

SELF CENTERING CHUCKS



Our chucks are manufactured at a most sophisticated plant well equipped with modern CNC machines and with updated measuring instruments. Strict quality control measures applied from raw materials purchase, its inspection, machining, heat treatment, fitting, final inspection and despatch assure international level quality to the satisfaction of our valued customers. This catalogue contains description of full range of manually operated chucks available with us.

No doubt CNC machines have become popular in these days, but still manually operated chucks form a major chunk in the industries because a lot of development has been made in Tooling Systems which can be used on conventional machines which help in obtaining more production with minimum of cost which is the need of the day. So the customer expects following features from manually operated Self centring Chucks:

- Economy
- High Accuracy
- High Gripping Power
- Long Service Life
- Safety

Continuous Research & Development at has helped to fulfill the above mentioned expectations. Improvements are being made from time to time so that our customers get best value for their money. We offer manually operated self centring chucks with

- Cast Iron Bodies
- Steel Bodies
- Spheroidal Graphite (SG) Iron Bodies

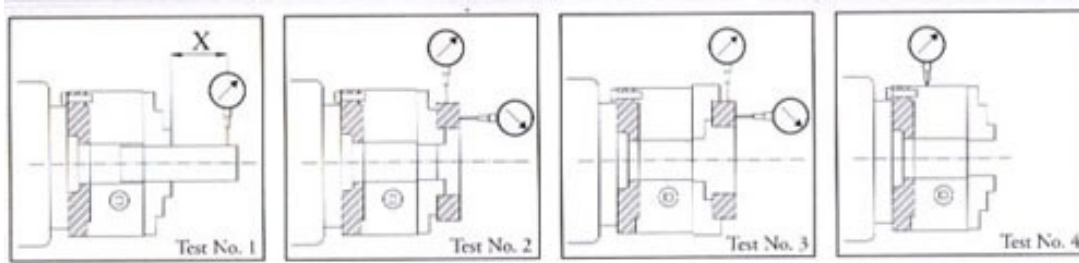
Chucks with Cast Iron Bodies are economical but their only limitation is that the same cannot be used at high rotational speeds. However where high rotational speed is required, Steel Body Chucks are recommended.

We have tried our best to include every information regarding the manually operated self centring chucks available with us. The chuck sizes and mountings specified in the tables of dimensions represent the popular requirement. Due to continuous Research & Development, the dimensions in tables can be changed without prior notice.

Variations in Sizes and Special type of Jaws can be available on request.

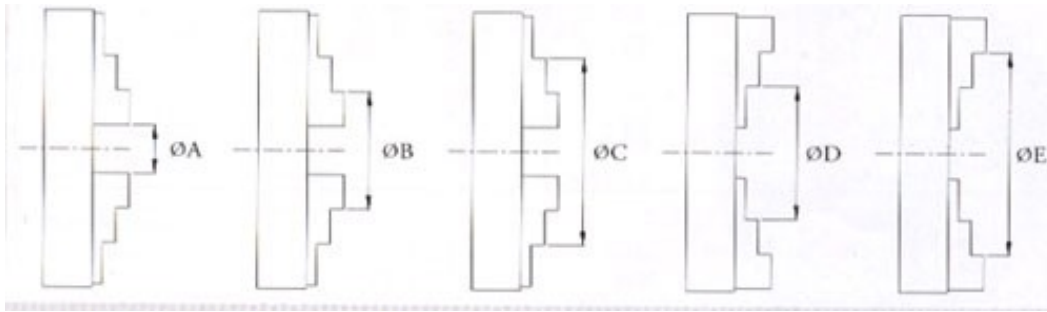
All Parts of Chucks are Interchangeable. The chucks come with a Guarantee of One Year against any manufacturing defect.

ACCURACY OF SELF CENTRING CHUCKS



Test No.	Test Applied	Size of chuck Over Upto and Including	Permissible Deviation in mm
1	Accuracy of Grip on Test Bar (Using Master Pinion)	160mm X=50mm	0.040
		160 mm 250 mm X = 50 mm	0.060
		250 mm 400 mm X = 75 mm	0.075
		400 mm 600 mm X = 100 mm	0.100
1	Accuracy of Grip on Test Bar (Using Any Pinion)	160mm X=50mm	0.080
		160 mm 250 mm X = 50 mm	0.080
		250 mm 400 mm X = 75 mm	0.100
		400mm 600mm X=100 mm	0.150
2 & 3	Accuracy of Grip on Test Rings when gripped internally or Externally (Using Master Pinion)	160 mm	0.030
		160 mm 250 mm	0.040
		250 mm 400 mm	0.060
		400 mm 600 mm	0.075
2 & 3	Accuracy of Grip on Test Rings on the Face of Ring	160 mm	0.025
		160 mm 250 mm	0.030
		250 mm 400 mm	0.040
		400 mm 600 mm	0.050
4	Concentricity of Outside Diameter	160 mm	0.030
		160 mm 250 mm	0.040
		250 mm 400 mm	0.060

GRIPPING CAPACITY OF SELF CENTRING CHUCKS



Size in mm	B (mm)		D(mm)		Min.		Max	Min.		Max	Min.		Max
	80	2	27	22	45	40	69	24	50	40	71		
100	3	33	25	60	55	87	32	70	60	93			
125	3	42	34	80	70	112	85	195	155	270			
315	10	180	80	200	150	299	96	225	165	315			
400	20	200	100	260	190	380	120	290	205	400			
500	35	260	135	300	225	480	155	370	265	500			
600	50	350	170	400	245	580	170	470	365	600			

MAX. RECOMMENDED REVOLUTIONS PER MINUTE (RPM) OF SELF CENTRING CHUCKS

Size in mm	80	100	125	160	200	230	250	270	315	400	500	600
Cast Iron Body	3000	2500	2000	1700	1300	1200	1100	1000	800	700	500	400
Steel Body	4000	3800	3200	2500	2000	1800	1600	1500	1300	1000	800	700