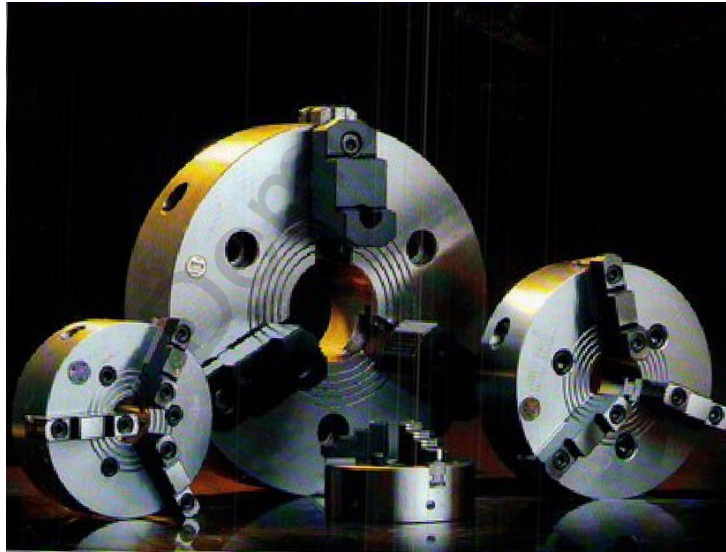


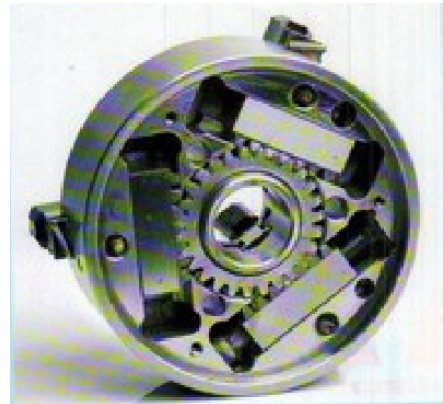
QUICK JAW CHANGE CHUCK



These chucks were earlier manufactured by M/S Batliboi & Co. in collaboration with Reishauer of Switzerland, These chucks are unique in design and accuracy with no scroll, no cams but with screw, rack and pinion drive. The main features are :

Body

Made of carbon steel forging and fitted with hardened and precision ground guides to ensure long lasting accuracy. The chucks are suitable for high spindle speeds.



Screw

Made of alloy steel, hardened and precision ground on Reishauer thread grinding machine.



Base Jaw

Made of alloy steel drop forging, Rack profile is hardened and ground on Reishauer rack grinding machines.

Racks

Made from drop forged alloy steel. The teeth for pinion and base jaws are hardened and ground on Reishauer rack grinding machines.

Reversible Jaws

Made of dropforged steel, hardened and ground. The jaws can be reset in less than one minute. Accuracy is obtained by grip grinding. It is also possible to mount soft jaws. It is advisable to take an additional set of base jaws for mounting soft jaws for higher productivity.

Gripping Power

Maximum gripping power in minimum space. Results in less operator fatigue and deeper depth of cut.

Accuracy

The chucks are one of the most accurate and reliable chucks available.

CHUCK MODEL	Units	HF 150	HF 195	HF 250	HF 330	HF 400
Outside dia of chuck	mm	150	195	250	330	400
Capacity external (Max. Min)	mm	150-4	195-8	250-8	330-18	400-20
Internal (Max. Min)	mm	150-45	195-70	250-80	330-112	400-120
Width of Chuck	mm	54	66	83	97	105
Locating dia for Flange	mm	138	180	230	312	380
Depth of location Dia	mm	4.0	5.5	5.5	6	6
Pitch circle dia for Fixing bolts	mm	86	102	140	205	260
Through bore	mm	40	45	65	90	110
Size of fixing bolts	mm	M10	M12	M16	M22	M24
Bolting in depth	mm	15.5	17	20.5	22	26
Admissible max. Speed	r.p.m.	3000	2500	2000	1250	1000
Minimum flange width	Mm	18	24	30	40	40
Weight of chuck	Kgs.	7	15	30	61	91

Chuck Accuracy Chart

Testing Results in mm	Tolerance as per I.S. 2876-78	Grade
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OD and face

Ø150 – Ø250	0.05	0.02
Ø330 - Ø400	0.05	0.03

Run out on test mandrel held n jaws

Ø150 – Ø250	0.075	0.015
Ø330	0.075	0.02
Ø400	0.075	0.03

Concentricity face runout over disc runout

Ø150 – Ø250	0.075	0.01
Ø330 – Ø400	0.075	0.02

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