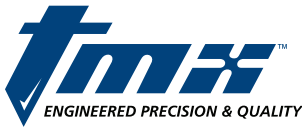




Manual Chucks  
Oil Country Chucks  
VTL Chucks  
Rotary Table Packages  
Power Chucks  
Centers & Rotating Bodies  
Milling Machine Vises

# Workholding Catalog





Our time proven quality and reliability lies in our history of **European craftsmanship and engineering**. Toolmex's European factories are ISO 9001 certified and manufacture to international standards.

**TMX Workholding products deliver the precision, accuracy and reliability** associated with European manufacturing.

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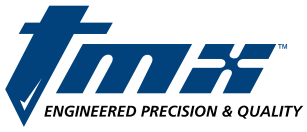
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**Notes:**

# Selection Guide

DESIGNED AND ENGINEERED FOR PRECISION



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## Lathe Chuck Safety Conditions

- Due to chuck rotating speeds and cutting forces during machining, care should be taken to ensure the proper and safe use of your TMX chuck
- Cleaning should be done often for safety purposes as well as to provide a long work life for your chuck
- Proper maintenance ensures longer life of the product

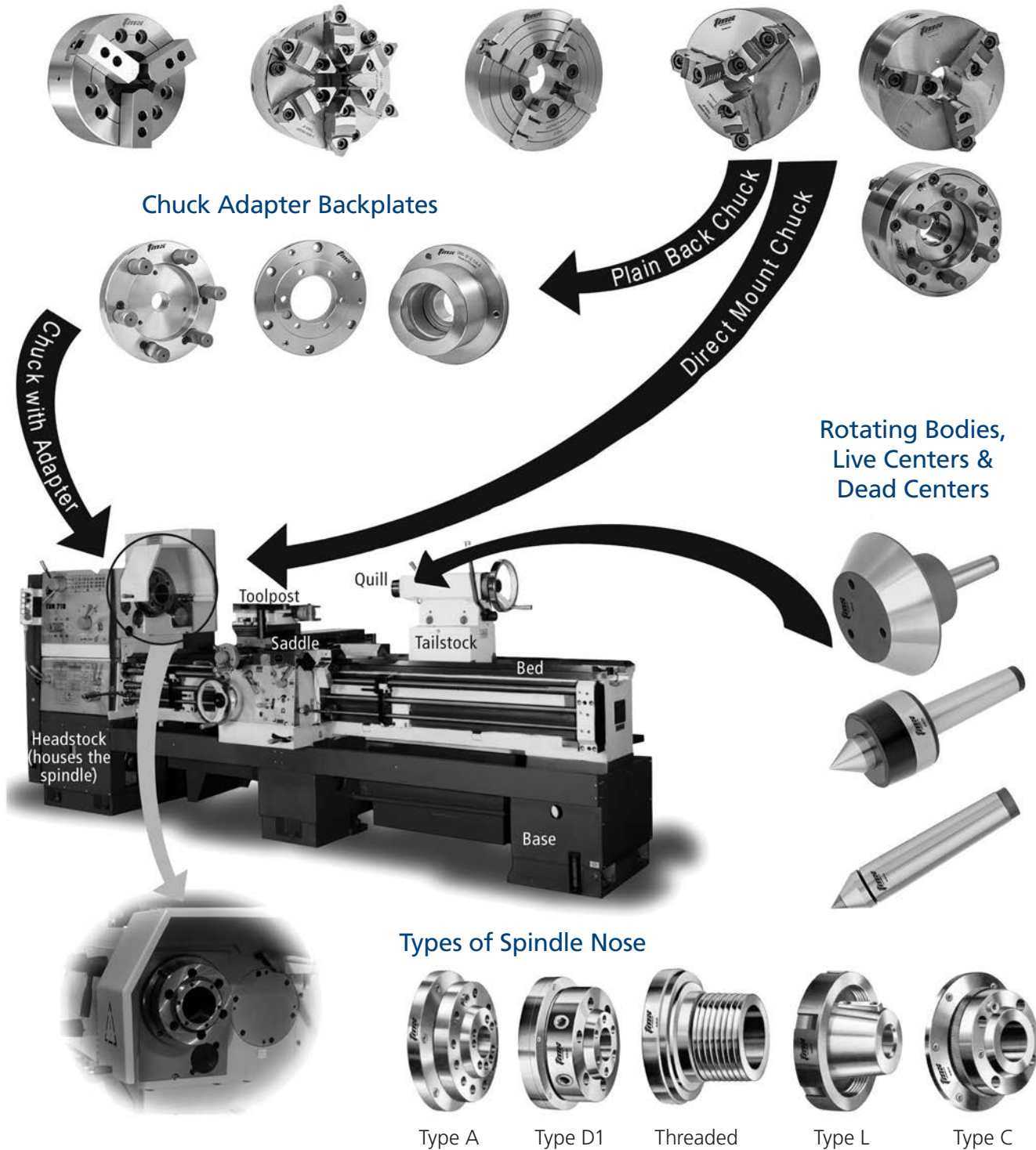


### PRIOR TO OPERATING YOUR TMX LATHE CHUCK, PLEASE:

- 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. Refer to the tables to select the correct size chuck for the application
- Do not clamp long work pieces in the chuck without additional support as this can cause heavy damage to the lathe and work environment. Refer to the table for safety parameters
- Always remove the chuck wrench before starting the machine
- Do not remove the safety spring from the chuck wrench
- Never operate the chuck if any parts are damaged, missing, or cracked
- Do not tamper with the chuck. If an inaccuracy is found, check the spindle nose or backplate 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 for recommended maximum speeds for self-centering chucks
- 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



## Application of Chucks & Centers



## Manual Chuck Selection Worksheet (Email to support@tmxtools.com)

### Chuck Parameters

Proper identification of all chuck parameters will help us with recommendations and options

|                                    |  |                        |  |
|------------------------------------|--|------------------------|--|
| Maximum Weight of Workpiece (lbs)  |  | Maximum Gripping Force |  |
| Workpiece Diameter (max-min range) |  | Minimum Hole Diameter  |  |
| Workpiece Length                   |  | Maximum RPM            |  |
| Additional Workpiece Support       |  | Machining Conditions   |  |

### Chuck Diameter

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

### Type of Chuck ✓

|                         |  |
|-------------------------|--|
| Self-Centering (scroll) |  |
| SET TRU (scroll)        |  |
| Independent             |  |
| 5C Collet (manual)      |  |
| 16C Collet (manual)     |  |
| Rotating with MT Shank  |  |

### Number of Jaws ✓

|   |  |
|---|--|
| 2 |  |
| 3 |  |
| 4 |  |
| 6 |  |

### Type of Chuck Jaws ✓

|                                       |  |
|---------------------------------------|--|
| 2pc Reversible Hard Jaws              |  |
| Set of OD & Set of ID Hard Solid Jaws |  |
| Hard Solid Reversible Jaws            |  |
| Soft Top Jaws & Hard Master Jaws      |  |
| Soft Solid Jaws                       |  |

### Type of Mounting - Lathe Spindle Nose for Chucks and Backplates

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

### Additional Notes:

## Determining the Proper Spindle Type and Size

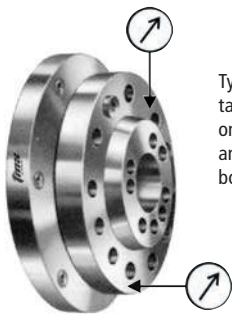
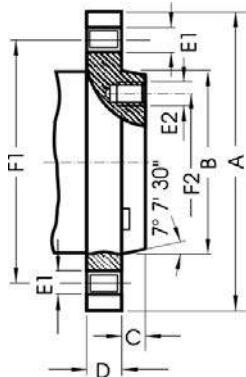
TMX Chucks meet all of the requirements of ASA Standard B5.9-1960.

For spindle nose accuracy (T.I.R.) see page 8.

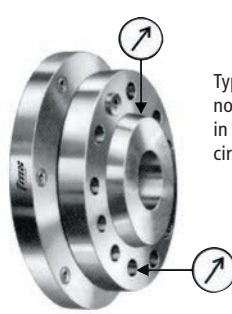
### Selecting the chuck mounting from the following types:

- For short taper spindle nose, Type A, D, or C (DIN), measure the pilot diameter and length (dimensions B and C), bolt circle diameter (dimensions F1 and F2) and diameter of the holes (dimensions E1 and 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 either A1 or A2 spindle nose
- For the long taper spindle nose, type L, check pilot diameter, length and thread size (dimensions A, C, and B)
- For the threaded spindle nose, check the thread diameter, number of threads per inch and length (dimensions B and D), plus overall length (dimension F1)

## Spindle Type A1 and A2



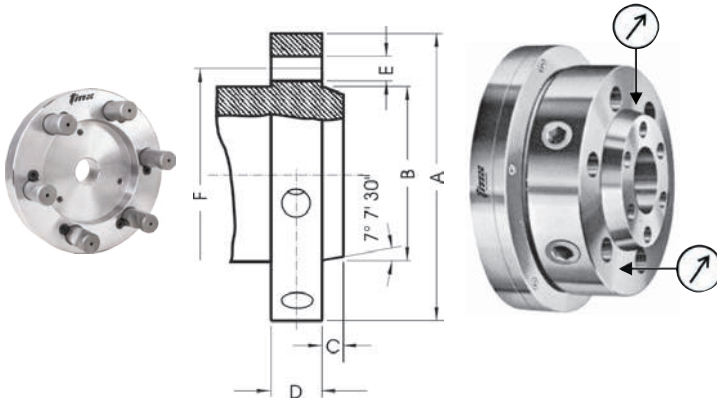
Type A1 has tapped holes on both inner and outer bolt circles



Type A2 does not have holes in the inner bolt circle

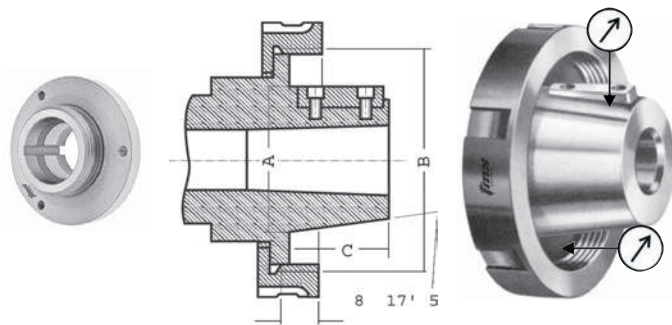
| Spindle Nose | F1      | F2      | B               | C max | Thread E1 = E2 UNC-3B |
|--------------|---------|---------|-----------------|-------|-----------------------|
| A-4          | 3.2500  | -       | 2.5005 + .0005  | .4375 | 7/16-14               |
| A-5          | 4.1250  | 2.4374  | 3.2505 + .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               |

## Camlock Spindle Type D1



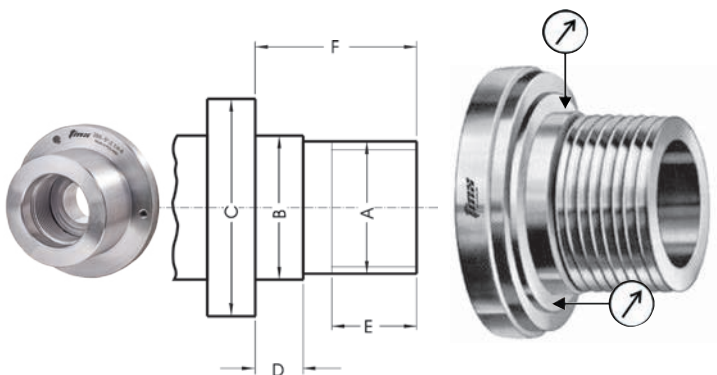
| Spindle Nose | A      | F       | B               | C max | E     | # of Holes | Camlock Stud Dia |
|--------------|--------|---------|-----------------|-------|-------|------------|------------------|
| D1-3         | 3.622  | 2.7820  | 2.1250 + .00025 | .4375 | .5937 | 3          | 9/16             |
| D1-4         | 4.606  | 3.2500  | 2.5005 + .0005  | .4375 | .6562 |            | 5/8              |
| D1-5         | 5.748  | 4.1250  | 3.2505 + .0005  | .5000 | .8750 | 6          | 3/4              |
| D1-6         | 7.126  | 5.2500  | 4.1880 + .0005  | .5625 | 1.000 |            | 7/8              |
| D1-8         | 8.858  | 6.7500  | 5.50075 + .0005 | .6250 | 1.125 |            | 1                |
| D1-11        | 11.732 | 9.2520  | 7.75075 + .0005 | .6875 | 1.250 |            | 1 3/16           |
| D1-15        | 15.866 | 13.0000 | 11.251 + .001   | .7500 | 1.375 |            | 1 3/8            |

## Long Taper Key Drive, Spindle Type L



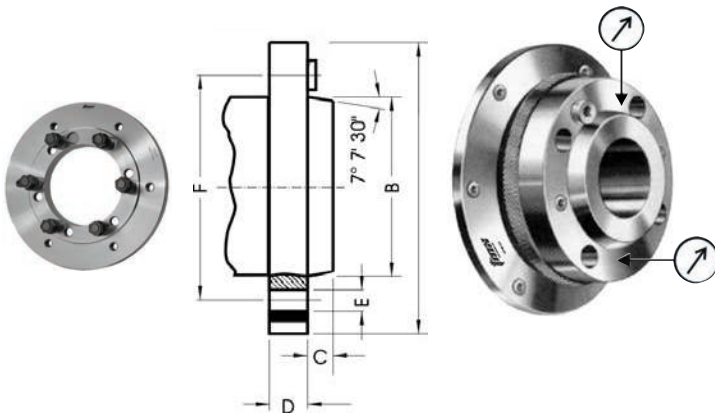
| Spindle Nose | B            | C     | A     | Key               |
|--------------|--------------|-------|-------|-------------------|
| L00          | 3 3/4" - 6"  | 2     | 2.750 | 3/8 x 3/8 x 1 1/2 |
| L0           | 4 1/2" - 6"  | 2 3/8 | 3.250 | 3/8 x 3/8 x 1 3/4 |
| L1           | 6" - 6"      | 2 7/8 | 4.125 | 5/8 x 5/8 x 2 3/8 |
| L2           | 7 3/4" - 5"  | 3 3/8 | 5.250 | 3/4 x 3/4 x 2 7/8 |
| L3           | 10 3/8" - 4" | 3 7/8 | 6.500 | 1 x 1 x 3 1/4     |

## Threaded Spindle



| Spindle Nose A      | B      | F      | 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 |

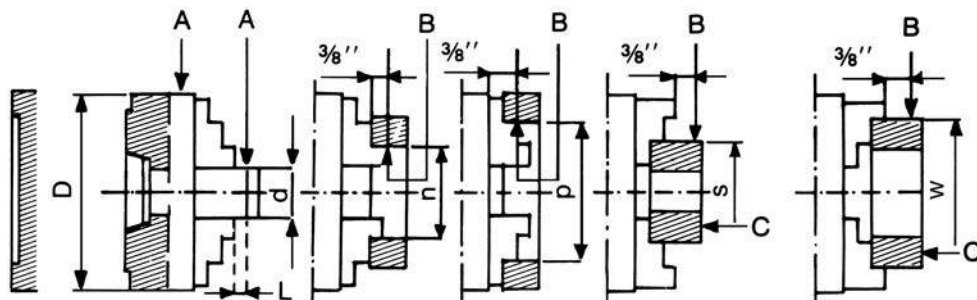
## German Standard DIN 55027, Spindle Type C



| Spindle Nose | F      | B       | C max | E    | # 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          |

## Self-Centering Scroll Chuck Accuracy

- All allowable runouts which are specified relate to measurements at three different jaw openings **d** (1, 2, and 3)

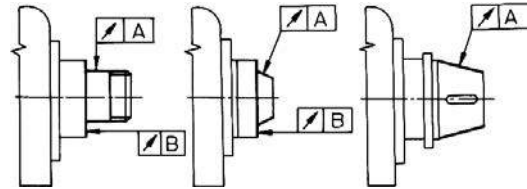


| Chuck Dia<br>D | d    |      |      | L    | n    | p     | s     | with solid jaws | with 2-piece jaws | Radial Runout |        | Axial Runout<br>C |
|----------------|------|------|------|------|------|-------|-------|-----------------|-------------------|---------------|--------|-------------------|
|                | 1    | 2    | 3    |      |      |       |       |                 |                   | A             | B      |                   |
| 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            |

## Permissible Spindle Runout

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

1. Reduce play in the spindle bearings to allowable minimum.
2. Ensure the machine spindle nose does not exceed the values specified.
3. Meet the basic requirements for correct mounting of the chuck on the spindle nose.
4. Follow the chuck manual.

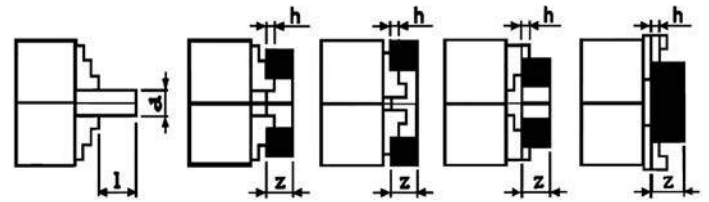


| Chuck Diameter | Spindle Runout |
|----------------|----------------|
| 3" - 16"       | .00012" max    |
| 20" - 25"      | .0002" max     |

## Safe Operating Parameters

Conditions:

- l and z = maximum length of workpiece
- d = workpiece diameter
- h = height of the clamping jaw step
- Workpiece is clamped into the chuck jaws without additional support



| Chuck Diameter | 3-1/4"  | 4" | 5" | 6-1/4" | 8" | 10" | 12-1/2" | 15-3/4" | 20" | 25"   | 31-1/2" |
|----------------|---------|----|----|--------|----|-----|---------|---------|-----|-------|---------|
| l              | 1.2 × d |    |    |        |    |     | 1.5 × d |         |     | 1 × d |         |
| z              | 4 × h   |    |    |        |    |     |         |         |     |       |         |

## Total Gripping Force of all Scroll Chucks

| Chuck Diameter       | 3-1/4" | 4" | 5" | 6-1/4" | 8"  | 10" | 12-1/2" | 15-3/4" | 20" | 25" | 31-1/2" |
|----------------------|--------|----|----|--------|-----|-----|---------|---------|-----|-----|---------|
| Max Pinion Torque Nm | 35     | 50 | 75 | 120    | 160 | 180 | 200     | 280     | 360 | 460 | 500     |

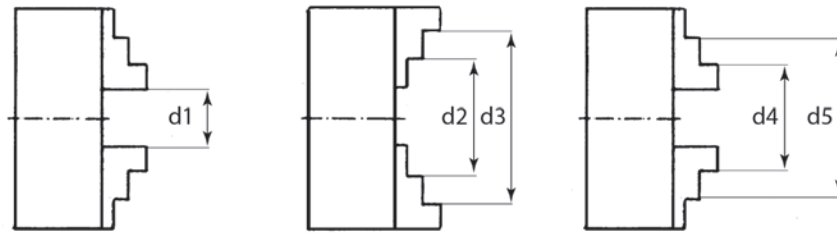
## Recommended Maximum Speeds for Scroll Chucks

| Chuck Diameter | 3-1/4" | 4"   | 5"   | 6-1/4" | 8"   | 10"  | 12-1/2" | 15-3/4" | 20"  | 25"  | 31-1/2" |
|----------------|--------|------|------|--------|------|------|---------|---------|------|------|---------|
| Max RPM        | 6300   | 6300 | 5500 | 4600   | 4000 | 3500 | 2800    | 2000    | 1300 | 1000 | 800     |

## Value of Unbalancing for Scroll Chucks

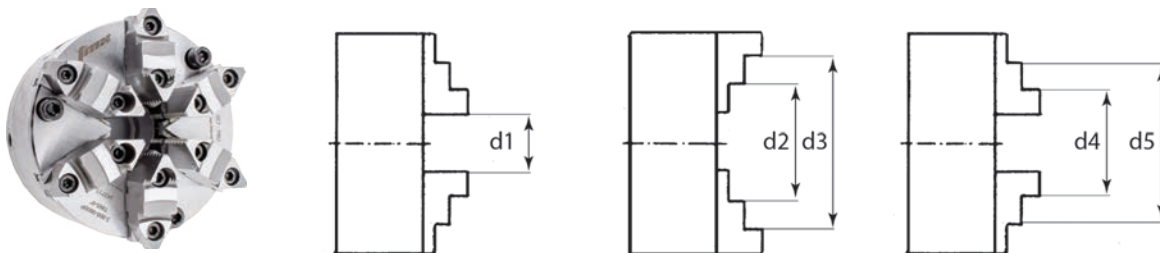
| Chuck Diameter           | 3-1/4" | 4"   | 5"   | 6-1/4" | 8"   | 10"  | 12-1/2" | 15-3/4" | 20"  | 25"  |
|--------------------------|--------|------|------|--------|------|------|---------|---------|------|------|
| Unbalancing (ounce-inch) | 0.15   | 0.22 | 0.32 | 0.44   | 0.62 | 0.87 | 1.25    | 1.94    | 4.16 | 8.88 |

## Clamping Ranges for 2, 3 and 4-Jaw Scroll Chucks



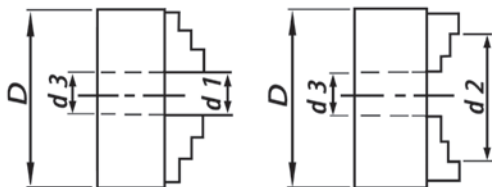
| Chuck Dia D    |    | 2-1/3"    | 3-1/4"    | 4"          | 5"          | 6-1/4"      | 8"          | 10"          | 12-1/2"      | 15-3/4"      | 20"          | 25"          | 31-1/2"     |
|----------------|----|-----------|-----------|-------------|-------------|-------------|-------------|--------------|--------------|--------------|--------------|--------------|-------------|
| Solid Jaws     | d1 | .02-.95   | .08-1.06  | .118 - 1.30 | .118 - 1.97 | .118 - 2.52 | .157 - 3.54 | .197 - 4.65  | .394 - 5.16  | .39-7.09     | .79-9.25     | 1.18-13.19   | 5.9-18.98   |
|                | d2 | .79-1.65  | .87-1.81  | 1.26 - 2.44 | 1.54 - 3.27 | 1.97 - 4.21 | 2.36 - 5.71 | 3.03 - 7.40  | 3.54 - 8.46  | 3.35-9.92    | 4.72-13.19   | 6.30-18.31   | 11.10-24.17 |
|                | d3 | 1.46-2.36 | 1.77-2.72 | 2.44 - 3.27 | 3.15 - 4.92 | 3.86 - 6.30 | 5.12 - 7.87 | 6.30 - 9.84  | 7.48 - 12.40 | 8.27-14.96   | 9.65-18.74   | 12.80-24.80  | 17.64-30.71 |
|                | d4 | .79-1.65  | .98-1.97  | .98 - 2.20  | 1.34 - 2.91 | 1.65 - 3.94 | 2.05 - 5.31 | 2.44 - 6.85  | 3.07 - 7.87  | 4.05-10.71   | 5.51-14.06   | 7.09-19.17   | 11.89-24.96 |
|                | d5 | 1.50-2.36 | 1.89-2.80 | 2.20 - 3.43 | 2.83 - 4.53 | 3.70 - 6.06 | 4.72 - 7.95 | 5.71 - 10.08 | 6.77 - 11.77 | 9.05-15.75   | 10.87-19.69  | 13.58-24.80  | 18.43-31.50 |
| Two-Piece Jaws | d1 | -         | -         | -           | .118 - 1.97 | .118 - 2.52 | .157 - 3.54 | .197 - 4.65  | .394 - 5.16  | .394 - 7.09  | .787 - 9.25  | 1.18 - 13.19 | 5.9-18.98   |
|                | d2 | -         | -         | -           | 2.05 - 3.78 | 2.44 - 4.76 | 2.83 - 6.14 | 3.39 - 7.76  | 4.06 - 8.90  | 5.00 - 11.57 | 4.33 - 15.75 | 4.72 - 22.44 | 9.92-28.99  |
|                | d3 | -         | -         | -           | 3.74 - 4.92 | 4.53 - 6.30 | 5.24 - 7.87 | 6.30 - 9.84  | 7.48 - 12.40 | 9.06 - 15.75 | 7.48 - 19.69 | 7.87 - 24.80 | 12.91-31.97 |
|                | d4 | -         | -         | -           | 1.34 - 2.99 | 1.65 - 3.81 | 1.97 - 5.12 | 2.28 - 6.50  | 2.56 - 7.17  | 2.84 - 8.98  | 4.72 - 16.14 | 5.51 - 23.23 | 9.45-28.5   |
|                | d5 | -         | -         | -           | 2.95 - 4.65 | 3.46 - 5.75 | 4.13 - 7.48 | 4.92 - 9.25  | 5.71 - 10.43 | 6.50 - 12.95 | 7.87 - 19.09 | 8.27 - 26.18 | 12.44-31.50 |

## Clamping Ranges for 6-Jaw Set-Tru Scroll Chucks



| Chuck Dia D    |    | 4"            | 5"          | 6-1/4"      | 8"          | 10"          | 12-1/2"      | 15-3/4"      | 20"          | 25"          |
|----------------|----|---------------|-------------|-------------|-------------|--------------|--------------|--------------|--------------|--------------|
| Solid Jaws     | d1 | .118 - 1.299  | .236 - 1.69 | .315 - 2.51 | .315 - 3.54 | .47 - 4.65   | .47 - 5.16   | –            | –            | –            |
|                | d2 | 1.259 - 2.440 | 1.65 - 3.07 | 2.05 - 4.21 | 2.52 - 5.71 | 3.23 - 7.40  | 3.74 - 8.46  | –            | –            | –            |
|                | d3 | 2.440 - 3.661 | 3.27 - 4.72 | 4.02 - 6.30 | 5.20 - 7.87 | 6.50 - 9.84  | 7.56 - 12.40 | –            | –            | –            |
|                | d4 | 1.023 - 2.204 | 1.34 - 2.68 | 1.85 - 3.94 | 2.17 - 5.31 | 2.68 - 6.85  | 3.23 - 7.87  | –            | –            | –            |
|                | d5 | 2.244 - 3.425 | 2.91 - 4.33 | 3.86 - 6.06 | 4.76 - 7.95 | 5.91 - 10.08 | 7.01 - 11.77 | –            | –            | –            |
| Two-Piece Jaws | d1 | –             | .236 - 1.69 | .315 - 2.51 | .315 - 3.54 | .47 - 4.65   | .47 - 5.16   | .59 - 7.95   | 1.18 - 9.25  | 1.57 - 13.19 |
|                | d2 | –             | 1.97 - 3.43 | 2.64 - 4.76 | 2.91 - 6.14 | 3.23 - 7.40  | 4.25 - 8.90  | 5.20 - 11.65 | 4.76 - 15.83 | 5.20 - 21.85 |
|                | d3 | –             | 3.70 - 4.92 | 4.65 - 6.30 | 5.28 - 7.78 | 6.46 - 9.84  | 6.02 - 12.40 | 9.29 - 15.75 | 7.76 - 18.82 | 8.27 - 24.80 |
|                | d4 | –             | 1.30 - 2.75 | 1.77 - 3.82 | 2.05 - 5.12 | 2.68 - 6.85  | 2.68 - 7.17  | 2.87 - 9.92  | 5.31 - 16.26 | 5.91 - 23.03 |
|                | d5 | –             | 2.30 - 4.68 | 3.62 - 5.75 | 4.29 - 7.48 | 5.91 - 10.08 | 5.91 - 10.08 | 6.65 - 13.86 | 8.27 - 19.25 | 8.66 - 26.02 |

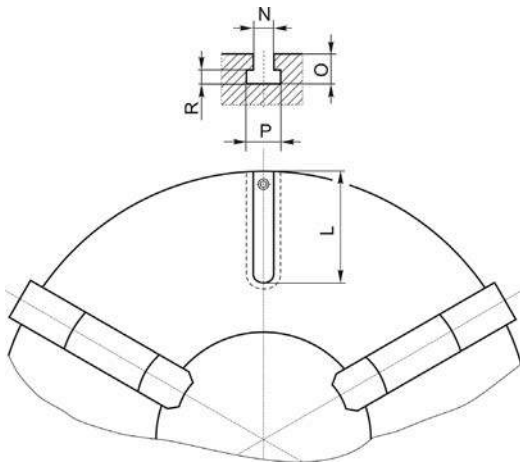
## Clamping Ranges for 4-Jaw Independent Chucks



| Chuck Dia D | d1 min | d2 max |
|-------------|--------|--------|
| 3-1/2"      | 0.118  | 3.346  |
| 5"          | 0.315  | 4.9213 |
| 6-1/4"      | 0.315  | 6.2992 |
| 8"          | 0.394  | 7.874  |
| 10"         | 0.394  | 9.843  |
| 12-1/2"     | 0.59   | 12.402 |
| 15-3/4"     | 0.787  | 15.748 |
| 20"         | 1.772  | 19.685 |
| 25"         | 1.969  | 24.803 |
| 31-1/2"     | 1.969  | 31.496 |
| 36"         | 4.724  | 36.024 |
| 39-3/8"     | 6.693  | 39.37  |
| 49"         | 6.693  | 49.213 |



## T-Slot Dimensions



## 3 Jaw Scroll Chucks

| Chuck Dia D   | # of T-Slots | MM       |    |       |    |    |
|---------------|--------------|----------|----|-------|----|----|
|               |              | NxL      | N  | O     | P  | R  |
| 20 in (500mm) | 3            | 14 x 105 | 14 | 21    | 23 | 9  |
| 24in (600mm)  | 3            | 18       | 18 | 36-30 | 30 | 12 |
| 25in (630mm)  | 3            | 18 x 120 | 18 | 26    | 30 | 12 |
| 28in (700mm)  | 3            | 18       | 18 | 36-30 | 30 | 12 |
| 32in (800mm)  | 3            | 18       | 18 | 36-30 | 30 | 12 |
| 36in (900mm)  | 3            | 18       | 18 | 36-30 | 30 | 12 |
| 40in (1000mm) | 3            | 18       | 18 | 36-30 | 30 | 12 |
| 48in (1200MM) | 3            | 18       | 18 | 36-30 | 30 | 12 |

## 4 Jaw Independent Chucks

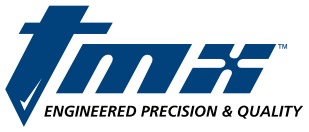
| Chuck Dia D                              | # of T-Slots | MM        |    |         |    |      |
|--|--------------|-----------|----|---------|----|------|
|  |              | NxL       | N  | O       | P  | R    |
| 10in (250mm)                             | 4            | 14 x 50   | 14 | 24      | 23 | 9    |
| 12in (315mm)                             | 4            | 18 x 67.5 | 18 | 30      | 32 | 12.5 |
| 16in (400mm)                             | 4            | 18 x 80   | 18 | 30      | 32 | 12.5 |
| 20in (500mm)-All except A-11             | 4            | 22 x 150  | 22 | 35      | 37 | 16   |
|  | 4            | 22 x 120  | 22 | 35      | 37 | 16   |
| 24in (600mm)                             | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 25in (630mm)-All except A-11 except A-20 | 4            | 22x 215   | 22 | 35      | 37 | 16   |
|  | 4            | 22 x 185  | 22 | 35      | 37 | 16   |
|  | 4            | 22 x 135  | 22 | 35      | 37 | 16   |
| 28in (700mm)                             | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 32in (800mm)                             | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 36in (900mm)                             | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 40in (1000mm)                            | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 48in (1200mm)                            | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 55in (1400mm)                            | 4            | 22        | 22 | 45 - 38 | 37 | 16   |
| 60in (1500mm)                            | 4            | 22        | 22 | 45 - 38 | 37 | 16   |

## 3 Jaw Oil Country Scroll Chucks

| Chuck Dia D   | # of T-Slots | MM        |    |       |    |    |
|---------------|--------------|-----------|----|-------|----|----|
|               |              | NxL       | N  | O     | P  | R  |
| 20in (500mm)  | 3            | 14 x Full | 14 | 21    | 23 | 9  |
| 25in (630mm)  | 3            | 18        | 18 | 36-30 | 30 | 12 |
| 28in (700mm)  | 3            | 18        | 18 | 36-30 | 30 | 12 |
| 32in (800mm)  | 3            | 18        | 18 | 36-30 | 30 | 12 |
| 36in (900mm)  | 3            | 18        | 18 | 36-30 | 30 | 12 |
| 40in (1000mm) | 3            | 18        | 18 | 36-30 | 30 | 12 |

## 4 Jaw Oil Country Independent Chucks

| Chuck Dia D  | # of T-Slots | MM  |    |         |    |    |
|--------------|--------------|-----|----|---------|----|----|
|              |              | NxL | N  | O       | P  | R  |
| 25in (630mm) | 4            | 22  | 22 | 45 - 38 | 37 | 16 |
| 28in (700mm) | 4            | 22  | 22 | 45 - 38 | 37 | 16 |
| 32in (800)   | 4            | 22  | 22 | 45 - 38 | 37 | 16 |
| 36in (900)   | 4            | 22  | 22 | 45 - 38 | 37 | 16 |
| 40in (1000)  | 4            | 22  | 22 | 45 - 38 | 37 | 16 |



**Notes:**

# Manual Lathe Chucks

DESIGNED AND MANUFACTURED  
IN EUROPE



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## Manual Lathe Chucks

TMX Chucks can handle rough as well as precision machining demands while extending the life of cutting tools and machine spindles due to the increased rigidity, accuracy and optimal wear behavior.

- 2 year quality and performance warranty
- ISO Certified
- All chuck mounting sizes meet DIN standards
- Guaranteed to maintain exceptional accuracy for an extended period

### Bodies

- Chuck bodies are drop forged and hardened to 28 HRc
- 28 HRc is hard enough to wear longer but not brittle which eliminates stress cracks in critical areas

### Jaws

- 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System are made of high quality alloy steel then hardened to 50 HRc and ground
- Jaws hardened to 50 HRc
- Jaw teeth are “softer” than the rest of the jaw to allow for a slight flex which will extend the life of the master jaw
- Solid and soft top jaws also available

### Adapter Plates

- Adapters are made of steel and not heat treated delivering optimum functionality and performance
- Fully-finished to precisely fit TMX plain back chucks without a need for any additional machining
- See [www.tmxtools.com](http://www.tmxtools.com) for the full offering of A, D, L, C and threaded taper plates



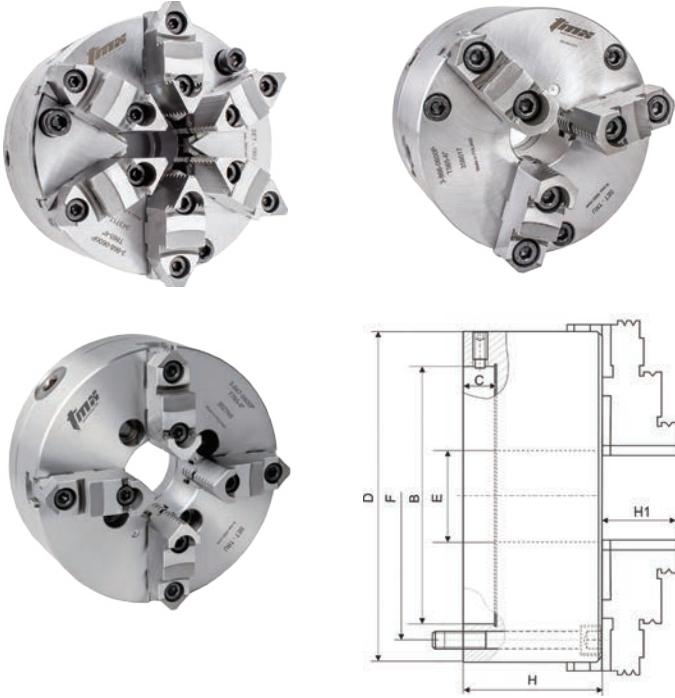
## Super Precision SET-TRU™ Chucks

3, 4 & 6-Jaw – 0.0006" T.I.R. Repeatability with Fine Adjustment

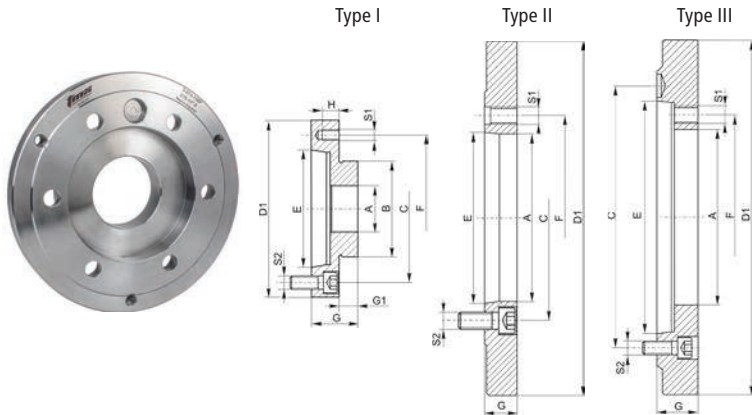
- Forged Steel Body
- Fine adjustment with 4 micro adjustment screws for outstanding repeatability
- 16", 20" and 25" diameter chucks with 3-Jaws and 6-Jaws use 8 micro adjustment screws achieving extremely high gripping concentricity
- 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Compatible with Rotary Table Packages (see page 19)
- Chucks 20" and above have T-Slots (for detailed specifications see page 11)

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench
- 1 Set of Fine Adjustment Screws
- 1 Set of Mounting Bolts
- Eyebolts for chucks 16" and larger



| Chuck Dia D | Item Number | # of Jaws | B     | C    | Thru-Hole (E) | F     | H    | H1   | Gripping Force (daN) | Max RPMs | Wt (lbs) |
|-------------|-------------|-----------|-------|------|---------------|-------|------|------|----------------------|----------|----------|
| 5           | 3-866-0500P | 3         | 2.16  | 0.59 | 1.37          | 4.25  | 2.83 | 1.57 | 2400                 | 5500     | 15       |
| 6           | 3-866-0600P |           | 3.38  | 0.70 | 1.65          | 5.51  | 3.48 | 1.73 | 3100                 | 4600     | 29       |
| 8           | 3-866-0800P |           | 4.33  | 0.78 | 2.16          | 6.92  | 3.89 | 1.77 | 3700                 | 4000     | 50       |
| 10          | 3-866-1000P |           |       |      |               |       |      |      |                      |          |          |
| 12          | 3-866-1200P |           | 7.08  | 4.05 | 11.26         | 4.66  | 2.24 | 5500 | 2800                 | 138      |          |
| 16          | 3-866-1600P |           | 11.78 | 0.86 | 5.35          | 6.75  | 5.11 | 2.63 | 6500                 | 2000     | 222      |
| 20          | 3-866-2000P |           | 16.03 | 1.18 | 7.48          | 9.25  | 6.29 | 3.15 | 7200                 | 1300     | 396      |
| 25          | 3-866-2500P |           |       |      | 9.92          | 13.00 | 6.89 | 3.42 | 8000                 | 1000     | 716      |
| 6           | 3-847-0600P | 4         | 3.38  | 0.70 | 1.65          | 5.51  | 3.48 | 1.73 | 3100                 | 4600     | 29       |
| 8           | 3-847-0800P |           | 4.33  | 0.78 | 2.16          | 6.92  | 3.89 | 1.77 | 3700                 | 4000     | 50       |
| 10          | 3-847-1000P |           | 5.70  |      | 2.99          | 8.81  | 4.29 | 2.05 | 4600                 | 3500     | 81       |
| 12          | 3-847-1200P |           | 7.08  | 4.05 | 11.26         | 4.66  | 2.24 | 5500 | 2800                 | 138      |          |
| 16          | 3-847-1600P |           | 11.78 | 0.86 | 5.35          | 6.75  | 5.11 | 2.63 | 6500                 | 2000     | 222      |
| 5           | 3-868-0500P | 6         | 2.16  | 0.59 | 1.37          | 4.25  | 2.83 | 1.57 | 2400                 | 3800     | 15       |
| 6           | 3-868-0600P |           | 3.38  | 0.70 | 1.65          | 5.51  | 3.48 | 1.73 | 3100                 | 3200     | 29       |
| 8           | 3-868-0800P |           | 4.33  | 0.78 | 2.16          | 6.92  | 3.89 | 1.77 | 3700                 | 2800     | 50       |
| 10          | 3-868-1000P |           | 5.70  |      | 2.99          | 8.81  | 4.29 | 2.05 | 4600                 | 2400     | 81       |
| 12          | 3-868-1200P |           | 7.08  | 4.05 | 11.26         | 4.66  | 2.24 | 5500 | 1900                 | 138      |          |
| 16          | 3-868-1600P |           | 11.78 | 0.86 | 5.35          | 6.75  | 5.11 | 2.63 | 6500                 | 1400     | 222      |
| 20          | 3-868-2000P |           | 16.03 | 1.18 | 7.48          | 9.25  | 6.29 | 3.15 | 7200                 | 900      | 396      |
| 25          | 3-868-2500P |           |       |      | 9.92          | 13.00 | 6.89 | 3.42 | 8000                 | 700      | 716      |

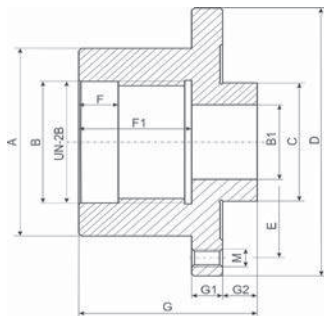


## Type A Steel Backplates for Super Precision SET-TRU™ Chucks

- Designed for use with TMX Super Precision SET-TRU™ Chucks
- All backplates come with spindle mounting bolts
- All backplates are made of hardened steel
- Backplates are fully machined

| Chuck Dia D | Item Number | Taper Size | Type | A    | B    | C    | D1    | Thru-Hole (E) | F     | G    | G1   | H    | S1  | S2  | Wt   |
|-------------|-------------|------------|------|------|------|------|-------|---------------|-------|------|------|------|-----|-----|------|
| 4           | 3-874-043P  | 3          | I    | 0.78 | 1.77 | 2.77 | 3.93  | 2             | 3.26  | 1.57 | 0.47 | 0.55 | M8  | M10 | 3.5  |
| 5           | 3-874-053P  | 3          | I    | 1.37 | 2.16 | 2.77 | 4.92  | 2             | 4.25  | 1.41 | 0.55 | 0.80 | M8  | M10 | 5.7  |
|             | 3-874-054P  | 4          |      |      |      | 3    |       | 0.86          |       |      |      | 4.8  |     |     |      |
|             | 3-874-055P  | 5          |      |      |      | 4    |       | 0.86          |       |      |      | 4.1  |     |     |      |
|             | 3-874-056P  | 6          |      |      |      | 4    |       | 0.55          |       |      |      | 7.7  |     |     |      |
| 6           | 3-874-064P  | 4          | I    | 1.65 | 3.38 | 3.25 | 6.29  | 3             | 5.51  | 1.77 | 0.62 | 1.08 | M10 | M10 | 6.8  |
|             | 3-874-065P  | 5          |      |      |      | 4    |       | 0.82          |       |      |      | 7.2  |     |     |      |
|             | 3-874-066P  | 6          |      |      |      | 4    |       | 1.02          |       |      |      | 9.7  |     |     |      |
| 8           | 3-874-084P  | 4          | I    | 2.16 | 4.33 | 3.25 | 7.87  | 3             | 6.92  | 1.29 | 0.66 | 0.57 | M10 | M10 | 9.2  |
|             | 3-874-085P  | 5          |      |      |      | 4    |       | 1.04          |       |      |      | 13.6 |     |     |      |
|             | 3-874-086P  | 6          |      |      |      | 4    |       | 1.77          |       |      |      | 17.1 |     |     |      |
| 10          | 3-874-105P  | 5          | I    | 2.99 | 5.70 | 4.12 | 9.84  | 3             | 8.81  | 1.49 | 0.74 | 0.68 | M12 | M10 | 17.4 |
|             | 3-874-106P  | 6          |      |      |      | 4    |       | 1.00          |       |      |      | 20.2 |     |     |      |
|             | 3-874-108P  | 8          |      |      |      | 6    |       | 1.81          |       |      |      | 27.1 |     |     |      |
| 12          | 3-874-126P  | 6          | I    | 4.05 | 7.08 | 5.25 | 12.40 | 4             | 11.25 | 1.49 | 0.74 | 0.68 | M16 | M12 | 35.2 |
|             | 3-874-128P  | 8          |      |      |      | 6    |       | 1.00          |       |      |      | 41.2 |     |     |      |
|             | 3-874-129P  | 11         |      |      |      | 8    |       | 2.16          |       |      |      | 31.5 |     |     |      |
| 16          | 3-874-166P  | 6          | II   | 4.05 | -    | 5.25 | 11.75 | 4             | 6.74  | 1.37 | -    | 1.37 | M16 | M12 | 28.2 |
|             | 3-874-168P  | 8          | 6    | 1.45 |      | 36.5 |       |               |       |      |      |      |     |     |      |
|             | 3-874-169P  | 11         | III  | 5.35 |      | 8    |       | 1.88          |       |      |      | 1.10 |     |     | 69.4 |
| 20          | 3-874-208P  | 8          | II   | 5.35 | -    | 6.75 | 16.02 | 6             | 9.25  | 1.41 | -    | 1.22 | M20 | M16 | 60.8 |
|             | 3-874-209P  | 11         | 8    | 1.41 |      | 76.2 |       |               |       |      |      |      |     |     |      |
|             | 3-874-215P  | 15         | III  | 7.48 |      | 11   |       | 2.04          |       |      |      | 1.18 |     |     | 69.4 |
| 25          | 3-874-258P  | 8          | II   | 5.35 | -    | 6.75 | 16.02 | 6             | 13.00 | 1.41 | -    | 1.22 | M20 | M16 | 60.8 |
|             | 3-874-259P  | 11         |      | 8    |      | 1.41 |       | 65.2          |       |      |      |      |     |     |      |
|             | 3-874-260P  | 15         |      | 11   |      | 2.04 |       | 2.04          |       |      |      | 71.6 |     |     |      |

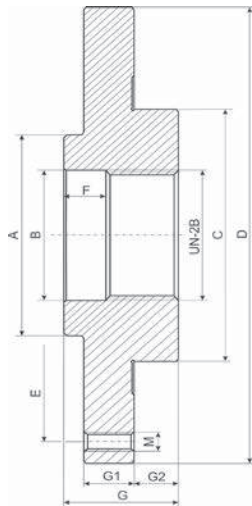
Type I



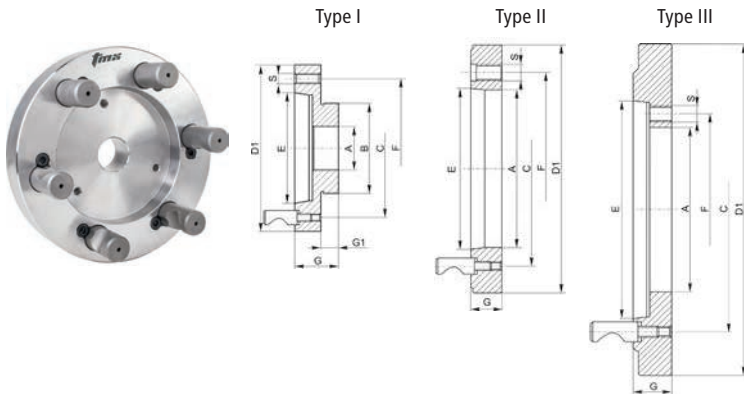
## Threaded Steel Backplates for Super Precision SET-TRU™ Chucks

- Designed for use with TMX Super Precision SET-TRU™ Chucks
- All backplates are made of hardened steel
- Backplates are fully machined

Type II



| Chuck Dia D | Item Number | Type | UN-2B      | A    | B H7 | B1   | C    | Thru-Hole (E) | F    | F1   | G    | G1   | G2   | M     | Wt (lbs) |
|-------------|-------------|------|------------|------|------|------|------|---------------|------|------|------|------|------|-------|----------|
| 5           | 3-876-052P  | II   | 1.1/2"-8   | 2.68 | 1.52 | -    | 2.17 | 4.25          | 0.51 | -    | 1.54 | 0.51 | 0.55 | 3xM8  | 3.50     |
|             | 3-876-054P  | I    | 2.3/16"-10 | 3.46 | 2.20 | 1.38 |      |               | 0.63 | 1.85 | 2.91 |      |      |       | 6.40     |
|             | 3-876-056P  |      | 2.1/4"-8   |      | 2.26 |      |      |               | 2.91 | 6.40 |      |      |      |       |          |
| 6           | 3-876-062P  | II   | 1.1/2"-8   | 2.68 | 1.52 | -    | 3.39 | 5.51          | 0.51 | -    | 1.54 | 0.71 | 0.63 | 3xM10 | 7.60     |
|             | 3-876-064P  |      | 2.3/16"-10 | 3.46 | 2.20 | -    |      |               | 0.63 | -    | 1.77 |      |      |       | 7.40     |
|             | 3-876-066P  |      | 2.1/4"-8   |      | 2.26 |      |      |               | 1.77 | 7.40 |      |      |      |       |          |
| 8           | 3-876-083P  | II   | 2.1/4"-8   | 3.46 | 2.26 | -    | 4.33 | 6.93          | 0.63 | -    | 1.77 | 0.79 | 0.67 | 3xM10 | 12.80    |

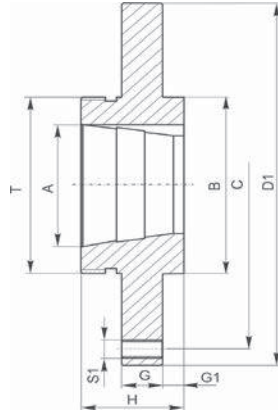


## Type D Steel Backplates for Super Precision SET-TRU™ Chucks

- Designed for use with TMX Super Precision SET-TRU™ Chucks
- All backplates are made of hardened steel
- Backplates are fully machined

| Chuck Dia D | Item Number | Taper Size | Type | A    | B    | C    | D1    | Thru-Hole (E) | F     | G    | G1   | S   | Wt (lbs) |
|-------------|-------------|------------|------|------|------|------|-------|---------------|-------|------|------|-----|----------|
| 4           | 3-875-043P  | 3          | I    | 0.78 | 1.77 | 2.77 | 3.93  | 2             | 3.26  | 1.49 | 0.47 | M8  | 3.5      |
|             | 3-875-044P  | 4          |      |      |      | 3.25 | 4.25  | 3             |       | 1.57 |      |     | 3.9      |
| 5           | 3-875-053P  | 3          | I    | 1.37 | 2.16 | 2.77 | 4.92  | 2             | 4.25  | 1.57 | 0.55 | M8  | 5.9      |
|             | 3-875-054P  | 4          |      |      |      | 3.25 |       | 3             |       | 1.65 |      |     | 5.7      |
|             | 3-875-055P  | 5          |      |      |      | 4.12 | 5.31  | 4             |       | 1.73 |      |     | 6.8      |
|             | 3-875-056P  | 6          |      |      |      | 5.25 | 6.69  | 4             |       | 1.92 |      |     | 13.0     |
|             | 3-875-058P  | 8          |      |      |      | 6.75 | 8.66  | 6             |       | 2.04 |      |     | 17.6     |
|             |             |            |      |      |      |      |       |               |       |      |      |     |          |
| 6           | 3-875-063P  | 3          | I    | 1.65 | 3.38 | 2.77 | 6.29  | 2             | 5.51  | 1.81 | 0.62 | M10 | 10.8     |
|             | 3-875-064P  | 4          |      |      |      | 3.25 |       | 3             |       |      |      |     | 1.81     |
|             | 3-875-065P  | 5          |      |      |      | 4.12 | 4     | 2.00          |       | 13.0 |      |     |          |
|             | 3-875-066P  | 6          |      |      |      | 5.25 | 6.69  | 4             |       | 2.12 |      |     | 13.0     |
|             | 3-875-068P  | 8          |      |      |      | 6.75 | 8.66  | 6             |       | 2.12 |      |     | 24.9     |
| 8           | 3-875-083P  | 3          | I    | 2.02 | 4.33 | 2.77 | 7.87  | 2             | 6.92  | 1.29 | 0.66 | M10 | 10.3     |
|             | 3-875-084P  | 4          |      | 2.16 |      | 3.25 |       | 3             |       | 1.85 |      |     | 15.8     |
|             | 3-875-085P  | 5          |      |      |      | 4.12 | 4     | 2.00          |       | 17.6 |      |     |          |
|             | 3-875-086P  | 6          |      | 5.25 |      | 6    | 2.16  | 19.8          |       |      |      |     |          |
|             | 3-875-088P  | 8          |      | 6.75 |      | 8.66 | 6     | 2.16          |       | 19.8 |      |     |          |
| 10          | 3-875-104P  | 4          | I    | 2.38 | 5.70 | 3.25 | 9.84  | 3             | 8.81  | 1.49 | 0.74 | M12 | 18.9     |
|             | 3-875-105P  | 5          |      | 2.99 |      | 4.12 |       | 4             |       | 2.08 |      |     | 17.6     |
|             | 3-875-106P  | 6          |      | 3.01 |      | 5.25 |       | 6             |       | 2.36 |      |     | 28.4     |
|             | 3-875-108P  | 8          |      |      |      | 6.75 |       | 8             |       | 2.36 |      |     | 32.4     |
| 12          | 3-875-126P  | 6          | I    | 4.05 | 7.08 | 5.25 | 12.40 | 4             | 11.25 | 1.49 | 0.74 | M16 | 28.4     |
|             | 3-875-128P  | 8          |      |      |      | 6.75 |       | 6             |       | 2.24 |      |     | 47.8     |
|             | 3-875-129P  | 11         |      |      |      | 9.25 |       | 8             |       | 2.51 |      |     | 52.9     |
| 16          | 3-875-166P  | 6          | II   | 4.05 | -    | 5.25 | 11.75 | 4             | 6.74  | 1.37 | -    | M16 | 25.7     |
|             | 3-875-168P  | 8          | III  | 5.35 |      | 6.75 |       | 6             |       | 1.49 |      |     | 26.2     |
|             | 3-875-169P  | 11         |      |      |      | 9.25 |       | 8             |       | 1.88 |      |     | 38.5     |
| 20          | 3-875-208P  | 8          | II   | 5.35 | -    | 6.75 | 16.02 | 6             | 9.25  | 1.49 | -    | M20 | 73.8     |
|             | 3-875-209P  | 11         | 7.59 | 8    |      | 1.73 |       | 77.8          |       |      |      |     |          |
|             | 3-875-215P  | 15         | 7.48 | 11   |      | 2.04 |       | 83.3          |       |      |      |     |          |
| 25          | 3-875-258P  | 8          | II   | 5.35 | -    | 6.75 | 16.02 | 6             | 13.00 | 1.49 | -    | M20 | 73.8     |
|             | 3-875-259P  | 11         |      | 7.59 |      | 8    |       | 1.73          |       | 77.8 |      |     |          |
|             | 3-875-260P  | 15         |      | 9.92 |      | 11   |       | 2.04          |       | 71.6 |      |     |          |





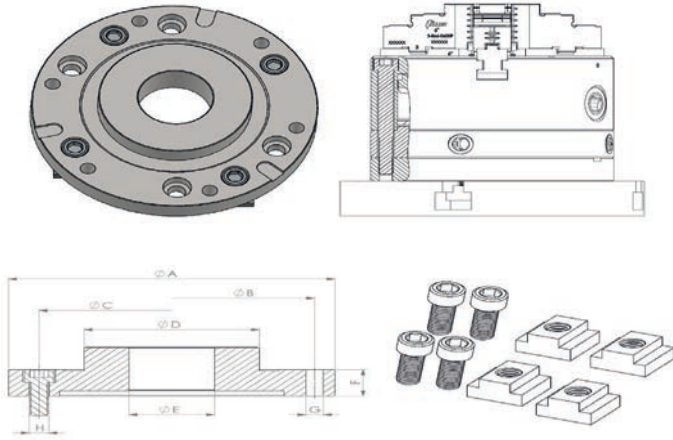
## Type L Steel Backplates for Super Precision SET-TRU™ Chucks

- Designed for use with TMX Super Precision SET-TRU™ Chucks
- All backplates are made of hardened steel
- Backplates are fully machined

| Chuck Dia D | Item Number | Taper Size | A    | B     | C     | D1    | G    | G1   | H       | S1    | T           | Wt (lbs) |
|-------------|-------------|------------|------|-------|-------|-------|------|------|---------|-------|-------------|----------|
| 5           | 3-879-9051P | L00        | 2.75 | 2.16  | 4.25  | 4.92  | 0.51 | 0.55 | 3.07    | 3xM8  | 3.3/4-6 UNS | 6.2      |
| 6           | 3-879-9061P | L00        | 2.75 | 3.38  | 5.51  | 6.29  | 0.78 | 0.62 | 2.55    | 3xM10 | 3.3/4-6 UNS | 7.3      |
|             | 3-879-9062P | L0         | 3.25 |       |       |       |      |      |         |       | 4.1/2-6 UNS | 7.7      |
| 8           | 3-879-9081P | L00        | 2.75 | 4.33  | 6.92  | 7.87  | 0.78 | 0.66 | 2.55    | 3xM10 | 3.3/4-6 UNS | 12.5     |
|             | 3-879-9082P | L0         | 3.25 |       |       |       |      |      |         |       | 4.1/2-6 UNS | 13.2     |
|             | 3-879-9083P | L1         |      |       |       |       |      |      | 6-6 UNS |       | 16.0        |          |
| 10          | 3-879-9101P | L00        | 2.75 | 5.70  | 8.81  | 9.84  | 0.90 | 0.74 | 2.75    | 3xM12 | 3.3/4-6 UNS | 22.0     |
|             | 3-879-9102P | L0         | 3.25 |       |       |       |      |      |         |       | 4.1/2-6 UNS | 22.5     |
|             | 3-879-9103P | L1         | 4.12 |       |       |       |      |      | 2.99    |       | 3xM16       | 6-6 UNS  |
| 12          | 3-879-9123P | L1         | 4.12 | 7.08  | 11.25 | 12.40 | 0.90 | 0.74 | 2.99    | 3xM12 | 6-6 UNS     | 40.0     |
|             | 3-879-9124P | L2         | 5.25 |       |       |       |      |      | 3.50    | 3xM16 | 7.3/4-5 UNS | 45.0     |
| 16          | 3-879-9164P | L2         | 5.25 | 11.75 | 6.74  | 11.75 | 0.90 | 0.90 | 3.50    | 6xM16 | 7.3/4-5 UNS | 55.0     |

## Steel Baseplates for 3-Jaw Super Precision SET-TRU™ Chucks

- Designed for TMX 3-Jaw SET-TRU™ Chucks – can be used with the following models: 3-866, 3-868, 3-847
- Ideal for use on milling and drilling machines as well as on rotary tables with 3/6 and 4/8 slots
- Base Plates are supplied with 4 mounting bolts and T-Nuts
- Chucks are sold separately

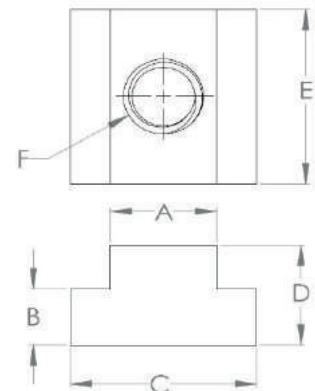


### Base Plate

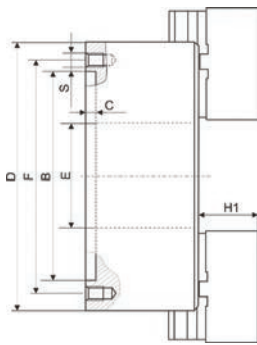
| Chuck Dia D | Base Plate  |       |       |       |       |               |      |             |               | Chuck Mounting Bolt | Chuck Part Number |
|-------------|-------------|-------|-------|-------|-------|---------------|------|-------------|---------------|---------------------|-------------------|
|             | Item Number | A     | B     | C     | D     | Thru-Hole (E) | F    | G           | H             |                     |                   |
| 6           | 3-872-606P  | 6.29  | 5.51  | 5.11  | 3.38  | 1.65          | 0.78 | 3x M10x1.5  | 4x 3/8-16 UNC | 3x M10x1.5          | 3-866-0600P       |
| 8           | 3-872-608P  | 7.87  | 6.92  | 6.33  | 4.33  | 2.16          | 0.86 |             |               |                     | 3-866-0800P       |
| 10          | 3-872-610P  | 9.84  | 8.81  | 8.18  | 5.70  | 2.99          | 0.98 | 3x M12x1.75 | 4x 1/2-13 UNC | 3x M12x1.75         | 3-866-1000P       |
| 12          | 3-872-612P  | 12.40 | 11.25 | 10.62 | 7.08  | 4.05          | 1.18 | 3x M16x2.0  |               | 3x M16x2.0          | 3-866-1200P       |
| 15          | 3-872-616P  | 15.74 | 6.75  | 17.71 | 11.78 | 5.35          | 1.25 | 6x M16x2.0  | 4x 5/8-11 UNC | 6x M16x2.0          | 3-866-1600P       |
| 20          | 3-872-620P  | 19.68 | 9.25  | 17.91 | 16.02 | 7.48          | 1.37 | 6x M20x2.5  | 4x 3/4-10 UNC | 6x M20x2.5          | 3-866-2000P       |

### T-Slot Nut

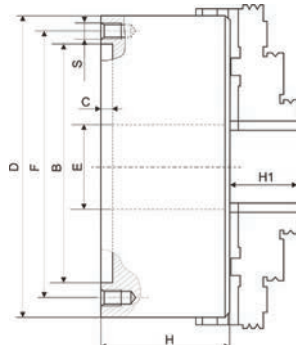
| Chuck Dia D | T-Slot Nut  |      |      |      |      |               |               |
|-------------|-------------|------|------|------|------|---------------|---------------|
|             | Item Number | A    | B    | C    | D    | Thru-Hole (E) | F (in)*       |
| 6           | 3-706-3816  | 0.50 | 0.28 | 0.87 | 0.50 | 0.87          | 4x 3/8-16 UNC |
| 8           |             |      |      |      |      |               |               |
| 10          | 3-706-1213  | 0.62 | 0.34 | 1.00 | 0.62 | 1.12          | 4x 1/2-13 UNC |
| 12          |             |      |      |      |      |               |               |
| 16          | 3-706-5811  | 0.68 | 0.43 | 1.12 | 0.75 | 1.25          | 4x 5/8-11 UNC |
| 20          | 3-706-3410  | 0.87 | 0.56 | 1.50 | 1.00 | 1.50          | 4x 3/4-10 UNC |



F\* - T-Nut is fully threaded.



Type I



Type II

## Precision Scroll Chucks

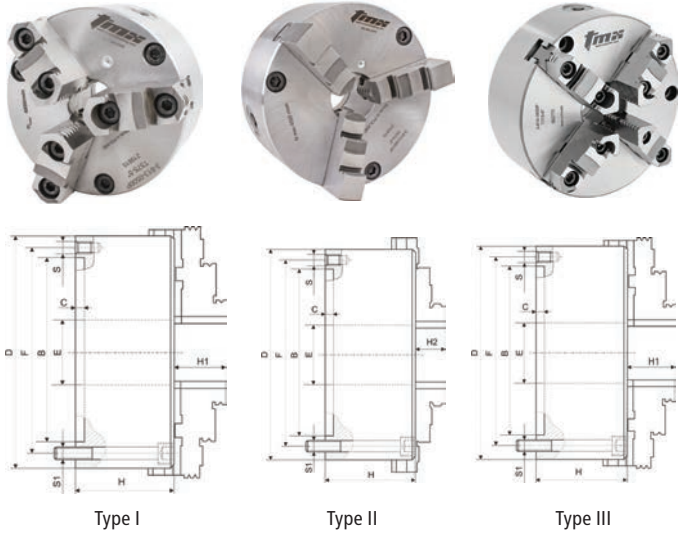
### 2, 3 & 4-Jaw – Self-Centering

- Forged Steel Body
- Each scroll chuck is statically balanced to ultra-high tolerance levels before assembly for longer life and higher accuracy
- All bearing surfaces are carefully machined at high tolerances and hardened to increase precision
- 3 and 4-Jaw Chucks come standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- 2-Jaw Chucks come standard with 2-Piece Hard Master and Soft Top Jaws
- Chucks 20" and above have T-Slots (for detailed specifications see page 11)

#### Each Chuck Provided With

- 3 & 4-Jaw Chucks
  - 1 Set of Hard Master Jaws
  - 1 Set of Reversible Hard Top Jaws
- 2-Jaw Chucks
  - 1 Set of Hard Master Jaws
  - 1 Set of Soft Top Jaws
- 1 Chuck Wrench
- 1 Set of Mounting Bolts
- Eyebolts for Chucks 16" and Larger

| Chuck Dia D | Item Number | Jaw Type                | # of Jaws | Type  | B     | C    | Thru-Hole (E) | F    | H    | H1    | S     | Max RPMs | Gripping Force (daN) | Wt (lbs) |
|-------------|-------------|-------------------------|-----------|-------|-------|------|---------------|------|------|-------|-------|----------|----------------------|----------|
| 6           | 3-831-0600P | 2 Pc with Soft Top Jaws | 2         | I     | 4.92  | 0.15 | 1.65          | 5.51 | 2.53 | 1.69  | 6xM10 | 3600     | 2400                 | 22       |
| 8           | 3-831-0800P |                         |           |       | 6.29  |      | 2.16          | 6.92 | 2.95 | 1.77  |       | 3000     | 2900                 | 39       |
| 10          | 3-831-1000P |                         |           |       | 7.87  |      | 2.99          | 8.81 | 3.34 | 2.08  |       | 2500     | 3600                 | 64       |
| 12          | 3-831-1200P |                         |           |       | 10.23 | 4.05 | 11.25         | 3.70 | 2.24 | 6xM16 | 2000  | 4400     | 111                  |          |
| 16          | 3-831-1600P |                         |           |       | 12.99 |      |               |      |      |       | 5.35  | 14.25    | 4.13                 | 2.63     |
| 5           | 3-820-0500P | 2 Pc with Hard Top Jaws | 3         | II    | 3.74  | 0.15 | 1.25          | 4.25 | 2.20 | 1.57  | 3xM8  | 5500     | 2400                 | 11       |
| 6           | 3-820-0600P |                         |           |       | 4.92  |      | 1.65          | 5.51 | 2.53 | 1.73  | 6xM10 | 4600     | 3100                 | 22       |
| 8           | 3-820-0800P |                         |           |       | 6.29  |      | 2.16          | 6.92 | 2.95 | 1.77  | 4000  | 3700     | 39                   |          |
| 10          | 3-820-1000P |                         |           |       | 7.87  | 2.99 | 8.81          | 3.34 | 2.05 | 6xM12 | 3500  | 4600     | 64                   |          |
| 12          | 3-820-1200P |                         |           |       | 10.23 |      |               |      |      |       | 4.05  | 11.25    | 3.70                 | 2.24     |
| 16          | 3-820-1600P |                         |           |       | 12.99 | 5.35 | 14.25         | 4.13 | 2.63 | 2000  | 6500  | 189      |                      |          |
| 20          | 3-820-2000P |                         |           |       | 16.53 | 7.48 | 18.03         | 4.72 | 3.14 | 1300  | 7200  | 322      |                      |          |
| 25          | 3-820-2500P |                         |           |       | 21.45 | 9.92 | 23.07         | 5.31 | 3.42 | 6xM20 | 1000  | 8000     | 556                  |          |
| 32          | 3-820-3200P |                         |           |       | 28.74 |      |               |      |      |       | 10.55 | 29.92    | 6.10                 | 3.66     |
| 40          | 3-820-4000P | 35.82                   | 15.35     | 37.40 | 6.46  |      |               |      |      |       | 3.66  | 610      | 12000                | 1600     |
| 5           | 3-841-0500P | 2 Pc with Hard Top Jaws | 4         | II    | 3.74  | 0.15 | 1.25          | 4.25 | 2.20 | 1.57  | 3xM8  | 5500     | 2400                 | 11       |
| 6           | 3-841-0600P |                         |           |       | 4.92  |      | 1.65          | 5.51 | 2.53 | 1.73  | 6xM10 | 4600     | 3100                 | 22       |
| 8           | 3-841-0800P |                         |           |       | 6.29  |      | 2.16          | 6.92 | 2.95 | 1.77  |       | 4000     | 3700                 | 39       |
| 10          | 3-841-1000P |                         |           |       | 7.87  | 2.99 | 8.81          | 3.34 | 2.05 | 6xM12 | 3500  | 4600     | 64                   |          |
| 12          | 3-841-1200P |                         |           |       | 10.23 |      |               |      |      |       | 4.05  | 11.25    | 3.70                 | 2.24     |
| 16          | 3-841-1600P |                         |           |       | 12.99 | 5.35 | 14.25         | 4.13 | 2.63 | 2000  | 6500  | 189      |                      |          |
| 20          | 3-841-2000P |                         |           |       | 16.53 | 7.48 | 18.03         | 4.72 | 3.14 | 1300  | 7200  | 322      |                      |          |



## Front & Back Mount Precision Scroll Chucks

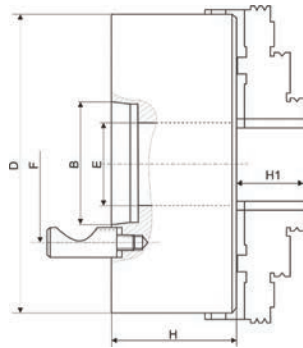
### 3 & 4-Jaw – Self-Centering

- Forged Steel Body
- 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
- Compatible with Rotary Table Packages (see page 19)
- Base plates are designed for use with all rotary tables and other devices where back mounting chucks cannot be used
- These chucks can also be mounted to a rough machined backplate, but will require machining of bolt hole patterns and projections for finished assembly
- Chucks 20" and above have T-Slots (for detailed specifications see page 11)

#### Each Chuck Provided With

- 2-Piece Jaw Chucks
  - 1 Set of Reversible Hard Master Jaws
  - 1 Set of Reversible Hard Top Jaws
- Solid Jaw Chucks
- 1 Chuck Wrench
- 1 Set of Mounting Bolts
- Eyebolts for chucks 16" and larger

| Chuck Dia D | Item Number | Jaw Type | # of Jaws | Type | B     | C    | Thru-Hole (E) | F     | H     | H1/H2 | S     | S1    | Max RPMs | Gripping Force (daN) | Wt (lbs) |      |      |     |
|-------------|-------------|----------|-----------|------|-------|------|---------------|-------|-------|-------|-------|-------|----------|----------------------|----------|------|------|-----|
| 3           | 3-813-0301P | Solid    | 3         | II   | 2.20  | 0.11 | 0.63          | 2.63  | 1.73  | 0.51  | 3xM6  | 3xM6  | 7000     | 1000                 | 3        |      |      |     |
| 4           | 3-813-0401P |          |           |      | 0.78  |      | 3.26          | 1.96  | 0.66  |       | 3xM8  | 3xM8  | 6300     | 1700                 | 6        |      |      |     |
| 5           | 3-813-0501P |          |           |      | 1.26  |      | 4.25          | 2.20  | 0.78  |       |       |       | 5500     | 2400                 | 11       |      |      |     |
| 6           | 3-813-0601P |          |           |      | 4.92  | 0.15 | 1.29          | 1.65  | 5.51  | 2.53  | 1.29  | 3xM10 | 3xM10    | 4600                 | 3100     | 22   |      |     |
| 8           | 3-813-0801P |          |           |      | 2.16  |      |               | 6.92  | 2.95  | 1.14  |       |       |          | 4000                 | 3700     | 39   |      |     |
| 10          | 3-813-1001P |          |           |      | 7.87  | 0.19 | 1.33          | 2.99  | 8.81  | 3.34  | 1.33  | 3xM12 | 3xM12    | 3500                 | 4600     | 64   |      |     |
| 12          | 3-813-1201P |          |           |      | 4.05  |      |               | 11.26 | 3.70  | 2.24  |       |       |          | 3xM16                | 3xM16    | 2800 | 5500 | 111 |
| 5           | 3-813-0500P | 2pc      | 3         | I    | 3.74  | 0.15 | 1.26          | 4.25  | 2.20  | 1.57  | 3xM8  | 3xM8  | 5500     | 2400                 | 11       |      |      |     |
| 6           | 3-813-0600P |          |           |      | 1.65  |      | 5.51          | 2.53  | 1.73  |       | 3xM10 | 3xM10 | 4600     | 3100                 | 22       |      |      |     |
| 8           | 3-813-0800P |          |           |      | 2.16  |      | 6.92          | 2.95  |       |       |       |       | 1.77     | 4000                 | 3700     | 39   |      |     |
| 10          | 3-813-1000P |          |           |      | 7.87  | 0.19 | 2.05          | 2.99  | 8.81  | 3.34  | 2.05  | 3xM12 | 3xM12    | 3500                 | 4600     | 64   |      |     |
| 12          | 3-813-1200P |          |           |      | 4.05  |      |               | 11.26 | 3.70  | 2.24  |       |       |          | 3xM16                | 3xM16    | 2800 | 5500 | 111 |
| 16          | 3-813-1600P |          |           |      | 5.35  |      |               | 14.25 | 4.13  | 2.63  |       |       |          |                      |          | 2000 | 6500 | 189 |
| 20          | 3-813-2000P |          |           |      | 16.53 | 0.27 | 3.15          | 7.48  | 18.03 | 4.72  | 3.15  | 6xM16 | 6xM16    | 1300                 | 7200     | 322  |      |     |
| 25          | 3-813-2500P | 9.92     | 23.07     | 5.31 | 3.42  |      |               | 1000  | 8000  | 556   |       |       |          |                      |          |      |      |     |
| 6           | 3-814-0600P | 2pc      | 4         | III  | 4.92  | 0.15 | 1.65          | 5.51  | 2.53  | 1.73  | 3xM10 | 3xM10 | 4600     | 3100                 | 22       |      |      |     |
| 8           | 3-814-0800P |          |           |      | 2.16  |      | 6.92          | 2.95  | 1.77  |       |       |       | 4000     | 3700                 | 39       |      |      |     |
| 10          | 3-814-1000P |          |           |      | 7.87  | 0.19 | 2.05          | 2.99  | 8.81  | 3.34  | 2.05  | 3xM12 | 3xM12    | 3500                 | 4600     | 64   |      |     |
| 12          | 3-814-1200P |          |           |      | 4.05  |      |               | 11.26 | 3.70  | 2.24  |       |       |          | 3xM16                | 3xM16    | 2800 | 5500 | 111 |
| 16          | 3-814-1600P |          |           |      | 5.35  |      |               | 14.25 | 4.13  | 2.63  |       |       |          |                      |          | 2000 | 6500 | 189 |
| 20          | 3-814-2000P |          |           |      | 16.53 | 0.19 | 3.15          | 7.48  | 18.03 | 4.72  | 3.15  | 6xM16 | 6xM16    | 1300                 | 7200     | 322  |      |     |



## Type D1 Direct Mount Precision Scroll Chucks

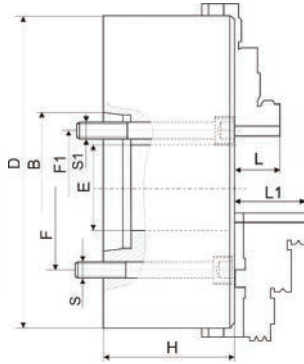
3-Jaw – No Need for Machining - No Adapter Plate Required

- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Chucks 20" and above have T-Slots (for detailed specifications see page 11)

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench
- 1 Set of Camlock Studs
- 1 Set of Camlock Set Screws
- Eyebolts for chucks 16" and larger

| Chuck Dia D | Item Number | Taper Size | B    | Thru-Hole (E) | F    | H    | H1   | Max RPMs | Gripping Force (daN) | Wt (lbs) | Camlock Studs |          |         |
|-------------|-------------|------------|------|---------------|------|------|------|----------|----------------------|----------|---------------|----------|---------|
|             |             |            |      |               |      |      |      |          |                      |          | Qty           | Dia (in) | Thread  |
| 8           | 3-823-0834P | D1-4       | 2.50 | 2.16          | 3.25 | 3.87 | 1.77 | 4000     | 3700                 | 50       | 3             | 5/8      | M10x1   |
|             | 3-823-0836P | D1-6       | 4.18 |               | 5.25 | 4.25 |      |          |                      | 52       | 6             | 7/8      | M16x1.5 |
| 10          | 3-823-1036P | D1-6       | 4.18 | 2.99          | 5.25 | 4.60 | 2.05 | 3500     | 4600                 | 86       | 6             | 7/8      | M16x1.5 |
|             | 3-823-1038P | D1-8       | 5.50 |               | 6.74 | 4.70 |      |          |                      | 88       |               | 1        | M20x1.5 |
| 12          | 3-823-1236P | D1-6       | 4.18 | 4.05          | 5.25 | 5.05 | 2.24 | 2800     | 5500                 | 153      | 6             | 7/8      | M16x1.5 |
|             | 3-823-1238P | D1-8       | 5.50 | 4.17          | 6.74 |      |      |          |                      | 150      |               | 1        | M20x1.5 |
|             | 3-823-1239P | D1-11      | 7.75 | 4.05          | 9.25 |      |      |          |                      | 5.37     |               | 151      | 1-3/16  |
| 16          | 3-823-1636P | D1-6       | 4.18 | 5.35          | 5.25 | 5.49 | 2.63 | 2000     | 6500                 | 260.9    | 6             | 7/8      | M16x1.5 |
|             | 3-823-1638P | D1-8       | 5.50 |               | 6.74 |      |      |          |                      | 261      |               | 1        | M20x1.5 |
|             | 3-823-1639P | D1-11      | 7.75 |               | 9.25 |      |      |          |                      | 5.80     |               | 261      | 1-3/16  |
| 20          | 3-823-2038P | D1-8       | 5.50 | 5.35          | 6.74 | 6.08 | 3.15 | 1300     | 7200                 | 433      | 6             | 1        | M20x1.5 |
|             | 3-823-2039P | D1-11      | 7.75 | 7.48          | 9.25 | 6.39 |      |          |                      | 424      |               | 1-3/16   | M22x1.5 |
| 25          | 3-823-2539P | D1-11      | 7.75 | 7.48          | 9.25 | 6.92 | 3.42 | 1000     | 8000                 | 748      | 6             | 1-3/16   | M22x1.5 |



## Type A2 Direct Mount Precision Scroll Chucks

3-Jaw – No Need for Machining - No Adapter Plate Required

- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Chucks 20" and above have T-Slots (for detailed specifications see page 11)

Each Chuck Provided With

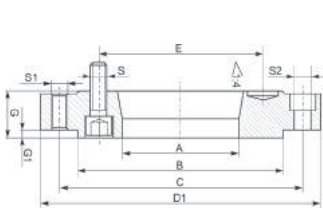
- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Set of Mounting Bolts
- 1 Chuck Wrench
- Eyebolts for chucks 16" and larger

| Chuck Dia D | Item Number | Taper Size | B     | Thru-Hole (E) | F     | H    | L1   | S     | Max RPMs | Wt (lbs) |
|-------------|-------------|------------|-------|---------------|-------|------|------|-------|----------|----------|
| 16          | 3-821-1628P | A2-8       | 4.18  | 5.35          | 6.74  | 5.37 | 2.63 | 6xM16 | 2000     | 246      |
|             | 3-821-1629P | A2-11      | 7.75  |               | 6.50  |      |      | 6xM20 |          |          |
| 20          | 3-821-2028P | A2-8       | 5.50  | 5.35          | 6.74  | 5.96 | 3.15 | 6xM16 | 1300     | 414      |
|             | 3-821-2029P | A2-11      | 7.75  | 7.48          | 9.25  |      |      | 6xM20 |          |          |
| 20          | 3-821-2030P | A2-15      | -     | -             | -     | 5.96 | 3.15 | 6xM20 | 1300     | 414      |
| 25          | 3-821-2529P | A2-11      | 7.75  | 7.48          | 9.25  | 6.73 | 3.42 | 6xM20 | 1000     | 726      |
|             | 3-821-2530P | A2-15      | 11.25 | 9.92          | 13.00 |      |      | 6xM24 |          |          |
| 32          | 3-821-3211P | A2-11      | 28.74 | 10.70         | 29.92 | 6.10 | 3.66 | 6xM20 | 765      | 900      |
|             | 3-821-3215P | A2-15      |       |               |       |      |      |       |          |          |
| 40          | 3-821-4015P | A2-15      | 35.82 | 15.35         | 37.40 | 6.49 | 3.66 | 6xM24 | 610      | 1600     |

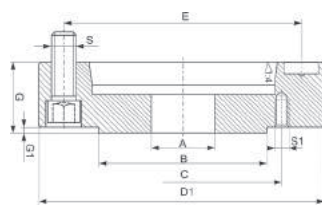


## Type A Steel Backplates for Precision Scroll Chucks

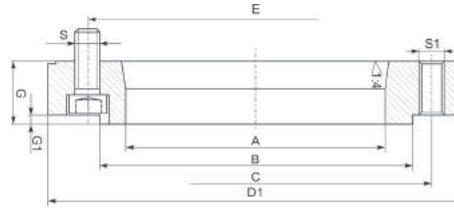
- Designed for use with TMX Precision Scroll Chucks
- All backplates come with spindle mounting bolts
- All backplates are made of hardened steel
- Backplates are fully machined



Type I



Type II



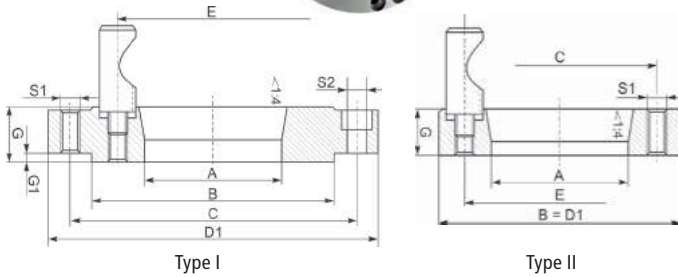
Type III

| Chuck Dia D | Item Number | Taper Size | Type | A     | Bh4   | C     | D1    | Thru-Hole (E) | G    | G1   | S     | S1    | S2     | Wt (lbs) |       |   |   |
|-------------|-------------|------------|------|-------|-------|-------|-------|---------------|------|------|-------|-------|--------|----------|-------|---|---|
| 4           | 3-873-043P  | 3          | I    | 2.02  | 2.75  | 3.26  | 3.93  | 2.77          | 0.86 | 0.09 | 3xM10 | 3xM8  | -      | 4        |       |   |   |
| 5           | 3-873-053P  | 3          | I    | 2.02  | 3.74  | 4.25  | 4.92  | 2.77          | 0.86 | 0.13 | 3xM10 | 3xM8  | 3x8.4  | 5.30     |       |   |   |
|             | 3-873-054P  | 4          | II   | 2.39  |       |       |       | 5.11          |      |      | 4.12  |       | 1.02   |          | 6xM10 | - | 6 |
|             | 3-873-055P  | 5          |      | 3.12  |       |       |       | 6.37          |      |      | 5.25  |       | 1.57   |          | 6xM12 | - |   |
|             | 3-873-056P  | 6          | III  | 1.41  |       |       |       |               |      |      |       |       |        |          |       |   |   |
| 6           | 3-873-063P  | 3          | I    | 2.02  | 4.92  | 5.51  | 6.29  | 2.77          | 0.86 | 0.13 | 3xM10 | 3xM10 | 6x10.5 | 9.3      |       |   |   |
|             | 3-873-064P  | 4          |      | 2.39  |       |       |       | 4.12          |      |      | 6xM10 |       |        |          |       |   |   |
|             | 3-873-065P  | 5          |      | 3.12  |       |       |       | 6xM10         |      |      |       |       |        |          |       |   |   |
|             | 3-873-066P  | 6          | II   | 4.05  |       |       |       | 6.49          |      |      | 5.25  |       | 0.98   |          | 3xM12 | - |   |
| 8           | 3-873-084P  | 4          | I    | 2.39  | 6.29  | 6.92  | 7.87  | 3.25          | 0.86 | 0.13 | 6xM10 | 3xM10 | 6x10.5 | 18       |       |   |   |
|             | 3-873-085P  | 5          |      | 3.12  |       |       |       | 4.12          |      |      | 6xM12 |       |        |          |       |   |   |
|             | 3-873-086P  | 6          |      | 4.05  |       |       |       | 5.25          |      |      | 6xM12 |       |        |          |       |   |   |
| 10          | 3-873-105P  | 5          | I    | 3.12  | 7.87  | 8.81  | 9.84  | 4.12          | 1.10 | 0.17 | 6xM10 | 3xM12 | 6x13.0 | 27       |       |   |   |
|             | 3-873-106P  | 6          |      | 4.05  |       |       |       | 5.25          |      |      | 0.96  |       |        |          | 6xM12 |   |   |
|             | 3-873-108P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      | 1.10  |       |        |          | 6xM16 |   |   |
| 12          | 3-873-126P  | 6          | I    | 4.05  | 10.23 | 11.25 | 12.40 | 5.25          | 1.29 | 0.17 | 6xM12 | 3xM16 | 6x17.0 | 49       |       |   |   |
|             | 3-873-128P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      | 6xM16 |       |        |          |       |   |   |
|             | 3-873-129P  | 11         | II   | 7.59  |       |       |       | 9.25          |      |      | 1.49  | 6xM20 | 6xM16  |          | -     |   |   |
| 16          | 3-873-166P  | 6          | I    | 4.05  | 12.99 | 14.25 | 15.74 | 5.25          | 1.41 | 0.17 | 6xM12 | 3xM16 | 6x17.0 | 93       |       |   |   |
|             | 3-873-168P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      | 6xM16 |       |        |          |       |   |   |
|             | 3-873-169P  | 11         |      | 7.59  |       |       |       | 5.25          |      |      | 6xM20 |       |        |          |       |   |   |
| 20          | 3-873-208P  | 8          | I    | 5.35  | 16.53 | 18.03 | 19.68 | 6.74          | 1.41 | 0.17 | 6xM16 | 3xM16 | 6x17.0 | 130      |       |   |   |
|             | 3-873-209P  | 11         |      | 7.59  |       |       |       | 5.25          |      |      | 6xM20 |       |        | 120      |       |   |   |
|             | 3-873-215P  | 15         |      | 11.07 |       |       |       | 13            |      |      | 6xM24 |       |        | 115      |       |   |   |
| 25          | 3-873-258P  | 8          | I    | 5.35  | 21.45 | 23.07 | 24.80 | 6.74          | 1.65 | 0.23 | 6xM16 | 6xM16 | 6x17.0 | 205      |       |   |   |
|             | 3-873-259P  | 11         |      | 7.59  |       |       |       | 5.25          |      |      | 6xM20 |       |        | 242      |       |   |   |
|             | 3-873-260P  | 15         |      | 11.07 |       |       |       | 13            |      |      | 6xM24 |       |        |          |       |   |   |
| 32          | 3-873-329P  | 11         | -    | 7.59  | 14.96 | 13    | 14.96 | 5.25          | 1.77 | -    | 6xM20 | 6xM24 | -      | 89       |       |   |   |
|             | 3-873-330P  | 15         |      | 11.07 |       |       |       | 13            |      |      | 1.57  |       |        | 6xM24    | 69    |   |   |



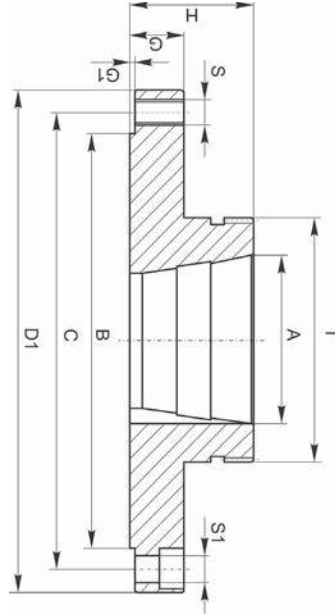
## Type D Steel Backplates for Precision Scroll Chucks

- Designed for use with TMX Precision Scroll Chucks
- All backplates are made of hardened steel
- Backplates are fully machined



| Chuck Dia D | Item Number | Taper Size | Type | A     | Bh4   | C     | D1    | Thru-Hole (E) | G    | G1   | S1    | S2     | Wt (lbs) |       |
|-------------|-------------|------------|------|-------|-------|-------|-------|---------------|------|------|-------|--------|----------|-------|
| 5           | 3-878-053P  | 3          | I    | 2.02  | 3.74  | 4.25  | 4.92  | 2.77          | 1.02 | 0.13 | 3xM8  | 3x8.4  | 3.0      |       |
|             | 3-878-054P  | 4          |      | 2.39  |       |       |       | 3.25          |      |      |       |        |          |       |
|             | 3-878-055P  | 5          |      | 1.65  |       |       |       | 4.12          |      |      |       |        |          | 1.25  |
|             | 3-878-056P  | 6          |      | 2.75  |       |       |       | 5.25          |      |      |       |        |          | 1.53  |
|             | 3-878-058P  | 8          |      |       |       |       |       | 6.88          |      |      |       |        |          | 6.74  |
| 6           | 3-878-063P  | 3          | I    | 2.01  | 4.92  | 5.51  | 6.29  | 2.77          | 1.06 | 0.13 | 3xM10 | 6x10.5 | 5.7      |       |
|             | 3-878-064P  | 4          |      | 2.39  |       |       |       | 3.25          |      |      |       |        | 1.18     | 5.5   |
|             | 3-878-065P  | 5          |      | 3.12  |       |       |       | 4.12          |      |      |       |        | 1.43     | 4.8   |
|             | 3-878-066P  | 6          |      | 4.05  |       |       |       | 5.25          |      |      |       |        | 1.43     | 4.1   |
| 8           | 3-878-084P  | 4          | I    | 2.39  | 6.29  | 6.92  | 7.87  | 3.25          | 1.06 | 0.13 | 3xM10 | 6x10.5 | 9.0      |       |
|             | 3-878-085P  | 5          |      | 3.12  |       |       |       | 4.12          |      |      |       |        | 1.18     | 7.7   |
|             | 3-878-086P  | 6          |      | 4.05  |       |       |       | 5.25          |      |      |       |        | 1.49     | 7.9   |
| 10          | 3-878-105P  | 5          | I    | 3.12  | 7.87  | 8.81  | 9.84  | 4.12          | 1.18 | 0.17 | 3xM12 | 6x13.0 | 17.8     |       |
|             | 3-878-106P  | 6          |      | 4.05  |       |       |       | 5.25          |      |      |       |        | 1.43     | 16.7  |
|             | 3-878-108P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      |       |        | 1.53     | 14.7  |
| 12          | 3-878-126P  | 6          | I    | 4.05  | 10.23 | 11.25 | 12.40 | 5.25          | 1.53 | 0.17 | 3xM16 | 6x17.0 | 33.2     |       |
|             | 3-878-128P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      |       |        | 1.85     | 30.8  |
|             | 3-878-129P  | 11         |      | 7.59  |       |       |       | 9.25          |      |      |       |        | 1.85     | 26.8  |
| 16          | 3-878-166P  | 6          | I    | 4.05  | 12.99 | 14.25 | 15.74 | 5.25          | 1.53 | 0.17 | 3xM16 | 6x17.0 | 62.1     |       |
|             | 3-878-168P  | 8          |      | 5.35  |       |       |       | 6.74          |      |      |       |        | 1.85     | 59.3  |
|             | 3-878-169P  | 11         |      | 7.59  |       |       |       | 9.25          |      |      |       |        | 1.85     | 54.4  |
| 20          | 3-878-208P  | 8          | I    | 5.35  | 16.53 | 18.03 | 19.68 | 6.74          | 1.53 | 0.17 | 3xM16 | 6x17.0 | 97.6     |       |
|             | 3-878-209P  | 11         |      | 7.59  |       |       |       | 9.25          |      |      |       |        | 1.85     | 92.8  |
|             | 3-878-210P  | 15         |      | 11.07 |       |       |       | 13            |      |      |       |        | 1.96     | 78.7  |
| 25          | 3-878-258P  | 8          | I    | 5.35  | 21.45 | 23.07 | 24.80 | 6.74          | 1.53 | 0.23 | 3xM16 | 6x17.0 | 186.9    |       |
|             | 3-878-259P  | 11         |      | 7.59  |       |       |       | 9.25          |      |      |       |        | 1.85     | 180.5 |
|             | 3-878-265P  | 15         |      | 11.07 |       |       |       | 13            |      |      |       |        | 1.96     | 163.1 |
| 32          | 3-878-329P  | 11         | II   | 7.59  | 14.96 | 13    | 14.96 | 9.25          | 1.85 | -    | 6xM24 | -      | 94.7     |       |
|             | 3-878-330P  | 15         | II   | 11.07 |       |       |       | 13            |      |      |       |        | 1.96     | 71.2  |

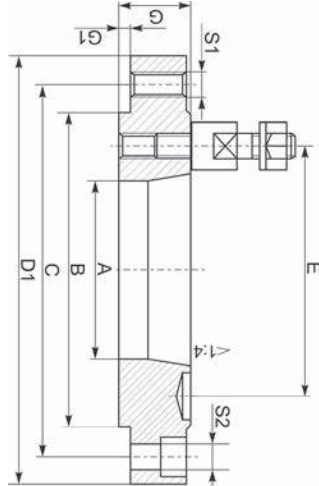




## Type L Steel Backplates for Precision Scroll Chucks

- Designed for use with TMX Precision Scroll Chucks
- All backplates come with spindle mounting bolts
- All backplates are made of hardened steel
- Backplates are fully machined

| Chuck Dia D | Item Number | Taper Size | A    | B     | C     | D1    | G    | G1   | H    | S1    | S2    | T           | Wt (lbs) |
|-------------|-------------|------------|------|-------|-------|-------|------|------|------|-------|-------|-------------|----------|
| 6           | 3-879-061P  | L00        | 2.75 | 4.92  | 5.51  | 6.29  | 0.70 | 0.13 | 2.12 | 3xM10 | 6xØ11 | 3.3/4-6 UNS | 7.4      |
|             | 3-879-062P  | L0         | 3.25 |       |       |       |      |      | 2.51 |       |       | 4.1/2-6 UNS | 9.0      |
| 8           | 3-879-081P  | L00        | 2.75 | 6.29  | 6.92  | 7.87  | 0.70 | 0.13 | 2.12 | 3xM10 | 6xØ11 | 3.3/4-6 UNS | 18.9     |
|             | 3-879-082P  | L0         | 3.25 |       |       |       |      |      | 2.51 |       |       | 4.1/2-6 UNS | 13.0     |
|             | 3-879-083P  | L1         | 4.12 |       |       |       |      |      | 2.99 |       |       | 6-6 UNS     | 18.9     |
| 10          | 3-879-101P  | L00        | 2.75 | 7.87  | 8.81  | 9.84  | 0.82 | 0.17 | 2.12 | 3xM12 | 6xØ13 | 3.3/4-6 UNS | 19.7     |
|             | 3-879-102P  | L0         | 3.25 |       |       |       |      |      | 2.51 |       |       | 4.1/2-6 UNS | 21.3     |
|             | 3-879-103P  | L1         | 4.12 |       |       |       |      |      | 2.99 |       |       | 6-6 UNS     | 25.7     |
|             | 3-879-104P  | L2         | 5.25 |       |       |       |      |      |      |       |       | 7.3/4-5 UNS | 34.1     |
| 12          | 3-879-122P  | L0         | 3.25 | 10.23 | 11.25 | 12.40 | 1.10 | 0.17 | 2.51 | 3xM16 | 6xØ17 | 4.1/2-6 UNS | 40.9     |
|             | 3-879-123P  | L1         | 4.12 |       |       |       |      |      |      |       |       | 6-6 UNS     | 44.4     |
|             | 3-879-124P  | L2         | 5.25 |       |       |       |      |      |      |       |       | 7.3/4-5 UNS | 50.0     |
| 16          | 3-879-162P  | L0         | 3.25 | 12.99 | 14.25 | 15.74 | 1.10 | 0.17 | 2.51 | 3xM16 | 6xØ17 | 4.1/2-6 UNS | 67.2     |
|             | 3-879-163P  | L1         | 4.12 |       |       |       |      |      | 2.99 |       |       | 6-6 UNS     | 70.1     |
|             | 3-879-164P  | L2         | 5.25 |       |       |       |      |      | 3.50 |       |       | 7.3/4-5 UNS | 71.2     |
| 20          | 3-879-204P  | L2         | 5.25 | 16.53 | 18.03 | 19.68 | 1.14 | 0.17 | 3.50 | 3xM16 | 6xØ17 | 7.3/4-5 UNS | 220.4    |



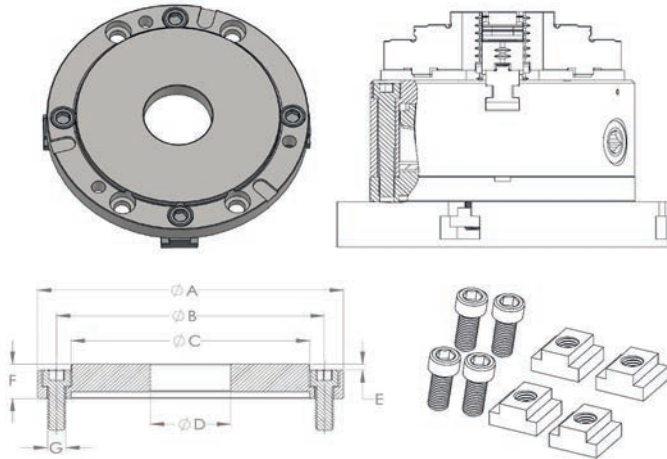
## Type C (DIN 55027) Steel Backplates for Precision Scroll Chucks

- Designed for use with TMX Precision Scroll Chucks
- All backplates come with spindle mounting bolts
- All backplates are made of hardened steel
- Backplates are fully machined

| Chuck Dia D | Item Number | Taper Size | A     | Bh4   | C     | D1    | Thru-Hole (E) | G    | G1   | S1    | S2     | Wt (lbs) |
|-------------|-------------|------------|-------|-------|-------|-------|---------------|------|------|-------|--------|----------|
| 4           | 3-921-043P  | 3          | 2.02  | 2.75  | 3.26  | 3.93  | 2.77          | 0.78 | 0.09 | 6xM8  | 3x8.4  | 1.9      |
| 5           | 3-921-053P  | 3          | 2.02  | 3.74  | 4.25  | 4.92  | 2.95          | 0.78 | 0.13 | 3xM8  | 3x8.4  | 3.5      |
|             | 3-921-054P  | 4          | 2.39  |       |       |       | 3.34          | 0.86 |      |       |        | 3.0      |
| 6           | 3-921-063P  | 3          | 2.02  | 4.92  | 5.51  | 6.29  | 2.95          | 0.86 | 0.13 | 3xM10 | 6x10.5 | 5.7      |
|             | 3-921-064P  | 4          | 2.39  |       |       |       | 3.34          |      |      |       |        | 5.5      |
|             | 3-921-065P  | 5          | 3.12  |       |       |       | 4.12          |      |      |       |        | 4.8      |
|             | 3-921-066P  | 6          | 4.05  |       |       |       | 5.25          |      |      |       |        | 4.1      |
| 8           | 3-921-084P  | 4          | 2.39  | 6.29  | 6.92  | 7.87  | 3.34          | 0.86 | 0.13 | 3xM10 | 6x10.5 | 9.0      |
|             | 3-921-085P  | 5          | 3.12  |       |       |       | 4.12          |      |      |       |        | 7.7      |
|             | 3-921-086P  | 6          | 4.05  |       |       |       | 5.25          |      |      |       |        | 7.9      |
| 10          | 3-921-105P  | 5          | 3.12  | 7.87  | 8.81  | 9.84  | 4.125         | 1.10 | 0.17 | 3xM12 | 6x13.0 | 17.8     |
|             | 3-921-106P  | 6          | 4.05  |       |       |       | 5.25          |      |      |       |        | 16.7     |
|             | 3-921-108P  | 8          | 5.35  |       |       |       | 6.74          |      |      |       |        | 14.7     |
| 12          | 3-921-126P  | 6          | 4.05  | 10.23 | 11.25 | 12.40 | 5.25          | 1.29 | 0.17 | 3xM16 | 6x17.0 | 33.2     |
|             | 3-921-128P  | 8          | 5.35  |       |       |       | 6.74          |      |      |       |        | 30.8     |
|             | 3-921-129P  | 11         | 7.59  |       |       |       | 9.25          |      |      |       |        | 26.8     |
| 16          | 3-921-166P  | 6          | 4.05  | 12.99 | 14.25 | 15.74 | 5.25          | 1.41 | 0.17 | 3xM16 | 6x17.0 | 62.1     |
|             | 3-921-168P  | 8          | 5.35  |       |       |       | 6.74          |      |      |       |        | 59.3     |
|             | 3-921-169P  | 11         | 7.59  |       |       |       | 9.25          |      |      |       |        | 54.4     |
| 20          | 3-921-208P  | 8          | 5.35  | 16.53 | 18.03 | 19.68 | 6.74          | 1.41 | 0.17 | 3xM16 | 6x17.0 | 97.6     |
|             | 3-921-209P  | 11         | 7.59  |       |       |       | 9.25          |      |      |       |        | 92.8     |
|             | 3-921-210P  | 15         | 11.07 |       |       |       | 13            |      |      |       |        | 78.7     |
| 25          | 3-921-258P  | 8          | 5.35  | 21.45 | 23.07 | 24.80 | 6.74          | 1.65 | 0.23 | 3xM16 | 6x17.0 | 186.9    |
|             | 3-921-259P  | 11         | 7.59  |       |       |       | 9.25          |      |      |       |        | 180.5    |
|             | 3-921-260P  | 15         | 11.07 |       |       |       | 13            |      |      |       |        | 163.1    |
| 32          | 3-921-329P  | 11         | 7.59  | 14.96 | 13    | 14.96 | 9.25          | 1.77 | -    | 6xM24 | -      | 94.7     |
|             | 3-921-330P  | 15         | 11.07 |       |       |       | 13            |      |      |       |        | 71.2     |

## Steel Baseplates for 3-Jaw Front Mount Precision Scroll Chucks

- Designed for TMX Front Mount Self-Centering
- Precision Scroll Chucks (Chuck part numbers start with 3-813 and 3-814)
- Ideal for use on milling and drilling machines as well as on rotary tables with 3/6 and 4/8 slots
- Base plates are supplied with four mounting bolts with T-nuts
- Chucks are sold separately



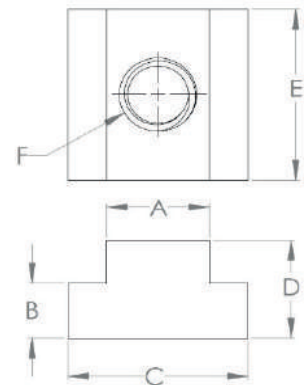
### Base Plate

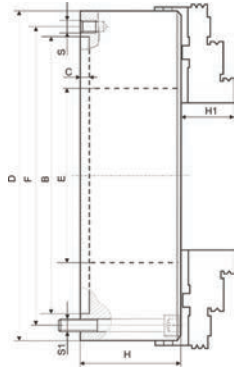
| Chuck Dia D | Base Plate  |       |       |       |      |               |      |               | Chuck Mounting Bolt | Chuck Part Number |
|-------------|-------------|-------|-------|-------|------|---------------|------|---------------|---------------------|-------------------|
|             | Item Number | A     | B     | C     | D    | Thru-Hole (E) | F    | G             |                     |                   |
| 6           | 3-872-306P  | 6.29  | 5.51  | 4.92  | 1.65 | 0.13          | 0.78 | 4x 3/8-16 UNC | 3x M10x1.5          | 3-813-0600P       |
| 8           | 3-872-308P  | 7.87  | 6.92  | 6.29  | 2.16 |               | 0.86 |               |                     | 3-813-0800P       |
| 10          | 3-872-310P  | 9.84  | 8.81  | 7.87  | 2.99 | 0.17          | 0.98 | 4x 1/2-13 UNC | 3x M12x1.75         | 3-813-1000P       |
| 12          | 3-872-312P  | 12.40 | 11.25 | 10.23 | 4.05 |               | 1.18 |               |                     | 3-813-1200P       |
| 16          | 3-872-316P  | 15.74 | 14.25 | 12.99 | 5.35 |               | 1.25 | 4x 5/8-11 UNC | 3x M16x2.0          | 3-813-1600P       |
| 20          | 3-872-320P  | 19.68 | 18.03 | 16.53 | 7.48 |               | 1.37 | 4x 3/4-10 UNC |                     | 6x M16x2.0        |

### T-Slot Nut

| Chuck Dia D | T-Slot Nut  |      |      |      |      |               |               |
|-------------|-------------|------|------|------|------|---------------|---------------|
|             | Item Number | A    | B    | C    | D    | Thru-Hole (E) | F (in)*       |
| 6           | 3-706-3816  | 0.50 | 0.28 | 0.87 | 0.50 | 0.87          | 4x 3/8-16 UNC |
| 8           |             |      |      |      |      |               |               |
| 10          | 3-706-1213  | 0.62 | 0.34 | 1.00 | 0.62 | 1.12          | 4x 1/2-13 UNC |
| 12          |             |      |      |      |      |               |               |
| 16          | 3-706-5811  | 0.68 | 0.43 | 1.12 | 0.75 | 1.25          | 4x 5/8-11 UNC |
| 20          | 3-706-3410  | 0.87 | 0.56 | 1.50 | 1.00 | 1.50          | 4x 3/4-10 UNC |

F\* - T-Nut is fully threaded.





## Extra Large Thru-Hole Precision Scroll Chucks

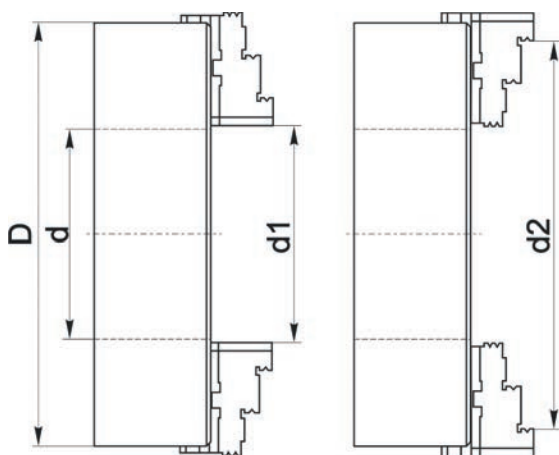
3-Jaw – Self-Centering

- Forged Steel Body
- Designed for pipe machining or pipe welding cut-off operations
- Front and Back Mount - Can be used on lathes, rotary tables and welding devices

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Set of Soft Long Jaws
- 1 Chuck Wrench
- Eyebolt

| Chuck Dia D | Item Number | B     | C    | Thru-Hole (E) | F     | H    | H1   | S     | S1    | Max RPMs | Gripping Force (daN) | Wt (lbs) |
|-------------|-------------|-------|------|---------------|-------|------|------|-------|-------|----------|----------------------|----------|
| 12          | 3-819-1200P | 10.23 | 0.19 | 5.70          | 11.26 | 3.81 | 2.24 | 3xM16 | 3xM16 | 1400     | 5500                 | 103      |
| 16          | 3-819-1600P | 14.25 | 0.23 | 8.66          | 15.00 | 4.13 | 2.63 | 6xM12 | 6xM12 | 1000     | 6500                 | 143      |
| 20          | 3-819-2000P | 18.18 | 0.31 | 12.60         | 18.95 | 4.48 | 3.15 | 6xM16 | 6xM16 | 800      | 7200                 | 264      |
| 26          | 3-819-2600P | 22.83 | 0.27 | 15.98         | 24.40 | 5.31 | 3.42 | 6xM16 | 6xM16 | 600      | 7700                 | 508      |



## Clamping Ranges

| Item Number | d     | d1          | d2    |
|-------------|-------|-------------|-------|
| 3-819-1200P | 5.70  | 1.57-5.70   | 12.40 |
| 3-819-1600P | 8.66  | 5.43-8.66   | 15.98 |
| 3-819-2000P | 12.59 | 10.39-12.59 | 20.31 |
| 3-819-2600P | 15.98 | 13.74-15.98 | 24.8  |

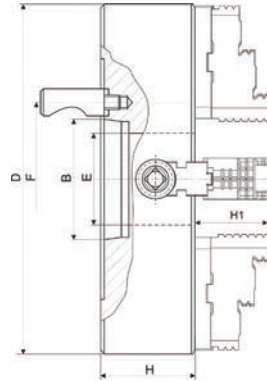
## Independent Chucks

### 4-Jaw Plain Back

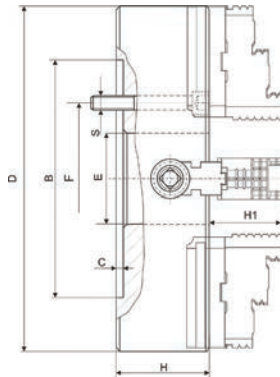
- Forged Steel Body
- Operating screws are hardened and ground
- Comes standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Chucks 10" and larger have T-Slots

### Each Chuck Provided With

- 2-Piece Jaw Chucks
  - 1 Set of Reversible Hard Master Jaws
  - 1 Set of Reversible Hard Top Jaws
- Solid Jaw Chucks
  - 1 Set Each Solid ID and OD Jaws
- 1 Chuck Wrench
- 1 Set of Mounting Bolts
- Eyebolts for chucks 16" and larger

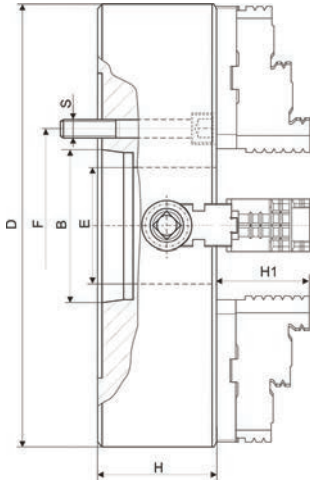


Type I



Type II

| Chuck Dia D | Item Number | Jaw Type | Type | B     | Thru-Hole (E) | C    | F    | H    | H1/H2 | S     | Max RPMs | Wt (lbs) |
|-------------|-------------|----------|------|-------|---------------|------|------|------|-------|-------|----------|----------|
| 4           | 3-855-0401P | Solid    | I    | 3.12  | 0.98          | 0.09 | 2.12 | 1.57 | 0.67  | 4xM8  | 3800     | 6        |
| 5           | 3-855-0501P |          |      | 2.74  | 1.02          |      |      | 1.69 | 0.79  |       | 3500     |          |
| 6           | 3-855-0601P |          |      | 3.25  | 1.65          |      | 2.75 | 1.69 | 0.79  | 4xM10 | 3200     | 11       |
| 8           | 3-855-0800P | 2pc      | II   | 4.33  | 1.96          | 0.19 | 3.25 | 2.85 | 1.82  | 4xM10 | 2500     | 38       |
| 10          | 3-855-1000P |          |      | 5.90  | 2.55          | 0.27 | 4.12 | 3.05 | 2.37  | 4xM12 | 2000     | 58       |
| 12          | 3-855-1200P |          |      | 6.88  | 3.14          |      | 5.25 | 3.42 | 2.39  | 4xM16 | 1500     | 107      |
| 16          | 3-855-1600P |          |      | 7.87  | 3.93          | 0.39 | 6.74 | 3.62 | 2.84  |       | 1100     | 189      |
| 20          | 3-855-2000P |          |      | 10.62 | 4.92          | 0.47 | 9.25 | 4.21 | 3.85  | 4xM20 | 700      | 333      |
| 25          | 3-855-2500P |          |      | 6.29  | 5.00          |      |      | 550  |       |       | 633      |          |
| 32          | 3-855-3200P |          |      | 9.84  | 5.31          | 0.19 | 8.66 | 4.92 | 3.30  | 8xM24 | 764      | 990      |
| 36          | 3-855-3600P |          |      | 5.51  | 5.31          |      |      | 679  |       |       | 1350     |          |
| 40          | 3-855-4000P |          |      | 5.90  | 5.51          | 0.27 | 9.84 | 5.51 | 3.58  |       | 611      | 1740     |
| 48          | 3-855-4800P |          |      | 5.70  | 5.90          |      |      | 509  |       |       | 2300     |          |
| 55          | 3-855-5500P | 6.29     | 6.49 | 437   | 3530          |      |      |      |       |       |          |          |
| 60          | 3-855-6000P | 8xM30    | 407  | 4320  |               |      |      |      |       |       |          |          |



## Type A2 Direct Mount Independent Chucks

4-Jaw – No Need for Machining - No Adapter Plate Required

- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Chucks 10" and above have T-Slots (for detailed specifications see page 11)

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Set of Mounting Bolts
- 1 Chuck Wrench
- Eyebolts for chucks 16" and larger

| Chuck Dia D | Item Number | Taper Size | B     | Thru-Hole (E) | F     | H    | H1   | S      | Max RPM | Wt (lbs) |
|-------------|-------------|------------|-------|---------------|-------|------|------|--------|---------|----------|
| 8           | 3-856-0816P | A2-6       | 4.18  | 1.96          | 5.25  | 2.85 | 1.77 | 4xM12  | 2500    | 38       |
| 10          | 3-856-1016P | A2-6       | 4.18  | 2.55          | 5.25  | 3.05 | 2.05 | 4xM12  | 2000    | 58       |
|             | 3-856-1018P | A2-8       | 5.50  |               | 6.74  |      |      | 4xM16  |         |          |
| 12          | 3-856-1216P | A2-6       | 4.18  | 3.14          | 5.25  | 3.42 | 2.24 | 8xM12  | 1500    | 107      |
|             | 3-856-1218P | A2-8       | 5.50  |               | 6.74  |      |      | 4xM16  |         |          |
| 16          | 3-856-1616P | A2-6       | 4.18  | 3.93          | 5.25  | 3.62 | 2.63 | 8xM12  | 1100    | 189      |
|             | 3-856-1618P | A2-8       | 5.50  |               | 6.74  |      |      | 4xM16  |         |          |
|             | 3-856-1619P | A2-11      | 7.75  |               | 9.25  |      |      | 4xM20  |         |          |
| 20          | 3-856-2018P | A2-8       | 5.50  | 4.92          | 6.74  | 4.21 | 3.14 | 8xM16  | 700     | 333      |
|             | 3-856-2019P | A2-11      | 7.75  |               | 9.25  |      |      | 8xM20  |         |          |
|             | 3-856-2020P | A2-15      | 11.25 |               | 13.00 |      |      | 4xM24  |         |          |
| 25          | 3-856-2519P | A2-11      | 7.75  | 6.29          | 9.25  | 5.0  | 3.42 | 8xM20  | 550     | 633      |
|             | 3-856-2520P | A2-15      | 11.25 |               | 13.00 |      |      | 4xM24  |         |          |
| 28          | 3-856-2811P | A2-11      | 7.75  | 4.72          | 9.25  | 4.72 | 2.83 | 12xM20 | 873     | 715      |
| 32          | 3-856-3211P | A2-11      | 7.75  | 5.31          | 9.25  | 4.92 | 2.83 | 12xM20 | 764     | 990      |
|             | 3-856-3215P | A2-15      | 11.25 |               | 13.00 |      |      | 12xM24 |         |          |
| 36          | 3-856-3611P | A2-11      | 7.75  | 5.51          | 9.25  | 5.31 | 2.83 | 12xM20 | 679     | 1353     |
|             | 3-856-3615P | A2-15      | 11.25 |               | 13.00 |      |      | 12xM24 |         |          |
| 40          | 3-856-4011P | A2-11      | 7.75  | 5.90          | 9.25  | 5.51 | 3.14 | 12xM20 | 611     | 1738     |
|             | 3-856-4015P | A2-15      | 11.25 |               | 13.00 |      |      | 12xM24 |         |          |
|             | 3-856-4020P | A2-20      | 16.25 |               | 18.25 |      |      |        |         |          |
| 48          | 3-856-4811P | A2-11      | 7.75  | 6.29          | 9.25  | 5.70 | 3.14 | 12xM20 | 509     | 2299     |
|             | 3-856-4815P | A2-15      | 11.25 |               | 13.00 |      |      | 12xM24 |         |          |
|             | 3-856-4820P | A2-20      | 16.25 |               | 18.25 |      |      |        |         |          |
| 55          | 3-856-5511P | A2-11      | 7.75  | 6.29          | 9.25  | 5.90 | 3.14 | 12xM20 | 437     | 3531     |
|             | 3-856-5515P | A2-15      | 11.25 |               | 13.00 |      |      | 12xM24 |         |          |
|             | 3-856-5520P | A2-20      | 16.25 |               | 18.25 |      |      |        |         |          |
| 60          | 3-856-6015P | A2-15      | 11.25 | 6.29          | 13.00 | 6.49 | 3.14 | 12xM24 | 407     | 4312     |
|             | 3-856-6020P | A2-20      | 16.25 |               | 18.25 |      |      |        |         |          |

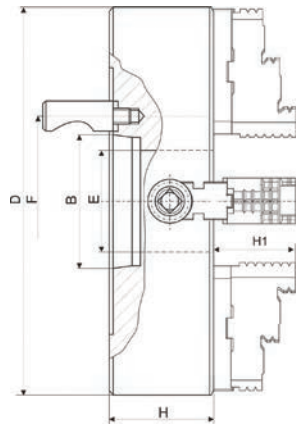
## Type D1 Direct Mount Independent Chucks

4-Jaw – No Need for Machining - No Adapter Plate Required

- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible TMX American Tongue and Groove Jaw System
- Chucks 10" and above have T-Slots (for detailed specifications see page 11)

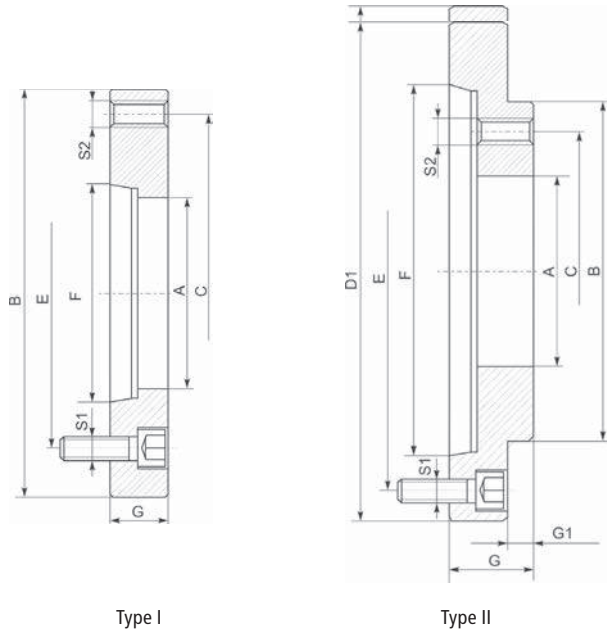
Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench
- 1 Set of Camlock Studs
- 1 Set of Camlock Set Screws
- Eyebolts for chucks 16" and larger



| Chuck Dia D | Item Number | Taper Size | B    | Thru-Hole (E) | F    | H    | H1   | Max RPM | Wt (lbs) | Camlock Studs |          |         |
|-------------|-------------|------------|------|---------------|------|------|------|---------|----------|---------------|----------|---------|
|             |             |            |      |               |      |      |      |         |          | Qty           | Dia (in) | Thread  |
| 8           | 3-857-0833P | D1-3       | 2.12 | 1.96          | 2.78 | 2.85 | 1.77 | 2500    | 38       | 3             | 9/16     | M10x1   |
|             | 3-857-0834P | D1-4       | 2.50 |               | 3.25 |      |      |         |          |               | 5/8      |         |
|             | 3-857-0835P | D1-5*      | 3.25 | 1.97          | 4.13 | 4.31 |      |         | 47       | 6             | 3/4      |         |
|             | 3-857-0836P | D1-6*      | 4.19 |               | 5.25 | 4.31 |      |         | 52       |               | 7/8      |         |
| 10          | 3-857-1036P | D1-6       | 4.18 | 2.55          | 5.25 | 3.09 | 2.05 | 2000    | 58       | 6             | 7/8      | M16x1.5 |
|             | 3-857-1038P | D1-8*      | 5.50 | 2.56          | 6.75 | 4.59 |      |         |          |               | 82       | 1       |
| 12          | 3-857-1236P | D1-6       | 4.18 | 3.15          | 5.25 | 3.42 | 2.24 | 1500    | 107      | 6             | 7/8      | M16x1.5 |
|             | 3-857-1238P | D1-8       | 5.50 |               | 6.74 |      |      |         |          |               | 1        | M20x1.5 |
| 16          | 3-857-1636P | D1-6       | 4.18 | 3.93          | 5.25 | 3.62 | 2.63 | 1100    | 189      | 6             | 7/8      | M16x1.5 |
|             | 3-857-1638P | D1-8       | 5.50 |               | 6.74 |      |      |         |          |               | 1        | M20x1.5 |
|             | 3-857-1639P | D1-11      | 7.75 |               | 9.25 |      |      |         |          |               | 1-3/16   | M22x1.5 |
| 20          | 3-857-2038P | D1-8       | 5.50 | 4.92          | 6.74 | 4.21 | 3.15 | 700     | 333      | 6             | 1        | M20x1.5 |
|             | 3-857-2039P | D1-11      | 7.75 |               | 9.25 |      |      |         |          |               | 1-3/16   | M22x1.5 |
| 25          | 3-857-2538P | D1-8       | 5.50 | 6.29          | 6.74 | 5.00 | 3.42 | 550     | 633      | 6             | 1        | M20x1.5 |
|             | 3-857-2539P | D1-11      | 7.75 |               | 9.25 |      |      |         |          |               | 1-3/16   | M22x1.5 |

\* Indirect mount chucks

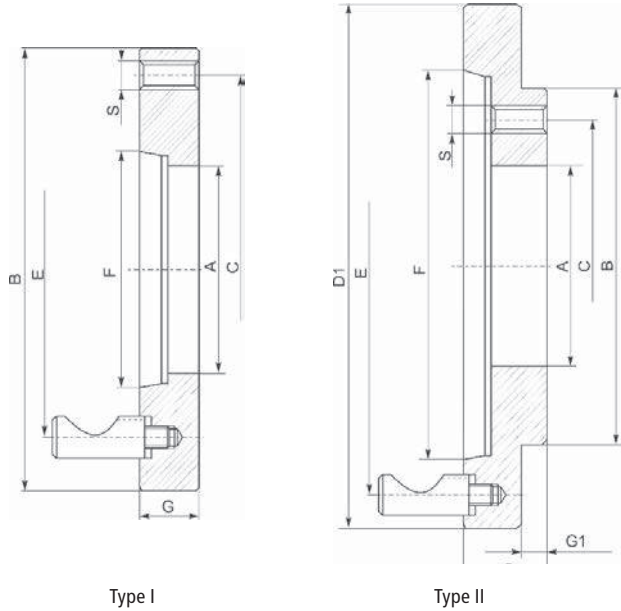


## Independent Chuck Fully Finished A Type Adapters



| Chuck Dia D | Item Number  | Taper Size | Type | A     | B     | C     | D1    | Thru-Hole (E) | G        | G1       | S1        | S2  | Wt (lbs) |
|-------------|--------------|------------|------|-------|-------|-------|-------|---------------|----------|----------|-----------|-----|----------|
| 6           | 3-873-9065P  | A2-5       | II   | 1.65  | 3.25  | 2.75  | 5.23  | 4.12          | 1.39     | 0.11     | 6x7/16-14 | M10 | 6.4      |
|             | 3-873-9084P  | A2-4       | I    | 1.96  | 4.33  | 3.25  | -     | 3.25          | 1.10     | -        | 4x7/16-14 |     | 3.3      |
| 8           | 3-873-9085P  | A2-5       | II   | 1.96  | 4.33  | 3.25  | 5.23  | 4.12          | 1.49     | 0.21     | 4x7/16-14 | M10 | 6.7      |
|             | 3-873-9086P  | A2-6       |      |       |       |       | 6.49  | 5.25          | 1.25     |          | 6x1/2-13  |     | 7.8      |
|             | 3-873-9105P  | A2-5       | I    | 2.55  | 5.90  | 4.12  | -     | 4.12          | 1.06     | -        | 8x7/16-14 | M12 | 6.2      |
| 10          | 3-873-9106P  | A2-6       | II   | 2.55  | 5.90  | 4.12  | 6.49  | 5.25          | 1.57     | 0.29     | 6x1/2-13  | M12 | 10.2     |
|             | 3-873-9108P  | A2-8       |      |       |       |       | 8.26  | 6.74          | 1.49     |          | 6x5/8-11  |     | 15.6     |
|             | 3-873-9125P  | A2-5       | I    | 3.11  | 6.88  | 5.25  | -     | 4.12          | 1.18     | -        | 6x7/16-14 | M16 | 9.8      |
| 12          | 3-873-9126P  | A2-6       | I    | 3.14  | 6.88  | 5.25  | -     | 5.25          | 1.37     | -        | 8x1/2-13  | M16 | 10.4     |
|             | 3-873-9128P  | A2-8       | II   |       |       |       | 8.26  | 6.74          | 1.59     | 0.29     | 6x5/8-11  |     | 16.4     |
|             | 3-873-9129P  | A2-11      |      | 11.02 | 9.25  | 1.92  | -     | 6x3/4-10      | 37.8     |          |           |     |          |
|             | 3-873-9166P  | A2-6       | I    | 4.05  | 7.87  | 6.74  | -     | 5.25          | 1.18     | -        | 6x1/2-13  |     | 11.8     |
| 16          | 3-873-9168P  | A2-8       | I    | 3.93  | 7.87  | 6.74  | -     | 6.74          | 1.39     | -        | 6x5/8-11  | M16 | 12.2     |
|             | 3-873-9169P  | A2-11      | II   |       |       |       | 11.02 | 9.25          | 1.79     | 0.41     | 6x3/4-10  |     | 28.9     |
|             | 3-873-91615P | A2-15      |      | 14.96 | 13.00 | 2.55  | -     | 6x7/8-9       | 88.9     |          |           |     |          |
|             | 3-873-9206P  | A2-6       | I    | 4.05  | 10.62 | 9.25  | -     | 5.25          | 1.18     | -        | 6x1/2-13  |     | M20      |
| 20          | 3-873-9208P  | A2-8       | I    | 4.92  | 10.62 | 9.25  | -     | 6.74          | 1.37     | -        | 6x5/8-11  | M20 | 22.9     |
|             | 3-873-9211P  | A2-11      |      |       |       |       | 9.25  | 1.79          | -        | 6x3/4-10 | 21.8      |     |          |
|             | 3-873-9215P  | A2-15      | II   | 14.96 | 13.00 | 2.04  | 0.49  | 6x7/8-9       | 66.7     |          |           |     |          |
|             | 3-873-92508P | A2-8       | I    | 5.35  | -     | 6.74  | 1.25  | -             | 6x5/8-11 | 23.3     |           |     |          |
| 25          | 3-873-92511P | A2-11      | II   | 6.29  | 10.62 | 9.25  | 11.02 | 9.25          | 1.49     | 0.49     | 6x3/4-10  | M20 | 24.2     |
|             | 3-873-92515P | A2-15      |      |       |       |       | 14.96 | 13.00         | 2.14     |          | 6x7/8-9   |     | 66.7     |
|             | 3-873-92520P | A2-20      |      |       |       |       | 20.47 | 18.25         | 2.36     |          | 6x1-8     |     | 140.0    |
| 32          | 3-873-93211P | A2-11      |      | 7.59  | 14.96 | 13.00 | -     | 9.25          | 1.57     | -        | 6x3/4-10  | M24 | 57.8     |



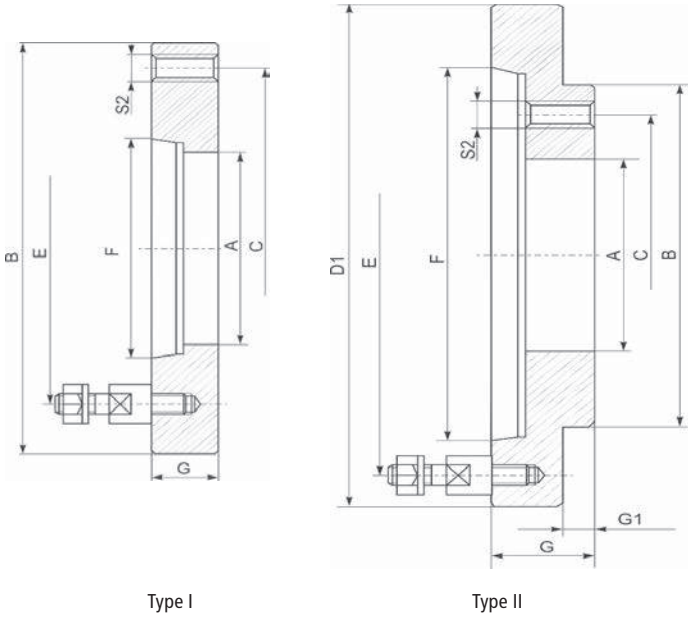


## Independent Chuck Fully Finished D Type Adapters



| Chuck Dia D | Item Number | Taper Size | Type | A    | B     | C    | D1    | Thru-Hole (E) | G    | G1   | S     | Wt (lbs) |
|-------------|-------------|------------|------|------|-------|------|-------|---------------|------|------|-------|----------|
| 6           | 3-878-9064P | 6" D1-4    | II   | 1.65 | 3.25  | 2.75 | 4.72  | 3.25          | 1.96 | 0.11 | M10x4 | 8.2      |
|             | 3-878-9065P | 6" D1-5    |      |      |       |      | 5.74  | 4.12          | 1.51 |      |       | 6.2      |
| 8           | 3-878-9084P | 8" D1-4    | II   | 1.96 | 4.33  | 3.25 | 4.60  | 3.25          | 1.81 | 0.21 | M10x4 | 6.9      |
|             | 3-878-9086P | 8" D1-6    |      |      |       |      | 7.12  | 5.25          | 1.57 |      |       | 14.4     |
| 10          | 3-878-9106P | 10" D1-6   | II   | 2.55 | 5.90  | 4.12 | 7.12  | 5.25          | 1.96 | 0.29 | M12x4 | 18.2     |
| 12          | 3-878-9126P | 12" D1-6   | II   | 3.14 | 6.88  | 5.25 | 7.12  | 5.25          | 2.75 | 0.29 | M16x4 | 25.3     |
| 16          | 3-878-9166P | 16" D1-6   | I    | 3.93 | 7.87  | 6.74 | -     | 5.25          | 1.00 | -    | M16x4 | 15.6     |
|             | 3-878-9168P | 16" D-8    | II   |      |       |      | 8.85  | 6.74          | 2.75 | 0.41 |       | 37.3     |
|             | 3-878-9169P | 16" D-11   |      |      |       |      | 11.73 | 9.25          | 2.36 |      |       | 52.9     |
| 20          | 3-878-9206P | 20" D1-6   | I    | 4.05 | 10.62 | 9.25 | -     | 5.25          | 1.39 | -    | M20x4 | 29.8     |
|             | 3-878-9208P | 20" D1-8   |      | 5.36 |       |      |       | 6.74          | 1.49 |      |       |          |
|             | 3-878-9211P | 20" D-11   | II   | 7.59 |       |      |       | 11.73         | 9.25 |      |       | 1.77     |

## Independent Chuck Fully Finished C Type (DIN 55027) Adapters



| Chuck Dia D | Item Number | Taper Size | Type | A    | Bh4   | C    | D1   | Thru-Hole (E) | F    | G    | G1   | S2  | Wt (lbs) |
|-------------|-------------|------------|------|------|-------|------|------|---------------|------|------|------|-----|----------|
| 6           | 3-921-0660P | 6          | II   | 1.65 | 3.25  | 2.75 | 6.69 | 5.25          | 4.18 | 1.33 | 0.11 | M10 | 6.2      |
| 8           | 3-921-0860P | 6          | II   | 1.96 | 4.33  | 3.25 | 6.69 | 5.25          | 4.18 | 1.33 | 0.21 | M10 | 7.7      |
| 10          | 3-921-1060P | 6          | II   | 2.55 | 5.90  | 4.12 | 6.49 | 5.25          | 4.18 | 1.39 | 0.29 | M12 | 9.7      |
|             | 3-921-1080P | 8          |      |      |       |      | 8.66 | 6.74          | 5.50 | 1.49 |      |     | 14.3     |
| 12          | 3-921-1260P | 6          | I    | 3.15 | 6.89  | 5.25 | -    | 5.25          | 4.18 | 1.29 | -    | M16 | 9.9      |
|             | 3-921-1280P | 8          | II   |      |       |      | 8.26 | 6.74          | 5.50 | 1.59 | 0.29 |     | 20.9     |
| 20          | 3-921-2080P | 8          | I    | 4.92 | 10.63 | 9.25 | -    | 6.74          | 5.50 | 1.18 | -    | M20 | 24.7     |

TMX 5C and 16C collets  
available on [www.tmxtools.com](http://www.tmxtools.com)

## 5C & 16C Collet Chucks

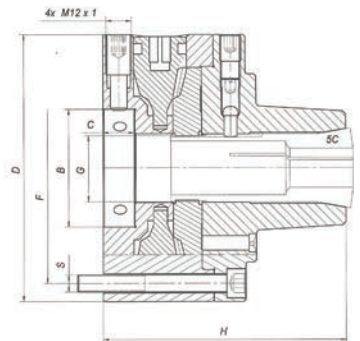
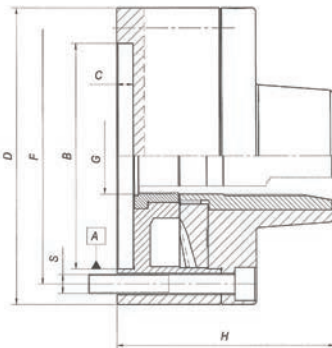
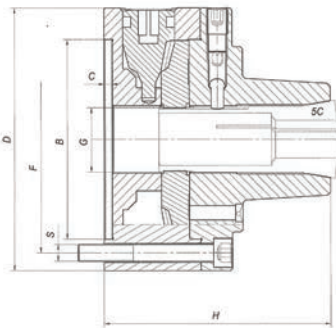
- Forged Steel Body
- All forged steel bodies
- Tru-Length type features fixed collet position for fast and accurate workpiece changes.
- Super Precision SET-TRU™ type offers fine adjustment with 4 micro-adjustment screws for outstanding repeatability



3-862-0501P  
5C Standard

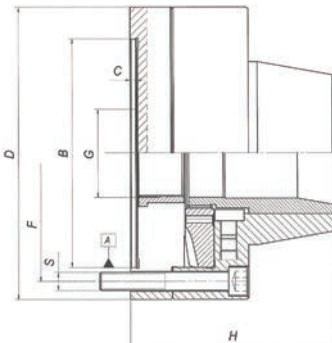
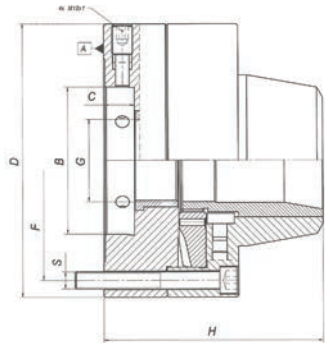
3-862-0503P  
5C TRU-Length

3-862-0505P  
5C Super Precision SET-TRU™



3-862-0605P  
16C Super Precision SET-TRU™  
and TRU-Length

3-862-0601P  
16C TRU-Length



| Chuck Dia D | Item Number | Collet Size | Type                                    | B    | C    | F    | H    | G          | S1       | Max RPM | Wt (lbs)  |
|-------------|-------------|-------------|---|------|------|------|------|------------|----------|---------|-----------|
| 5           | 3-862-0501P | 5C          | Standard                                | 3.74 | 0.15 | 4.25 | 4.23 | 1.239"-20  | 3xM8x65  | 6000    | 10        |
|             | 3-862-0503P |             | TRU-Length                              |      | 0.27 |      | 3.62 | 1.239"-20  |          |         | 11        |
|             | 3-862-0505P |             | Super Precision SET-TRU™                |      | 2.16 |      | 0.59 | 4.48       |          |         | 1.239"-20 |
| 6           | 3-862-0601P | 16C         | TRU-Length                              | 4.92 | 0.15 | 5.51 | 4.50 | M47.5x1.75 | 3xM10x70 | 6000    | 21        |
|             | 3-862-0605P |             | Super Precision SET-TRU™ and TRU-Length | 3.38 | 0.70 |      | 5.05 | M47.5x1.75 |          |         | 3xM8x85   |



## Fully Machined Adapters for Collet Chucks

4-Jaw – No Need for Machining - No Adapter Plate Required

- Designed for use with TMX 5C & 16C Collet Chucks
- All backplates come with spindle mounting bolts
- All backplates are made of hardened steel
- Backplates are fully machined

| Super Precision SET-TRU™ | Standard & Tru-Length | Taper Size | Collet Size |
|--------------------------|-----------------------|------------|-------------|
| 3-874-054P               | -                     | A2-4       | 5C          |
| 3-874-055P               | 3-873-055P            | A2-5       |             |
| 3-874-056P               | 3-873-056P            | A2-6       |             |
| 3-875-053P               | 3-878-053P            | D1-3       |             |
| 3-875-054P               | 3-878-054P            | D1-4       |             |
| 3-875-055P               | 3-878-055P            | D1-5       |             |
| 3-875-056P               | 3-878-056P            | D1-6       |             |
| 3-875-058P               | 3-878-058P            | D1-8       |             |
| 3-879-9051P              | 3-879-051P            | L00        |             |
| 3-876-052P               | 3-871-052P            | 1.1/2-8    |             |
| 3-876-054P               | -                     | 2.3/16-10  |             |
| 3-876-056P               | -                     | 2.1/4-8    |             |

| Super Precision SET-TRU™ | Standard & Tru-Length | Taper Size | Collet Size |
|--------------------------|-----------------------|------------|-------------|
| 3-874-065P               | 3-873-065P            | A2-5       | 16C         |
| 3-874-066P               | 3-873-066P            | A2-6       |             |
| 3-875-063P               | 3-878-063P            | D1-3       |             |
| 3-875-064P               | 3-878-064P            | D1-4       |             |
| 3-875-065P               | 3-878-065P            | D1-5       |             |
| 3-875-066P               | 3-878-066P            | D1-6       |             |
| 3-875-068P               | -                     | D1-8       |             |
| 3-879-9061P              | 3-879-061P            | L00        |             |
| 3-879-9062P              | 3-879-062P            | L00        |             |
| 3-876-062P               | 3-871-062P            | 1.1/2-8    |             |
| 3-876-064P               | -                     | 2.3/16-10  |             |
| 3-876-066P               | 3-871-063P            | 2.1/4-8    |             |

# Oil Country Chucks

LARGE DIAMETER,  
EXTRA HEAVY DUTY



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## Oil Country Chucks

TMX Oil Country Chucks are specifically designed for rigorous use in the oil and gas industry where large thru-holes and high gripping forces are required for holding tubes and pipes. With 3-Jaw Scroll Chucks, 4-Jaw Independent Chucks, extra-large thru-holes and expanded sizes, TMX has a chuck available for any energy sector application.

- Made in Europe
- All Forged-Steel Bodies
- 2 year quality and performance warranty

### Heavy Duty Construction

- TMX Oil Country Chucks are a perfect fit for the high use, high demands seen in oil and gas operations

### Extra Heavy Duty TMX American Tongue and Groove Jaw System

- Both top and master jaws have fine serrated matching surfaces to expand total gripping area, maximize gripping force and help reduce workpiece slippage

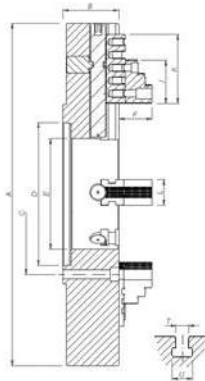
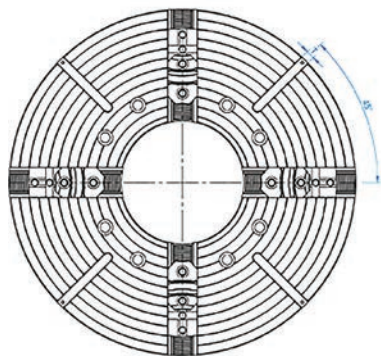
### Exceptional Accuracy

- The high gripping power and the rigidity of the chuck body along with robust jaws contributes to superior accuracy and repeatability providing higher tolerances on workpieces and greater RPMs

### Available Options

- 3-Jaw Scroll and 4-Jaw Independent Chucks
- Direct Mount for A2 and D1 Spindles
- Large Bore (Thru-Hole) Options
- 16-40" standard with larger sizes upon request
- Plain Back chucks available upon request
- All chucks have T-slots (for detailed specifications see page 11)
- Extra-Large Bore (Thru-Hole) options





## 4-Jaw Extra Heavy Duty Independent Chucks

Type A2 Direct Mount, Extra Large Thru-Hole

- Type A Direct Mount – No need for machining, no backplate required
- All forged steel bodies are hardened to 28 HRC providing improved durability and rigidity
- Hardened and ground operating screws
- Extra Heavy Duty 2 piece Hard Reversible American Standard Tongue and Groove jaws are made of high quality alloy steel then hardened
- Gripping surfaces serrated for more holding power
- Large Thru-Hole
- All chucks have T-Slots (for detail specifications see page 11)
- Made in Europe

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Set of Mounting Bolts
- 1 Chuck Wrench
- Eyebolt

| A<br>Ø<br>Dia | Spindle<br>Mount | Item<br>Number | B     | C     | D     | Thru-<br>Hole<br>(E) | F     | J | K    | L    | T    | T-<br>Slots | M   | Max<br>RPM | Max Torque<br>on Key<br>Da.N.M | Gripping<br>Force<br>(daN) | Wt<br>(lbs)* |
|---------------|------------------|----------------|-------|-------|-------|----------------------|-------|---|------|------|------|-------------|-----|------------|--------------------------------|----------------------------|--------------|
| 18            | A2-11            | 3-859-1811P    | 5.75  | 9.25  | 7.75  | 6.73                 | 3.270 | 5 | 6.5  | 2.36 | 0.71 | 4x18        | Ø40 | 1350       | 40                             | 2750                       | 230          |
|               | A2-15            | 3-859-1815P    |       | 13.00 | 11.25 | 7.28                 |       |   |      |      |      |             |     |            |                                |                            |              |
| 21            | A2-11            | 3-859-2111P    | 5.75  | 9.25  | 7.75  | 7.56                 | 3.270 | 5 | 6.5  | 2.36 | 0.71 | 4x18        | Ø40 | 1150       | 50                             | 3125                       | 470          |
|               | A2-15            | 3-859-2115P    |       | 13.00 | 11.25 | 7.28                 |       |   |      |      |      |             |     |            |                                |                            |              |
| 24            | A2-11            | 3-859-2411P    | 6.10  | 9.25  | 7.75  | 7.56                 | 3.620 | 5 | 7.99 | 2.95 | 0.87 | 4x22        | Ø50 | 1019       | 60                             | 3750                       | 661          |
|               | A2-15            | 3-859-2415P    |       | 13.00 | 11.25 | 11.06                |       |   |      |      |      |             |     |            |                                |                            |              |
|               | A2-20            | 3-859-2420P    |       | 18.25 | 16.25 | 12.6                 |       |   |      |      |      |             |     |            |                                |                            |              |
| 28            | Recessed         | 3-859-2800P    | 6.30  | 20.50 | 22    | 16                   | 3.740 | 5 | 7.99 | 2.95 | 0.87 | 4x22        | Ø50 | 873        | 60                             | 3750                       | 825          |
|               | A2-15            | 3-859-2815P    | 6.10  | 13.00 | 11.25 | 10.51                | 3.620 |   |      |      |      |             |     |            |                                |                            |              |
|               | A2-20            | 3-859-2820P    | 18.25 | 16.25 | 12.6  |                      |       |   |      |      |      |             |     |            |                                |                            |              |
| 32            | A2-15            | 3-859-3215P    | 6.50  | 13.00 | 11.25 | 10.51                | 3.620 | 5 | 7.99 | 2.95 | 0.87 | 4x22        | Ø50 | 764        | 70                             | 4750                       | 1191         |
|               | A2-20            | 3-859-3220P    |       | 18.25 | 16.25 | 12.6                 |       |   |      |      |      |             |     |            |                                |                            |              |
|               | A2-20            | 3-859-3222P    |       |       |       | 14.75                |       |   |      |      |      |             |     |            |                                |                            |              |
| 36            | A2-15            | 3-859-3615P    | 6.50  | 13.00 | 11.25 | 11.06                | 3.620 | 5 | 7.99 | 2.95 | 0.87 | 4x22        | Ø50 | 679        | 70                             | 4750                       | 1543         |
|               | A2-20            | 3-859-3620P    |       | 18.25 | 16.25 | 14.56                |       |   |      |      |      |             |     |            |                                |                            |              |
| 40            | Recessed         | 3-859-4000P    | 6.50  | 31.50 | 27.56 | 22                   | 3.820 | 5 | 7.76 | 2.92 | 0.87 | 4x22        | Ø50 | 611        | 70                             | 4750                       | 1800         |
|               | A2-15            | 3-859-4015P    |       | 18.25 | 16.25 | 14.56                | 3.620 |   |      |      |      |             |     |            |                                |                            |              |
|               | A2-20            | 3-859-4020P    |       | 13.00 | 11.25 | 10.51                |       |   |      |      |      |             |     |            |                                |                            |              |
|               | A2-28            | 3-859-4028P    |       | 25.50 | 16.25 | 20.87                |       |   |      |      |      |             |     |            |                                |                            |              |

All dimensions in inches (in) unless otherwise specified. \*Weights are approximate.

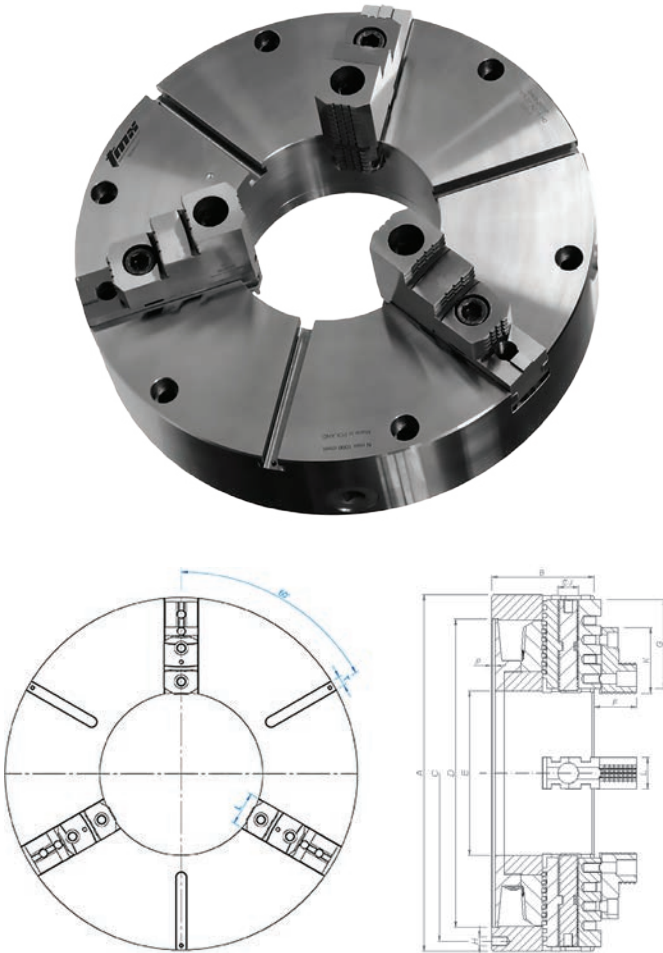
## 3-Jaw Extra Heavy Duty Scroll Chucks

Type A2 Mount, Extra Large Thru-Hole

- Type A Direct Mount – No need for machining, no backplate required
- All forged steel bodies are hardened to 28 HRC providing improved durability and rigidity
- All bearing surfaces are carefully hardened and machined at high tolerances. Each scroll is balanced.
- Extra Heavy Duty 2 piece Hard Reversible American Standard Tongue and Groove jaws are made of high quality alloy steel then hardened
- Gripping surfaces serrated for more holding power
- Large Thru-Hole
- All chucks have T-Slots (for detail specifications see page 11)
- Made in Europe

Each Chuck Provided With

- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Set of Mounting Bolts
- 1 Chuck Wrench
- Eyebolt



| Ø Dia A | Spindle Mount | Item Number | B    | C     | D     | Thru-Hole (E) | F    | K    | G    | L    | T-Slots | Max RPM | Max Torque on key Da.N.m | Gripping Force (daN) | Wt (lbs)* |
|---------|---------------|-------------|------|-------|-------|---------------|------|------|------|------|---------|---------|--------------------------|----------------------|-----------|
| 20      | A2-11         | 3-825-2011P | 5.87 | 9.25  | 7.75  | 7.48          | 3.43 | 5.32 | 6.65 | 2.13 | -       | 1000    | 40                       | 12500                | 560       |
|         | A2-15         | 3-825-2025P |      | 13    | 11.25 | 8.07          |      |      |      |      |         |         |                          |                      | 530       |
| 25      | A2-15         | 3-825-2515P | 6.61 | 13    | 11.25 | 11.06         | 3.27 | 5    | 6.5  | 2.36 | 4x22    | 970     | 40                       | 12500                | 650       |
|         | A2-20         | 3-825-2520P | 6.69 | 14.5  | 16.25 | 12.52         |      |      |      |      |         |         |                          |                      | 650       |
| 28      | A2-15         | 3-825-2815P | 6.81 | 13    | 11.25 | 11.06         | 3.62 | 5    | 7.99 | 2.95 | 4x22    | 873     | 70                       | 13500                | 816       |
|         | A2-20         | 3-825-2820P | 6.89 | 14.5  | 16.25 | 12.52         |      |      |      |      |         |         |                          |                      | 816       |
| 32      | A2-15         | 3-825-3215P | 7.01 | 13    | 11.25 | 11.06         | 3.62 | 5    | 7.99 | 2.95 | 4x22    | 764     | 75                       | 15000                | 992       |
|         | A2-20         | 3-825-3220P | 6.50 | 18.25 | 16.25 | 12.55         |      |      |      |      | 4x23    |         |                          |                      | 1191      |
| 36      | A2-15         | 3-825-3615P | 7.48 | 13    | 11.25 | 11.06         | 3.62 | 5    | 7.99 | 2.95 | 4x22    | 679     | 75                       | 12500                | 1433      |
|         | A2-20         | 3-825-3620P |      | 18.25 | 16.25 | 16.06         |      |      |      |      |         |         |                          |                      | 1433      |
| 40      | A2-20         | 3-825-4020P | 7.48 | 18.25 | 16.25 | 16.06         | 3.62 | 5    | 7.99 | 2.95 | 4x22    | 611     | 90                       | 12000                | 1720      |
|         | A2-28         | 3-825-4028P | 7.64 | 25.5  | 23    | 18.5          |      |      |      |      |         |         |                          |                      | 1720      |



# VTL Chucks

VERTICAL TURNING  
LATHE CHUCKS



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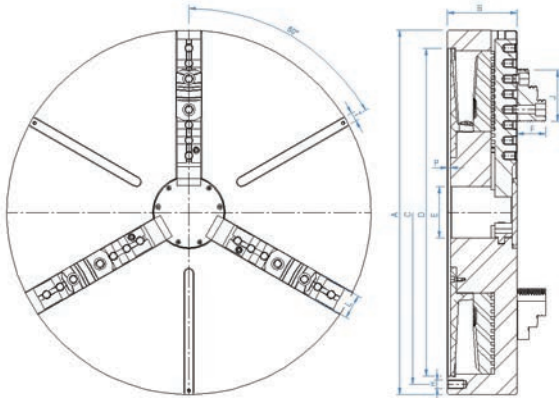
## VTL Chucks

Supplied with wipers, extra-long master jaws, and a center plug to prevent chips and contaminants entering the internal operation of the chuck, these chucks are available in both forged steel body manual and power (hydraulic) execution.

- Made in Europe
- Heavy Duty Steel Bodies
- Fitted with Wiper Seals
- Extended Master Jaws for extra rigidity
- Center Plug seals out chips and containments
- Available in sizes from 25"-80"
- All Chucks come with T-Slots



"Custom Mounting Options" available.



## 3 & 4-Jaw VTL Scroll Chucks

### Self-Centering

- Forged Steel Body
- Heavy Duty Steel Body
- Fitted with Wiper Seals
- Extended Master Jaws for extra rigidity
- Center Plug seals out chips and containments
- T-Slots-All sizes

### Each Chuck Provided With

- 1 Set of Extra-Long Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench

## 3-Jaw Self-Centering VTL Chucks

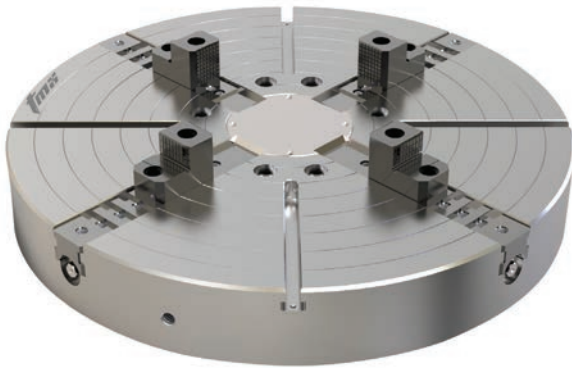
| # of Jaws | A Dia Ø     | Part Number | B     | C     | D     | F     | H     | J    | L    | P    | T-Slots | Max Torque on Key Da.N.M | Gripping Force DAN | Max RPM | Wt* (lbs) | Clamping Range |       |
|-----------|-------------|-------------|-------|-------|-------|-------|-------|------|------|------|---------|--------------------------|--------------------|---------|-----------|----------------|-------|
|           |             |             |       |       |       |       |       |      |      |      |         |                          |                    |         |           | Ø Max          | Ø Min |
| 3         | 28          | 3-826-2800P | 6.38  | 25.98 | 24.80 | 2.80  | 6xM20 | 5.00 | 2.36 | 0.31 | 4x18    | 70                       | 11700              | 873     | 739       | 27.56          | 7.09  |
|           | 32          | 3-826-3200P | 6.57  | 29.92 | 28.74 |       |       |      |      |      |         |                          |                    |         |           | 3.15           |       |
|           | 36          | 3-826-3600P | 6.77  | 33.46 | 31.89 | 7.87  | 6xM22 | 5.12 | 2.95 | 0.39 | 4x18    | 11500                    | 679                | 1246    | 35.43     |                | 7.87  |
|           | 40          | 3-826-4000P | 7.87  | 37.40 | 35.83 |       |       |      |      |      |         |                          |                    |         |           | 3.15           |       |
|           | 48          | 3-826-4800P |       |       |       | 41.34 | 6xM30 | 5.12 | 2.95 | 0.39 | 8x22    | 140                      | 15500              | 509     | 2646      |                | 47.24 |
|           | 52          | 3-826-5200P | 41.34 | 6xM30 | 5.12  |       |       |      |      |      |         |                          |                    |         |           | 2.95           | 0.39  |
|           | 55          | 3-826-5500P |       |       |       | 41.34 | 6xM30 | 5.12 | 2.95 | 0.39 | 8x22    | 140                      | 15500              | 437     | 4079      |                |       |
|           | 63          | 3-826-6300P | 41.34 | 6xM30 | 5.12  |       |       |      |      |      |         |                          |                    |         |           | 2.95           | 0.39  |
| 71        | 3-826-7100P | 41.34       |       |       |       | 6xM30 | 5.12  | 2.95 | 0.39 | 8x22 | 140     | 15500                    | 340                | 9480    | 70.87     |                |       |

All dimensions in inches (in) unless otherwise specified. \*Weights are approximate. "Custom Mounting Options" available.

## 4-Jaw Self-Centering VTL Chucks

| # of Jaws | A Dia Ø | Part Number | B     | C     | D     | F    | H     | J     | L    | P    | T-Slots | Max Torque on Key Da.N.M | Gripping Force DAN | Max RPM | Wt* (lbs) | Clamping Range |       |
|-----------|---------|-------------|-------|-------|-------|------|-------|-------|------|------|---------|--------------------------|--------------------|---------|-----------|----------------|-------|
|           |         |             |       |       |       |      |       |       |      |      |         |                          |                    |         |           | Ø Max          | Ø Min |
| 4         | 28      | 3-842-2800P | 6.38  | 25.98 | 24.80 | 2.80 | 6xM20 | 5.00  | 2.36 | 0.31 | 4x18    | 70                       | 11700              | 873     | 752       | 27.56          | 7.09  |
|           | 32      | 3-842-3200P | 6.57  | 29.92 | 28.74 |      |       |       |      |      |         | 80                       | 12300              | 764     | 915       | 31.50          |       |
|           | 36      | 3-842-3600P | 6.77  | 33.46 | 31.89 |      |       |       |      |      |         | 11500                    | 679                | 1257    | 35.43     |                |       |
|           | 40      | 3-842-4000P | 7.87  | 37.40 | 35.83 | 2.80 | 6xM24 | 5.12  | 2.95 | 0.39 | 4x18    | 140                      | 15500              | 611     | 1609      | 39.37          | 9.45  |
|           | 48      | 3-842-4800P |       |       |       | 509  |       |       |      |      |         |                          |                    | 2712    | 47.24     |                |       |
|           | 52      | 3-842-5200P |       |       |       | 470  |       |       |      |      |         |                          |                    | 1640    | 48.43     |                |       |
|           | 55      | 3-842-5500P |       |       |       | 437  |       |       |      |      |         |                          |                    | 4189    | 55.12     |                |       |
|           | 63      | 3-842-6300P |       |       |       | 382  |       |       |      |      |         |                          |                    | 6327    | 62.99     |                |       |
|           | 71      | 3-842-7100P | 41.34 | 6xM30 | 8x22  | 340  | 9700  | 70.87 |      |      |         |                          |                    |         |           |                |       |

All dimensions in inches (in) unless otherwise specified. \*Weights are approximate. "Custom Mounting Options" available.



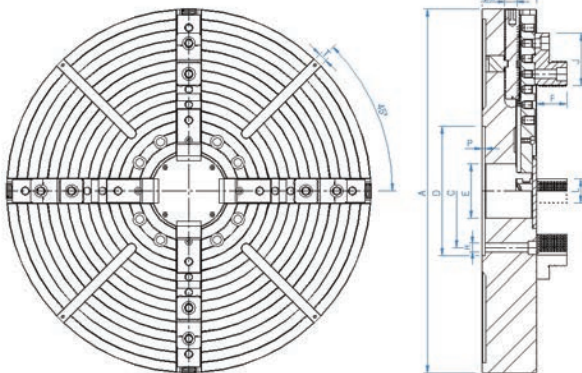
## VTL Independent Chucks

### 4-Jaw – Plain Back and Recessed Mount

- Forged Steel Body
- Heavy Duty Steel Body
- Fitted with Wiper Seals
- Extended Master Jaws for extra rigidity
- Center Plug seals out chips and containments

#### Each Chuck Provided With

- 1 Set of Extra-Long Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench



## Plain Back Independent VTL Chucks

| A Dia<br>Ø | Part Number | B    | C     | D     | F    | H     | J    | L    | M Ø<br>Screw | T-<br>Slots | Max Torque<br>on Key<br>Da.N.M | Gripping<br>Force<br>DAN | Max<br>RPM | Wt*<br>(lbs) | Clamping Range |       |
|------------|-------------|------|-------|-------|------|-------|------|------|--------------|-------------|--------------------------------|--------------------------|------------|--------------|----------------|-------|
|            |             |      |       |       |      |       |      |      |              |             |                                |                          |            |              | Ø Max          | Ø Min |
| 24         | 3-858-2400P | 5.31 | 9.25  | 11.81 | 2.91 | 8xM20 | 5.12 | 2.36 | 40           | 4x22        | 60                             | 4000                     | 970        | 529          | 23.62          | 7.09  |
| 28         | 3-858-2800P |      |       |       |      |       |      |      |              |             |                                |                          | 873        | 838          | 27.56          |       |
| 55         | 3-858-5500P | 6.69 | 18.25 | 20.47 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                             | 6250                     | 437        | 3748         | 55.12          | 9.45  |
| 63         | 3-858-6300P | 7.28 | 25.50 | 28.35 | 4.02 | 8xM30 | 7.09 | 3.54 | 64           | 8x28        | 110                            | 7000                     | 382        | 5732         | 62.99          | 9.45  |
| 71         | 3-858-7100P |      |       |       |      |       |      |      |              |             |                                |                          | 340        | 6900         | 70.87          |       |
| 79         | 3-858-7900P |      |       |       |      |       |      |      |              |             |                                |                          | 7.87       | 306          | 9259           |       |

## 14.96" (380mm) Recessed Mount

| A Dia<br>Ø | Part Number | B    | C     | D     | F    | H     | J    | L    | M Ø<br>Screw | T-<br>Slots | Max Torque<br>on Key<br>Da.N.M | Gripping<br>Force<br>DAN | Max<br>RPM | Wt*<br>(lbs) | Clamping Range |       |
|------------|-------------|------|-------|-------|------|-------|------|------|--------------|-------------|--------------------------------|--------------------------|------------|--------------|----------------|-------|
|            |             |      |       |       |      |       |      |      |              |             |                                |                          |            |              | Ø Max          | Ø Min |
| 32         | 3-858-3200P | 5.31 | 13.00 | 14.96 | 2.91 | 8xM24 | 5.12 | 2.36 | 40           | 4x22        | 70                             | 4500                     | 764        | 1124         | 31.50          | 7.09  |
| 40         | 3-858-4000P | 5.91 | 13.00 | 14.96 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                             | 6250                     | 611        | 1874         | 39.37          | 7.87  |
| 48         | 3-858-4800P | 6.30 | 18.25 | 20.47 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                             | 6250                     | 509        | 2646         | 47.24          | 9.45  |

All dimensions in inches (in) unless otherwise specified. \*Weights are approximate. All above diameters are also available with A type mounts. "Custom Mounting Options" available.



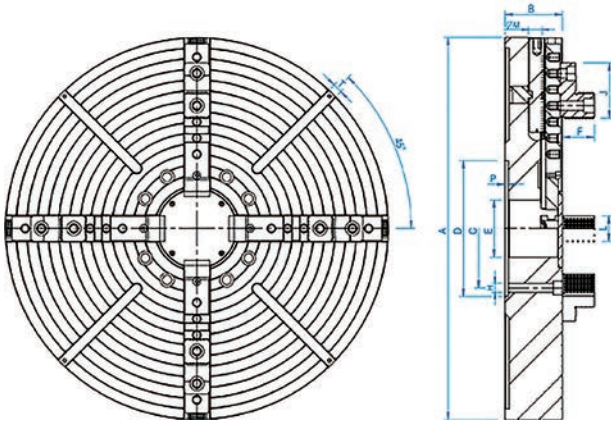
## Type A2 Direct Mount VTL Independent Chucks

4-Jaw – No Adapter Plate Required

- Forged Steel Body
- Fitted with Wiper Seals
- Extended Master Jaws for extra rigidity
- Center Plug seals out chips and containments

Each Chuck Provided With

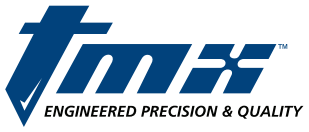
- 1 Set of Extra-Long Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench



All dimensions in inches (in) unless otherwise specified. \*Weights are approximate.

## Type A Direct Mount

| A<br>Dia<br>Ø | Spindle<br>Mount | Part<br>Number | B    | C     | D     | F    | H     | J    | L    | M<br>Ø Screw | T-<br>Slots | Max Torque on<br>Key Da.N.M | Gripping<br>Force DAN | Max<br>RPM | Wt*<br>(lbs) | Clamping Range |       |
|---------------|------------------|----------------|------|-------|-------|------|-------|------|------|--------------|-------------|-----------------------------|-----------------------|------------|--------------|----------------|-------|
|               |                  |                |      |       |       |      |       |      |      |              |             |                             |                       |            |              | Ø Max          | Ø Min |
| 24            | A2-8             | 3-858-2408P    | 5.31 | 9.25  | 11.81 | 2.91 | 8xM20 | 5.12 | 2.36 | 40           | 4x22        | 60                          | 4000                  | 970        | 529          | 23.62          | 7.09  |
|               | A2-11            | 3-858-2411P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 28            | A2-8             | 3-858-2808P    | 5.31 | 9.25  | 11.81 | 2.91 | 8xM20 | 5.12 | 2.36 | 40           | 4x22        | 60                          | 4000                  | 873        | 838          | 27.56          | 7.09  |
|               | A2-11            | 3-858-2811P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 32            | A2-11            | 3-858-3211P    | 5.31 | 13.00 | 14.96 | 2.91 | 8xM24 | 5.12 | 2.36 | 40           | 4x22        | 70                          | 4500                  | 764        | 1124         | 31.50          | 7.09  |
|               | A2-15            | 3-858-3215P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 36            | A2-11            | 3-858-3611P    | 5.31 | 13.00 | 14.96 | 2.91 | 8xM24 | 5.12 | 2.36 | 40           | 4x22        | 70                          | 4500                  | 679        | 1378         | 35.43          | 7.09  |
|               | A2-15            | 3-858-3615P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 40            | A2-11            | 3-858-4011P    | 5.91 | 13.00 | 14.96 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                          | 6250                  | 611        | 1874         | 39.37          | 7.87  |
|               | A2-15            | 3-858-4015P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
|               | A2-20            | 3-858-4020P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 48            | A2-11            | 3-858-4811P    | 6.30 | 18.25 | 20.47 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                          | 6250                  | 509        | 2646         | 47.24          | 9.45  |
|               | A2-15            | 3-858-4815P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
|               | A2-20            | 3-858-4820P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 55            | A2-11            | 3-858-5511P    | 6.69 | 18.25 | 20.47 | 3.07 | 8xM24 | 5.12 | 2.95 | 50           | 4x22        | 90                          | 6250                  | 437        | 3748         | 55.12          | 9.45  |
|               | A2-15            | 3-858-5515P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
|               | A2-20            | 3-858-5520P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 60            | A2-15            | 3-858-6015P    | 6.89 | 25.50 | 28.35 | 3.07 | 8xM30 | 5.12 | 2.95 | 50           | 4x22        | 90                          | 6250                  | 407        | 4718         | 59.06          | 9.45  |
|               | A2-20            | 3-858-6020P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 63            | A2-15            | 3-858-6315P    | 7.28 | 25.50 | 28.35 | 4.02 | 8xM30 | 7.09 | 3.54 | 64           | 8x28        | 110                         | 7000                  | 382        | 5732         | 62.99          | 9.45  |
|               | A2-20            | 3-858-6320P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 71            | A2-15            | 3-858-7115P    | 7.28 | 25.50 | 28.35 | 4.02 | 8xM30 | 7.09 | 3.54 | 64           | 8x28        | 110                         | 7000                  | 340        | 6900         | 70.87          | 9.45  |
|               | A2-20            | 3-858-7120P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
|               | A2-28            | 3-858-7128P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
| 79            | A2-15            | 3-858-7915P    | 7.87 | 25.50 | 28.35 | 4.02 | 8xM30 | 7.09 | 3.94 | 64           | 8x28        | 110                         | 7000                  | 306        | 9259         | 78.74          | 9.45  |
|               | A2-20            | 3-858-7920P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |
|               | A2-28            | 3-858-7928P    |      |       |       |      |       |      |      |              |             |                             |                       |            |              |                |       |



**Notes:**



# Chuck Packages for Rotary Tables, Indexers and Trunnions



## Chuck Packages for Rotary Tables, Indexers and Trunnions

TMX Chuck Packages for Rotary Tables, Indexers and Trunnions offer convenience and productivity of a turn-key bundle that has you machining in no time. We provide the top of the line Forged Steel, 3 Jaw Super Precision SET-TRU® Chuck for increased precision and rigidity, custom made TMX steel adapter for interface between your system and the chuck, as well as all necessary bolts and T-nuts.

Dependent on your application, also available are 3,4 or 6 jaw Super Precision SET-TRU® Chuck, 3 or 4 Jaw Self-Centering, 4 jaw Independent, 5C or 16C Collet chuck configurations.

With TMX chuck packages users will receive all components necessary for conversion without the worry of part compatibility or having to search multiple vendors. We have ability to manufacture chuck packages for all market leading Rotary Tables, Indexers and Trunnions.

TMX Chuck Packages for Rotary Tables, Indexers and Trunnions include:

- Forged Steel Body Chuck
- Mounting Adapter
- Bolts
- T-Nuts

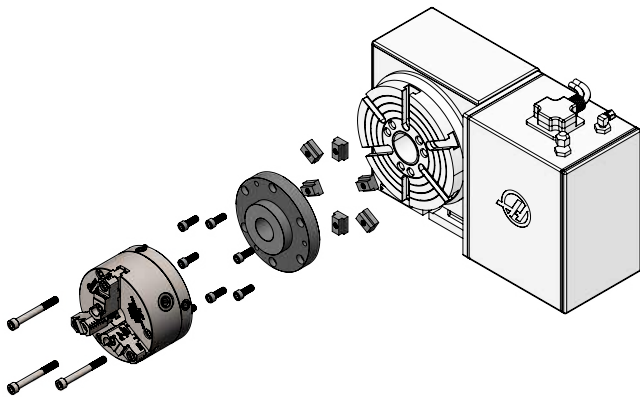


Image courtesy of Haas Automation, Inc.®



Image courtesy of DMG Mori®



Each package contains either a TMX 3, 4 or 6 jaw Super Precision SET-TRU® Chuck, 3 or 4 Jaw Self-Centering, 4 jaw Independent or 5C, 16C Collet chuck configurations

T-Nuts and Mounting Bolts are included



To learn more visit [www.tmxtools.com](http://www.tmxtools.com) and click on Workholding.

# Power Chucks

DESIGNED AND ENGINEERED  
FOR PRECISION



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## Power Chucks

Featuring the quality and precision associated with European manufacturing, TMX Power Chucks are direct, drop-in replacements for all major machine brands including Okuma®, Mazak®, Haas®, Hyundai®, Doosan® and many more. All TMX Power Chucks are designed and engineered in the USA and are backed by a No Hassle, 2-Year Warranty. TMX also offers a full line of off the shelf accessories and supplies.

- ISO certified
- 2 Year Quality and Performance Warranty
- Direct replacements for ALL major brands

### Interchangeable Top Tooling

- 1.5mm x 60° Serrations for chuck diameters up to 18" and 3mm x 60° Serrations for 21" and 24" chucks

### Durable

- Heat treatment is performed to alloy steel along with an improved lubrication system to obtain high accuracy, strength and durability

### High Gripping Force

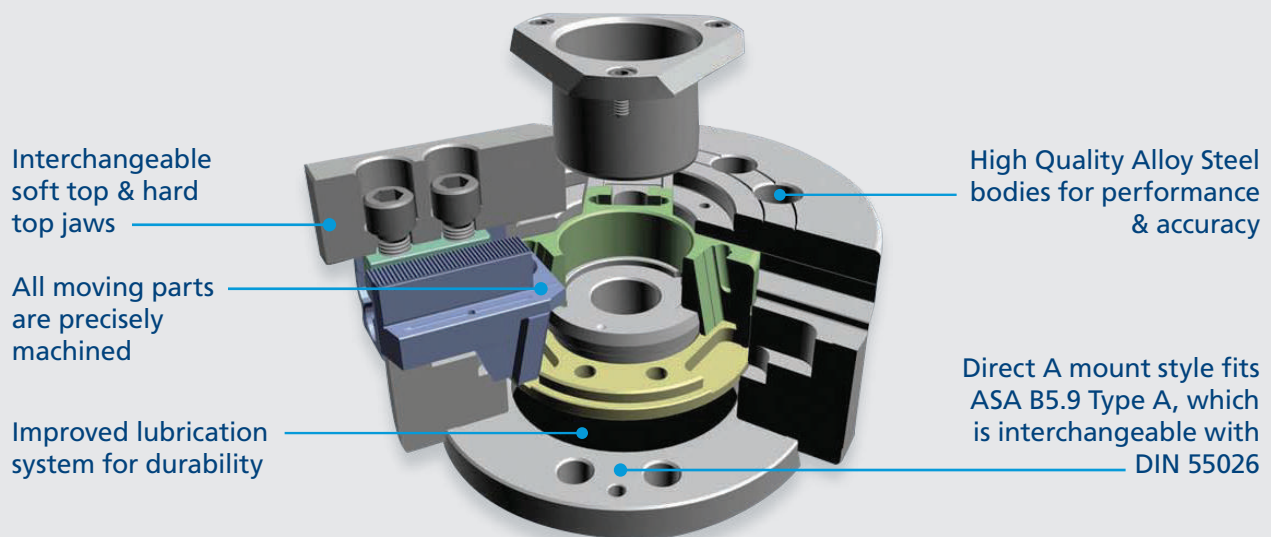
- By increasing dynamic gripping force, work efficiency and safety have been greatly improved

### High Speed

- Strong gripping force, safety and performance are realized by optimal design resulting in higher rotational speeds

### Lightweight

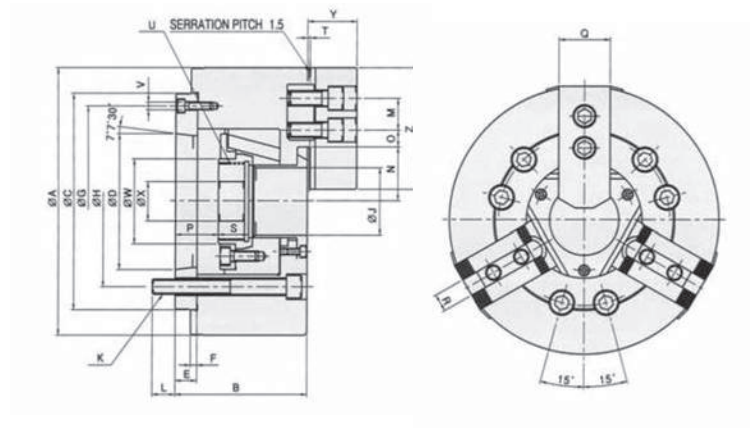
- Equipment load has been reduced by weight reduction, increasing efficiency





## 3-Jaw Large Thru-Hole Direct A2 Mount Chucks

- Fits ASA B5.9 type A (interchangeable with DIN 55026)
- Performance and quality are identical to TMX Large Thru-Hole Chucks [3-780 series]
- Shorter Chuck Replacement Time - replacing and/or changing a chuck can be minimized as run-out accuracy is maintained after mounting



| Chuck Dia D | Part Number | Spindle Nose | WThru Hole | Jaw Stroke | Plunger Stroke | Gripping Dia Max | Gripping Dia Min | Max Permissible Input Force | Max Static Gripping Force | Max Speed | Wt (lbs) | Moment of Inertia |
|-------------|-------------|--------------|------------|------------|----------------|------------------|------------------|-----------------------------|---------------------------|-----------|----------|-------------------|
|             |             |              | in         |            |                |                  |                  | lbf                         |                           | RPM       | lbs      | lbs*ft2           |
| 6           | 3-781-0650  | A2-5         | 1.8110     | 0.2165     | 0.5118         | 6.6535           | 0.5118           | 5512                        | 14167                     | 6000      | 30       | 0.0512            |
| 8           | 3-781-0860  | A2-6         | 2.0472     | 0.2992     | 0.7087         | 8.2677           | 0.4331           | 8995                        | 21159                     | 5000      | 52       | 0.1454            |
| 10          | 3-781-1080  | A2-8         | 3.0315     | 0.3346     | 0.7874         | 10.0000          | 1.2205           | 11244                       | 28088                     | 4200      | 88       | 0.2642            |
| 12          | 3-781-1280  |              | 3.5827     | 0.4016     | 0.9449         | 11.9685          | 1.3386           | 13043                       | 33071                     | 3300      | 141      | 0.6267            |
| 15          | 3-781-1511  | A2-11        | 4.6457     | 0.4173     | 0.9055         | 15.0000          | 1.1811           | 15962                       | 40467                     | 2500      | 280      | 1.9539            |
| 18          | 3-781-1811  |              |            |            |                | 17.7165          |                  |                             |                           | 2000      | 392      | 3.9120            |
| 21          | 3-781-2115  | A2-15        | 5.5118     | 0.4173     | 0.9055         | 20.8661          | 3.4252           | 20233                       | 52606                     | 1700      | 542      | 7.5782            |
| 24          | 3-781-2415  |              | 6.4961     | 0.4094     |                | 24.0157          | 4.3307           |                             |                           | 1400      | 670      | 13.5998           |

## Dimensions

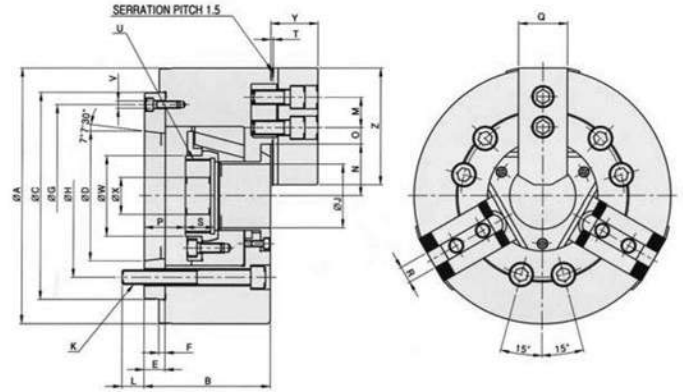
| Chuck Dia D | Part Number | A       | B      | C       | D       | E      | F      | G       | H       | J      | K     | L      | M      | N max  | N min  |
|-------------|-------------|---------|--------|---------|---------|--------|--------|---------|---------|--------|-------|--------|--------|--------|--------|
| 6           | 3-781-0650  | 6.6535  | 3.5433 | 5.5118  | 3.2505  | 0.5906 | 0.1969 | 4.5669  | 4.1260  | 1.8110 | 6-M10 | 0.6299 | 0.7874 | 1.3189 | 1.2087 |
| 8           | 3-781-0860  | 8.2677  | 4.0551 | 6.6929  | 4.1880  | 0.6693 | 0.1969 | 5.9055  | 5.2520  | 2.0472 | 6-M12 | 0.7087 | 0.9843 | 1.6417 | 1.4921 |
| 10          | 3-781-1080  | 10.0000 | 4.4488 | 8.6614  | 5.5007  | 0.7087 | 0.1969 | 7.4803  | 6.7480  | 3.0315 | 6-M16 | 0.9449 | 1.1811 | 2.1457 | 1.9803 |
| 12          | 3-781-1280  | 11.9685 | 5.0000 |         |         |        | 0.2362 |         |         |        |       | 3.5827 |        | 0.9843 | 2.4449 |
| 15          | 3-781-1511  | 15.0000 | 5.8661 | 11.8110 | 7.7507  | 0.8661 | 0.2362 | 10.2362 | 9.2520  | 4.6457 | 6-M20 | 1.1024 | 1.6929 | 3.2283 | 3.0197 |
| 18          | 3-781-1811  | 17.7165 |        | 14.9606 |         |        |        | 12.5984 |         |        |       |        |        |        |        |
| 21          | 3-781-2115  | 20.8661 | 6.3386 | 14.9606 | 11.2510 | 1.0630 | 0.2362 | 13.0000 | 13.0000 | 5.5118 | 6-M22 | 1.3386 | 2.3622 | 3.8780 | 3.6693 |
| 24          | 3-781-2415  | 24.0157 | 6.6929 |         |         |        |        |         |         | 6.4961 |       | 1.3780 |        | 4.2677 | 4.0630 |

| Chuck Dia D | Part Number | O max  | O min  | P max  | P min  | Q      | R      | S      | T      | U max  | V     | W      | X      | Y      | Z      |
|-------------|-------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-------|--------|--------|--------|--------|
| 6           | 3-781-0650  | 0.9055 | 0.3937 | 1.0630 | 0.5512 | 1.2205 | 0.4724 | 0.7480 | 0.0787 | M55x2  | 3-M6  | 2.3622 | 0.7874 | 1.2992 | 2.5984 |
| 8           | 3-781-0860  | 1.0630 |        | 1.3189 | 0.6102 | 1.5354 | 0.5512 | 0.8071 |        | M60x2  |       | 2.5984 | 1.1811 | 1.5354 | 3.3858 |
| 10          | 3-781-1080  | 1.2205 | 0.4724 | 1.0827 | 0.2953 | 1.7323 | 0.6299 | 1.0630 | 0.0787 | M85x2  | 3-M8  | 3.7008 | 1.1811 | 1.7717 | 4.2520 |
| 12          | 3-781-1280  | 1.7717 | 0.5906 | 1.1024 | 0.1575 | 1.9685 | 0.8268 | 1.1024 |        | M100x2 |       | 4.2520 |        | 2.0079 | 4.3701 |
| 15          | 3-781-1511  | 1.7244 | 0.7205 | 1.2992 | 0.3937 | 2.4409 | 0.8661 | 1.5354 | 0.1969 | M130x2 | 3-M10 | 5.4724 | 2.3622 | 2.7559 | 6.4961 |
| 18          | 3-781-1811  | 2.9055 |        |        |        |        |        |        |        |        |       |        |        |        |        |
| 21          | 3-781-2115  | 3.4449 | 0.8465 | 1.4961 | 0.5906 | 2.5591 | 0.9843 | 1.5354 | 0.1969 | M155x3 | 3-M12 | 6.5354 | 3.1496 | 2.8740 | 7.0866 |
| 24          | 3-781-2415  | 4.6260 |        | 1.8504 | 0.9449 |        |        | 1.5748 |        | M175x3 |       | 7.3622 |        |        |        |



### 3-Jaw Extra Large Thru-Hole Direct A2 Mount Chucks

- Fits ASA B5.9 type A (interchangeable with DIN 55026)
- Performance and quality are identical to TMX Large Thru-Hole Chucks [3-770 series]
- Shorter Chuck Replacement Time - replacing and/or changing a chuck can be minimized as run-out accuracy is maintained after mounting
- Extra Large Thru-Hole Chucks enable a broader range of manufacturing such as bar feeder work, tube, pipe, etc.

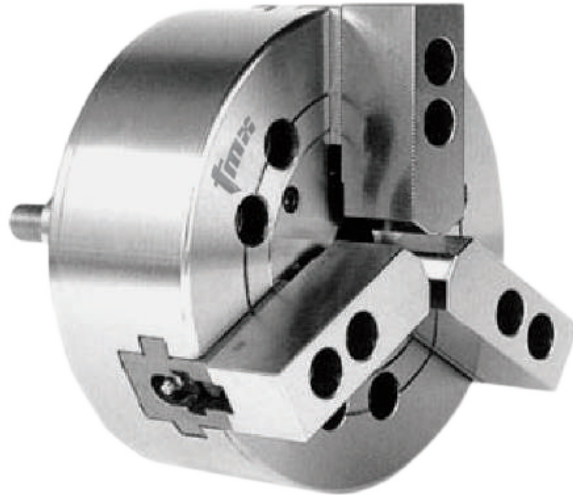


| Chuck Dia D | Part Number | Spindle Nose | Thru Hole | Jaw Stroke | Plunger Stroke | Gripping Dia Max | Gripping Dia Min | Max Permissible Input Force | Max Static Gripping Force | Max Permissible Speed | Wt (lbs) | Moment of Inertia   |
|-------------|-------------|--------------|-----------|------------|----------------|------------------|------------------|-----------------------------|---------------------------|-----------------------|----------|---------------------|
|             |             |              | in        |            |                |                  |                  | lbf                         |                           | RPM                   | lbs      | lbs*ft <sup>2</sup> |
| 6           | 3-771-0650  | A2-5         | 2.0866    | 0.2165     | 0.5118         | 6.6535           | 0.5118           | 5622                        | 14167                     | 6000                  | 30       | 0.0512              |
| 8           | 3-771-0860  | A2-6         | 2.5984    | 0.2992     | 0.7087         | 8.2677           | 0.4331           | 8598                        | 21159                     | 5000                  | 52       | 0.1454              |
| 10          | 3-771-1080  | A2-8         | 3.2283    | 0.3346     | 0.7874         | 10.0000          | 1.2205           | 11244                       | 26986                     | 4200                  | 88       | 0.2642              |

## Dimensions

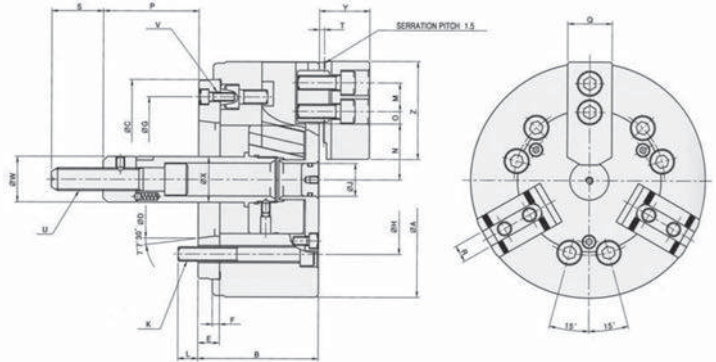
| Chuck Dia D | Part Number | A       | B      | C      | D      | E      | F      | G      | H      | J      | K     | L      | M      | N max  | N min  |
|-------------|-------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|-------|--------|--------|--------|--------|
| 6           | 3-771-0650  | 6.6929  | 3.5827 | 5.5118 | 3.2505 | 0.5906 | 0.1969 | 4.5669 | 4.1260 | 2.0866 | 6-M10 | 0.6299 | 0.7874 | 1.4567 | 1.3480 |
| 8           | 3-771-0860  | 8.2677  | 4.3701 | 6.6929 | 4.1880 | 1.0236 |        | 5.9055 | 5.2520 | 2.5984 | 6-M12 | 0.8268 | 0.9843 | 1.8189 | 1.6693 |
| 10          | 3-771-1080  | 10.0000 | 4.4488 | 8.6614 | 5.5007 | 0.7087 |        | 7.4803 | 6.7480 | 3.2283 | 6-M16 | 0.9449 | 1.1811 | 2.2154 | 2.0551 |

| Chuck Dia D | Part Number | O max  | O min  | P max  | P min  | Q      | R      | S      | T      | U max | V     | W      | X      | Y      | Z      |
|-------------|-------------|--------|--------|--------|--------|--------|--------|--------|--------|-------|-------|--------|--------|--------|--------|
| 6           | 3-771-0650  | 0.8268 | 0.3150 | 1.0630 | 0.5512 | 1.2205 | 0.4724 | 0.7480 | 0.0787 | M60x2 | 3-M6  | 2.5984 | 0.7874 | 1.3189 | 2.8346 |
| 8           | 3-771-0860  | 0.9154 | 0.4035 | 1.2992 | 0.5906 | 1.5354 | 0.5512 | 0.8071 |        | M80x2 | 6-M12 | 3.4646 | 1.1811 | 1.5354 | 3.7402 |
| 10          | 3-771-1080  | 1.2205 | 0.4724 | 1.0827 | 0.2953 | 1.7323 | 0.6299 | 1.0630 |        | M90x2 | 3-M8  | 3.8583 |        | 1.7717 | 4.3307 |



### 3-Jaw Closed Center Chucks

Direct A2 Mount, 6" thru 12"



| Chuck Dia D | Part Number | Spindle Nose | Jaw Stroke | Plunger Stroke | Gripping Dia Max | Gripping Dia Min | Max Permissible Input Force | Max Static Gripping Force | Max Permissible Speed | Weight (lbs) | Moment of Inertia  |
|-------------|-------------|--------------|------------|----------------|------------------|------------------|-----------------------------|---------------------------|-----------------------|--------------|--------------------|
|             |             |              | in         |                |                  |                  | lbf                         |                           | RPM                   | lbs          | lb*ft <sup>2</sup> |
| 6           | 3-761-0650  | A2-5         | 0.3622     | 0.7874         | 6.4961           | 0.7480           | 4273                        | 14167                     | 6000                  | 31           | 0.0410             |
| 8           | 3-761-0860  | A2-6         | 0.3465     | 0.8268         | 8.2677           | 0.9055           | 6297                        | 17990                     | 4800                  | 60           | 0.1208             |
| 10          | 3-761-1080  | A2-8         | 0.3465     | 0.9843         | 10.0000          | 0.9449           | 7309                        | 25861                     | 4100                  | 88           | 0.2683             |
| 12          | 3-761-1280  | A2-8         | 0.4134     | 1.1811         | 11.9685          | 1.0236           | 9332                        | 35306                     | 3400                  | 146          | 0.6165             |

### Dimensions

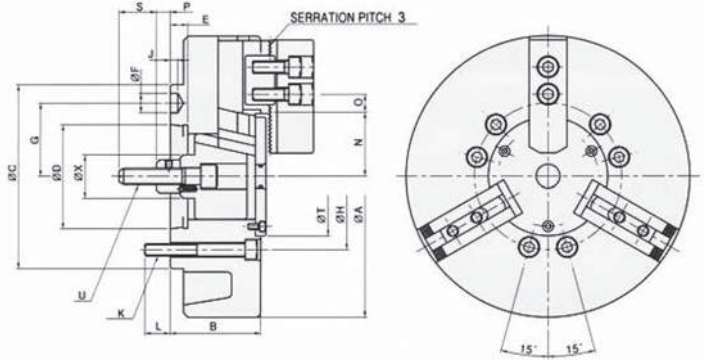
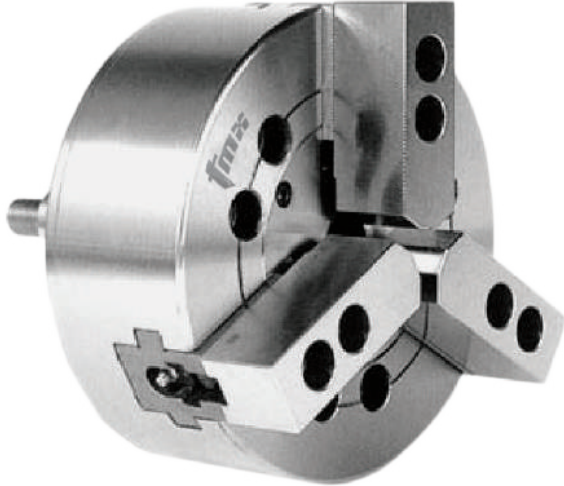
| Chuck Dia D | Part Number | A       | B      | C      | D      | E      | F      | G      | H      | J      | K     | L      | M      | N max  | N min  |
|-------------|-------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|-------|--------|--------|--------|--------|
| 6           | 3-761-0650  | 6.6535  | 3.3071 | 5.5118 | 3.2505 | 0.5906 | 0.1969 | 4.5669 | 4.1260 | 0.9055 | 6-M10 | 0.5512 | 0.7874 | 1.6142 | 1.4449 |
| 8           | 3-761-0860  | 8.2677  | 3.8189 | 6.6929 | 4.1880 | 0.6693 | 0.1969 | 5.9055 | 5.2520 | 1.1024 | 6-M12 | 0.7087 | 0.9843 | 1.8228 | 1.6496 |
| 10          | 3-761-1080  | 10.0000 | 4.0157 | 8.6614 | 5.5007 | 0.7087 | 0.1969 | 7.4803 | 6.7480 | 1.3386 | 6-M16 | 0.9843 | 1.1811 | 2.0118 | 1.8386 |
| 12          | 3-761-1280  | 11.9685 | 4.6457 |        |        |        | 0.2362 |        |        | 1.5354 |       |        |        | 2.4016 | 2.1929 |

| Chuck Dia D | Part Number | O max  | O min  | P max  | P min  | Q      | R      | S      | T      | U max   | V    | W      | X      | Y      | Z      |
|-------------|-------------|--------|--------|--------|--------|--------|--------|--------|--------|---------|------|--------|--------|--------|--------|
| 6           | 3-761-0650  | 0.5118 | 0.2756 | 3.4055 | 2.6181 | 1.2205 | 0.4724 | 1.4173 | 0.1575 | M16x2.0 | 3-M6 | 1.2598 | 1.2598 | 1.3780 | 2.8346 |
| 8           | 3-761-0860  | 0.8858 | 0.3543 | 4.3307 | 3.5039 | 1.5354 | 0.5512 |        | 0.1969 | M20x2.5 |      | 1.4961 | 1.4961 | 1.6929 | 3.7402 |
| 10          | 3-761-1080  | 1.2087 | 0.4409 | 5.5118 | 4.5276 | 1.7323 | 0.6299 | 1.4173 | 0.1969 | M20x2.5 | 3-M8 | 1.4961 | 1.7323 | 1.9685 | 4.3307 |
| 12          | 3-761-1280  | 1.9173 | 0.5000 | 5.7087 |        | 1.9685 | 0.7087 |        |        |         |      |        | 1.9685 | 2.1260 | 4.3701 |



### 3-Jaw Closed Center Chucks

Direct A2 Mount, 15" thru 24"



| Chuck Dia D | Part Number | Spindle Nose | Jaw Stroke | Plunger Stroke | Gripping Dia Max | Gripping Dia Min | Max Permissible Input Force | Max Static Gripping Force | Max Speed | Weight (lbs) | Moment of Inertia   |
|-------------|-------------|--------------|------------|----------------|------------------|------------------|-----------------------------|---------------------------|-----------|--------------|---------------------|
|             |             |              | in         |                |                  |                  | lbf                         |                           | RPM       | lbs          | lbs*ft <sup>2</sup> |
| 15          | 3-761-1508  | A2-8         | 0.7323     | 1.3780         | 15.0000          | 2.3622           | 16399                       | 32797                     | 2100      | 216          | 1.4583              |
|             | 3-761-1511  | A2-11        |            |                |                  |                  |                             |                           |           |              |                     |
| 18          | 3-761-1808  | A2-8         | 0.7323     | 1.3780         | 17.9921          | 2.3622           | 16399                       | 32797                     | 1700      | 291          | 2.8265              |
|             | 3-761-1811  | A2-11        |            |                |                  |                  |                             |                           |           |              |                     |
| 21          | 3-761-2111  | A2-11        | 0.7323     | 1.3780         | 20.8661          | 4.3307           | 21886                       | 43283                     | 1500      | 430          | 5.6120              |
|             | 3-761-2115  | A2-15        |            |                |                  |                  |                             |                           |           |              |                     |
| 24          | 3-761-2411  | A2-11        | 0.7323     | 1.3780         | 24.0157          | 4.3307           | 21886                       | 43283                     | 1200      | 551          | 9.5280              |
|             | 3-761-2415  | A2-15        |            |                |                  |                  |                             |                           |           |              |                     |

### Dimensions

| Chuck Dia D | Part Number | A       | B      | C       | D       | E       | F      | G      | H       | J      | K (ANSI)  | K (JIS)  |
|-------------|-------------|---------|--------|---------|---------|---------|--------|--------|---------|--------|-----------|----------|
| 15          | 3-761-1508  | 15.0000 | 4.9213 | 8.8583  | 5.5006  | 0.7874  | 0.9531 | 3.3750 | 6.7500  | 0.3150 | 5/8-11UNC | 6-M16    |
|             | 3-761-1511  |         |        | 11.0236 | 7.7506  |         |        |        |         |        |           |          |
| 18          | 3-761-1808  | 17.9921 | 4.9213 | 8.8583  | 5.5006  | 0.7874  | 0.9531 | 3.3750 | 6.7500  | 0.3150 | 5/8-11UNC | 6-M16    |
|             | 3-761-1811  |         |        | 11.0236 | 7.7506  |         | 1.1559 | 4.6260 | 9.2520  | 0.3937 | 3/4-10UNC | 6-M20    |
| 21          | 3-761-2111  | 20.8661 | 5.5118 | 14.9606 | 7.7506  | 0.7874  | 1.1559 | 4.6260 | 9.2520  | 0.3937 | 3/4-10UNC | 6-M20    |
|             | 3-761-2115  |         |        |         | 11.2505 | 0.8661  | 1.4059 | 6.5000 | 13.0000 |        | 7/8-9UNC  | 6-M22    |
| 24          | 3-761-2411  | 24.0157 | 5.5118 | 11.0236 | 7.7506  | 0.7874  | 1.1559 | 4.6260 | 9.2520  | 0.3937 | 3/4-10UNC | 6-M20    |
|             | 3-761-2415  |         |        |         | 14.9606 | 11.2505 | 0.8661 | 1.4059 | 6.5000  |        | 13.0000   | 7/8-9UNC |

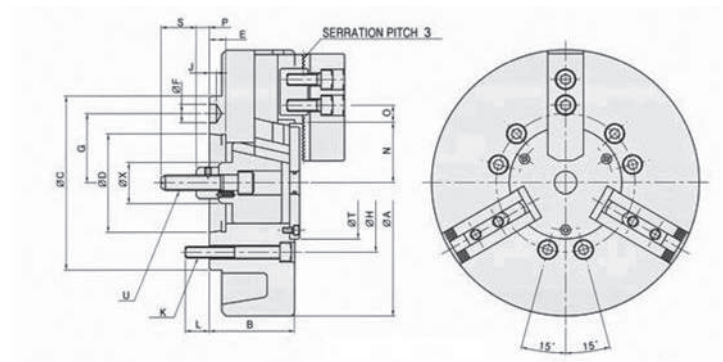
## Dimensions

| Chuck Dia D | Part Number | L (ANSI) | L (JIS) | N max  | N min  | O max  | O min  | P max  | P min  | S      | T      | U       | V      | X      |
|-------------|-------------|----------|---------|--------|--------|--------|--------|--------|--------|--------|--------|---------|--------|--------|
| 15          | 3-761-1508  | 0.9449   | 0.8858  | 2.9331 | 2.5669 | 2.1457 | 0.8465 | 1.3780 | 0.0000 | 1.9685 | 6.8898 | M27x3.0 | 3.3465 | 2.4803 |
|             | 3-761-1511  | 0.9055   | 1.0236  |        |        |        |        |        |        |        |        |         | 2.5591 |        |
| 18          | 3-761-1808  | 0.9449   | 0.8858  | 2.9331 | 2.5669 | 3.5630 | 0.8465 | 1.3780 | 0.0000 | 1.9685 | 6.8898 | M27x3.0 | 4.7244 | 2.4803 |
|             | 3-761-1811  | 0.9055   | 1.0236  |        |        |        |        |        |        |        |        |         | 3.9370 |        |
| 21          | 3-761-2111  | 1.3150   | 1.2205  | 3.9961 | 3.6299 | 3.9567 | 0.8465 | 1.3780 | 0.0000 | 2.1654 | 8.6614 | M30x3.5 | 4.3307 | 2.9528 |
|             | 3-761-2115  | 1.3937   | 1.2598  |        |        |        |        |        |        |        |        |         |        |        |
| 24          | 3-761-2411  | 1.3150   | 1.2205  | 3.9961 | 3.6299 | 5.3740 | 0.8465 | 1.3780 | 0.0000 | 2.1654 | 8.6614 | M30x3.5 | 5.7087 | 2.9528 |
|             | 3-761-2415  | 1.3937   | 1.2598  |        |        |        |        |        |        |        |        |         |        |        |



### 3-Jaw Closed Center Chucks

Direct A2 Mount, 32" thru 63"



| Chuck Dia D | Part Number | Jaw Stroke | Plunger Stroke | Gripping Dia Max | Gripping Dia Min | Max Permissible Input Force | Max Static Gripping Force | Max Speed | Weight | Moment of Inertia   |
|-------------|-------------|------------|----------------|------------------|------------------|-----------------------------|---------------------------|-----------|--------|---------------------|
|             |             | in         |                |                  |                  | lbf                         |                           | RPM       | lbs    | lbs*ft <sup>2</sup> |
| 32          | 3-761-3200  | 0.7323     | 1.4961         | 31.4961          | 7.8740           | 25927                       | 46453                     | 800       | 752    | 0.4977              |
| 40          | 3-761-4000  | 1.8110     | 2.2441         | 39.3701          | 7.0866           | 40452                       | 71915                     | 630       | 1323   | 1.4399              |
| 50          | 3-761-5000  |            | 2.2441         | 49.2126          | 7.8740           |                             |                           | 500       | 1764   | 3.0272              |
| 63          | 3-761-6300  |            | 2.3622         | 62.9921          | 12.5984          |                             |                           | 280       | 3527   | 10.4395             |

## Dimensions

| Chuck Dia D | Part Number | A       | B      | C       | E      | G       | H       | K (JIS) | L (JIS) |
|-------------|-------------|---------|--------|---------|--------|---------|---------|---------|---------|
| 32          | 3-761-3200  | 31.4961 | 5.9055 | 14.9606 | 0.2362 | 13.0000 | 13.0000 | 6-M24   | 1.2205  |
| 40          | 3-761-4000  | 39.3701 | 7.0866 | 20.4724 | 0.3150 | 18.2520 | 18.2520 | 6-M24   | 1.2598  |
| 50          | 3-761-5000  | 49.2126 |        |         |        |         |         |         |         |
| 63          | 3-761-6300  | 62.9921 | 8.6614 | 28.3465 | 0.3150 | 25.4961 | 25.4961 | 6-M30   | 1.8110  |

| Chuck Dia D | Part Number | N max  | N min  | P max  | P min   | S      | T       | U        | X      |
|-------------|-------------|--------|--------|--------|---------|--------|---------|----------|--------|
| 32          | 3-761-3200  | 3.9764 | 2.5157 | 1.3780 | -0.1181 | 2.3622 | 10.6299 | M30xP3.5 | 4.4882 |
| 40          | 3-761-4000  | 8.1496 | 6.0630 | 1.2598 | -0.9843 | 2.6772 | 13.3858 | M30xP3.5 | 2.3622 |
| 50          | 3-761-5000  | -      | -      |        |         |        |         | M36xP4.0 |        |
| 63          | 3-761-6300  | -      | -      | 0.5118 | -1.8504 | 2.6772 | 15.3543 | M36xP4.0 | 2.3622 |



### Soft Top Jaws, Serration 1.5mm x 60

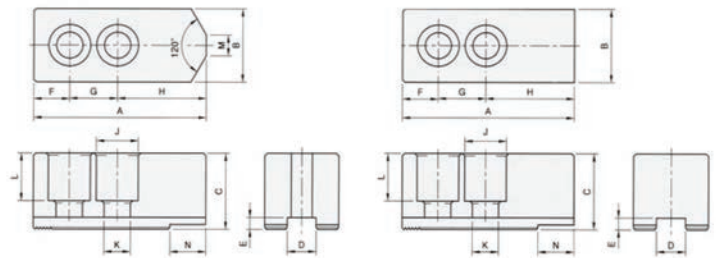


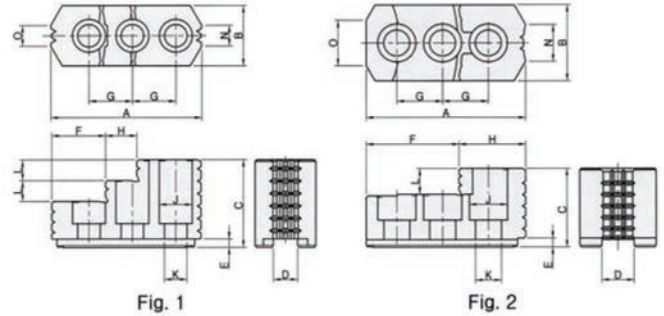
Fig. 1

Fig. 2

| Chuck Dia D | Part Number | Fig. | Serration | A       | B      | C      | D      | E      | F      | G      | H      | J      | K      | L      | M      | N      |
|-------------|-------------|------|-----------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 6"          | 3-788-306   | 1    | 1.5x60°   | 2.8346  | 1.2205 | 1.2402 | 0.4724 | 0.1969 | 0.5906 | 0.7874 | 1.4567 | 0.6890 | 0.4331 | 0.7677 | 0.4724 | 0.5906 |
| 8"          | 3-788-308   |      |           | 3.7402  | 1.4567 | 1.4764 | 0.5512 |        | 0.7874 | 0.9843 | 1.9685 | 0.7874 | 0.5512 | 0.8858 |        | 0.7874 |
| 10"         | 3-788-310   |      |           | 4.3307  | 1.7323 | 1.752  | 0.6299 |        | 1.1811 | 1.1811 | 1.9685 | 0.7874 | 0.5512 | 1.122  |        | 0.5906 |
| 12"         | 3-788-312   | 2    | 1.5x60°   | 4.3701  | 1.9291 | 1.9488 | 0.8268 | 0.1969 | 0.8268 | 1.1811 | 2.3622 | 0.9843 | 0.6693 | 1.2402 | -      | -      |
| 15 & 18"    | 3-788-315   |      |           | 6.4961  | 2.3228 | 2.3425 | 0.8661 | 0.315  | 1.8504 | 1.6929 | 2.9528 | 1.2598 | 0.8661 | 1.4173 |        |        |
| 21"         | 3-788-321   |      |           | 3.0x60° |        |        | 7.0866 | 0.9843 | 0.374  | 1.5748 | 2.3622 |        |        |        |        |        |



## Hard Top Jaws, Serration 1.5mm x 60



| Chuck Dia D | Part Number | Fig. | Serration | A      | B      | C      | D      | E      | F      | G      | H      | J      | K      | L      | M      | N      | O      |        |
|-------------|-------------|------|-----------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 6           | 3-787-306   | 1    | 1.5x60°   | 2.9724 | 1.2205 | 1.6142 | 0.4724 | 0.1969 | 1.1811 | 0.7874 | 0.4724 | 0.6890 | 0.4331 | 0.3937 | 0.3937 | 0.5906 | —      |        |
| 8           | 3-787-308   |      |           | 3.4252 | 1.5354 | 2.0079 | 0.5512 |        | 1.0630 | 0.9843 | 0.8661 | 0.7480 | 0.5118 | 0.4724 | 0.4724 | 0.4724 | 0.4724 | 0.5906 |
| 10          | 3-787-310   |      |           | 3.9764 | 0.3937 | 2.1260 | 0.6299 |        | 1.6929 | 1.1811 | 6.8504 | 0.5118 | 0.5906 | 0.5906 | 0.5906 | 0.7087 |        |        |
| 12          | 3-787-312   | 2    | 1.5x60°   | 4.1654 | 1.9685 | 2.0472 | 0.8268 | 0.1969 | 2.3819 | 1.1811 | 1.7835 | 0.9843 | 0.6693 | 0.6693 | 1.1811 | 1.1811 | 0.5906 |        |
| 15 & 18     | 3-787-315   | 1    | 1.5x60°   | 6.2677 | 2.4409 | 3.3858 | 0.8661 | 0.3150 | 2.5984 | 1.6929 | 1.3780 | 1.2598 | 0.8268 | 0.7874 | 1.5748 | 1.5748 | 1.1811 |        |
| 21          | 3-787-321   | 2    | 3.0x60°   | 6.2795 | 3.1496 | 3.5433 | 0.9843 | 0.0787 | 4.0740 | 1.9685 | 2.2126 | 1.2598 | 0.8661 | 1.5748 | 2.1654 | —      | 1.5748 |        |

## T-Nuts

| Chuck Dia D | Part Number | A      | B      | C      | F      | G      | H (h6) | Bolt Size |
|-------------|-------------|--------|--------|--------|--------|--------|--------|-----------|
| 6-1/4       | 3-789-906   | 0.0271 | 0.0543 | 0.0287 | 0.0310 | 0.0116 | 0.0186 | M10*P1.5  |
| 8           | 3-789-908   | 0.0318 | 0.0713 | 0.8071 | 0.0318 | 0.0131 | 0.0217 | M12*P1.75 |
| 10          | 3-789-910   | 0.0348 | 0.0790 | 0.0333 | 0.0440 | 0.0131 | 0.0248 | M12*P1.75 |
| 12-1/2      | 3-789-912   | 0.0456 | 0.0829 | 0.0426 | 0.0465 | 0.0178 | 0.0325 | M16*P2.0  |
| 15-3/4      | 3-789-915   | 0.0519 | 0.1240 | 0.0705 | 0.0666 | 0.0256 | 0.0372 | M20*P2.5  |



## Draw Tube Nut Blanks

| Chuck Dia D | Part Number |
|-------------|-------------|
| 6           | 3-789-0601  |
| 8           | 3-789-0801  |
| 10          | 3-789-1001  |
| 12          | 3-789-1201  |
| 15          | 3-789-1501  |

# Centers & Rotating Bodies

DESIGNED AND MANUFACTURED  
IN EUROPE



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## Centers & Rotating Bodies

### Live Centers

- Precisely machined, hardened and ground from one single piece of high quality alloy steel, heat treated to RC 60-62
- Each live center is provided with three selected heavy-duty precision bearings
- Each bearing is specifically protected against dust and coolant



### Dead Centers

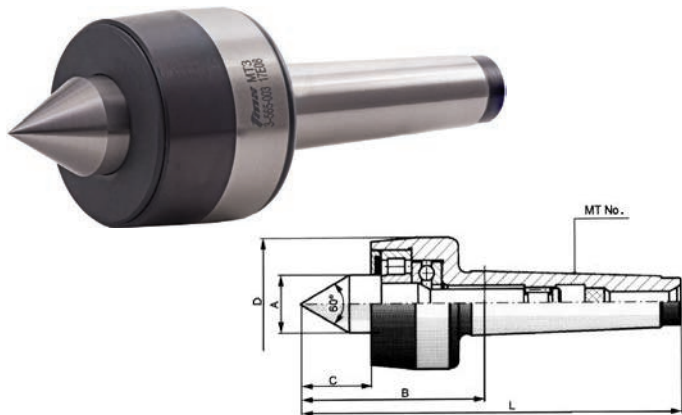
- Precisely machined, hardened and ground from one single piece of steel forging case hardened to 61-63HRC
- T.I.R. of 0.0002"



### Rotating Bodies

- Designed for use with interchangeable tapered heads or with 3", 4" and 5" front mounting, self-centering chucks
- Steel body construction with hardened and ground scroll and pinions

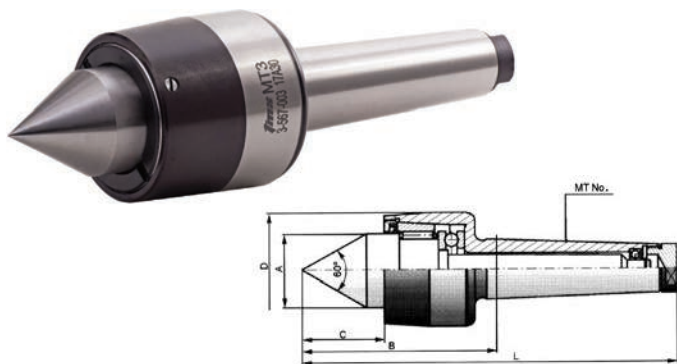




## Precision & Super Precision Live Centers

- Each center hardened and ground from one single piece of forging
- Spindles are made of high quality alloy steel & heat treated to RC 60-62
- 3 precision high-quality bearings are protected by a special steel shield and neoprene seal
- Each bearing is specifically protected against dust and coolant

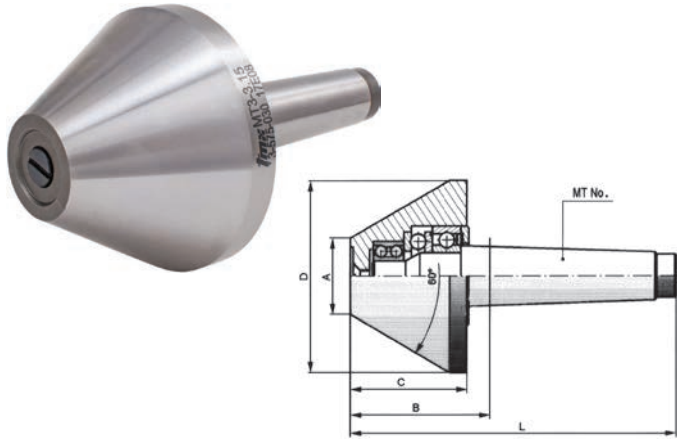
| Morse Taper | Precision   |        | Super Precision |        | Max Wt of Workpiece | Point Diameter A | Projection Length B | Point Length C | Diameter D | Overall Length L (in) | Max RPM | Wt (lbs) |
|-------------|-------------|--------|-----------------|--------|---------------------|------------------|---------------------|----------------|------------|-----------------------|---------|----------|
|             | Part Number | T.I.R. | Part Number     | T.I.R. |                     |                  |                     |                |            |                       |         |          |
| 1           | 3-565-001P  | 0.0003 | 3-565-101P      | 0.0002 | 220                 | 0.59             | 1.97                | 0.70           | 1.50       | 4.07                  | 5000    | 1        |
| 2           | 3-565-002P  |        | 3-565-102P      | 0.0001 | 460                 | 0.70             | 2.22                | 0.87           | 1.57       | 4.74                  | 5000    |          |
| 3           | 3-565-003P  |        | 3-565-103P      |        | 925                 | 0.98             | 2.95                | 1.12           | 2.20       | 6.14                  | 4000    |          |
| 4           | 3-565-004P  |        | 3-565-104P      | 1850   | 1.10                | 3.21             | 1.24                | 2.52           | 7.24       | 3000                  |         |          |
| 5           | 3-565-005P  | 0.0004 | 3-565-105P      | 0.0002 | 4400                | 1.61             | 4.23                | 1.77           | 3.35       | 9.33                  | 2500    | 8        |
| 6           | 3-565-006P  |        | 3-565-106P      |        | 7700                | 2.48             | 5.96                | 2.52           | 5.12       | 13.13                 | 2000    | 26       |



## Ultra Precision Adjustable Live Centers

- Easy to adjust
- Adjustable, ultra precision radial bearing reduces run out to minimum after much use
- Heavy Duty
- Triple Bearing
- T.I.R. 0.00012

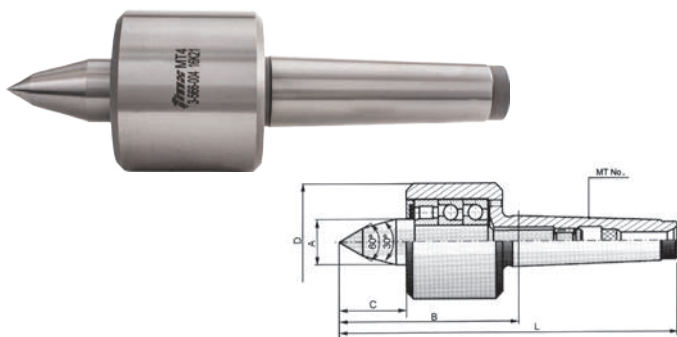
| Morse Taper | Part Number | Max Wt of Workpiece lbs | Thrust lbs at 1000 RPM | Point Diameter A | Projection Length B | Point Length C | Diameter D | Overall Length L | Max RPM | Wt (lbs) |
|-------------|-------------|-------------------------|------------------------|------------------|---------------------|----------------|------------|------------------|---------|----------|
| 2           | 3-567-002P  | 220                     | 90                     | 0.91             | 2.87                | 1.02           | 1.73       | 5.41             | 8000    | 1        |
| 3           | 3-567-003P  | 440                     | 170                    | 1.10             | 3.37                | 1.26           | 1.89       | 6.53             | 6000    | 2        |
| 4           | 3-567-004P  | 880                     | 350                    | 1.53             | 3.88                | 1.69           | 2.36       | 7.89             | 4500    | 4        |
| 5           | 3-567-005P  | 1430                    | 550                    | 1.77             | 4.70                | 2.01           | 2.76       | 9.80             | 4000    | 7        |
| 6           | 3-567-006P  | 3080                    | 1200                   | 2.40             | 5.47                | 2.44           | 3.70       | 12.64            | 3000    | 17       |



## Bull Head Live Centers

- Centers are designed to hold pipe and hollow work
- Triple bearing design
- Three matched bearings are preloaded at the factory
- Good thrust and radial capabilities
- Bearings are protected by a special seal
- Head is made of high quality Alloy Steel and heat treated to RC 61-63
- 60 degree head angle

| Morse Taper | Part Number | T.I.R. | Minimum Point Diameter A | Projection Length B | Head Length C | Diameter D | Overall Length L | Max RPM | Max Weight of Workpiece | Weight (lbs) |
|-------------|-------------|--------|--------------------------|---------------------|---------------|------------|------------------|---------|-------------------------|--------------|
| 1           | 3-575-010P  | 0.0003 | 0.79                     | 1.56                | 1.38          | 1.97       | 3.66             | 5000    | 220                     | 1            |
| 2           | 3-575-020P  | 0.0003 | 1.18                     | 1.6                 | 1.38          | 2.36       | 4.11             | 5000    | 400                     | 1            |
|             | 3-575-021P  |        |                          | 2.32                | 2.09          | 3.15       | 4.84             | 4500    | 660                     | 3            |
| 3           | 3-575-030P  | 0.0003 | 1.18                     | 2.32                | 2.09          | 3.15       | 5.51             | 4500    | 770                     | 3            |
|             | 3-575-031P  |        | 1.57                     | 2.64                | 2.4           | 3.93       | 5.83             | 3000    | 1210                    | 5            |
| 4           | 3-575-040P  | 0.0003 | 1.57                     | 2.7                 | 2.4           | 3.93       | 6.73             | 3000    | 1320                    | 6            |
|             | 3-575-042P  | 0.0004 | 2.76                     | 3.05                | 2.76          | 5.51       | 7.09             |         | 1540                    | 11           |
| 5           | 3-575-051P  | 0.0008 | 3.94                     | 3.05                | 2.76          | 6.69       | 8.15             | 2000    | 1653                    | 18           |
| 6           | 3-575-060P  | 0.002  | 7.09                     | 4.57                | 4.21          | 11.5       | 11.73            | 1000    | 4400                    | 75           |



## NC Quad-Bearing Live Centers

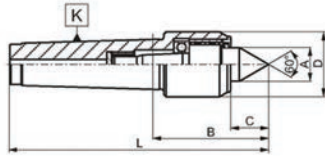
- Heavy duty
- High speed
- 7000 to 6000 RPM

| Morse Taper | Part Number | T.I.R. | Point Diameter A | Projection Length B | Point Length C | Diameter D | Overall Length L | Max RPM | Max Wt of Workpiece | Weight (lbs) |
|-------------|-------------|--------|------------------|---------------------|----------------|------------|------------------|---------|---------------------|--------------|
| 4           | 3-566-004P  | 0.0002 | 1.10             | 4.58                | 1.91           | 2.76       | 8.62             | 7000    | 2200                | 6            |
| 5           | 3-566-005P  | 0.0002 | 1.57             | 5.87                | 2.64           | 3.47       | 11.00            | 6000    | 4400                | 11           |

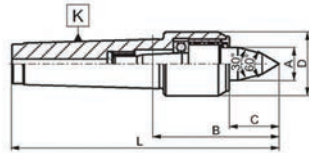




3-560 Series Slim Casing



3-561 Series Extended Point



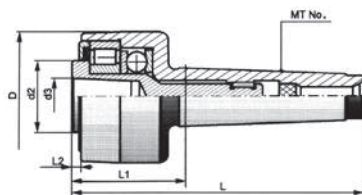
## Slim Casing Live Centers

- For counter-clamping workpieces on turning and grinding machines
- Especially suited for cramped work area between center point and workpiece
- Enlarged work area and better workpiece accessibility thanks to narrow casing diameter
- Maximum rigidity at high speeds thanks to compact design
- Maximum concentricity deviation of 0.0002 in for maximum precision

| Morse Taper                                   | Part Number | Point Diameter A | Projection Length B | Point Length C | Diameter D | Overall Length L | Max. Workpiece Weight | Max RPM | Weight (lbs) |
|---|-------------|------------------|---------------------|----------------|------------|------------------|-----------------------|---------|--------------|
| <b>Slim Casing</b>                            |             |                  |                     |                |            |                  |                       |         |              |
| 2   | 3-560-002P  | 0.591            | 2.441               | 0.709          | 1.260      | 4.961            | 440                   | 7000    | 1            |
| 3   | 3-560-003P  |                  |                     |                | 1.339      | 5.630            | 880                   |         |              |
| 4   | 3-560-004P  | 0.787            | 2.972               | 0.984          | 1.654      | 7.008            | 1760                  | 6300    | 2            |
| 5   | 3-560-005P  | 1.181            | 4.055               | 1.339          | 2.284      | 9.154            | 3530                  | 4300    | 6            |
| 6   | 3-560-006P  | 1.654            | 5.571               | 1.929          | 3.150      | 12.756           | 7720                  | 3000    | 17           |
| <b>Slim Casing with Extended Center Point</b> |             |                  |                     |                |            |                  |                       |         |              |
| 2   | 3-561-002P  | 0.591            | 2.874               | 1.142          | 1.260      | 5.394            | 370                   | 7000    | 1            |
| 3   | 3-561-003P  |                  | 2.953               | 1.221          | 1.221      | 6.142            | 750                   |         |              |
| 4   | 3-561-004P  | 0.787            | 3.484               | 1.496          | 1.496      | 7.520            | 1540                  | 6300    | 2            |
| 5   | 3-561-005P  | 1.181            | 4.744               | 2.028          | 2.028      | 9.843            | 3090                  | 4300    | 6            |
| 6   | 3-561-006P  | 1.654            | 6.437               | 2.795          | 2.795      | 13.622           | 6610                  | 3000    | 18           |



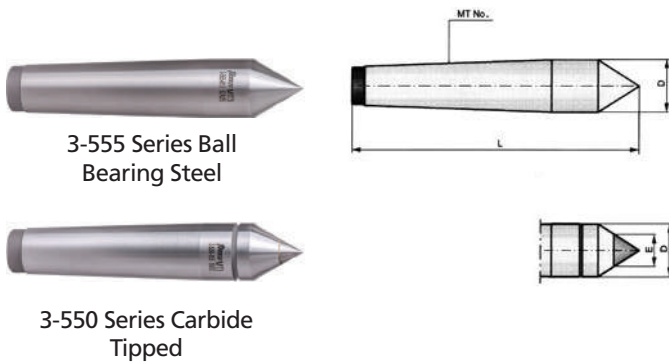
Visit [www.tmxtools.com](http://www.tmxtools.com) for interchangeable inserts offering



## Live Centers with Interchangeable Inserts

- Body of live centers and inserts are made of forgings, hardened and precisely ground
- Sets are provided with the main body and seven different style inserts
- Precision high quality bearings
- Special sealing ring protects the bearings from coolant and dust
- Inserts are easily interchangeable

| Morse Taper | Set Part Number | Body Only Part Number | T.I.R. | Diameter D | d2   | d3   | Overall Length L | Projection Length L1 | L2    | Max Wt of Workpiece (lbs) | RPM Max | Weight without insert (lbs) |
|-------------|-----------------|-----------------------|--------|------------|------|------|------------------|----------------------|-------|---------------------------|---------|-----------------------------|
| 2           | 3-570-002P      | 3-570-102P            | 0.0008 | 1.57       | 0.71 | 0.28 | 4.055            | 1.54                 | 0.177 | 220                       | 5000    | 1                           |
| 3           | 3-570-003P      | 3-570-103P            | 0.0008 | 2.20       | 0.98 | 0.47 | 5.217            | 2.03                 | 0.197 | 440                       | 4000    | 2                           |
| 4           | 3-570-004P      | 3-570-104P            | 0.0008 | 2.52       | 1.10 | 0.59 | 6.220            | 2.19                 | 0.217 | 880                       | 3000    | 4                           |
| 5           | 3-570-005P      | 3-570-105P            | 0.0012 | 3.35       | 1.61 | 0.87 | 7.815            | 2.72                 | 0.256 | 1770                      | 2500    | 8                           |
| 6           | 3-570-006P      | 3-570-106P            | 0.0012 | 5.12       | 2.48 | 1.89 | 10.846           | 3.7                  | 0.256 | 3550                      | 2000    | 25                          |



## Dead Centers

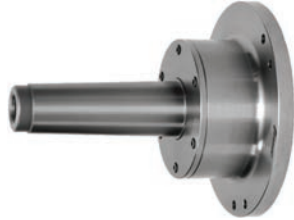
### Carbide Tipped & Steel

- Designed for use wherever high accuracy is required
- T.I.R.  $\pm 0.0001$ in
- Case hardened to 61-63HRC
- Carbide Tipped Centers give longer tool life and require less regrinding

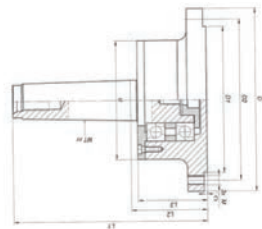
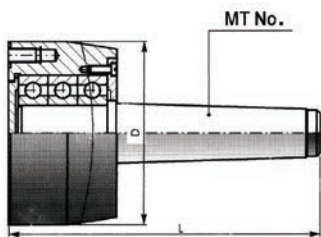
| Morse Taper | Ball Bearing Steel Part Number | Carbide Tipped Part Number | Overall Length L | Diameter D | Point Diameter E | Weight (lbs) |
|-------------|--------------------------------|----------------------------|------------------|------------|------------------|--------------|
| 1           | 3-555-005P                     | 3-550-005P                 | 3.15             | 0.48       | 0.28             | 0            |
| 2           | 3-555-010P                     | 3-550-010P                 | 3.94             | 0.71       | 0.28             | 0            |
| 3           | 3-555-015P                     | 3-550-015P                 | 4.92             | 0.95       | 0.43             | 1            |
| 4           | 3-555-020P                     | 3-550-020P                 | 6.30             | 1.24       | 0.55             | 2            |
| 5           | 3-555-025P                     | 3-550-025P                 | 7.87             | 1.76       | 0.71             | 4            |
| 6           | 3-555-030P                     | 3-550-030P                 | 10.63            | 2.51       | 0.74             | 12           |



Rotating Body for 3"-6"  
Diameter Chucks or Heads



Rotating Body for 8"-10"  
Diameter Chucks or Heads



## Rotating Bodies

For Chucks & Interchangeable Heads

- Designed for use with interchangeable tapered heads or with 3", 4", and 5" front mounting, self-centering chucks
- Steel body construction with hardened and ground scroll and pinions
- Hardened and ground MT shank
- Triple bearing design
- Sealed ball bearings, lubrication through roller
- Bodies, chucks and heads sold separately

## Rotating Bodies for 3"-6" Diameter Chucks or Heads

| Chuck/Head Diameter | Morse Taper | Body Only Part Number | T.I.R. | Overall Length L | Body Diameter D | Max RPM | Max Workpiece Weight | Weight (lbs) |
|---------------------|-------------|-----------------------|--------|------------------|-----------------|---------|----------------------|--------------|
| 3                   | 2           | 3-573-032P            | 0.002  | 4.84             | 3.07            | 4000    | 1543                 | 4            |
|                     | 3           | 3-573-033P            |        | 5.52             |                 |         |                      | 2            |
| 4                   | 3           | 3-573-043P            | 0.002  | 5.63             | 3.86            | 3500    | 2205                 | 8            |
|                     | 4           | 3-573-044P            |        | 6.54             |                 |         |                      |              |
| 5                   | 3           | 3-573-053P            | 0.002  | 5.98             | 4.84            | 3200    | 3307                 | 15           |
|                     | 4           | 3-573-054P            |        | 6.89             |                 |         |                      | 8            |
|                     | 5           | 3-573-055P            |        | 7.95             |                 |         |                      |              |
| 6                   | 5           | 3-573-065P            | 0.002  | 8.07             | 6.30            | 3000    | 3900                 | 17           |

## Rotating Bodies for 8"-10" Diameter Chucks or Heads

| Chuck/<br>Head<br>Diameter | Morse<br>Taper | Part<br>Number | T.I.R. | Point<br>Length<br>C | Dia<br>D | Boss<br>Dia<br>D1 | Bolt<br>Circle Dia<br>d2 | Overall<br>Length<br>L1 | Gage<br>Length<br>L2 | Projection<br>Length<br>L3 | Hole<br>Thread<br>Size M | Max<br>RPM | Max<br>Workpiece<br>Wt (lbs) | Wt<br>(lbs) |
|----------------------------|----------------|----------------|--------|----------------------|----------|-------------------|--------------------------|-------------------------|----------------------|----------------------------|--------------------------|------------|------------------------------|-------------|
| 8                          | 5              | 3-573-085P     | 0.0008 | 0.138                | 7.874    | 6.299             | 6.929                    | 9.212                   | 4.291                | 3.858                      | M10                      | 2800       | 550                          | 49          |
|                            | 6              | 3-573-086P     |        |                      |          |                   |                          | 11.378                  |                      |                            |                          |            |                              |             |
| 10                         | 5              | 3-573-105P     | 0.0008 | 0.138                | 9.843    | 7.874             | 8.819                    | 9.212                   | 4.291                | 3.858                      | M12                      | 2500       | 1100                         | 49          |
|                            | 6              | 3-573-106P     |        | 0.177                |          |                   |                          | 11.378                  |                      |                            |                          |            |                              |             |



3-813



3-814

Compatible with  
Front Mount Scroll Chucks



Interchangeable Tapered  
Heads available on  
[www.tmxtools.com](http://www.tmxtools.com)

# Milling Machine Vises



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## Milling Machine Vises

### Single Station Vises

- 7.5", 8.9" or 10" Jaw openings
- 10 year warranty
- Body made from high quality ductile iron hardened to 45RC
- Sealed bearing system increases the life of the vise
- Close tolerance bed heights for excellent accuracy
- Anti-lift mechanism keeps the workpiece from lifting
- Chip cover for lead screw protection

### Double Station Vises

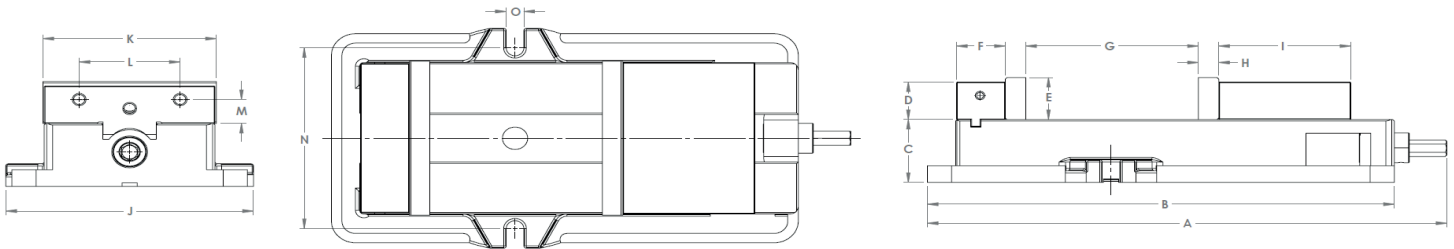
- Double station can clamp two dissimilar workpieces with same force at same time and provides 6 different clamping positions
- Clamping force equalization (patented) ensures same clamping force to clamp two different size/shape workpieces and avoid deflection and lift
- Lockwell anti-lift mechanism (patented) & automatic return mechanism (patented) ensures the workpiece does not deflect and lift
- Rigid and tensile ductile iron FCD-60 (80,000PSI) vise body. Slide surface flame hardened to HS65° to maintain accuracy. S50C jaw-plate has been carburizing heat treated the hardness to HRC54°
- Unique design facilitates the evacuation of chips
- U.S.A. patented





## Single Station Vises

- 7.5", 8.9" or 10" Jaw Openings
- 10 Year Warranty
- Body made from high quality ductile iron hardened to 45RC
- Sealed bearing system increases life of the vise
- Close tolerance bed heights for excellent accuracy
- Anti-lift mechanism keeps the workpiece from lifting
- Chip cover for lead screw protection



| Part Number | A     | B     | C BED HEIGHT +/-0.0005 | D    | E    | F    | Jaw Opening G | H    | I    | J     | K    | L    | M    | N    | O    | Max Gripping Force | Wt (lbs) |
|-------------|-------|-------|------------------------|------|------|------|---------------|------|------|-------|------|------|------|------|------|--------------------|----------|
| 3-220-006   | 18.78 | 17.00 | 2.875                  | 1.49 | 1.75 | 2.04 | 7.55          | 0.70 | 4.84 | 9.24  | 5.94 | 3.87 | 0.93 | 7.55 | 0.68 | 8200               | 79       |
| 3-220-0068  | 18.92 | 17.20 | 2.875                  | 1.49 | 1.75 | 2.04 | 8.89          | 0.70 | 4.84 | 8.75  | 5.98 | 3.87 | 0.93 | 7.58 | 0.68 | 9840               | 80       |
| 3-220-0081  | 24.31 | 21.85 | 3.310                  | 1.96 | 2.20 | 2.28 | 10.43         | 0.95 | 6.18 | 11.59 | 8.11 | 4.72 | 1.26 | 9.52 | 0.70 | 11600              | 150      |

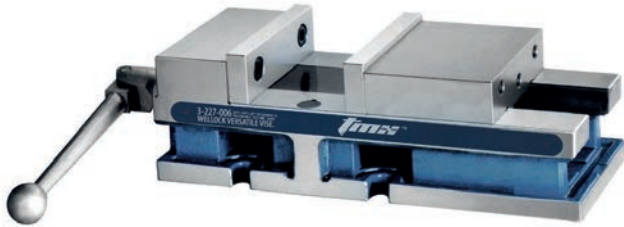
\*All dimensions in inches unless otherwise indicate d; dimensions and weights are approximate

## Materials and Torque Specifications

| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-220-006   | 14              | 1798                 | Ductile Iron | Hardened Steel | 79       |
|             | 29              | 2248                 |              |                |          |
|             | 43              | 3147                 |              |                |          |
|             | 57              | 5171                 |              |                |          |
|             | 72              | 6744                 |              |                |          |
|             | 87              | 8093                 |              |                |          |
|             | 116             | 9442                 |              |                |          |

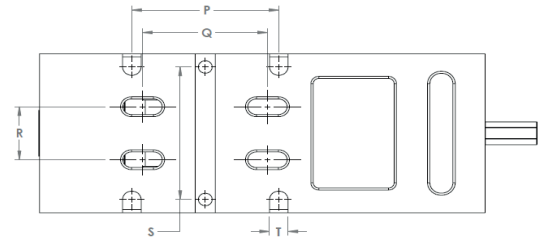
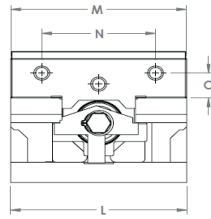
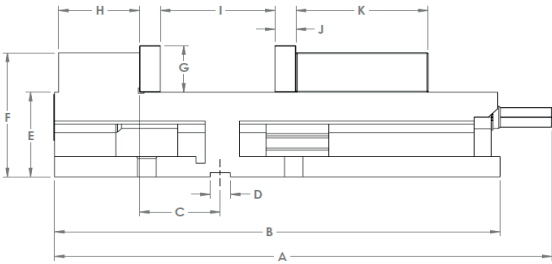
| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-220-0068  | 14              | 1349                 | Ductile Iron | Hardened Steel | 80       |
|             | 29              | 1798                 |              |                |          |
|             | 43              | 3822                 |              |                |          |
|             | 57              | 5395                 |              |                |          |
|             | 72              | 7194                 |              |                |          |
|             | 87              | 8992                 |              |                |          |
|             | 116             | 10791                |              |                |          |

| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-220-0081  | 14              | 2248                 | Ductile Iron | Hardened Steel | 150      |
|             | 29              | 3147                 |              |                |          |
|             | 43              | 4496                 |              |                |          |
|             | 57              | 6295                 |              |                |          |
|             | 72              | 8093                 |              |                |          |
|             | 116             | 10791                |              |                |          |



## Wellock Versatile Vise

- Vise for basic single station CNC. Features prevent lift of workpiece and provides high accuracy
- Two operating positions for VMC, upright & lay down
- One horizontal operating position for HMC2
- 3. Material of MG/MGR:FCD-60



| Part Number | A     | B     | C    | D    | E    | F    | G    | H    | I    | J    | K    | L    | M    | N    | O    | P    | Q    | R    | S    | T    | Wt (lbs) |
|-------------|-------|-------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|----------|
| 3-227-006   | 16.92 | 15.15 | 2.75 | 0.68 | 3.18 | 4.67 | 1.75 | 2.75 | 6.41 | 0.70 | 4.50 | 6.00 | 5.98 | 3.87 | 0.94 | 5.00 | 4.25 | 2.00 | 5.00 | 0.63 | 68.2     |

## Materials and Torque Specifications

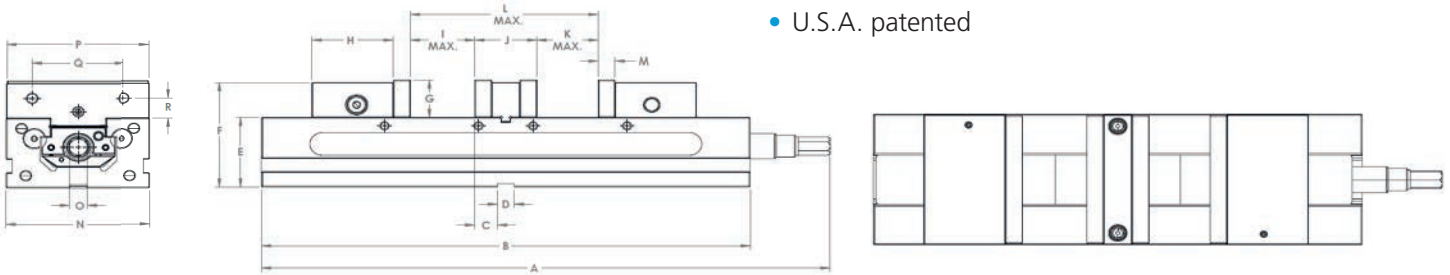
| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-227-006   | 14              | 899                  | Ductile Iron | Hardened Steel | 68.2     |
|             | 29              | 2698                 |              |                |          |
|             | 43              | 4047                 |              |                |          |
|             | 57              | 5620                 |              |                |          |
|             | 72              | 7194                 |              |                |          |
|             | 101             | 10791                |              |                |          |





## Double Station Vises

- Double station can clamp two dissimilar workpieces with the same force at the same time and provides 6 different clamping positions
- Clamping Force Equalization (patented) ensures that the same clamping force is used to clamp two different sized/shaped workpieces and avoid deflection and lift
- Lockwell Anti-Lift Mechanism (patented) & Automatic Return Mechanism (patented) ensures that the workpiece does not deflect and lift
- Rigid and tensile ductile iron FCD-60 (80,000PSI) vise body. Slide surface flame-hardened to HS65° to maintain accuracy. S50C jaw-plate has been carburized to HRC54°
- Unique design facilitates the evacuation of chips
- U.S.A. patented



| Part Number | A     | B     | C    | D    | E    | F    | G    | H    | I    | J    | K    | L     | M    | N    | O    | P    | Q    | R    | Wt (lbs) |
|-------------|-------|-------|------|------|------|------|------|------|------|------|------|-------|------|------|------|------|------|------|----------|
| 3-224-004   | 17.22 | 15.94 | 0.72 | 0.70 | 2.50 | 3.79 | 1.49 | 2.71 | 3.54 | 2.16 | 3.54 | 9.25  | 0.59 | 4.09 | 0.55 | 4.01 | 2.50 | 0.68 | 44       |
| 3-224-006   | 23.82 | 20.47 | 0.94 | 0.70 | 3.25 | 4.88 | 1.75 | 3.04 | 4.92 | 2.59 | 4.92 | 12.44 | 0.70 | 6.06 | 0.74 | 5.98 | 3.87 | 0.93 | 114.6    |

## Materials and Torque Specifications

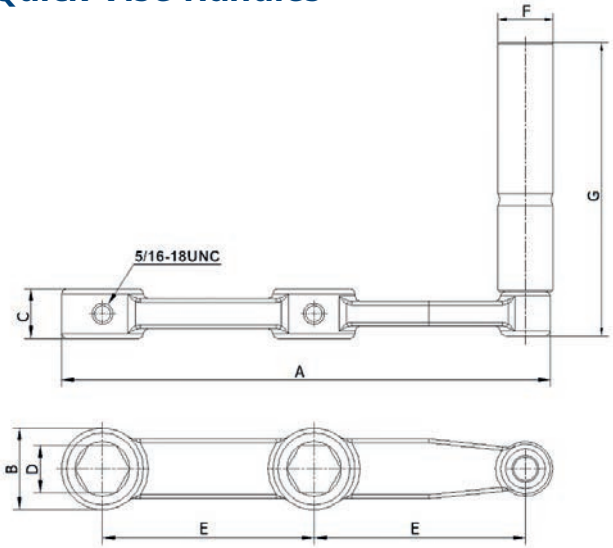
| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-224-004   | 7               | 450                  | Ductile Iron | Hardened Steel | 44.0     |
|             | 14              | 1124                 |              |                |          |
|             | 22              | 1461                 |              |                |          |
|             | 29              | 1798                 |              |                |          |
|             | 36              | 2249                 |              |                |          |
|             | 43              | 2698                 |              |                |          |
|             | 51              | 3147                 |              |                |          |
|             | 57              | 3822                 |              |                |          |
|             | 65              | 4271                 |              |                |          |
|             | 72              | 4946                 |              |                |          |

| Part Number | Torque (ft.lbs) | Clamping Force (lbs) | Body         | Jaws           | Wt (lbs) |
|-------------|-----------------|----------------------|--------------|----------------|----------|
| 3-224-006   | 7               | 450                  | Ductile Iron | Hardened Steel | 114.6    |
|             | 14              | 899                  |              |                |          |
|             | 22              | 1124                 |              |                |          |
|             | 29              | 1574                 |              |                |          |
|             | 36              | 1798                 |              |                |          |
|             | 43              | 2023                 |              |                |          |
|             | 51              | 2473                 |              |                |          |
|             | 57              | 3147                 |              |                |          |
|             | 65              | 3372                 |              |                |          |
|             | 72              | 4047                 |              |                |          |
|             | 80              | 4496                 |              |                |          |
|             | 87              | 4721                 |              |                |          |
|             | 101             | 5395                 |              |                |          |
|             | 116             | 6295                 |              |                |          |
|             | 130             | 7194                 |              |                |          |

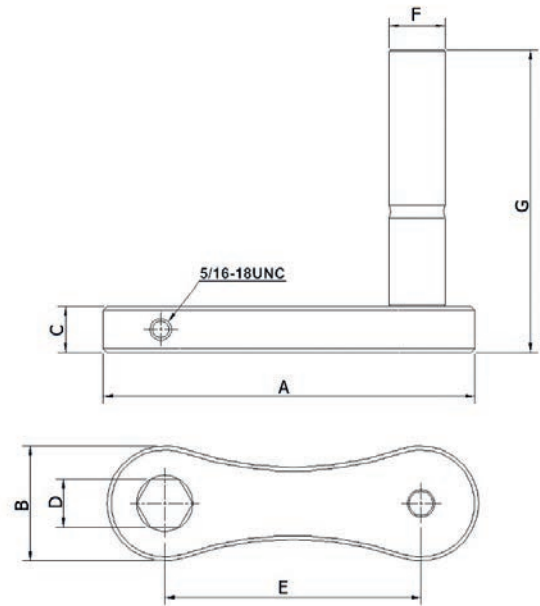
## Quick Vise Handles



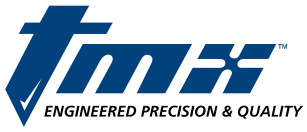
| Part Number | A    | B    | C    | D    | E    | F     | G    | Wt (lbs) |
|-------------|------|------|------|------|------|-------|------|----------|
| 3-300-6SHL  | 7.75 | 1.29 | 0.78 | 0.74 | 3.34 | Ø0.86 | 4.64 | 0.66     |



| Part Number | A    | B    | C    | D    | E    | F     | G    | Wt (lbs) |
|-------------|------|------|------|------|------|-------|------|----------|
| 3-300-6SHS  | 5.70 | 1.77 | 0.70 | 0.74 | 3.93 | Ø0.86 | 4.64 | 0.66     |



**Notes:**



**Notes:**

**Notes:**







# Workholding Catalog

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