

NUMERICAL INDEX

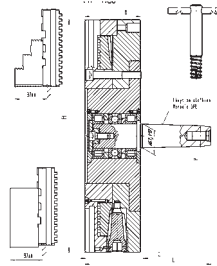
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LARGE THRU-HOLE CHUCKS
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EXTRA HEAVY DUTY OIL COUNTRY CHUCKS
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PNEUMATIC SELF-CONTAINED CHUCKS
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QUICK CLAMPING SCROLL CHUCKS
3 & 6 Jaw
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SCROLL CHUCKS for DRILL SHARPENING
6 Jaw
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5C & 16C COLLET CHUCKS
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TOP QUALITY BENCH VISES
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Manual Chuck Selection Process

Chuck Outside Diameter

inch	2	3	4	5	6-1/4	8	10	12-1/2	15-3/4	20	25	32	36	40	49
mm	60	80	100	125	160	200	250	315	400	500	630	800	915	1000	1250

Type of Chuck

Type of Chuck	Plain Back *	Direct Mount
Self-Centering (Scroll) Chuck		
SET-TRU Chuck		N/A
Independent Chuck		
Combination Chuck		N/A
5C Collet Chuck (manual)		
5C Collet Chuck (power operated)		
16C Collet chuck		N/A
Rotating with MT Shank	N/A	MT Shank
Quick Clamping		N/A
Special		

* See type of mounting to select proper adapter plate.

Chuck Body Materials

Semi-steel	
Cast steel body	
Forged steel body	
Aluminium body	
Special	

Number of Chuck Jaws

Two Jaw (self-centering only)	
Three Jaw (self-centering only)	
Four Jaw (self-centering, combination and independent)	
Six-jaw (self-centering only)	

Type of Chuck Jaws

Two-piece reversible hard jaws (std. on 3 & 4-jaw steel chucks & SET-TRU chucks)	
Set of OD & Set of ID hard solid jaws (self-centering chucks only)	
Hard Solid Reversible Jaws (4-jaw independent chucks only)	
Soft Top Jaws (require 2-pc jaws on chuck)	
Soft Solid Jaws (3-jaw and 4-jaw scroll chucks, combination chucks)	
Special	

Type of mounting (Lathe Spindle Nose) for Chucks and Adapters

Plain Back								
Short Taper "A1 or A2"	-	4	5	6	8	11	15	20
Short Taper "D1"	3	4	5	6	8	11	15	-
Short Taper "C" (DIN)	-	4	5	6	8	11	-	-
Long Taper "L"	L00	L0	L1	L2	L3	-	-	-
Threaded standard	1"-10	1-1/2"-8	2-3/16"-6	2-1/4"-8	2-3/4"-8	M39x4		
Threaded Hardinge	2-3/16"-10							
5C Adapters	-	4"	5"	6"	-	-	-	-
MT Adapters	MT3	MT4	MT5	-	-	-	-	-
Special Adapters								

Chuck Working Parameters

Min. Chuck Whole Diameter	
Max. RPM	
Max. Weight of Workpiece Lbs.	
Workpiece Diameter max-min.	
Workpiece Length	
Additional Workpiece Support (with or without additional support)	

Proper identification of all Chuck Parameters assists with recommendations, options, and helps eliminate mis-applications and returns.

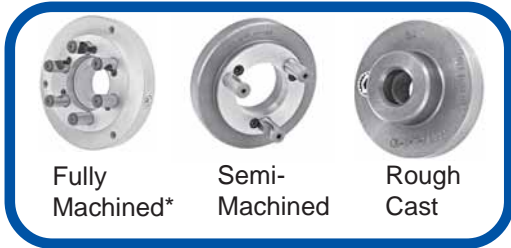


Application of Chucks & Centers

Lathe Chucks



Adapter Plates (Chuck Adapters)



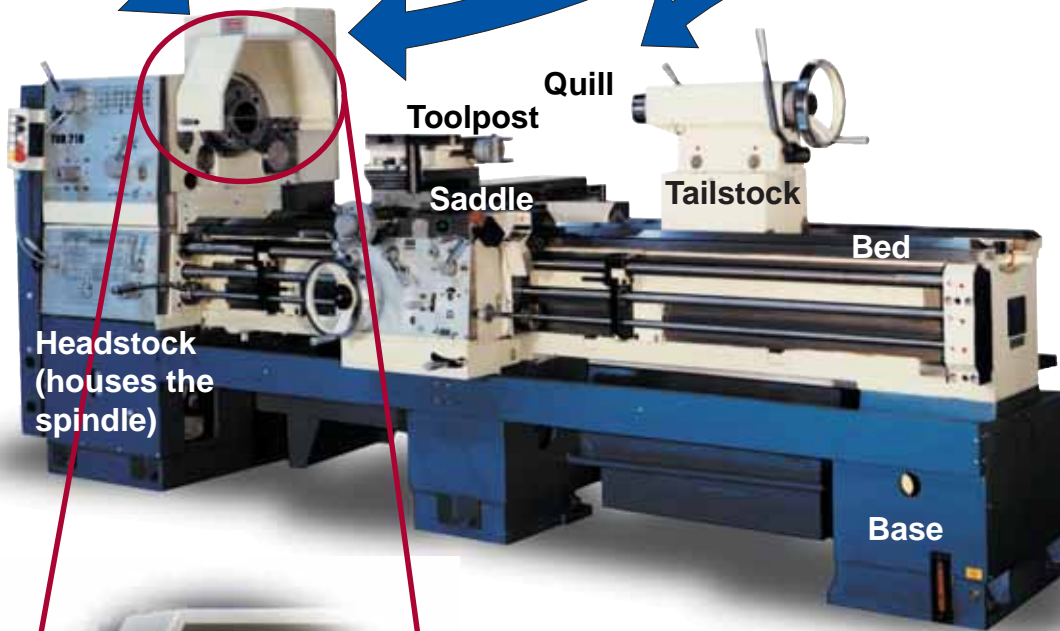
*See page 61.

Plain Back Chuck

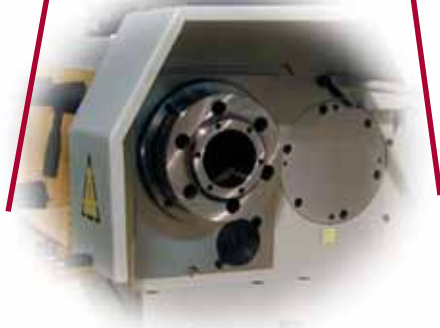
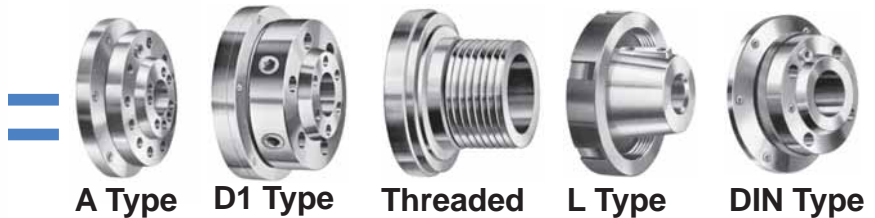
Direct Mount Chuck

Chuck with Adapter

Rotating Chucks, Live Centers & Dead Centers



Types of Spindle Noses

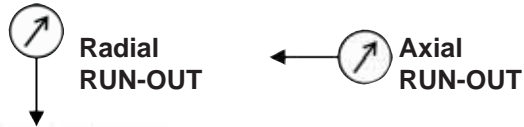


Spindle Noses

Determining the proper spindle type and size

BISON Chucks meet all of the requirements of ASA Standard B5.9-1960. For spindle nose accuracy (T.I.R.) see page 150.

If further assistance is desired, please contact Bison at 1-800-99BISON (1-800-992-4766).



Spindle Type "A 1 & A 2"

Spindle Nose	F1	F2	B	C max.	Thread E1 = E2 UNC-3B
A-4	3.2500	-	2.5005 +.0005	7/16	7/16-14
A-5	4.1250	2.4374	3.2505 +.0005	.5625	7/16-14
A-6	5.2500	3.2500	4.1880 +.0005	.6250	1/2-13
A-8	6.7500	4.37500	5.50075 +.0005	.6875	5/8-11
A-11	9.2500	6.5000	7.75075 +.0005	.7500	3/4-10
A-15	13.0000	9.7500	11.251 +.001	.8125	7/8-9
A-20	18.2500	14.5000	16.251 +.001	.8750	1-8
A-28	25.5000	20.8750	23.001 +.001	1.000	1.1/4-7

Type A 1 is exactly as shown with tapped holes on both inner and outer bolt circles.

Type A 2 is same as shown except omit holes in inner bolt circle.



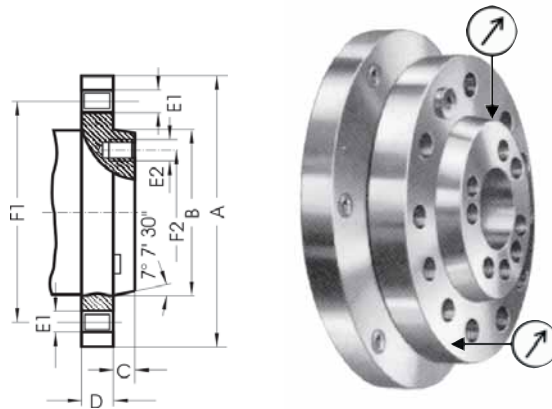
Camlock Spindle Type "D 1"

Spindle Nose	A	F	B	C max.	E	No. of Holes	Camlock Stud Dia.
D1-3	3.622	2.7820	2.1250 +.00025	7/16	.5937	3	9/16
D1-4	4.606	3.2500	2.5005 +.0005	7/16	.6562	3	5/8
D1-5	5.748	4.1250	3.2505 +.0005	1/2	.8750	6	3/4
D1-6	7.126	5.2500	4.1880 +.0005	9/16	1.000	6	7/8
D1-8	8.858	6.7500	5.50075 +.0005	5/8	1.125	6	1
D1-11	11.732	9.2520	7.75075 +.0005	11/16	1.250	6	1-3/16
D1-15	15.866	13.0000	11.251 +.001	3/4	1.375	6	1-3/8

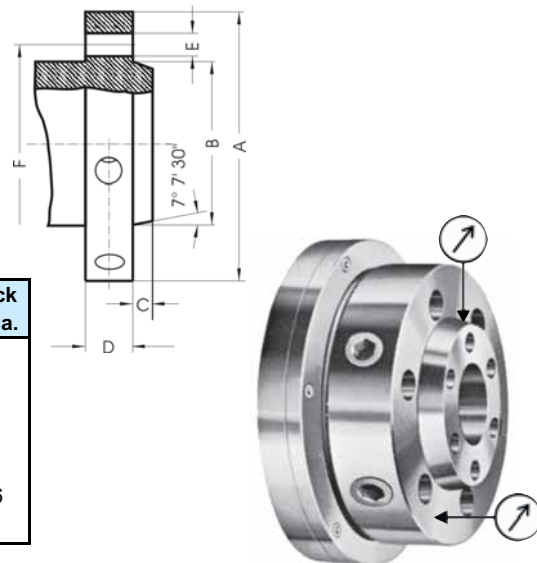
Note: Camlock stud length is adjustable to suit spindle cam.

Selecting the chuck mounting:

- Choose from the types shown below.
- For the short taper spindle noses Type A, D & C (DIN) measure the pilot diameter and length (sizes B and C), bolt circle diameter (size F1 & F2) and diameter of the holes (size E1 & E2).
In the case of A type mount check the number of bolt circles (one for A2 mount or two for A1 mount). All chucks with A1 mount can be installed on A1 spindle nose only.
All chucks with A2 mount can be installed on A1 or A2 spindle noses.
- For the long taper spindle noses Type L, check pilot diameter, length and thread size (size A,C & B).
- For the threaded spindle noses, check the thread diameter, number of threads per inch and length (sizes A and E), pilot diameter and length (sizes B and D), plus overall length (size F1).



USAS B5.9 - 1967



USAS B5.9 - 1967



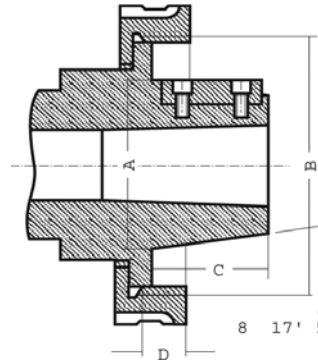
Spindle Noses

Determining the proper spindle type and size



Long Taper Key Drive Spindle Type "L"

Spindle Nose	Thread B	C	A	Key
L00	3-3/4" - 6	2	2.750	3/8x3/8x1-1/2
L0	4-1/2" - 6	2-3/8	3.250	3/8x3/8x1-3/4
L1	6" - 6	2-7/8	4.125	5/8x5/8x2-3/8
L2	7-3/4" - 5	3-3/8	5.250	3/4x3/4x2-7/8
L3	10-3/8" - 4"	3-7/8	6.500	1x1x3-1/4

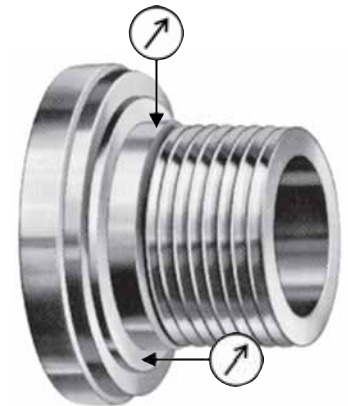
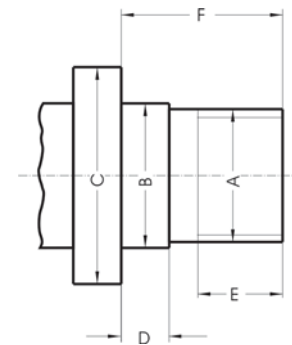


USAS B5.9 - 1967



Threaded Spindle

Spindle Nose A	B	F1	D	E
1" - 10 UNS-2B	1.015	1.500	.4375	1.000
1-1/2" - 8 UN-2B	1.515	1.500	.4375	1.000
2-3/16" - 10 UN-2B	2.2025	1.750	.5625	1.125
2-1/4" - 8 UN-2B	2.260	1.750	.5625	1.125
2-3/16" - 6 UN-2B	2.2025	1.750	.5625	1.125
2-3/4" - 8 UN-2B"	2.760	2.0625	.6875	1.3125

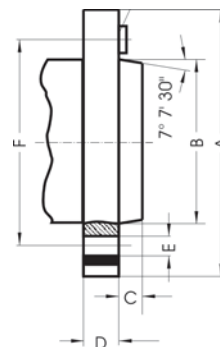


Note! Check your spindle dimensions before you place the order for the chuck or adaptor plate. Check the Spindle RUN-OUT on the diameter "B" and on the flange.



German Standard DIN 55027 Spindle Type "C"

Spindle Nose	F	B	C max.	E	No. of Holes
C - 4	3.2500	2.5005	.4331	.83	3
C - 5	4.1250	3.2505	.5118	.83	4
C - 6	5.2500	4.1880	.5512	.91	4
C - 8	6.7500	5.50075	.6299	1.14	4
C - 11	9.2520	7.75075	.7087	1.42	6

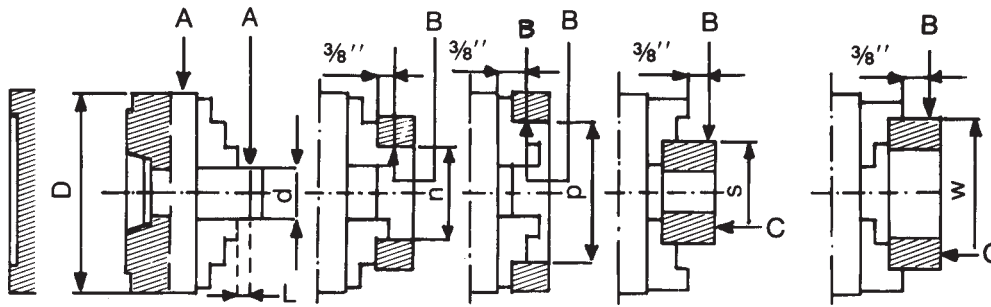


DIN 55027 (55022)

This spindle nose is provided with a short tapered flange like the American spindle noses A and D. Spindle flange has a number of mounting holes (3, 4 or 6) into which the lock studs of the chuck or adaptor plate can be inserted and locked.



Self-Centering Scroll Chuck Accuracy



All allowable runouts which are specified concern measurements at three different jaw openings d (1, 2 & 3).

Size of Chuck D	Universal and Precision Chucks Series 3200, 3500, 3600, and 3700											
	d			L	n	p	s	w*	w**	Radial Runout		Axial Runout
	1	2	3							A	B	C
3-1/2"	0.39	—	0.55	1.57	1.57	2.36	1.38	2.48	—	0.0008	0.001	0.0006
4"	0.39	0.55	0.71	1.57	1.57	2.95	1.97	3.15	—	0.0008	0.001	0.0006
5"	0.71	0.98	1.18	2.36	1.97	3.94	2.44	3.94	4.72	0.0012	0.0014	0.0008
6-1/4"	0.71	1.18	1.57	2.36	1.97	5.31	3.46	3.94	5.9	0.0012	0.0014	0.0008
8"	1.18	1.57	2.08	3.15	3.15	6.38	3.78	6.3	7.28	0.0016	0.0018	0.001
10"	1.18	2.08	2.95	3.15	3.15	7.87	5.9	6.3	8.86	0.0016	0.0018	0.001
12-1/2"	2.08	2.95	3.94	4.72	4.92	9.92	8.27	9.84	11.81	0.002	0.0022	0.0012
15-3/4"	2.08	3.94	4.92	4.72	4.92	11.1	9.84	9.84	13.78	0.0024	0.0025	0.0012
20"	2.95	3.94	4.92	6.3	7.87	11.1	11.81	15.75	15.75	0.004	0.004	0.002
25"	2.95	4.92	6.3	6.3	7.87	12.79	15.75	15.75	15.75	0.004	0.004	0.002
31-1/2"	6.3	7.87	9.84	6.3	12.8	19.7	15.75	19.7	19.7	0.0059	0.0059	0.0024

* For solid jaws ** For two piece jaws

Permissible Spindle Runout

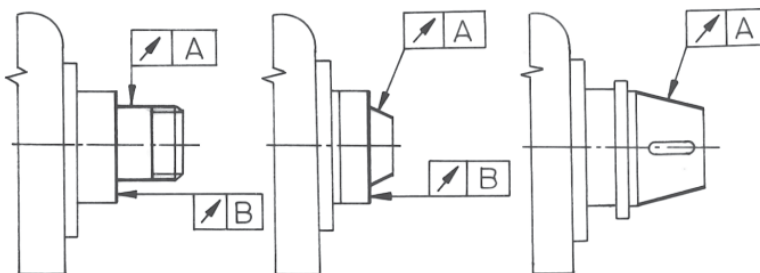
Chuck Dia.	Spindle Run Out
3500 Steel Body Chucks	
3" - 16"	.00012" max.
20" - 25"	.0002" max.
3200 Semi Steel Body	
3" - 6"	.00012" max.
8" - 32"	.0002" max.

PLEASE NOTE

To obtain the specified clamping accuracy of a chuck mounted on a machine tool, it is necessary to:

- reduce play in the spindle bearings to the allowable minimum
- ensure the machine spindle nose runout does not exceed the values specified.
- meet the basic requirements for correct mounting of the chuck on the spindle nose.

Follow the chuck MANUAL!



Threaded

A, D & DIN

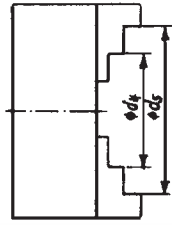
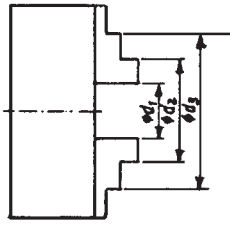
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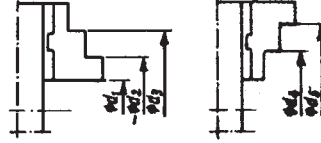
Clamping Ranges

For Self-Centering Scroll Chucks

Solid Jaws (S)



Two-piece Jaws (R)



Chuck Dia.		d 1		d 2		d3 MAX.		d4 MAX.		d5 MAX.	
		JAWS									
mm	inch	solid	reversible	solid	reversible	solid	reversible	solid	reversible	solid	reversible
60		.02-.95	–	.79-1.65	–	1.46-2.36	–	.79-1.65	–	1.50-2.36	–
80	3-1/4"	.08-1.06	–	.87-1.81	–	1.77-2.72	–	.98-1.97	–	1.89-2.80	–
100	4"	.12-1.30	–	.98-2.20	–	2.20-3.43	–	1.26-2.44	–	2.44-3.27	–
125	5"	.12-1.97	.12-1.97	1.37-2.91	1.34-2.99	2.83-4.53	2.95-4.65	1.54-3.27	2.05-3.78	3.15-4.92	3.74-4.92
160	6-1/4"	.12-2.52	.12-2.52	1.65-3.94	1.65-3.82	3.70-6.06	3.46-5.75	1.97-4.21	2.44-4.76	3.86-6.30	4.53-6.30
200	8"	.16-3.54	.16-3.54	2.05-5.31	1.97-5.12	4.72-7.95	4.13-7.48	2.36-5.71	2.83-6.14	5.12-7.87	5.24-7.87
250	10"	.20-4.65	.20-4.65	2.44-6.85	2.28-6.50	5.70-10.43	4.92-9.25	3.03-7.40	3.38-7.75	6.30-9.84	6.30-9.84
315	12-1/2"	.39-5.16	.20-5.16	3.07-7.87	2.56-7.16	6.77-11.77	5.70-10.43	3.54-8.46	4.06-8.90	7.48-12.40	7.48-12.40
400	15-3/4"	.39-7.09	.39-7.09	3.35-9.92	2.83-8.98	8.27-14.96	6.50-12.95	4.05-10.71	5.00-11.57	9.05-15.75	9.05-15.75
500	20"	.79-9.25	.79-9.25	4.72-13.19	4.72-16.14	9.65-18.74	7.87-19.10	5.51-14.06	4.33-15.75	10.87-19.69	7.48-19.69
630	25"	1.18-13.19	1.18-13.19	6.30-18.31	5.51-23.23	12.80-24.80	8.27-26.18	7.09-19.17	4.72-22.44	13.58-24.80	7.88-24.80
800	31-1/2"	5.9-18.98	5.9-18.98	11.10-24.17	9.92-28.99	17.64-30.71	12.91-31.97	11.89-24.96	9.45-28.5	18.43-31.50	12.44-31.50

S = Solid Jaws R = Reversible Jaws

To avoid a chuck gripping problem select the proper Hard Top Jaws or Soft Top Jaws



Jaw for Heavy Machining



Jaws for Special Applications



Jaw for Finishing



Chuck Safety Parameters

Maximum length of workpiece, clamped into the chuck jaws, without additional support.

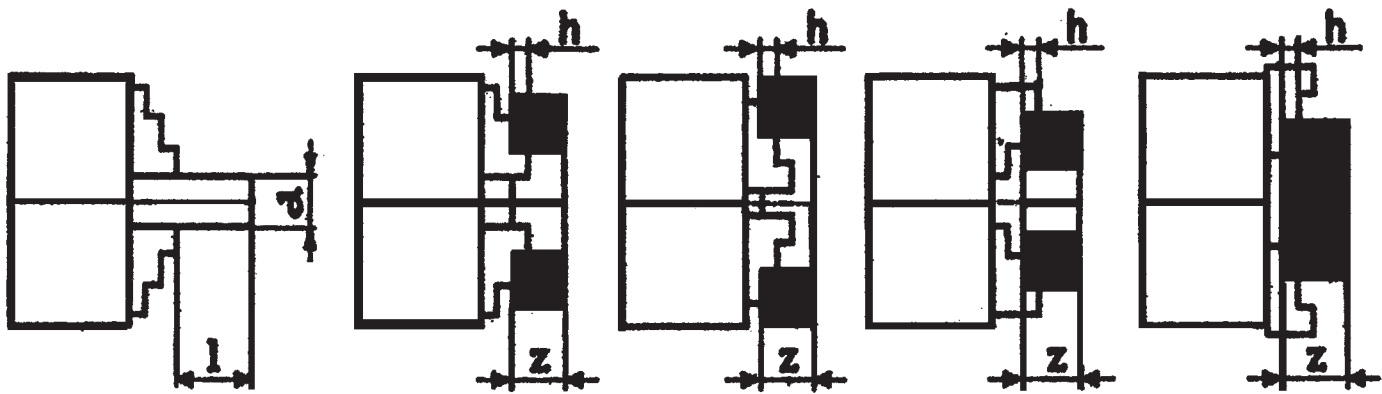
Chuck Size	3-1/4	4	5	6-1/4	8	10	12-1/2	15-3/4	20	25	32
l	1,2d					1,5d			1d		
z	4h										

d - Workpiece diameter

h - Height of the clamping jaw step

l & z - Maximum length of workpiece

See chuck manual for more information.



Total Gripping Force of all BISON self-centering chucks (lbs)

Size of chuck (in.)	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	31-1/2"
Steel & Semi-Steel Chucks	2200	3750	5300	6800	8200	10000	12000	14300	16000	17700	19800

Recommended maximum speeds for self-centering chucks (RPM)

Size of chuck (in.)	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	31-1/2"
Universal chucks (Semi-steel body)	4000	3500	3200	3000	2500	2000	1500	1000	700	500	300
Precision chucks (Steel body)	6000	5200	4800	4500	4000	3500	2800	2000	1200	1000	450

Value of balancing - for precision self-centering chucks only

Size of chuck (in.)	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Balancing (ounce-inch)	0.15	0.22	0.32	0.44	0.62	0.87	1.25	1.94	4.16	8.88



Lathe Chuck Safety Conditions

Due to chuck rotating speeds and cutting forces during machining, care should be taken to insure the proper and safe use of your BISON chuck.

Cleaning and machining should be done often for safety purposes as well as to provide a long work life for your chuck. Proper maintenance will insure your satisfaction. Before you start to operate your BISON lathe chuck, please read the following recommendations:

- Read the chuck manual.
- Do not start the lathe until all is clear. A Collision between the chuck and lathe will cause damage to both.
- Do not use the chuck on heavy work where the chuck jaws project appreciably from the chuck body. Use the correct size chuck for the job. Refer to the tables on **page 9**.
- Do not clamp long work pieces in the chuck without additional support, this can cause heavy damage to your lathe and work environment. See table on **page 10**.
- Always remove the chuck wrench before starting the machine.
- Do not remove the safety spring from the chuck wrench.
- Do not tamper with the chuck. If an inaccuracy is found, check the spindle nose or adapter plate for true-running and make sure there is no dirt or foreign matter between the mounting faces.
- Never exceed maximum speed (RPM) of the chuck. The Max RPM is stamped on the chuck face. Refer to the table on **page 10**.
- Never operate the chuck if any parts are damaged, missing or cracked.
- Periodically inspect and service chucks for wear to avoid inadequate workholding conditions.
- Be sure top jaws are securely bolted to the master jaws.
- Never do any unauthorized chuck modifications.
- Always keep your chuck clean and lubricated.
- For the best **chuck gripping** results try the BISON recommended chuck grease: Grease Code No. **7-799-025**



LIMITED WARRANTY

BISON offers a one year limited warranty.

BISON LATHE CHUCKS are warranted by BISON to the original user against defects in workmanship or materials under normal use for one year after date of purchase. Any part which is determined, by Toolmex, to be defective in material or workmanship can be returned to an authorized service location designated by Toolmex, shipping costs prepaid.

- Each chuck must be returned complete and in it's original box.
- Before returning, an authorization must be obtained by your distributor from Toolmex Corporation.

CHUCKS WITHOUT PROPER AUTHORIZATION & ORIGINAL PACKAGING WILL BE RETURNED TO THE SENDER!

For more information please refer to the chuck manual or call our customer service department at 1-800-99BISON (1-800-992-4766).

PLEASE NOTE: The data provided in this catalog represents the most accurate description of BISON products and their performance available at the time of publication. All data is subject to modification without notice.

Before you place an order carefully evaluate your production conditions. Be aware that chuck performance depends on a combination of many factors such as; RPM, weight of workpiece, diameter and length of workpiece, composition of workpiece material, speed of feed and cutting depth, gripping forces, used step of the jaws, and chuck conditions.



2,3,4 & 6 Jaw "SET-TRU" Scroll Chucks

With Fine Adjustment, Forged Steel Body, 2 & 3 pinion design.
0.0004" T.I.R.

BISON "SET-TRU" chucks can be used for many machining operations for which universal scroll chucks are unsuitable and all operations for which universal chucks are used.

6 jaws grip firmly with less pressure and less distortion per jaw. Ideal for thin wall and second operation work.

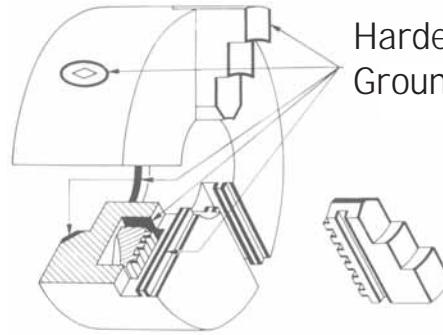
Eliminates the need for spring collets.

Outstanding accuracy, versatility and long life make BISON "SET-TRU" chucks invaluable in the modern workshop and indispensable in the toolroom.

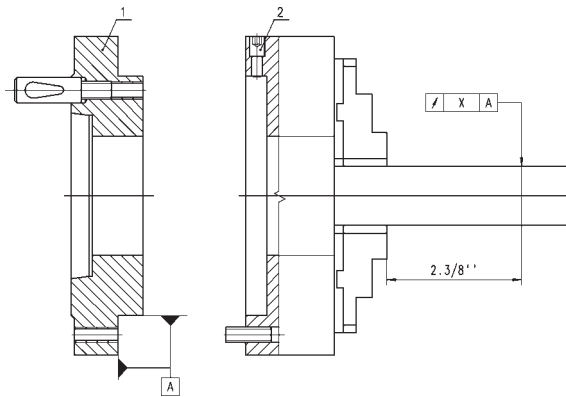
- 4 micro adjustment screws provide .0004" T.I.R. repeatability.
- 16", 20" & 25" 3 & 6 jaw chucks use 8 micro adjustment screws. *Extremely high gripping concentricity.
- 2-piece top & master jaws are American Standard Tongue & Groove.
- 4" chuck has 2 sets of solid jaws.
- Chuck body - made of high quality forged steel, is safe at high lathe speeds.
- Forged scroll fully hardened with thread flanks ground on both sides for longer life and higher accuracy.
- Each scroll is precisely balanced.
- Jaws - the teeth and guides on both sides are fully hardened and ground. *Hardened and ground bushings are pressed into the pinion seats. *3 pinions are hardened and ground.
- Each chuck is balanced within fine limits. See page 10.
- Steel mounting plates and the same size of BISON "SET-TRU" chuck are interchangeable so that one chuck can be used on different spindles. *The life of BISON "SET-TRU" chucks is approximately 2.5 times longer than universal chucks.
- The life of your BISON chuck can be extended significantly through proper maintenance - it must be cleaned on a regular basis.
- For the best gripping results try the BISON recommended chuck grease, Code No. 7-799-025.



TOP accuracy & quality



Hardened and Ground Surfaces



Adapter front view



Chuck back view



For 5C SET-TRU Collet Chucks and Rotating MT Chucks see **pages 67 and 62.**



2,3,4 & 6 Jaw "SET-TRU" Scroll Chucks

With Fine Adjustment, Forged Steel Body, 3 pinion design.



3564
3 Jaw Scroll Chucks.
Two-Sets of Hard **Solid** Jaws,
Dia. 4" to 12-1/2"
Code No. 7-866-8...



3565
3 Jaw Scroll Chucks.
Two-Piece Hard **Reversible** Jaws,
Dia. 5" to 25"
Code No. 7-866-....



3864
6 Jaw Scroll Chucks.
Two-Sets of Hard **Solid** Jaws,
Dia. 4" to 12-1/2"
Code No. 7-868-8...



3865
6 Jaw Scroll Chucks.
Two-Piece Hard **Reversible** Jaws,
Dia. 5" to 25"
Code No. 7-868-...



3765
4 Jaw Scroll Chucks.
Two-Piece Hard **Reversible** Jaws,
Dia. 6-1/4" to 12-1/2"
Code No. 7-847-....



3165
2 Jaw Scroll Chucks.
Soft Top **Reversible** Jaws,
Dia. 6-1/4" to 15-3/4"
Code No. 7-827-....

Chuck Dia.	Hole Dia.	2-Jaw		3165	3-Jaw		3565	3564	4-jaw		3765	6-Jaw		3865	3864
		RPM max.	Weight lbs.	Code No.	RPM max.	Weight lbs.	Code No.	Code No.	RPM max.	Weight lbs.	Code No.	RPM max.	Weight lbs.	Code No.	Code No.
4"	0.787	-	-	-	4200	7.3	-	7-866-8040	-	-	-	4000	9.7	-	7-868-8040
5"	1.378	-	-	-	3800	11	7-866-0500	7-866-8050	-	-	-	3000	13.7	7-868-0500	7-868-8050
6-1/4"	1.654	3000	19	7-827-0600	3500	21	7-866-0600	7-866-8060	2500	22	7-847-0600	2500	25	7-868-0600	7-868-8060
8"	2.165	2500	34	7-827-0800	3100	35	7-866-0800	7-866-8080	2200	37	7-847-0800	2200	42	7-868-0800	7-868-8080
10"	2.992	2000	57	7-827-1000	2700	59	7-866-1000	7-866-8100	1900	65	7-847-1000	1900	78	7-868-1000	7-868-8100
12-1/2"	4.055	1500	96	7-827-1200	2200	105	7-866-1200	7-866-8120	1500	119	7-847-1200	1500	128	7-868-1200	7-868-8120
15-3/4"	5.354	1000	176	7-827-1600	1800	201	7-866-1600	-	-	-	-	1500	250	7-868-1600	-
20"	7.480	-	-	-	1200	377	7-866-2000	-	-	-	-	800	397	7-868-2000	-
25"	9.921	-	-	-	1000	630	7-866-2500	-	-	-	-	700	647	7-868-2500	-

Standard Accessories:

- 2 Jaw Chucks 7-827-
 - 1 set of hard master jaws and 1 set of soft top jaws
- 3 & 6 Jaw Chucks 7-866-8... & 7-868-8...
 - 2 sets of hard solid jaws (OD & ID)
- 3 & 6 Jaw Chucks 7-866-0... & 7-868-0...
 - 1 set of hard master jaws and 1 set of hard top reversible jaws
- 4 Jaw Chucks 7-847-
 - 1 set of hard master jaws and 1 set of hard top reversible jaws

All chucks are supplied with:

- 1 wrench
- 1 set of mounting bolts
- 2 hex keys and
- 1 set of fine adjustment screws.

Optional Accessories:

Soft top jaws, solid ID & OD jaws.
Rotating Body for 4", 5" & 6".

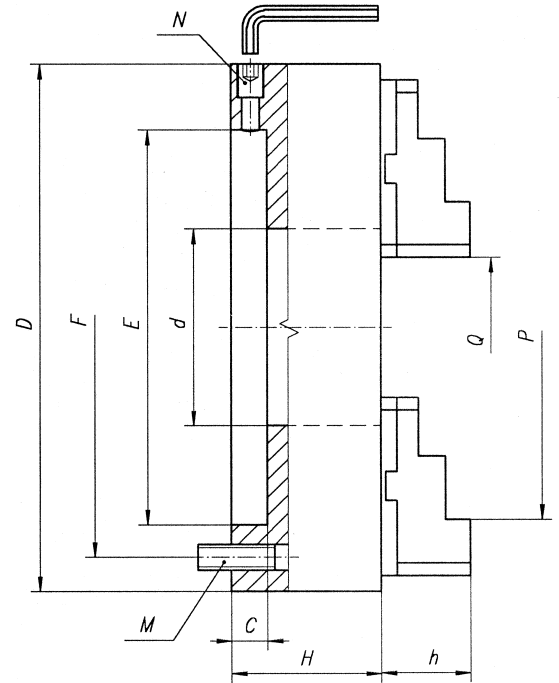
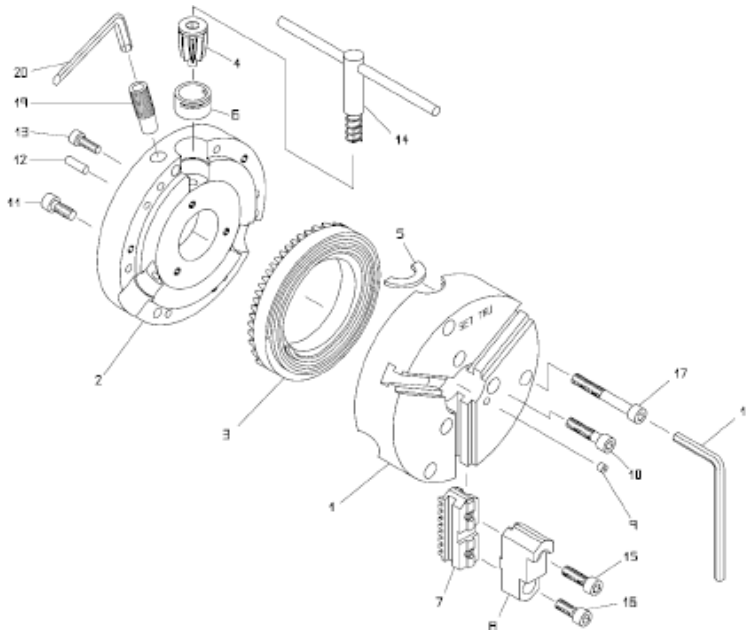
Spare Parts & Adapter Plates see **pages: 15-22.**



Do not require machining. Adapters and Set-Tru chucks are sold separately.



Three & Six - Jaw BISON "SET-TRU" Scroll Chucks With Fine Adjustment, Forged Steel Body, 3 - pinion design.



Principal Dimensions

Chuck Dia. D	F	E	Hole d min.	H	h			C	M		N	
					Two-Piece Jaws	Solid Jaws	Soft Top Jaws 2-Jaw Chucks		Thread	Qty.	Thread	Qty.
4"	3.2677	1.7717	0.787	2.677	-	0.63	-	0.51	M8x1.25	3	M12x1	4
5"	4.252	2.1654	1.378	2.362	1.575	0.787	-	0.59	M8x1.25	3	M12x1	4
6-1/4"	5.5118	3.3858	1.654	2.677	1.71	1.26	1.697	0.67	M10x1.5	3	M18x1	4
8"	6.9291	4.3307	2.165	3.071	1.77	1.142	1.776	0.71	M10x1.5	3	M18x1	4
10"	8.8188	5.7086	2.992	3.504	2.05	1.339	2.071	0.79	M12x1.75	3	M18x1	4
12-1/2"	11.2598	7.0866	4.055	3.819	2.24	1.693	2.24	0.79	M16x2	3	M18x1	4
15-3/4"	6.75	11.781	5.354	4.803	2.638	-	2.598	0.87	5/8x11	6	M18x1	8
20"	9.252	16.0299	7.48	5.669	3.11	-	-	1.18	3/4x10	6	M18x1	8
25"	13	16.0299	9.921	5.905	3.425	-	-	1.18	3/4x10	6	M18x1	8

Clamping Ranges

Jaw Opening* Two Piece Reversible Jaws				Jaw opening* Solid Jaws OD & ID			
3 & 4-Jaw		6-Jaw		3 Jaw		6 Jaw	
Q min.-max.	P max.	Q min.-max.	P max.	Q min.-max.	P max.	Q min.-max.	P max.
-	-	-	-	.12-1.30	3.26	.12-1.30	2.44-3.27
.12-1.97	4.92	.16-1.97	4.92	.12-1.97	4.92	.16-1.97	4.69
.12-2.52	6.3	.67-2.52	6.3	.12-2.52	6.3	.67-2.52	5.75
.16-3.54	7.87	.71-3.54	7.87	.16-3.54	7.95	.71-3.54	7.48
.20-4.65	9.84	.79-4.65	9.84	.20-4.65	10.1	.79-4.65	10.1
.39-5.16	12.4	.79-5.16	12.4	.39-5.16	11.8	.79-5.16	10.4
.39-7.09	15.75	.87-7.09	15.75	.39-7.09	15	-	-
.79-9.25	19.68	1.182-9.25	19.68	.79-9.25	18.7	-	-
1.18-13.2	24.8	1.57-13.2	24.8	1.18-13.2	24.8	-	-

Note:

* Workpiece diameter cannot be larger than Qmax. and Pmax. See chuck manual.

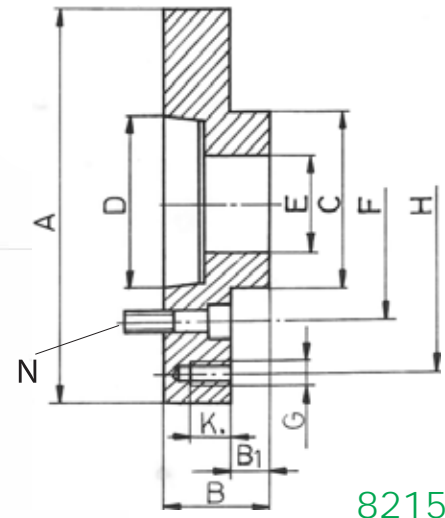


Steel Adapters

Fully Machined
For "SET-TRU" Chucks



A Type



8215

Chuck Dia.	Taper Size	D	G	d	B	E	F	M	J	C	L	N	No. of Bolts	Weight lbs.	Code No.				
5"	A4	4.92	2.5005		3.252				.87		1.42	7/16-14	4	4.8	7-874-054				
	A5	4.92	3.2505	1.378	4.126	2.164	4.252	M8-1.25	.87	.55	1.42	7/16-14		4.2	7-874-055				
	A6	6.30	4.1880		5.252				.53		1.89	1/2-13		9.1	7-874-056				
6-1/4"	A5	6.30	3.2505	1.654	4.126	3.385	5.512	M10-1.5	.82	.62	1.45	7/16-14	4	6.77	7-874-065				
	A6		-	-	-							-		1/2-13	-	7-874-066			
8"	A5	7.87	3.2505	2.165	4.126	4.330	6.929	M10-1.5	.62	.66	1.29	7/16-14	4	9.3	7-874-085				
	A6		4.1880		5.252							1.77		1/2-13	13.5	7-874-086			
10"	A5	9.84	3.2505	2.992	4.126	5.708	8.819	M12-1.75	.74	.74	1.49	7/16-14	4	17.3	7-874-105				
	A6		4.1880		5.252							1.49		1/2-13	17.3	7-874-106			
	A8		5.5007		6.748							1.81		5/8-11	20.2	7-874-108			
12-1/2"	A6	12.40	4.1880	4.055	5.252	7.086	11.260	M16-2	.74	.74	1.49	1/2-13	4	27.3	7-874-126				
	A8		5.5007		6.748							1.81		5/8-11	35.7	7-874-128			
	A11		7.7507		9.252							2.17		3/4-10	41.20	7-874-129			
15-3/4"	A6	11.75	4.1880	4.055	5.252	11.75	6.748	5/8 - 11	1.38	-	1.38	1/2-13	6	31.4	7-874-166				
	A8		5.5007		5.346							6.748		1.14	-	1.46	5/8-11	28.8	7-874-168
	A11		7.7507		5.354							9.252		1.06	-	1.89	3/4-10	35.8	7-874-169
20"	A8	16.02	5.5007	5.346	6.748	16.02	9.252	3/4 - 10	1.42	-	1.42	5/8-11	6	69	7-874-208				
	A11		7.7507		7.590							9.252		1.18	-	1.42	3/4-10	61	7-874-209
	A15		11.2505		7.480							13.000		1.18	-	2.05	7/8-9	76	7-874-215
25"	A8	16.02	5.5007	5.346	6.748	16.02	13.000	3/4 - 10	1.42	-	1.42	5/8-11	6	69	7-874-258				
	A11		7.7507		7.590			9.252				1.42		-	1.42	3/4-10	61	7-874-259	
	A15		11.2505		9.921			13.000				2.05		-	2.05	7/8-9	76	7-874-260	
	A20		16.2518		9.921			18.252				1 - 8		2.76	-	2.76	1-8	90	7-874-265

Note! These adapters are designed to mount on A1 & A2 Spindles.

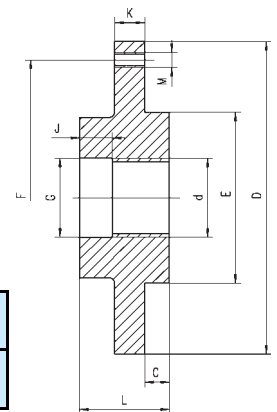
Threaded Adapters

Fully Machined
For Hardinge Lathes



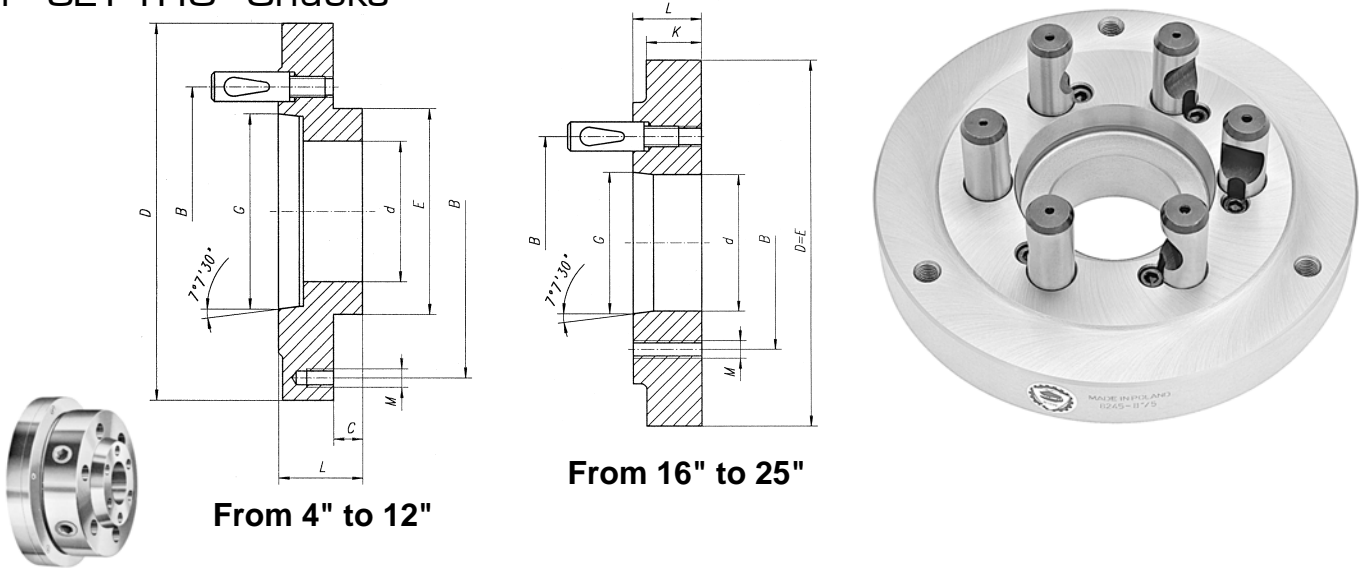
8285

Chuck Dia.	D	Thread d	G	E	F	L	C	K	M	No. of Bolts	Weight lbs.	Code No.
5"	5	2-3/16 - 10	2.1889	2.164	4.25	2.44	.55	.51	M8 x 1.25	3	7.05	7-876-054
6-1/4"	6.3			3.385	5.51	1.61	.63	.79	M10 x 1.5		7.50	7-876-064



Steel Adapters

Fully Machined
For "SET-TRU" Chucks



D-Type

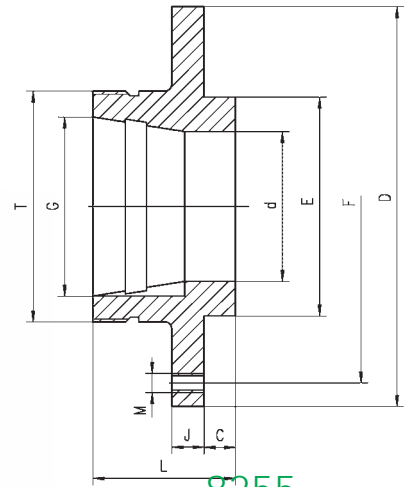
8245

Chuck Dia.	Taper Size	Studs		D	B	G	d	E	F	M	C	L	K	Weight lbs.	Code No.								
		Qty.	Dia.																				
4"	D1-3	3	9/16"	3.94	2.78	2.1250	.787	1.771	3.268	M8 x 1.25	.47	1.50	-	3.31	7-875-043								
	D1-4		5/8"	4.25	3.25	2.5005										3.97	7-875-044						
5"	D1-3	3	9/16"	4.92	2.78	2.1250	1.378	2.164	4.252	M8 x 1.25	.55	1.73	-	5.95	7-875-053								
	D1-4		5/8"	4.92	3.25	2.5005										5.73	7-875-054						
	D1-5	3/4"	5.31	4.13	3.2503	6.92								7-875-055									
	D1-6	7/8"	7.12	5.25	4.1878	13.06								7-875-056									
	D1-8	1"	-	-	-	15.00								7-875-058									
6-1/4"	D1-3	3	9/16"	6.30	2.78	2.1250	1.654	3.385	5.512	M10 x 1.5	.63	1.81	-	10.80	7-875-063								
	D1-4		5/8"	6.30	3.25	2.5005										9.92	7-875-064						
	D1-5	3/4"	6.30	4.13	3.2503	9.89								7-875-065									
	D1-6	7/8"	6.69	5.25	4.1878	13.00								7-875-066									
8"	D1-3	3	9/16"	7.87	2.78	2.1250	2.024	4.330	6.929	M10 x 1.5	.67	1.30	-	10.36	7-875-083								
	D1-4		5/8"		3.25	2.5005	2.165									10.36	7-875-084						
	D1-5	3/4"	4.13		3.2503	2.165	15.87							7-875-085									
	D1-6	7/8"	5.25		4.1878	2.165	17.64							7-875-086									
	D1-8	1"	-		-	-	20.00							7-875-088									
10"	D1-4	3	5/8"	9.84	3.25	2.6005	2.382	5.708	8.819	M12 x 1.75	.75	1.50	-	18.84	7-875-104								
	D1-5		3/4"		4.13	3.2510	3.130									17.64	7-875-105						
	D1-6	7/8"	5.25		4.1878	2.992	28.44							7-875-106									
	D1-8	1"	6.75		5.50055	2.992	32.41							7-875-108									
12-1/2"	D1-6	6	7/8"	5.25	4.1878	4.055	7.086	11.260	M16 x 2	.75	1.50	-	28.44	7-875-126									
	D1-8		1"	12.40	6.75	5.50055									4.055	7.086	11.260	M16 x 2	.75	2.24	-	47.84	7-875-128
	D1-11		1-3/16"	9.25	7.75055	4.055									7.086	11.260	M16 x 2	.75	2.52	-	52.91	7-875-129	
15-3/4"	D1-6	6	7/8"	5.25	4.1878	4.055	11.75	6.748	5/8" x 11"	-	1.38	.87	29.0	7-875-166									
	D1-8		1"	11.75	6.75	5.50055									5.358	11.75	6.748	5/8" x 11"	-	1.50	27.2	7-875-168	
	D1-11		1-3/16"	9.25	7.75055	5.358									11.75	6.748	5/8" x 11"	-	1.89	26.8	7-875-169		
20"	D1-8	6	1"	6.75	5.50055	5.358	16.02	9.252	3/4" x 10"	-	1.50	1.50	74	7-875-208									
	D1-11		1-3/16"	16.02	9.25	7.75055									7.590	16.02	9.252	3/4" x 10"	-	1.73	1.73	78	7-875-209
	D1-15		1-3/8"	13.00	11.2505	7.480									7.480	13.071	9.252	3/4" x 10"	-	2.05	2.05	83	7-875-215
25"	D1-8	6	1"	6.75	5.50055	5.358	16.02	13.071	3/4" x 10"	-	1.50	1.50	74	7-875-258									
	D1-11		1-3/16"	16.02	9.25	7.75055									7.590	16.02	13.071	3/4" x 10"	-	1.73	1.73	78	7-875-259
	D1-15		1-3/8"	13.00	11.2505	9.920									9.920	13.071	13.071	3/4" x 10"	-	2.05	2.05	83	7-875-260



Steel Adapters

Fully Machined
For "SET-TRU" Chucks



8255

L Type

Chuck Dia.	D	Taper Size	Thread T - UNS3	G	d	E	F	M	J	C	L	Weight lbs.	Code No.
5"	4.92	LO0	3-3/4 - 6	2.75	2.2	2.164	4.252	M10 x 1.5		0.55		7.5	7-879-9051
6-1/4"	6.30	L00	3-3/4 - 6	2.750	2.20	3.385	5.51	M10 x 1.5	0.79	0.63	2.56	9.0	7-879-9061
		L0	4-1/2 - 6	3.250	2.60							9.5	7-879-9062
8"	7.87	L00	3-3/4 - 6	2.750	2.20	4.330	6.93	M10 x 1.5	0.79	0.67	2.56	15.0	7-879-9081
		L0	4-1/2 - 6	3.250	2.60						2.56	15.4	7-879-9082
		L1	6 - 6	4.125	3.35						2.99	16.5	7-879-9083
10"	9.84	L00	3-3/4 - 6	2.750	2.20	5.708	8.82	M12 x 1.75	0.91	0.75	2.76	25.0	7-879-9101
		L0	4-1/2 - 6	3.250	2.60						2.76	26.1	7-879-9102
		L1	6 - 6	4.125	3.35						2.99	37.0	7-879-9103
12-1/2"	12.40	L0	4-1/2 - 6	3.250	2.60	7.086	11.26	M16 x 2	0.91	0.75	2.76	37.0	7-879-9122
		L1	6 - 6	4.125	3.35						2.99	37.0	7-879-9123
		L2	7-3/4 - 5	5.250	4.29						3.50	38.8	7-879-9124
15-3/4"	11.75	L1	6 - 6	4.125	3.35	11.75	6.75	5/8"x11"	0.87	-	2.95	34.2	7-879-9163
		L2	7-3/4 - 5	5.250	4.29						3.46	45.4	7-879-9164
		L3	10-3/8 - 4	6.500	5.43						3.94	67.2	7-879-9165
20"	16.02	L2	7-3/4 - 5	5.250	4.29	16.02	9.25	3/4"x10"	1.18	-	3.66	60.2	7-879-9264
		L3	10-3/8 - 4	6.500	5.43						4.14	81.3	7-879-9265

5C & MT Steel Adapters

Fully Machined
For 3 & 6 Jaw SET-TRU Chucks

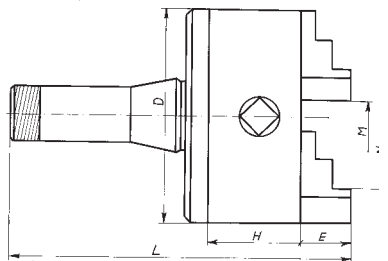
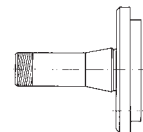
8288

Chuck Dia. D	L	H	E	M Min-Max	N Max	3-jaw Chucks	6-jaw Chucks	5C Adapter Code No.
4"	7.29	2.68	0.67	.12-1.30	3.66	7-866-8040*	7-868-8040*	7-912-304
5"	7.12	2.362	1.58	.12-1.97	4.92	7-866-0500	7-868-0500	7-912-305
6-1/4"	7.95	2.677	1.71	.12-2.52	6.3	7-866-0600	7-868-0600	7-912-306

*4" Solid Jaws only.

8280

Chuck Dia.	MT Shank	3-jaw Chucks	6-jaw Chucks	MT Adapter Code No.
4"	3	7-866-8040	7-868-8040	7-914-043
	4			7-914-044

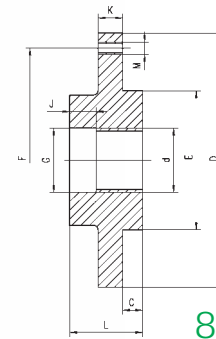


Adapters &
SET-TRU
Chucks are
sold separately.



Steel Adapters

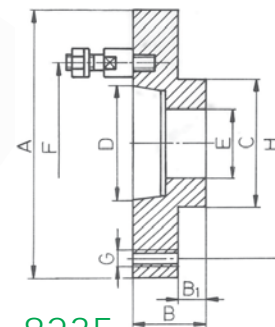
Fully Machined
For "SET-TRU" Chucks



8285

Threaded

Chuck Dia.	D	Thread d	G	E	F	L	C	K	M	No. of Bolts	Weight lbs.	Code No.
4"	3.94	1-10 UNS-2B	1.0150	1.771	3.268	1.54	0.47	.51	M8 x 1.25	3	4.85	7-876-041
		1-1/8 - 12W	-								-	7-876-0415
		1-1/2 - 8 UN-2B	1.5150								5.29	7-876-042
5"	4.92	1-10 UNS-2B	1.0150	2.164	4.252	1.54	0.55	.51	M8 x 1.25	3	6.17	7-876-051
		1-1/8 - 12W	-			-					7-876-0515	
		1-1/2 - 8 UN-2B	1.5150			1.54					6.61	7-876-052
		2-3/16 - 10 Hardinge	2.1889			2.44					7.05	7-876-054
		2-1/4 - 8 UN-2B	2.260	1.54	6.8	7-876-056						
6-1/4"	6.30	1-1/2 - 8 UN-2B	1.5150	3.385	5.512	1.50	0.63	.59	M10 x 1.5	3	7.05	7-876-062
		2-3/16 - 10 Hardinge	2.1889			1.61					7.50	7-876-064
		2-1/4 - 8 UN-2B	2.2600			1.75					7.94	7-876-066
8"	7.87	1-1/2 - 8 UN-2B	1.5150	4.330	6.929	1.50	0.67	.59	M10 x 1.5	3	9.92	7-876-082
		2-1/4 - 8 UN-2B	2.2600			1.75					11.46	7-876-083
		2-3/8 - 6 UN-2B	2.3850			2.00					13.89	7-876-084
10"	9.84	2-3/8 - 6 UN-2B	2.3850	5.708	8.819	2.00	0.74	.75	M12 x 1.75	3	30.0	7-876-104
12-1/2"	12.40	2-3/8 - 6 UN-2B	2.3850	7.086	11.280	2.00	1.00	.94	M16 x 2	3	50.0	7-876-124



8235

C-Type/DIN 55027

Chuck Dia.	Taper Size	D	G	d	E	F	B	C	L	M	No. of Studs	Weight lbs.	Code No.	
5"	C-5	4.92	3.251	1.38	2.164	4.252	4.126	0.55	1.46	M8 x 1.25	4	3.4	7-920-055	
6-1/4"	C-6	6.30	4.189	1.65	3.385	5.512	3.346	0.63	1.26	M10 x 1.5	4	6.0	7-920-066	
8"	C-6	7.87	4.188	2.17	4.330	6.929	5.252	0.67	1.57	M10 x 1.5	4	12.0	7-920-086	
10"	C-6	9.84	4.188	2.99	5.708	8.819	5.252	0.75	1.50	M12 x 1.75	4	28.0	7-920-106	
12-1/2"	C-8	12.4	5.501	4.06	7.086	11.26	6.748	0.75	1.69	M16 x 2	4	48.0	7-920-128	
15-3/4"	C-8	11.75	5.501	5.35	11.75	6.75	6.75	-	1.46	5/8 x 11	6	27	7-920-168	
	C-11		7.751	4.72								9.25	25	7-920-169
20"	C-8	16.02	5.501	5.35	16.02	9.25	9.25	-	1.42	3/4 x 10	6	70	7-920-208	
	C-11		7.751	7.57								9.25	66	7-920-209
	C-15		11.251	7.48								13.0	2.05	86
25"	C-8	16.02	5.501	5.35	16.02	13.0	9.25	-	1.42	3/4 x 10	6	70	7-920-258	
	C-11		7.751	7.57								9.25	66	7-920-259
	C-15		11.251	9.92								13.0	2.05	75



Hard & Soft Solid Jaws

For 3, 4 & 6 Jaw SET- TRU Chucks



O.D. Hard Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw	6-Jaw
	Code No.		
4"	7-880-304	-	7-880-604
5"	7-880-305	-	7-880-605
6"	7-880-306	7-880-406	7-880-606
8"	7-880-308	7-880-408	7-880-608
10"	7-880-310	7-880-410	7-880-610
12"	7-880-312	7-880-412	7-880-612
16"	7-880-316	-	7-880-616
20"	7-880-320	-	-
25"	7-880-325	-	-

Sold in sets

I.D. Hard Solid Jaws

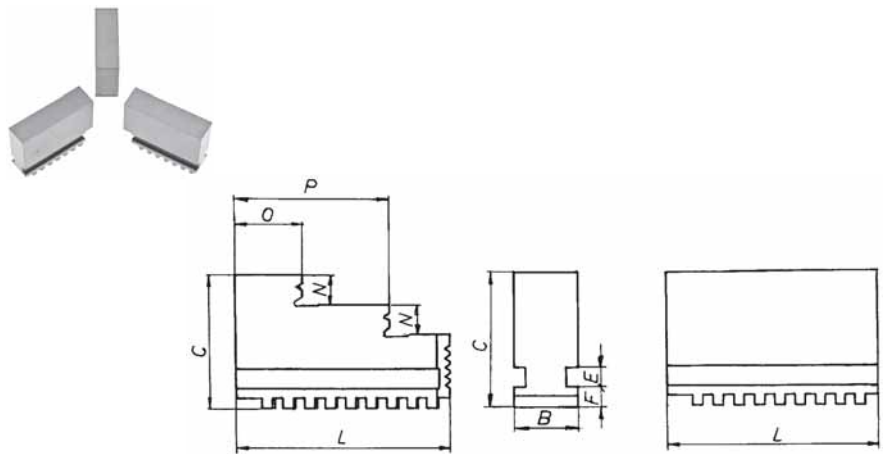
Chuck Dia.	3-Jaw	4-Jaw	6-Jaw
	Code No.		
4"	7-881-304	-	7-881-604
5"	7-881-305	-	7-881-605
6"	7-881-306	7-881-406	7-881-606
8"	7-881-308	7-881-408	7-881-608
10"	7-881-310	7-881-410	7-881-610
12"	7-881-312	7-881-412	7-881-612
16"	7-881-316	-	7-881-616
20"	7-881-320	-	-
25"	7-881-325	-	-

Sold in sets

Soft Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
4"	7-882-304	-
5"	7-882-305	-
6"	7-882-306	7-882-406
8"	7-882-308	7-882-408
10"	7-882-310	7-882-410
12"	7-882-312	7-882-412
16"	7-882-316	-
20"	7-882-320	-
25"	7-882-325	-

Sold in sets



Principal Dimensions

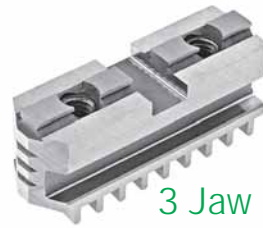
Chuck Dia.	C	L	B	F	E	N	P	O	Hard Solid Jaws			Soft Solid Jaws	
									Weight Set/lbs.				
									3-Jaw	4-jaw	6-Jaw	3-Jaw	4-Jaw
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.58	-	1.16	.86	-
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.319	.512	1.2	-	2.4	1.7	-
6"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	2.4	3.2	4.8	3.3	4.4
8"	2.1260	3.3465	.9843	.3543	.3937	.4724	2.244	.906	3.2	4.3	6.5	5.3	7.1
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	5.2	7.0	10.	9.0	12
12"	2.8740	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	8.7	12	18	13	17
16"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	16	-	31	16	-
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	22	-	44	33	-
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	38	-	77	57	-



Spare Parts for SET-TRU Chucks

2, 3, 4 & 6 Jaw Hard Master Jaws

Chuck Dia.	2-Jaw	3-Jaw	4-Jaw	6-Jaw
	Code No.			
5"	-	7-885-305	7-885-405	7-885-605
6"	7-885-206	7-885-306	7-885-406	7-885-606
8"	7-885-208	7-885-308	7-885-408	7-885-608
10"	7-885-210	7-885-310	7-885-410	7-885-610
12"	7-885-212	7-885-312	7-885-412	7-885-612
16"	7-885-216	7-885-316	7-885-416	7-885-616
20"	-	7-885-320	7-885-420	7-885-620
25"	-	7-885-325	7-885-425	7-885-625

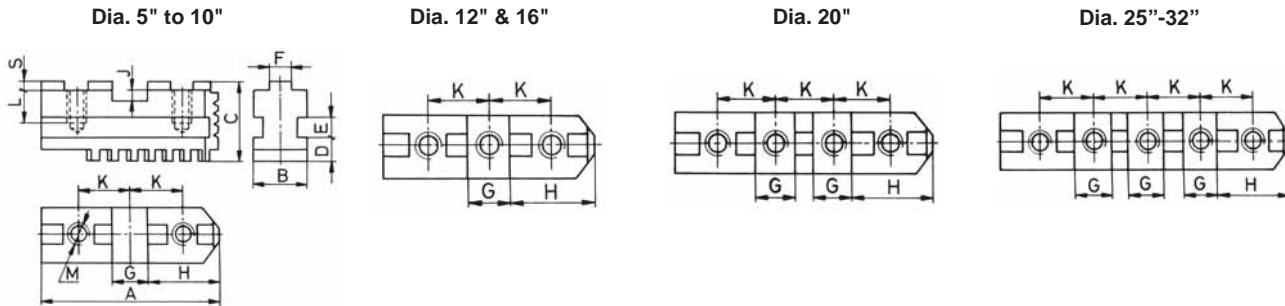


3 Jaw



6 Jaw

Sold in sets



Principal Dimensions

Chuck Dia.	M	H	G	J	K	D	F	N	C	B	OAL A	O	P	3 - Jaw	4-Jaw	6 - Jaw
													Weight Set / lbs.			
5"	5/8	57/64	.4996	.35	.59	.3129	.1260	.315	1.516	.866	2.205	.57	1.38	0.93	-	1.90
6-1/4"	3/4	1-1/8	.4996	.43	.71	.3129	.1260	.335	1.634	.984	2.638	.71	1.63	1.20	1.60	2.40
8"	7/8	1-3/8	.4996	.43	.71	.3129	.1260	.374	1.713	1.063	3.347	.85	2.01	2.10	2.80	4.20
10"	1-1/16	1-9/16	.7496	.55	.78	.5004	.1260	.472	2.023	1.280	3.740	.96	2.32	3.20	4.27	6.40
12-1/2"	1-1/4	1-7/8	.7496	.55	.78	.5004	.1260	.512	2.165	1.457	4.331	1.04	2.68	5.10	6.80	10.20
15-3/4"	1-1/2	2-1/4	.7496	.71	1.0	.5004	.2480	.532	2.539	1.654	5.000	1.06	3.01	7.30	-	14.60
20"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.689	2.933	1.654	5.000	1.97	3.46	14.40	-	28.80
25"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.827	3.228	2.047	5.000	2.01	3.50	27.10	-	44.20

American Standard tongue & groove Jaws.

Camlock Studs & Set Screws

Taper Size	Camlock Studs			Set Screw*	Qty. per Set
	Dia.	Thread	Code No.	Code No.	
D1-3	9/16"	M10x1	7-899-103	7-899-305	3
D1-4	5/8"	M10x1	7-899-104	7-899-305	3
D1-5	3/4"	M12x1	7-899-105	7-899-305	6
D1-6	7/8"	M16x1.5	7-899-106	7-899-310	6
D1-8	1"	M20x1.5	7-899-108	7-899-310	6
D1-11	1-3/16"	M22x1.5	7-899-111	7-899-310	6
D1-15	1-3/8"	M24x1.5	7-899-115	7-899-310	6

Sold by piece

DIN Studs

Taper Size	Stud Dia. Inch	Stud Dia. Mmm	Thread mm	Qty. per Set	Code No.
C - 4	.7677	19.5	M10 - 39	3	7-921-904
C - 5	.7677	19.5	M10 - 43	4	7-921-905
C - 6	.8465	21.5	M12 - 50	4	7-921-906
C - 8	1.063	27.0	M16 - 60	4	7-921-908
C - 11	1.339	34.0	M20 - 75	6	7-921-911

Sold by piece



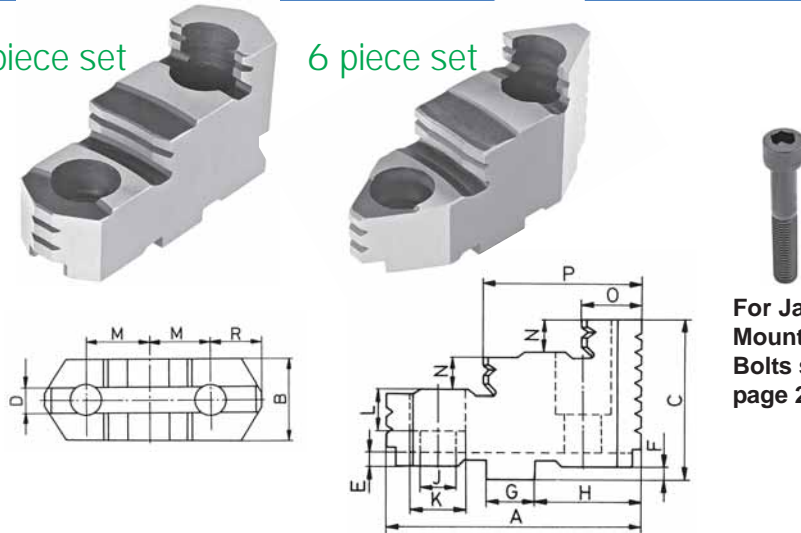
Spare Parts for SET-TRU Chucks

2, 3, 4 & 6 Jaw
Hard Top Jaws

3 piece set

6 piece set

Chuck Dia.	3-Jaw	4-Jaw	6-Jaw
	Code No.		
5"	7-883-305	7-883-405	7-883-605
6"	7-883-306	7-883-406	7-883-606
8"	7-883-308	7-883-408	7-883-608
10"	7-883-310	7-883-410	7-883-610
12"	7-883-312	7-883-412	7-883-612
16"	7-883-316	7-883-416	7-883-616
20"	7-883-320	7-883-420	7-883-620
25"	7-883-325	7-883-425	7-883-625



For Jaw Mounting Bolts see page 22.

Sold in sets

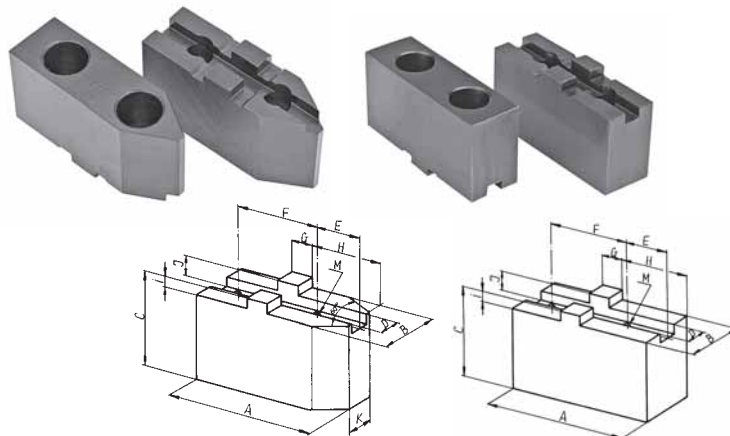
Principal Dimensions

Chuck Dia.	M	H	G	J	K	D	F	N	C	B	OAL A	O	P	3 - Jaw	4-Jaw	6 - Jaw
														Weight Set / lbs.		
5"	5/8	57/64	.4996	.35	.59	.3129	.1260	.315	1.516	.866	2.205	.57	1.38	0.93	-	1.90
6-1/4"	3/4	1-1/8	.4996	.43	.71	.3129	.1260	.335	1.634	.984	2.638	.71	1.63	1.20	1.60	2.40
8"	7/8	1-3/8	.4996	.43	.71	.3129	.1260	.374	1.713	1.063	3.347	.85	2.01	2.10	2.80	4.20
10"	1-1/16	1-9/16	.7496	.55	.78	.5004	.1260	.472	2.023	1.280	3.740	.96	2.32	3.20	4.27	6.40
12-1/2"	1-1/4	1-7/8	.7496	.55	.78	.5004	.1260	.512	2.165	1.457	4.331	1.04	2.68	5.10	6.80	10.20
15-3/4"	1-1/2	2-1/4	.7496	.71	1.0	.5004	.2480	.532	2.539	1.654	5.000	1.06	3.01	7.30	-	14.60
20"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.689	2.933	1.654	5.000	1.97	3.46	14.40	-	28.80
25"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.827	3.228	2.047	5.000	2.01	3.50	27.10	-	44.20

American Standard tongue & groove Jaws.

Soft Top Jaws

Chuck Dia.	2-Jaw	3-Jaw	6-Jaw
	Code No.		
5"	-	7-884-305	-
6"	7-884-206	7-884-306	7-884-606
8"	7-884-208	7-884-308	7-884-608
10"	7-884-210	7-884-310	7-884-610
12"	7-884-212	7-884-312	7-884-612
16"	-	7-884-316	7-884-616
20"	-	7-884-320	-
25"	-	7-884-325	-



Sold by piece

Principal Dimensions

Chuck Dia.	A	B	C	D	E	F	G	H	I	J	K	Bolt Size M	Weight lbs./pc. 3,4&6 Jaw	Weight lbs./pc. 2 Jaw	
		3, 4 & 6 Jaw													B 2 Jaw
5"	2.520	0.866	-	1.520	.3129	0.5910	1-1/4	.500	1.000	.1260	.283	-	5/16-18	.66	-
6-1/4"	3.071	1.000	1.575	1.634	.3129	0.8386	1-1/2	.500	1.339	.1260	.283	.118	3/8-16	1.01	1.40
8"	3.543	1.063	1.575	1.713	.3129	0.9488	1-3/4	.500	1.575	.1260	.283	.197	3/8-16	1.43	2.00
10"	4.173	1.280	1.850	2.028	.5000	1.0827	2-1/8	.750	1.772	.1260	.283	.315	1/2-13	2.54	3.30
12-1/2"	4.724	1.457	2.047	2.165	.5000	1.2087	2-1/2	.750	2.087	.2480	.283	.394	1/2-13	3.53	4.60
15-3/4"	5.512	1.654	-	2.539	.5000	1.3443	3	.750	2.480	.2480	.406	.512	5/8-11	4.85	-
20"	5.512	1.654	-	2.933	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	5.29	-
25"	6.299	2.047	-	3.288	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	9.26	-



Spare Parts for SET-TRU Chucks

2, 3, 4 & 6 Jaw



D - OD Dia.
H - Height
L - OAL

Chuck Dia.	Scroll				Pinion				Wrench		Pinion Sleeve		Half Ring	
	2 - 6 Jaw			Weight lbs.	2 - 6 Jaw			Weight lbs.	2 - 6 Jaw Code No.	Square Size	2 - 6 Jaw Code No.	ID	2 - 6 Jaw	
	Code No.	D	H		Code No.	D	L						Code No.	D
4"	7-887-304	2.74	0.49	0.34	7-886-304	0.98	1.4	0.12	7-889-005	0.35	-	-	7-888-904*	-
5"	7-887-505	3.7	0.63	0.84	7-886-505	0.98	1.44	0.13	7-889-005	0.35	7-888-505	0.98	7-888-705	1.52
6"	7-887-506	4.88	0.83	2.03	7-886-506	1.1	1.57	0.18	7-889-008	0.43	7-888-506	1.1	7-888-706	1.72
8"	7-887-508	6.24	0.94	3.62	7-886-508	1.2	1.99	0.37	7-889-008	0.43	7-888-508	1.2	7-888-708	1.85
10"	7-887-510	7.82	1.1	4.54	7-886-510	1.4	2.36	0.44	7-889-012	0.55	7-888-510	1.4	7-888-710	1.94
12"	7-887-512	10.1	1.2	10.2	7-886-512	1.5	2.85	0.71	7-889-012	0.55	7-888-512	1.5	7-888-712	2.17
16"	7-887-516	12.9	1.3	22.7	7-886-516	1.7	3.66	1.3	7-889-016	0.67	7-888-516	1.7	7-888-716	2.42
20"	7-887-520	16.4	1.2	36.4	7-886-520	2	4.45	2.1	7-889-025	0.75	7-888-520	2	7-888-720	2.76
25"	7-887-525	21.3	1.6	65.7	7-886-525	2	5.24	2.5	7-889-025	0.75	7-888-525	2	7-888-725	2.95

Sold by piece

*Pinion retaining screw



Fine Adjustment Screws

Chuck Dia.	Screw Size mm	L	Pieces in set	Hex Key Code No.	Screw Code No.
4"	M12x1	1.02	4	6-999-586	7-897-6041
5"	M12x1	1.34	4	6-999-586	7-897-6051
6"	M18x1	1.42	4	6-999-590	7-897-6061
8"	M18x1	1.70	4	6-999-590	7-897-6081
10"	M18x1	2.03	4	6-999-590	7-897-6101
12"	M18x1	2.62	4	6-999-590	7-897-6121
16"	M18x1	1.93	8	6-999-590	7-897-6161
20"	M18x1	1.77	8	6-999-590	7-897-6201
25"	M18x1	4.33	8	6-999-590	7-897-6251

Sold by piece



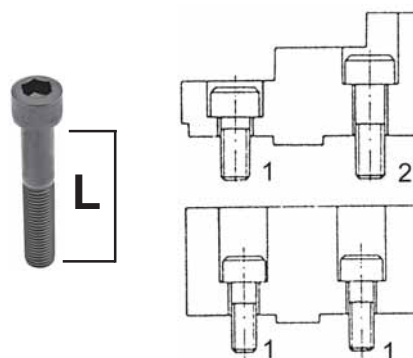
Chuck Mounting Bolts

Chuck Dia.	Bolt Size	L	No. of Bolts	Code No.
4" & 5"	M8x1.25	2.756	3	7-897-705
6"	M10x1.5	2.756	3	7-897-706
8"	M10x1.5	3.149	3	7-897-708
10"	M12x1.75	3.543	3	7-897-710
12"	M16x2	3.937	3	7-897-712
16"	5/8x11	4.330	6	7-897-716
20"	3/4x10	4.724	6	7-897-720
25"	3/4x10	5.118	6	7-897-725

Sold by piece

Mounting Bolts for Hard & Soft Top Jaws

Chuck Dia.	Thread	Screw No.1				Screw No.2			
		L	3-jaw	6-jaw	L	3-jaw	6-jaw		
			Code No.	Code No.		Code No.	Code No.		
5"	5/16-18	.79	7-897-503	-	1.00	7-897-504	-		
6"	3/8-16	.79	7-897-510	7-897-510	1.18	7-897-512	7-897-512		
8"	3/8-16	.79	7-897-511	7-897-511	1.18	7-897-513	7-897-513		
10 & 12"	1/2-13	1.00	7-897-530	7-897-530	1.57	7-897-531	7-897-531		
16"	5/8-11	1.18	7-897-540	7-897-540	1.77	7-897-541	7-897-541		
20"	3/4-10	1.57	7-897-560	7-897-560	2.95	7-897-561	7-897-561		
25"	3/4-10	1.57	7-897-560	7-897-560	3.15	7-897-562	7-897-562		



Sold by piece



3 & 4 Jaw Self-Centering Scroll Chucks

Forged Steel, High Speed

Precision lathe chucks have top accuracy and the guarantee to maintain this accuracy for an extended period of time. These chucks have a modern and compact design. They are able to fulfill the highest demands of our customers. They can be used wherever high precision machining is demanded.

BODY - drop-forged of highest grade steel and put through precise machining operations. All bearing surfaces are carefully hardened and precisely ground.

SCROLL PLATE - drop-forged of fine alloy steel and carefully case hardened. Thread flanks are ground on both sides.

JAWS - the teeth and guides are hardened and fully ground on both sides.

PINIIONS - hardened and ground.

BUSHINGS - hardened and ground, pressed into the pinion seats. Jaws, pinions and bushings are made of fine alloy steel. Precision grinding of scroll and jaws teeth will permit you to:

- eliminate possible deformation as a result of heat treatment
- reach uniform radial gripping force on all teeth of jaws
- increase guarantee period for high centering accuracy
- increase gripping force

Each chuck is provided with lubricator enabling current maintenance and extending the life of chuck components.

Each scroll and assembled chuck is statically balanced within fine limits. Interstage and final inspection assure high quality.

TOP Accuracy & Quality



Hardened and Ground Surfaces

Standard Accessories:

- 4" - 2 sets of hard solid jaws (inside and outside)
- 5" - 25" - 1 set of two-piece reversible jaws (hard top jaws and hard master jaws).
- 1 wrench, 1 set of mounting screws

Optional Accessories:

Soft top jaws. Solid I.D. & O.D. jaws.

Spare Parts see pages 27 - 30.

Adapter Plates see pages 58 - 61.

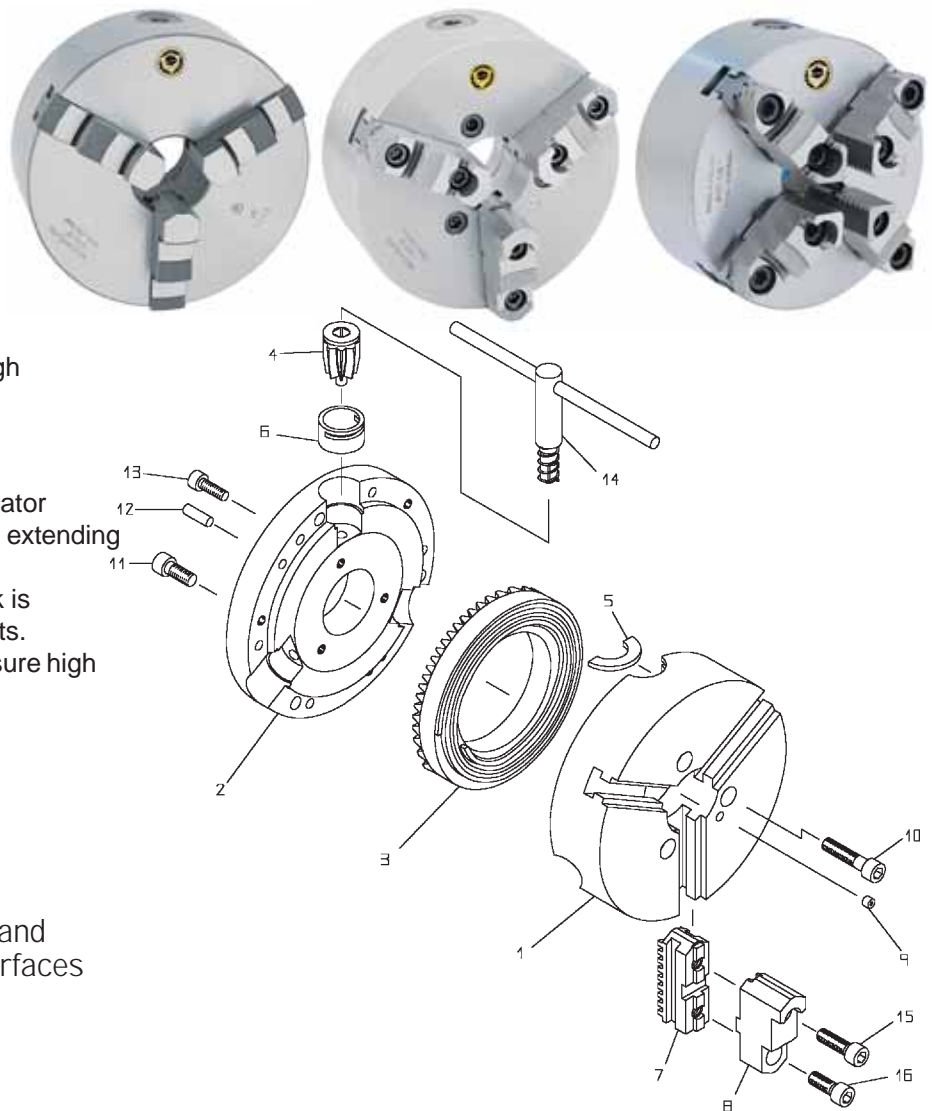


Chuck Grease

Code No. 7-799-025



American Standard tongue & groove Jaws.



3 & 4 Jaw Self-Centering Scroll Chucks

Forged Steel Body
Plain Back Chuck, Back Plates Required



3505



3504



3705



Back View

3505 3504 3705

Chuck Dia.	Hole Dia.	RPM max.	Weight lbs.	Code No.		
				3-Jaw Two Piece	3 Jaw Solid	4 Jaw Two Piece
4"	.78	5200	6.2	-	7-829-0400	-
5"	1.26	4800	10	7-820-0500	7-829-0500	-
6-1/4"	1.65	4500	21	7-820-0600	7-829-0600	7-841-0600
8"	2.17	4000	36	7-820-0800	7-829-0800	7-841-0800
10"	2.99	3500	75	7-820-1000	7-829-1000	7-841-1000
12-1/2"	4.08	2800	123	7-820-1200	7-829-1200	7-841-1200
15-3/4"	5.35	2000	198	7-820-1600	-	7-841-1600
20"	7.48	1200	276	7-820-2000	-	7-841-2000
25"	9.92	1000	485	7-820-2500	-	7-841-2500
32"	10.5	450	772	7-820-3200	-	-

Note: Plain back chucks require adapter plates which may require machining to fit. See page 61.

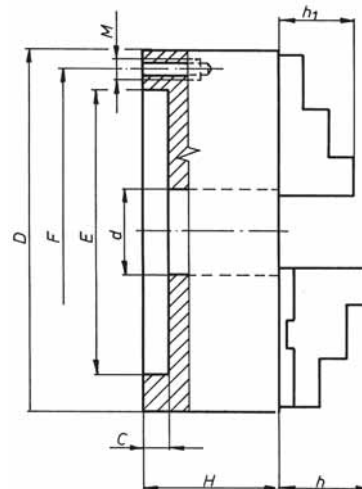


32" Steel Body Chuck see page 40.

Principal Dimensions



Chuck Dia. D	F	E	d	C	H	h	Adapter Mounting Bolts			
							Thread M	L	Qty. per set	Code No.
5"	4.2520	3.7402	1.3976	.1575	2.422	1.575	M8x1.25	.98	3	7-897-105
6-1/4"	5.5118	4.9213	1.6535	.1575	2.756	1.693	M10x1.5	.98	3	7-897-108
8"	6.9291	6.2992	2.1654	.1575	3.150	1.772	M10x1.5	.98	6	7-897-108
10"	8.8189	7.8740	2.9921	.1969	3.543	2.087	M12x1.75	1.18	6	7-897-110
12-1/2"	11.2598	10.2362	4.0551	.1969	3.937	2.244	M16x2	1.18	6	7-897-112
15-3/4"	14.2519	12.9921	5.3543	.1969	4.331	2.639	M16x2	1.57	6	7-897-125
20"	18.0314	16.5354	7.4803	.1969	4.685	3.150	M16x2	1.57	6	7-897-125
25"	23.0709	21.4567	9.9212	.2756	5.079	3.425	M16x2	1.57	6	7-897-125
32"	See page 41									7-897-132



3 Jaw Self-Centering Scroll Chucks

Forged Steel Body, High Speed
A 1 / A 2 Type, Direct Mount



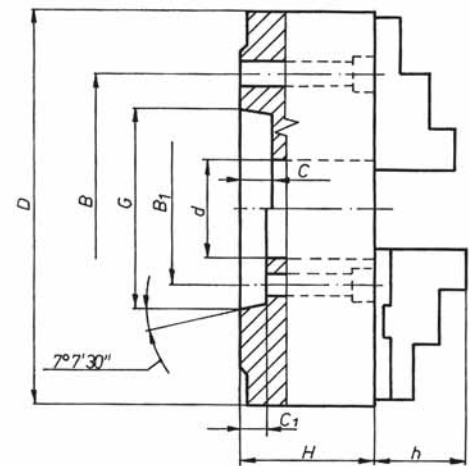
Note:

Type A 1 Spindle has 2 Bolt Hole Pattern (inside B & outside the taper B1) an A 1 or A 2 Chuck will fit on it.

Type A 2 Spindle has 1 Bolt Pattern (outside the taper B) only an A 2 chuck will fit on it.

3515

Chuck Dia.	Taper Size	Hole Dia.	RPM max.	Weight lbs.	Code No.
6-1/4"	A1-5	1.65	4500	22	7-821-0615
8"	A1-5	1.65	4000	42	7-821-0815
	A1-6	2.17			7-821-0816
10"	A1-6	2.17	3500	71	7-821-1016
	A1-8	2.99			7-821-1018
12-1/2"	A2-6	4.06	2800	121	7-821-1226
	A1-8	3.15			7-821-1228
15-3/4"	A2-8	5.35	2000	203	7-821-1628
	A1-11	5.12			7-821-1629
20"	A2-8	5.35	1200	353	7-821-2028
	A2-11	7.48			7-821-2029
25"	A2-11	7.48	1000	628	7-821-2529
	A2-15	9.92			7-821-2530



Principal Dimensions

Chuck Dia.	Taper Size	B (A-2)	B1 (A-1)	G	d	C/C1	H	h	Screws M			
									Thread	L	Qty.	Code No.
6 1/4"	A1-5	-	2.4374	3.2505	1.6535	.563	2.6772	1.693	7/16-14	2-3/8	3	7-897-520
8"	A1-5	-	2.4374	3.2505	1.6535	.563	3.0709	1.772	7/16-14	2-3/4	3	7-897-521
	A1-6	-	3.2500	4.1880	2.1653	.625						1/2-13
10"	A1-6	-	3.2500	4.1880	2.1653	.625	3.5039	2.087	1/2-13	3-1/8	6	7-897-533
	A1-8	-	4.3750	5.5007	2.9921	.688						5/8-11
12-1/2"	A2-6	5.2520	-	4.1880	4.0551	.630	3.7874	2.244	1/2-13	4	6	7-897-535
	A1-8	-	4.3750	5.5007	3.1496	.688						5/8-11
15-3/4"	A2-8	6.7480	-	5.5007	5.3543	.709	4.2520	2.639	5/8-11	4-5/16	6	7-897-549
	A1-11	-	6.5000	7.7507	5.1181	.750						3/4-10
20"	A2-8	9.2520	-	5.5007	5.3543		4.6850	3.091	5/8-11	4-3/4	6	7-897-551
	A2-11	9.2520	-	7.7507	7.4803	.787						3/4-10
25"	A2-11	9.2520	-	7.7507		.750	5.0787	3.425	3/4-10	5-5/16	6	7-897-566
	A2-15	13.000	-	11.251	7.5905	.813						7/8-9

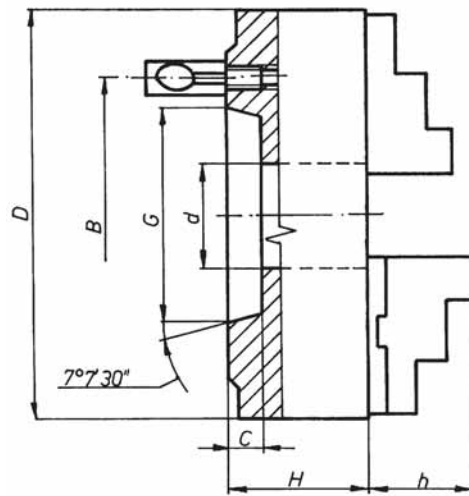


3 Jaw Self-Centering Scroll Chuck

Forged Steel Body, High Speed
D1 Type, Direct Mount

3545

Chuck Dia.	Taper Size	Stud Dia.	Hole Dia.	RPM max.	Weight lbs.	Code No.
6-1/4"	D1-3	9/16	1.65	4500	20	7-823-0633
	D1-4	5/8				7-823-0634
	D1-5	3/4				7-823-0635
8"	D1-5	3/4	2.17	4000	42	7-823-0835
	D1-6	7/8				7-823-0836
10"	D1-6	7/8	2.99	3500	71	7-823-1036
	D1-8	1				7-823-1038
12-1/2"	D1-6	7/8	4.06	2800	112	7-823-1236
	D1-8	1				7-823-1238
	D1-11	1-3/16				7-823-1239
15-3/4"	D1-8	1	5.35	2000	223	7-823-1638
	D1-11	1-3/16				7-823-1639
20"	D1-8	1	5.35	1200	331	7-823-2038
	D1-11	1-3/16	7.48			7-823-2039
25"	D1-8	1	5.35	1000	604	7-823-2538
	D1-11	1-3/16	7.48			7-823-2539



For Camlock Studs with inch thread see page 34.

Principal Dimensions

Chuck Dia.	Taper Size	B	G	d	C	H	h	Camlock Studs				Set Screw Code No.
								Dia.	Thread	Qty.	Code No.	
6-1/4"	D1-3	2.7795	2.1250	1.6535	.5118	2.6772	1.693	9/16	M10x1	3	7-899-103	7-899-305
	D1-4	3.2520	2.5005		.5118			5/8	M10x1	3	7-899-104	
	D1-5	4.1260	3.7505		.5629			3/4	M12x1	6	7-899-105	
8"	D1-5	4.1260	3.2505	2.1653	.5629	3.0719	1.772	3/4	M12x1		7-899-105	7-899-310
	D1-6	5.2520	4.1880		.6299			7/8	M16x1.5	6	7-899-106	
10"	D1-6	5.2520	4.1880	2.9921	.6299	3.5039	2.087	7/8	M16x1.5		7-899-106	7-899-310
	D1-8	6.7480	5.5007		.7087			1	M20x1.5	6	7-899-108	
12-1/2"	D1-6	5.2520	4.1880	4.0551	.6299	3.7874	2.244	7/8	M16x1.5		7-899-106	7-899-310
	D1-8	6.7480	5.5007		.7087			1	M20x1.5	6	7-899-108	
	D1-11	9.2520	7.7507		.7874			1-3/16	M22x1.5		7-899-111	
15-3/4"	D1-8	6.7480	5.5007	5.3543	.7087	4.2570	2.639	1	M20x1.5		7-899-108	7-899-310
	D1-11	9.2520	7.7507		.7874			1-3/16	M22x1.5	6	7-899-111	
20"	D1-8	6.7480	5.5007	5.3543	.7087	4.6850	3.150	1	M20x1.5		7-899-108	7-899-310
	D1-11	9.2520	7.7507		7.5984			.7874	1-3/16	M22x1.5	6	
25"	D1-8	6.7480	5.5007	5.3543	.7087	5.0787	3.425	1	M20x1.5		7-899-108	7-899-310
	D1-11	9.2520	7.7507		7.4803			.7874	1-3/16	M22x1.5	6	



Spare Parts

For 3 & 4 Jaw Steel Scroll Chucks
Hard & Soft Solid Jaws



O. D. Hard Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
4"	7-880-304	-
5"	7-880-305	7-880-405
6"	7-880-306	7-880-406
8"	7-880-308	7-880-408
10"	7-880-310	7-880-410
12"	7-880-312	7-880-412
16"	7-880-316	7-880-416
20"	7-880-320	7-880-420
25"	7-880-325	7-880-425

Sold in sets



I. D. Hard Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
4"	7-881-304	-
5"	7-881-305	7-881-405
6"	7-881-306	7-881-406
8"	7-881-308	7-881-408
10"	7-881-310	7-881-410
12"	7-881-312	7-881-412
16"	7-881-316	7-881-416
20"	7-881-320	7-881-420
25"	7-881-325	7-881-425

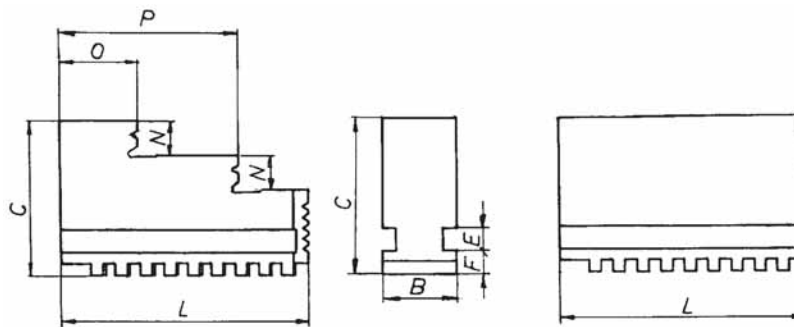
Sold in sets



Soft Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
4"	7-882-307	-
5"	7-882-305	7-882-405
6"	7-882-306	7-882-406
8"	7-882-308	7-882-408
10"	7-882-310	7-882-410
12"	7-882-312	7-882-412
16"	7-882-316	7-882-416
20"	7-882-320	7-882-420
25"	7-882-325	7-882-425

Sold in sets



Principal Dimensions

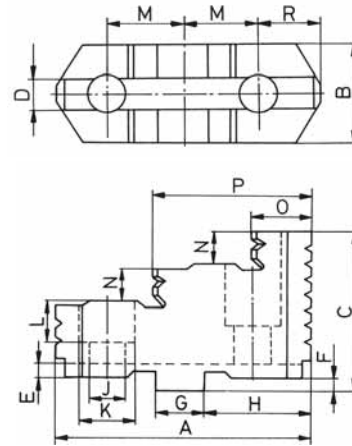
Chuck Dia.	C	L	B	F	E	N	P	O	Hard Solid Jaws Weight Set/lbs.		Soft Solid Jaws Weight Set/lbs.	
									3-Jaw	4-jaw	3-Jaw	4-Jaw
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.58	-	.86	-
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.319	.512	1.2	-	1.7	-
6"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	2.4	3.2	3.3	4.4
8"	2.1260	3.3465	.9843	.3543	.3937	.4724	2.244	.906	3.2	4.3	5.3	7.1
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	5.2	7.0	9.0	12
12"	2.8740	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	8.7	12	13	17
16"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	16	-	16	-
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	22	-	33	-
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	38	-	57	-



Spare Parts

For 3 & 4 Jaw Steel Scroll Chucks Hard Top Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
5"	7-883-305	7-883-405
6"	7-883-306	7-883-406
8"	7-883-308	7-883-408
10"	7-883-310	7-883-410
12"	7-883-312	7-883-412
16"	7-883-316	7-883-416
20"	7-883-320	7-883-420
25"	7-883-325	7-883-425



Jaw mounting bolts page 36.

Sold in sets

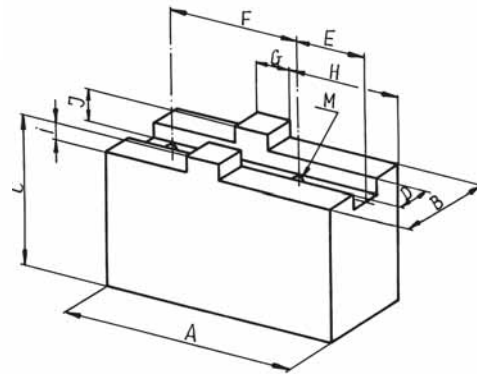
Principal Dimensions

Chuck Dia.	M	H	G	J	K	D	F	N	C	B	OAL A	O	P	3 - Jaw	4-Jaw
														Weight Set lbs.	
5"	5/8	57/64	.4996	.35	.59	.3129	.1260	.315	1.516	.866	2.205	.57	1.38	0.93	-
6-1/4"	3/4	1-1/8	.4996	.43	.71	.3129	.1260	.335	1.634	.984	2.638	.71	1.63	1.20	1.60
8"	7/8	1-3/8	.4996	.43	.71	.3129	.1260	.374	1.713	1.063	3.347	.85	2.01	2.10	2.80
10"	1-1/16	1-9/16	.7496	.55	.78	.5004	.1260	.472	2.023	1.280	3.740	.96	2.32	3.20	4.27
12-1/2"	1-1/4	1-7/8	.7496	.55	.78	.5004	.1260	.512	2.165	1.457	4.331	1.04	2.68	5.10	6.80
15-3/4"	1-1/2	2-1/4	.7496	.71	1.0	.5004	.2480	.532	2.539	1.654	5.000	1.06	3.01	7.30	-
20"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.689	2.933	1.654	5.000	1.97	3.46	14.40	-
25"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.827	3.228	2.047	5.000	2.01	3.50	27.10	-

American Standard tongue & groove Jaws.

Soft Top Jaws

Chuck Dia.	3 & 4-Jaw Code No.
5"	7-884-305
6"	7-884-306
8"	7-884-308
10"	7-884-310
12"	7-884-312
16"	7-884-316
20"	7-884-320
25"	7-884-325



Sold by piece

Principal Dimensions

Chuck Dia.	A	B	C	D	E	F	G	H	I	J	K	Bolt Size M	Weight lbs./pc.
5"	2.520	0.866	1.520	.3129	0.5910	1-1/4	.500	1.000	.1260	.283	-	5/16-18	.66
6-1/4"	3.071	1.000	1.634	.3129	0.8386	1-1/2	.500	1.339	.1260	.283	.118	3/8-16	1.01
8"	3.543	1.063	1.713	.3129	0.9488	1-3/4	.500	1.575	.1260	.283	.197	3/8-16	1.43
10"	4.173	1.280	2.028	.5000	1.0827	2-3/16	.750	1.772	.1260	.283	.315	1/2-13	2.54
12-1/2"	4.724	1.457	2.165	.5000	1.2087	2-1/2	.750	2.087	.2480	.283	.394	1/2-13	3.53
15-3/4"	5.512	1.654	2.539	.5000	1.3443	3	.750	2.480	.2480	.406	.512	5/8-11	4.85
20"	5.512	1.654	2.933	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	5.29
25"	6.299	2.047	3.288	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	9.26



Jaw mounting bolts page 36.



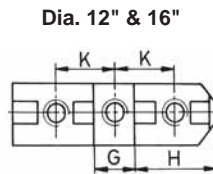
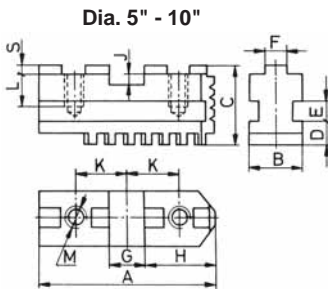
Spare Parts

For 3 & 4 Jaw Steel Scroll Chucks Hard Master Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
5"	7-885-305	7-885-405
6"	7-885-306	7-885-406
8"	7-885-308	7-885-408
10"	7-885-310	7-885-410
12"	7-885-312	7-885-412
16"	7-885-316	7-885-416
20"	7-885-320	7-885-420
25"	7-885-325	7-885-425



Sold in sets



Principal Dimensions

Chuck Dia.	K	H	G	F	J	L	D	E	B	OAL A	Thread M	3-Jaw	4-Jaw
5"	5/8	57/64	.4996	5/16	.1575	.4724	.3150	.3150	.7874	2.1259	5/16-18	0.93	-
6"	3/4	1-1/8	.4996	5/16	.1575	.5511	.3150	.3150	.7874	2.5590	3/8-16	1.20	1.60
8"	7/8	1-3/8	.4996	5/16	.1575	.5511	.3543	.3937	.9843	3.1102	3/8-16	2.10	2.80
10"	1-1/16	1-9/16	.7496	1/2	.1575	.6299	.4331	.4724	1.1024	3.6220	1/2-13	3.20	4.27
12"	1-1/4	1-7/8	.7496	1/2	.1575	.6299	.5000	.4724	1.2598	4.3307	1/2-13	5.10	6.80
16"	1-1/2	2-1/4	.7496	1/2	.2835	.8661	.5906	.5512	1.4173	5.1181	5/8-11	7.30	9.70
20"	1-1/2	2-1/4	.7496	1/2	.2835	1.2598	.6299	.5512	1.5748	6.5351	3/4-10	14.4	19.2
25"	1-1/2	2-1/4	.7496	1/2	.2835	1.2598	.6299	.5512	1.9685	8.2677	3/4-10	27.1	36.1

American Standard tongue & groove Jaws.

D - OD Dia.
H - Height
L - OAL



Sold by piece

Chuck Dia.	Scroll				Pinion			Wrench		Pinion	Sleeve	Half Ring		
	3 & 6 Jaw		Weight lbs.	Code No.	3 & 6 Jaw		Weight lbs.	3 & 6 Jaw Code No.	Square Size	3 & 6 Jaw Code No.	ID	3 & 6 Jaw		
	Code No.	D			H	D						L	Code No.	D
4"	7-887-304	2.74	.49	.34	7-886-304	.98	1.40	.12	7-889-005	.35	-	-	7-888-904*	-
5"	7-887-505	3.70	.63	.84	7-886-505	.98	1.44	.13	7-889-005	.35	7-888-505	.98	7-888-705	1.52
6"	7-887-506	4.88	.83	2.03	7-886-506	1.1	1.57	.18	7-889-008	.43	7-888-506	1.1	7-888-706	1.72
8"	7-887-508	6.24	.94	3.62	7-886-508	1.2	1.99	.37	7-889-008	.43	7-888-508	1.2	7-888-708	1.85
10"	7-887-510	7.82	1.1	4.54	7-886-510	1.4	2.36	.44	7-889-012	.55	7-888-510	1.4	7-888-710	1.94
12"	7-887-512	10.1	1.2	10.2	7-886-512	1.5	2.85	.71	7-889-012	.55	7-888-512	1.5	7-888-712	2.17
16"	7-887-516	12.9	1.3	22.7	7-886-516	1.7	3.66	1.3	7-889-016	.67	7-888-516	1.7	7-888-716	2.42
20"	7-887-520	16.4	1.2	36.4	7-886-520	2.0	4.45	2.1	7-889-025	.75	7-888-520	2.0	7-888-720	2.76
25"	7-887-525	21.3	1.6	65.7	7-886-525	2.0	5.24	2.5	7-889-025	.75	7-888-525	2.0	7-888-725	2.95



Universal Self-Centering Scroll Chucks

2, 3 & 4 Jaw Plain Back, Semi-Steel Body

These modern Bison precision lathe chucks can be used on all types of lathes and different kinds of milling, drilling and CNC attachments. The chucks come with **American Standard Two-Piece Tongue & Groove Jaws** or with two sets of hard solid OD & ID jaws.

BODY - is made of high quality cast iron. All guideways and bearing surfaces are precisely machined.

SCROLL PLATE - drop forged of fine alloy steel, carefully case hardened. Thread flanks ground on both sides.

JAWS - the teeth and guides are hardened and fully ground on both sides.

PINIONS - hardened and ground.

Two-Piece Jaw Chuck Standard Accessories:

2 Jaw Chucks 7-830-...

- 1 set of master jaws
- 1 set soft top jaws
- 3 & 4 Jaw Chucks 7-800-... & 7-840-...
- 1 set of two-piece reversible jaws (hard top jaws and hard master jaws)
- 1 self-ejecting wrench
- 1 set of mounting screws
- 2 allen keys

Optional Accessories:

- Soft top jaws

Solid Jaw Chuck Standard Accessories:

3 & 4 Jaw Chucks 7-810-... & 7-845-...

- 2 sets of hard solid jaws (inside and outside)
- 1 self ejecting wrench
- mounting bolts
- 1 allen key.

Optional Accessories:

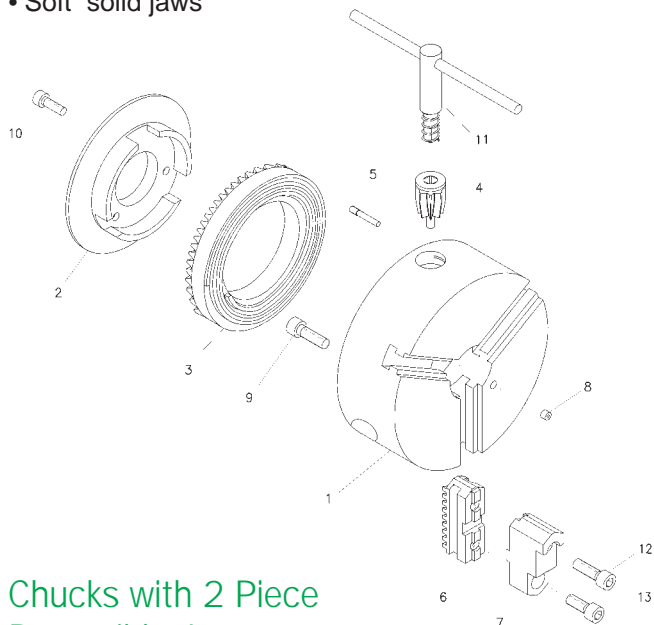
- Soft solid jaws



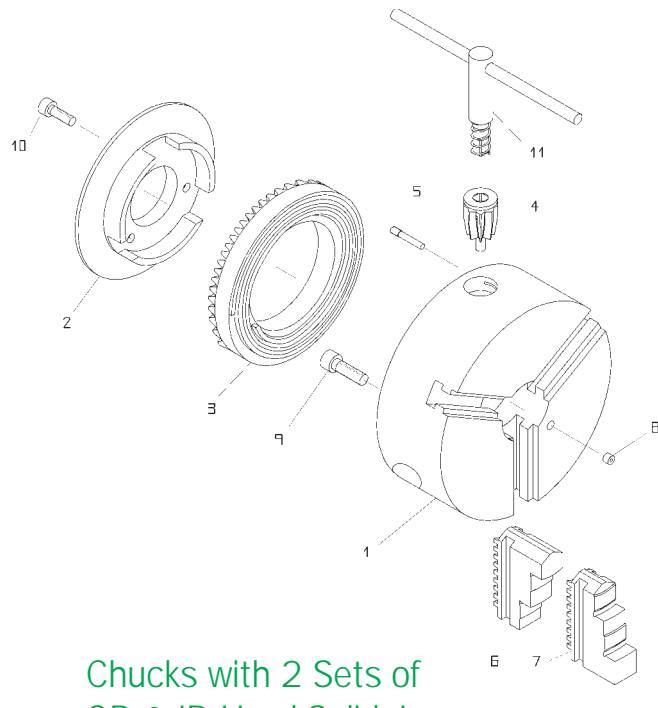
32" Chuck - for more information see page 40.



Spare Parts see pages 36-38.
Adapter plates see page 58-61.



Chucks with 2 Piece Reversible Jaws



Chucks with 2 Sets of OD & ID Hard Solid Jaws



Universal Self-Centering Scroll Chucks

2, 3 & 4 Jaw Plain Back, Semi-Steel Body

2 Jaw Two-Piece
3105

3 Jaw Two-Piece
3205

3 Jaw Solid
3204

4 Jaw Two-Piece
3605

4 Jaw Solid
3604

Back View



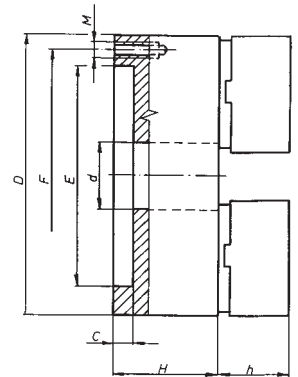
3105 3205 3204 3605 3604

Chuck Dia.	Hole Dia.	R.P.M max*	Weight lbs.	2-Jaw Two Piece	3-Jaw Two Piece	3-Jaw Solid	4-Jaw Two Piece	4-Jaw Solid
				Code No.				
3"	.6299	4000	3.3	-	-	7-810-0300	-	-
4"	.7874	3500	6.2	-	-	7-810-0400	-	-
5"	1.2598	3200	11.0	-	7-800-0500	7-810-0500	7-840-0500	7-845-0500
6-1/4"	1.6535	3000	22.0	7-830-0600	7-800-0600	7-810-0600	7-840-0600	7-845-0600
8"	2.1654	2500	39.0	7-830-0800	7-800-0800	7-810-0800	7-840-0800	7-845-0800
10"	2.9921	2000	64.0	7-830-1000	7-800-1000	7-810-1000	7-840-1000	7-845-1000
12-1/2"	4.0551	1500	110	7-830-1200	7-800-1200	7-810-1200	7-840-1200	7-845-1200
15-3/4"	5.3543	1000	188	7-830-1600	7-800-1600	7-810-1600	7-840-1600	7-845-1600
20"	7.4803	700	320	-	7-800-2000	7-810-2000	7-840-2000	7-845-2000
25"	9.9212	500	551	-	7-800-2500	7-810-2500	7-840-2500	7-845-2500
32"	10.500	350	890	-	7-800-3200	-	-	-

Note: Plain back chucks require adapter plates which may require machining to fit.

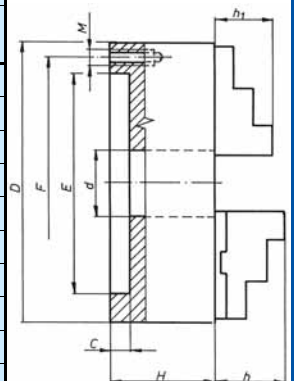
2 Jaw, Principal Dimensions (Back Mounting)

Chuck Dia. D	F	E	d	C	H	Top Jaws		Screws	
						h	Width	Thread M	Qty. per set
6-1/4"	5.5118	4.9213	1.6535	.1575	2.756	1.697	1.575	M10	3
8"	6.9291	6.2992	2.1654	.1575	3.150	1.776	1.575	M10	6
10"	8.8189	7.8740	2.9921	.1969	3.543	2.071	1.850	M12	6
12-1/2"	11.2598	10.2362	4.0551	.1969	3.937	2.240	2.047	M16	6
15-3/4"	14.2519	12.9921	5.3543	.1969	4.331	2.598	2.047	M16	6



3 & 4 Jaw, Principal Dimensions (Back Mounting)

Chuck Dia. D	F	E	d	C	H	h	h1	Adapter Mounting Bolts			
								Thread M	L	Qty. per set	Code No.
3-1/4"	2.6378	2.2047	0.6299	0.1181	1.732	-	0.512	M6x1	0.98	3	7-897-103
4"	3.2677	2.7559	0.7874	0.1181	1.969	-	0.669	M8x1.25	0.98	3	7-897-105
5"	4.252	3.7402	1.2598	0.1575	2.205	1.575	0.787	M8x1.25	0.98	3	7-897-105
6-1/4"	5.5118	4.9213	1.6535	0.1575	2.539	1.693	1.26	M10x1.5	0.98	3	7-897-108
8"	6.9291	6.2992	2.1654	0.1575	2.953	1.772	1.142	M10x1.5	0.98	6	7-897-108
10"	8.8189	7.874	2.9921	0.1969	3.347	2.087	1.339	M12x1.75	1.18	6	7-897-110
12-1/2"	11.2598	10.2362	4.0551	0.1969	3.701	2.244	1.693	M16x2	1.18	6	7-897-112
15-3/4"	14.2519	12.9921	5.3543	0.1969	4.134	2.639	2.165	M16x2	1.57	6	7-897-125
20"	18.0314	16.5354	7.4803	0.1969	4.724	3.15	2.362	M16x2	1.57	6	7-897-125
25"	23.0709	21.4567	9.9212	0.2756	5.315	3.425	2.756	M16x2	1.57	6	7-897-125
32"	SEE PAGE 40										7-897-132



Universal Self-Centering Scroll Chucks

3 Jaw
A1 & A 2 Type, Direct Mount

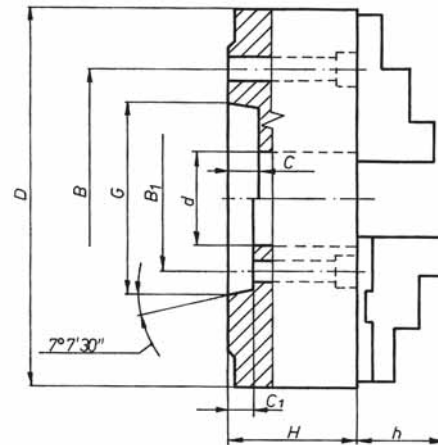
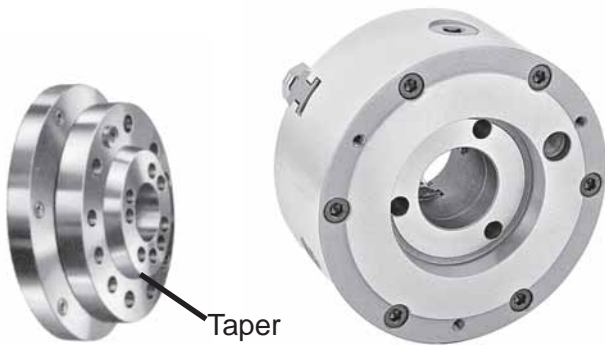
3215

Chuck Dia.	Taper Size	Hole Dia.	R.P.M. max.	Weight lbs.	Code No.
6-1/4"	A1-5	1.653	3000	22	7-801-0615
8"	A1-5	1.653	2500	42	7-801-0815
	A1-6	2.165			7-801-0816
10"	A2-5	2.992	2000	71	7-801-1015
	A1-6	2.165			7-801-1016
	A1-8	2.992			7-801-1018
12-1/2"	A2-6	4.055	1500	121	7-801-1216
	A1-8	3.150			7-801-1218
15-3/4"	A2-6	4.055	1000	203	7-801-1616
	A2-8	5.354			7-801-1618
	A1-11	5.118			7-801-1619
20"	A2-11	7.59	700	353	7-801-2029
25"	A2-11	7.590	500	628	7-801-2511
	A2-15	7.590			7-801-2515
32"	A2-20	12.598	300	847	7-801-3220

Note:
Type A1 Spindle has a 2 Bolt Hole Pattern (inside & outside the taper) an A1 or A2 Chuck will fit on it.
Type A2 Spindle has a 1 Bolt Pattern (outside the taper) only an A2 chuck will fit it.



Spare Parts on pages 36 - 38.



Principal Dimensions

Chuck Dia.	Taper Size	B (A-2)	B1 (A-1)	G	d	C/C1	H	h	Chuck Mounting Bolts			
									Thread	L	Qty.	Code No.
6-1/4"	A1-5	-	2.437	3.2505	1.6535	0.563	3.2087	1.693	7/16-14	2-3/4	3	7-897-521
8"	A1-5	-	2.437	3.2505	1.6535	0.563	3.5827	1.772	7/16-14	3-1/8	3	7-897-522
	A1-6	-	3.25	4.188	2.1653	0.625			1/2-13			7-897-533
10"	A2-5	4.126	-	3.2505	2.9921	0.563	4.0748	2.087	7/16-14	4-1/8	6	7-897-524
	A1-6	-	3.25	4.188	2.1653	0.625			1/2-13			7-897-534
	A1-8	-	4.375	5.5007	2.9921	0.688			5/8-11			7-897-545
12-1/2"	A2-6	5.252	-	4.188	4.0551	0.63	4.6338	2.244	1/2-13	4-3/4	6	7-897-537
	A1-8	-	4.375	5.5007	3.1496	0.688			5/8-11			7-897-548
15-3/4"	A2-6	5.252	-	4.188	4.0551	0.63	5.0591	2.639	1/2-13	5	6	7-897-552
	A2-8	6.748	-	5.5007	5.3543	0.709			5/8-11			7-897-552
	A1-11	-	6.5	7.7507	5.1181	0.75			3/4-10			7-897-564
20"	A2-11	9.252	-	7.7507	7.5905	0.787	5.748	3.091	3/4-10	5-7/8	6	7-897-567
	A2-11	9.252	-	7.7507	7.5905	0.75			3/4-10			7-897-569
25"	A2-15	13	-	11.251	7.5905	0.813	6.496	3.425	7/8-9	6	6	7-897-574
	A2-11	9.252	-	7.7507	7.5905	0.75			3/4-10			7-897-569
32"	A2-20	14.5	-	16.252	12.598		7.0866	3.425	1-8	6-1/8	6	7-897-584



Universal Self-Centering Scroll Chucks

3 Jaw
D 1 Type, Direct Mount

3245 3244

Chuck Dia.	Taper Size	Stud Dia.	Hole Dia.	R.P.M. max.	Weight lbs.	Two piece Code No.	Solid Code No.
5"	D1-3	16-Sep	1.26	3200	11	7-803-0533	-
	D1-4	8-May				7-803-0534	-
6-1/4"	D1-3	16-Sep	1.654	3000	20	7-803-0633	-
	D1-4	8-May				7-803-0634	7-809-0634
8"	D1-3	16-Sep	2.028	2500	42	7-803-0833	7-809-0833
	D1-4	8-May	2.165			7-803-0834	7-809-0834
	D1-5	4-Mar	2.165			7-803-0835	7-809-0835
	D1-6	7/8/2003	2.165			7-803-0836	7-809-0836
10"	D1-5	4-Mar	2.992	2000	71	7-803-1035	7-809-1035
	D1-6	7/8/2003				7-803-1036	7-809-1036
	D1-8	1/1/1900				7-803-1038	7-809-1038
12-1/2"	D1-6	7/8/2003	4.055	1500	112	7-803-1236	7-809-1236
	D1-8	1/1/1900				7-803-1238	7-809-1238
	D1-11	1/3/2016				7-803-1239	7-809-1239
15-3/4"	D1-6	7/8/2003	4.055	1000	223	7-803-1636	-
	D1-8	1/1/1900	5.354			7-803-1638	7-809-1638
	D1-11	1/3/2016	5.354			7-803-1639	7-809-1639
20"	D1-8	1/1/1900	5.354	700	331	7-803-2038	-
	D1-11	1/3/2016	7.598			7-803-2039	-
25"	D1-11	1/3/2016	7.598	500	604	7-803-2539	-



For Camlock Studs with Imperial Thread see pages 34.

Principal Dimensions

Chuck Dia.	Taper No.	B	G	d	C	H	h	Camlock Studs				Set Screw Code No.
								Dia.	Thread	Qty.	Code No.	
5"	D1-3	2.7795	2.1250	1.2598	.5118	2.7559	1.575	9/16	M10x1	3	7-899-103	7-899-305
	D1-4	3.2520	2.5005					5/8			7-899-104	
6-1/4"	D1-3	2.7795	2.1250	1.6535	.5118	3.2087	1.693	9/16	M10x1	3	7-899-103	7-899-305
	D1-4	3.2520	2.5005					5/8			7-899-104	
8"	D1-3	2.7795	2.1250	2.0275	.5118	3.5827	1.772	9/16	M10x1	3	7-899-103	7-899-305
	D1-4	3.2520	2.5005	2.1653	.5118			5/8			7-899-104	
	D1-5	4.1260	3.2505	2.1653	.5629			3/4	M12x1	6	7-899-105	7-899-305
	D1-6	5.2520	4.1880	2.1653	.5629			7/8	M16x1.5	6	7-899-106	7-899-306
10"	D1-5	4.1260	3.2505		.5629	4.0748	2.087	3/4	M12x1	6	7-899-105	7-899-305
	D1-6	5.2520	4.1880	2.9921	.6299			7/8			M16x1.5	
	D1-8	6.7480	5.5007		.7087			1	M20x1.5	6	7-899-108	7-899-310
12-1/2"	D1-6	5.2520	4.1880		.6299	4.6338	2.244	7/8	M16x1.5	6	7-899-106	7-899-310
	D1-8	6.7480	5.5007	4.0551	.7087			1			M20x1.5	
	D1-11	9.2520	7.7507		.7874			5.5118	1-3/16	M22x1.5	6	7-899-111
15-3/4"	D1-6	5.2520	4.1880	4.0551	.6299	5.0591	2.639	7/8	M16x1.5	6	7-899-106	7-899-310
	D1-8	6.7480	5.5007	5.3543	.7087			1			M20x1.5	
	D1-11	9.2520	7.7507	5.3543	.7874			1-3/16	M22x1.5	6	7-899-111	
20"	D1-8	6.7480	5.5007	5.3543	.7087	5.7480	3.150	1	M20x1.5	6	7-899-108	7-899-310
	D1-11	9.2520	7.7507	7.5984	.7874			1-3/16			M22x1.5	
25"	D1-11	9.2520	7.7507	7.5984	.7874	6.4960	3.425	1-3/16	M22x1.5	6	7-899-111	7-899-310



Universal Self-Centering Scroll Chucks

Camlock Studs with inch & metric threads & Set Screws
For D 1 Type, Direct Mount

Taper Size	Dia.	Qty. per Set	Camlock Studs Metric		Set Screw*	Camlock Studs English	
			Thread	Code No.	Code No.	Thread	Code No.
D1-3	9/16"	3	M10x1	7-899-103	7-899-305	7/16" - 20	7-899-403
D1-4	5/8"	3	M10x1	7-899-104	7-899-305	7/16" - 20	7-899-404
D1-5	3/4"	6	M12x1	7-899-105	7-899-305	1/2" - 20	7-899-405
D1-6	7/8"	6	M16x1.5	7-899-106	7-899-310	5/8" - 18	7-899-406
D1-8	1"	6	M20x1.5	7-899-108	7-899-310	3/4" - 16	7-899-408
D1-11	1-3/16"	6	M22x1.5	7-899-111	7-899-310	7/8" - 14	7-899-411
D1-15	1-3/8"	6	M24x1.5	7-899-115	7-899-310	-	-



For BISON Chucks use Studs with metric thread only.

Sold by piece

3 Jaw

L Type, Direct Mount 3255

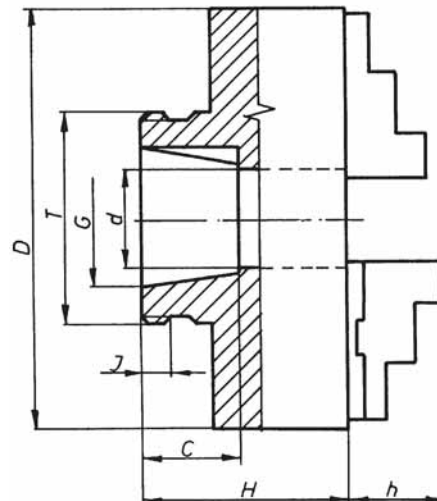
Chuck Dia.	Taper No.	Hole Dia.	R.P.M max*	Weight lbs.	Code No.
6-1/4"	L00	2.20	3000	23	7-804-0641
	L0	2.60			7-804-0642
8"	L00	2.20	2500	42	7-804-0841
	L0	2.60			7-804-0842
	L1	3.35			7-804-0843
10"	L0	2.60	2000	64	7-804-1042
	L1	3.35			7-804-1043
	L2	4.29			7-804-1044
12-1/2"	L0	2.60	1500	134	7-804-1242
	L1	3.35			7-804-1243
	L2	4.29			7-804-1244
15-3/4"	L1	3.35	1000	251	7-804-1643
	L2	4.29			7-804-1644



Spare Parts see page 36-38.

Principal Dimensions

Chuck Dia.	Taper Size	Thread T	G	d	J	C	H	h
6-1/4"	L00	3-3/4" - 6	2-3/4	2.2047	.5512	2.1260	4.0551	1.693
	L0	4-1/2" - 6	3-1/4	2.5984	.5906	2.5197	4.4488	
8"	L00	3-3/4" - 6	2-3/4	2.2047	.5512	2.1260	4.3701	1.772
	L0	4-1/2" - 6	3-1/4	2.5984	.5906	2.5197	4.7638	
	L1	6" - 6	4-1/8	3.3465	.6299	2.9921	5.2362	
10"	L0	4-1/2" - 6	3-1/4	2.5984	.5906	2.5197	5.0394	2.087
	L1	6" - 6	4-1/8	2.9900	.6299	2.9921	5.5118	
	L2	7-3/4" - 5	5-1/4	4.2913	.8661	3.5039	6.0236	
12-1/2"	L0	4-1/2" - 6	3-1/4	2.5984	.5906	2.5197	5.3937	2.244
	L1	6" - 6	4-1/8	3.3465	.6299	2.9921	5.8661	
	L2	7-3/4" - 5	5-1/4	4.2913	.8661	3.5039	6.3780	
15-3/4"	L1	6" - 6	4-1/8	3.3465	.6299	2.9921	6.1811	2.639
	L2	7-3/4" - 5	5-1/4	4.2913	.8661	3.5039	6.6929	



Universal Self-Centering Scroll Chucks

3 Jaw Threaded Direct Mount

3285/3284

Chuck Dia.	Thread Dia.	Hole Dia.	R.P.M max*	Weight lbs.	Code No.
4"	1" - 10	.79	3500	8.8	7-805-0451
	1-1/8" - 12W				7-805-0555
	1-1/2" - 8				7-805-0452
5"	1" - 10	1.26	3200	12	7-805-0551
	1-1/2" - 8				7-805-0552
6-1/4"	1-1/2" - 8	1.57	3000	23	7-805-0652
	2-1/4" - 8				7-805-0653
8"	1-1/2" - 8	2.17	2500	45	7-805-0852
	2-1/4" - 8				7-805-0853
	2-3/8" - 6				7-805-0854
10"	2-1/4" - 8	2.99	2000	75	7-805-1053
12-1/2"	2-3/8" - 6	4.06	1500	121	7-805-1254
	2-3/4" - 8				7-805-1255

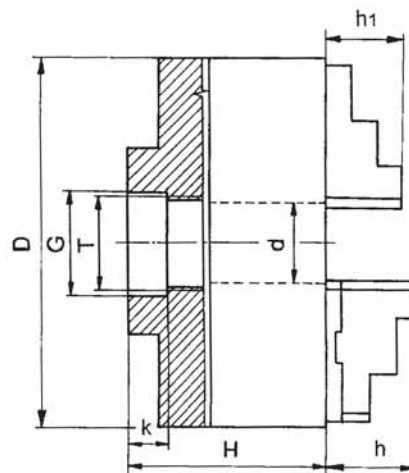


4" only



Principal Dimensions

Chuck Dia.	Thread Dia.	G	d	k	H	h	h1
4"	1" - 10	1.0150	.7874	1/2	3.543	-	.669
	1-1/8" - 12W	-					
	1-1/2" - 8"	1.5150					
5"	1" - 10	1.0150	1.2598	1/2	3.740	1.575	-
	1-1/2" - 8"	1.5150					
6-1/4"	1-1/2" - 8	1.5150	1.5748	1/2 5/8	4.134 4.331	1.693	-
	2-1/4" - 8"	2.2600					
8"	1-1/2" - 8	1.5150	2.1653	1/2 5/8 3/4	4.528 4.724 4.922	1.772	-
	2-1/4" - 8	2.2600					
	2-3/8" - 6"	2.3850					
10"	2-1/4" - 8"	2.2600	2.9921	5/8	5.512	2.087	-
12-1/2"	2-3/8" - 6	2.3850	4.0551	3/4	5.906	2.244	-
	2-3/4" - 8"	2.7600					



Hard & Soft Solid Jaws

For 3 & 4 Jaw Scroll Chucks



O. D. Hard Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
3"	7-880-303	-
4"	7-880-304	-
5"	7-880-305	7-880-405
6"	7-880-306	7-880-406
8"	7-880-308	7-880-408
10"	7-880-310	7-880-410
12"	7-880-312	7-880-412
16"	7-880-316	7-880-416
20"	7-880-320	7-880-420
25"	7-880-325	7-880-425



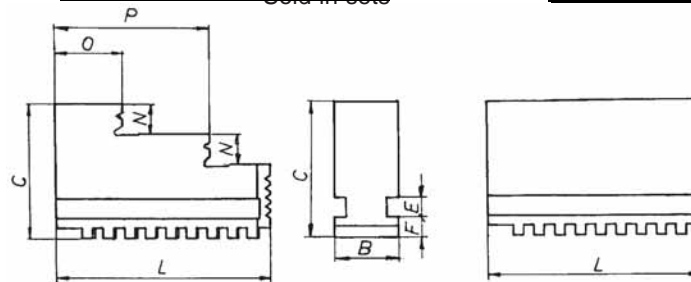
I. D. Hard Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
3"	7-881-303	-
4"	7-881-304	-
5"	7-881-305	7-881-405
6"	7-881-306	7-881-406
8"	7-881-308	7-881-408
10"	7-881-310	7-881-410
12"	7-881-312	7-881-412
16"	7-881-316	7-881-416
20"	7-881-320	7-881-420
25"	7-881-325	7-881-425



Soft Solid Jaws

Chuck Dia.	3-Jaw	4-Jaw
	Code No.	
3"	7-882-303	-
4"	7-882-304	-
5"	7-882-305	-
6"	7-882-306	7-882-406
8"	7-882-308	7-882-408
10"	7-882-310	7-882-410
12"	7-882-312	7-882-412
16"	7-882-316	7-882-416
20"	7-882-320	7-882-420
25"	7-882-325	7-882-425

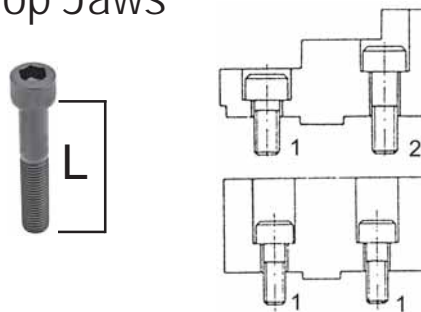


Principal Dimensions

Chuck Dia.	C	L	B	F	E	N	P	O	Hard Solid Jaws Weight lbs./1 pc.	Soft Solid Jaws Weight lbs./1 pc.
3"	1.1024	1.2598	.4331	.2362	.2362	.2362	0.827	.374	.10	.13
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.19	.29
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.313	.512	.40	.57
6-1/4"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	.80	1.10
8"	2.1260	3.3459	.9843	.3543	.3937	.4724	2.244	.906	1.07	1.77
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	1.73	3.00
12-1/2"	2.9528	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	2.90	4.20
15-3/4"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	5.20	5.33
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	7.33	11.00
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	13.00	19.00

Mounting Bolts for Hard & Soft Top Jaws

Chuck Dia.	Thread	Screw No. 1		Screw No. 2	
		L	Code No.	L	Code No.
5"	5/16"-18	.79	7-897-503	1.00	7-897-504
6-1/4"	3/8"-16	.79	7-897-510	1.18	7-897-512
8"	3/8"-16	.79	7-897-511	1.18	7-897-513
10" & 12-1/2"	1/2"-13	1.00	7-897-530	1.57	7-897-531
15-3/4"	5/8"-11	1.18	7-897-540	1.77	7-897-541
20"	3/4"-10	1.57	7-897-560	2.95	7-897-561
25" & 32"	3/4"-10"	1.57	7-897-560	3.15	7-897-562



Sold by piece

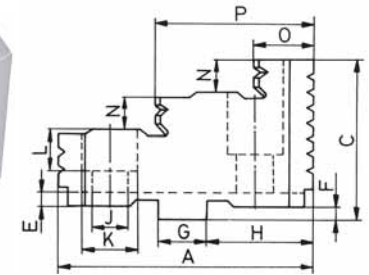


Chuck Jaws

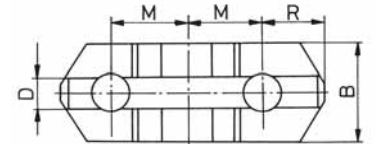
Hard Top Jaws for 2, 3 & 4 Jaw Scroll Chucks

Chuck Dia.	3-Jaw	3-Jaw Heavy Duty	4-Jaw
	Code No.		
5"	7-883-305	-	7-883-405
6-1/4"	7-883-306	-	7-883-406
8"	7-883-308	-	7-883-408
10"	7-883-310	7-883-3100	7-883-410
12-1/2"	7-883-312	7-883-3120	7-883-412
15-3/4"	7-883-316	7-883-3160	7-883-416
20"	7-883-320	7-883-3200	7-883-420
25"	7-883-325	7-883-3250	7-883-425
32"	7-883-325	7-883-3250	-

Standard Jaws



Note: Standard Jaws are designed for finishing and medium duty machining. Heavy Duty Jaws are designed for heavy duty machining.



Sold in sets

Principal Dimensions

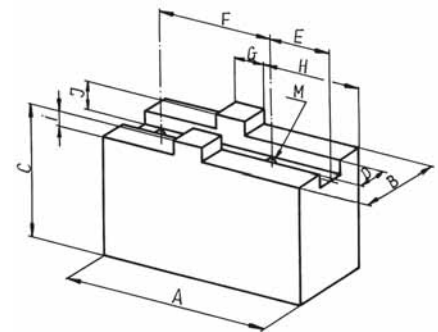
American Standard tongue & groove Jaws.

Chuck Dia.	M	H	G	J	K	D	F	N	C	B	OAL A	O	P	Weight of One Jaw lbs.
5"	5/8	57/64	.4996	.35/.26*	.59/.43*	.3129	.1260	.315	1.516	.866	2.205	.57	1.38	.37
6"	3/4	1-1/8	.4996	.43/.35*	.71/.55*	.3129	.1260	.335	1.634	.984	2.638	.71	1.63	.56
8"	7/8	1-3/8	.4996	.43/.35*	.71/.55*	.3129	.1260	.374	1.713	1.063	3.347	.85	2.01	.79
10"	1-1/16	1-9/16	.7496	.55	.78	.5004	.1260	.472	2.023	1.280	3.740	.96	2.32	1.32
12"	1-1/4	1-7/8	.7496	.55	.78	.5004	.1260	.512	2.165	1.457	4.331	1.04	2.68	2.01
16"	1-1/2	2-1/4	.7496	.71	1.0	.5004	.2480	.532	2.539	1.654	5.000	1.06	3.01	2.98
20"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.689	2.933	1.654	5.000	1.97	3.46	3.42
25" & 32"	1-1/2	2-1/4	.7496	.87	1.3	.5004	.2480	.827	3.228	2.047	5.000	2.01	3.50	5.34

Soft Top Jaws

Jaw mounting bolts see page 36.

Chuck Dia.	2-aw	3-Jaw
	Code No.	
5"	-	7-884-305
6"	7-884-206	7-884-306
8"	7-884-208	7-884-308
10"	7-884-210	7-884-310
12"	7-884-212	7-884-312
16"	-	7-884-316
20"	-	7-884-320
25" & 32"	-	7-884-325



Sold by piece

Principal Dimensions

American Standard tongue & groove Jaws.

Chuck Dia.	A	3 & 4 Jaw B	2,3 & 4 Jaw B	C	D	E	F	G	H	I	J	K	Bolt Size M 3-jaw	Weight lbs/pc.
5"	2.520	0.866	-	1.520	.3129	0.5910	1-1/4	.500	1.000	.1260	.283	-	5/16-18	.66
6-1/4"	3.071	1.000	1.575	1.634	.3129	0.8386	1-1/2	.500	1.339	.1260	.283	.118	3/8-16	1.01
8"	3.543	1.063	1.575	1.713	.3129	0.9488	1-3/4	.500	1.575	.1260	.283	.197	3/8-16	1.43
10"	4.173	1.280	1.850	2.028	.5000	1.0827	2-1/8	.750	1.772	.1260	.283	.315	1/2-13	2.54
12-1/2"	4.724	1.457	2.047	2.165	.5000	1.2087	2-1/2	.750	2.087	.2480	.283	.394	1/2-13	3.53
15-3/4"	5.512	1.654	2.047	2.539	.5000	1.3543	3	.750	2.480	.2480	.406	.512	5/8-11	4.85
20"	5.512	1.654	-	2.933	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	5.29
25"-32"	6.299	2.047	-	3.288	.5000	1.3543	3	.750	2.480	.2480	.406	-	3/4-10	9.26
36"-49"	6.299	2.835	-	3.819	.5000	1.1583	3	.750	2.284	.2480	.409	-	3/4-10	16.00



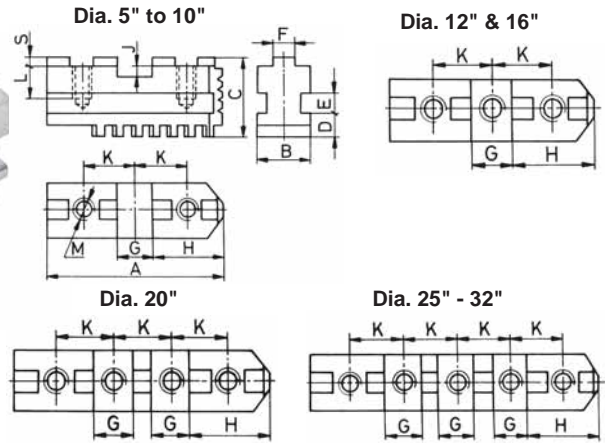
Jaw mounting bolts see page 36.



Hard Master Jaws

For 2, 3 & 4 Jaw Self-Centering Scroll Chucks

Chuck Dia.	2-Jaw	3-Jaw	4-Jaw
	Code No.		
5"	-	7-885-305	7-885-405
6"	7-885-206	7-885-306	7-885-406
8"	7-885-208	7-885-308	7-885-408
10"	7-885-210	7-885-310	7-885-410
12"	7-885-212	7-885-312	7-885-412
16"	7-885-216	7-885-316	7-885-416
20"	-	7-885-320	7-885-420
25"	-	7-885-325	7-885-425
32"	-	7-885-325	-



Sold in sets

Principal Dimensions

Chuck Dia.	K	H	G	F	J	L	D	E	B	OAL A	S	Thread M	Weight* lbs.
5"	5/8	57/64	.4996	5/16	.1575	.4724	.3150	.3150	.7874	2.1259		5/16-18	.31
6"	3/4	1-1/8	.4996	5/16	.1575	.5511	.3150	.3150	.7874	2.5590		3/8-16	.40
8"	7/8	1-3/8	.4996	5/16	.1575	.5511	.3543	.3937	.9843	3.1102		3/8-16	.68
10"	1-1/16	1-9/16	.7496	1/2	.1575	.6299	.4331	.4724	1.1024	3.6220		1/2-13	1.06
12"	1-1/4	1-7/8	.7496	1/2	.1575	.6299	.5000	.4724	1.2598	4.3307	.126	1/2-13	1.70
16"	1-1/2	2-1/4	.7496	1/2	.2835	.8661	.5906	.5512	1.4173	5.1181		5/8-11	2.43
20"	1-1/2	2-1/4	.7496	1/2	.2835	1.2598	.6299	.5512	1.5748	6.5351		3/4-10	4.81
25"	1-1/2	2-1/4	.7496	1/2	.2835	1.2598	.6299	.5512	1.9685	8.2677		3/4-10	7.36
32"	1-1/2	2-1/4	.7496	1/2	.2835	1.2598	.6299	.5512	1.9685	8.8583		3/4-10	7.36



Jaw mounting bolts see page 36.

American Standard tongue & groove Jaws.

*Approximate weight of one jaw.

Spare Parts

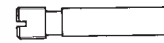
For 2, 3 & 4 Jaw Self-Centering Scroll Chucks

D - OD Dia.

H - Height

L - OAL

Sold by piece



Chuck Dia.	Scroll				Pinion				Wrench		Pinion Screw
	2-3-4-Jaw			Weight lbs.	2-3-4-Jaw			Weight lbs.	2-3-4-Jaw	Square Size	2-3-4-Jaw
	Code No.	D	H		Code No.	D	L		Code No.		Code No.
3"	7-887-303	2.16	.41	.16	7-886-303	.75	1.02	.04	7-889-003	.2344	7-888-904
4"	7-887-304	2.74	.49	.34	7-886-304	.98	1.40	.12	7-889-005	.3543	7-888-904
5"	7-887-305	3.70	.53	.66	7-886-305	.98	1.63	.14	7-889-005	.3543	7-888-906
6-1/4"	7-887-306	4.88	.71	1.85	7-886-306	1.1	1.87	.20	7-889-008	.4331	7-888-906
8"	7-887-308	6.26	.79	2.65	7-886-308	1.2	2.30	.42	7-889-008	.4331	7-888-910
10"	7-887-310	7.84	.87	4.28	7-886-310	1.4	2.72	.51	7-889-012	.5512	7-888-910
12-1/2"	7-887-312	10.1	.98	9.50	7-886-312	1.5	3.60	.77	7-889-012	.5512	7-888-910
15-3/4"	7-887-316	12.9	1.10	18.8	7-886-316	1.7	4.41	1.48	7-889-016	.6693	7-888-920
20"	7-887-320	16.4	1.18	36	7-886-320	2.0	5.30	2.09	7-889-025	.7480	7-888-920
25"	7-887-325	21.3	1.57	66	7-886-325	2.0	5.87	2.51	7-889-025	.7480	7-888-920
32"	7-887-332	27.4	1.77	148	7-886-332	2.0	8.07	4.41	7-889-332	.7480	7-888-920

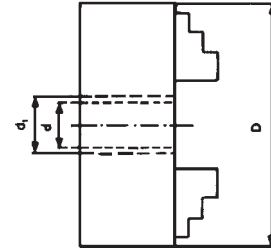


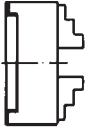

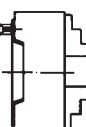


Thru Hole Permissible Enlargements

For Chucks 3200, 3500

d* - through hole diameter made by manufacturer

d₁ - permissible enlargement of through hole



Mounting	Hole Dia.	Chuck Size	3-1/2"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	32-1/2"
3505 3204/5 	d*	plain back	0.6299	0.7874	1.2598	1.6535	2.1654	2.9922	4.0551	5.3543	7.4803	9.9213	10.5
	d ₁		0.7087	0.9055	1.3465	1.9252	2.819	3.5827	4.4882	5.748	8.3465	12.0472	12.5984
3515 3214/5  Short	d*	Taper 1 in 4				1.6535	1.6535 2.1635	2.9921 2.1635 2.9921	4.0551 3.1496	4.0551 5.3543 5.1181	5.3543 7.5905	5.1181	
	d ₁		5 6 8 11				1.6535	1.6535 2.2835	3.0708 2.2835 3.1496	4.252 3.1496	4.252 5.3543 5.1969	5.3543 7.5905	5.1181
3545 3244/5  Camlock "D"	d*	Taper 1 in 4		0.7847	1.2598 1.2598	1.6535 1.6535 1.6535	2.0236 2.1654 2.1654	2.9922 2.9922 2.9922	4.0551 4.0551	4.0551 5.3543 5.3543	5.3543 7.5984	7.5984	
	d ₁		3 4 5 6 8 11		0.7847	1.2598 1.2598	1.9685 1.9685 1.9685	2.0236 2.3622 2.6378	2.9922 3.7402 3.7402	4.0551 4.5276	4.0551 5.3543 5.9055	5.3543 7.5984	7.5984
3254/5 	d*	L00 L0 L1 L2 L3			1.2598	1.6535 1.6535 1.6535	2.1654 2.1654 2.1654	2.2047 2.5984 2.9921 2.9921	2.5984 3.3464 4.0551	2.5984 3.3464 4.2913 5.3543			
	d ₁	L00 L0 L1 L2 L3			1.2598	1.7717 1.7717 1.7717	2.1654 2.1654 2.559	2.2047 2.5984 2.9921 2.9921	2.5984 3.3464 4.0551	2.5984 3.3464 4.2913 5.3543			
3284/5 	d*	1"-10 1-1/2"-8 2-1/4"-8 2-3/8"-6 2-3/8"-8		0.7874 0.7874	0.88 1.2598	1.3647 1.6535	1.3647 2.1147 2.1654	2.1147	2.1946 2.2397				
	d ₁	1"-10 1-1/2"-8 2-1/4"-8 2-3/8"-6 2-3/8"-8		0.7874 0.7874	0.88 1.2598	1.3647 1.7717	1.3647 2.1147 2.5591	2.1147	2.1946 2.2397				



Large Thru-Hole 3 Jaw Self-Centering

Scroll Chucks, Plain Back
Steel & Semi-Steel Body

3205/3505

Chuck Dia.	Chuck Body	Hole Dia.	R.P.M. max.	Weight lbs.	Code No.
31-1/2"	semi-steel	10-1/2"	300	7 38	7-800-3200
	steel		450	7 72	7-820-3200

Universal, Three-Jaw, Scroll Lathe Chucks with large through hole. Two-piece reversible tongue and groove jaws. Available in semi-steel or steel body. Plain back mount. Jaws, scroll plate and three pinions are made of fine alloy steel, carefully heat treated and ground; balanced scroll.

Chucks are available with 10-1/2" through-hole which can be increased by the user to 12-1/2".

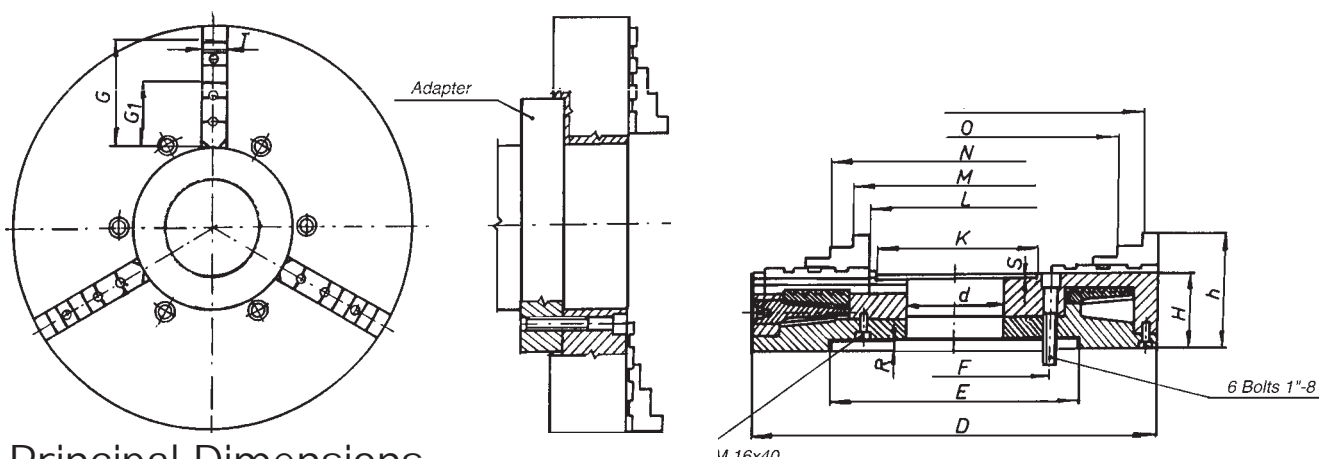
Standard Accessories:

1 set of two-piece reversible jaws (hard top jaws and hard master jaws), 1 wrench, 1 set of mounting screws.

Optional Accessories:

Soft top jaws.

Adapter Plates on pages 58 & 59.



Principal Dimensions

Chuck Dia.	d	E	F	H	h	K	R	L	M	N	O	P
31-1/2"	10-1/2	17.717	14.500	6.26	9.67	12-1/2	.7874	5.91-18.98	11.10-24.17	17.64-30.71	11.89-24.96	18.43-31-1/2

Spare Parts



Chuck Dia.	Hard Master Jaws 3pc/Set	Hard Top Jaws 3pc/Set	Hard Top Jaws Heavy Duty 3pc/Set	Soft Top Jaw 1 Pc.	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.	Pinion Screw 1 Pc.	Chuck Mounting Bolts, 1Pc.
Code No.									
32"	7-885-332	7-883-325	7-883-3250	7-884-332	7-887-532	7-886-332	7-889-032	7-888-920	7-897-125



XLarge Thru-Hole 3 Jaw Self-Centering

Scroll Chucks, Plain Back
Semi-Steel Body

3295

Chuck Dia.	Hole Dia.	Jaw Stroke		Weight lbs.	Max R.P.M.	Code No.
		min.	max.			
16"	8.66	6.61	11.34	127	500	7-819-1600
20"	12.60	9.87	14.96	167	350	7-819-2000
26"	15.98	14.80	19.57	300	250	7-819-2600

American Standard Two-Piece Tongue & Groove Jaws

Large Diameter through-hole Chucks are designed for pipe machining or pipe welding/cut off operations. They can also be used on lathes, rotary tables and welding devices.

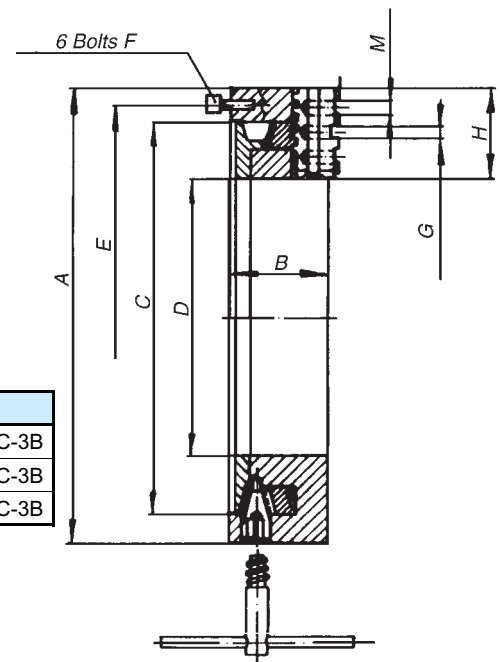
Two-piece reversible American Standard Tongue and Groove jaws. Semi-steel body. Plain back mount. Jaws, scroll plate and three pinions are made of fine alloy steel, heat treated and ground. Balanced scroll.

Standard Accessories:

- 1 set of master jaws.
- 1 wrench, 1 set of mounting screws.

Optional Accessories:

- Hard top jaws.
- Soft top jaws.
- Adapter Plates see pages 58 & 59.



Principal Dimensions

Chuck Dia.	G	F	D	B	E	C	H	M
15-3/4"	0.7496	M 12x40	8.661	4.134	15.000	14.252	4.724	5/8"-11 UNC-3B
20"	0.7496	M 16x40	12.600	4.724	18.957	18.189	4.724	3/4"-10 UNC-3B
26"	0.7496	M 16x40	16	5.315	24.409	22.835	5	3/4"-10 UNC-3B

Spare Parts



Chuck Dia.	Hard Master Jaws 3pc/Set	Hard Top Jaws 3pc/Set	Hard Top Jaws Heavy Duty 3pc/Set	Soft Top Jaw 1 Pc.	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.	Pinion Screw 1 Pc.	Chuck Mounting Bolts, 1Pc.
	Code No.								
15-3/4"	7-885-116	7-883-316	7-883-3160	7-884-316	7-887-216	7-886-216	7-889-016	7-888-920	7-897-116
20"	7-885-120	7-883-320	7-883-3200	7-884-320	7-887-220	7-886-220	7-889-025	7-888-920	7-897-125
26"	7-885-126	7-883-325	7-883-3250	7-884-325	7-887-226	7-886-226	7-889-025	7-888-920	7-897-125



Front Mounting Self-Centering

3 & 4 Jaw Scroll Chucks Plain Back, Steel & Semi-Steel Body

3274 / 3574
7-811- / 7-813-...1

3274 3275 3275 3575 3675

3275 / 3575
7-812- / 7-813-...0

3675
7-814-

Chuck Dia.	Hole Dia.	Weight lbs.	3-Jaw			4-Jaw	
			Solid Jaws Code No.	2pc. Jaws Code No.	2pc. Jaws Code No.	Solid Jaws Code No.	2pc. Jaws Code No.
3-1/4"	.6299	3.6	7-811-0300	-	-	7-813-0301	-
3.3"	.7087	4.2	7-811-0330	-	-	-	-
4"	0.7874	5.3	7-811-0400	-	-	7-813-0401	-
5"	1.2598	9.3	7-811-0500	7-812-0500	7-813-0500	7-813-0501	7-814-0500
6-1/4"	1.6535	17.0	7-811-0600	7-812-0600	7-813-0600	7-813-0601	7-814-0600
8"	2.1654	32.0	7-811-0800	7-812-0800	7-813-0800	7-813-0801	7-814-0800
10"	2.9921	52.0	7-811-1000	7-812-1000	7-813-1000	7-813-1001	7-814-1000
12-1/2"	4.0551	87.0	7-811-1200	7-812-1200	7-813-1200	7-813-1201	7-814-1200
15-3/4"	5.3543	163	-	-	7-813-1600	7-813-1601	7-814-1600



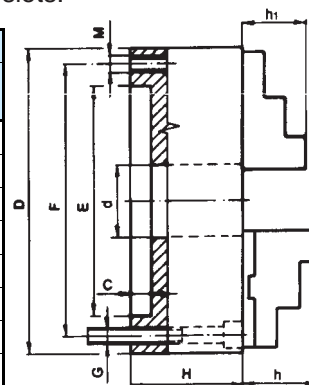
Base Plates are designed for use with BISON 3 & 4 Jaw, Front Mounting, Self-Centering Lathe Chucks. Ideal for use on milling and drilling machines as well as on rotary tables with 3/6 or 4/8 slots. For more information see page 96.



3 and 4 Jaw Scroll Chucks with semi-steel (7-811-, 7-812- & 7-814-) and forged steel body (7-813-) are designed for use with all rotary tables and other devices where back mounting chucks cannot be used. They can be mounted directly on 3/6 slot rotary tables or on a base plate when the rotary table has 3/6 or 4/8 T-slots.

Principal Dimensions

Chuck Dia. D	F	E H7	d	C	H	h	h1	Screws			
								Thread G	Qty. per set	Thread M	Qty. per set
3-1/4"	2.6378	2.2047	0.6299	0.1181	1.732		0.512	1/4-20 x 1.97	3	M6	3
3.3"	2.8346	2.4409	0.71	0.118	1.73		0.51	1/4-20 x 1.97		M6	3
4"	3.2677	2.7559	0.7874	.1181	1.969	-	0.669	5/16-18 x 2.17		M8	3
5"	4.2520	3.7402	1.2598	.1575	2.205	1.575	0.787	5/16-18 x 2.17		M8	3
6-1/4"	5.5118	4.9213	1.6535	.1575	2.559	1.693	1.260	3/8-16 x 2.76		M10	3
8"	6.9291	6.2992	2.1654	.1575	2.953	1.772	1.142	3/8-16 x 3.15		M10	6
10"	8.8189	7.8740	2.9921	.1969	3.347	2.087	1.339	1/2-13 x 3.54		M12	6
12-1/2"	11.2598	10.2362	4.0551	.1969	3.701	2.244	1.693	5/8-11 x 3.94		M12	6
15-3/4"	14.2519	12.9921	5.3543	.1969	4.134	2.639	2.165	5/8-11 x 4.53		M16	6



Spare Parts

Chuck Dia.	Master Jaws 3pc-SET	Master Jaws 4pc-SET	OD Jaws 3pc-SET	ID Jaws 3pc-SET	Soft Top Jaw/1 Pc.	Scroll 1 Pc.	Scroll 1 Pc.	Pinion 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.
Code No.										
3"	-	-	7-880-303	7-881-303	-	7-887-303	-	7-886-303	-	7-889-003
3.3"	-	-	7-880-303	7-881-303	-	7-887-303	-	7-886-303	-	7-889-003
4"	-	-	7-880-304	7-881-304	-	7-887-304	-	7-886-304	-	7-889-005
5"	7-885-305	7-885-405	7-880-305	7-881-305	7-884-305	7-887-305	7-887-505	7-886-305	7-886-505	7-889-005
6-1/4"	7-885-306	7-885-406	7-880-306	7-881-306	7-884-306	7-887-306	7-887-506	7-886-306	7-886-506	7-889-008
8"	7-885-308	7-885-408	7-880-308	7-881-308	7-884-308	7-887-308	7-887-508	7-886-308	7-886-508	7-889-008
10"	7-885-310	7-885-410	7-880-310	7-881-310	7-884-310	7-887-310	7-887-510	7-886-310	7-886-510	7-889-012
12-1/2"	7-885-312	7-885-412	7-880-312	7-881-312	7-884-312	7-887-312	7-887-512	7-886-312	7-886-512	7-889-012
15-3/4"	7-885-315	7-885-416	-	-	7-884-316	7-887-316	-	7-886-316	-	7-889-016



3 Jaw Self-Centering Scroll Chucks

with Double Jaw Guides

These precision lathe chucks are highly rigid with double jaw guides. They can be used on all types of lathes and different kinds of milling, drilling, CNC attachments. Chucks are provided with two sets of hard solid OD & ID jaws.

BODY - is made of high quality cast iron. All guideways and bearing surfaces are precisely machined.

SCROLL PLATE - drop forged of fine alloy steel, carefully case hardened. Thread flanks are ground on both sides.

JAWS - the teeth and guides are hardened and fully ground on both sides.

3 PINIONS - are hardened and ground.

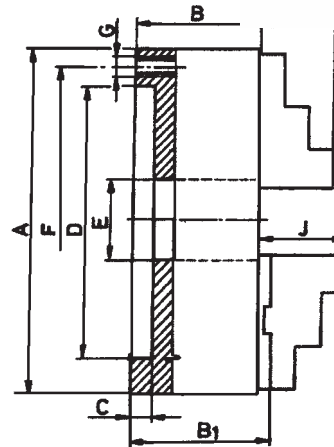


Standard Accessories:

- 2 sets of hard solid jaws (inside and outside),
- 1 self-ejecting wrench, mounting bolts,
- 1 allen key

Optional Accessories:

- Soft solid jaws.



3202

Chuck Dia.	B	C	D	E Hole	F	G*	B1	H	J**	Weight lbs.	R.P.M. Max.	3-Jaw Code No.
6-1/4"	2.93	.26	4.9213	1.65	5.5118	M10	3.12	.98	1.70	22	3000	7-816-0600
8"	3.27	.26	6.2992	2.17	6.9291	M10	3.46	1.14	1.77	39	2500	7-816-0800
10"	3.78	.24	7.8740	2.99	8.8189	M12	3.93	1.38	2.09	65	2000	7-816-1000
12-1/2"	4.33	.25	10.2362	4.06	11.2598	M16	4.53	1.63	2.24	110	1500	7-816-1200
15-3/4"	4.72	.24	12.9921	5.35	14.2519	M16	5.01	2.20	2.64	203	1000	7-816-1600
20"	5.51	.63	16.5354	7.48	18.0314	M16	5.94	2.36	3.09	282	700	7-816-2000

*Each Chuck has 6 mounting bolts.

**Two piece jaw chucks.



Adapter Plates see pages 58-61.



Spare Parts

Chuck Dia.	ID Jaws 3 Pc./Set	OD Jaws 3 Pc./Set	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.	Pinion Screw/1 Pc.
	Code No.					
6-1/4"	7-885-806	7-883-806	7-887-306	7-886-306	7-889-008	7-888-906
8"	7-885-808	7-883-808	7-887-308	7-886-308	7-889-008	7-888-910
10"	7-885-810	7-883-810	7-887-310	7-886-310	7-889-012	7-888-910
12-1/2"	7-885-812	7-883-812	7-887-312	7-886-312	7-889-012	7-888-910
15-3/4"	7-885-816	7-883-816	7-887-316	7-886-316	7-889-016	7-888-920
20"	7-885-820	7-883-820	7-887-320	7-886-320	7-889-025	7-888-920



4 Jaw Combination Lathe Chucks

Steel & Semi-steel Body

4605

4805

Chuck Dia.	Hole Dia.	Semi-Steel			Steel		
		RPM	Weight lbs.	Code No.	RPM	Weight lbs.	Code No.
8"	2.17	2000	41.4	7-848-0800	2500	43.0	7-849-0800
10"	2.99	1800	65.0	7-848-1000	2000	68.3	7-849-1000
12-1/2"	4.05	1500	120	7-848-1200	1700	124	7-849-1200
15-3/4"	5.35	1000	194	7-848-1600	1500	198	7-849-1600
20"	7.48	500	330	7-848-2000	1000	342	7-849-2000
25"	9.92	350	551	7-848-2500	750	573	7-849-2500



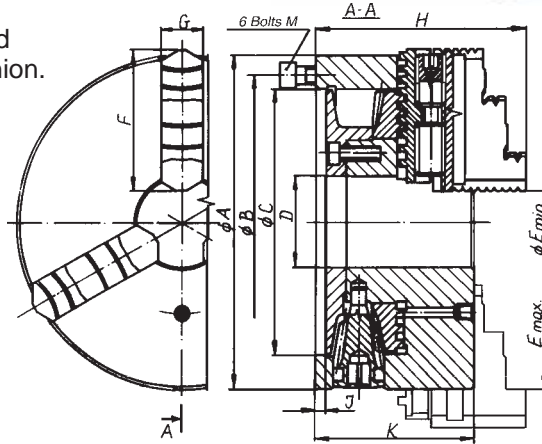
Bison Plain Back combination chucks combine the advantages of a scroll chuck with those of an independent chuck. Each jaw may be adjusted individually with an independent operating screw. After the desired eccentric setting has been made, all jaws can then be opened and closed simultaneously with the use of a scroll and pinion. The jaws are reversible and may be used as inside and outside jaws.

Standard Accessories:

- 1 set of hard solid reversible jaws,
- 1 wrench,
- 1 set of mounting screws.

Optional Accessories:

- Soft solid jaws.



Principal Dimensions

Chuck Size	B	C	D	E		F	G	H	J	K	M
				min.	max.						
8"	6.9291	6.2992	2.1654	0.15	8	3.3465	.984	5.0000	.2165	3.7800	M10
10"	8.8190	7.8740	2.9921	0.20	10	3.5827	1.102	5.3150	.2362	4.0157	M12
12-1/2"	11.2598	10.2362	4.0551	0.39	12-1/5	4.9213	1.260	6.2402	.2362	4.6063	M16
15-3/4"	14.2520	12.9921	5.3543	0.59	15-3/4	5.7087	1.457	7.1650	.2480	4.8400	M16
20"	18.0315	16.5354	7.4803	0.78	20	7.0866	1.653	8.1100	.3150	5.7087	M16
25"	23.0709	21.4567	9.9221	1.18	25	8.8583	1.653	9.1340	.3937	6.2992	M16



Adapter Plates see pages 58 - 61.



Spare Parts

Chuck Dia.	Hard Reversible Jaws Set	Hard Master Jaws Set	Soft Solid Jaw Set	Operating Screw 1 Pc.	Scroll Plate 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.
	Code No.						
8"	7-891-108	7-891-208	7-891-308	7-891-408	7-887-308	7-886-308	7-891-908
10"	7-891-110	7-891-210	7-891-310	7-891-410	7-887-310	7-886-310	7-891-910
12-1/2"	7-891-112	7-891-212	7-891-312	7-891-412	7-887-312	7-886-312	7-891-912
15-3/4"	7-891-116	7-891-216	7-891-316	7-891-416	7-887-316	7-886-316	7-891-916
20"	7-891-120	7-891-220	7-891-320	7-891-420	7-887-320	7-886-320	7-891-925
25"	7-891-125	7-891-225	7-891-325	7-891-425	7-887-325	7-886-325	7-891-925



4 Jaw Independent Lathe Chucks

Steel & Semi-steel Body

BISON medium duty and heavy duty 4 Jaw independent chucks are designed to grip round or odd shaped work.

- Medium duty chucks have a semi-steel body and hard solid reversible jaws (36" has two-piece hard reversible jaws)
- Heavy duty chucks have a steel body and two-piece hard reversible jaws
- Solid jaws are made of high quality carbon steel and they are hardened
- Hard Top and Hard Master Jaws are made of high quality alloy steel and they are hardened and ground.
- Four jaw semi-steel body Lathe Chucks with hard solid reversible jaws.

Standard Accessories:

Chucks with Dia. 3-1/2" to 32" are provided with 1 set of hard solid reversible jaws, 1 wrench, 1 set of clamping bolts. 36" chuck is provided with with two-piece reversible jaws (hard top jaws & hard master jaws).

Optional Accessories:

Hard top jaws, hard master jaws & soft top jaws.



Adapter Plates see pages 58 - 61.



Spare parts see pages 50 & 51.



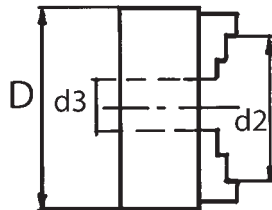
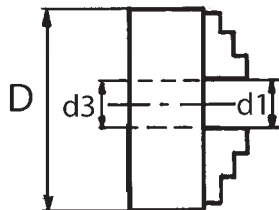
Chuck Grease
Code No. 7-799-025



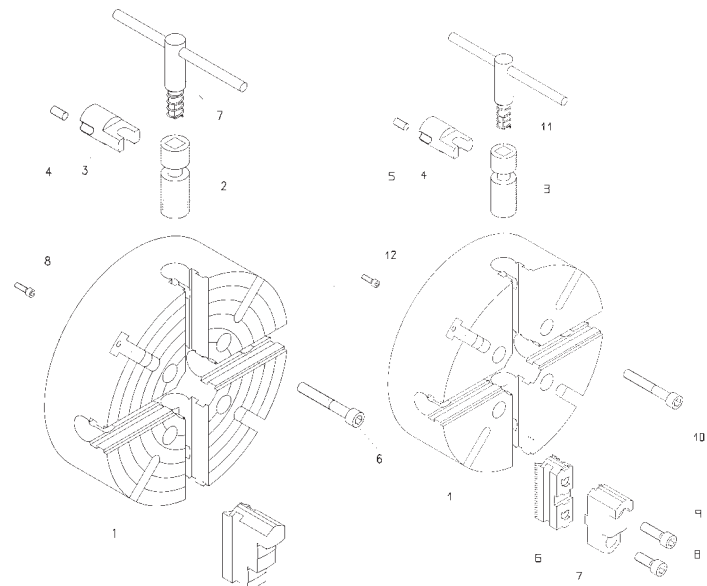
Larger Diameter chucks (from 10" to 49") are supplied with T-slots.

Clamping Ranges

Chuck Size D	3-1/2"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	31-1/2"	36"	39-3/8"	49"
d1 min	0.118	0.315	0.315	0.394	0.394	0.59	0.787	1.772	1.969	1.969	4.724	6.693	6.693
d2 max	3.346	4.9213	6.2992	7.874	9.843	12.402	15.748	19.685	24.803	31.496	36.024	39.37	49.213
d3	0.984	1.0236	1.6535	1.772	2.362	2.953	3.74	4.724	6.102	7.677	7.48	7.48	7.48



Solid & Two-piece jaws



Chucks with Solid Jaws

Chucks with Two Piece Reversible Jaws



4 Jaw Independent Lathe Chucks

Steel & Semi-steel Body, Plain Back



All Chucks with diameters of 10" through 49" are supplied with T-slots.

4304

4303

Chuck Dia.	Hole Dia.	Semi-Steel with Solid Jaws					Steel with 2-Piece Jaws			
		Weight lbs.	Load Capacity lbs.*	RPM**	Solid Jaws Code No.	2-pcs Jaws Code No.	Weight lbs.	Load* Capacity lbs.	RPM	Code No.
3-1/2***	1.000	3.4	33	4000	7-850-0300	-	-	-	-	-
5***	1.0236	8.0	330	3500	7-850-0500	-	-	-	-	-
6-1/4"	1.6535	9.0	550	3200	7-850-0600	-	-	-	-	-
8"	1.9685	32	1320	1800	7-850-0800	-	35	1700	2500	7-855-0800
10"	2.5591	55	2200	1500	7-850-1000	-	59	2800	2000	7-855-1000
12-1/2"	3.1496	88	3300	1200	7-850-1200	-	95	4290	1500	7-855-1200
15-3/4"	3.9370	139	6600	800	7-850-1600	-	150	8600	1100	7-855-1600
20"	4.9313	231	9900	500	7-850-2000	-	250	12900	700	7-855-2000
25"	6.2992	364	14300	400	7-850-2500	7-850-2522	390	18600	550	7-855-2500
32"	7.8740	700	18700	300	7-850-3200	7-850-3222	750	24300	450	7-855-3200
32"/T	10.500	672	18700	300	7-850-3300	-	-	-	-	-
36"	7.4809	800	20900	150	-	7-850-3622	856	27170	200	7-855-3600
40"	7.4809	-	25300	150	-	-	1367	32900	200	7-855-4000
49"	7.4809	-	28600	100	-	-	2138	37600	150	7-855-4900



All Plain Back Chucks require Back Plates which need machining.

Chucks with Diameters 3", 4", 5" & 6" are made of steel.

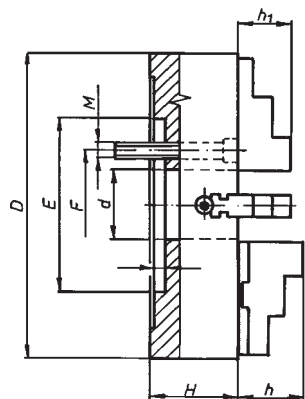
* Max. Load Capacity per one chuck is rated for Plain Back Chucks, A1/ A2 & D1 Chucks.

Max. Load Capacity & Max. RPM has been calculated for workpiece supported by a live center or being gripped in two chucks.

** Max. RPM was estimated for round and centered workpiece ONLY! for Plain Back & Direct mount Chucks.

Principal Dimensions

Chuck Dia. D	E	F	C	d	h1	h	H	Chuck Mounting Bolts			Code No.
								Thread M	L	Qty. per set	
3.35"	2.4409	2.8346	.1969	.9843	.6693	-	1.5748	1/4"-20	1-1/4	4	7-898-002
5"	2.7500	2.1260	.0984	1.0236	.7874	-	1.6929	5/16"-18	1-3/4	4	7-898-017
6-1/4"	3.2500	2.7500	.0984	1.6535	.7874	-	1.6929	3/8"-16	1-3/4	4	7-898-117
8"	4.3307	3.2520	.1969	1.9685	1.5867	1.8268	3.1496	7/16"-14	2-3/4	4	7-898-235
10"	5.9055	4.1260	.2756	2.5591	1.5866	2.3780	3.3465	1/2"-13	3-1/8	4	7-898-335
12-1/2"	6.8898	5.2520	.2756	3.1496	1.5856	2.3976	3.7402	5/8"-11	3-1/2	4	7-898-438
15-3/4"	7.8740	6.7480	.3937	3.9370	1.9606	2.8465	4.1339	5/8"-11	3-1/2	4	7-898-438
20"	10.6299	9.2520	.4724	4.9213	1.9606	3.551	4.7244	3/4"-10	4	4	7-898-544
25"	10.6299	9.2520	.4724	6.2992	2.3543	3.8504	5.5118	3/4"-10	4-3/4	4	7-898-550
32"	14.9606	13.0000	.4724	7.8740	2.7874	3.6929	6.2992	7/8"-9	5-7/8	4	7-898-610
32"/T	14.9606	13.0000	.4724	10-1/2	2.7874	3.6929	6.2992	7/8"-9	5-7/8	4	7-898-610
36"	14.5669	12.9921	.7090	7.4803	-	4.0472	6.6929	1"-8	8	8	7-898-765
40"	14.5669	12.9921	.7090	7.4803	-	4.0472	6.6929	1"-8	8	8	7-898-765
49"	21.6535	19.6850	.7090	7.4803	-	4.0472	7.4803	1"-8	8	8	7-898-765



4 Jaw Independent Lathe Chucks

Steel & Semi-steel Body, A1 / A2 Type, Direct Mount

4314

4313



Chuck Dia.	Taper Size	Hole Dia.	Weight lbs.	Semi-Steel Solid Jaws Code No.	Weight lbs.	Steel 2 Piece Jaws Code No.
8"	A2-5	1.969	38	7-851-0815	41	-
	A2-6			7-851-0816		7-856-0816
10"	A2-5	2.559	56	7-851-1025	60	-
	A2-6			7-851-1016		7-856-1016
	A2-8			7-851-1018		7-856-1018
12-1/2"	A2-5	3.150	88	7-851-1215	94	-
	A2-6			7-851-1226		7-856-1216
	A2-8			7-851-1218		7-856-1218
15-3/4"	A2-6	3.937	143	7-851-1626	153	7-856-1616
	A2-8			7-851-1628		7-856-1618
	A2-11			7-851-1619		7-856-1619
20"	A2-8	4.921	251	-	269	7-856-2018
	A2-11			7-851-2019		7-856-2019
	A2-15			-		7-856-2020
25"	A2-11	6.299	364	7-851-2519	389	7-856-2519
	A2-15	6.299		-		7-856-2520
	A2-15	10.50		-		7-856-2522
32"	A2-11	6.299	672	7-851-3219	719	7-856-3219
	A2-15	7.87		-		7-856-3220
	A2-15	10.50		-		7-856-3222
	A2-20	10.50		-		7-856-3229
	A2-20	12.50		-		7-856-3225
A2-20	14.50	-	7-856-3223			
40"	A 2-15	7.50	-	-	744	7-856-4015
		10.50		-		7-856-4022



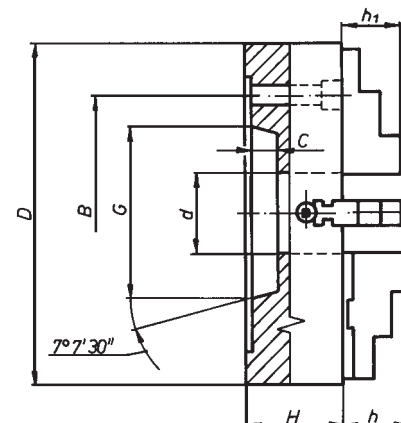
Principal Dimensions

Chuck Dia.	Taper No.	B (A-2)	G	C	d	H	Spindle Mounting Bolts					
							Thread	L	Qty.	Code No.		
8"	A2-5	4.1250	3.2503	.6299	1.969	3.1496	7/16"-14	3-1/8	4	7-897-522		
	A2-6	5.2500	4.1878	.6693			1/2"-13			7-897-533		
10"	A2-5	4.1250	3.2503	.6299	2.559	3.3465	7/16"-14	3-1/8	8	7-897-522		
	A2-6	5.2500	4.1878	.6693			1/2"-13			3-1/8	4	7-897-533
	A2-8	6.7500	5.50055	.7480			5/8"-11			3-3/8	4	7-897-544
12-1/2"	A2-5	4.1250	3.2503	.6299	3.150	3.7402	7/16"-14	3-1/2	4	7-897-523		
	A2-6	5.2500	4.1878	.6693			1/2"-13			3-1/2	8	7-897-534
	A2-8	6.7500	5.50055	.7480			5/8"-11			3-1/4	4	7-897-546
15-3/4"	A2-6	5.2500	4.1878	.6693	3.937	4.1339	1/2"-13	4	4	7-897-535		
	A2-8	6.7500	5.50055	.7480			5/8"-11			4	7-897-547	
	A2-11	9.2520	7.75055	.8268			3/4"-10			4	7-897-563	
20"	A2-8	6.7500	5.50055	.7480	4.921	4.7244	5/8"-11	4-1/2	8	7-897-550		
	A2-11	9.2520	7.75055	.8288			3/4"-10			8	7-897-564	
	A2-15	13.0000	11.2505	.8661			7/8"-9			4	7-897-572	
25"	A2-11	9.2520	7.75055	.8268	6.299	5.5118	3/4"-10	5-5/16	8	7-897-566		
	A2-15	13.0000	11.2505	.8661			7/8"-9			4	7-897-573	
32"	A2-11	9.2520	7.75055	.8268	6.299	6.2992	3/4"-10	5-7/8	6	7-897-567		
	A2-15	13.0000	7.75055	.8268			7/8"-9			6-1/8	8	7-897-575
	A2-20	18.2500	11.2505	.8661			1"-8			6-1/8	4	7-897-585
40"	A2-15	13.0000	11.2505	.8661	6.693	6.6929	7/8"-9	7-3/32	8	7-897-587		

Note:

Type A1 Spindle has a 2 Bolt Hole Pattern (inside & outside the taper) an A1 or A2 Chuck will fit on it.

Type A2 Spindle has a 1 Bolt Pattern (outside the taper) only an A2 chuck will fit it.



4 Jaw Independent Lathe Chucks

Steel & Semi-steel Body, D 1 Type, Direct Mount

4344

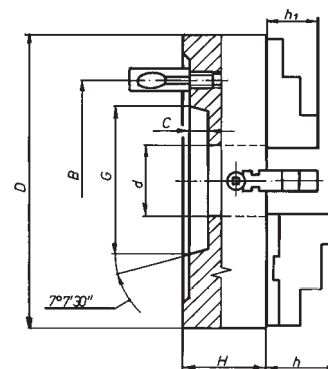
4343

Chuck Dia.	Taper Size	Stud Dia.	Studs Qty.	Hole Dia.	Weight lbs.	Semi-Steel Code No.	Weight lbs.	Steel Code No.
8"	D1-3	9/16	3	1.969	37	7-853-0833	40	-
	D1-4	5/8	3			7-853-0834		7-857-0834
	D1-5	3/4	6			7-853-0835		7-857-0835
	D1-6	7/8	6			-		7-857-0836
10"	D1-4	5/8	3	2.362	61	7-853-1034	65	-
	D1-5	3/4	6	2.559		7-853-1035		7-857-1035
	D1-6	7/8	6	2.559		7-853-1036		7-857-1036
	D1-8	1	6	2.559		-		7-857-1038
12-1/2"	D1-5	3/4	6	3.150	87	7-853-1235	93	-
	D1-6	7/8				7-853-1236		7-857-1236
	D1-8	1				7-853-1238		7-857-1238
15-3/4"	D1-6	7/8	6	3.937	132	7-853-1636	141	7-857-1636
	D1-8	1				7-853-1638		7-857-1638
	D1-11	1-3/16				7-853-1639		7-857-1639
	D1-11	1-3/16				-		7-857-1643
20"	D1-8	1	6	4.921	211	7-853-2038	226	7-857-2038
	D1-11	1-3/16		4.921		7-853-2039		7-857-2039
	D1-11	1-3/16		5.500		-		7-857-2043
	D1-15	1-3/8		4.921		-		7-857-2040
25"	D1-8	1	6	4.921	364	-	389	7-857-2538
	D1-11	1-3/16		6.299		7-853-2539		7-857-2539
	D1-15	1-3/8		6.299		-		7-857-2540
32"	D1-11	1-3/16	6	7.087	-	-	703	7-857-3239
	D1-15	1-3/8		7.874		-		7-857-3240



Principal Dimensions

Chuck Dia.	Taper Size	G	B	C	d	H	Camlock Studs				Set Screw Code No.
							Dia.	Thread	Qty.	Code No.	
8"	D1-3	2.1250	2.7795	.5118	1.969	3.1495	9/16	M10x1	3	7-899-103	7-899-305
	D1-4	2.5005	3.2520	.5118			5/8	M10x1	3	7-899-104	7-899-305
	D1-5	3.2505	4.1260	.5906			3/4	M12x1	6	7-899-105	7-899-305
	D1-6	4.1880	5.2520	.6299			7/8	M16x1.5	6	7-899-106	7-899-310
10"	D1-4	2.5005	3.2520	.5118	2.362	3.3465	5/8	M10x1	3	7-899-104	7-899-305
	D1-5	3.2505	4.1260	.5906	2.559		3/4	M12x1	6	7-899-105	7-899-305
	D1-6	4.1880	5.2520	.6299	2.559		7/8	M16x1.5	6	7-899-106	7-899-310
	D1-8	5.5007	6.7480	.7087	2.559		1	M20x1.5	6	7-899-108	7-899-310
12-1/2"	D1-5	3.2505	4.1260	.5118	3.150	3.7402	3/4	M12x1	6	7-899-105	7-899-305
	D1-6	4.1880	5.2520	.6299			7/8	M16x1.5		7-899-106	7-899-310
	D1-8	5.5007	6.7480	.7087			1	M20x1.5		7-899-108	
15-3/4"	D1-6	4.1880	5.2520	.6299	3.937	4.1339	7/8	M16x1.5	6	7-899-106	7-899-310
	D1-8	5.5007	6.7480	.7087			1	M20x1.5		7-899-108	
	D1-11	7.7507	9.2520	.7874			1-3/16	M22x1.5		7-899-111	
20"	D1-8	5.5007	6.7480	.7087	4.921	4.7244	1	M20x1.5	6	7-899-108	7-899-310
	D1-11	7.7505	9.2520	.7874	1-3/16		M22x1.5	7-899-111			
	D1-15	11.251	13.00	.7874	4.921		1-3/8	M24x1.5		7-899-115	
25"	D1-8	5.5007	6.7480	.7087	4.921	5.5118	1	M20x1.5	6	7-899-108	7-899-310
	D1-11	7.7507	9.2520	.7874	6.299		1-3/16	M22x1.5		7-899-111	
	D1-15	11.251	13.00	.7874	6.299		1-3/8	M24x1.5		7-899-115	
32"	D1-11	7.7507	9.2520	.7874	7.087	6.2992	1-3/16	M22x1.5	6	7-899-111	7-899-310
	D1-15	11.251	13.000	.7874	7.874		1-3/8	M24x1.5		7-899-115	

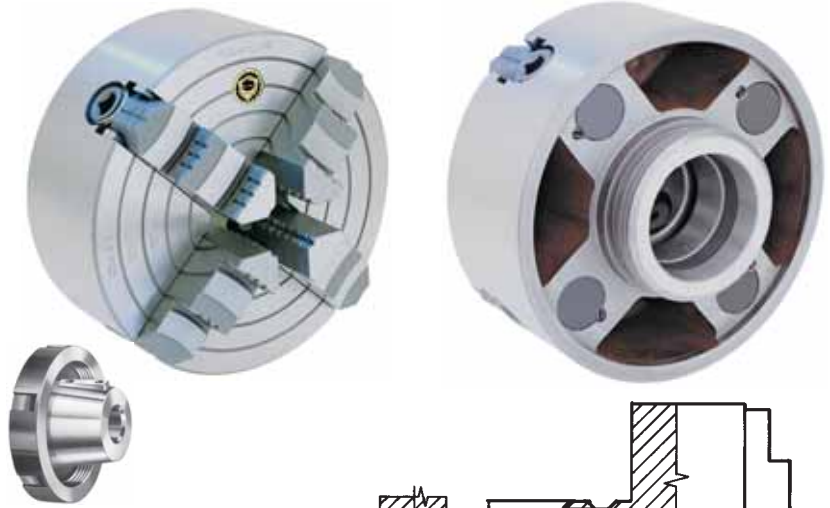


4 Jaw Independent Lathe Chucks

Semi-steel Body, "L" Type, Direct Mount

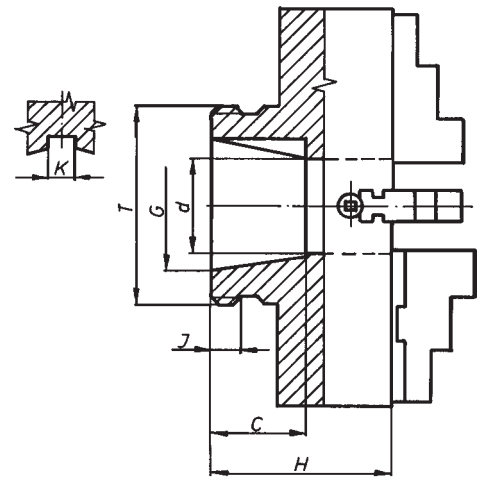
4354

Chuck Dia.	Taper Size	Hole Dia.	Weight Lbs.	Code No.
8"	L00	1.96	34	7-854-0841
	L0			7-854-0842
10"	L00	2.56	57	7-854-1041
	L0			7-854-1042
	L1			7-854-1043
12-1/2"	L0	3.15	119	7-854-1242
	L1			7-854-1243
	L2			7-854-1244
15-3/4"	L1	3.93	154	7-854-1643
	L2			7-854-1644
20"	L2	4.92	256	7-854-2044



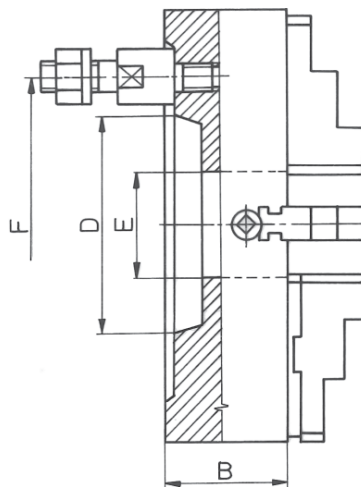
Principal Dimensions

Chuck Dia.	Taper Size	Thread T	G	C	J	d	K	H
8"	L00	3-3/4" - 6	2.7500	2.1250	.5512	1.9685	.3839	4.005
	L0	4-1/2" - 6"	3.2500	2.5000	.5905			4.449
10"	L00	3-3/4" - 6	2.7500	2.1250	.5512		.3839	4.055
	L0	4-1/2" - 6	3.2500	2.5000	.5905	2.5591	.3839	4.449
	L1	6" - 6"	4.1250	2.9921	.6299		.6358	4.961
12-1/2"	L0	4-1/2" - 6	3.2500	2.5000	.5905		.3839	4.724
	L1	6" - 6	4.1250	2.9921	.6299	3.1496	.6358	5.197
	L2	7-3/4" - 5"	5.2500	3.5039	.8661		.7598	5.709
15-3/4"	L1	6" - 6	4.1250	2.9921	.6299	3.9370	.6358	5.197
	L2	7-3/4" - 5"	5.2500	3.5039	.8661		.7598	5.709
20"	L2	7-3/4" - 5"	5.2500	3.5039	.8661	4.9213	6.0630	6.063



Semi-steel Body, "DIN" Type, Direct Mount

Chuck Dia. D	Taper Size	F	D	C	E	B	DIN Studs				Chuck Code No.
							Dia.	Thread	Qty.	Code No.	
15-3/4"	DIN 6	4.188	5.252	0.6299	3.937	4.1339	0.846	M12	4	7-921-906	7-852-1636
25"	DIN 11	7.7507	9.252	0.7874	6.299	5.5118	1.339	M20	6	7-921-911	7-852-2539



Note: Picture shows plain back chuck. DIN Mount does not have front mounting holes.



4 Jaw Independent Lathe Chucks

Steel & Semi-steel Body, Spare Parts

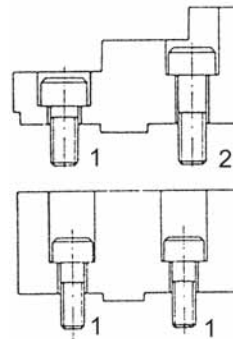


Chuck Dia.	Hard Top Reversible Jaws/ 1Pc.	Hard Master Jaws/1Pc.	Hard Solid Jaws/Set	Medium Soft Top Jaws/1 Pc.	Heavy Duty Soft Top Jaws/1 Pc.	Operating Screw 1 Pc.			Thrust Bearing 1 Pc			Wrench 1 Pc.
							O D*	L *		O D*	L*	
Code No.												
3-1/2"	-	-	7-890-1030	-	-	7-890-603	0.63	1.14	7-890-703	0.51	0.87	7-889-003
5"	-	-	7-890-1060	-	-	7-890-606	0.709	1.57	7-890-705	0.71	1.04	7-890-906
6-1/4"	-	-	7-890-1060	-	7-884-206	7-890-606	0.709	1.57	7-890-706	0.71	1.04	7-890-906
8"	7-890-208	7-890-308	7-890-1080	7-884-308	7-884-208	7-890-608	1.1	2.83	7-890-708	1.18	1.91	7-890-910
10"	7-890-210	7-890-310	7-890-1100	7-884-310	7-884-210	7-890-610	1.1	3.15	7-890-710	1.18	2.11	7-890-910
12-1/2"	7-890-212	7-890-312	7-890-1120	7-884-312	7-884-212	7-890-612	1.26	4.13	7-890-712	1.42	2.32	7-890-916
15-3/4"	7-890-216	7-890-316	7-890-1160	7-884-316	7-884-216	7-890-616	1.26	5.31	7-890-716	1.42	2.52	7-890-916
20"	7-890-220	7-890-320	7-890-1200	7-884-320	-	7-890-620	1.42	6.57	7-890-720	1.57	2.84	7-890-925
25"	7-890-225	7-890-325	7-890-1250	7-884-325	-	7-890-625	1.57	8.74	7-890-725	1.77	3.15	7-890-925
32"	7-890-232	7-890-332	7-890-1320	7-884-325	-	7-890-632	1.73	11.6	7-890-732	1.89	3.52	7-890-932
32"/T	7-890-232	7-890-332	7-890-1320	7-884-325	-	7-890-633	1.73	10.2	7-890-732	1.89	3.52	7-890-932
36"	7-890-236	7-890-336	-	7-884-332	-	7-890-636	1.73	12.7	7-890-736	1.89	4.33	7-890-932
40"	7-890-236	7-890-336	-	7-884-332	-	7-890-640	1.73	13.8	7-890-736	1.89	4.33	7-890-932
49"	7-890-236	7-890-336	-	7-884-332	-	7-890-649	1.73	18.4	7-890-736	1.89	4.33	7-890-932

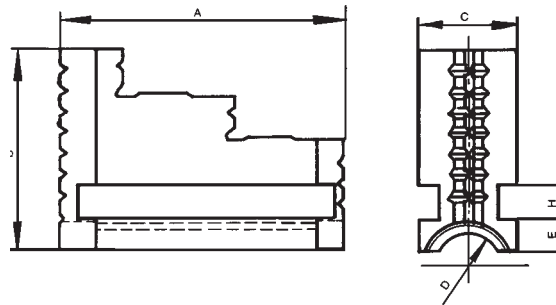
Mounting Bolts for Hard & Soft Top Jaws

Chuck Dia.	Bolt Thread	Screw No. 1		Screw No. 2	
		L	Code No.	L	Code No.
8"	3/8"-16	.79	7-897-810	1.2	7-897-812
10"&12"	1/2"-13	1	7-897-814	1.6	7-897-816
16"	5/8"-11	1.2	7-897-818	1.8	7-897-820
20"	3/4"-10	1.6	7-897-822	2.2	7-897-826
25"	3/4"-10	1.6	7-897-822	2.4	7-897-828
32"	3/4"-10	1.6	7-897-822	2.6	7-897-830
36",40"&49"	3/4"-10"	1.8	7-897-824	1.8	7-897-824

Sold by piece



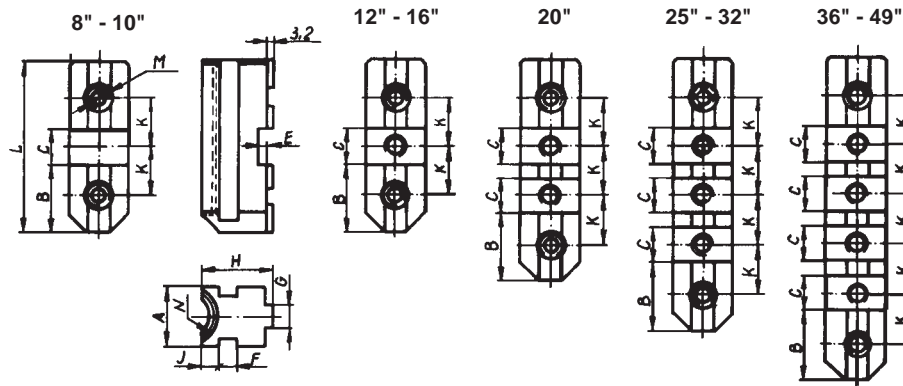
Reversible Hard Solid Jaws Principal Dimensions



Size of Chuck	3-1/2"	5 & 6"	8"	10"	12"	16"	20"	25"	32"
A	1.3385	2.0078	3.1890	3.7992	4.3700	5.0787	6.0039	6.9685	7.9527
B	1.1800	1.3583	2.4803	2.4803	3.0118	3.0118	3.6811	3.6811	4.5078
C	.5100	.6299	1.2598	1.2598	1.5748	1.5748	2.0472	2.0472	2.7552
D Thread	Tr 16x2 left	Tr 18x4 left	Tr 28x5 left	Tr 28x5 left	Tr 32x6 left	Tr 32x6 left	Tr 36x6 left	Tr 40x6 left	Tr 44x8 left
H	.1969	.1968	.3937	.3937	.4724	.4724	.5905	.5905	.7874
E	.1772	.2362	.3425	.3425	.3819	.3819	.4606	.4606	.6181



4 Jaw Independent Lathe Chucks



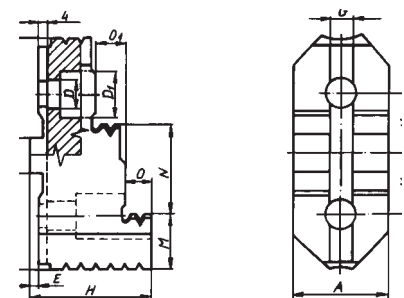
Master Jaws Principal Dimensions

Chuck Size	8"	10"	12"	16"	20"	25"	32"	36" & 40"	49"
A	1.2598	1.2598	1.5748	1.5748	2.0472	2.0472	2.7559	2.7559	2.7559
B	1.3071	1.4764	1.7874	2.1614	2.1850	2.1850	2.1850	2.1850	2.1850
C	0.4996	0.7496	0.7496	0.7496	0.7496	0.7496	0.7496	0.7496	0.7496
E	0.1575	0.1575	.01575	0.2835	0.2835	0.2835	0.2835	0.2835	0.2835
F	0.3937	0.3937	0.4724	0.4724	0.5906	0.5906	0.7874	0.7874	0.7874
G	0.3126	0.500	0.500	0.500	0.500	0.500	0.500	0.500	0.500
H	1.2598	1.4961	1.5354	1.7321	2.3228	2.3228	2.3228	2.3228	2.3228
J	0.3425	0.3425	0.3819	0.3819	0.4606	0.4606	0.6181	0.6181	0.6181
K	0.8760	1.0630	1.2500	1.500	1.500	1.500	1.500	1.500	1.500
L	3.1102	3.7008	4.3307	5.0787	6.6142	8.1102	8.1102	9.6063	9.6063
M	3/8-16	1/2-13	1/2-13	5/8-11	3/4-10	3/4-10	3/4-10	3/4-10	3/4-10
N	Tr.28x5	Tr.28x5	Tr.32x6	Tr.32x6	Tr.36x6	Tr.40x6	Tr.44x8	Tr.44x8	Tr.44x8

All Master Jaws are American Standard tongue and groove.

Top Jaws Principal Dimensions

Chuck Size	8"	10"	12"	16"	20"	25"	32"	36", 40" & 49"
A	1.3386	1.3386	1.6535	1.6535	2.1260	2.1260	2.8346	2.8346
B	1.3858	1.5748	1.8858	2.2598	2.2835	2.2835	2.2835	2.2835
C	0.4996	0.7496	0.7496	0.7496	0.7496	0.7496	0.7496	0.7496
D	0.4331	0.5512	0.5512	0.7087	0.8661	0.8661	0.8661	0.8661
D1	0.6693	0.8268	0.8268	1.0236	1.2598	1.2598	1.2598	1.2598
E	0.1260	0.1260	0.1260	0.2480	0.2480	0.2480	0.2480	0.2480
G	0.3130	0.5004	0.5004	0.5004	0.5004	0.5004	0.5004	0.5004
H	1.7126	2.0276	2.1654	2.5394	2.9331	3.2283	3.4647	3.8190
K	0.8760	1.0630	1.2500	1.500	1.500	1.500	1.500	1.500
L	3.2283	3.7992	4.4291	5.0787	5.3543	5.3543	5.3543	6.2992
M	0.7874	1.0236	1.1811	1.4173	1.4173	1.4173	1.4173	2.3622
N	1.2598	1.4567	1.6929	1.9685	1.9685	1.9685	1.9685	—
O	0.3740	0.4724	0.5118	0.5315	0.7087	0.8268	0.9449	1.9685
O1	0.4134	0.5118	0.5512	0.5709	0.7087	0.8268	0.9449	—

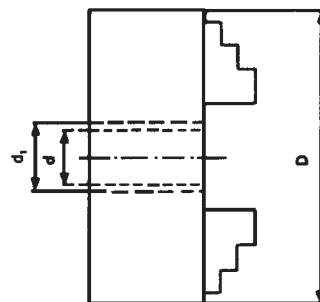


All Top Jaws are American Standard tongue and groove.



4 Jaw Independent Lathe Chucks

Thru Hole Diameters



d - through hole diameter made by manufacturer
 d1- permissible enlargement of through hole
 ** Hole diameter d1 may be made only to depth X.

Mounting	Hole Dia.	Chuck Size	D	5"	6"	8"	10"	12"	16"	20"	25"	32"	32"	36"	40"	49"
4304	d*	plain back		1.0236	1.6535	1.9685	2.5591	3.1496	3.9370	4.9213	6.2992	7.8740	10.4725	7.4803	7.4803	7.4803
	d1			1.3780	1.8504	1.9685	2.9528	3.7402	4.7244	6.1024	6.8898	7.8740	10.4725	10.5	11.3	12.36
4314	d	Short Taper "A"	5			1.9685	2.5591	3.1496								
			6			1.9685	2.5591	3.1496	3.9370	3.9370						
			8				2.5591	3.1496	3.9370	3.9370	4.9213	4.9213				
			11							3.9370	4.9213	6.2992	7.0866			
			15								6.299	6.2992	7.8740			
4344	d	Camlock "D"	3			1.9685	1.9685									
			4			1.9685	2.3622									
			5			1.9685	2.5591	3.1496								
			6				2.5591	3.1496	3.9370	3.9370						
			8					3.1496	3.9370	4.9213	4.9213					
			11						3.9370	4.9213	6.2992	7.0866				
			15							4.9213	6.2992	7.8740				
4354	d	Long Taper	L00			1.9685	2.5591	3.1496								
			L0			1.9685	2.5591	3.1496	3.9370	4.9213						
			L1				2.5591	3.1496	3.9370	4.9213						
			L2					3.1496	3.9370	4.9213	6.2992	7.8740				
			L3						3.9370	4.9213	6.2992	7.8740				
	d1		L00			1.9685	2.5591	3.1496								
			L0			1.9685	2.9528	3.3465	3.9370	4.9213						
			L1				2.9528	3.7795	4.1339	4.9213						
			L2					3.6220	4.7244	5.3150	6.2992	7.8740				
			L3						4.7244	6.1024	6.4961	7.8740				
		X**				-	1.9448	2.2047	2.2047	2.5590	2.7165	-				



Radial T-Slot Table

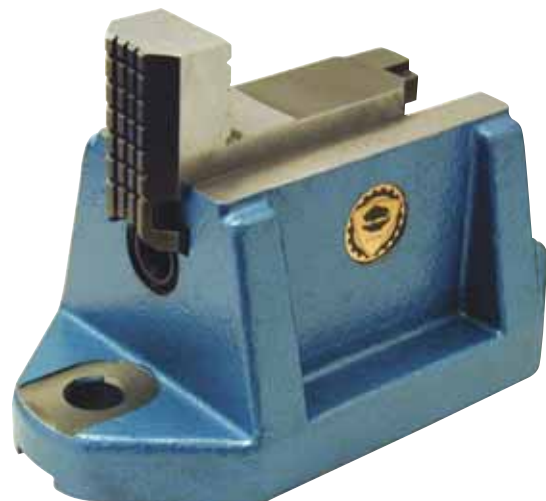
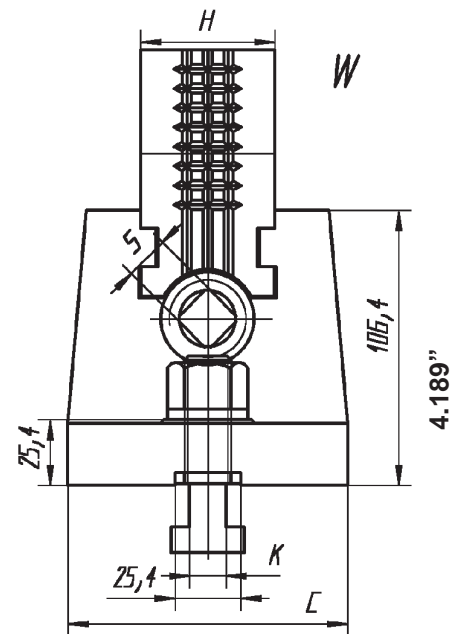
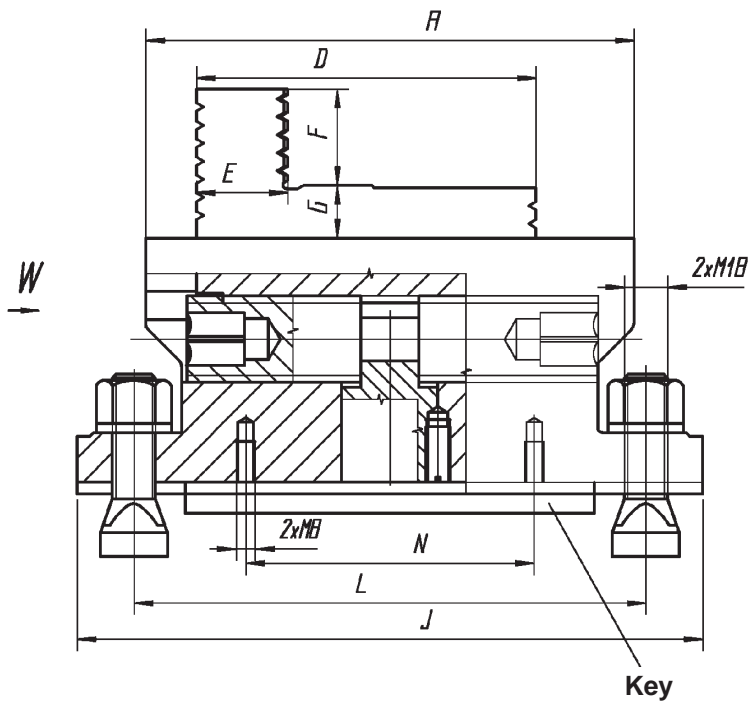
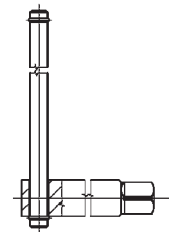
Face Plate Jaws

Type 9170

Jaw Size	A	B	C	D	E	F	G	H	J	K	L	N	S	Weight 4pc. Set lbs.	Code No.
6"	6.00	4.189	4.00	4.748	1.500	1.563	.8740	2.047	8.185	1.00	6.378	3.071	.6690	57	7-645-006
8"	8.00		4.252	5.563					10.248		8.386	4.724		69	7-645-008

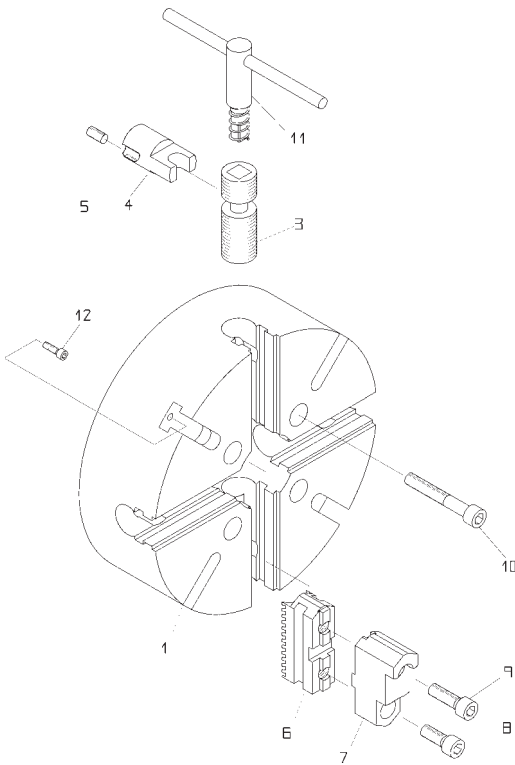
- Heavy Semi-Steel Body
- Hard Solid Reversible Jaws
- Each set of Jaws is furnished with mounting bolts (M18) and a wrench
- Sold in a 4 piece Set

Wrench



Oil Country Chucks

4 Jaw Independent, Extra Heavy Duty Forged Steel Solid Body, with Extra Large Thru-Hole



Standard Accessories:

1 set of two-piece reversible jaws (hard top jaws and hard master jaws), 1 wrench, 1 set of mounting bolts, 2 allen keys and 2 eye bolts.

Optional Accessories:

Soft top jaws.

Note:

Type A1 Spindle has a 2 Bolt Hole Pattern (inside and outside the taper) an A1 or A2 Chuck will fit on it.

Type A2 Spindle has 1 Bolt Pattern (outside the taper) only an A2 chuck will fit on it.



Camlock "D" Direct Mount



A 2 Direct Mount



Oil Country Chucks, Direct Mount

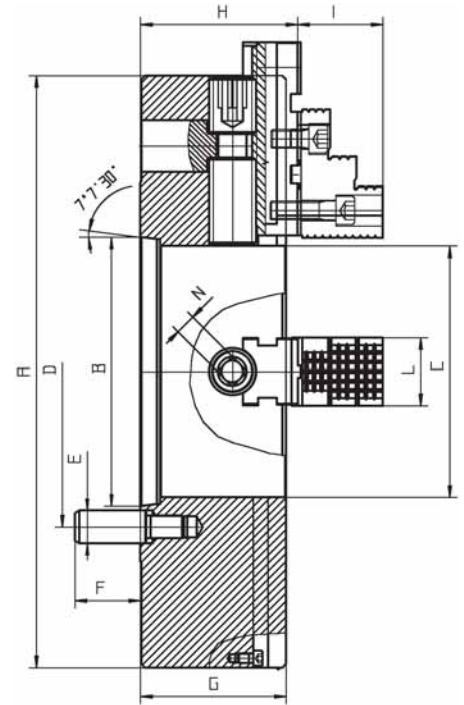
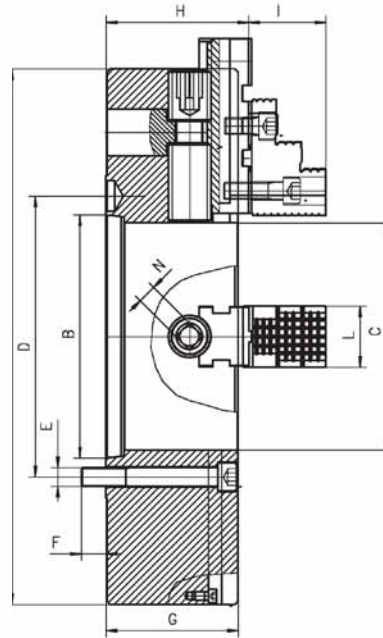
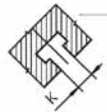
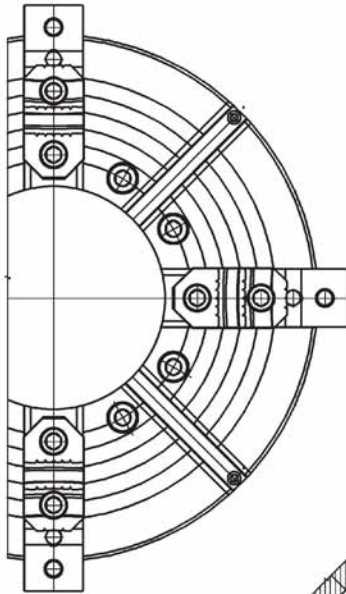
4 Jaw Independent, Extra Heavy Duty
Forged Steel Solid Body,
with Extra Large Thru-Hole



"A2" Mount



Camlock "D" Mount



Chuck Dia. A	Type of Mounting	Hole Dia. C inch/mm	B +.001"	D	G	H	I	K	L	N	E	F	Max. R.P.M.	Weight lbs.	Code No.
Direct Mount A2 Type 4317															
15-3/4"	A2-8	5.3" (135)	5.50075	6.750	5.71	6.067	2981	.709	2.362	.748	5/8-11	.961	1200	320	7-859-1620
	A2-11	6.5" (165)	7.75075	9.2500				.709					1200	302	7-859-1625
20"	A2-11	6.5" (165)	7.75075	9.2500	5.71	6.067	2.981	.866	2.362	.748	3/4-10	1.118	1000	450	7-859-2033
	A2-15	8.0" (205)	11.251	13.000							7/8-9	1.340	1000	414	7-859-2043
25"	A2-15	10.5" (267)	11.251	13.000							7/8-9	1.340	850	684	7-859-2543
	A2-20	12.55" (320)	16.251	18.252	6.10	6.579					1-8	1.50		662	7-859-2555
28"	A2-15	10.5" (267)	11.251	13.000			3.571	.866	2.953	.866	7/8-9	1.34	750	915	7-859-2845
	A2-20	12.55"(320)	16.251	18.252							1-8	1.50		873	7-859-2853
32"	A2-15	10.5" (267)	11.251	13.000							7/8-9	1.34	600	1290	7-859-3243
	A2-20	12.55" (320)	16.251	18.252	6.50	6.972					1-8	1.50		1246	7-859-3255
40"	A2-28	20.86" (530)	23.001	25.500	6.89	7.366	3.571	1.10	2.953	.866	1-1/4 - 7	1.53	430	1687	7-859-4053
Direct Mount D1 Type 4347															
15-3/4"	D1-8	5.3" (135)	5.50075	6.7500				.709			1	2	1200	300	7-859-6150
	D1-11	6.5" (165)	7.75075	9.2520							1.25	2.4		282	7-859-6153
20"	D1-8	5.3" (135)	5.50075	6.7500	5.71	6.067	2.981		2.362	.748	1	2	1000	468	7-859-6200
	D1-11	6.5" (165)	7.75075	9.2520				.866			1.25	2.4		452	7-859-6203
28"	D1-11	7.5" (192)	7.75075	9.252	6.10	6.579	3.57		2.953	.866	1.25	2.4	750	993	7-859-6839



Oil Country Chucks

4 Jaw Independent, Extra Heavy Duty
Forged Steel Solid Body, Extra Large Thru-Hole

Chuck Parameters

Chuck Dia. D	Type of Mounting	Gripping Force		Clamping Capacity	
		Wrench Torque	Jaw lbs.	Min.	Max.
15-3/4"	A2-8 / D1-8	350Nm	7057	1.00	15.75
	A2-11 / D1-11			1.77	19.68
20"	D1-8	400Nm	8160	1.97	24.80
	A2-11 / D1-11			3.94	24.80
25"	A2-15	450Nm	9040	2.95	27.95
	A2-20			3.94	27.95
28"	A2-15	450Nm	9040	2.95	31.50
	A2-20			4.53	31.50

Spare Parts



Chuck Dia.	Hole Dia.	Hard Top Reversible Jaws/1 Pc.	Hard Master Jaws/1 Set	Thrust Bearing 1 Pc.	Wrench 1 Pc.	Operating Screw 1pc.
15-3/4"	5.3"	7-890-2223	7-890-1620	7-890-7165	7-890-9323	7-890-6163
	6.5"					7-890-6165
20"	5.3"	7-890-2020	7-890-7205	7-890-7255	7-890-9325	7-890-6203
	6.5"					7-890-6205
	8.0"					7-890-6208
25"	10.5"	7-890-2323	7-890-3320	7-890-7325	7-890-9325	7-890-6257
	12.5"					7-890-6259
28"	10.5"	7-890-2323	7-890-3320	7-890-7325	7-890-9325	7-890-6277
	12.5"					7-890-6279
32"	10.5"	7-890-2323	7-890-3320	7-890-7325	7-890-9325	7-890-6327
	12.5"					7-890-6329

Top Jaw Mounting Bolts

Chuck Dia.	Thread	Short Screw		Long Screw	
		L	Code No.	L	Code No.
15-3/4"	3/4" - 10	1-1/2	7-897-558	2-1/2	7-897-560
20"					
25"	7/8" - 9	1-1/2	7-897-572	2-3/4	7-897-573
28"					
32"					



"A" Spindle Mounting Bolts

Chuck Dia.	Taper Size	Thread Size E	L	Bolt Circle Dia. D	Qty. per Chuck	Code No.
15-3/4"	A2-8	3/4-10	6	6.750	8	7-897-5685
	A2-11	3/4-10		9.2500		7-897-5685
20"	A2-11	3/4-10	6.5	9.2500	8	7-897-5685
	A2-15	7/8-9		18.250		7-897-574
25"	A2-15	7/8-9	6.5	13.000	8	7-897-578
	A2-20	1-8		18.252		7-897-588
28"	A2-15	7/8-9	6.5	13.000	8	7-897-578
	A2-20	1-8		18.252		7-897-588
32"	A2-15	7/8-9	6.5	13.000	8	7-897-578
	A2-20	1-8		18.252		7-897-588



Spindle sizes according to USAS B5.9-1986

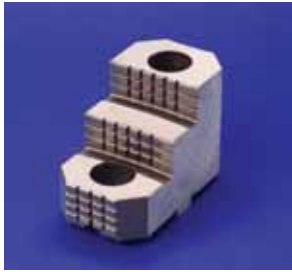
Camlock Studs & Set Screws

Taper Size	Camlock Studs			Set Screw Code No.	Qty. per Chuck
	Dia.	Thread	Code No.		
D1-8	1"	M20x1.5	7-899-108	7-899-310	6
D1-11	1-3/16"	M22x1.5	7-899-111	7-899-310	

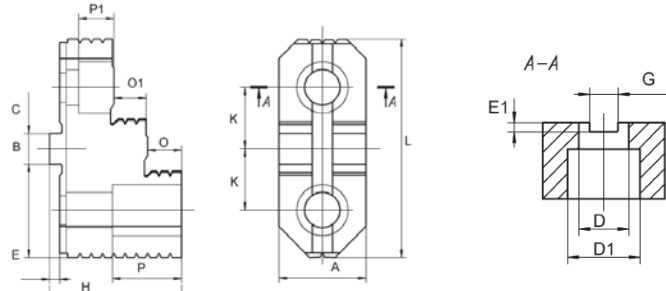


Oil Country Chucks

HARD TOP JAWS

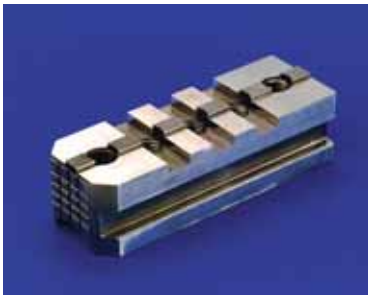


Principal Dimensions

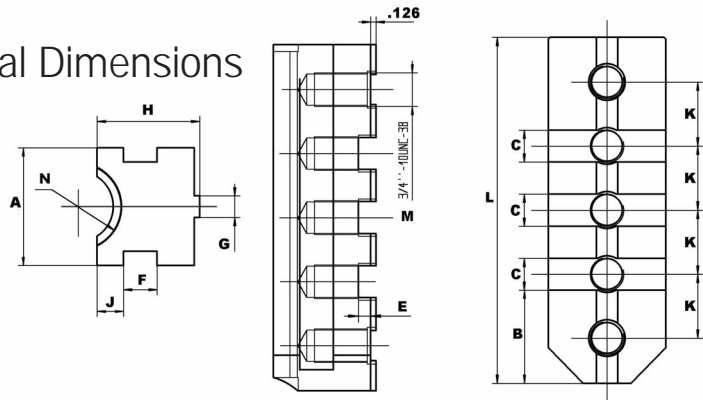


Chuck Dia.	A	B	C	D	D1	E	E1	G	H	K	OAL	O	O1	P	P1	Jaw Code No.
15-3/4"	2.362	2.248	.7496	.866	1.295	.248	.1575	.5004	3.228	1.500	5.378	.827	.827	1.693	.8661	7-890-2023
20"																
25" - 28"	2.953	2.248	.7496	.866	1.299	.248	.1575	.5004	3.819	1.500	5.343	1.102	1.102	1.969	.9055	7-890-2323
32"																

HARD MASTER JAWS

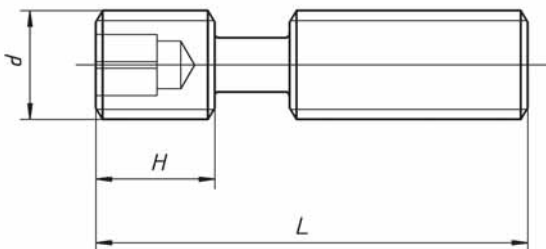


Principal Dimensions



Chuck Dia.	A	B	C	E	F	G	H	J	K	OAL L	M	N mm	Jaw Code No.
15-3/4"	2.047						2.283			5.197	3/4-10	Tr 44x8 LH	7-890-1620
20"		2.244	.7496	.2835	.7874	.5000		.6181	1.50	6.693		Tr 44x8 LH	7-890-2020
25" - 28"	2.756						2.275			8.189	7/8-9	Tr 50x8 LH	7-890-3320
32"													

OPERATING SCREW



Principal Dimensions



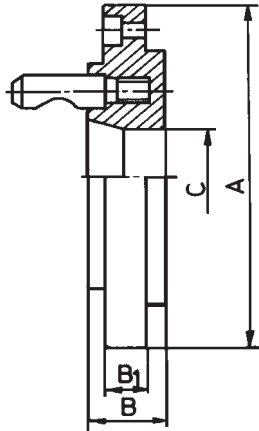
Chuck Dia.	Hole Dia.	Thread Size d mm	H	OAL L	Square S	Operating Screw Code No.
15-3/4"	5.3"	Tr 44 x 8 LH	1.929	5.079	.748 (19mm)	7-890-6163
	6.5"			4.488		7-890-6165
20"	5.3"		7.047	7-890-6203		
	6.5"		6.457	7-890-6205		
	8.0"	5.669	7-890-6208			
25"	10.5"	Tr. 50 x 8 LH	2.362"	6.988"	.866 (22mm)	7-890-6257
	12.5"			5.925"		7-890-6259
28"	10.5"		8.563"	7-890-6277		
	12.5"		7.500"	7-890-6279		
32"	10.5"	3.543"	10.335"	7-890-6327		
	12.5"		9.272"	7-890-6329		

Cast-Iron Adapters

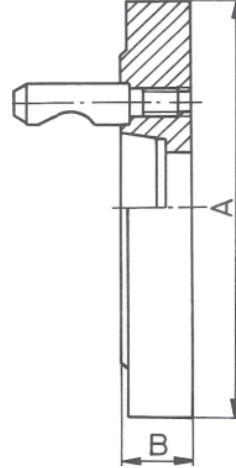
D1 Adapters

8240 Fully Machined Adapters* for BISON plain back, self-centering Chucks - designed for direct mounting on camlock spindle noses.

8242 Semi Machined Adapters* for plain back Chucks designed for direct mounting on camlock spindle noses.



8240



8242

Note: Number of camlock studs depends on spindle size. Please refer to table.

8240

8242

Chuck Dia.	Taper Size	Stud Dia.	No. of Studs	Whole Dia. C	Fully machined					Semi machined									
					Dia. A	B	B1	Weight lbs.	Code No.	Dia. A	Weight lbs.	Flange thickness	Code No.						
5"	D1-3	9/16	3	2.02	4.94	1.02	.57	5.3	7-878-053	-	-	-	-						
	D1-4	5/8		2.40										.87	7-878-055	-	-	-	-
6-1/4"	D1-3	9/16	3	2.02	6.32	1.06	.71	9.5	7-878-063	6.38	9.3	1.02	7-878-0630						
	D1-4	5/8	3	2.40										1.06	.71	7-878-064	1.14	7-878-0640	
	D1-5	3/4	6	3.13										1.18	1.0	7-878-065	1.14	7-878-0650	
	D1-6	7/8	6	4.06										1.44	1.32	7-878-066	-	-	
8"	D1-3	9/16	3	2.02	7.89	1.06	.71	15.4	7-878-083	8.00	27	1.73	7-878-0830						
	D1-4	5/8	3	2.40										1.06	.71	7-878-084	1.73	7-878-0840	
	D1-5	3/4	6	3.13										1.18	.71	7-878-085	1.97	7-878-0850	
	D1-6	7/8	6	4.06										1.44	1.26	7-878-086	1.38	7-878-0860	
10"	D1-5	3/4	6	3.13	9.86	1.18	.87	24.3	7-878-105	9.96	35	1.93	7-878-1050						
	D1-6	7/8		4.06										1.44	.87	24.3	7-878-106	7-878-1060	
	D1-8	1		5.35										1.54	1.36	39.7	7-878-108	7-878-1080	
12-1/2"	D1-6	7/8	6	4.06	12.42	1.56	.94	39.7	7-878-126	12.52	49	2.76	7-878-1260						
	D1-8	1		5.35										1.65	.94	39.7	7-878-128	2.17	7-878-1280
	D1-11	1-3/16		7.59										1.85	1.36	39.7	7-878-129	2.17	7-878-1290
15-3/4"	D1-6	7/8	6	4.06	15.77	1.44	1.10	79	7-878-166	15.94	93	2.17	7-878-1660						
	D1-8	1		5.35										1.54	1.10	79	7-878-168	2.76	7-878-1680
	D1-11	1-3/16		7.59										1.85	1.10	79	7-878-169	1.96	7-878-1690
20"	D1-8	1	6	5.35	19.70	1.54	1.14	132	7-878-208	19.88	159	1.81	7-878-2080						
	D1-11	1-3/16		7.59										1.85	1.14	132	7-878-209	2.83	7-878-2090
25"	D1-8	1	6	5.35	24.82	1.54	1.14	232	7-878-258	25.00	232	2.83	7-878-2580						
	D1-11	1-3/16		7.59										1.85	1.14	232	7-878-259	2.83	7-878-2590

*See mounting instructions on page 61.

Note: Plain back chucks require adapter plates which may require machining to fit.

Cast-Iron Adapters

A1 / A2 Adapters

Semi Machined & Fully Machined Adapters**

for plain back chucks - designed for direct mounting on A1 and A2 spindle noses. May be used for both scroll and independent chucks. Provided with the spindle mounting bolts.

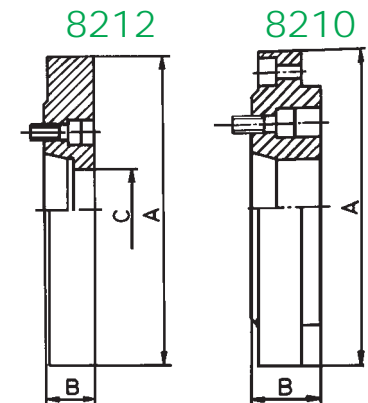
8212

8210

Chuck Dia.	Taper No.	A	B	C	Weight lbs.	Semi-Mach. Code No.	Weight lbs.	Fully Mach. Code No.
5"	A-6	5.00	1.02	2.13	6.5	7-873-056	5.3	7-873-0560
	A-8		1.81	3.15		7-873-058		7-873-0580
6-1/4"	A-5	6.40	.827	3.13	9.5	7-873-065	-	-
	A-6		.827			7-873-066	-	-
8"	A-5	7.99	1.50	2.17	19.0	7-873-085	18	7-873-0850
	A-6		1.30	15.5	7-873-086	-	-	
10"	A-6	9.96	1.30	3.17	38	7-873-106	-	-
	A-8		1.97	33	7-873-108	-	-	
12-1/2"	A-6	12.52	1.30	4.06	45	7-873-126	-	-
	A-8		2.17	62	7-873-128	-	-	
15-3/4"	A-8	15.94	1.70	5.36	85	7-873-168	-	-
	A-11		2.95		141	7-873-169	-	-
20"	A-11	19.88	1.77	7.59	133	7-873-209	-	-
	A-15		15.00	1.77	7.59	158	7-873-259	-
25"	A-11	25.00	1.65	11.1	-	-	231	7-873-2600
	A-15		15.00	1.65	11.1	-	-	-
36",40",49"	A-15	21.85	2.76	7.48	242	7-873-3615	-	-
	A-20		3.15	249	7-873-3620	-	-	

*For SCROLL CHUCKS only!

**See mounting instruction on page 61.



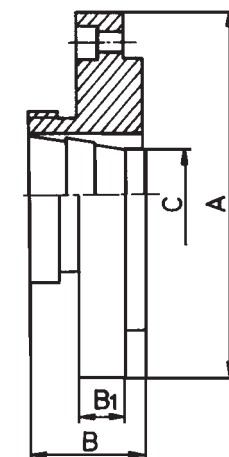
L Type Adapters

Fully Machined Adapters* for BISON plain back, self-centering chucks - designed for direct mounting on L type spindle noses.

8250

Chuck Dia.	Taper No.	Thread Dia.	A	B	C	B1	Weight lbs.	Code No.
5"	L00	3-3/4"-6	4.92	2.13	2.2	0.71	10	7-879-051
6-1/4"	L00	3-3/4"-6	6.32	2.13	2.20	0.71	13	7-879-061
	L0	4-1/2"-6"		2.52	2.60			7-879-062
8"	L00	3-3/4"-6	7.91	2.13	2.20	0.71	22	7-879-081
	L0	4-1/2"-6		2.52	2.60			7-879-082
	L1	6"-6"		2.99	3.35			7-879-083
10"	L00	3-3/4"-6	9.88	2.13	2.20	0.83	33	7-879-101
	L0	4-1/2"-6		2.52	2.60			7-879-102
	L1	6"-6		2.99	3.35			7-879-103
	L2	7-3/4"-5"		3.50	4.29			7-879-104
12-1/2"	L0	4-1/2"-6	12.44	2.52	2.60	1.10	57	7-879-122
	L1	6"-6		2.99	3.35			7-879-123
	L2	7-3/4"-5"		3.50	4.29			7-879-124
15-3/4"	L0	4-1/2"-6	15.83	2.52	2.60	1.10	95	7-879-162
	L1	6"-6		2.99	3.35			7-879-163
	L2	7-3/4"-5		3.50	4.29			7-879-164
	L3	10-3/8"-4"		4.02	5.43			7-879-165
20"	L2	7-3/4"-5	19.76	3.50	4.29	1.14	159	7-879-204
	L3	10-3/8"-4"		4.02	5.43			7-879-205
25"	L2	7-3/4"-5	24.82	3.78	4.29	1.38	397	7-879-254
	L3	10-3/8"-4"		4.02	5.43			7-879-255

*See mounting instructions on page 61. Semi finished adapters are available.



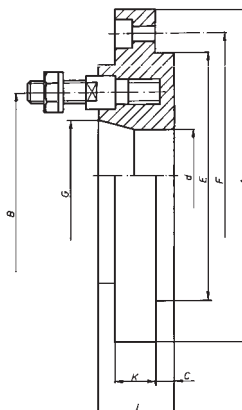
Cast-Iron Adapters

German DIN Spindle Adapters
Type C, DIN 55027

DIN Studs



Taper Size	Stud Dia. Inch	Stud Dia. Mmm	Thread mm	Qty. per Set	Code No.
C-4	.7677	19.5	M10 - 39	3	7-921-904
C-5	.7677	19.5	M10 - 43	4	7-921-905
C-6	.8465	21.5	M12 - 50	4	7-921-906
C-8	1.063	27.0	M16 - 60	4	7-921-908
C-11	1.339	34.0	M20 - 75	6	7-921-911



8230

8232

Chuck Dia.	Taper Size	Stud Dia.	No. of Studs	whole Dia. C	Fully machined				Semi machined			
					Dia. A	B	Weight lbs.	Code No.	Dia. A	Weight lbs.	Flange thickness	Code No.
5"	C-2	-	3	-	-	-	-	7-921-052	-	-	-	-
	C-5	.768	4	3.13	4.94	-	5.3	7-921-055	-	-	-	-
6-1/4"	C-4	.768	3	2.4	6.32	.83	9.5	7-921-064	6.38	9.3	-	-
	C-5	.768	4	3.13	6.32	.83	9.5	7-921-065	6.38	9.3	1.14	7-921-0650
8"	C-4	.768	3	2.40	7.89	.83	15	7-921-084	8.00	27	-	-
	C-5	.768	4	3.13	7.89	.83	15	7-921-085	8.00	27	1.97	7-921-0850
	C-6	.846	4	4.06	7.89	.83	15	7-921-086	8.00	27	1.38	7-921-0860
10"	C-5	.768	4	3.13	9.86	.83	24	7-921-105	9.96	35	1.93	7-921-1050
	C-6	.846	4	4.06	9.86	.83	24	7-921-106	9.96	35	1.93	7-921-1060
12-1/2"	C-6	.846	4	4.06	12.42	1.30	40	7-921-126	12.52	49	2.76	7-921-1260
	C-8	1.063	4	5.35	12.42	1.30	40	7-921-128	12.52	49	2.17	7-921-1280
	C-11	1.339	6	7.59	12.42	1.30	40	7-921-129	12.52	49	2.17	7-921-1290
15-3/4"	C-8	1.063	4	5.35	15.77	1.30	80	7-921-168	15.94	93	2.76	7-921-1680
	C-11	1.339	6	7.59	15.77	1.30	80	7-921-169	15.94	93	1.96	7-921-1690
20"	C-8	1.063	4	5.35	19.70	1.34	132	7-921-208	19.88	159	1.81	7-921-2080
	C-11	1.339	6	7.59	19.70	1.34	132	7-921-209	19.88	159	2.83	7-921-2090
25"	C-8	1.063	4	5.35	24.82	1.30	231	7-921-258	25.00	232	2.83	7-921-2580
	C-11	1.339	6	7.59	24.82	1.65	231	7-921-259	25.00	232	2.83	7-921-2590

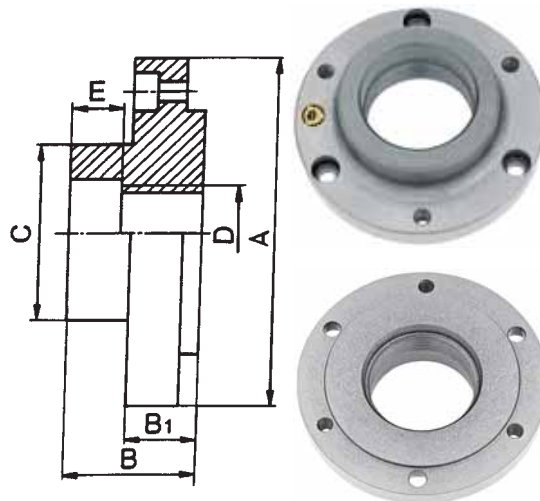
*See mounting instruction on page 61.

Threaded Adapters

8204

Chuck Dia.	A	Thread D	C	B	B1	E	Weight lbs.	Code No.
3-1/4"	3.15	M14 x 1	-	.6299	.6299	.1969	4	7-922-031
		3/4" - 16	-					7-922-035
4"	3.94	1" - 10	1.97	1.50	.551	.5630	5	7-922-043
		1-1/8" - 12W	1.97					7-922-045
		1-1/2" - 8	2.36					7-922-046
5"	4.92	M39 x 4	3.00	2.00	.75	.6260	11	7-922-051
		2-3/16" - 10	3.11	1.61	.689			7-922-053
6-1/4"	-	M39 x 4	3.11	1.61	.689	.6260	13	7-922-061
	6.3	2-3/16" - 10						.768

*See mounting instruction on page 61.

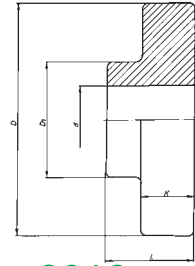


Fully Machined Adapters* for BISON plain back, self-centering Chucks.

Cast-Iron Adapters

Adapters for Threaded Spindles

Rough Adapters
for Scroll Chucks



8205 for Independent Chucks

8262

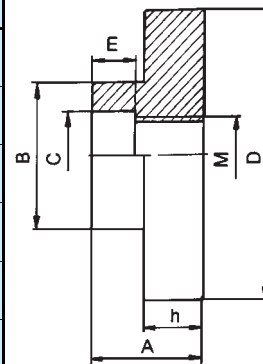
Chuck Dia.	D	d	D1	K	L	Weight lbs.	Code No.
3",4", 5"	5.20	.71	3.46	.98	2.20	4.4	7-870-105
6-1/4"	6.70	.98	3.46	.98	2.20	12	7-870-106
8"	8.30	.98	4.02	1.18	2.83	22	7-870-108
10"	10.24	1.57	4.53	1.26	3.54	34	7-870-110
12-1/2"	12.30	1.97	6.77	1.26	4.02	66	7-870-120
15-3/4"	16.34	2.76	9.06	2.17	4.92	154	7-870-116
20"	20.28	3.15	9.84	2.56	5.98	267	7-870-120
25"	25.20	4.72	11.81	3.35	7.09	496	7-870-125

Chuck Dia.	D	d	B	I	L	Weight lbs.	Code No.
6-1/4"	3.94	.79	2.95	1.18	2.17	8	7-870-306
8"	5.12	1.18	3.74	1.38	2.56	11	7-870-308
10"	7.09	1.57	4.72	1.97	3.35	25	7-870-310
12-1/2"	8.66	2.17	5.51	2.36	3.74	49	7-870-312
15-3/4"	10.63	2.95	7.48	2.36	5.51	95	7-870-316
20",25"	11.02	3.54	7.87	2.36	5.51	99	7-870-320
32"	15.75	3.54	8.66	2.36	5.51	177	7-870-325

Semi-finished Threaded Adapters

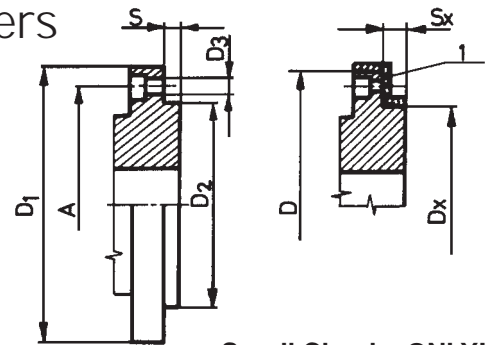
8206

Chuck Dia.	A	B	C	D	h	E	Weight lbs.	Thread M	Code No.
4"	1.535	2.165	1.01500	4.095	.709	.5000	8	1-10	7-871-041
						.6260		1-1/2-8	7-871-042
5"	1.535	2.165	1.01500	5.079	.709	.5000	10	1-10	7-871-051
						.6260		1-1/2-8	7-871-052
6-1/4"	1.535	3.189	1.51421	6.535	.787	.5000	12	1-1/2-8	7-871-062
						.6260		2-1/4-8	7-871-063
8"	1.535	3.583	1.51421	8.110	.866	.5000	12	1-1/2-8	7-871-082
						.6260		2-1/4-8	7-871-083
10"	1.791	4.173	2.26000	10.079	.984	.6260	22	2-1/4-8	7-871-103
						.7480		2-3/8-6	7-871-104
12-1/2"	2.047	4.331	2.38500	12.638	1.102	.7480	33	2-3/8-6	7-871-124
						.6260		2-3/4-8	7-871-125



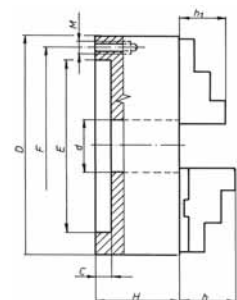
Main Mounting Dimensions For Bison Adapters

After selecting the back plate suitable for your lathe, mount the back plate on the spindle nose of your lathe. This is very important in order to **secure concentricity** between your lathe spindle and the chuck. The back of the Lathe Chuck has a counterbore diameter (E) finished in H6 class, with the depth (C). Before you start Adapter machining, measure the chuck counterbore diameter (E) and depth (C) with the proper accuracy. **A good press fit (H6/k5) is most desirable.** If you do an accurate job, it will ensure satisfactory concentricity.



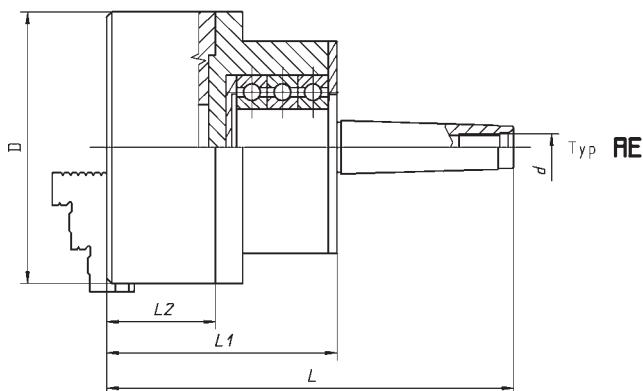
Scroll Chucks ONLY!

Chuck Dia.	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	32"
A=F	2.6378	3.2677	4.2520	5.5118	6.9291	8.8189	11.2598	14.2520	18.0315	23.0709	14.5000
D	3.1496	3.3970	4.9213	6.2992	7.8740	9.8425	12.4016	15.7480	19.6850	24.8031	-
D1	3.1693	3.9567	4.9409	6.3189	7.9134	9.8819	12.4409	15.8268	19.7638	24.9213	-
D3	0.0252	0.3307	0.3307	0.4134	0.5118	0.6693	0.6693	0.6693	0.6693	0.6693	-
D2	2.2835	2.8346	3.8189	5.0000	6.3780	7.9528	10.3150	13.1102	16.6535	21.5748	17.7170
E (H6)	2.2047	2.7559	3.7402	4.9213	6.2992	7.8740	10.2362	12.9221	16.5354	21.4567	17.7170
DX (k5)	2.2047	2.7559	3.7402	4.9213	6.2992	7.8740	10.2362	12.9221	16.5354	21.4567	-
S*	0.0787	0.0787	0.1181	0.1181	0.1181	0.1575	0.1575	0.1575	0.1575	0.2362	-
Sx*	0.0984	0.0984	0.1378	0.1378	0.1378	0.1772	0.1772	0.1772	0.1772	0.2559	-
C	0.1181	0.1181	0.1575	0.1575	0.1575	0.1969	0.1969	0.1969	0.1969	0.2756	0.7874



Rotating Chucks 3 Jaw Self Centering

with fine adjustment SET-TRU
 .0005" T.I.R.



Rotating chucks are provided in a handsome wooden case.

Standard Accessories:

- 4" two sets of hard solid jaws (ID & OD), 1 chuck wrench and 1 hex key.
- 5" & 6" 1 set of two-piece reversible jaws (hard top jaws & hard master jaws), 1 chuck wrench and 1 hex key.

Optional Accessories:

- 4" soft solid jaws,
- 5" & 6" soft top jaws,
- 4 & 6 Jaw SET-TRU chuck,
- 5" 5C Collet Chuck,
- 5" & 6" rotating body.



- These precision chucks are used in tail stocks for jobs where centers can not be used (example: machining of lube).
- Steel body. Hardened and ground scroll and pinions.
- Hardened and ground MT spindle.
- Sealed ball bearings: lubrication through oiler.
- 4 fine adjustment screws provide .0005 T.I.R. repeatability.

5" & 6" with American Standard Two-Piece Tongue & Groove Jaws

9164/9165

Chuck Diameter	d1 Min.	d2 Max.	L	L1	L2	h	Thread d	Max. R.P.M.	MT No.	Weight lbs.	Rotating Chuck Code No.	Body Only Code No.
4"	0.12	3.27	8.70	5.24	2.68	0.67	1/2"-13	2500	3	14.9	7-861-0400	-
5"	0.12	4.92	9.65	6.12	2.81	0.79	5/8"-11	2000	4	22.7	7-861-0500	7-861-9500
6-1/4"	0.12	6.30	11.22	6.16	2.68	1.26	5/8"-11	1800	5	71.3	7-861-0600	7-861-9600

*Solid Jaws only.

Spare Parts



Chuck Dia.	Hard Master Jaws/Set	Hard Top Jaws/Set	Hard Solid Jaws		Soft Top Jaw/1 Pc.	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.	Fine Adj. Screws
			OD Set	ID Set					
Code No.									
4"	-	-	7-880-304	7-881-304	-	7-887-304	7-886-304	7-889-005	7-897-6041
5"	7-885-305	7-883-305	-	-	7-884-305	7-887-505	7-886-505	7-889-005	7-897-6051
6-1/4"	7-885-306	7-883-306	-	-	7-884-306	7-887-506	7-886-506	7-889-008	7-897-6061
8"	7-885-308	7-883-308	-	-	7-884-308	7-887-508	7-886-508	7-889-008	7-897-6081

Rotating Chucks 3 Jaw, Self Centering

with MT Shanks

These precision rotating chucks are used in tailstock for jobs where centers cannot be used (example: machining of tube).

- Steel Body.
- Hardened and ground scroll and pinions.
- Hardened and ground MT shank.
- Sealed ball bearings, lubrication through oiler.
- 3 Jaw Lathe Chucks can be easily removed and replaced with 4 Jaw Scroll Chucks (5", 6"), Face Plate (6"), tapered heads (3" to 5") and by the 5C Collet Chuck (5").

Standard Accessories:

3" & 4" two sets of hard solid jaws (ID & OD),
1 chuck wrench and 1 hex key.

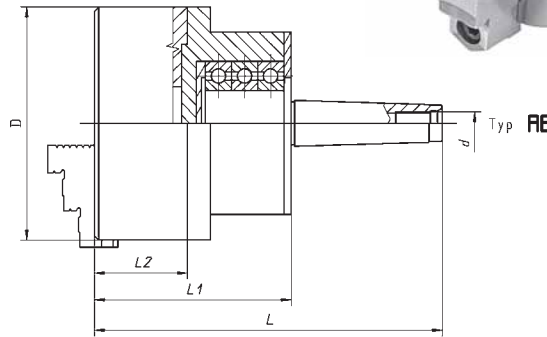
5" & 6" one set of two-piece reversible jaws (hard top jaws & hard master jaws), 1 chuck wrench and 1 hex key.

Optional Accessories:

- 3" & 4" - soft solid jaws,
- 5" & 6" - soft top jaws,
- 3" to 5"- special tapered heads
- 6" - Face Plate and 5" 5C Collet Chuck.



Body only



9154 9155

Chuck Dia.	MT No.	Clamping Range		L	L1	L2	Max. R.P.M.	Weight lbs.	Solid Jaws	2-Piece Jaws	Body Only	*Adapter Only
		min.	max.						Code No.	Code No.		
3"	2	0.08	2.80	6.99	3.84	1.73	4000	8.0	7-860-0300	-	7-573-032	-
	3	-	-	-	-	-		-	-	-	7-573-033	-
4"	3	0.12	3.66	8.09	4.19	2	3500	13.5	7-860-0400	-	7-573-043	7-860-7004
	4	-	-	-	-			-	-	-	-	7-573-044
5"	4	0.12	4.92	9.63	4.78	2.0	3200	25	7-860-0500	7-865-0500	7-573-054	7-860-7005
	5			11.4	5.20	2.2		32	-	-	7-573-055	-
6-1/4"	5	0.12	6.3	11.77	5.24	2.56	3000	34	7-860-0600	7-865-0600	7-573-065	7-860-7006

5" & 6" Chucks with American Standard Two-Piece Tongue & Groove Jaws

*4 Jaw Independent chucks only.

Spare Parts

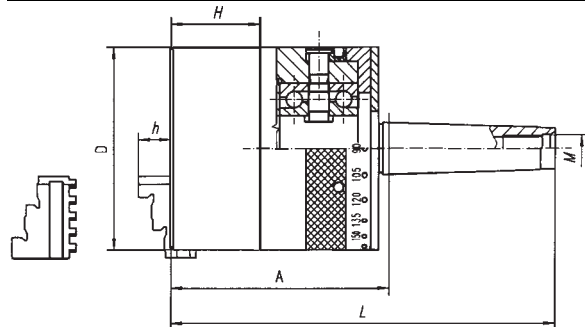


Chuck Dia.	Hard Master Jaws/Set	Hard Top Jaws/Set	Hard Solid Jaws		Soft Top Jaw/1 Pc.	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.
			OD Set	ID Set				
Code No.								
3"	-	-	7-880-303	7-881-303	-	7-887-303	7-886-303	7-889-003
4"	-	-	7-880-304	7-881-304	-	7-887-304	7-886-304	7-889-005
5"	7-885-305	7-883-305	7-880-305	7-881-305	7-884-305	7-887-305	7-886-305	7-889-005
6-1/4"	7-885-306	7-883-306	7-880-306	7-881-306	7-884-306	7-887-306	7-886-306	7-889-008

Rotating Chucks 3 Jaw Self Centering

with MT Shank & angular indexing 9184/9185

Chuck Dia.	d1 min.	d2 max.	L	A	H	Max. R.P.M.	MT No.	Weight lbs.	Code No.
3"	.08	2.80	6.97	4.48	1.73	3000	2	8.6	7-867-0300
4"	.12	3.66	8.05	4.86	1.97	2500	3	13.7	7-867-0400
5"	.12	4.92	9.53	5.49	2.20	2000	4	24.3	7-867-0500
6-1/4"	.12	6.30	10.93	5.83	2.54	1800	5	41.9	7-867-0600



This new generation of BISON Rotating Chucks has additional features: angular indexing and locking mechanism. Angular indexing can be performed through the graduated ring from 0° to 360° in increments of 1. Special locking mechanism enables positioning chuck at every 15. This permits divisions in **2, 3, 4, 6, 8, 12 & 24**. Rotating chuck is furnished with 3 Jaw, front mounting lathe chuck which can be replaced with 4 Jaw, self-centering front mounting chuck.

Standard Accessories:

3" & 4" Two sets of hard solid jaws (ID & OD),
1 chuck wrench and 1 hex key.
5" & 6" 1 set of two-piece reversible jaws (hard top jaws & hard master jaws), 1 chuck wrench and 1 hex key.

Optional Accessories:

3" & 4" soft solid jaws,
5" & 6" soft top jaws,
5" & 6" 4 Jaw scroll chuck,
6" Face Plate,
Tailstocks



Rotating chucks are provided in a handsome wooden case.

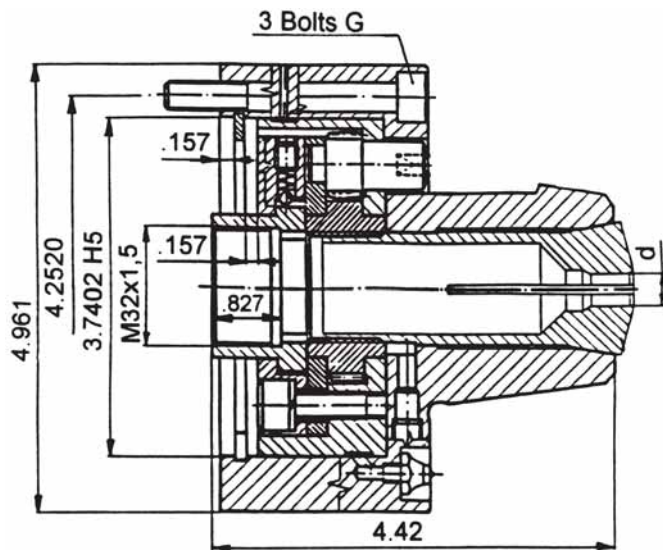
5C Collect Chuck, Power Operated

Plain Back, 0.0004" T.I.R.

2912

Chuck Size	5C Collet Holding Capacity	RPM	Max. Draw Bar Pull Force lbs.	Max Draw Bar Stroke	Code No.
5"	1/16 - 1-1/8	10000	3300	.1575	7-862-0520

5C Collets not included.



New Bison Power operated 5" 5C Collet Chucks are designed for use with all 5C collets. Chucks can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines. A quick and easy to use mechanism allows fast collet change-over. Forged Steel Body. Uses standard draw tubes with thread M32x1.5. Chuck can be used with air, hydraulic cylinders or lever type closers. A, D, DIN & Threaded adapters are available.

4" 5C Collet Chucks *NEW*

Plain Back, T.I.R. 0.0004"

Low Profile, Light Weight, Steel Body, 8000 R.P.M.

Designed for use with all 5C Collets. 3 Pinion design.

They can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines.

The simple key operated scroll provides a uniform, distortion free clamping of work pieces and low collect exchange times.

This unique design, rugged construction and fine workmanship assures high quality and long service life.

BODY - made of high quality **FORGED STEEL**.

FORGED SCROLL - fully hardened and ground for longer life.

3 - PINIONS - hardened and ground.

Each chuck is **balanced** within fine limit.

Adapter plates for **D & Threaded** spindles as well as 5 C adjustable collect stop for the 5C Collect Chuck are available.

Standard Accessories:

1 Chuck Wrench, 2 sets of (front & back) mounting bolts,

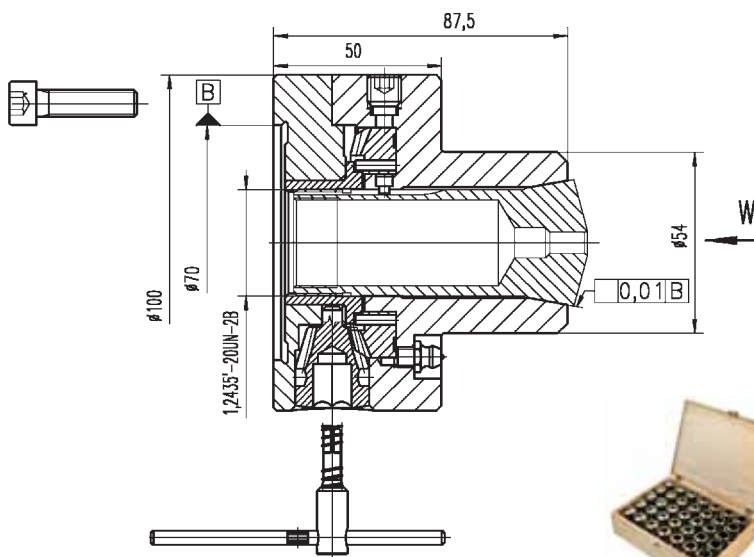
1 Hex Key.

4" OD DIA.



3974

Chuck Size	Mounting	5C Collet Capacity	RPM Max.	Weight lbs.	Chuck	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.	Front Mounting Bolt 1 Pc.	Back Mounting Bolt 1 Pc.	Hex Key
											Code No.
4"	Plain Back	3/64 x 1-1/8	8000	7.0	7-862-0401	7-887-103	7-886-103	7-889-103	7-862-977	7-862-972	6-999-586



Finished Adapter Plates for Threaded & D1 Lathe Spindles

Chuck Dia.	Spindle Size	Code No.
4"	1" -10	7-922-043
	1-1/8" 12W	7-922-045
	1-1/2" - 8	7-922-046
	D1-3	7-878-043
	D1-4	7-878-044
	D1-5	7-878-045



5C Collet Sets

Collet Sets	Code No.
18 Piece 1/16" - 1-1/8" by 16ths	7-168-168
35 Piece 1/16" - 1-1/8" by 32nds	7-168-185
69 Piece 1/16" - 1-1/8" by 64ths	7-168-190
24 Piece 3 mm - 26 mm by 1 mm	7-168-674



5C Emergency Collets

Description	Code No.
1/16" Steel	7-168-404



Adjustable 5C Collet Stop

Code No. 7-460-200



Universal 5pc 5C Collet Stop

Code No. 7-460-210



5C Collet Chucks

For Mounting With Adapter Plates
6000 R.P.M.

Chuck Dia.	Mounting	Model No.	5C Collet Gripping Capacity (inches)	RPM	Weight lbs.	Code No.
5"	Plain Back	3911-5C	3/64 x 1-1/8	6000	12	7-862-0501
Direct Mount						
5"	D1-3	3944-5C	3/64 X 1-1/8	6000	15	7-862-0510
	D1-4					7-862-0511
	D1-5					7-862-0512
	1-1/2" X 8	3984-5C				7-862-0515
	2-1/4" X 8					7-862-0517
Chuck with Threaded Nose 2-3/16 x 10						
5"	Plain Back	3974-5CT	3/64 X 1-1/8	6000	12	7-862-0502
	Shoulder Length Stop					7-862-953
TRU-LENGTH						
5"	Plain Back	3975-5C	3/64 X 1-1/8	6000	13	7-862-0503

The 5C Collet Chucks are designed for use with all 5C Collets. They can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines. The simple key operated scroll provides a uniform, distortion free clamping of work pieces and low collect exchange times. Their simple design, rugged construction and fine workmanship assures high quality and long service life.

BODY - made of high quality FORGED STEEL.
FORGED SCROLL - fully hardened and ground for longer life.
PINIONS - hardened and ground.

Machined* Adapters for A, D, DIN, NST & Threaded Lathe Spindles.

Chuck Dia.	Taper Size	Code No.
5"	A-4	7-877-054
	A-5	7-877-055
	A-6	7-877-056
	A-8	7-877-058
	D1-3	7-878-053
	D1-4	7-878-054
	D1-5	7-878-055
	D1-6	7-878-056
	D1-8	7-878-058
	L00	7-879-051
	NST 50	7-915-505
	C-2 / DIN-2	7-921-052
	C-5 / DIN-5	7-921-055
	M39 X 4	7-922-051
	2-3/16" - 10	7-922-053

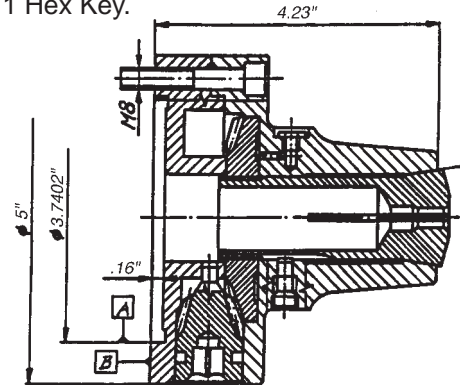


5C Collets 7-168-

Adapter plates for **A, D, DIN, Threaded & NST50** spindles as well as 5 C adjustable collect stop for the 5C Collect Chuck are available.

Standard Accessories:

- 1 Chuck Wrench, 1 set of mounting bolts, 1 Hex Key.



* See mounting instructions.

Semi-machined Adapters for Threaded Lathe Spindles.

Chuck Size	Spindle Size	Code No.
5"	1 x 10	7-871-051
	1-1/2 x 8	7-871-052
	Rough	7-870-105



Spare Parts



Chuck Dia.	Scroll 1 Pc.	Pinion 1 Pc.	Wrench 1 Pc.
Code No.			
5"	7-887-105	7-886-105	7-889-005



3911 UNIVERSAL 0.0004"
 5C 5" Collet Chucks, 6000R.P.M.
 Forged Steel Body, Dia. 5"
 Code No. 7-862-0501 PLAIN BACK,
 Code No. 7-862-051. D1 & Thr. MOUNT



3911 TRU LENGTH 0.0004"
 5C 5" Collet Chucks, 6000R.P.M.
 Forged Steel Body,
 NO Work piece movement.
 Code No. 7-862-0503 PLAIN BACK



3911-5CT THREADED 0.0004"
 5C 5" Collet Chucks, 6000R.P.M.
 Forged Steel Body,
 Threaded nose 2-3/16"-10,
 Code No. 7-862-0502 PLAIN BACK

Super Precision 5C Collet Chucks

with Fine Adjustment
for Mounting With Adapter Plates
0.0004" T.I.R. and 6000 R.P.M.

**BISON INTRODUCES THE NEW 5" "SET-TRU"
5C COLLET CHUCK, 6000 RPM & .0004" T.I.R.**

The Super Precision 5C Collet Chucks are designed for use with all 5C collets.

They can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines.

The simple key operated scroll provides a uniform, distortion free clamping of the work-piece and low collet exchange time.

Four fine adjustment screws are used to set up the chuck on its mounting plate to get precision within **.0004" T.I.R**

on duplicate parts.

Outstanding accuracy, low cost, versatility and long life make BISON 5" **5 C SET-TRU** Chucks invaluable in the workshop and indispensable in the tool-room.

BODY - made of high quality **FORGED STEEL**.

FORGED SCROLL - fully hardened & ground for longer life.

PINIONS - hardened and ground.

5" mounting plates (Adapters) **A5, D3, D4, D5,**

Threaded and DIN are available.

Standard Accessories:

1 Chuck Wrench, 1 set of mounting bolts,

1 Hex Key.

Fully machined Steel Adapters
for A, D, DIN and Threaded Spindles.

Chuck Dia.	Taper Size	Code No.
5"	A-4	7-874-054
	A-5	7-874-855
	A-6	7-874-056
	D1-3	7-875-053
	D1-4	7-875-054
	D1-5	7-875-055
	D1-6	7-875-056
	D1-8	7-875-058
	L00	7-879-9051
	1" x 10	7-876-051
	1-1/2" x 8	7-876-052
	2-3/16" x 10	7-876-054
	2-1/4" x 8"	7-876-056
	C-5 / DIN-5	7-920-055
	5C Shank	7-912-305

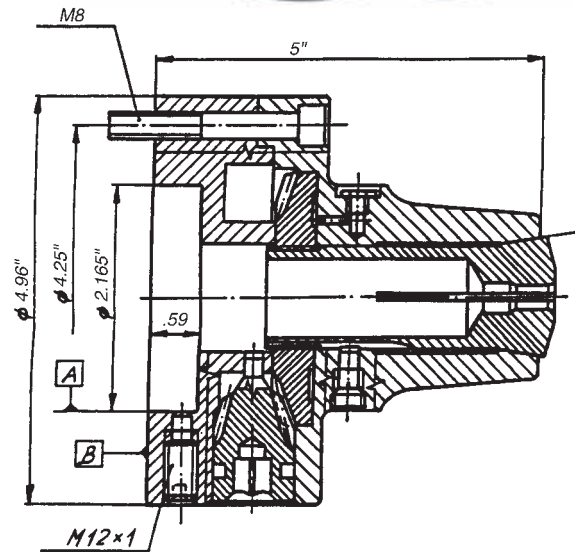


5C Collets 7-168-

Spare Parts



Chuck Dia.	Scroll 1 Pc.	Pinion 1 Pc.	Fine Adj. Screws/1 Pc.	Wrench 1 Pc.
5"	7-887-105	7-886-105	7-897-6051	7-889-005



3960-5C

Chuck Dia.	5C Collet Holding Capacity In.	R.P.M.	Weight lbs.	Code No.
5"	3/64 x 1-1/8	6000	12	7-862-0505

5C Collets not included, see page 230.

Optional Accessories:

Adjustable 5C Collet Stop
Code No. 7-460-200

Universal 5pc 5C Collet Stop
Code No. 7-460-210



16C Collet Chucks

Plain Back & SET-TRU
Steel Body, T.I.R. 0.0004"
6000 R.P.M.

TRU- LENGTH
NO Workpiece
Movement !

3975

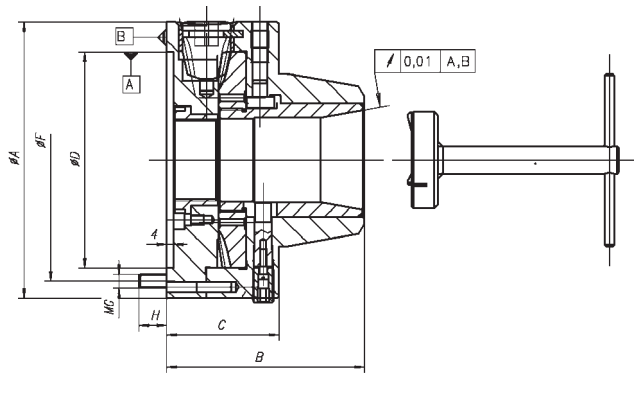
Chuck Size	Mounting	16C Collet Holding Capacity	RPM	Weight lbs.	Code No.
6"	Plain Back	1/16 - 1-5/8	6000	21.0	7-862-0601
	SET-TRU			24.0	7-862-0605



Adapters for A, D, C L & Threaded Spindles



Chuck Dia.	Taper Size	Plain Back Code No.	SET-TRU Code No.
6-1/4"	A-5	7-873-065	7-874-065
	A-6	-	7-874-066
	D1-3	7-878-063	7-875-063
	D1-4	7-878-064	7-875-064
	D1-5	7-878-065	7-875-065
	D1-6	7-878-066	7-875-066
	L00	7-879-061	7-879-9061
	L0	7-876-062	7-879-9062
	C-4 / DIN-4	7-921-064	-
	C-5 / DIN-5	7-921-065	-
	C-6 / DIN-6	-	7-920-066
	1-1/2" - 8	7-871-062	7-876-062
	2-3/16" - 10	7-922-063	7-876-064
	2-1/4" - 8	7-871-063	7-876-066



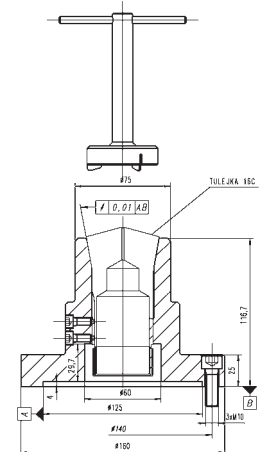
Spare Parts



Chuck Dia.	Mounting	Scroll 1 Pc.	Pinion 1 Pc.	Fine Adj. Screws 1 Pc.	Collet Wrench 1 Pc.	Chuck Wrench 1 Pc.	Mounting Screws 1 Pc.
6"	Plain Back	7-887-106	7-886-606	-	7-862-860	7-889-008	7-898-128
	SET-TRU			7-897-6061			7-862-963

Power Operated
Forged Steel Body, Plain Back
T.I.R. 0.0004", 6000 R.P.M.

2974



Chuck Size	16C Collet Holding Capacity	Max. Draw Bar Pull Force lbs.	Max. Draw Bar Stroke	Chuck Code No.	Wrench Code No.
6"	1/16 - 1-5/8	5290	0.157	7-862-0630	7-862-860

5C & 16C Precision Round Collets



Concentricity guaranteed to 0.0004"



Inch

Size (inch)	Code No.	Size (inch)	Code No.	Size (inch)	Code No.
3/64	7-168-002	27/64	7-168-050	51/64	7-168-098
1/16	1-168-004	7/16	7-168-052	13/16	7-168-100
5/64	1-168-006	29/64	7-168-054	53/64	7-168-102
3/32	7-168-008	15/32	7-168-056	27/32	7-168-104
7/64	7-168-010	31/64	7-168-058	55/64	7-168-106
1/8	7-168-012	1/2	7-168-060	7/8	7-168-108
9/64	7-168-014	33/64	7-168-062	57/64	7-168-110
5/32	7-168-016	17/32	7-168-064	29/32	7-168-112
11/64	7-168-018	35/64	7-168-066	59/64	7-168-114
3/16	7-168-020	9/16	7-168-068	15/16	7-168-116
13/64	7-168-022	37/64	7-168-070	61/64	7-168-118
7/32	7-168-024	19/32	7-168-072	31/32	7-168-120
15/64	7-168-026	39/64	7-168-074	63/64	7-168-122
1/4	7-168-028	5/8	7-168-076	1	7-168-124
17/64	7-168-030	41/64	7-168-078	1-1/64	7-168-126
9/32	7-168-032	21/32	7-168-080	1-1/32	7-168-128
19/64	7-168-034	43/64	7-168-082	1-3/64	7-168-130
5/16	7-168-036	11/16	7-168-084	1-1/16	7-168-132
21/64	7-168-038	45/64	7-168-086	1-5/64	7-168-134
11/32	7-168-040	23/32	7-168-088	1-3/32	7-168-136
23/64	7-168-042	47/64	7-168-090	1-7/64	7-168-138
3/8	7-168-044	3/4	7-168-092	1-1/8	7-168-140
25/64	7-168-046	49/64	7-168-094		
13/32	7-168-048	25/32	7-168-096		
18 Piece Collet Set 1/16" - 1-1/8" by 16ths					7-168-168
35 Piece Collet Set 1/16" - 1-1/8" by 32nds					7-168-185
69 Piece Collet Set 1/16" - 1-1/8" by 64ths					7-168-190

Sets

Collet Sets	Code No.
18 Piece 1/16" - 1-1/8" by 16ths	7-168-168
35 Piece 1/16" - 1-1/8" by 32nds	7-168-185
69 Piece 1/16" - 1-1/8" by 64ths	7-168-190
24 Piece 3 mm - 26 mm by 1 mm	7-168-674



Emergency Collets

Description	Code No.
1/16" Steel	7-168-404

Metric

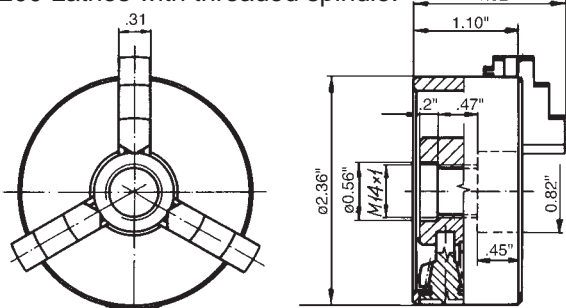
Size	Code No.	Size	Code No.
3 mm	7-168-603	17 mm	7-168-617
4 mm	7-168-604	18 mm	7-168-618
5 mm	7-168-605	19 mm	7-168-619
6 mm	7-168-606	20 mm	7-168-620
7 mm	7-168-607	21 mm	7-168-621
8 mm	7-168-608	22 mm	7-168-622
9 mm	7-168-609	23 mm	7-168-623
10 mm	7-168-610	24 mm	7-168-624
11 mm	7-168-611	25 mm	7-168-625
12 mm	7-168-612	26 mm	7-168-626
13 mm	7-168-613	24 Piece Collet Set 3 - 26 mm by 1 mm	7-168-674
14 mm	7-168-614		
15 mm	7-168-615		
16 mm	7-168-616		

Size (inch)	Code No.	Size (inch)	Code No.	Size (inch)	Code No.
5/64	1-164-006	15/32	7-164-056	55/64	7-164-106
3/32	7-164-008	31/64	7-164-058	7/8	7-164-108
7/64	7-164-010	1/2	7-164-060	57/64	7-164-110
1/8	7-164-012	33/64	7-164-062	29/32	7-164-112
9/64	7-164-014	17/32	7-164-064	59/64	7-164-114
5/32	7-164-016	35/64	7-164-066	15/16	7-164-116
11/64	7-164-018	9/16	7-164-068	61/64	7-164-118
3/16	7-164-020	37/64	7-164-070	31/32	7-164-120
13/64	7-164-022	19/32	7-164-072	63/64	7-164-122
7/32	7-164-024	39/64	7-164-074	1	7-164-124
15/64	7-164-026	5/8	7-164-076	1-1/16	7-164-132
1/4	7-164-028	41/64	7-164-078	1-5/64	7-164-134
17/64	7-164-030	21/32	7-164-080	1-3/32	7-164-136
9/32	7-164-032	43/64	7-164-082	1-7/64	7-164-138
19/64	7-164-034	11/16	7-164-084	1-1/8	7-164-140
5/16	7-164-036	45/64	7-164-086	1-3/16	7-164-142
21/64	7-164-038	23/32	7-164-088	1-1/4	7-164-144
11/32	7-164-040	47/64	7-164-090	1-5/16	7-164-146
23/64	7-164-042	3/4	7-164-092	1-3/8	7-164-148
3/8	7-164-044	49/64	7-164-094	1-7/16	7-164-150
25/64	7-164-046	25/32	7-164-096	1-1/2	7-164-152
13/32	7-164-048	51/64	7-164-098	1-9/16	7-164-154
27/64	7-164-050	13/16	7-164-100	1-5/8	7-164-156
7/16	7-164-052	53/64	7-164-102		
29/64	7-164-054	27/32	7-164-104		

Mini Self-Centering Scroll Chucks

With hard reversible jaws, Steel Body
 3 Jaw Self-Centering Scroll Chucks
 with reversible jaws, Steel Body

Special compact design to achieve very small turned diameters.
 These chucks are suitable for EMCO, UNIMAT 3 &
 PRAZI MD200 Lathes with threaded spindle.



Wrench



3286

3286

Standard Accessories:

1 set of hard solid reversible Jaws,
 1 chuck wrench.

Optional Accessories:

Set of soft solid jaws,
 Drill chuck Arbor
 MT2 x 1/2"-20.



Code No. 7-052-613

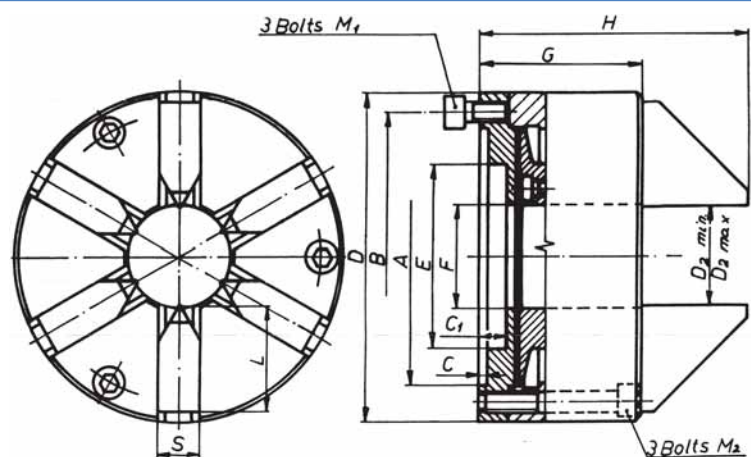
Chuck Dia.	Type of Mounting	Weight lbs.	Clamping Ranges min. - max.	Chuck Code No.	Hard Solid Jaws/Set	Soft Solid Jaws/Set	Scroll 1 Pc.	Wrench 1 Pc.
2-1/3"	M12 X 1	.98	.02 - 2.36	7-810-0212	7-893-002	7-882-214	7-887-002	7-889-002
	M14 X 1			7-810-0214				
	1/2" - 20			7-810-0222				
	3/4" - 16			7-810-0225				

6 Jaw Scroll Chucks for Drill Sharpening Steel Body, Plain Back



Specially designed for grinding twist drills and other cutting tools. Forged steel body. Forged scroll and pinions - hardened and ground.

T.I.R. 0.00059"



Mounting Bolts:
 3" & 4" (M2) Thr. M6,
 6" (M1) Thr. M10.

3867

Chuck Dia.	D	B	A	C	G	H	S	L	Clamping Ranges min. - max.	Hole F	Weight lbs.	Code No.	Hard Solid Jaws 6 pieces/set Code No.	Scroll Code No.	Pinion Code No.
3"	3.35	2.756	2.440	.15	1.73	3.19	.433	1.26	.039-.984	1.00	4.6	7-863-0300	7-863-903	7-887-303	7-886-303
4"	4.33	3.740	3.386	.16	1.97	3.27	.591	1.50	.091-1.260	1.28	7.7	7-863-0400	7-863-904	7-887-304	7-886-304
6-1/4"	6.30	5.512	4.921	.16	3.11	5.12	.787	2.01	.100-1.970	2.01	9.9	7-863-0600	7-863-906	7-887-506	7-886-506

Quick Clamping

Self-Centering Scroll Chucks, Steel Body
R.P.M. 100, T.I.R. 0.00059"

FOR DRILLING & END MILL
SHARPENING AS WELL AS FOR
FIXTURES WITH 5C & MT SOCKETS

3266

3866



Chuck Dia.	Hole Dia.	R.P.M. max.	3-Jaw		R.P.M. max.	6-Jaw	
			Weight lbs.	Code No.		Weight lbs.	Code No.
2"	M14	6000	1.0	7-864-0214	-	-	-
3"	.95	2000	2.4	7-864-0300	1600	2.8	7-869-0300
4"	1.26	2000	7.1	7-864-0400	1600	6.2	7-869-0400
5"	1.50	1500	8.8	7-864-0500	1200	8.8	7-869-0500
6-1/4"	2.05	1500	16.1	7-864-0600	1200	15.4	7-869-0600
8"	2.44	1200	30.0	7-864-0800	-	-	-

BISON 3 & 6 Jaw lever operated, super accurate, low profile chucks are designed to solve tool grinding problems. The keyless and pinionless gripping system allows the reduction of clamping and unclamping time to a minimum. 6 jaw chucks provide a uniform distortion free clamping of work pieces. Chucks can be mounted on the spindle noses of tool grinders, on rotary tables, indexing fixtures and measuring devices. Special adapters for tool grinders as well as adapters with 5C & MT shanks are available.

Standard Accessories:

3 Jaw Chucks are provided with
1 set of ID & 1 set of OD Jaws,
1 Wrench.

6 Jaw Chucks are provided with
1 set of Jaws and
1 Wrench.

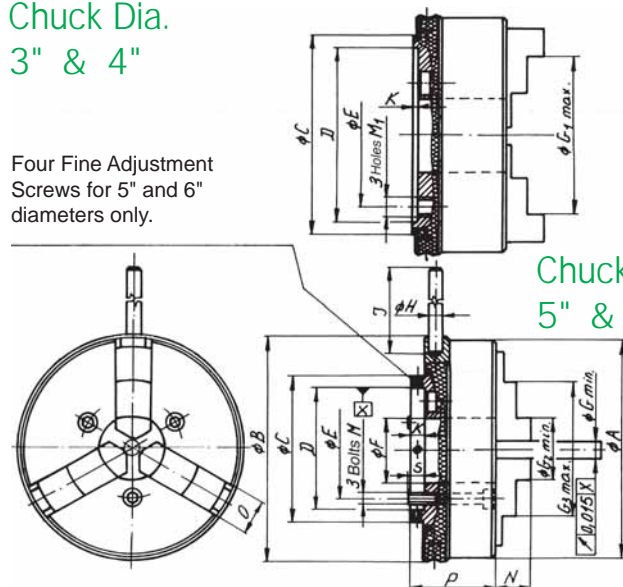
Optional Accessories:

Soft Solid Jaws.
Hard Master Jaws.
5C & MT Adapters.

Chuck Dia.

3" & 4"

Four Fine Adjustment
Screws for 5" and 6"
diameters only.

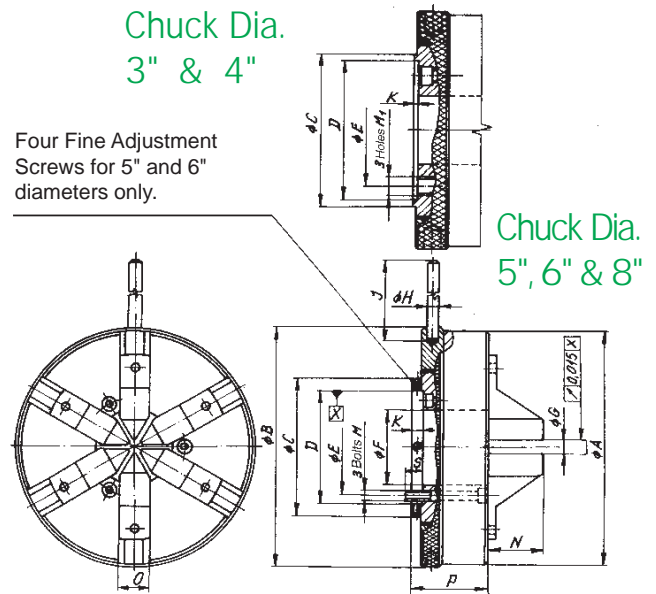


Chuck Dia.
5" & 6"

Chuck Dia.

3" & 4"

Four Fine Adjustment
Screws for 5" and 6"
diameters only.



Chuck Dia.
5", 6" & 8"

Chuck Dia. A	B	C	D	E	F	M	M1	P	3-Jaw Chucks								6-Jaw Chucks					
									G min.	G1 max.	G2 min.	G3 max.	K	N	O	S	G min.	G max.	K	N	O	S
3"	3.23	2.05	1.8898	1.5354	.95	-	M6	1.38	.0394	2.9331	.8268	2.8150	.0591	.5118	.4331	-	.0394	.9055	.0591	.8661	.4331	-
4"	4.02	3.35	2.9528	2.4409	1.26	-	M8	1.57	.0787	3.7001	.9843	3.4646	.0787	.6693	.5906	-	.0591	1.2205	.0787	.9843	.5906	-
5"	5.08	3.27	2.7559	2.2047	1.50	M6	-	1.89	.0984	4.9213	1.2598	4.6063	.3150	.7874	.7874	.31	.0787	1.4567	.3150	1.4173	.5906	.3071
6-1/4"	6.46	3.78	3.0901	2.5591	2.05	M6	-	2.05	.0984	6.2992	1.6142	6.0827	.3150	1.2992	.7874	.31	.1181	2.0079	.3150	1.4173	.7874	.3071
8"	8.07	5.79	4.5276	3.3071	2.44	M8	-	2.60	.1378	7.8740	2.0079	8.0709	.5118	1.1811	.9843	.43	-	-	-	-	-	-

Quick Clamping Chucks

Spare Parts



Chuck Dia.	Hard Solid Jaws			Soft Solid Jaws	Hard Master Jaws		Scroll	Wrench
	6-Jaw/Set	3-Jaw ID/Set	3-Jaw OD/Set	3-Jaw/Set	6-Jaw/Set	3-Jaw/Set	1 Pc.	1 Pc.
Code No.								
3"	7-892-603	7-881-503	7-880-503	7-882-503	-	-	7-887-603	7-889-903
4"	7-892-604	7-881-504	7-880-504	7-882-504	-	-	7-887-604	7-889-904
5"	7-892-605	7-881-505	7-880-505	7-882-505	-	-	7-887-605	7-889-905
6-1/4"	7-892-606	7-881-306	7-880-306	7-882-306	7-885-606	7-885-306	7-887-606	7-889-606
8"	-	7-881-308	7-880-308	7-882-308	-	7-885-308	7-887-608	7-889-608

5C Adapters Fully Machined

5C & MT Adapters are designed for use with BISON 3 & 6 Jaw Quick Clamping Lathe Chucks.

Made of high quality forged steel, hardened & precision ground for maximum accuracy. Wide clamping range and high accuracy makes them very useful in many precision drilling, turning, grinding and milling operations. BISON Quick Clamping Chucks give accuracy not available with standard and precision 5C collets.

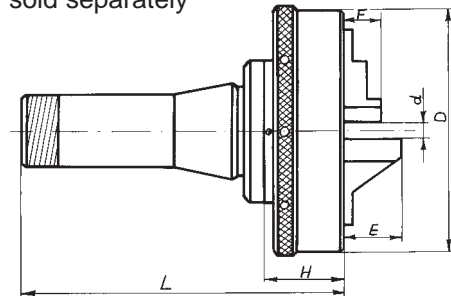


Adapters & Chucks are sold separately

T.I.R. 3"& 4" 0.001" 5"& 6" 0.0006"

8287

Chuck Dia. D	L	H	Thru Hole Dia.	3-jaw F	6-jaw E	3-jaw d min.-max.	6-jaw d min.-max.	Code No.
3"	5.37	1.38	.866	.51	.87	.039-0.91	.039-0.91	7-910-603
4"	5.42	1.57		.67	.98	.079-1.22	.059-1.22	7-910-604
5"	5.74	1.89		.79	1.42	.098-1.46	.079-1.46	7-910-605
6-1/4"	5.82	2.05		1.30	1.42	.098-2.00	.118-2.00	7-910-606



MT Adapters Fully Machined

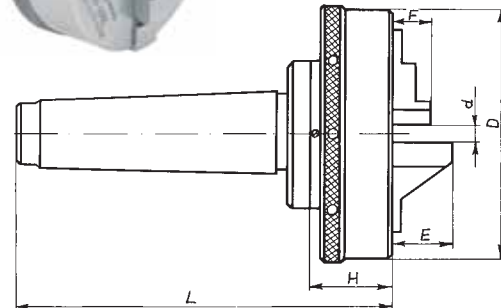
Adapters & Chucks are sold separately



T.I.R. 3"& 4" 0.001" 5"& 6" 0.0006"

8283

MT No.	Chuck Dia. D	L	H	3-jaw F	6-jaw E	3-jaw d min.-max.	6-jaw d min.-max.	Code No.
3	3" & 4"	5.51	1.57	.67	.98	.079-1.22	.059-1.22	7-913-403
	5"	5.60	1.89	.79	1.42	.098-1.46	.079-1.46	7-913-503
4	4"	6.41	1.57	.67	.98	.079-1.22	.059-1.22	7-913-404
	5"	6.50	1.89	.79	1.42	.098-1.46	.079-1.46	7-913-504
5	6"	7.68	2.05	1.30	1.42	.098-2.00	.118-2.00	7-913-605



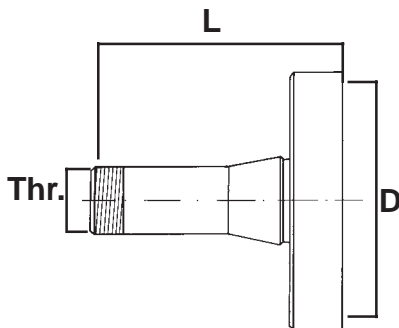
5C Adapters

for BISON Lathe Chucks Semi-Finished

5C Adapters are designed for use with Self-Centering or Independent Lathe Chucks. Made of high quality forged steel. 5C shank is hardened & precision ground for maximum accuracy. Soft flange. Wide clamping range and high accuracy makes them very useful in many precision drilling, turning, grinding and milling operations. **BISON Chucks and 5C Adapters give accuracy not available with standard and precision 5C collets.**



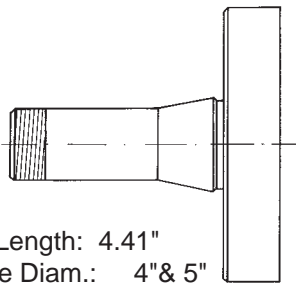
8289



5C						Lathe Chucks		
Shank	Flange Dia. D	Hole d	L	Thr.	Code No.	Chuck Dia.	3&4-Jaw Code No.	4-Jaw Code No.
5C	4"	.866	4.41	1.24"x20"	7-909-304	3" & 4"	7-810-0300 7-810-0400 7-811-0400	7-850-0300
	5"				7-909-305	5" & 6"***	7-800-0500 7-810-0500 7-812-0500 7-814-0500	7-850-0500 7-850-0600
	6"				7-909-306	6"	7-800-0600 7-812-0600 7-814-0600	-

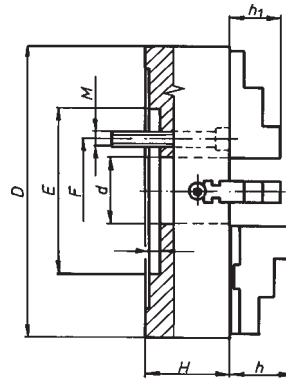
Principal Dimensions for BISON Chucks with 5C Adapters

5C Soft Blank
Adapters

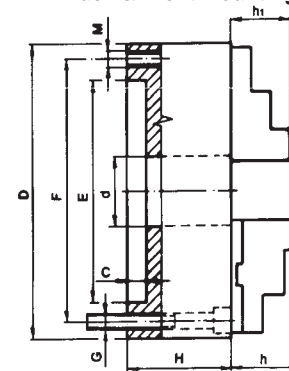


Total Length: 4.41"
Flange Diam.: 4" & 5"
Flange Thickness: 1"
Hole Diam.: .866"

4 Jaw Independent
Chuck



3 Jaw Scroll Chucks
Back & Front Mounting



4 Jaw Independent Chucks

Chuck Dia. D	E	F	d	C	H	h1	M
3"	2.4409	2.83	.98	.20	1.57	.67	"1/4"-20
5"	2.7500	2.13	1.02	.10	1.69	.79	5/16"-18
6"	3.2500	2.75	1.65	.10	1.69	.79	3/8"-16"

For more information see page

3 Jaw Scroll Chucks

Chuck Dia. D	F	E	d	C	H	h1	M	G
3"	2.64	2.2047	.63	.12	1.73	.51	M6	M6
4"	3.27	2.7559	.79	.12	1.97	.67	M8	M8
5"	4.25	3.7402	1.26	.16	2.21	.79	M8	M8
6"	5.51	4.9213	1.65	.16	2.56	1.26	M10	M10

For more information see page

3 Jaw Large Thru-Hole

Power Operated Chucks Type 2405 with A2 Mount

BISON introduces a new line of 3 Jaw Power Operated Lathe Chucks designed with a large thru-hole as a direct replacement for Kitagawa style standard chucks.

Features:

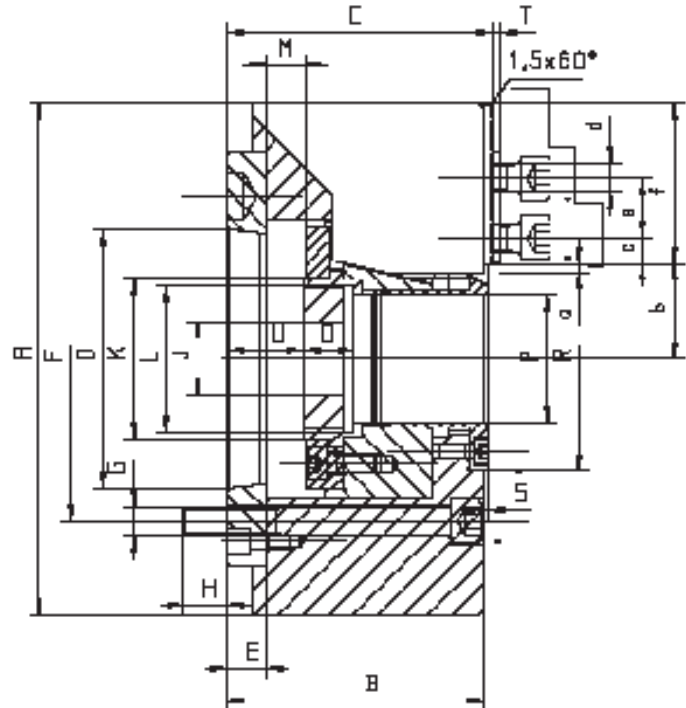
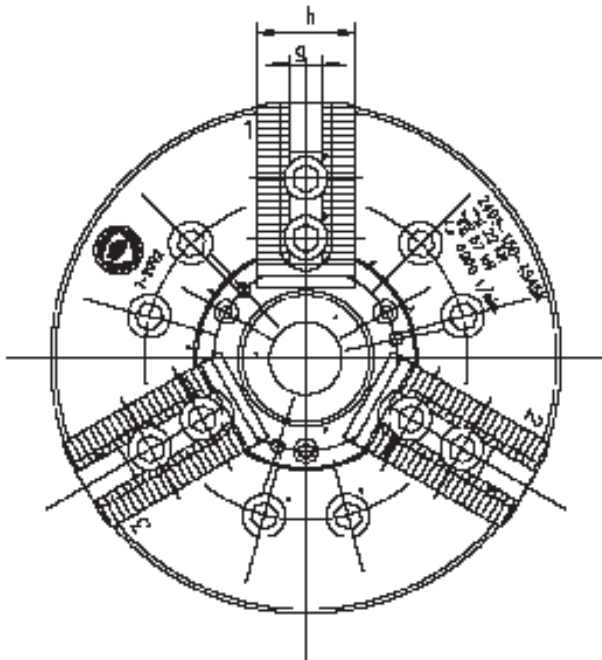
- Repeatability +/- 0.0005".
- Body and parts manufactured of high grade alloy steel.
- Mating surfaces of body, wedge and jaws are case hardened (58HRC) and ground.
- Rigid design.
- Master jaws secured against throw-off.
- Direct lubrication of master jaws.
- Unbalance within the limits by DIN 6386.
- A2 mounting corresponds to the USAS B5.9-1967.
- Chuck & chuck jaws correspond to the ASME B5.8-2001.

Standard Accessories:

- Hard Top Jaws.
- Chuck Mounting Bolts.
- T-nuts with jaw mounting bolts.
- Draw Nut.
- Piston Nut Wrench.
- Hex Key.

Optional Accessories:

- Soft Top Jaws.



Standard Serrations:
1.5mm x 60

Note: Plain Back Chucks available.

Chuck Diameter		6"	160 mm	8"	210 mm	10"	250 mm	12"	315 mm	
Code No.		7-781-0650		7-781-0860		7-781-1080		7-781-1280		
Spindle Nose		A2-5		A2-6		A2-8*		A2-8*		
A	inch/mm	6.6535	169	8.2677	210	10	254	12.402	315	
B	inch/mm	3.543	90	4.1732	106	4.685	119	4.7638	121	
C	inch/mm	3.685	93.59	4.3146	109.59	4.8264	122.59	4.9213	124.59	
D	inch/mm	3.2505	82.563	4.188	106.375	5.5007	139.719	5.5007	139.719	
E	inch/mm	0.5906	15	0.6693	17	0.748	19	0.748	19	
F	inch/mm	4.126	104.8	5.252	133.4	6.748	171.4	6.748	171.4	
G (6 Bolts)	mm	7/16" - 14		1/2" - 13		5/8" -11		5/8" - 11		
H	inch/mm	0.4528	11.5	0.6693	17	0.7480	19	0.7087	18	
J	inch/mm	0.7874	20	1.1811	30	1.7717	45	1.9685	50	
K	inch/mm	2.3622	60	2.5984	66	3.7008	94	4.252	108	
L max	mm	M55x2		M60x2		M85x2		M100x2		
Wedge Stroke M	inch/mm	0.4724	12	0.6299	16	0.748	19	0.9055	23	
O	inch/mm	0.748	19	0.8071	20.5	0.9843	25	1.1023	28	
Thru-Hole P	inch/mm	1.7717	45	2.0472	52	2.9528	75	3.5827	91	
R	inch/mm	2.756	70	3.622	92	4.6063	117	5.2756	134	
S	inch/mm	0.1024	2.6	0.1024	2.6	0.1024	2.6	0.1024	2.6	
T	inch/mm	0.0949	2.41	0.1343	3.41	0.1343	3.41	0.1343	3.41	
U	inch/mm	min.	0.5906	15	0.6496	16.5	0.7402	18.8	0.4331	11
		max.	1.063	27	1.2795	32.5	1.4882	37.8	1.3386	34
Jaw Travel a	inch/mm	0.1083	2.75	0.1457	3.7	0.1732	4.4	0.2087	5.3	
b	inch/mm	min.	1.5551	29.35	1.3858	35.2	1.8346	46.6	2.2047	56
		max.	1.2638	32.1	1.5315	38.9	2.0079	51	2.4134	61.3
c	inch/mm	min.	0.3543	9	0.4134	10.5	0.4016	10.2	0.6181	15.7
		max.	1.0039	25.5	1.2992	33	0.1248	38.17	1.9882	50.5
d	mm	M10		M12		M12		M16		
e	inch/mm	0.7087	18	0.9843	25	1.1811	30	1.2598	32	
f	inch/mm	2.0669	52.5	2.5984	66	2.9921	76	3.7598	95.5	
g (H7)	inch/mm	0.4724	12	0.5512	14	0.6299	16	0.8268	21	
h	inch/mm	1.4961	38	1.575	40	1.7717	45	2.0472	52	
Max. Swing of Top Jaws	inch/mm	8.346	212	10.945	278	13.583	345	15.433	392	
Max. Draw Bar Pull Force	lbf/kN	4850	22	7496	34	9480	43	12346	56	
Max. Gripping Force	lbf/kN	12566	57	18959	86	24471	111	31816	144	
Max. Speed	rpm	6000		5000		4200		3300		
Moment of Inertia lbsxft ² /kgxm ²		1.342	0.057	3.53	0.15	7.3	0.31	17.18	0.73	
Weight without Top Jaws	lbs/kg	27.6	12.5	44.0	20.0	83.8	38.0	130.1	59	
Matching Hard Top Jaws	Code No.	7-787-306		7-787-308		7-787-310		7-787-312		
Matching Soft Top Jaws		7-788-306		7-788-308		7-788-310		7-788-312		
Matching Cylinder		7-797-135		7-797-150		7-797-170		7-797-210		

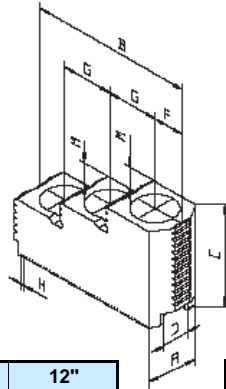
Hydraulic Rotating Cylinders with Thru-Hole, High Speed

1305-M

Chuck Dia.	in.	6-1/4"	8"	10"	12-1/2"
Code No.		7-797-135	7-797-150	7-797-170	7-797-210
Cylinder Size	mm	135/46	150/52	170/67	210/86
Piston Stroke	in.	.9843	1.181	1.378	1.378
Max. Draw Bar Pull Force	lbf.	7000	8000	11000	16000
Max. Speed	r.p.m.	7100	6300	5500	4500
Moment of Inertia	lbs.x ft ²	1.18	1.65	2.82	5.89
Weight	lbs.	47	56	69	95

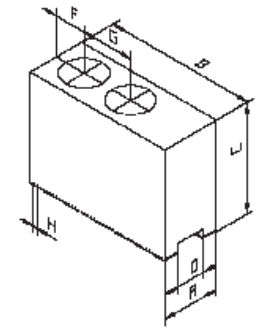


Hard Top Jaws



Chuck Dia.	6"	8"	10"	12"
Jaw Code No.	7-787-306	7-787-308	7-787-310	7-787-312
A	1.0236	1.2598	1.5748	1.5748
B	2.3622	3.1100	4.0157	4.0157
C	1.5354	1.9290	2.1260	2.2835
D H7	0.4724	0.5512	0.6300	0.8270
F	0.4921	0.5709	0.8270	0.7480
G	0.7087	0.9843	1.1811	1.2600
H	1.5 X 60 (Serration)			
M	0.3937	0.4724	0.5512	0.5512
Bolt Size	M10	M12	M12	M16
Weight (lbs.)	0.44	1.00	2.10	2.00

Soft Top Jaws

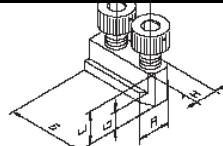
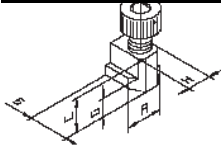


Chuck Dia.	6"	8"	10"	12"
Jaw Code No.	7-788-306	7-788-308	7-788-310	7-788-312
A	1.0236	1.5748	1.7717	1.7717
B	2.2047	2.9530	3.7008	4.2913
C	1.4961	1.9690	2.1654	2.7560
D H7	0.4724	0.5512	0.6299	0.8270
F	0.4331	0.5906	0.8268	0.8270
G	0.7087	0.9843	1.1811	1.2598
H	1.5 X 60 (Serration)			
Bolt Size	M10	M12	M12	M16
Weight (lbs.)	0.66	2.00	3.31	5.51

Jaw & Chuck Mounting Bolts



Chuck Dia.	6-1/4"	8"	10"	12-1/2"
Jaw Mounting Bolts				
Bolt Size	M10X1.5-20	M12X1.75-25	M12X1.75-30	M16X2-30
Code No.	7-789-9065	7-789-9085	7-789-9105	7-789-9125
Chuck Mounting Bolts, Plain Back				
Bolt Size	M10X1.5-75	M12X1.75-90	M12X1.75-100	M16X2-130
Code No.	7-897-1084	7-897-1114	7-897-1272	7-897-1275
Chuck Mounting Bolts, A2 Mount				
Mount	A2-5	A2-6	A2-6	A2-8
Bolt Size	M10X1.5-95	M12X1.75-110	M16X2-120	M16X2-130
Code No.	7-897-1085	7-897-1115	7-897-1273	7-897-1276



6" & 12" (2 pcs. per Jaw)

8" & 10" (1 pc. per Jaw)

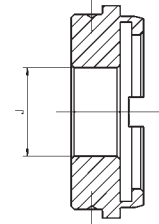
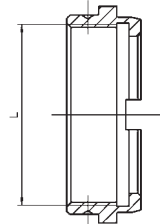
Chuck Dia.	6"	8"	10"	12"
T-Nut Code No.	7-789-906	7-789-908	7-789-910	7-789-912
A	0.6980	0.8071	0.9055	1.1417
B	0.6693	1.8110	2.0079	0.9449
C	0.7087	0.8071	0.8465	1.0236
F	N/A	0.9843	1.1811	N/A
G	0.2953	0.3346	0.3346	0.4134
H (h6)	0.4724	0.5512	0.6299	0.8268
Bolt Size	M10X1.5	M12X1.75	M12X1.75	M16X2

T-Nuts & Bolts sold separately

Draw Bar Nuts

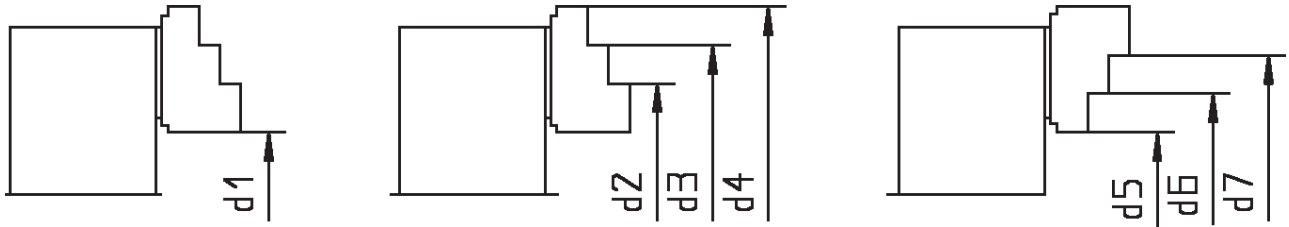
Threaded Nut

Blank Nut



Chuck Dia.	Thread L	Hole Dia. J	Code No.	Length of Nut
6"	M42X1.5	-	7-789-0642	0.276"
	M42X2.0	-	7-789-0644	
	M55X1.5	-	7-789-0652	
	M55X2.0	-	7-789-0654	
8"	BLANK	20mm	7-789-0601	1.063"
	M50X1.5	-	7-789-0852	0.417"
	M50X2.0	-	7-789-0854	
	M55X1.5	-	7-789-0862	
	M55X2.0	-	7-789-0864	
	M60X1.5	-	7-789-0872	
	M60X2.0	-	7-789-0874	
BLANK	30mm	7-789-0801	1.205"	
10"	M60X2.0	-	7-789-1074	0.512"
	M85X1.5	-	7-789-1082	
	M85X2.0	-	7-789-1084	
12-1/2"	BLANK	45mm	7-789-1001	1.299"
	M100X1.5	-	7-789-1292	0.650"
	M100X2.0	-	7-789-1294	
BLANK	50mm	7-789-1201	1.437"	

Clamping Ranges

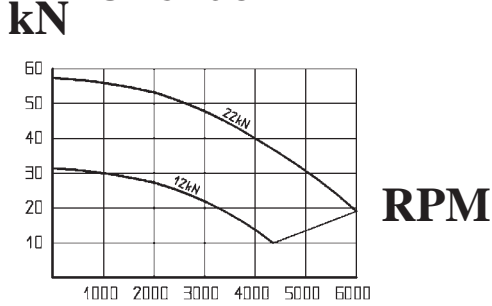


Chuck Dia.	d1	d2	d3	d4	d5	d6	d7
160 mm	17-89	65-137	101-173	138-210	19-91	57-129	93-165
6"	.6692-3.504	2.559-5.394	3.976-6.811	5.433-8.268	.7480-3.583	2.244-5.079	3.661-6.496
210 mm	16-114	74-174	122-224	174-274	22-114	72-162	122-210
8"	.6299-4.488	2.913-6.850	4.803-8.819	6.850-10.787	.8661-4.488	2.835-6.378	4.803-8.268
250 mm	13-136	91-214	156-276	221-342	13-136	77-200	141-264
10"	.5118-5.3543	3.5827-8.4252	6.1417-10.8661	8.7008-13.4646	.5118-5.3543	3.0315-7.8740	5.5512-10.3937
315 mm	41-184	118-261	181-324	246-389	41-184	104-248	168-312
12"	1.6142-7.2409	4.6457-10.2756	7.1260-12.7560	9.6850-15.3150	1.6142-7.2441	4.0945-9.7638	6.6142-12.2835

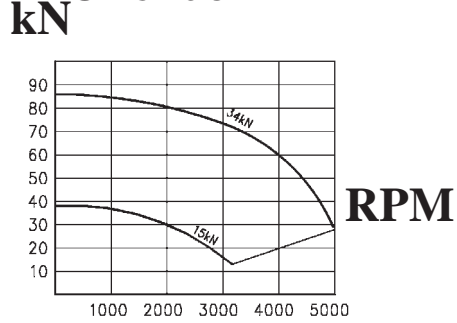
Total Gripping Force and Speed Diagram

The Gripping Force loss was determined on a chuck with BISON Hard Top Jaws.

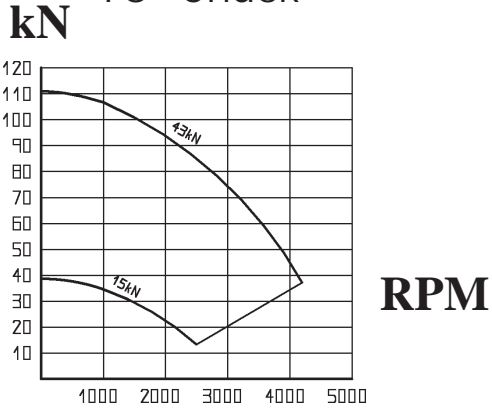
6" Chuck



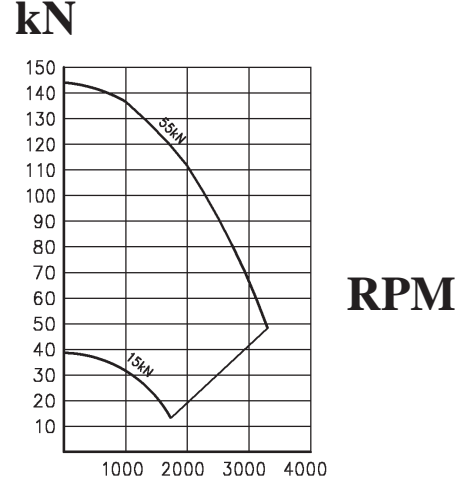
8" Chuck



10" Chuck



12" Chuck



Pneumatic Power Chuck

Self-Contained
with Large Thru-Hole, Steel Body, Plain Back, Wedge Type

Features:

- High clamping force
- Large thru-hole
- Rapid jaw stroke
- Steel body
- High clamping accuracy

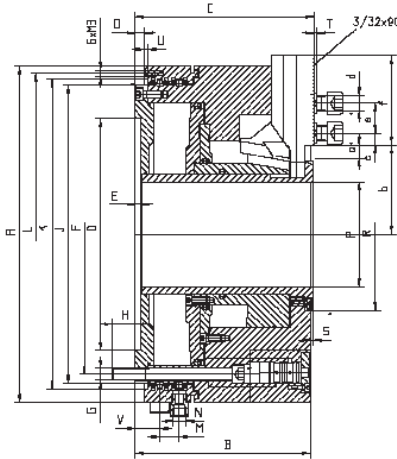
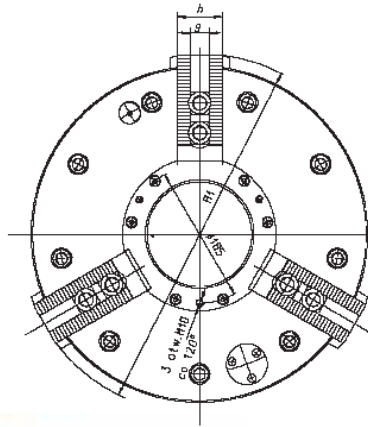
Extended Jaw Stroke

Standard Accessories:

- Hard master jaws
- T-Nuts & bolts

Optional Accessories:

- Hard top jaws
- Soft top jaws
- Adaptor plates



Back view



Chuck Dimensions	inch	mm
Chuck Dia.	15-3/4"	400
Thru Hole P	5.5118	140
A	17.7165	450
A1	19.0157	483
Clamping stroke per Jaw	.7480	7
Rapid stroke per Jaw	.2756	12
Stroke per Jaw	.4724	19
B	9.2126	234
C	9.4094	239
D H6	12.2047	310
E	.3150	8
F	14.7244	374
G	9 x M16	
H	1.1811	30
J	15.7480	400
K H9	16.3386	415
L	16.9291	430
M	1.0236	26
N	G 3/8"	
O	.4724	12
R g6	8.0701	205
S	.1575	4
T	.1378	3.5
U	.1969	5
V	1.2992	33
b min.	3.9370	100
b max.	4.6850	119
c min.	.6102	15.5
c max.	2.6772	68
d	M20	
e	1.5748	40
f	4.7244	120
g H7	1.0040	25.5
h	2.3622	60
Code No	7-785-1600	

Chuck Diameter	Unit	15-3/4" / 400
Operating Pressure (max./min.)	bar	3.5/10
Air Consumption / Jaw Stroke at 5 bar	ltr.	3.7
Total Gripping Force at 5 bar	daN	9000
Maximum Speed	r.p.m.	1300
Moment of Inertia	kgm2	6
Weight without the Top Jaws	lbs.	463

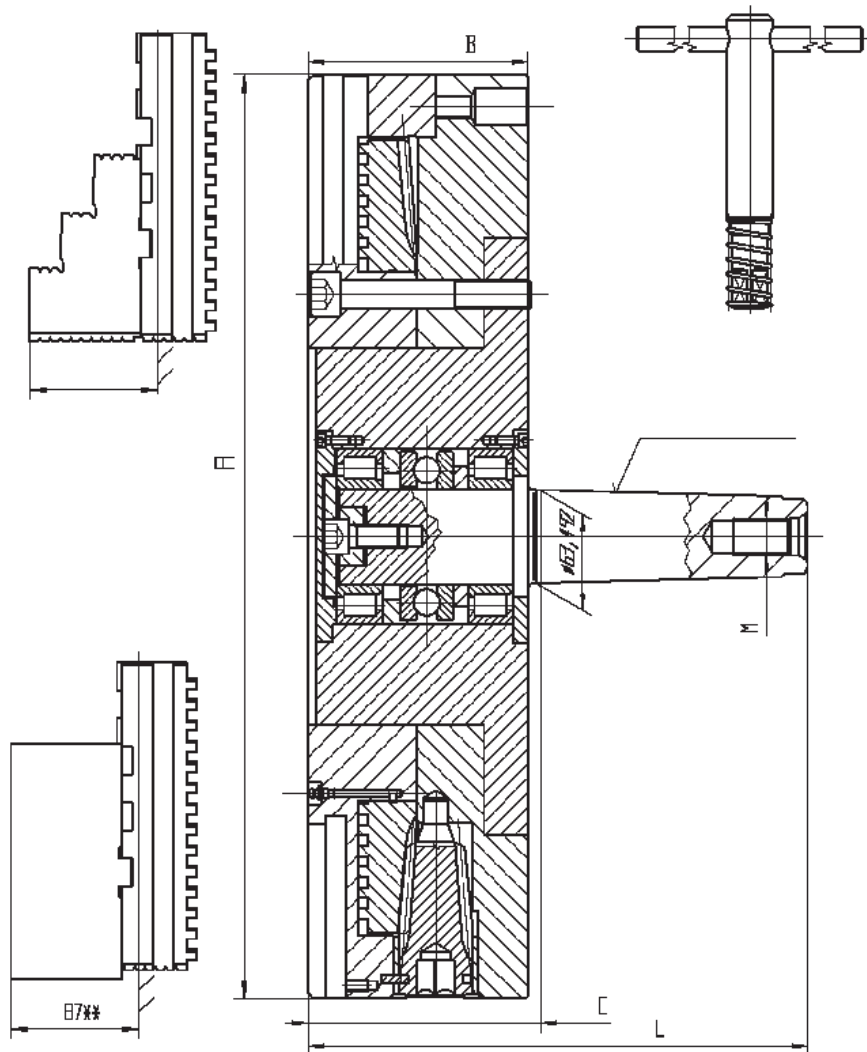
Heavy Duty Rotating Chucks

3 Jaw Self Centering with MT Shank

- These heavy duty rotating chucks are used in tailstock for jobs where lathe centers cannot be used.
- Example - tube machining.
- Forged Steel Body.
- Hardened and ground MT Shank.
- Scroll, pinions and master Jaws are standard BISON parts.
- Chucks are provided with two precision heavy duty roller bearings and one ball thrust bearing.

Standard Accessories:
Set of master jaws with mounting bolts,
Chuck wrench,

Optional Accessories:
Soft top jaws



Type 9188



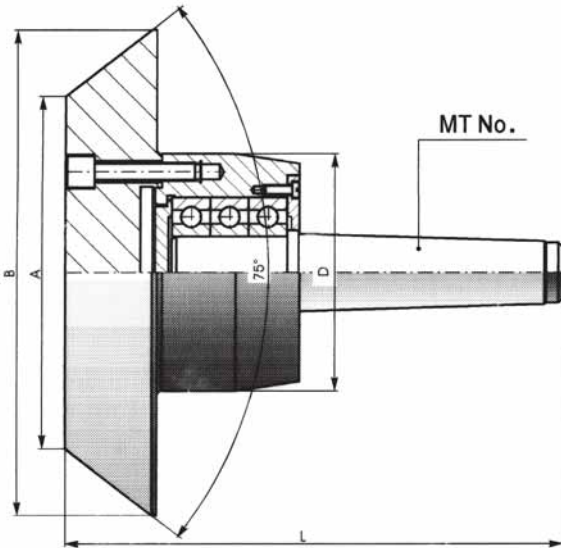
Chuck Dia. A	B	C	L	M	MT No.	RPM Max	Max. Load Capacity lbs.	Weight lbs.	Chuck Code No.	Hard Top Jaws	Soft Top Jaws	Hard Master Jaws	Scroll	Pinion
										Spare Parts Code No.				
12-1/2"	4.91	5.17	10.26	5/8"-11 UNC	5	300	5500	135	7-843-1295	7-883-3120	7-884-312	7-885-312	7-887-512	7-886-512
15-3/4"	5.69	6.00	13.17	1"-8 UNC	6	200	13000	237	7-843-1695	7-883-3160	7-884-316	7-885-316	7-887-516	7-886-516
20"	5.67	6.00	13.17	1"-8 UNC	6	150	13000	410	7-843-2000	7-883-3200	7-884-320	7-885-320	7-887-520	7-886-520
25"	5.91	6.24	13.41	1"-8 UNC	6	80	13000	670	7-843-2500	7-883-3250	7-884-325	7-885-325	7-887-525	7-886-525

Universal Pipe Live Centers

with Interchangeable Heads Triple Bearing Design

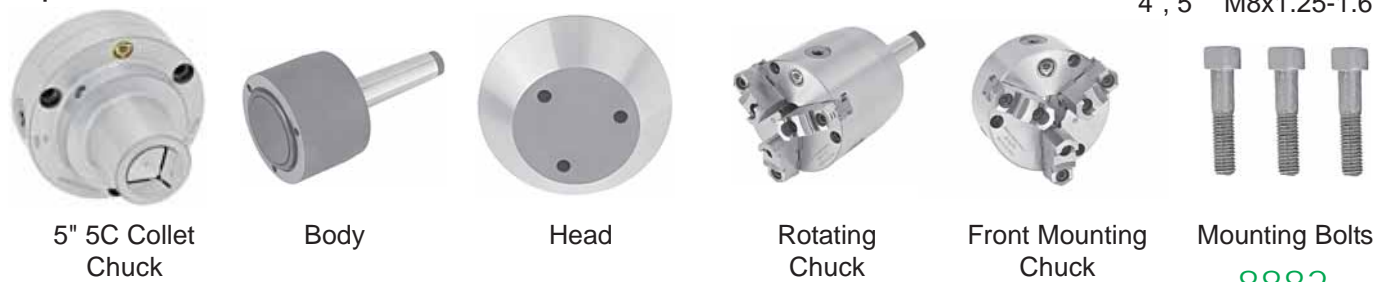
These precision Universal Pipe Live Centers are designed for using with interchangeable tapered heads or with 3", 4" & 5" front mounting, self-centering chucks. All parts are made of steel, hardened and precision ground. All interchangeable parts can be easily replaced.

Bodies, Heads, Chucks & Bolts are sold separately.



Draw Bar
Threads:
MT3 3/8"-16
MT4 1/2"-13
MT5 5/8"-11

Optional Accessories:



8882

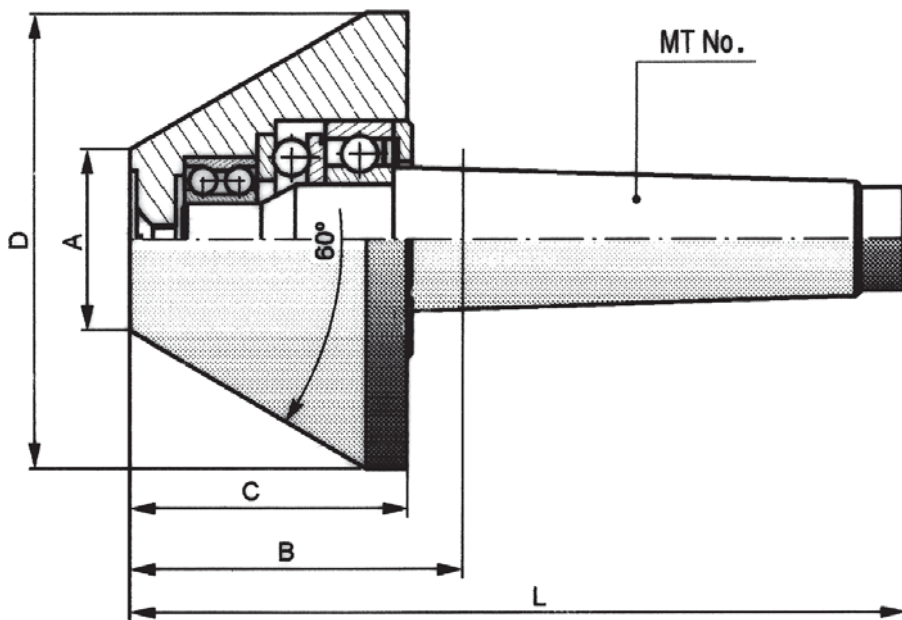
Morse Taper No.	3			4			5		
Size	80/1	80/2	100/1	100/2	100/3	125/2	125/3	125/4	
A	3.74	5.70	3.74	5.70	7.68	5.70	7.68	9.65	
B	5.90	7.87	5.90	7.87	9.84	7.87	9.84	11.81	
D	3.07	3.07	3.86	3.86	3.86	4.84	4.84	4.84	
L	7.09	7.09	8.11	8.11	8.11	9.52	9.52	9.52	
Max. RPM	4000	4000	3500	3500	3500	3200	3200	3200	
Max. weight of workpiece lbs.	1543	1543	2205	2205	2205	3307	3307	3307	
Weight with Head lbs.	13.5	22.5	16.5	25.4	32.6	32.0	41.0	53.0	
Max. Run out	.002	.002	.002	.002	.002	.002	.002	.002	
Body only Code No.	7-573-033			7-573-044			7-573-055		
Head only Code No.	7-573-0301	7-573-0302	7-573-0401	7-573-0402	7-573-0403	7-573-0502	7-573-0503	7-573-0504	
Bolts Code No.	7-573-106			7-573-108					
Chucks Code No.	7-811-0300*			7-811-0400*			7-812-0500*		

Bull Head Live Centers

Triple Bearing Design

Features:

- Three matched bearings are preloaded at the factory. This provides good thrust and radial capabilities.
- The bearings are protected by a special seal.
- The head is made of high carbon alloy steel, heat treated to RC 61-63.
- 60 Degree head angle.
- Centers are designed to hold pipe and hollow work.



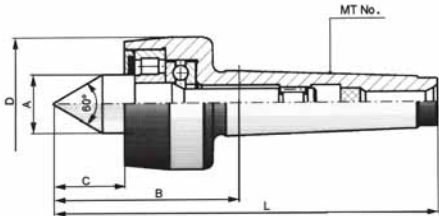
8825

MT No.	1	2	2	3	3	4	4	5	6
D	1.97	2.36	3.15	3.15	3.93	3.93	5.51	6.69	11.50
A	0.79	1.18	1.18	1.18	1.57	1.57	2.76	3.94	7.09
B	1.56	1.60	2.32	2.32	2.64	2.70	3.05	3.05	4.57
C	1.38	1.38	2.09	2.09	2.40	2.40	2.76	2.76	4.21
L	3.66	4.11	4.84	5.51	5.83	6.73	7.09	8.15	11.73
R.P.M.	5000	5000	4500	4500	3000	3000	3000	2000	1000
Max. weight of workpiece lbs.	220	400	660	770	1210	1320	1540	1653	4400
Weight lbs.	.77	1.32	2.76	2.98	5.07	5.62	11.00	17.60	75
Max. run out	.0003	.0003	.0003	.0003	.0003	.0003	.0004	.0008	.002
Code No.	7-575-010	7-575-020	7-575-021	7-575-030	7-575-031	7-575-040	7-575-042	7-575-051	7-575-060

Live Centers

Super Precision & Precision Live Centers

Machined from one piece of forging, hardened and precisely ground. Three precision, high quality bearings are protected by a special steel shield and neoprene seal. Live centers are lubricated with special grease and do not require any additional lubrication.

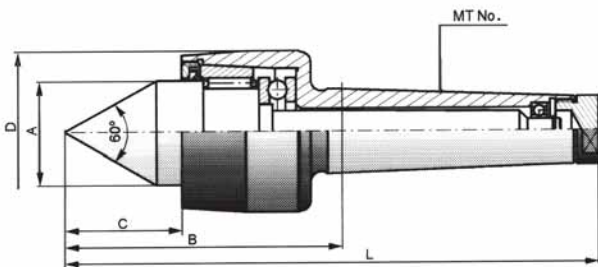


8811

Morse Taper No.	1	2	3	4	5	6
Max. Weight of workpiece Lbs.	220	460	925	1850	4400	7700
D	1.50	1.57	2.20	2.52	3.35	5.12
A	.59	.70	.98	1.10	1.61	2.48
L	4.07	4.74	6.14	7.24	9.33	13.13
C	.70	.87	1.12	1.24	1.77	2.52
B	1.97	2.22	2.95	3.21	4.23	5.96
Max. RPM	5000	5000	4000	3000	2500	2000
Weight Lbs.	.64	1.00	2.13	3.85	8.37	26.43
P Precision Accuracy	.0003	.0003	.0003	.0003	.0004	.0004
Code No.	7-565-001	7-565-002	7-565-003	7-565-004	7-565-005	7-565-006
S Super Precision Accuracy	.0002	.0001	.0001	.0001	.0002	.0002
Code No.	7-565-101	7-565-102	7-565-103	7-565-104	7-565-105	7-565-106

Ultra Precision Adjustable Live Centers Heavy Duty, Triple Bearing Design

Machined from one piece of forging, hardened and precisely ground. Three precision, high quality bearings are protected by a special steel shield and neoprene seal. Adjustable, ultra precision radial bearing reduces run out to minimum after much use.



± 0.00006 T.I.R.

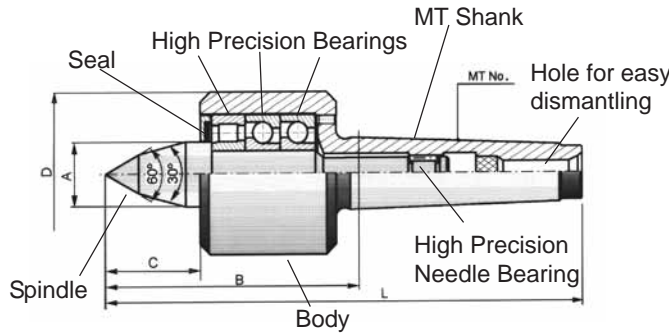


8823

Morse Taper	Max. Weight of Workpiece lbs.	Thrust/lbs. at 1000 R.P.M.	L	L1	L2	D	D1	Max R.P.M.	Weight lbs.	Code No.
2	660	400	5.41	2.87	1.02	1.73	0.91	8000	1.33	7-567-002
3	1320	530	6.53	3.37	1.26	1.89	1.10	6000	1.95	7-567-003
4	2860	770	7.89	3.88	1.69	2.36	1.53	4500	3.62	7-567-004
5	4400	990	9.80	4.70	2.01	2.76	1.77	4000	7.17	7-567-005
6	8800	1580	12.64	5.47	2.44	3.70	2.40	3000	17.20	7-567-006

NC Quad-Bearing Live Centers

Heavy Duty, High Speed: 7000 - 6000 R.P.M.



8814 NC

Morse Taper	Max. Weight of Workpiece lbs.	Max R.P.M.	Max Run out	A	B	C	D	L	Weight lbs.	Code No.
4	2200	7000	.0002"	1.10	4.58	1.91	2.76	8.62	5.50	7-566-004
5	4400	6000	.0002"	1.57	5.87	2.64	3.47	11.00	11.00	7-566-005

Lathe Mandrels Type 8500

These Mandrels are made of hardened steel and are accurately ground to size. Mandrels are slightly tapered with the size marked on the large end. Standard taper .0005" per inch. Sizes under 1" are .0005" undersize on small end. Sizes 1-1/16 to 3" are .001" undersize on small end.

Designed for setting up accurately bored or reamed blanks and castings for pulleys, hand wheels or hubs, on centers so that the outside diameter can be turned concentrically with the axis of the hole in which the mandrel is fixed.

Mandrel Dia.	Overall Length	Code No.
1/8	2-1/2	7-500-005
5/32	3	7-500-010
3/16	3	7-500-015
7/32	3-3/4	7-500-020
1/4	3-3/4	7-500-025
9/32	4	7-500-030
5/16	4	7-500-035
11/32	4-1/4	7-500-040
3/8	4-1/4	7-500-045
13/32	4-1/2	7-500-050
7/16	4-1/2	7-500-055
15/32	5	7-500-060
1/2	5	7-500-065
17/32	5-1/4	7-500-070
9/16	5-1/4	7-500-075
19/32	5-1/2	7-500-080
5/8	5-1/2	7-500-085
21/32	5-3/4	7-500-090

Mandrel Dia.	Overall Length	Code No.
11/16	5-3/4	7-500-095
23/32	6	7-500-100
3/4	6	7-500-105
25/32	6-1/4	7-500-110
13/16	6-1/4	7-500-115
27/32	6-1/2	7-500-120
7/8	6-1/2	7-500-125
29/32	6-3/4	7-500-130
15/16	6-3/4	7-500-135
31/32	7	7-500-140
1	7	7-500-145
1-1/16	7-1/4	7-500-150
1-1/8	7-1/2	7-500-155
1-3/16	7-3/4	7-500-160
1-1/4	8	7-500-165
1-5/16	8-1/4	7-500-170
1-3/8	8-1/2	7-500-175
1-7/16	8-3/4	7-500-180

Mandrel Dia.	Overall Length	Code No.
1-1/2	9	7-500-185
1-9/16	9-1/4	7-500-190
1-5/8	9-1/2	7-500-195
1-11/16	9-3/4	7-500-200
1-3/4	10	7-500-205
1-13/16	10-1/4	7-500-210
1-7/8	10-1/2	7-500-215
1-15/16	10-3/4	7-500-220
2	11	7-500-225
2-1/8	11-1/2	7-500-230
2-1/4	12	7-500-235
2-3/8	12	7-500-240
2-1/2	12-1/2	7-500-245
2-5/8	12-1/2	7-500-250
2-3/4	13	7-500-255
2-7/8	13	7-500-260
3	13	7-500-265



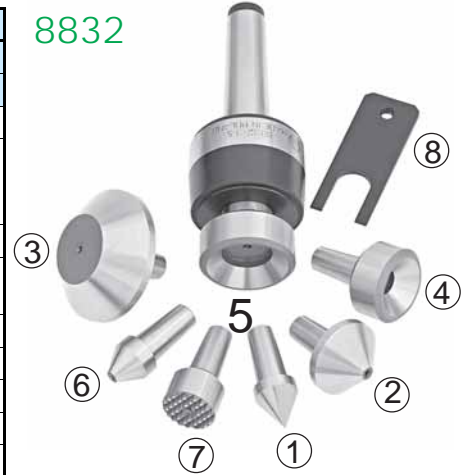
Live Centers

with Interchangeable Inserts

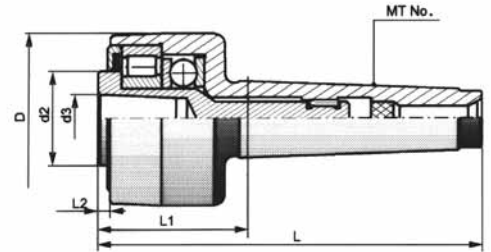
Set is provided with the main body and seven different style inserts in a wooden case. Body of the live center and inserts are made from forgings, hardened and precisely ground. Precision high quality bearings. Special sealing ring protects the bearings from coolant and dust. Inserts are easily interchangeable.

	Morse Taper	#2	#3	#4	#5	#6	
	Set Code No.	7-570-002	7-570-003	7-570-004	7-570-005	7-570-006	
	Body Only Code No.	7-570-102	7-570-103	7-570-104	7-570-105	7-570-106	
	Max R.P.M.	5000	4000	3000	2500	2000	
	Weight without insert approx. lbs.	0.98	2.02	3.71	8.00	25.40	
	Accuracy (inch)	0.0008	0.0008	0.0008	0.0012	0.0012	
	Workpiece weight max. lbs.	220	440	880	1770	3550	
	L	4.055	5.217	6.220	7.815	10.846	
	L1	1.54	2.03	2.19	2.72	3.70	
	L2	0.177	0.197	0.217	0.256	0.256	
	D	1.57	2.20	2.52	3.35	5.12	
	d2	0.71	0.98	1.10	1.61	2.48	
	d3	0.28	0.47	0.59	0.87	1.89	
Interchangeable Tips ONLY!							
8848	#1	*Code No.	7-570-202	7-570-203	7-570-204	7-570-205	7-570-206
		L3	0.75	0.98	1.18	1.46	1.73
		d3	0.28	0.47	0.59	0.87	1.89
		d4	0.59	0.79	0.98	1.26	1.42
8849	#2	*Code No.	7-570-302	7-570-303	7-570-304	7-570-305	7-570-306
		L4	0.51	0.79	0.91	1.10	1.34
		d5	0.87	1.42	1.77	2.20	2.76
		d6	0.12	0.24	0.39	0.55	0.70
8850	#3	*Code No.	7-570-402	7-570-403	7-570-404	7-570-405	7-570-406
		L4	0.51	0.79	0.91	1.10	1.34
		d7	1.50	2.48	2.76	3.15	3.94
		d8	0.71	1.30	1.38	1.50	1.97
8851	#4	*Code No.	7-570-502	7-570-503	7-570-504	7-570-505	7-570-506
		L4	0.51	0.79	0.91	1.10	1.34
		d9	0.87	1.42	1.77	2.20	2.76
		d10	0.71	1.10	1.46	1.73	2.28
8852	#5	*Code No.	7-570-602	7-570-603	7-570-604	7-570-605	7-570-606
		L4	0.51	0.79	0.91	1.10	1.34
		d12	1.18	1.77	2.48	2.76	3.94
		d13	0.98	1.50	2.09	2.36	3.46
8853	#6	*Code No.	7-570-702	7-570-703	7-570-704	7-570-705	7-570-706
		L4	0.51	0.79	0.91	1.10	1.34
		d16	0.049	0.049	0.098	0.098	0.157
		d4	0.59	0.79	0.98	1.26	1.42
8854	#7	*Code No.	7-570-802	7-570-803	7-570-804	7-570-805	7-570-806
		L4	0.51	0.79	0.91	1.10	1.34
		d15	0.71	0.98	1.26	1.77	2.20
		*Code No.	7-570-902	7-570-903	7-570-904	7-570-905	7-570-906
8855	#8	L5	2.36	3.15	3.94	4.72	6.30
		B	0.79	1.18	1.57	1.97	2.36

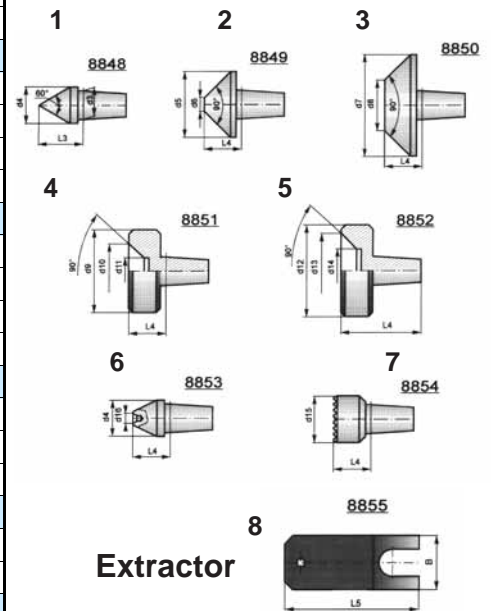
8832



Live Center Body



Interchangeable Inserts



Extractor

Full Dead Centers Half Dead Centers



8712
8710



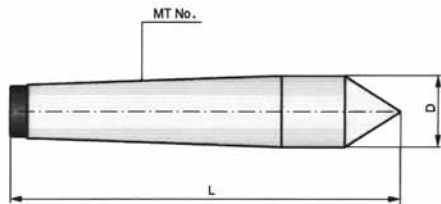
8730



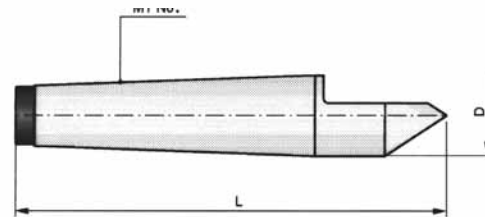
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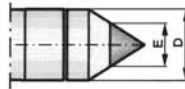
8731



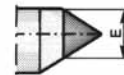
8712
8710



8730



8711



8731

MT No.	L	D	E	Weight Lbs.	Carbon Steel	Carbide Tipped	Ball Bearing Steel	Half	Half Carbide Tipped
					8710 Code No.	8711 Code No.	8712 Code No.	8730 Code No.	8731 Code No.
1	3.15	.48	.28	.13	7-560-005	7-550-005	7-555-005	7-540-001	7-541-001
2	3.94	.71	.28	.44	-	7-550-010	7-555-010	7-540-002	7-541-002
3	4.92	.95	.43	.66	-	7-550-015	7-555-015	7-540-003	7-541-003
4	6.30	1.24	.55	1.5	7-560-020	7-550-020	7-555-020	7-540-004	7-541-004
5	7.87	1.76	.71	4.0	7-560-025	7-550-025	7-555-025	7-540-005	7-541-005
6	10.63	2.51	.71	11.5	7-560-030	7-550-030	7-555-030	7-540-006	7-541-006

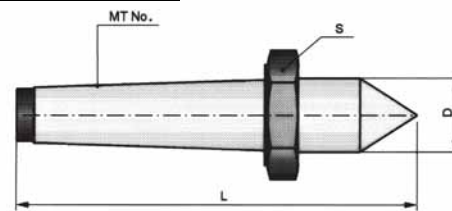
± 0.0001" T.I.R.

Dead Centers with Nut



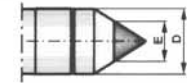
± 0.0001" T.I.R.

L1



8725

MT No.	L	L1	D	E	Weight Lbs.	Alloy Steel	Carbide Tipped	Spare Nut		
						8725 Code No.	8726 Code No.	Wrench Size	Thread Size	Code No.
1	3.54		.48	.28	.22	7-545-001	7-546-001	24 mm	M16 x 1.5	7-545-901
2	4.41		.71	.28	.55	7-545-002	7-546-002	32 mm	M22 x 1.5	7-545-902
3	5.43		.95	.43	1.10	7-545-003	7-546-003	41 mm	M27 x 1.5	7-545-903
4	6.89		1.24	.55	2.43	7-545-004	7-546-004	55 mm	M36 x 1.5	7-545-904
5	8.54		1.76	.71	5.73	7-545-005	7-546-005	75 mm	M48 x 1.5	7-545-905
6	11.42		2.51	.71	14.55	7-545-006	7-546-006	100 mm	M68 x 1.5	7-545-906



8726

- Centers are provided with the Nut.
- Run out between shank and points is accurate to +/-0.0001" T.I.R.
- These dead centers are design for use wherever high accuracies are required.
- Case hardened to 61-63 HRC.
- Carbide tipped centers give longer tool life and require less re-grinding.
- Center 8725 is threaded and provided with the nut to remove the center from a tailstock.

Automatic Face Drivers

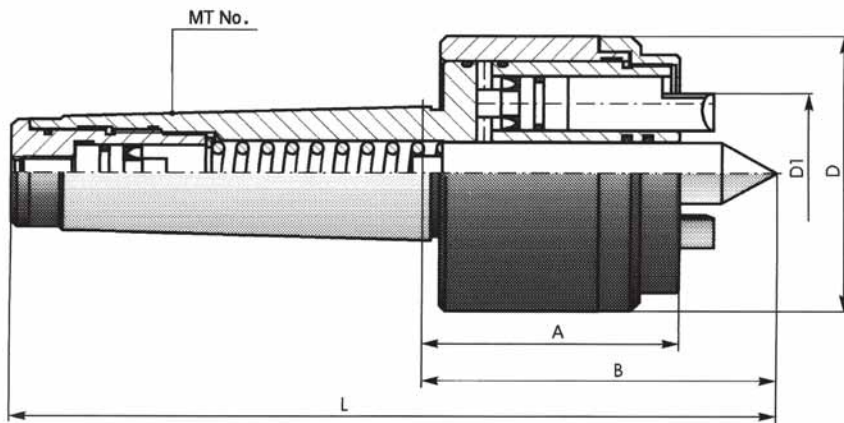
for RH & LH Operations, Type 8410

The ideal holding device for a modern, high production lathe. Specially suited to repetition work. Slim design. All wearable parts hardened and ground. No service required. Spring loaded center. The carrier teeth based on hydroplastic medium adjust automatically to the work piece.



Features:

- Saves setup time! One setting for machining all work pieces.
- Heavier cuts without slippage.
- Higher concentricity and accuracy.
- Most effective driving action even with irregular faces.
- All drive plate components are hardened and ground for long life.
- Complete OD machining in ONE clamping.
- Accurate end location.
- Load and unload automatically.
- Eliminate preliminary machining of end faces.
- Wide range clamping capability.

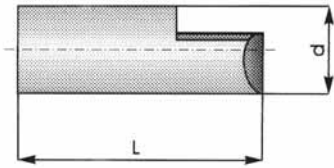


MT Shank	4	4	5	5	5	5
Head Dia. D	2.68	3.19	2.68	3.19	3.54	3.94
Clamping Range D1	1.18-1.97	1.65-3.94	1.18-1.97	1.65-3.94	2.05-4.72	2.56-5.91
Max. Weight of Workpiece Lbs.	121	143	121	141	220	220
Max. Arial Load Lbs.	2204	2645	2204	2645	4409	5511
A	2.52	2.64	2.52	2.64	3.39	3.39
B	3.15	3.31	3.15	3.81	4.45	4.45
L	7.28	7.36	8.35	8.35	9.94	9.94
Weight Lbs.	4.41	5.95	6.61	7.50	11.46	14.33
Face Driver Code No.	7-590-041	7-590-043	7-590-051	7-590-053	7-590-054	7-590-055
Spare Parts						
Drive Pin - Right Code No.	7-590-941R	7-590-943R	7-590-941R	7-590-943R	7-590-954R	7-590-955R
Drive Pin - Left Code No.	7-590-941L	7-590-943L	7-590-941L	7-590-943L	7-590-954L	7-590-955L
Center Code No.	7-590-841	7-590-843	7-590-841	7-590-843	7-590-855	
Spring	7-590-2037				7-590-2044	

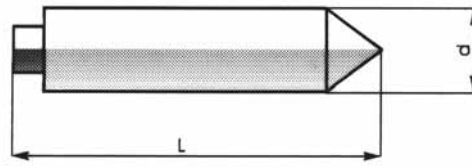
Face Drivers

Drive Pins & Centers for Face Driver Type 8410 Principal Dimensions

Drive Pins



Centers



Taper No.	Clamping Range	d	L	Qty. per set	Left Right	Code No.
4 & 5	1.18 - 1.97	.47	1.02	3	L	7-590-941L
					R	7-590-941R
4 & 5	1.65 - 3.94	.47	1.10	3	L	7-590-943L
					R	7-590-943R
5	2.05 - 4.72	.71	1.89	3	L	7-590-954L
					R	7-590-954R
5	2.56 - 5.91	.79	1.85	3	L	7-590-955L
					R	7-590-955R

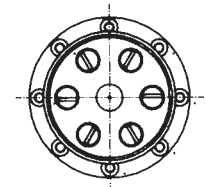
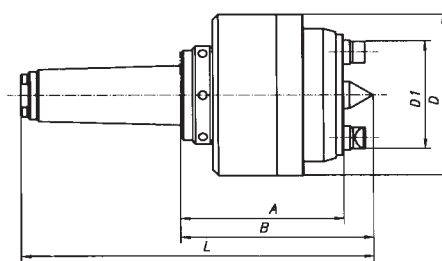
Taper No.	Clamping Range	L	D	Code No.
4 & 5	1.18 - 1.97	3.03	.47	7-590-841
4 & 5	1.65 - 3.94	3.23	.55	7-590-843
5	2.05 - 4.72	4.72	.79	7-590-855
	2.56 - 5.91			

Universal Heavy Duty Automatic RH & LH Face Drivers Type 8411

- Complete OD Machining in ONE clamping.
- Accurate End Location.
- Load and Unload Automatically.
- Eliminate Preliminary Machining of End Faces.
- Wide Range Clamping Capability.



MT Shank	5
Head Dia. D	4.72
Clamping Range	3.30 - 7.87
Max. Weight of Workpiece Lbs.	287
Max. Axial Load Lbs.	6170
D1	3.23
A	4.80
B	5.67
L	10.35
Weight Lbs.	20
Face Driver Code No.	7-591-051
Spare Parts	
Drive Pin Code No.	7-591-951
Center Code No.	7-591-851
Spring & Rod	7-591-751



**5 RH & LH
Driving Pins**

H/V Super Spacers

Horizontal - Vertical

New improved H/V Super Spacer with quick and easy change dividing plates are designed for milling, drilling, jig boring and related machining operations. Fixtures are also used to index parts which are being inspected.

High accuracy, versatility, a wide range of accessories and long life make this fixture invaluable in the work shop and indispensable in the tool room. They significantly increase productivity by reducing the time required to position the work piece on the machine.

- Type 5902 6" & 8"** have a friction bearing,
- Type 5912 12"** has a special heavy duty roller bearing.

New compact design provides a wide variety of dividing:

- a) **Angular Indexing:** can be performed through the graduated ring from 0° to 360° in increments of 1.
- b) **Direct Indexing:** is done by means of a special dividing mechanism, this permits divisions in 2, 3, 4, 6, 8, 12 & 24 without any disassembly operations.
- c) **Special Indexing:** To obtain divisions not listed above, the manufacturer offers an additional quick change dividing plates which can be easily mounted to the super spacer. See table below.

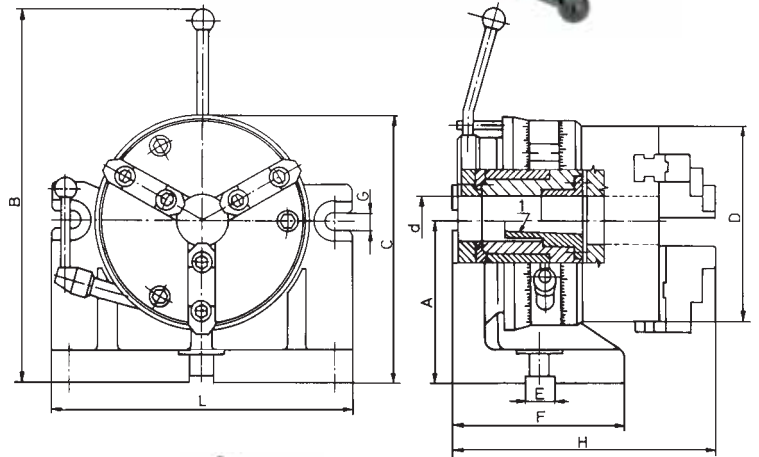
Accuracy

- Maximum total spacing error 2'
- Squareness (base to chuck) .0008" max.
- Parallelism over face .0008" max.
- Chuck concentricity (universal) .0015" T.I.R. max.
- Chuck concentricity (SET-TRU) .0004" T.I.R. max.
- Center hole concentricity .0008" T.I.R. max.
- Mounting flange concentricity .0008" T.I.R. max.

Standard Accessories:

- 2 mounting bolts with T-nuts,
- 2 hex keys, 1 chuck wrench,
- 2 eye bolts and 2 locating keys.

Optional Accessories



Chuck Dia.	A	B	C	D	Thru Hole Dia. D	E	F	G	H	L	Weight lbs.	With Chuck		Without Chuck	
												5902 Code No.	5912 Code No.	Code No.	Code No.
6-1/4"	4.92	11.85	8.27	6.30	1.653	.71	5.51	.55	8.66	9.65	72	7-609-006		7-609-016	
8"	6.30	15.04	10.43	7.87	2.165	.71	6.30	.71	9.72	11.81	127	7-609-008		7-609-018	
12-1/2"	9.84	21.85	16.24	12.40	4.055	.71	7.87	.71	12.24	15.75	317		7-609-012		7-609-022

H/V Super Spacers

Optional Accessories

Optional Dividing Plates
designed for fast and easy replacement

# of Teeth	# of Divisions	6"	8"	12"
		Code No. 7-609-		
24	2, 3, 4, 6, 8, 12, 24	-0701	-0735	-0765
23	23	-0703	-0737	-0767
22	2, 11, 22	-0705	-0739	-0769
21	3, 7, 21	-0707	-0741	-0771
20	2, 4, 5, 10, 20	-0709	-0743	-0773
19	19	-0711	-0745	-0775
18	2, 3, 6, 9, 18	-0713	-0747	-0777
17	17	-0715	-0749	-0779
16	2, 4, 8, 16	-0717	-0751	-0781
15	3, 5, 15	-0719	-0753	-0783
14	2, 7, 14	-0721	-0755	-0785
13	13	-0723	-0757	-0787
0	Soft Blank	-0730	-0760	-0790



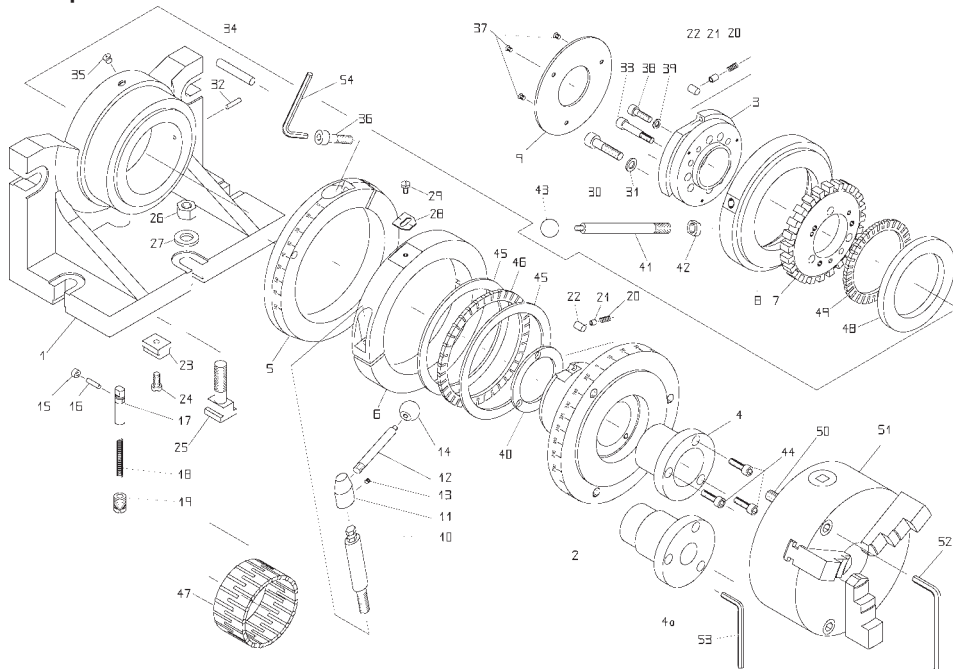
Chuck Dia.	Spacer without Chuck	SET-TRU Adapter	SET-TRU Chucks 3 Jaw	Front Mount Chucks 4 Jaw	SET-TRU Chucks 6 Jaw	Front Mount Chucks 3 Jaw
	Code No.					
6-1/4"	7-609-016	7-609-0677	7-866-0600	7-814-0600	7-868-0600	7-813-0600
8"	7-609-018	7-609-0877	7-866-0800	7-814-0800	7-868-0800	7-813-0800
12-1/2"	7-609-022	7-609-1277	7-866-1200	7-814-1200	7-868-1200	7-813-1200



ChuckDia.	Tailstock	Face Plate	MT Sleeve	5C Collet Chuck	MT Shank Adapter	MT Shank Adapter SET-TRU	5C Shank Adapters Finished	5C Shank Adapters Soft
	Code No.							
6-1/4"	7-610-106	7-610-506	MT 3	7-609-0426	7-609-6006	7-913-503	7-914-043	
8"	7-610-108	7-610-508	MT 4	7-609-0428	7-609-6008	7-913-504	7-914-044	7-910-606
12-1/2"	7-610-112	7-610-512	MT 5	7-609-0429	-	7-913-605	-	7-909-306

Super Spacers

Replacement Parts for 5902 & 5912



No.	Part Description	Size of Super Spacer		
		6" Code No.	8" Code No.	12" Code No.
1	Base	7-609-0106	7-609-0108	7-609-0112
2	Spindle	7-609-0206	7-609-0208	7-609-0212
3	Driving Plate	7-613-0306	7-613-0308	7-613-0312
4	Sleeve	7-613-0406	7-613-0408	7-613-0412
4a	MT Sleeve	7-613-0416	7-613-0418	7-613-0422
5	Indexing Collar	7-609-0506	7-609-0508	7-609-0512
6	Clamping Collar	7-609-0606	7-609-0608	7-609-0612
7	Dividing Plate*	7-609-0701	7-609-0735	7-609-0765
8	Driving Collar	7-609-0806	7-609-0808	7-609-0812
9	Back Cover	7-609-0906	7-609-0908	7-609-0912
10	Clamping Bar	7-613-0706	7-613-0708	7-613-0712
11	Head	7-613-0806	7-613-0808	7-613-0812
12	Handle	7-613-0906	7-613-0908	7-613-0912
13	Set Screw	M4X0.7X5	M6X1X6	M6X1X6
14	Handle Ball	7-613-2406	7-613-2408	7-613-2412
15	Roller Pin	7-613-1406	7-613-1408	7-613-1412
16	Pin	7-613-1306	7-613-1308	7-613-1312
17	Click Pin	7-613-1206	7-613-1208	7-613-1212
18	Spring	7-613-1806	7-613-1808	7-613-1812
19	Screw	M12X1.75X16	M16X2X23	M20X2.5X60
20	Brake Spring	7-613-1906		
21	Brake Sleeve	7-613-1506		
22	Brake Roller	7-613-2306		
23	Key & Screw	7-613-2906	7-613-2908	7-613-2912
24	Key Screw	M6X1X14	M6X1X14	M6X1X14
25	T-Bolt	7-613-2206	7-613-2208	7-613-2212
26	T-Bolt Nut	7-613-2706	7-613-2708	7-613-2712
27	T-Bolt Washer	7-613-2506	7-613-2508	7-613-2512

No.	Part Description	Size of Super Spacer		
		6" Code No.	8" Code No.	12" Code No.
28	Marking Plate	7-609-2806	7-609-2808	7-609-2812
29	Set Screw	M5X0.8X8	M5X0.8X8	M5X0.8X8
30	Bolt	M8X1.25X35	M10X1.75X40	M16X2X65
31	Washer	7-609-3106	7-609-3108	7-609-3112
32	Pin	7-613-3306	7-613-3308	7-613-3312
33	Bolt	M6X1X41	M6X1X46	M10X1.5X75
34	Dividing Pin	7-613-3506	7-613-3508	7-613-3512
35	Grease Nipple	N/A	N/A	N/A
36	Bolt	M8X1.25X30	M10X1.75X40	M12X1.75X60
37	Cover Screws	7-613-2806		
38	Bolt	M6X1X20	M8X1.25X20	M12X1.75X35
39	Washer	7-609-3906	7-609-3908	7-609-3912
40	Washer	7-609-4006	7-609-4008	7-609-4012
41	Driving Handle	7-613-4406	7-613-4408	7-613-4412
42	Locking Nut	7-613-4606	7-613-4608	7-613-4612
43	Ball	7-613-2406	7-613-2408	7-613-2412
44	Cap Screws	M6X1X20	M8X1.25X20	M8X1.25X20
45	Bearing Discs	N/A	N/A	7-609-945
46	Bearing	N/A	N/A	7-609-946
47	Bearing	N/A	N/A	7-609-947
48	Bearing Discs	N/A	N/A	7-609-948
49	Bearing	N/A	N/A	7-609-949
50	Chuck Bolts	M10X1.5X70	M10X1.5X80	M20X2X100
51	Chuck	7-813-0600	7-813-0800	7-813-1200
52	Hex Key	6-999-588		6-999-594
53	Hex Key	6-999-585	6-999-586	
54	Hex Key	6-999-586	6-999-588	6-999-590

Rotary Tables

Horizontal - Vertical Type 5859 Low Profile

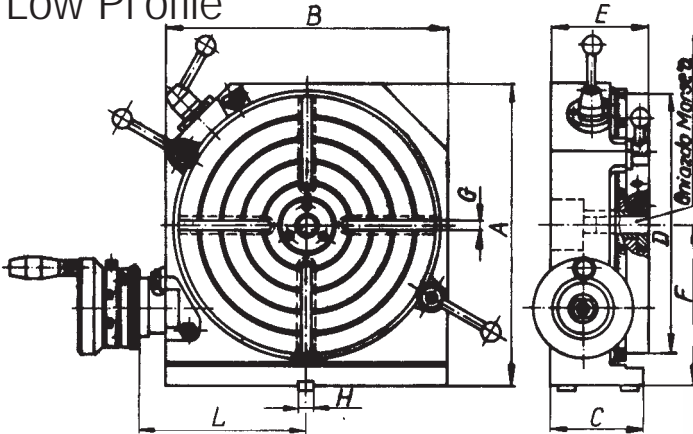


Table with mounted
Dividing Plate and
Handle



Features:

- Tables can be used horizontally and vertically.
- Rigid, low profile, compact design provides for three types of dividing:
 - 1) **Angular indexing:** can be performed through the graduated ring from **0° to 360°** in increments of 1.
 - 2) **Rapid indexing:** is done by means of a special dividing mechanism in divisions **2, 3, 4, 6, 8, 12 & 24** without any disassembly operations.
 - 3) **Indexing** with the set of special **dividing plates**.
- Disengage-able worm gear permits direct and rapid indexing.
- The table body is made of semi-steel.

Accuracy:

Parallelism of clamping surface to base .0008"
 Flatness of clamping surface .0008"
 True running of MT center hole .0004"
 Squareness of clamping surface to base .0008"
 Indexing accuracy 1'

Table with
mounted
Crank Wheel



Standard Accessories:

- a) Two mounting bolts with nuts, Crank Wheel and three dividing plates with 1 handle.
- b) Two mounting bolts with nuts & Crank Wheel.

Optional Accessories:



Table Size	A	B	C	D	H	F	G	E	L	Worm Ratio	Thru Holes	Center Hole, MT	Weight lbs.	Code No. with Plates	Code No. without Plates
6"	8.9	7.9	3.54	6.3	0.551	4.92	0.394	3.78	5.00	1:60	.827	3	44	7-621-006	7-621-0060
8"	10.6	9.5	3.74	7.87	0.551	5.91	0.394	3.86	5.79	1:60	1.378	3	55	7-621-008	7-621-0080
10"	12.5	11.2	4.53	9.84	.709	6.89	.472	4.52	6.89	1:90	1.378	3	121	7-621-010	7-621-0100
12"	14.7	13.7	4.53	12.6	.709	7.87	.472	4.72	8.15	1:90	1.417	3	176	7-621-012	7-621-0120
16"	18.3	16.9	4.92	15.7	.709	9.84	.551	5.31	9.76	1:90	1.969	4	269	7-621-016	7-621-0160
20"	22.9	21.1	6.69	19.7	.709	12.4	.630	6.89	12.2	1:120	2.559	5	573	7-621-020	7-621-0200

Sets of Dividing Plates with Handle - Specification

Table Size	Number of Divisions (Holes)			Set Code No.
	Plate No. I	Plate No. II	Plate No. III	
6" & 8"	23, 25, 28, 34, 36, 38, 44	21, 26, 29, 32, 33, 39, 43	20, 24, 27, 31, 36, 37, 41	7-622-008
10", 12", 16"	24, 25, 26, 28, 32, 34, 38, 44, 46	16, 17, 19, 21, 29, 33, 39, 43, 49	15, 18, 20, 23, 27, 31, 37, 41, 47	7-622-016
20"	24, 25, 28, 34, 38, 39, 44, 46, 49	21, 29, 32, 33, 43, 53, 59, 61, 63	15, 26, 27, 31, 36, 37, 41, 47, 65	7-622-020



Sets are provided with three Dividing Plates and one Handle

5C Super Spacers

5C Collet H/V Superspacer Type 5824 Chucks & 5C collets not included

5C H/V Super Spacers are designed for milling, drilling, jig boring and related machining operations. Fixtures are also used to index parts which are being inspected. High accuracy, versatility, a wide range of accessories and long life make this fixture invaluable in the work shop and indispensable in the tool room.

They significantly increase productivity by reducing the time required to position the work piece on the machine without additional setting.

Simple and compact design provides for two types of indexing:

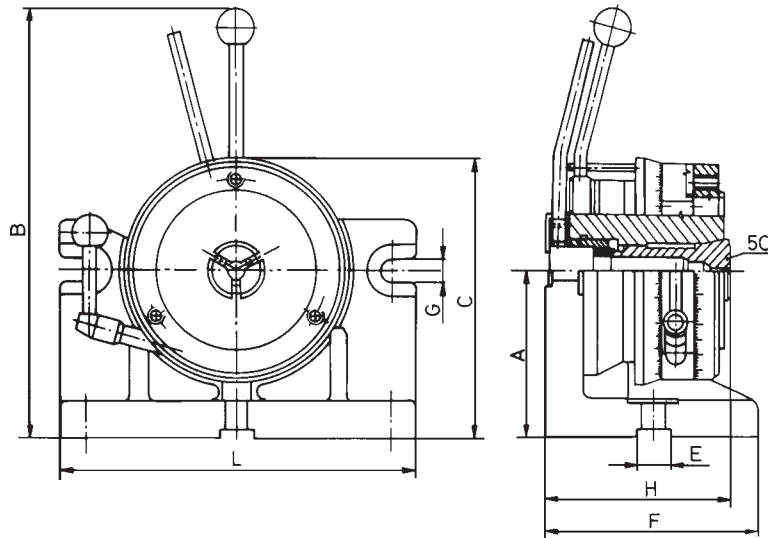
- a) **Angular indexing:** can be performed through the graduated ring from 0° to 360° in increments of 1°.
- b) **Direct indexing:** is done by means of a special dividing mechanism. This permits divisions in **2, 3, 4, 6, 8, 12 & 24** without any disassembly operations.

Accuracy:

- Maximum total spacing error 2'
- Squareness (base to chuck) .0008" max.
- Parallelism over face .0008" max.
- Chuck concentricity .0006" T.I.R.
- Center hole concentricity .0008" T.I.R.
- Mounting flange concentricity .0008" T.I.R.

Standard Accessories:

2 mounting bolts with T-nuts,
2 locating keys, 1 allen wrench.



Optional Accessories:



7-811-0500



7-812-0500



7-814-0500



5C Collets 7-168-



5C adapter with soft flange. 7-909 Series.



7-610-104



5C adapter with mounted quick clamping chuck. 7-910 & 7-869 Series.



5824 5818

Chuck Dia.	A	B	C	D	E	H7	F	G	H	L	Weight lbs.	Spacer Code No.	Tailstock Code No.	Chuck Mounting Bolts Code No.
5"	3.94	10	6.59	4.92	.55		5.12	.55	4.33	8.46	31	7-612-004	7-610-104	7-897-1055

5C H/V Super Spacer

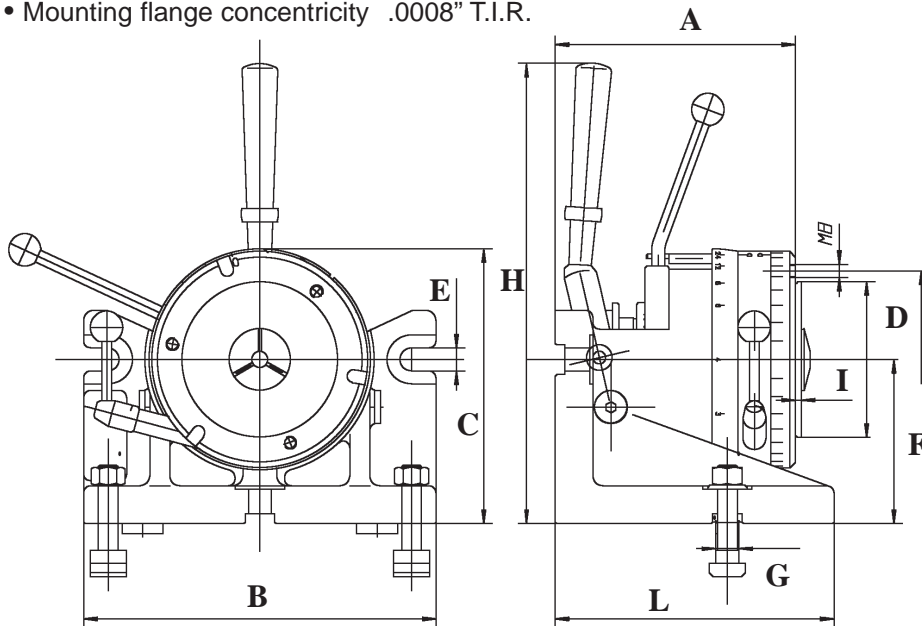
Quick Clamping Type 5825

New 5C H/V Super Spacers Lever Operated are designed for milling, drilling, jig boring and related machining operations. Fixtures are also used to index parts which are being inspected. High accuracy, versatility, a wide range of accessories and long life make this fixture invaluable in the work shop and indispensable in the tool room. The quick clamping lever operated mechanism significantly increases productivity by reducing the time required to grip and release work piece as well as position the work piece on the machine without additional setting. Simple and compact design provides for 2 types of indexing:

- a) **Angular indexing:** can be performed through the graduated ring from 0 to 360° in increments of 1°.
- b) **Direct indexing:** is done by means of a special dividing mechanism. This permits divisions in **2, 3, 4, 6, 8, 12 & 24** without any disassembly operations.

Accuracy:

- Maximum total spacing error 2'
- Squareness (base to chuck) .0008" max.
- Parallelism over face .0008" max.
- Chuck concentricity .0006" T.I.R.
- Center hole concentricity .0008" T.I.R.
- Mounting flange concentricity .0008" T.I.R.



Optional Accessories:



Standard Accessories:

- 2 mounting bolts with T-Nuts
- 2 locating keys, 1 hex key.
- Chucks & 5C Collets not included.**



5825 5818

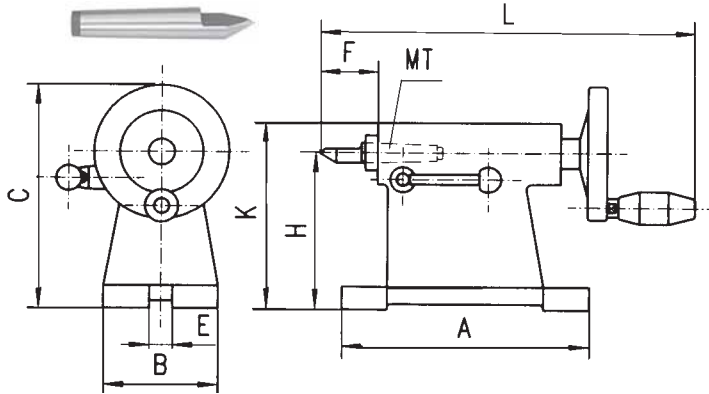
Chuck Mounting Bolts Code No. 7-897-1065

Chuck Dia.	A	B	C	D k6	E	F	G h6	H	I	L	Spacer Code No.	Tailstock Code No.
5"	5.768	8.465	7.382	3.7402	0.5512	3.937	0.5512	11.063	0.138	6.693	7-601-005	7-610-104

Tailstocks

For H/V Super Spacers

Tailstocks are designed for use with the BISON H/V Super Spacers. Rigid and precision design. They are provided with a precision dead center with .0002" T.I.R., two locating keys and two mounting bolts with T-nuts. For optional centers see Page 85.



5" Super Spacer

5818

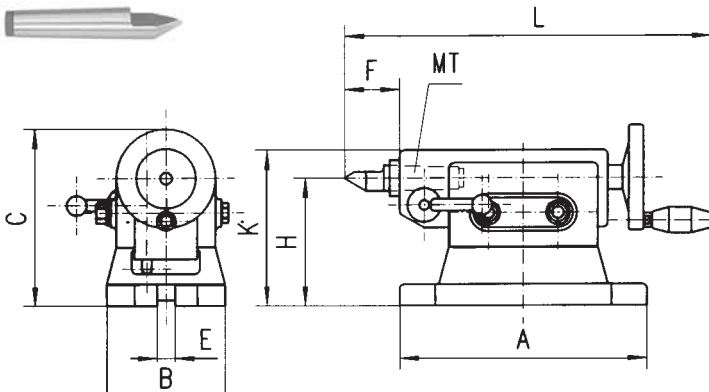


6", 8" & 12" Super Spacer

Size of Super Spacer	H +.002"	K	B	A	F		L	Key Size E	MT No.	Weight lbs.	Tailstock Code No.	Dead Centers Code No.
					min.	max.						
5"	3.937	5.51	3.15	7.68	1.3	2.48	11.77	0.55	2	14	7-610-104	7-540-002
6-1/4"	4.921	7.01	3.54	7.68	1.54	2.72	12.40	0.55	2	16	7-610-106	7-540-002
8"	6.299	8.39	4.53	9.84	1.89	3.35	14.41	0.71	3	28	7-610-108	7-540-003
12-1/2"	9.843	11.93	5.91	11.02	2.34	3.92	16.54	0.71	4	51	7-610-112	7-540-004

Adjustable Tailstocks

Adjustable Tailstocks are designed for use with H/V Super Spacers or any Rotary Tables. Precision, rigid design. Tailstocks are adjustable in two directions (all F and H). They are provided with a precision dead center with .0002" T.I.R., two locating keys and two mounting bolts with T-nuts. For optional centers see Page 85.



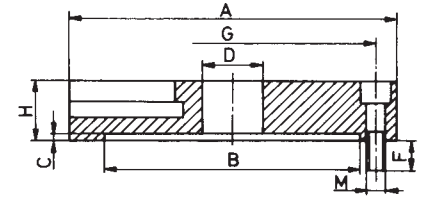
5819



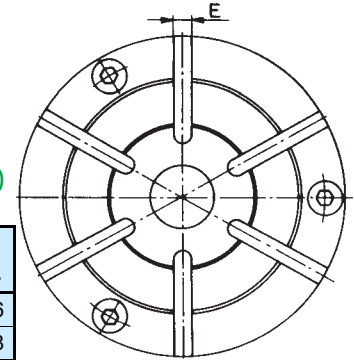
H min.-max.	F min.-max.	L	K max.	B	E (H7)	C max.	MT No.	Weight lbs.	Code No.	Dead Centers Code No.
3.74-5.12	1.57-2.76	13.19	6.10	3.94	.55	7.2	2	26.5	7-610-806	7-540-002
5.12-6.69	1.97-3.54	16.10	7.87	4.72	.71	8.8	3	41.5	7-610-808	7-540-003
6.69-7.87	1.97-3.54	17.05	9.06	5.59	.71	10	3	56.0	7-610-810	7-540-003
8.66-9.84	2.36-3.94	18.31	11.22	6.46	.71	12	4	95.0	7-610-816	7-540-004

Face Plates

Face Plates are designed for use with Bison H/V Super Spacers. They can also be mounted with an adapter plate on any lathe spindle nose.



9440



Dia. A	H	B	D	G [+.008]	M	F	T-Slot		J [+.008]	Weight lbs.	Plate Code No.
							E	Bolt			
6-1/4"	1.18	4.921	1.18	0.157	M10x1.5	0.59	.47	3/8"	5.512	8.6	7-610-506
8"	1.38	6.299	1.57	0.197	M10x1.5	0.59	.55	1/2"	6.929	12	7-610-508
10"	1.97	7.874	1.97	0.197	M12x1.75	.87	.71	5/8"	8.819	26.7	7-610-510
12-1/2"	1.97	10.236	1.97	0.197	M16x2	1.02	.71	5/8"	11.260	43	7-610-512

5C Precision Indexing

Fixtures, T.I.R 0.0004"

5801

Weight lbs.	Code No.
15.0	7-600-010

- Ideal for Surface Grinders, Milling Machines, Drill Presses as well as Inspections.
- Spindle hardened and ground to 0.0004" T.I.R.
- Base ground parallel to spindle socket.
- Hardened and ground indexing plate with 36 ground holes for direct indexing in 10° increments and graduations in 5° increments.
- 10 vernier holes for 1° indexing.
- Center height 2-3/4".
- Base sides ground parallel to spindle axis.
- Accuracy of dividing 10'.



Optional Accessories:



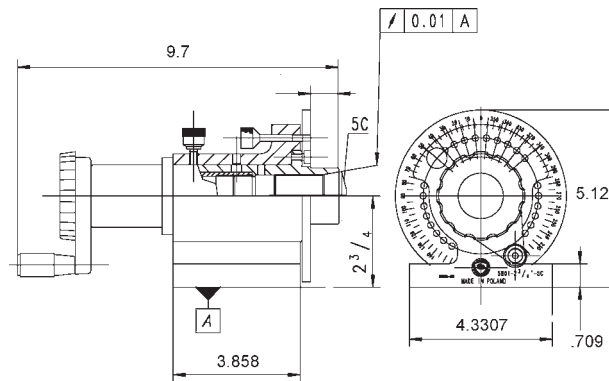
5C Collets
7-168-



5C Adapters
7-910-



Quick Clamping
Chucks 7-869-



Base Plates

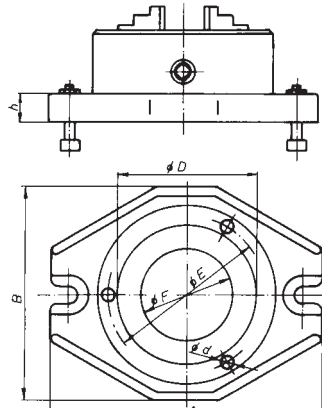
for Back Mount ONLY

9450

9452

Chuck Size	A	B	h	Weight lbs.	Plate for Universal Chucks				Plate for SET-TRU Chucks			
					D	E	F	Code No.	D	E	F	Code No.
6-1/4"	9.84	7.48	1.10	10.3	4.9213	5.5118	3.543	7-630-006	3.386	5.5118	2.36	7-630-606
8"	11.81	9.21	1.26	16.2	6.2992	6.9291	5.118	7-630-008	4.331	6.9291	2.76	7-630-608
10"	13.94	11.50	1.26	25.0	7.8740	8.8189	5.787	7-630-010	5.708	8.8188	3.94	7-630-610
12-1/2"	16.77	14.25	1.57	35.5	10.2362	11.2598	6.690	7-630-012	7.087	11.2598	4.72	7-630-612
15-3/4"	20.47	17.72	1.89	51.2	12.9921	14.2519	6.693	7-630-016	11.750	6.7500	4.72	7-630-616

These Base Plates are designed for use with BISON 2, 3 & 4 Jaw, Self-Centering Plain Back Lathe Chucks (**Back Mount ONLY**) with a semi-steel or forged steel body as well as 2, 3, 4 & 6 Jaw SET-TRU Chucks. They are ideal for milling and drilling operations. Base Plates are supplied with two mounting bolts with T-nuts, two T-Slot keys & chuck wrench with sliding T-Bar. Chucks are sold separately.



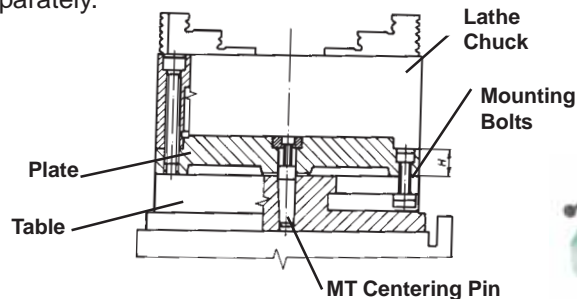
for Front & Back Mount

8293

8298

Chuck Dia.	Pin		Bolts		Plate for Universal Chucks			Plate for SET-TRU Chucks		
	MT	Code No.	Code No.	H	Weight lbs.	Code No.	H	Weight lbs.	Code No.	
5"	2	7-872-932	7-872-905	0.57	3.8	7-872-305	0.57	3.9	7-872-605	
6-1/4"	3	7-872-933	7-872-906	0.65	5.5	7-872-306	0.69	11.5	7-872-606	
8"	3	7-872-933	7-872-906	0.77	7.7	7-872-308	0.77	16.8	7-872-608	
10"	3	7-872-933	7-872-910	0.81	12.9	7-872-310	0.81	27.4	7-872-610	
12-1/2"	3	7-872-933	7-872-910	1.00	23.9	7-872-312	1.00	46.3	7-872-612	
15-3/4"	4	7-872-934	7-872-916	1.08	40.32	7-872-316	1.18	40.0	7-872-616	

These Base Plates are designed for use with BISON 2, 3 & 4 Jaw, **Front Mounting & Back Mounting** Self-Centering, Lathe Chucks and 2,3, 4 & 6 Jaw SET-TRU Lathe Chucks. Ideal for use on milling and drilling machines as well as on rotary tables with 3/6 & 4/8 slots. Base Plates are supplied with four mounting bolts with T-nuts and one MT centering sleeve. Chucks are sold separately.



4 Jaw Self-Centering Machine Fixtures

Low Profile Forged Steel Body
Rectangular Base

9419

Size	A	Q	B	K	C	D	E	E1	F	G	H	M=P	S	T	Clamping Range		lbs.	Code No.
															OD	ID		
6-1/4"	8.46	6.50	2.48	1.69	.709	1.772	.5512	.7087	.980	.433	2.64	5.669	.55	1.65	.1181-6.30	1.65-5.75	35	7-640-006
8"	9.84	7.87	2.84	1.77	.709	2.3622	.5512	.7087	1.06	.551	3.15	6.850	.55	2.17	.1575-7.48	1.97-7.84	51	7-640-008
10"	12.2	9.84	3.27	2.05	.846	3.150	.7087	.7087	1.25	.630	3.74	8.583	.71	2.99	.1968-9.84	2.28-9.25	81	7-640-010
12"	15.0	12.4	3.63	2.24	.913	4.1339	.7087	.7087	1.36	.709	4.33	10.79	.71	4.06	.1968-12.4	2.56-10.4	133	7-640-012

Features:

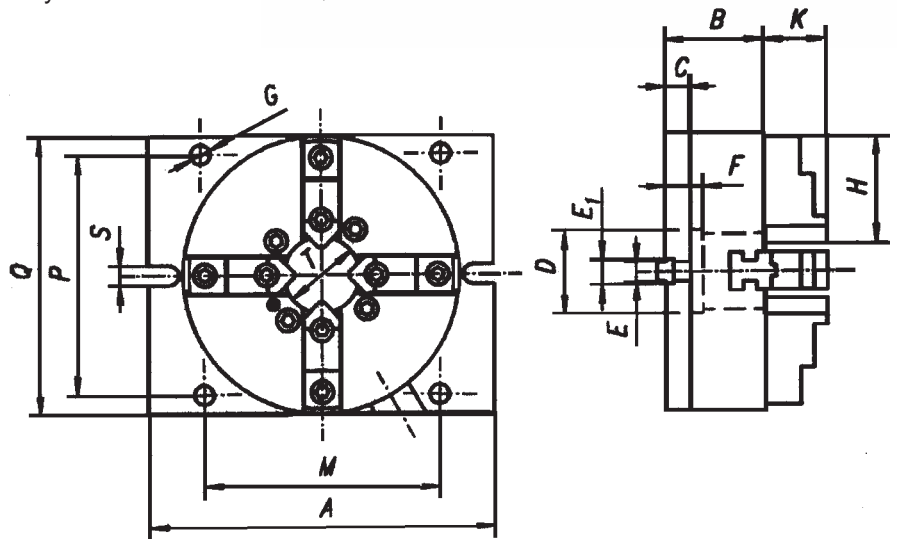
- Ideal for all types of milling, grinding, drilling and tapping operations on vertical and horizontal CNC machines and conventional milling and grinding machines.
- All surfaces are hardened and precision ground, square and parallel to an accuracy of 0.0008".
- Precision, steel body, 4 Jaw, BISON scroll chuck guarantees repeatability within 0.0004".
- American standard Two-Piece Tongue & Groove jaws.
- Soft top jaws are available.
- Ideal for pallet applications.

Standard Accessories:

1 Set of Two-piece reversible jaws (hard top & hard master jaws), 1 Ratchet wrench, 1 angled wrench, set of 2 mounting bolts with T-nuts & two T-Slot keys.

Optional Accessories:

Soft Top Jaws 7-884- Series.



Spare Parts

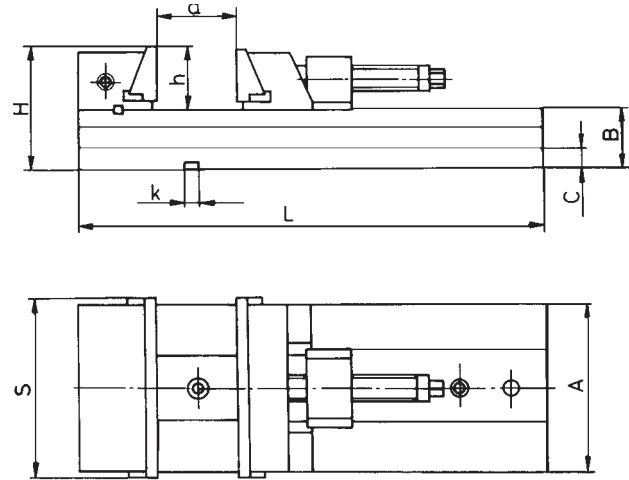
Chuck Size	6"	8"	10"	12"
Hard Top Jaws	7-883-406	7-883-408	7-883-410	7-883-412
H. Master Jaws	7-885-406	7-885-408	7-885-410	7-885-412
Scrolls	7-887-506	7-887-508	7-887-510	7-887-512
Pinions	7-886-506	7-886-508	7-886-510	7-886-512
Angled Wrench	7-640-908		7-640-910	
Ratchet Wrench	7-640-926	7-640-928	7-640-930	7-640-935
Mounting Bolts	7-640-948		7-640-950	

American Standard Two-Piece Tongue & Groove Jaws.

Modular Precision Vises

Type 6566

- High accuracy - all surfaces are hardened and precision ground square and parallel to an accuracy of 0.0012" Jaws and 0.0008" Base.
- Forged steel body.
- Low profile pull-down jaws.
- This design eliminates clamping deflection. It can be opened very wide and provides strong clamping power.
- Ideal for all types of milling, grinding, drilling and tapping operations on vertical and horizontal CNC machines.
- Vises have a modular design. They can be combined with other modules to meet your needs.
- V-Groove Jaw Inserts are available.



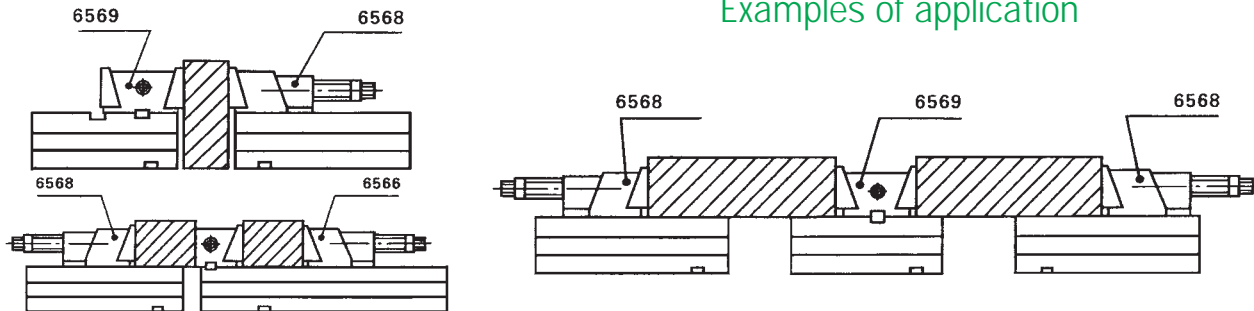
Width of Jaws S	A	B	C	H	L	a max.	h	k H7	Max. Clamping Force Lbs.	Weight Lbs.	Vise 6566 Code No.	Handle Code No.	Clamps Code No.
4	3.35	1.38	.51	2.76	12.60	6.30	1.38	.4724	4410	20	7-223-040	7-223-905	7-223-940
5	4.13	1.65	.59	3.35	13.20	6.30	1.69	.4724	6614	29	7-223-050		7-223-950
6	5.51	2.05	.71	4.29	16.70	7.87	2.24	.7874	9040	62	7-223-060	7-223-908	7-223-960
					18.70	9.84				66	7-223-062		7-223-980
8	6.50	2.40	.79	4.96	21.20	9.84	2.56	.7874	9920	106	7-223-080	7-223-908	7-223-980
					23.00	11.81				110	7-223-082		
					25.00	13.78				115	7-223-085		

Optional Accessories:

Size of Vise	Base 6586 Code No.	Module 6568 Code No.	Module 6569 Code No.
4	7-223-540	7-223-124	7-223-144
5	7-223-550	7-223-125	7-223-145
6	7-223-560	7-223-126	7-223-146
8	7-223-580	7-223-128	7-223-148



Examples of application



Precision Milling Machine

Vises for CNC Machines

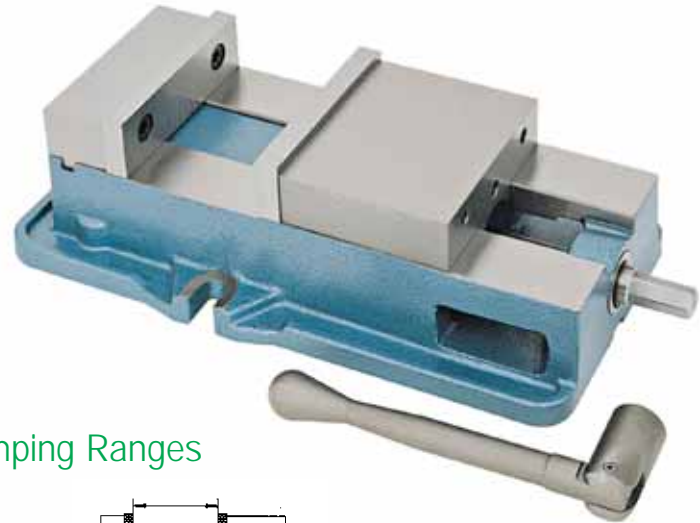
6523

Width of Jaws S	A	B	C	D (H7)	E	F	G	H	L	a	h	u	w	Weight lbs.	Swivel Base Code No.	Code No.
6"	8.90	8.27	3.56	.69	6.69	16.85	2.87	4.35	18.58	7.68	1.73	.94	3.87	76	7-220-960	7-220-006

The Bison Milling Machine Vise maintains the highest standards for accuracy, durability and clamping force.

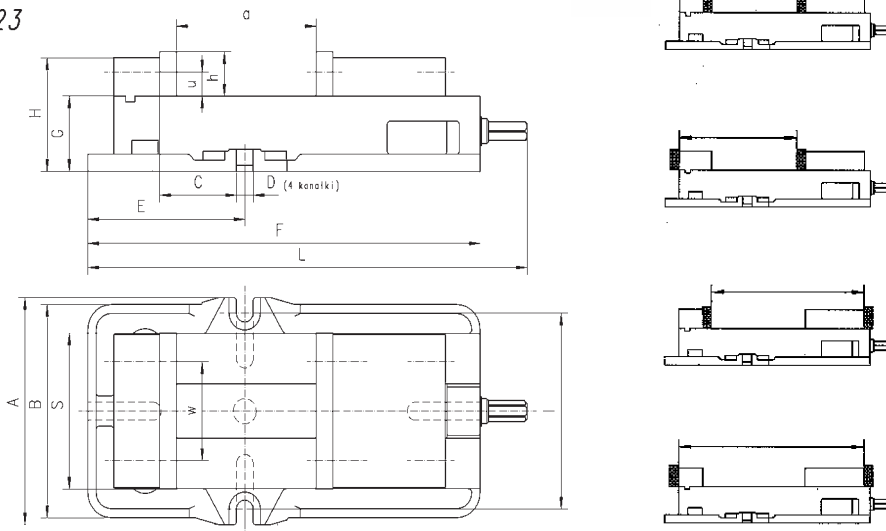
Features:

- 7-1/2" / 191mm full length opening
- 9900 lbs. clamping force
- 2.875" bed height within +/- 0.0005"
- Durable finish
- Non-lifting movable jaws
- Jaw plates are interchangeable with other manufacturer vises
- Optional swivel base is available
- Induction hardened guideways



Clamping Ranges

6523



Cam-Lock Milling Machine Vises for CNC Machines

Size S	A	H	L	a	h	k	Max. Clamping Force lbf.	Weight lbs.	Code No.
6"	8.82	6.26	20.3	0-7.1	1.97	.71	9259	104	7-226-006
8"	10.40	7.24	26.2	0-11	2.48	.71	14000	202	7-226-008

- The rear moveable jaw can be placed in different positions through unique quick locking cam mechanism.
- Supplied with 360° graduated swivel base.

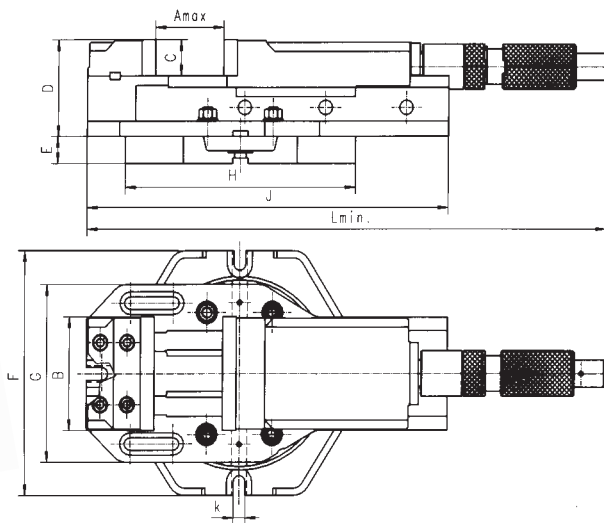


Vises

Milling Machine Vises with Hydraulic Spindle, Swivel Base 6515

Width of Jaws B	Maximum Clamping Force (lb.)	A. Max.	C	D	E	F	G	H	J	L		Weight lbs.	Code No.
										min.	max.		
5"	7800	0-8	1.65	4.29	1.18	10.63	7.71	10.63	16.73	20.9	28.2	62	7-224-005
6"	12300	0-11	1.97	5.12	1.34	12.79	9.68	12.79	22.25	24.2	35.0	151	7-224-006
8"	16800	0-14-3/4	2.48	6.38	1.77	14.96	11.97	14.96	26.57	31.3	42.5	267	7-224-008

These precision heavy duty milling machine vises with hydraulic spindle are used in operations where large clamping forces are required. Supplied with 360° graduated swivel base. The rigid body is made of semi-steel and the jaw plates are hardened and ground. The guideways of the movable jaw are accurately machined, hardened and ground. Vise has two jaw openings.



Two piece Milling Machine Vises 6522

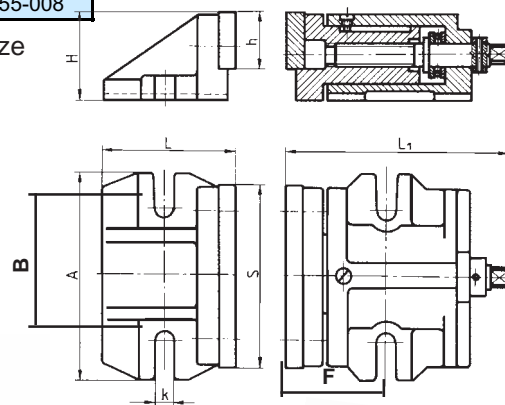
Width of Jaws S	Length L	Length L1	Width of Vise A	Depth of Jaws H	k	Clamp Travel	Weight lbs.	Code No.
6"	6.3"	7.6"	7.1"	3"	.67	3/8"	32	7-255-006
8"	6.8"	10.2"	7.7"	4"	.67	1/2"	58	7-255-008

This unique two piece milling machine vise makes it possible to utilize the full length of the machine table.

The work piece is located directly on the milling machine table for rigidity, accuracy and low profile machining.

SPECIAL FEATURES:

- The body is made of high quality casting.
- Jaw plates are hardened and precision ground.
- All working and mounting surfaces are precisely machined.
- Machined keyways enable accurate setup.



Optional Jaw Plates see page 105.



Wrench Code No. 7-233-040

Two Position Self-Centering

Milling Machine Vises for Holding Shafts & Round Work pieces

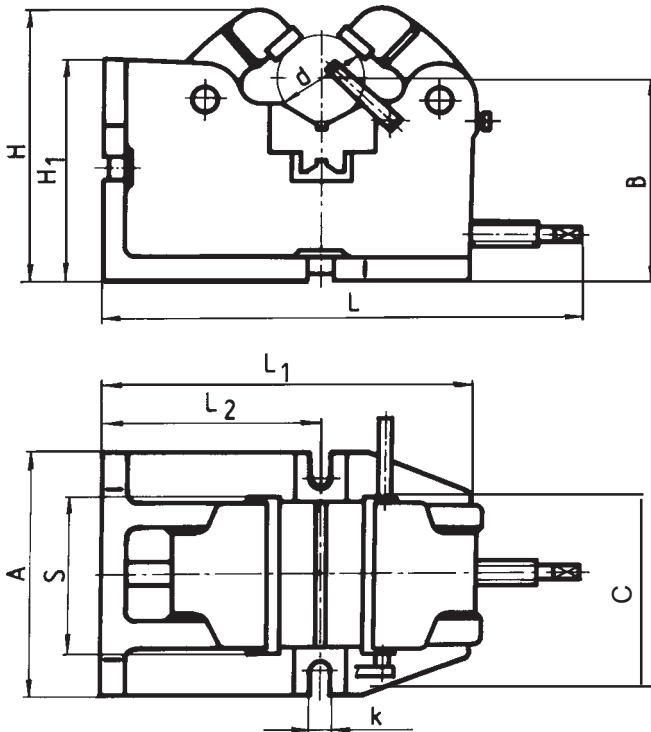
6546

Width of Jaws S	Shaft Capacity d min - max	H	H1	A	L	L1	L2	K	B min. - max.	Max Clamping Power lbs.	Weight lbs.	Code No.
4"	.394 - 2.48	6.69	5.32	7.09	12.00	8.74	5.28	0.71	4.40 - 5.30	2200	47	7-225-000
5"	.591 - 3.94	9.25	7.28	7.87	15.95	11.41	7.17	0.71	6.30 - 7.20	3300	84	7-225-005
6"	1.969 - 6.30	11.61	9.82	9.65	18.11	13.12	8.50	0.71	8.10 - 9.30	4400	165	7-225-006

These vises are used for clamping round work pieces with diameters from .394" to 6.30". For use on a milling machine or drill press.

SPECIAL FEATURES

The jaw plates are case-hardened and heat-treated to Rockwell C 55-60. The vise body and 2 movable jaws are made of semi-steel. Vises can be set up in two positions. The adjustable sliding rod enables the work pieces to be set in the same position repeatedly. Vises are supplied with 2 clamping bolts, wrench, V-block and sliding rod.



Spare Parts/Optional Accessories:

Width of Jaw	Movable Jaw Code No.	V - Block Code No.	Wrench Code No.	Jaw Insert Code No.	Jaw Screws Code No.	Lead Screws Code No	Work Stop Code No.
4"	7-225-204	7-225-104	7-233-030	7-225-304	7-290-908	7-225-214	7-225-504
5"	7-225-205	7-225-105	7-233-061	7-225-305	7-290-210	7-225-215	7-225-505
6"	7-225-206	7-225-106	7-233-040	7-225-306	7-290-210	7-225-216	7-225-506

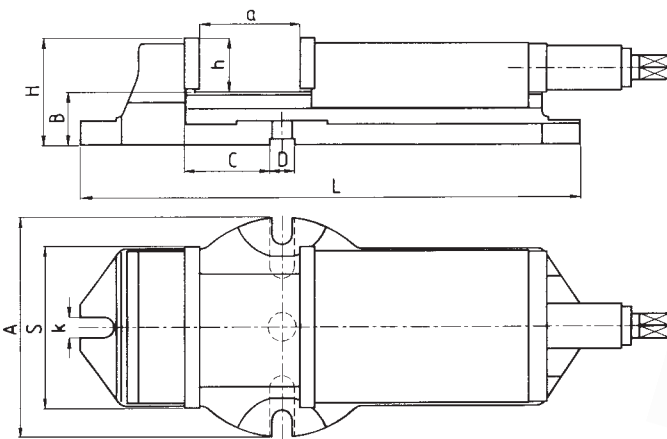
Vises

Heavy Duty Milling Machine Vises with Dovetail Guideways Swivel or Stationary

6910

Width of Jaws	A	B	C	D (H7)	H	L	a max.	h	k	Maximum Clamping Force Lbs.	Weight Lbs.	Vise Code No.	Swivel Base Code No.	Wrench Code No.
4	5.7	1.81	1.12		3.31	11.81	2.95	1.50	.630	5500	27	7-203-004	7-203-904	7-233-038
6	8.3	2.05	3.35	.984	4.13	19.49	6.50	2.09	.787	8370	80	7-203-006	7-203-906	
8	10.6	2.64	4.07		4.96	23.35	8.07	2.32	.787	11680	94	7-203-008	7-203-908	

Vises are provided with 2 clamping bolts with T-nuts, 1 wrench & Work Stop.



Milling Machine Vises Swivel or Stationary

6537

6512

Width of Jaws	Height of Jaws	Maximum Opening	SWIVEL			STATIONARY			Wrench Code No.
			Overall Height	Weight Lbs.	Code No.	Overall Height	Weight Lbs.	Code No.	
4"	1.26	3.15	4.8	31	7-202-005	3.3	22	7-222-005	7-233-040
5"	1.57	3.74	5.4	44	7-202-010	3.9	35	7-222-010	
6"	1.97	4.92	6.7	80	7-202-015	4.8	64	7-222-015	
8"	2.48	6.30	7.8	154	7-202-020	5.8	123	7-222-020	



Optional Jaw Plates see page 105.

These machine vises have a body, movable jaw and swivel base made of semi-steel. Remaining parts are made of high quality steel. The jaw plates are hardened, ground and serrated to ensure efficient gripping. Guideways of the body and the movable jaw are precisely machined. The lead screw is fully covered. This vise rotates 360° and is supplied with 2 clamping bolts with T-nuts and 1 wrench.



Vises

Shaper & Milling Machine Vises with Swivel Base Self - Centering 6531

Width of Jaw	Height of Jaw	Max. Opening	Overall Height	Weight lbs.	Vise Code No.	Wrench Code No.
5"	1.57	3.94	5.35	42	7-210-005	7-233-061
6"	1.97	4.92	6.65	74	7-210-006	7-233-061
8"	2.48	6.3	7.28	130	7-210-008	7-233-040



This self-centering, heavy duty, large capacity vise is designed for heavy milling or planing operations. Two movable jaws, body and swivel base are made of semi-steel and remaining parts of high quality alloy steel. The jaw plates are hardened and ground. The vise can swivel on the base up to 90°. Vises are provided with two mounting bolts with T-nuts and one wrench.



Optional Jaw Plates
see page 105.

Two Way Angle Milling Machine Vises with Swivel Base 6530

Width of Jaw	Height of Jaw	Max. Opening	Overall Height	Overall Length	Overall Width	Weight lbs.	Vise Code No.	Wrench Code No.
4"	1.26	3.15	5.71	14.6	5.7	28	7-249-005	7-233-040
5"	1.57	3.94	6.65	17.2	6.6	44	7-249-006	
6"	1.97	4.92	7.87	17.7	8.4	75	7-249-008	



This two angle milling machine vise makes most angle settings possible. The moveable jaw, body and swivel base are made of semi-steel. Remaining parts of high quality alloy steel. The jaw plates are hardened and ground. The vise rotates 360°. The lead screw is fully covered. This vise can incline from the horizontal position to an angle of 45° up or down. Vises are provided with two mounting bolts with T-nuts and one wrench.



Optional Jaw Plates
see page 105.

Vises

Quick Acting Machine Vises

6542

Width of Jaw	Height of Jaw	Max. Opening	Overall Height	Weight lbs.	Vise Code No.	4-position Jaw Plate Code No.
3"	1.18	3.15	2.8	11.5	7-205-000	7-205-903

These instant clamping vises are ideal when a large number of the same parts has to be machined on milling machines or drill presses.

The clamping of the work piece is done by a single movement of the lever. This vise saves a lot of time with it's fast clamping mechanism.

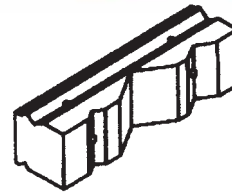
The base and movable jaw are made of semi-steel. The jaw plates are case-hardened and heat-treated.

The heavy base has six clamping slots and can be clamped to a milling machine table with two bolts.

The quick-acting cam can be set instantly to hold work.

Jaw plate with horizontal & vertical grooves can clamp different shaped work pieces in different positions.

Special Four Position jaw plate is available.



Special Four Position Jaw Plate - optional

Quality Drill Press Vises

6543

Width of Jaws	Height of Jaws	Max. Opening	Overall Height	Weight lbs.	Code No.
3"	1.18	2.76	2.52	7.5	7-207-003
4"	1.18	3.35	2.52	8.8	7-207-004

Rugged cast iron design.

Steel jaw plates case hardened and heat-treated.

Jaw plates with horizontal and vertical grooves can clamp different shaped work pieces in different positions.



Drill Press Vises

6538

Width of Jaw	Height of Jaw	Max. Opening	Overall Length	Overall Width	Overall Height	Weight Lbs.	Code No.
3-1/3"	1.25	1.77	10.1	5.83	2.35	7.94	7-208-003

- Ideal for any drilling and light milling operations.
- Special **ball bearing** guarantees smooth turning of the operating screw and permits clamping work piece gently or with higher clamping force.
- Rugged body is made of the highest quality casting.
- Jaw plates with horizontal & vertical grooves can clamp different shaped work pieces in different positions.

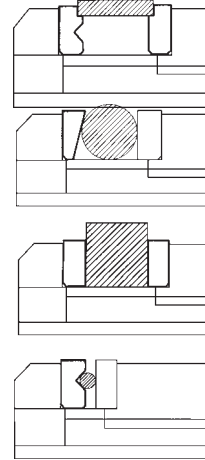


Jaw Plates

for Milling Machine Vises

- Steel jaws are hardened and precision ground.
- Each jaw can be combined with other jaw shape. See Fig. # 1.
- Jaws and screws are sold separately.

Fig. # 1



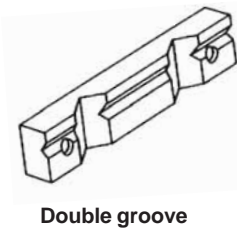
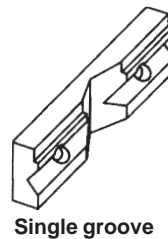
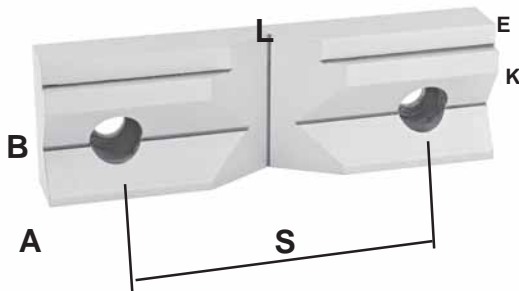
Jaw Screws



Width of Vise	S	Screw Size	Jaw Screw Code No.
4"	2.76	M8x1.25	7-290-908
5"	3.35	M10x1.25	7-290-910
6"	4.33	M10x1.25	
8"	5.51	M12x1.75	7-290-912

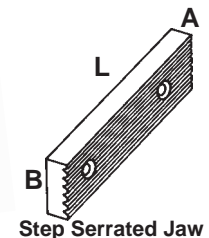
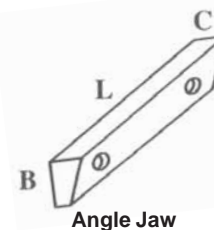
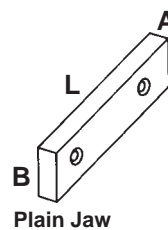
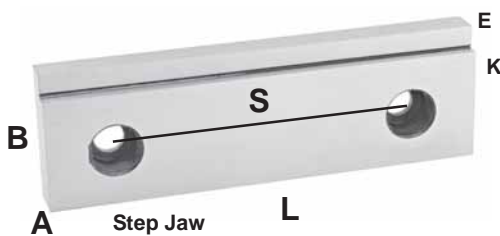
Jaw Plates - Grooved

Width of Vise	Width A	Height B	Length L	E	S	K	Jaw with Vertical Single Groove			Jaw with Vertical Double Grooves		
							Shaft Diameter D		Code No.	Shaft Diameter D		Code No.
							Horizontal min.-max.	Vertical min.-max.		Horizontal min.-max.	Vertical min.-max.	
4"	.71	1.28	3.94	.24	2.76	.16	.24-.94	.47-1.89	7-290-104	.28-1.26	.20-1.89	7-290-204
5"	.87	1.59	4.92	.31	3.35	.16	.31-1.18	.60-2.36	7-290-105	.35-1.89	.28-2.36	7-290-205
6"	.94	1.98	6.3	.31	4.33	.16	.40-1.38	.71-3.15	7-290-106	.39-2.36	.28-3.15	7-290-206
8"	1.18	2.50	7.87	.31	5.51	.16	.55-1.73	.87-3.97	7-290-108	.47-2.68	.39-3.94	7-290-208



Jaw Plates - Flat & Step

Width of Vise	Width A	Height B	Length L	S	Step Jaw		Plain Jaw	Angle Jaw		Serrated Jaw		
					E	K	Code No.	Code No.	C	Shaft Dia. min.-max.	Code No.	Code No.
4"	.53	1.28	3.94	2.76	.24	.16	7-290-004	7-290-024	.71	.31-1.18	7-290-044	7-290-074
5"	.63	1.59	4.92	3.35	.31	.16	7-290-005	7-290-025	.87	.47-1.50	7-290-045	7-290-075
6"	.63	1.98	6.30	4.33	.31	.16	7-290-006	7-290-026	.95	.55-1.89	7-290-046	7-290-076
8"	.79	2.50	7.87	5.51	.31	.16	7-290-008	7-290-028	1.18	.71-2.4	7-290-048	7-290-078



Vises

Heavy Duty Bench Vises with Swivel Base

Rugged body, movable jaw and swivel base made of high quality cast iron. Other parts made of alloy steel. Serrated, hardened, alloy steel jaw plates. Dual locking swivel base. Lead screw completely covered to keep out chips.

1255

Width of Jaw	Max. Opening	Depth of Jaw	Weight lbs.	Vise Code No.	Spare Handle Code No.
2-1/2"	2	1.77	10.8	7-232-005	7-233-130
3"	3.15	2.28	17.0	7-232-010	7-233-140
4"	3.15	2.28	18.7	7-232-015	7-233-140
5"	4.0	2.56	26	7-232-020	7-233-150
6"	4.9	2.95	40	7-232-025	7-233-160



Multi-Purpose Bench & Pipe Vises Super Heavy Duty

Rugged throughout. Takes heavier work loads. Serrated and grooved steel jaw plates. Two movable jaws can be rotated 360° and stopped every 45°. Swivels 360° and can be locked in any position.

1271

Width of Jaw	Max. Opening	Depth of Jaw	Clamping Force lbs.	Weight lbs.	Vise Code No.	Spare Handle Code No.
5"	6.00	3.15	6614.00	60	7-245-005	7-233-170



Mini Precision Bench Vises with Swivel Base

This precision, black finish, small bench vise can be clamped to any table with a max. thickness 1.97". Steel jaw plates are hardened and ground. Ideal for small precision work. Optional V-groove jaw plate is sold separately. H/V groove can clamp round work-pieces in horizontal or vertical positions.



1230

Width of Jaw	Depth of Jaw	Max. Opening	Min. Length	Weight lbs.	Vise Code No.	Jaw Plate Code No.	Spare Handle Code No.
2-1/2"	1.28	1.77	7.68	5.95	7-209-002	7-290-095	7-233-120



Quick Grip Vises

Drill Press Vises

Width of Jaw	Max Opening	Max Length	Weight lbs.	Code No.
3"	2.36	6	1.4	7-206-003
4"	3.94	7	3.1	7-206-004

- This quick release die cast vise is ideal for drilling operations.
- Steel jaw plates are hardened.
- Front jaw plate with H/V grooves can clamp different shaped work pieces in horizontal or vertical positions.



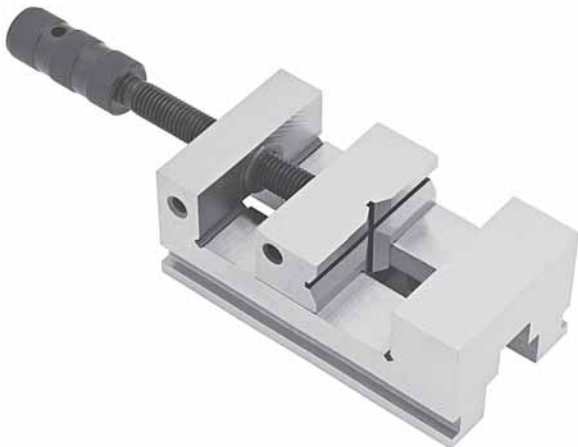
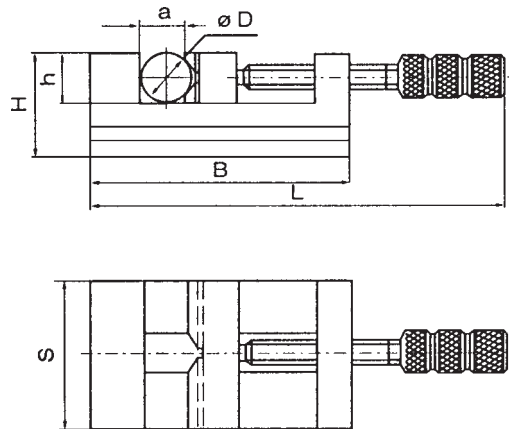
Toolmaker's Inspection Vises

PJNk/b

Width S	Height H	Length B	Total L min	Length L max	Opening a max	Depth h	Shaft D min	dia. D max	Weight lbs.	Code No.
2 1/2"	1.850	4.724	7.16	9.13	1.97	0.866	0.157	0.866	4.41	2-468-105
3 1/8"	2.205	5.748	8.42	10.86	2.44	1.063	0.197	1.063	7.93	2-468-110
4"	2.795	6.850	9.64	12.99	3.35	1.338	0.236	1.378	14.99	2-468-115

Special Features

- For inspection, precision jig boring, grinding and other operations where precise holding is necessary.
- Made of steel hardened to 55 HRC.
- V-grooved jaw for holding round work pieces.
- The base and front jaw are of one-piece, all steel construction.
- All surfaces are hardened and precision ground square and parallel to an accuracy of 0.0004".
- Clamping slots are provided and jaws are easily replaced.
- Hardened and ground dovetail slides eliminate "lift" and insure consistent accuracy.

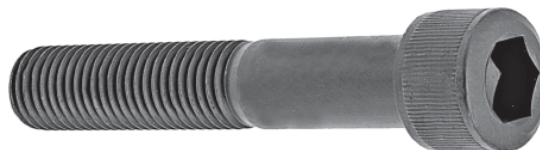


Socket Head Cap Screws

Standard ANSI B 18.3, Made in the U.S.A.

Sold in pkg. qty. of 1-- pcs. only

Size	Key Size	Length	Code No.
5/16 - 18	1/4	3/4	7-898-005
		1	7-898-008
		1-1/4	7-898-011
		1-3/4	7-898-017
		2-1/4	7-898-023
3/8 - 16	5/16	3/4	7-898-105
		1-1/4	7-898-111
		2-3/4	7-898-128
7/16 - 14	3/8	1	7-898-208
1/2 - 13	3/8	1	7-898-308
		1-1/2	7-898-314
		3-1/4	7-898-335
5/8 - 11	1/2	1-1/4	7-898-411
		1-3/4	7-898-417
		2-1/2	7-898-420
		2-3/4	7-898-428
		3-1/4	7-898-435
		3-1/2	7-898-438
		4-1/2	7-898-450
		3/4 - 10	5/8
2-1/4	7-898-523		
2-1/2	7-898-524		
3	7-898-530		
3-1/4	7-898-535		
4	7-898-544		
4-1/2	7-898-548		
5	7-898-556		
5-1/2	7-898-558		
7/8 - 9	3/4	6	7-898-610



Measurement translations:

- 1 foot = 12 inches
- 1 inch = 25.4 mm
- 1 cm = 10 mm
- 1 meter = 100 cm
- 1 micron = 0.001 mm
- 1 micron = 0.0000394 inches
- 1 lb. = 16 oz.
- 1 lb. = 0.4536 kg
- 1 kg = 2.20 lbs.

Fractional	Inch	mm
1/32	0.031	0.79
1/16	0.063	1.59
3/32	0.094	2.38
1/8	0.125	3.18
5/32	0.156	3.97
3/16	0.188	4.76
7/32	0.219	5.56
1/4	0.250	6.35
9/32	0.281	7.14
5/16	0.313	7.94
11/32	0.344	8.73
3/8	0.375	9.53
13/32	0.406	10.32
7/16	0.438	11.11
15/32	0.469	11.91
1/2	0.500	12.70
17/32	0.531	13.49
9/16	0.563	14.29
19/32	0.594	15.08
5/8	0.625	15.88
21/32	0.656	16.67
11/16	0.688	17.46
23/32	0.719	18.26
3/4	0.750	19.05
25/32	0.781	19.84
13/16	0.813	20.64
27/32	0.844	21.43
7/8	0.875	22.23
29/32	0.906	23.02
15/16	0.938	23.81
31/32	0.969	24.60
1	1.000	25.40

Hex L-Wrenches Singles Short

Fractional		
Size W	Lth (inches)	Code No.
1/16	1.8	6-998-145
5/64	1.9	6-998-147
3/32	2.0	6-998-150
7/64	2.1	6-998-151
1/8	2.3	6-998-153
9/64	2.4	6-998-156
5/32	2.5	6-998-159
3/16	2.8	6-998-162
7/32	3.0	6-998-165
1/4	3.3	6-998-168
5/16	3.8	6-998-171
3/8	4.3	6-998-174
7/16	4.8	6-998-177
1/2	5.3	6-998-180
9/16	5.8	6-998-183
5/8	6.3	6-998-165
3/4	7.3	6-998-187

Metric		
Size W (mm)	a (inches)	Code No.
2.0	1.97	6-999-582
3.0	2.56	6-999-583
4.0	2.83	6-999-584
5.0	3.15	6-999-585
6.0	3.54	6-999-586
7.0	3.7	6-999-587
8.0	3.94	6-999-588
10.0	4.4	6-999-590
12.0	4.9	6-999-592
14.0	5.5	6-999-594
17.0	6.3	6-999-597
19.0	7.0	6-999-599
22.0	7.9	6-999-602
3-22	11 pc. Set	6-999-711

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