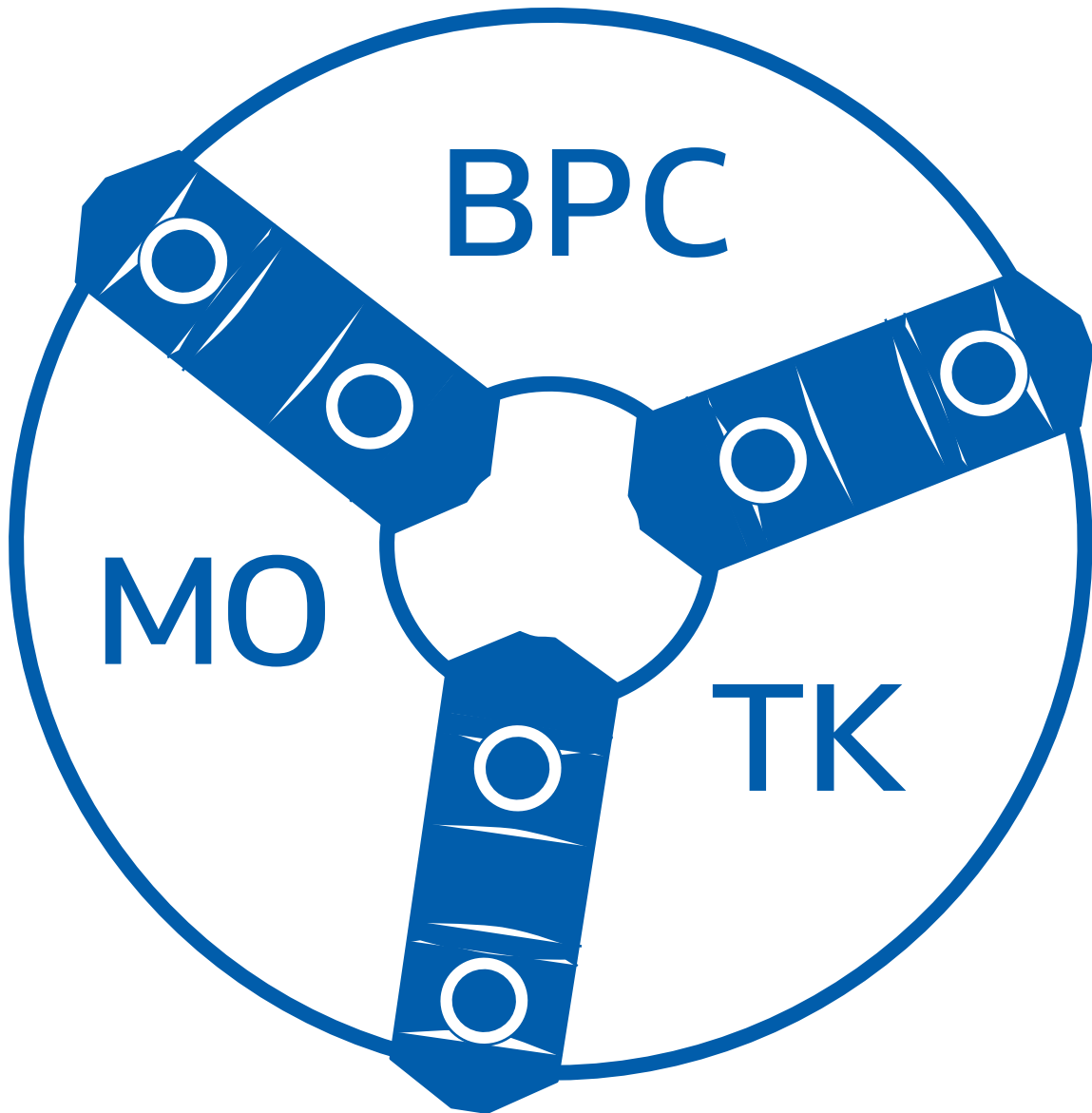
- Wrench inserted at 30 ° angle allowing for versatility in placement of chuck
- Super-thin design increases allowable distance of machining operations
- Flange mount makes unloading and loading operations simple and convenient
- Hard or soft top jaws can be used

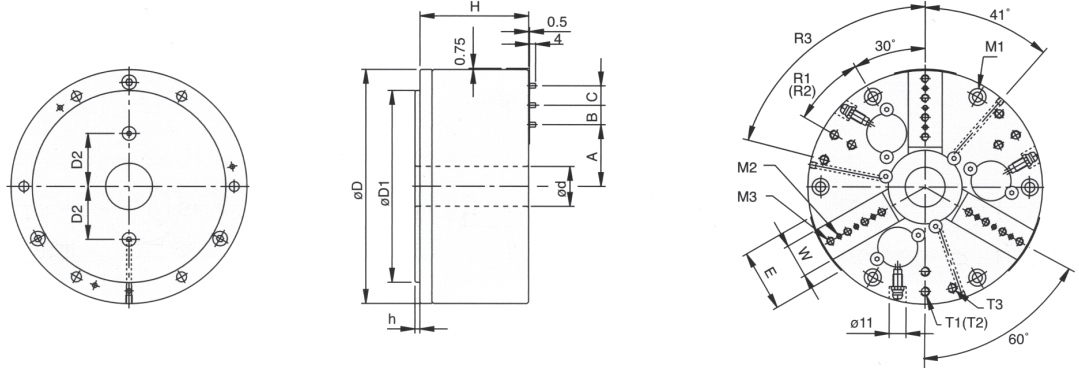


### 3-JAW

#### 3-Jaw Round Chuck

|     | Part No. | A1    | A2    | B1   | B2   | C    | D     | E    | F    | G             | H    | J    | K    | L    | M    | Gripping Dia. (mm) |        | Weight Lbs. |
|-----|----------|-------|-------|------|------|------|-------|------|------|---------------|------|------|------|------|------|--------------------|--------|-------------|
|     |          |       |       |      |      |      |       |      |      |               |      |      |      |      |      | EXT.               | INT.   |             |
| 6"  | NBK-06   | 8.66  | 6.69  | 2.28 | 0.71 | 5.12 | 5.79  | 1.77 | 0.24 | (3) M10x1.5P  | 2.68 | 1.02 | 1.57 | 0.39 | 0.51 | 8-160              | 48-150 | 24          |
| 8"  | NBK-08   | 10.63 | 8.27  | 2.56 | 0.79 | 6.10 | 6.77  | 2.36 | 0.24 | (3) M10x1.5P  | 3.23 | 1.10 | 1.69 | 0.43 | 0.51 | 11-200             | 62-190 | 40          |
| 10" | NBK-10   | 12.40 | 255   | 2.87 | 0.79 | 7.48 | 8.27  | 3.15 | 0.24 | (3) M12x1.75P | 3.66 | 1.26 | 2.05 | 0.47 | 0.63 | 12-250             | 72-240 | 61          |
| 12" | NBK-12   | 14.57 | 10.04 | 3.15 | 0.87 | 9.84 | 11.22 | 4.13 | 0.20 | (3) M12x1.75P | 4.65 | 1.57 | 2.32 | 0.55 | 0.71 | 15-300             | 86-290 | 95          |





## FEATURES AND BENEFITS:

- Pre-machined tapped holes for fixing jigs, making additional machining unnecessary
- Pre-machined lubrication path allows connection to auto-lubrication unit
- Built-in cylinder allows more stable gripping
- Dowel pins built into master jaws allow for more accurate and simplified remounting of soft jaws
- Good coaxiality and repeatability allows for 1µm accuracy, which simplifies machining process and increases efficiency

## CHUCK INCLUDES:

- One set of soft top jaws
- Wrench

| Model | A     | B    | C    | D     | E  | D1     | d (H7) | D2   | Range  |
|-------|-------|------|------|-------|----|--------|--------|------|--------|
| TK-04 | 20.75 | 12.7 | 12.7 | 101.6 | 30 | 82.55  | 18     | 25.0 | 9-101  |
| TK-06 | 39.75 | 12.7 | 12.7 | 152.4 | 40 | 124.97 | 26     | 34.5 | 15-152 |
| TK-08 | 65.75 | 25.4 | —    | 203.2 | 45 | 167.64 | 50     | 50.0 | 20-203 |

| Model | H    | h   | W  | M1                   | M2       |
|-------|------|-----|----|----------------------|----------|
| TK-04 | 70.3 | 3.2 | 16 | M5x0.8P(PCDØ88.9)    | M5x0.8P  |
| TK-06 | 70.3 | 3.2 | 22 | M6x1P(PCDØ135.89)    | M5x0.8P  |
| TK-08 | 99.5 | 7.0 | 25 | M10x1.5P(PCDØ182.88) | M10x1.5P |

| Model | M3     | T1                   | T2                |
|-------|--------|----------------------|-------------------|
| TK-04 | 9-3.18 | M5x0.8P(PCDØ88.9)    | —                 |
| TK-06 | 9-3.18 | M6x1P(PCDØ135.99)    | M6x1P(PCDØ110)    |
| TK-08 | 6-6.36 | M8x1.25P(PCDØ182.88) | M8x1.25P(PCDØ150) |

| Model | T3                   | R1  | R2  | R3  | T.I.R. Jaw<br>T.I.R. | Jaw Stroke<br>Dia. (mm) |
|-------|----------------------|-----|-----|-----|----------------------|-------------------------|
| TK-04 | —                    | 30° | —   | —   | 0.001                | 3                       |
| TK-06 | M6x1P(PCDØ135.99)    | 30° | 30° | 45° | 0.001                | 3                       |
| TK-08 | M8x1.25P(PCDØ182.88) | 30° | 30° | 30° | 0.001                | 3                       |

| Model | Repeatability | Gripping Force<br>At Air Pressure 100 psi<br>(lb.) | Max. Speed<br>rpm<br>(min <sup>-1</sup> ) | Weight<br>(lb.) |
|-------|---------------|----------------------------------------------------|-------------------------------------------|-----------------|
| TK-04 | 0.001         | 683                                                | 4500                                      | 10              |
| TK-06 | 0.001         | 1741                                               | 4500                                      | 22              |
| TK-08 | 0.001         | 3196                                               | 4500                                      | 58              |

Measurements in millimeters unless otherwise indicated.

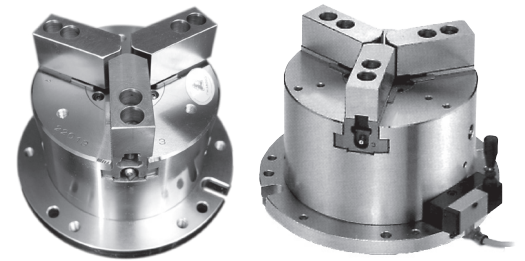
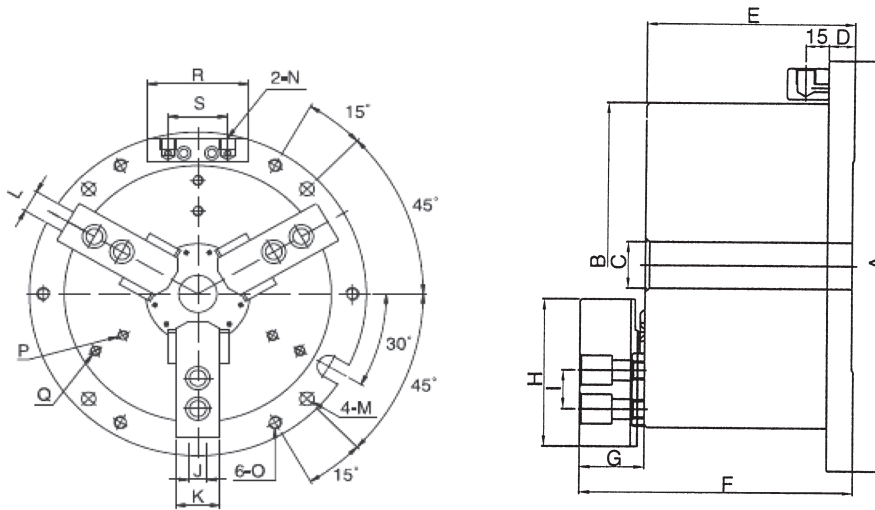
## REQUIRES

Air Feed Tube and ADP adapter



# MO Stationary Closed Center 3-Jaw

## Self-Contained Wedge Type



### FEATURES AND BENEFITS:

- Flange bottom allows chuck to be easily fixed on a plate for quick changeovers
- Built-in cylinder allows for better stability and takes up less space, which allows for higher machining efficiency
- Chuck can be controlled by M-code for use in an auto loading system
- Master jaws with 1.5 mm X 60° pitch enables hard and soft jaw interchangeability with CNC lathe chucks, allowing reduction in cost of spare jaws
- Dust-proof and water-resistant structure increases chuck life and efficiency

| MO 3-JAW WEDGE TYPE POWER CHUCK |     |     |    |    |      |       |    |      |    |    |    |
|---------------------------------|-----|-----|----|----|------|-------|----|------|----|----|----|
| Model                           | A   | B   | C  | D  | E    | F     | G  | H    | I  | J  | K  |
| M0-04                           | 155 | 115 | –  | 15 | 77.5 | 103.5 | 26 | 49.5 | 14 | 10 | 23 |
| M0-05                           | 185 | 135 | –  | 15 | 95   | 128   | 33 | 62   | 14 | 10 | 25 |
| M0-06                           | 224 | 169 | 25 | 16 | 118  | 158   | 40 | 73   | 20 | 12 | 31 |
| M0-08                           | 265 | 210 | 30 | 20 | 138  | 180   | 42 | 95   | 25 | 14 | 35 |
| M0-10                           | 315 | 254 | 52 | 23 | 150  | 196   | 46 | 110  | 30 | 16 | 40 |
| M0-12                           | 375 | 304 | 80 | 23 | 165  | 219   | 54 | 129  | 30 | 21 | 50 |

| MO 3-JAW WEDGE TYPE POWER CHUCK |    |              |       |           |           |           |    |    |
|---------------------------------|----|--------------|-------|-----------|-----------|-----------|----|----|
| Model                           | L  | M            | N     | O         | P         | Q         | R  | S  |
| M0-04                           | 13 | 9 (PCD 165)  | PT1/8 | M8x1.25P  | –         | –         | 64 | 47 |
| M0-05                           | 13 | 10 (PCD 135) | PT1/4 | M8x1.25P  | M8x1.25P  | –         | 80 | 47 |
| M0-06                           | 18 | 11 (PCD 202) | PT1/4 | M10x1.5P  | M8x1.25P  | –         | 80 | 47 |
| M0-08                           | 18 | 11 (PCD 243) | PT1/4 | M10x1.5P  | M10x1.5P  | M10x1.5P  | 80 | 47 |
| M0-10                           | 18 | 13 (PCD 285) | PT1/4 | M12x1.75P | M12x1.75P | M12x1.75P | 80 | 47 |
| M0-12                           | 18 | 17 (PCD 340) | PT3/8 | M16x2P    | M12x1.75P | M12x1.75P | 80 | 55 |

### CHUCK INCLUDES:

- One set of soft top jaws
- Wrench

### OPTIONAL ACCESSORY

Pneumatic Manual switch

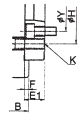
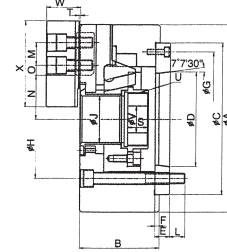
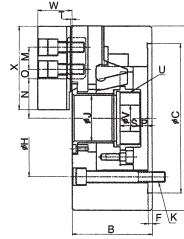
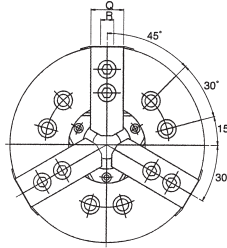
| MO 3-JAW WEDGE TYPE POWER CHUCK |                                |                     |                      |                           |                           |                                              |                    |                     |
|---------------------------------|--------------------------------|---------------------|----------------------|---------------------------|---------------------------|----------------------------------------------|--------------------|---------------------|
| Model                           | Piston Area (cm <sup>2</sup> ) | Plunger Stroke (mm) | Jaw Stroke Dia. (mm) | Max. Gripping Force (lb.) | Max. Hydr. Pressure (psi) | Gripping Force at Air Pressure 100 psi (lb.) | Gross Weight (lb.) | Gripping Range (mm) |
| M0-04                           | 57                             | 9                   | 3.8                  | 5291                      | 213                       | 2425                                         | 22                 | 9-115               |
| M0-05                           | 74                             | 10                  | 5.4                  | 7242                      | 284                       | 2866                                         | 25                 | 12-135              |
| M0-06                           | 97                             | 12                  | 5.5                  | 11111                     | 284                       | 4409                                         | 46                 | 15-169              |
| M0-08                           | 156                            | 16                  | 7.4                  | 17857                     | 284                       | 7275                                         | 81                 | 20-210              |
| M0-10                           | 235                            | 19                  | 8.8                  | 26918                     | 284                       | 10582                                        | 124                | 33-254              |
| M0-12                           | 292                            | 23                  | 10.6                 | 31967                     | 284                       | 11243                                        | 154                | 40-304              |

## FEATURES & BENEFITS:

- High-quality alloy steel body allows for higher speeds
- Sharply increased dynamic gripping force greatly improves work efficiency and safety
- Interchangeable top tooling with 1.5 mm x 60° jaw serration pitch
- Compact and lightweight, allowing for improved efficiency
- Direct mounting to fit ASA B5.9 Type A spindle
- Improved lubrication system for high accuracy and endurance
- Heat-treated alloy steel for high durability

## CHUCK INCLUDES:

- ASA B5.9 Type A spindle adapter
- 1 set of soft top jaws
- Wrench



MODEL 0P 3-JAW WEDGE TYPE POWER CHUCK

| Model  | Spindle Nose | A   | B   | C   | D      | E  | E1 | F | G   | H     | H1     | I1        | J     | K         | L  | M  | N Max. | N Min. |
|--------|--------------|-----|-----|-----|--------|----|----|---|-----|-------|--------|-----------|-------|-----------|----|----|--------|--------|
| BPC204 | —            | 110 | 59  | 85  | —      | —  | —  | 4 | —   | 70.6  | —      | —         | 26    | M10x1.5p  | —  | 14 | 23     | 20.3   |
| BPC205 | A2-4         | 135 | 60  | 110 | 63.51  | 20 | —  | 4 | 96  | 82.6  | PCD118 | M8x1.25P  | 33    | M10x1.5P  | 15 | 14 | 26.20  | 23.50  |
| BPC206 | A2-5         | 169 | 81  | 140 | 82.56  | 15 | —  | 5 | 116 | 104.8 | PCD145 | M10x1.5P  | 45    | M10x1.5P  | 16 | 20 | 32.35  | 29.60  |
| BPC208 | A2-6 (A2-5)  | 210 | 91  | 170 | 106.98 | 17 | 23 | 5 | 150 | 133.4 | PCD180 | M10x1.5P  | 52    | M12x1.75P | 18 | 25 | 39.10  | 35.40  |
| BPC210 | A2-8 (A2-6)  | 254 | 100 | 220 | 139.72 | 18 | 28 | 5 | 190 | 171.4 | PCD225 | M12x1.75P | 75.0  | M16x2P    | 19 | 30 | 51.5   | 47.1   |
| BPC212 | A2-8 (A2-6)  | 304 | 110 | 220 | 139.72 | 18 | —  | 6 | 190 | 171.4 | PCD250 | M12x1.75P | 91.0  | M16x2P    | 25 | 30 | 61.6   | 56.3   |
| BPC215 | A2-11 (A2-8) | 381 | 133 | 300 | 196.87 | 22 | 33 | 6 | 260 | 235.0 | PCD324 | M12x1.75P | 117.5 | M20x2.5P  | 28 | 43 | 82.3   | 77.0   |
| BPC218 | A2-11 (A2-8) | 450 | 133 | 300 | 196.87 | 22 | 33 | 6 | 260 | 235.0 | PCD230 | M12x1.75P | 120.0 | M20x2.5P  | 28 | 43 | 83.8   | 78.5   |

SPECIFICATIONS CONTINUED

| Model  | O Max. | O Min. | P Max. | P Min. | Q  | R  | S    | T | U        | V  | W    | X    | Y     | Thru-Hole Dia. | Plunger stroke (mm) |
|--------|--------|--------|--------|--------|----|----|------|---|----------|----|------|------|-------|----------------|---------------------|
| BPC204 | 11.5   | 6.7    | 3.5    | -6.5   | 23 | 10 | 17.5 | 2 | M32X1.5P | 12 | 24   | 49.5 | --    | 26             |                     |
| BPC205 | 19.0   | 6.0    | 1.0    | -9.0   | 25 | 10 | 20.0 | 2 | M40x1.5P | 12 | 31.5 | 62.0 | —     | 33.0           | 10                  |
| BPC206 | 24.0   | 7.0    | 11.0   | -1.0   | 31 | 12 | 19.0 | 2 | M55x2P   | 20 | 37.0 | 73.0 | —     | 45.0           | 12                  |
| BPC208 | 30.0   | 10.0   | 14.5   | -1.5   | 35 | 14 | 20.5 | 2 | M60x2P   | 30 | 39.0 | 95.0 | 104.8 | 52.0           | 16                  |
| BPC210 | 34.0   | 12.0   | 8.5    | -10.5  | 40 | 16 | 25.0 | 2 | M85x2P   | 40 | 43   | 110  | 133.4 | 75.0           | 19                  |
| BPC212 | 46.0   | 12.0   | 8.0    | -15.0  | 50 | 21 | 28.0 | 2 | M100x2P  | 50 | 51   | 129  | —     | 91.0           | 23                  |
| BPC215 | 46.0   | 13.0   | 7.0    | -16.0  | 62 | 22 | 42.5 | 5 | M130x2P  | 48 | 66   | 165  | 171.4 | 117.5          | 23                  |
| BPC218 | 78.0   | 18.0   | 7.0    | -16.0  | 62 | 22 | 42.5 | 5 | M130x2P  | 48 | 66   | 165  | 171.4 | 120.0          | 23                  |

SPECIFICATIONS CONTINUED

| Model  | Jaw Stroke Dia. (mm) | Max. Speed (rpm) | Gross Weight (lb.) | Max. Pull Force (lb.) | Max. Gripping Force (lb.) | Max. Hydr. Pressure (psi) | Gripping Range (mm) Min. Max. | Draw Nut Thread (mm) | Matching Cylinder |
|--------|----------------------|------------------|--------------------|-----------------------|---------------------------|---------------------------|-------------------------------|----------------------|-------------------|
| BPC204 | 5.4                  | 8000             |                    | 3147                  | 6294                      | 334                       | 7 110                         | M32X1.5P             | BC1036            |
| BPC205 | 5.4                  | 7000             | 13                 | 3814                  | 7870                      | 412                       | 10 135                        | M40x1.5P             | BC1036            |
| BPC206 | 5.5                  | 6000             | 28                 | 4718                  | 12588                     | 398                       | 13 169                        | M55x2P               | BC1246            |
| BPC208 | 7.4                  | 5000             | 48                 | 7408                  | 18430                     | 370                       | 13 210                        | M60x2P               | BC1552            |
| BPC210 | 8.8                  | 4200             | 74                 | 9436                  | 24273                     | 384                       | 30 254                        | M85x2P               | BC1875            |
| BPC212 | 10.6                 | 3300             | 122                | 12125                 | 31702                     | 384                       | 35 304                        | M100x2P              | BC2091            |
| BPC215 | 10.6                 | 2500             | 235                | 15741                 | 40234                     | 348                       | 35 381                        | M130x2P              | BC2511            |
| BPC218 | 10.6                 | 2000             | 250                | 15741                 | 40234                     | 348                       | 40 450                        | M130x2P              | BC2511            |

Dimensions denoted in millimeters unless otherwise specified. Specially threaded or blank draw nuts available.

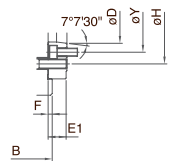
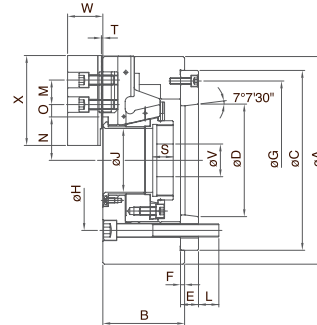
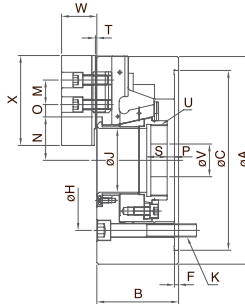
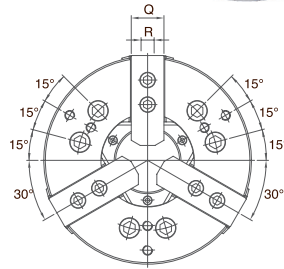
# BBC High-Speed, Large Bore 3-Jaw

Wedge Type - Direct OEM Replacement



## FEATURES AND BENEFITS:

- High-quality alloy steel body allows for higher speeds
- Sharply increased dynamic gripping force greatly improves work efficiency and safety
- Interchangeable top tooling with 1.5 mm x 60° jaw serration pitch
- Compact and lightweight, allowing for improved efficiency
- Direct mounting to fit ASA B5.9 Type A spindle
- Improved lubrication system for high accuracy and endurance
- Heat-treated alloy steel for high durability



## MODEL BBC 3-JAW WEDGE TYPE POWER CHUCK

| Model  | Spindle Nose | A   | B   | C   | D     | E  | E1 | F | G     | H        | J     | K         | L  | M  | N Max. | N Min. |
|--------|--------------|-----|-----|-----|-------|----|----|---|-------|----------|-------|-----------|----|----|--------|--------|
| BBC206 | A2-5         | 170 | 81  | 140 | 82.6  | -- | 20 | 5 | --    | PCD122   | 52    | M10x1.5P  | -- | 20 | 36.4   | 33.6   |
| BBC208 | A2-6         | 215 | 91  | 170 | 106.4 | -- | 22 | 5 | --    | PCD150   | 66    | M12x1.75P | -- | 25 | 46.6   | 42.9   |
| BBC210 | A2-8         | 256 | 100 | 220 | 139.7 | -- | 28 | 5 | --    | PCD180   | 81    | M16x2P    | -- | 30 | 54.6   | 50.1   |
| BBC212 | A2-11(A2-8)  | 315 | 108 | 300 | 196.9 | 22 | 33 | 5 | 260.0 | PCD235   | 106   | M20x2.5P  | 27 | 30 | 69.7   | 64.3   |
| BBC215 | A2-15(A2-11) | 405 | 133 | 380 | 285.8 | 27 | 41 | 6 | 330.2 | PCD330.2 | 142   | M24x3P    | 32 | 43 | 95.1   | 89.5   |
| BBC218 | A2-15(A2-11) | 455 | 134 | 380 | 285.8 | 27 | 41 | 6 | 330.2 | PCD330.2 | 166.5 | M24x3P    | 32 | 43 | 108.3  | 102.5  |

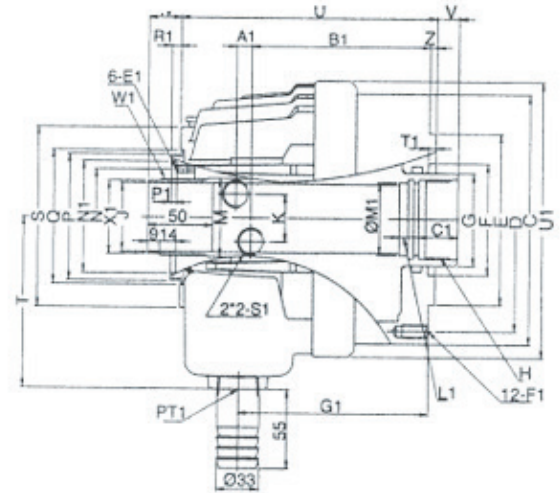
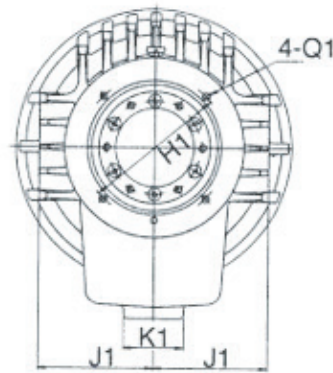
## SPECIFICATIONS CONTINUED

| Model  | O Max. | O Min. | P Max. | P Min. | Q  | R  | S    | T | U       | V  | W    | X   | Y     | Thru-Hole Dia. | Plunger stroke (mm) |
|--------|--------|--------|--------|--------|----|----|------|---|---------|----|------|-----|-------|----------------|---------------------|
| BBC206 | 21.1   | 9.1    | 7.0    | -5.0   | 31 | 12 | 23.0 | 2 | M60x2P  | 20 | 37.5 | 73  | 104.8 | 52             | 12                  |
| BBC208 | 26.6   | 11.6   | 10.0   | -6.0   | 35 | 14 | 25.0 | 2 | M75x2P  | 30 | 39.5 | 80  | 133.4 | 66             | 16                  |
| BBC210 | 33.1   | 13.6   | 8.5    | -10.5  | 40 | 16 | 25.0 | 2 | M90x2P  | 40 | 43   | 110 | 171.4 | 81             | 19                  |
| BBC212 | 45.6   | 12.6   | 8.0    | -15.0  | 50 | 21 | 28.0 | 2 | M115x2P | 50 | 51   | 129 | 171.4 | 106            | 23                  |
| BBC215 | 43.6   | 16.6   | 8.0    | -15.0  | 62 | 22 | 42.5 | 5 | M155x2P | 80 | 66   | 165 | 235   | 142            | 23                  |
| BBC218 | 55.6   | 16.6   | 11.5   | -13.0  | 62 | 22 | 38.0 | 5 | M180x3P | 48 | 66   | 165 | 171.4 | 166            | 23                  |

## SPECIFICATIONS CONTINUED

| Model  | Jaw Stroke Dia. (mm) | Max. Speed (rpm) | Gross Weight (lb.) | Max. Pull Force (lb.) | Max. Gripping Force (lb.) | Max. Hydr. Pressure (psi) | Gripping Range (mm) |      | Draw Nut Thread (mm) | Matching Cylinder |
|--------|----------------------|------------------|--------------------|-----------------------|---------------------------|---------------------------|---------------------|------|----------------------|-------------------|
|        |                      |                  |                    |                       |                           |                           | Min.                | Max. |                      |                   |
| BBC206 | 5.5                  | 6000             | 28                 | 4850                  | 13007                     | 298                       | 13                  | 1710 | M60x2P               | BC1452S           |
| BBC208 | 7.4                  | 5000             | 48                 | 7495                  | 19400                     | 370                       | 50                  | 215  | M75x2P               | BC1666S           |
| BBC210 | 8.8                  | 4200             | 74                 | 9479                  | 24471                     | 412                       | 34                  | 254  | M90x2P               | BC1881S           |
| BBC212 | 10.6                 | 3400             | 122                | 12345                 | 32143                     | 412                       | 50                  | 315  | M115x2P              | BC2511            |
| BBC215 | 10.6                 | 2500             | 235                | 15961                 | 40234                     | 370                       | 60                  | 405  | M155x2P              | BC2816            |
| BBC218 | 11.3                 | 2000             | 250                | 15961                 | 40234                     | 370                       | 80                  | 455  | M180x3P              | BC2816            |

Dimensions denoted in millimeters unless otherwise specified. Specially threaded or blank draw nuts available.



## FEATURES AND BENEFITS:

- Compact & Lightweight
- Large Thru-Hole Diameter
- Built-In Check-Valve
- Easy for Heat Dissipation

| Model  | A1   | B1    | C   | C1 | D   | E   | E1     | F   | F1       | G   | G1    | H        | H1  | J   | J1  | K  | K1 | L1 |
|--------|------|-------|-----|----|-----|-----|--------|-----|----------|-----|-------|----------|-----|-----|-----|----|----|----|
| BC1036 | 11   | 102.5 | 135 | 25 | 115 | 100 | M5x0.8 | 65  | M10x1.5  | 48  | 98    | M42x1.5  | 88  | 36  | 73  | 30 | 47 | 15 |
| BC1246 | 11.5 | 126.5 | 155 | 30 | 130 | 100 | M6x1.0 | 80  | M10x1.5  | 65  | 135   | M55x2.0  | 98  | 46  | 76  | 36 | 47 | 15 |
| BC1552 | 12   | 136   | 190 | 30 | 170 | 130 | M6x1.0 | 85  | M10x1.5  | 70  | 145   | M60x2.0  | 110 | 52  | 86  | 36 | 47 | 15 |
| BC1875 | 17.5 | 153.5 | 215 | 35 | 190 | 160 | M6x1.0 | 120 | M10x1.5  | 95  | 166.5 | M85x2.0  | 155 | 75  | 101 | 36 | 47 | 15 |
| BC2091 | 21   | 168   | 240 | 35 | 215 | 180 | M6x1.0 | 140 | M12x1.75 | 110 | 183   | M100x2.0 | 165 | 91  | 110 | 36 | 47 | 15 |
| BC2511 | 23   | 176.5 | 305 | 45 | 275 | 230 | M6x1.0 | –   | M16x2.0  | 140 | 193   | M130x2.0 | 215 | 118 | –   | 40 | –  | 15 |

| Model  | M     | M1 | N   | N1  | P   | P1 | Q   | Q1     | R1 | S   | S1    | T   | T1 | U   | U1  | V<br>Max. | V<br>Max. | W<br>Max. | W1      | W<br>Max. | X1 | Z |
|--------|-------|----|-----|-----|-----|----|-----|--------|----|-----|-------|-----|----|-----|-----|-----------|-----------|-----------|---------|-----------|----|---|
| BC1036 | 44.6  | 38 | 55  | 64  | 73  | 4  | 45  | M5x0.8 | 5  | 104 | PT3/8 | 115 | 6  | 161 | 150 | 10        | -5        | 40        | M44x1.5 | 25        | 42 | 5 |
| BC1246 | 52.9  | 50 | 64  | 76  | 85  | 4  | 90  | M5x0.8 | 6  | 118 | PT1/2 | 115 | 6  | 184 | 170 | 10        | -5        | 40        | M52x1.5 | 25        | 50 | 5 |
| BC1552 | 59.6  | 55 | 73  | 85  | 96  | 4  | 102 | M6x1.0 | 7  | 137 | PT1/2 | 130 | 6  | 196 | 210 | 17        | -5        | 47        | M58x1.5 | 25        | 56 | 5 |
| BC1875 | 84.6  | 80 | 98  | 108 | 121 | 4  | 131 | M6x1.0 | 7  | 166 | PT1/2 | 160 | 6  | 230 | 235 | 20        | -5        | 50        | M84x2.0 | 25        | 81 | 5 |
| BC2091 | 99.6  | 95 | 108 | 120 | 138 | 4  | 148 | M6x1.0 | 7  | 182 | PT1/2 | 185 | 6  | 253 | 260 | 25        | -5        | 55        | M99x2.0 | 25        | 96 | 5 |
| BC2511 | 133.6 | –  | 148 | 195 | –   | 5  | –   | M6x1.0 | –  | 230 | PT1/2 | 210 | –  | 275 | 315 | 25        | -5        | 52        | –       | –         | –  | – |

| Model  | Thru-Hole Dia. (mm) | Piston Stroke (mm) | Max. Speed (rpm) | Gross Weight (kg) | GD <sup>2</sup> (kfg-m <sup>2</sup> ) | Piston Dia. (mm) | Oil Leakage Rate (O/min) | Max. Speed (kfg/cm <sup>2</sup> ) | Piston Area (cm <sup>2</sup> ) |           | Operating Force Max. (psi) |           |
|--------|---------------------|--------------------|------------------|-------------------|---------------------------------------|------------------|--------------------------|-----------------------------------|--------------------------------|-----------|----------------------------|-----------|
|        |                     |                    |                  |                   |                                       |                  |                          |                                   | Push Side                      | Pull Side | Push Side                  | Pull Side |
| BC1036 | 36                  | 15                 | 8000             | 8.8               | 0.044                                 | 105              | 3.0                      | 40                                | 67                             | 64.5      | 2500                       | 2400      |
| BC1246 | 46                  | 15                 | 7000             | 13.8              | 0.078                                 | 125              | 3.0                      | 40                                | 100                            | 89        | 3700                       | 3200      |
| BC1552 | 52                  | 22                 | 6200             | 19.3              | 0.21                                  | 155              | 3.9                      | 40                                | 161                            | 150       | 5900                       | 5500      |
| BC1875 | 75                  | 25                 | 4700             | 28.5              | 0.38                                  | 180              | 4.2                      | 40                                | 198                            | 183       | 7200                       | 6700      |
| BC2091 | 91                  | 30                 | 3800             | 36.1              | 0.61                                  | 205              | 4.5                      | 40                                | 252                            | 234       | 9200                       | 8600      |
| BC2511 | 118                 | 30                 | 2800             | 54                | 1.5                                   | 250              | 7.0                      | 40                                | 345                            | 335       | –                          | –         |

Specifications subject to change without notice. \*12" Bore - 6 additional holes on a 9.50 B.C.

Dimensions denoted in millimeters unless otherwise specified. Compatible with chucks on pages 22, and 24.

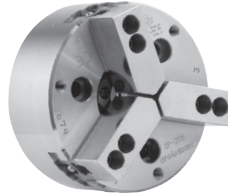
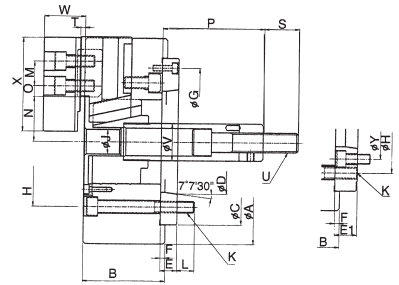
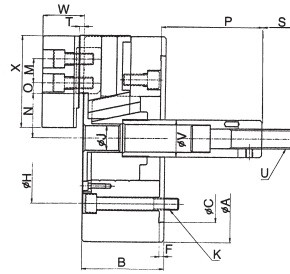
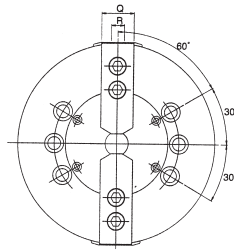
# CL High-Speed Closed Center 3-Jaw

Wedge Type - Direct OEM Replacement



## FEATURES AND BENEFITS:

- High-quality alloy steel body allows for high speeds
- Sharply increased dynamic gripping force greatly improves work efficiency and safety
- Interchangeable top tooling with 1.5 mm x 60° jaw serration pitch
- Compact and lightweight, allowing for increased efficiency
- Direct mounting to fit ASA B5.9 Type A spindle
- Improved lubrication system for high-accuracy and endurance
- Heat-treated alloy steel for high durability



## CHUCK INCLUDES:

- ASA B5.9 Type A spindle adapter
- 1 set of soft top jaws
- Wrench

MODEL CL 3-JAW WEDGE TYPE POWER CHUCK

| Model | Nose of Spindle                       | A   | B   | C   | D      | E  | E1 | F | G   | H     | J  | K         | L  | M  | Nmax  | Nmin   |
|-------|---------------------------------------|-----|-----|-----|--------|----|----|---|-----|-------|----|-----------|----|----|-------|--------|
| CL-05 | A <sub>2</sub> -4                     | 135 | 55  | 80  | 63.51  | —  | —  | 7 | —   | 100.0 | —  | M8x1.5P   | 14 | 14 | 30.4  | 27.20  |
| CL-06 | A <sub>2</sub> -5                     | 165 | 74  | 140 | 82.56  | 15 | —  | 5 | 116 | 104.8 | 21 | M10x1.5P  | 14 | 20 | 37.8  | 33.25  |
| CL-08 | A <sub>2</sub> -6 (A <sub>2</sub> -5) | 210 | 85  | 170 | 106.38 | 17 | 23 | 5 | 150 | 133.4 | 25 | M12x1.75P | 18 | 25 | 46.3  | 41.90  |
| CL-10 | A <sub>2</sub> -8 (A <sub>2</sub> -6) | 254 | 89  | 220 | 139.72 | 18 | 28 | 5 | 190 | 171.4 | 34 | M16x2P    | 25 | 30 | 51.4  | 47.00  |
| CL-12 | A <sub>2</sub> -8                     | 304 | 106 | 220 | 139.72 | 18 | —  | 6 | 190 | 171.4 | 34 | M16x2P    | 25 | 30 | 60.7  | 55.45  |
| CL-15 | A <sub>2</sub> -11                    | 381 | 114 | 300 | 196.87 | 22 | —  | 6 | 260 | 235.0 | —  | M20x2.5P  | 32 | 43 | 77.5  | 69.50  |
| CL-18 | A <sub>2</sub> -11                    | 450 | 114 | 300 | 196.87 | 22 | —  | 6 | 260 | 235.0 | —  | M20x2.5P  | 32 | 43 | 108.0 | 100.00 |

SPECIFICATIONS CONTINUED

| Model | Omax  | Omin  | Pmax  | Pmin  | Q  | R    | S  | T | U         | V  | W  | X   | Y     |
|-------|-------|-------|-------|-------|----|------|----|---|-----------|----|----|-----|-------|
| CL-05 | 17.00 | 7.00  | 9.0   | -6.0  | 25 | 10   | 35 | 2 | M12x1.75P | 28 | 31 | 62  | —     |
| CL-06 | 18.00 | 7.50  | 101.5 | 81.5  | 31 | 12   | 36 | 4 | M16x2P    | 34 | 39 | 73  | —     |
| CL-08 | 22.50 | 9.00  | 127.0 | 106.0 | 35 | 14   | 36 | 5 | M20x2.5P  | 38 | 42 | 95  | —     |
| CL-10 | 37.50 | 10.50 | 158.0 | 133.0 | 40 | 16   | 36 | 5 | M20x2.5P  | 45 | 46 | 110 | 104.8 |
| CL-12 | 47.00 | 11.00 | 163.0 | 133.0 | 50 | 18.0 | 36 | 5 | M20x2.5P  | 50 | 54 | 130 | 133.4 |
| CL-15 | 50.25 | 23.25 | 104.0 | 69.0  | 62 | 25.5 | 55 | 2 | M30x3.5P  | 60 | 63 | 165 | —     |
| CL-18 | 49.50 | 25.50 | 92.0  | 57.0  | 62 | 25.5 | 55 | 2 | M30x3.5P  | 60 | 63 | 165 | —     |

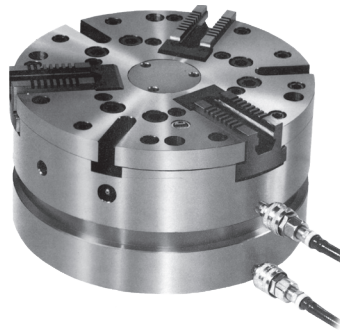
SPECIFICATIONS CONTINUED

| Model | Plunger Stroke (mm) | Jaw Stroke Dia. (mm) | Max RPM | Max Pull Force (lb.) | Max Grip Force (lb.) | Max Hydr. Pressure (psi) | Weight (lb.) | Grip Range (mm) |      |
|-------|---------------------|----------------------|---------|----------------------|----------------------|--------------------------|--------------|-----------------|------|
|       |                     |                      |         |                      |                      |                          |              | Min.            | Max. |
| CL-05 | 15                  | 6.4                  | 5500    | 1764                 | 5401                 | 312                      | 13           | 8               | 135  |
| CL-06 | 20                  | 8.5                  | 5000    | 3813                 | 11464                | 384                      | 25           | 18              | 165  |
| CL-08 | 21                  | 8.8                  | 4600    | 5379                 | 16402                | 355                      | 48           | 12              | 210  |
| CL-10 | 25                  | 8.8                  | 4000    | 6283                 | 23831                | 412                      | 74           | 16              | 254  |
| CL-12 | 30                  | 10.5                 | 3200    | 8994                 | 34171                | 412                      | 129          | 18              | 304  |
| CL-15 | 35                  | 16.0                 | 2800    | 18210                | 55754                | 462                      | 222          | 68              | 381  |
| CL-18 | 25                  | 16.0                 | 2500    | 18210                | 55754                | 462                      | 250          | 85              | 450  |

Dimensions denoted in millimeters unless otherwise specified. Available in larger sizes and two-jaw model.

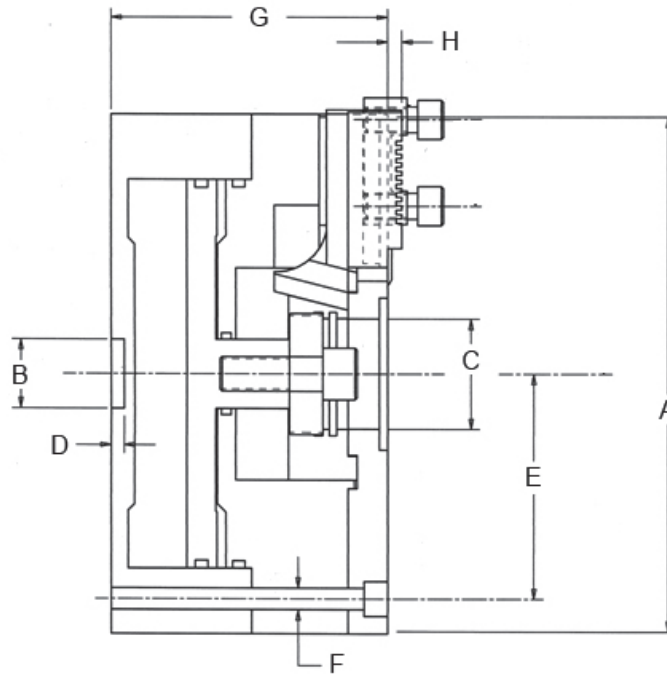
## FEATURES AND BENEFITS:

- Stationary hydraulic/pneumatic built-in cylinder uses less space, while increasing stability and machining efficiency
- Ideal for CNC machining centers as well as standard mills and grinders
- Designed with a sealed face to help protect internal parts from abrasion for a longer service life in the most demanding applications
- Guaranteed repeatability of .001" TIR or better on duplicate part production
- Wear plates under master jaws are easily shimmed or replaced to restore original accuracy



## NOTES:

- Featured with American Square Serrated Master Jaws (other jaw styles available)
- Available with or without a Thru-Hole; available in 2-Jaw, 3-Jaw or 2/3-Jaw styles
- Also available in a lightweight aluminum body
- Parts available for previous models
- Made in the USA



**STATIONARY HYDRAULIC/PNEUMATIC 3-JAW POWER CHUCK**

| Model | A     | B    | C    | D    | E    | F    | G    | H    | Jaw Travel | Max Drawbar Pull (lb.) | Max Line Pressure (psi) |
|-------|-------|------|------|------|------|------|------|------|------------|------------------------|-------------------------|
| A5606 | 6.50  | 2.00 | 1.00 | 0.25 | 2.88 | 0.41 | 5.19 | 0.16 | 0.25       | 2800                   | 166                     |
| A5608 | 8.25  | 2.00 | 1.50 | 0.22 | 3.72 | 0.34 | 5.78 | 0.16 | 0.25       | 5000                   | 170                     |
| A5610 | 10.00 | 2.00 | 2.00 | 0.31 | 4.50 | 0.53 | 6.37 | 0.31 | 0.25       | 9000                   | 195                     |
| A5612 | 12.00 | 2.00 | 2.00 | 0.31 | 5.38 | 0.53 | 6.25 | 0.19 | 0.25       | 10500                  | 160                     |
| A5615 | 15.00 | 2.00 | 3.18 | 0.31 | 6.75 | 0.66 | 8.06 | 0.38 | 0.25       | 15000                  | 160                     |
| A5618 | 18.00 | 2.00 | 3.18 | 0.31 | 8.00 | 0.66 | 8.06 | 0.38 | 0.25       | 15000                  | 105                     |
| A5624 | 24.00 | 2.00 | 3.75 | 0.50 | 9.38 | 0.78 | 9.50 | 0.31 | 0.25       | 15000                  | 50                      |

Measurements in inches unless otherwise indicated.

# Super Life 3-Jaw

The Original Buck Power Chuck – Hydraulic Sliding Jaw

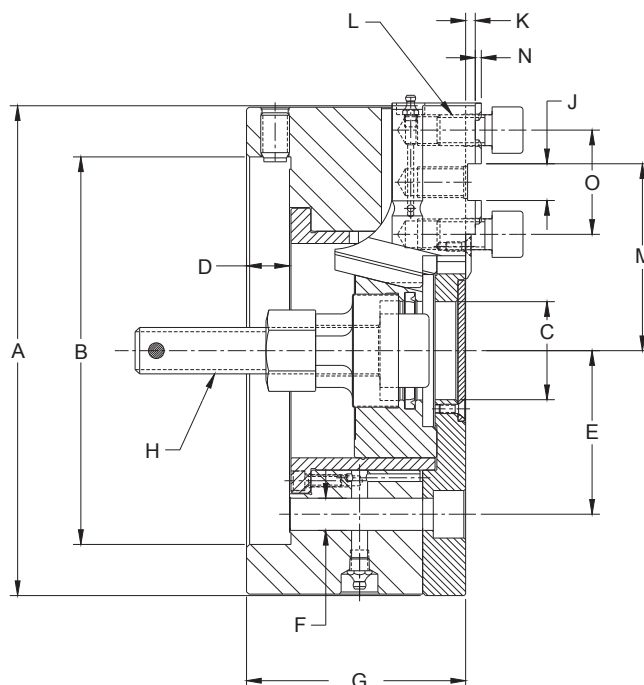
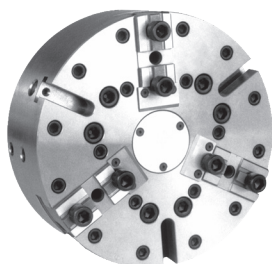


## FEATURES AND BENEFITS:

- Adjust-Tru® Precision! Dead-zero precision mounting feature for "near-zero" runout
- Wide keyway to increase bearing surfaces, lessen wear and increase stability
- Hardened and ground steel wear surfaces increase service life
- Guaranteed repeatability of .001" TIR or better on duplicate part production
- Wear plates under master jaws are easily shimmed or replaced to restore original accuracy
- Hardened replaceable wedge bushings available for factory or field replacement; simple grinding restores wedge to original fit
- 4-to-1 mechanical advantage in all chuck sizes

## NOTES:

- Featured with tongue & groove master jaws. Other jaw styles available
- Available with or without a Thru Hole
- Available in 2-Jaw, 3-Jaw or 2/3-Jaw styles
- Also available in lightweight aluminum body
- Parts available for previous models
- Adjust-Tru® power chuck mounting plate required
- Made in the USA



**SUPER LIFE 3-JAW MODEL POWER CHUCK**

| Model | A     | B     | C    | D    | E    | F    | G    | H       | J    | K    | L        | M (max) | M (min) | N    | O    |
|-------|-------|-------|------|------|------|------|------|---------|------|------|----------|---------|---------|------|------|
| A4006 | 6.50  | 4.78  | 1.00 | 0.63 | 2.06 | 0.47 | 3.25 | 5/8"-18 | 0.50 | 0.16 | 7/16"-14 | 2.44    | 2.19    | 0.13 | 1.50 |
| A4008 | 8.25  | 6.16  | 1.50 | 0.66 | 2.63 | 0.53 | 3.86 | 5/8"-18 | 0.50 | 0.16 | 1/2"-13  | 3.06    | 2.75    | 0.13 | 1.75 |
| A4010 | 10.00 | 7.91  | 2.00 | 0.88 | 3.38 | 0.69 | 4.47 | 1"-14   | 0.75 | 0.19 | 5/8"-11  | 3.81    | 3.44    | 0.13 | 2.13 |
| A4012 | 12.00 | 7.91  | 2.00 | 0.88 | 3.38 | 0.69 | 4.47 | 1"-14   | 0.75 | 0.19 | 5/8"-11  | 4.50    | 4.13    | 0.13 | 2.50 |
| A4015 | 15.00 | 11.78 | 3.19 | 0.94 | 4.63 | 0.78 | 5.16 | 1"-14   | 0.75 | 0.28 | 3/4"-10  | 5.63    | 5.25    | 0.13 | 3.00 |
| A4018 | 18.00 | 11.78 | 3.19 | 0.94 | 4.63 | 0.78 | 5.16 | 1"-14   | 0.75 | 0.28 | 3/4"-10  | 5.63    | 5.25    | 0.13 | 3.00 |
| A4021 | 21.00 | 16.03 | 3.75 | 1.19 | 6.50 | 0.94 | 6.50 | 1"-14   | 0.75 | 0.31 | 3/4"-10  | 7.13    | 6.63    | 0.13 | 3.00 |
| A4024 | 24.00 | 16.03 | 3.75 | 1.19 | 6.50 | 0.94 | 6.50 | 1"-14   | 0.75 | 0.31 | 3/4"-10  | 7.13    | 6.63    | 0.13 | 3.00 |

**SPECIFICATIONS CONTINUED**

| Model | Jaw Travel | Max Drawbar Force (lb.) | Max RPM | Wedge Travel (in.) | Total Compensation | Weight (lb.) |
|-------|------------|-------------------------|---------|--------------------|--------------------|--------------|
| A4006 | 0.25       | 1900                    | 4000    | 1.00               | 0.13               | 26           |
| A4008 | 0.31       | 3300                    | 3500    | 1.25               | 0.13               | 55           |
| A4010 | 0.38       | 6000                    | 3000    | 1.50               | 0.25               | 92           |
| A4012 | 0.38       | 7000                    | 2500    | 1.50               | 0.25               | 133          |
| A4015 | 0.38       | 10000                   | 2000    | 1.50               | 0.25               | 218          |
| A4018 | 0.38       | 10000                   | 1500    | 1.50               | 0.25               | 331          |
| A4021 | 0.50       | 10000                   | 1200    | 2.00               | 0.25               | 570          |
| A4024 | 0.50       | 10000                   | 1000    | 2.00               | 0.25               | 748          |

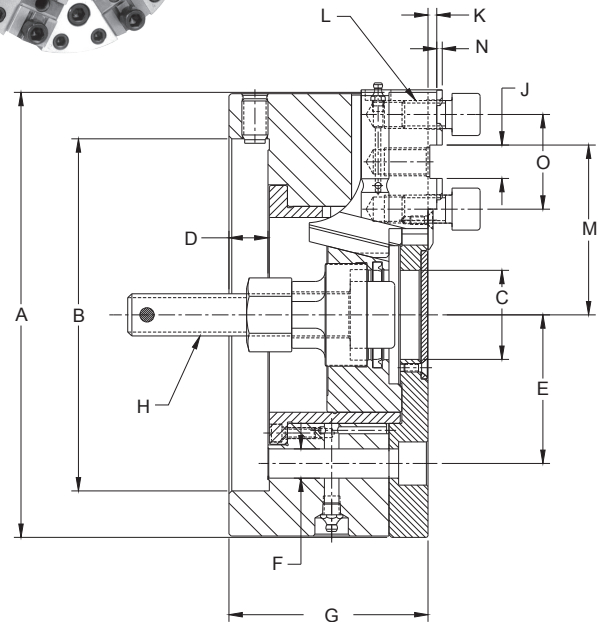
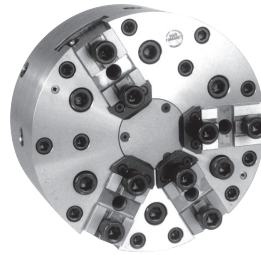
Actuation Packages may be needed. Measurements in inches unless otherwise indicated.

### FEATURES AND BENEFITS:

- Adjust-Tru® Precision! Dead-zero precision mounting features for "near-zero" runout
- Holds both round and square parts for greater flexibility and less machine down time
- Extended master jaws bear against front plate to virtually eliminate "bell mousing"
- Wide keyways to increase bearing surfaces, lessen wear and increase stability
- Extremely rugged and precise – designed for easy maintenance
- Hardened and ground steel wear surfaces increase service life
- Guaranteed repeatability of .001" TIR or better on duplicate part production
- Wear plates under master jaws are easily shimmed or replaced to restore original accuracy
- Hardened replaceable wedge bushings available for factory or field replacement; simple grinding restores wedge to original fit
- 4 to 1 mechanical advantage

### NOTES:

- Featured with tongue and groove master jaws; other styles available
- Available with or without a Thru Hole
- 2-Jaw, 3-Jaw or 2/3-Jaw styles available
- Parts available for previous models
- Also available in lightweight aluminum body
- Adjust-Tru® power chuck mounting plate required
- Made in the USA



| SUPER LIFE 2/3-JAW COMBINATION POWER CHUCK |    |       |      |      |      |      |      |       |      |      |         |         |         |      |      |
|--------------------------------------------|----|-------|------|------|------|------|------|-------|------|------|---------|---------|---------|------|------|
| Model                                      | A  | B     | C    | D    | E    | F    | G    | H     | J    | K    | L       | M (max) | M (min) | N    | O    |
| A4610                                      | 10 | 7.91  | 2.00 | 0.88 | 3.38 | 0.69 | 4.47 | 1"-14 | 0.75 | 0.19 | 5/8"-11 | 3.81    | 3.44    | 0.13 | 2.13 |
| A4612                                      | 12 | 7.91  | 2.00 | 0.88 | 3.38 | 0.69 | 4.47 | 1"-14 | 0.75 | 0.19 | 5/8"-11 | 4.50    | 4.13    | 0.13 | 2.50 |
| A4615                                      | 15 | 11.78 | 3.19 | 0.94 | 4.63 | 0.78 | 5.16 | 1"-14 | 0.75 | 0.28 | 3/4"-10 | 5.63    | 5.25    | 0.13 | 3.00 |
| A4618                                      | 18 | 11.78 | 3.19 | 0.94 | 4.63 | 0.78 | 5.16 | 1"-14 | 0.75 | 0.28 | 3/4"-10 | 5.63    | 5.25    | 0.13 | 3.00 |
| A4621                                      | 21 | 16.03 | 3.75 | 1.19 | 6.50 | 0.94 | 6.50 | 1"-14 | 0.75 | 0.31 | 3/4"-10 | 7.13    | 6.63    | 0.13 | 3.00 |
| A4624                                      | 24 | 16.03 | 3.75 | 1.19 | 6.50 | 0.94 | 6.50 | 1"-14 | 0.75 | 0.31 | 3/4"-10 | 7.13    | 6.63    | 0.13 | 3.00 |

| SUPER LIFE 2/3-JAW COMBINATION POWER CHUCK |            |                        |              |         |              |
|--------------------------------------------|------------|------------------------|--------------|---------|--------------|
| Model                                      | Jaw Travel | Max Drawbar Force (kg) | Wedge Travel | Max RPM | Weight (lb.) |
| A4610                                      | 0.38       | 9000                   | 1.5          | 2600    | 92           |
| A4612                                      | 0.38       | 10500                  | 1.5          | 2200    | 133          |
| A4615                                      | 0.38       | 15000                  | 1.5          | 1500    | 218          |
| A4618                                      | 0.38       | 15000                  | 1.5          | 1200    | 331          |
| A4621                                      | 0.50       | 15000                  | 2.0          | 1000    | 570          |
| A4624                                      | 0.50       | 15000                  | 2.0          | 900     | 748          |

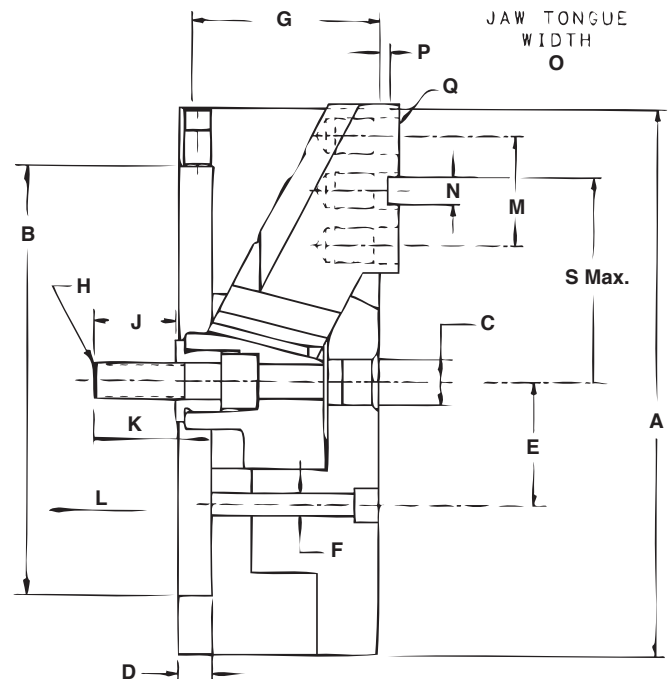
Measurements in inches unless otherwise indicated. Actuation Packages may be needed.

## FEATURES AND BENEFITS:

- Adjust-Tru® Precision! Dead-zero precision mounting features for “near-zero” runout
- 100% more gripping power than conventional chucks
- Perfect match for single or multiple spindle machines making heavy cuts on precision work
- Angular jaws on wider keyway plus heavy-duty wedge offer strength and rigidity for maximizing gripping power from beginning to end of jaw travel
- Provides positive end location of parts by holding work solidly against work stops

## NOTES:

- Also available in 3-Jaw
- Parts available for previous models
- Adjust-Tru® power chuck mounting plate required
- Made in USA



**2-JAW PULL-BACK POWER CHUCK**

| Part # | Chuck Size | A     | B     | C    | D    | E    | F     | G    | H        | J    | K    | L    | M    | N    | O    | P MIN | P MAX |
|--------|------------|-------|-------|------|------|------|-------|------|----------|------|------|------|------|------|------|-------|-------|
| 3806   | 6          | 6.50  | 4.78  | 0.75 | 0.63 | 2.06 | 0.469 | 3.06 | .625"-18 | 1.25 | 2.25 | 1.13 | 1.50 | 0.50 | 0.31 | 0.31  | 0.16  |
| 3808   | 8          | 8.25  | 6.16  | 0.88 | 0.66 | 2.63 | 0.530 | 3.75 | .625"-18 | 1.75 | 2.53 | 1.28 | 1.75 | 0.50 | -    | 0.31  | 0.16  |
| 3810   | 10         | 10.00 | 7.91  | 0.88 | 0.88 | 2.63 | 0.530 | 4.72 | 1"-14    | 2.66 | 3.69 | 1.69 | 2.13 | 0.75 | -    | 0.34  | 0.16  |
| 3812   | 12         | 12.00 | 7.91  | 0.88 | 0.88 | 3.38 | 0.660 | 5.13 | 1"-14    | 2.66 | 3.69 | 1.69 | 2.50 | 0.75 | -    | 0.38  | 0.19  |
| 3815   | 15         | 15.00 | 11.78 | 1.25 | 0.94 | 4.63 | 0.780 | 5.50 | 1"-14    | 2.25 | 3.19 | 1.69 | 3.00 | 0.75 | -    | 0.58  | 0.38  |
| 3818   | 18         | 18.00 | 11.78 | 1.25 | 0.94 | 4.63 | 0.780 | 6.00 | 1"-14    | 1.50 | 2.69 | 1.69 | 3.00 | 0.75 | -    | 0.58  | 0.31  |
| 3821   | 21         | 21.00 | 16.03 | 2.00 | 1.19 | 6.50 | 0.940 | 7.94 | 1"-14    | 1.75 | 4.00 | 2.28 | 3.00 | 0.75 | -    | 0.58  | 0.31  |
| 3824   | 24         | 24.00 | 16.03 | 2.00 | 1.19 | 6.50 | 0.940 | 7.94 | 1"-14    | 1.75 | 4.00 | 2.28 | 3.00 | 0.75 | -    | 0.58  | 0.31  |

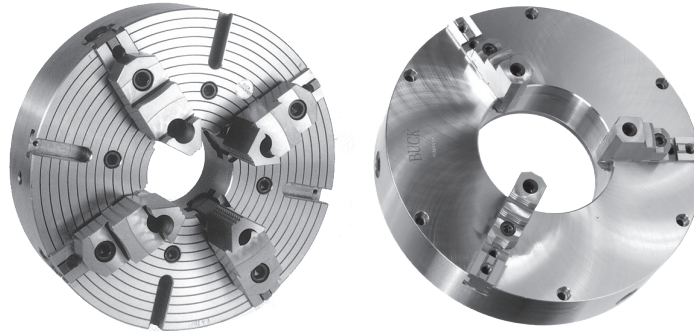
**SPECIFICATIONS CONTINUED**

| Part # | Q        | R | S MAX | Jaw Travel (in.) | Wedge Travel (in.) | Max. Drawbar Force (kg) | Max. RPM | Weight (lb.) |
|--------|----------|---|-------|------------------|--------------------|-------------------------|----------|--------------|
| 3806   | .437"-14 | 1 | 2.44  | 0.25             | 1.13               | 6000                    | 3000     | 26           |
| 3808   | .750"-16 | 1 | 3.06  | 0.28             | 1.28               | 10000                   | 2500     | 55           |
| 3810   | .875"-14 | 1 | 3.81  | 0.38             | 1.69               | 15000                   | 2000     | 92           |
| 3812   | .875"-14 | 1 | 4.50  | 0.38             | 1.69               | 18000                   | 1700     | 133          |
| 3815   | 1"-14    | 1 | 5.63  | 0.38             | 1.69               | 25000                   | 1400     | 218          |
| 3818   | 1"-14    | 2 | 5.63  | 0.38             | 1.69               | 25000                   | 1100     | 331          |
| 3821   | 1"-14    | 2 | 7.13  | 0.50             | 2.28               | 25000                   | 1080     | 570          |
| 3824   | 1"-14    | 3 | 7.13  | 0.50             | 2.28               | 25000                   | 900      | 748          |

Actuation Packages may be needed. Measurements in inches unless otherwise indicated.



BUCK Chuck offers a wide variety of heavy duty oil country chucks. Below are the most standard offerings. However, if you don't see what you are looking for here, please let us know. We can provide chucks up to 80", both manual and power operated.



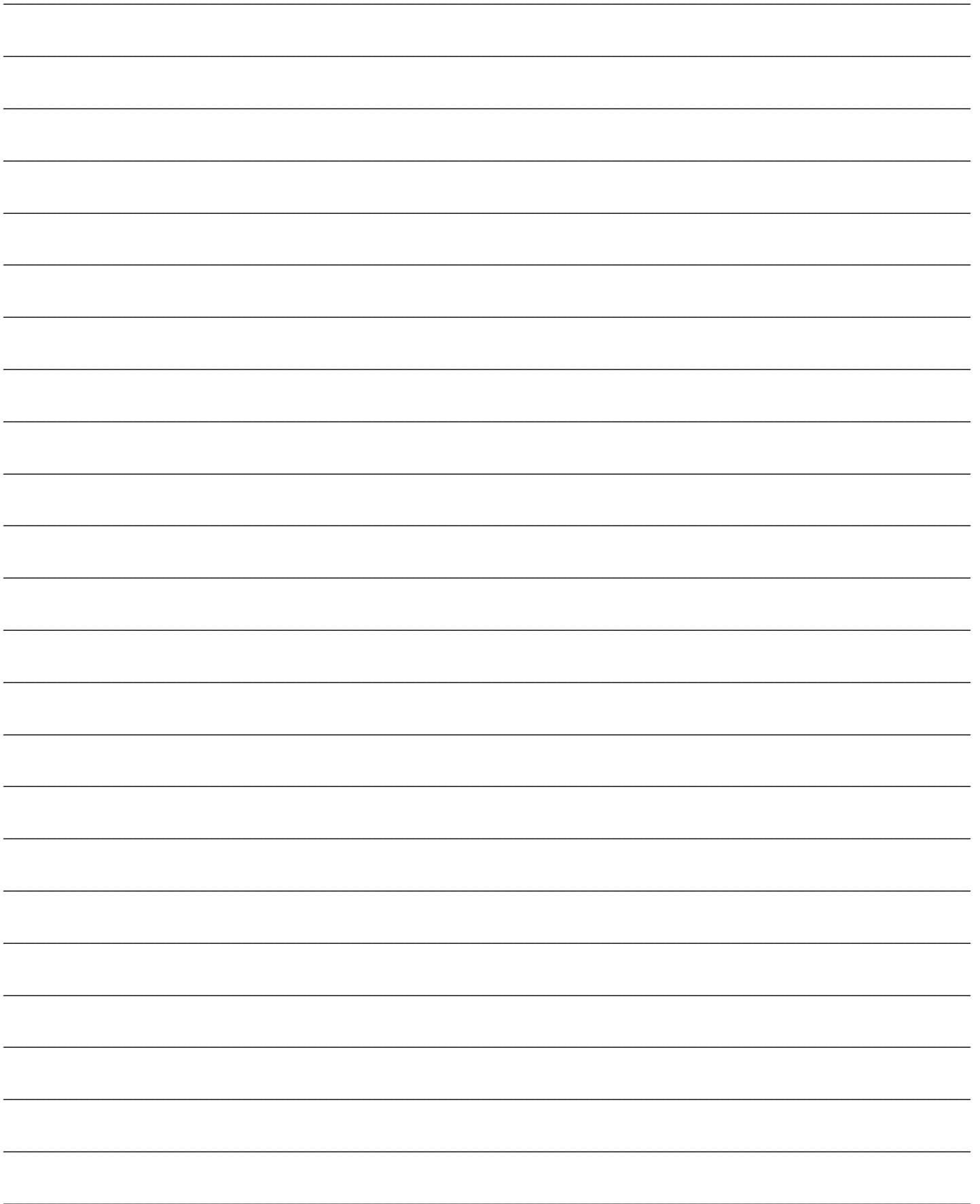
## 3 JAW HEAVY DUTY OIL COUNTRY SCROLL CHUCKS

| Chuck Dia.<br>(in) | Spindle Mount | Thru-Hole | Max RPM | Clamp Range<br>(in) | Grip Force<br>(lbf) | Weight<br>(lbs) | Load Capacity<br>(lb) |
|--------------------|---------------|-----------|---------|---------------------|---------------------|-----------------|-----------------------|
| 20"                | A2-11         | 7.50      | 1000    | 1.77-19.68          | 16300               | 560             | 5200                  |
| 20"                | A2-15         | 8.00      | 1000    | 1.77-19.68          | 16300               | 560             | 5200                  |
| 25"                | A2-15         | 10.50     | 850     | 3.15-24.50          | 18040               | 630             | 7800                  |
| 25"                | A2-20         | 12.50     | 850     | 6.30-24.80          | 18040               | 630             | 7800                  |
| 32"                | A2-15         | 10.50     | 600     | 5.12-31.50          | 19140               | 1200            | 10400                 |
| 32"                | A2-20         | 12.50     | 600     | 7.09-31.50          | 19140               | 1200            | 10400                 |

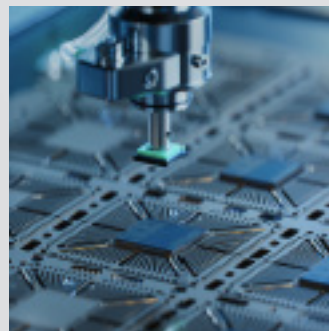
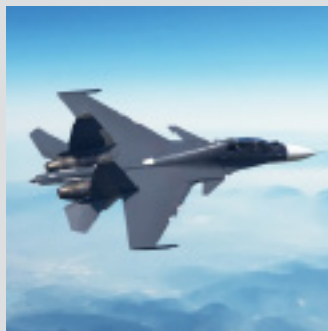
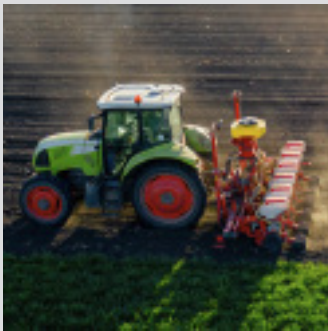
## 4 JAW HEAVY DUTY OIL COUNTRY INDEPENDENT CHUCKS

| Chuck Dia.<br>(in) | Spindle Mount | Thru-Hole | Max RPM | Clamp Range<br>(in) | Grip Force<br>(lbf) | Weight<br>(lbs) | Load Capacity<br>(lb) |
|--------------------|---------------|-----------|---------|---------------------|---------------------|-----------------|-----------------------|
| 20"                | A2-11         | 6.50      | 1000    | 1.77-19.68          | 7057                | 450             | 9900                  |
| 20"                | A2-15         | 8.00      | 1000    | 1.77-19.68          | 7057                | 450             | 9900                  |
| 25"                | A2-15         | 10.50     | 850     | 1.97-24.80          | 8160                | 630             | 14300                 |
| 25"                | A2-20         | 12.50     | 850     | 3.94-24.80          | 8160                | 630             | 14300                 |
| 32"                | A2-15         | 10.50     | 600     | 5.12-31.50          | 9040                | 1287            | 18700                 |
| 32"                | A2-20         | 12.50     | 600     | 7.09-31.50          | 9040                | 1287            | 18700                 |

Larger sizes and alternate mounts available.



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