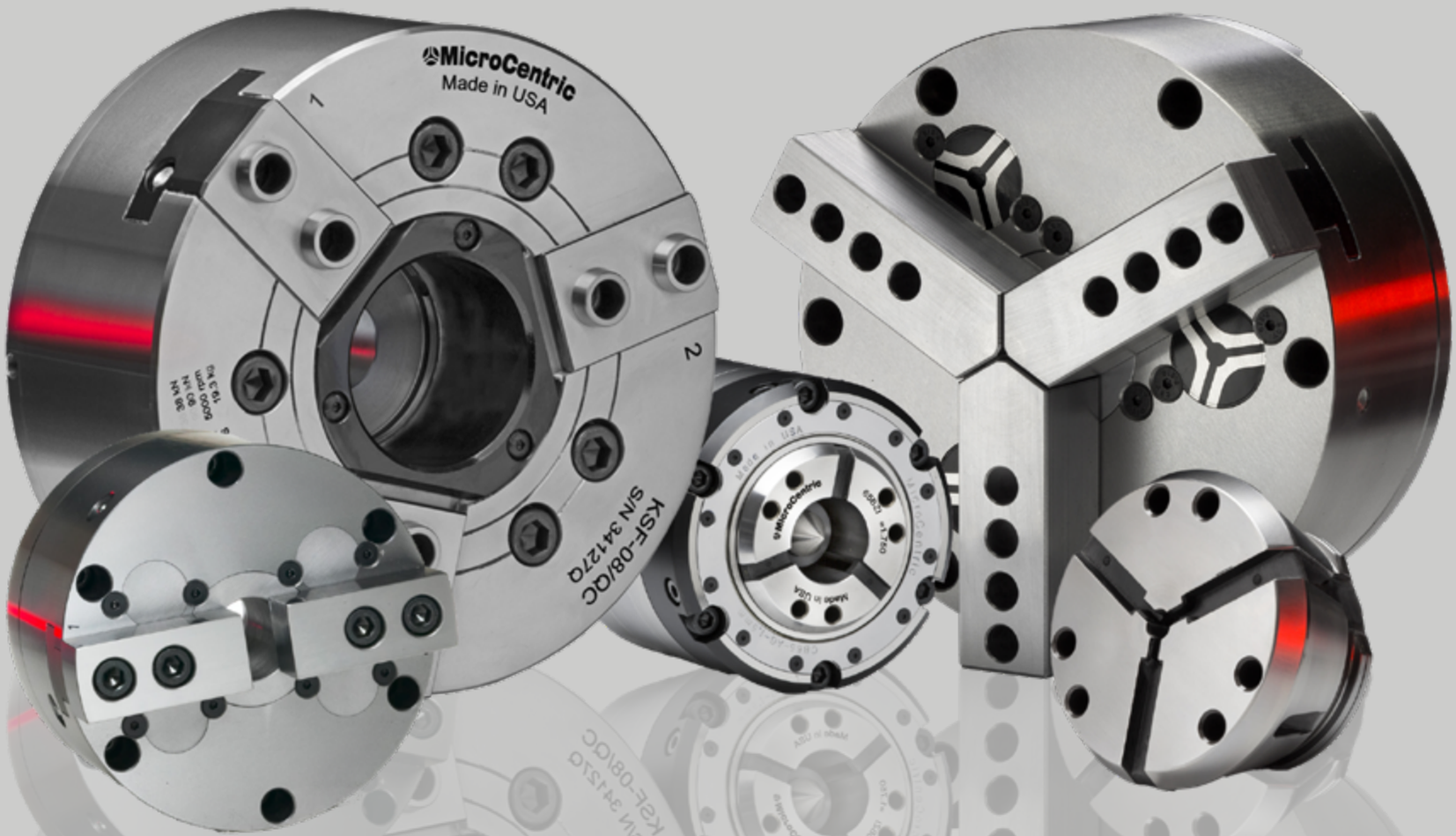
PRODUCT

Catalog 2025



MicroCentric

Precision Workholding Technology

Content

About us

Back to Content

MicroCentric has been at the forefront of precision chuck innovation for over 50 years, mastering the art of design and engineering to become the leading global expert in workholding.

With half a century of experience under our belt, each and every MicroCentric product reflects our dedication to quality. These products are built on a foundation of superior design, top-grade materials, and precise craftsmanship, ensuring they deliver reliable, long-lasting performance and unbeatable accuracy.

MicroCentric's journey isn't just about the years—it's a story of consistency, innovation, and a relentless drive for excellence. Our focus on setting new standards in precision engineering while prioritizing customer satisfaction has remained constant. Year after year, we continue to redefine what quality workholding technology means, creating products that aren't just tools but symbols of precision and reliability.

Innovation

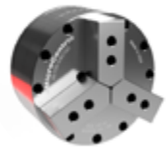
We have revolutionized industry standards through a series of patented breakthroughs, fundamentally altering the course of precision engineering.

Technology

With cutting-edge manufacturing technology, we achieve an extraordinary standard repeating accuracy of up to **.00002" TIR (0.0005mm),** setting an unmatched standard in precision

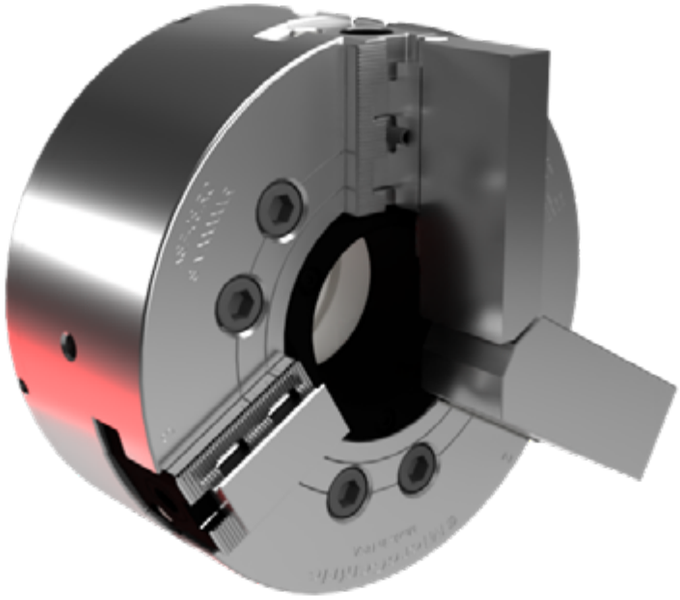
Quality

Our dedication to uncompromising quality sets a new standard in precision engineering, showcasing our commitment to excellence.



KSF Power Chuck

Back to Content



RC Rapid Change Jaw Locating System

Patented RC Rapid Change jaw system eliminates investing in multiple sets of base jaws or expensive monoblock jaws, while retaining the flexibility and cost savings of quick change chucks. With the RC design only the top jaw to be changed, not the entire base jaw. A patented locking cam mechanism and dovetail clamp secures top jaw to the base jaw. Top jaws are located on the base jaws by 1.5 x 60° serrations. This allows the top jaw to be adjusted radially increasing clamping range. Since RC top jaws are not mounted to the base jaws by cap screws, there are no counter bored holes in the top jaw to interrupt the clamping diameter.

RC System Design

The RC top jaw is locked and released by a patented cam mechanism and dovetail clamp. The cam bolt is accessed on the outside surface of the base jaws. A preset torque must be applied to the cam bolt when locking the top jaw to the base jaw.

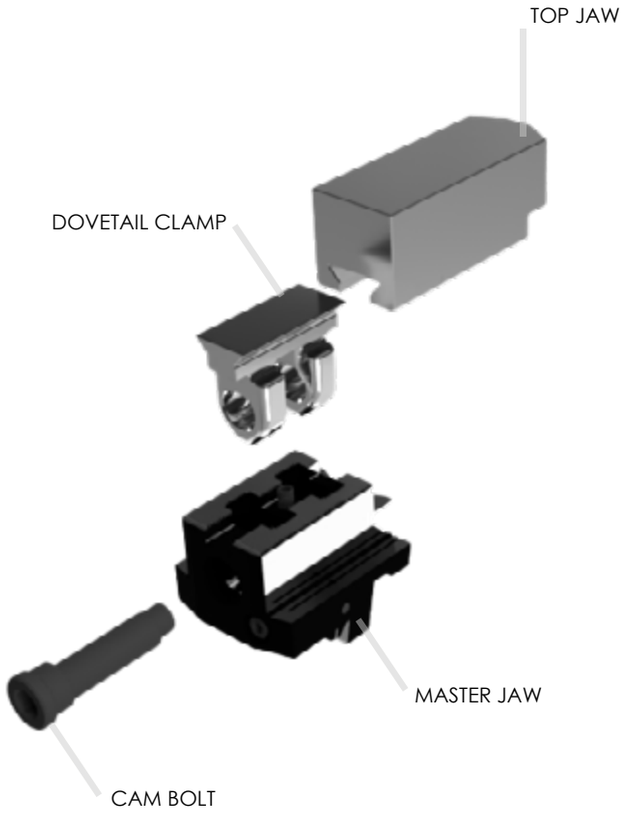
RC System Accuracies

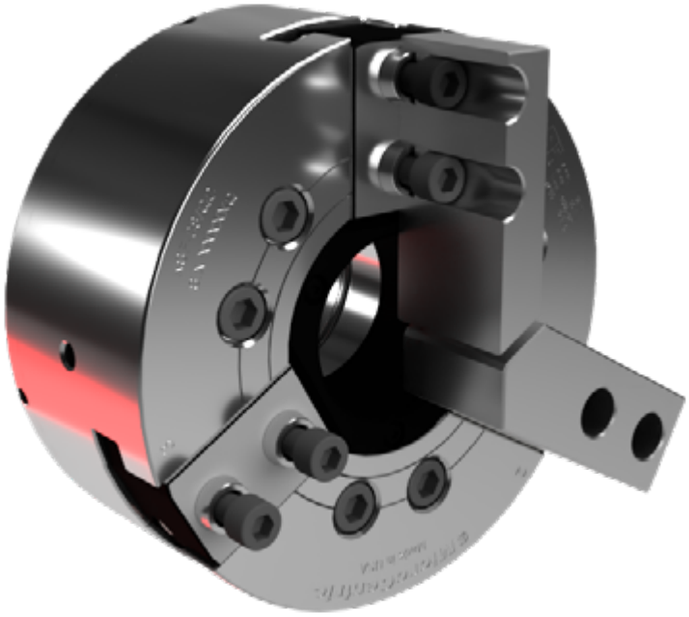
- .0004" / 0.01mm TIR max runout when top jaws finished on chuck without removal
- .0008" / 0.02mm TIR max runout when top jaws are finished and replaced on same jaw location

RC Top Jaws

Blank RC Top Jaws are made from 1045 steel. Special RC Top Jaws are quoted upon request.

Rapid Change Claw Top Jaws and Rapid Change Step Top Jaws are made from 4150 hardened Rc.52-56.





QC Precision Change Jaw Locating System

Patented QC Precision Change jaw locating system reduces setup time by maintaining .0002" / 0.005mm runout after changing top jaws. MicroCentric's QC system reduces setup time by eliminating re-machining top jaws or stirring-in the chuck in order to maintain close workpiece concentricity. KSF/QC chucks are qualified so jaws can be changed between chucks and still maintain .0008" / 0.02mm TIR runout.

QC System Design

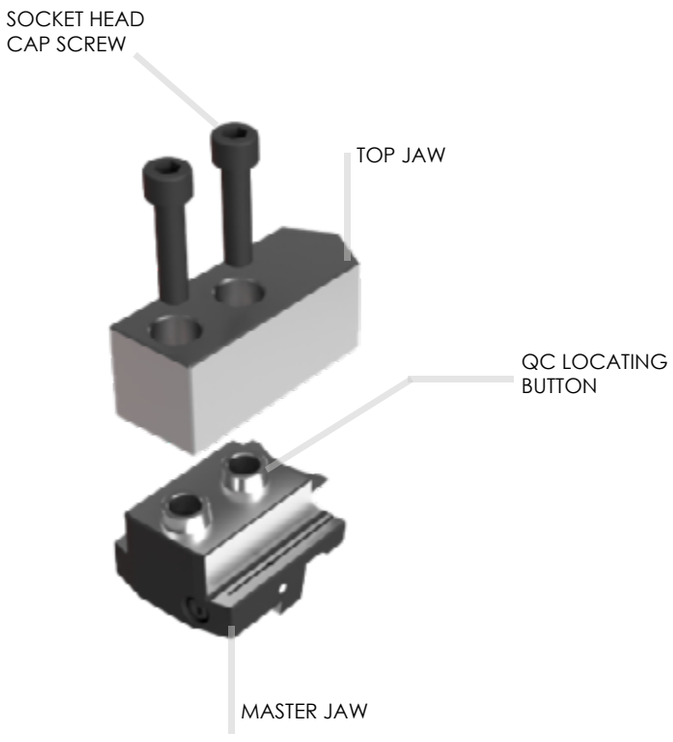
QC top jaws are located by two tapered buttons mounted in the master jaw. QC top jaws feature precision finished taper seats that are located by the tapered buttons.
QC top jaws seat on the OD of the tapered buttons and the face of the master jaw, assuring high accuracy and rigidity.

QC System Accuracies

- .0001" / 0.002mm TIR max runout when top jaws finished on chuck without removal
- .0002" / 0.005mm TIR max runout when top jaws finished and replaced on same chuck
- .0008" / .02mm TIR max runout when top jaw finished on another QC chuck (same model)

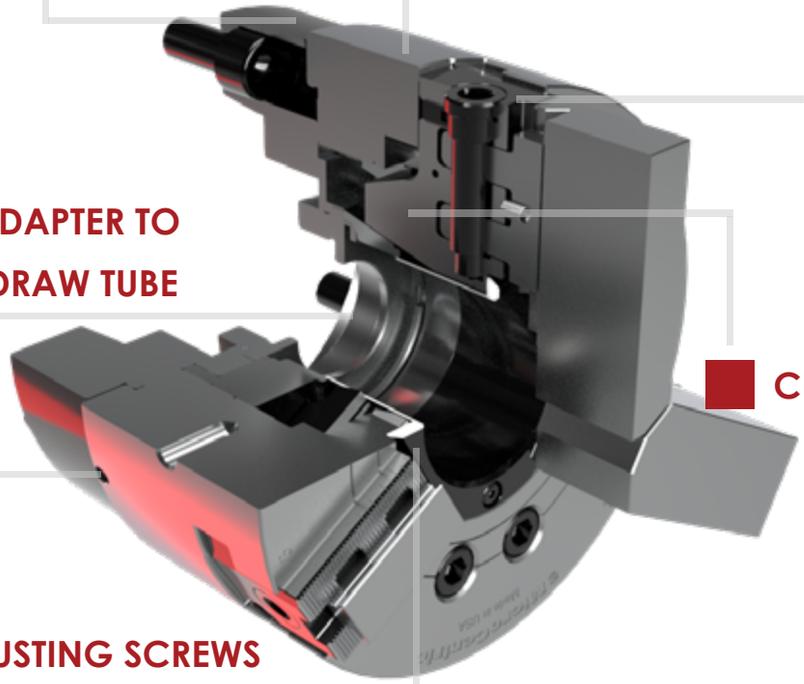
QC Top Jaws

Blank QC Top Jaws are made from A-2 tool steel. The tapered locating holes are precision jig bored for accurate location. QC jaws can be heat treated with minimal distortion to a hardness up to Rc 58-62. Special QC Top Jaws are quoted upon request.



HARDENED & PRECISION GROUND AL-LOY STEEL SPINDLE ADAPTER PLATE

HARDENED ALLOY STEEL CHUCK BODY WITH PRECISION GROUND JAW SLOTS



PRECISION GROUND & LAPPED MASTER JAWS TO FIT EACH JAW SLOT IN THE CHUCK BODY

DRAW TUBE ADAPTER TO FIT EXISTING DRAW TUBE

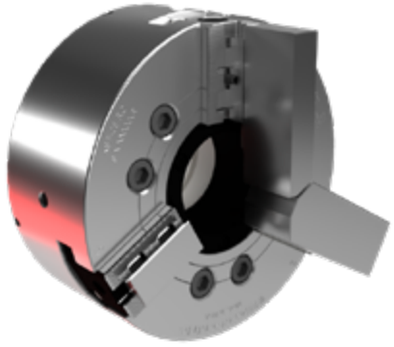
CENTER WEDGE DESIGN

RADIAL ADJUSTING SCREWS

LARGE THROUGH HOLE

Technical Data KSF-08/ RC

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-5, A2-6, A2-8 as well as other spindle mounting plates are available.

No. of Jaws	Repeating Accuracy[1]	Through Hole Diam-eter	Jaw Stroke (on Diameter)	Actuator Stroke	Max Draw Tube Force	Max Clamping Force	Max Speed[2]	Chuck Weight[3]	Moment of Inertia[4]
3	.0004"/ .01mm	2.589"/ 66mm	.299"/ 7.6mm	.709"/ 18mm	8,540 lb/ 38 kN	21,130 lb/ 94kN	5,000 rpm	52.0 lb/ 23.6kg	13.5 lb-ft^2/ 0.57kg-m^2

1 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
2 With standard top jaws at max draw tube force.
3 With standard top jaws and A2-6 spindle mounting plate.
4 With standard top jaws and A2-6 spindle mounting plate.

Drawings
PAGE 9

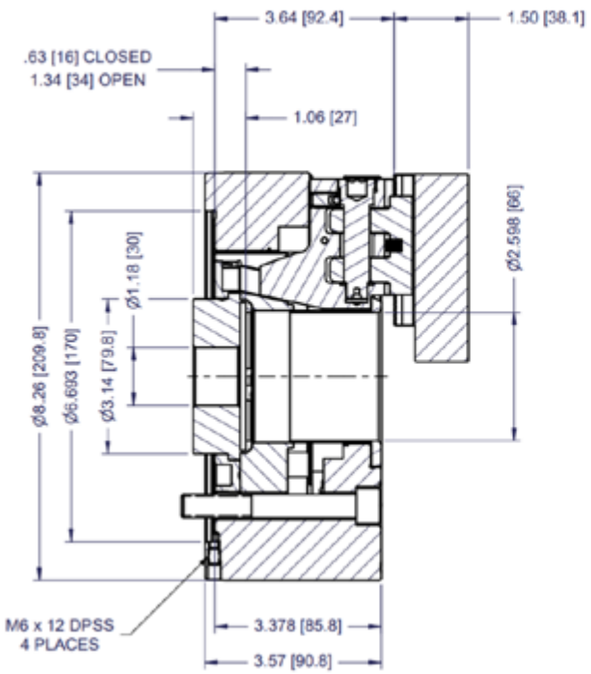
Top Jaws
PAGE 16

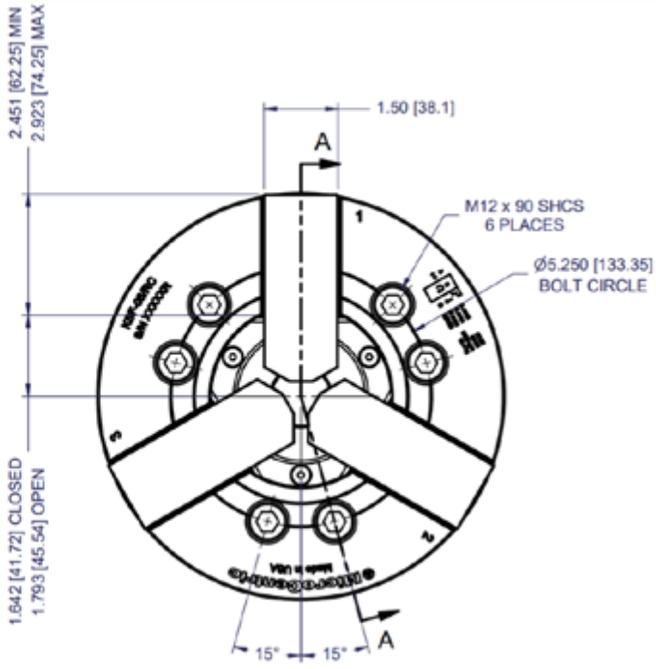
Accessories
PAGE 18

KSF-08/ RC Drawings

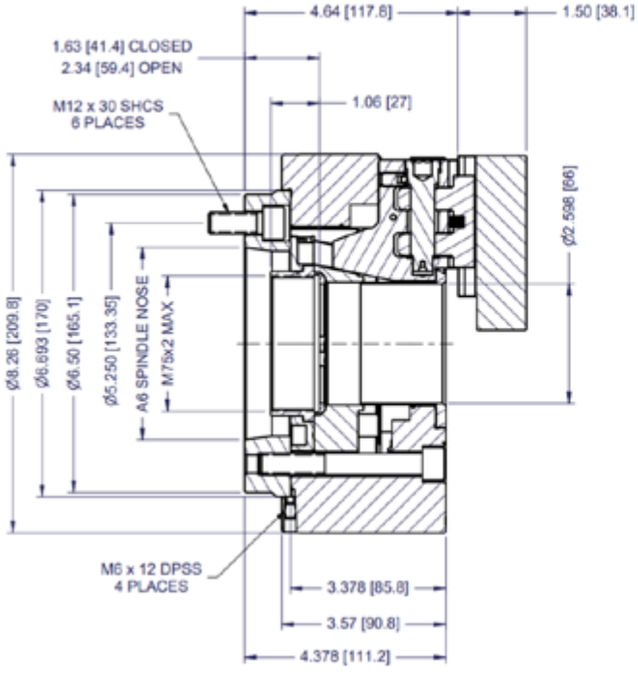
Back to Content

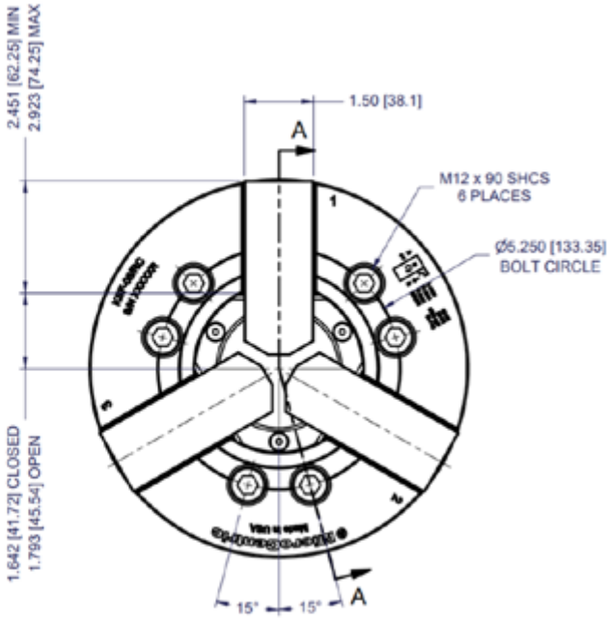
KSF-08/RC Dimensions





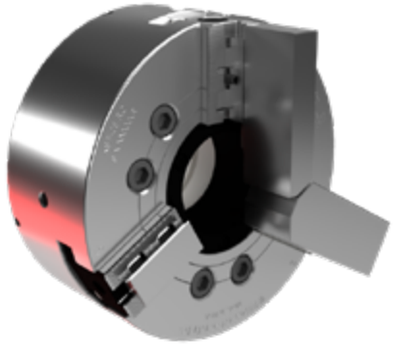
KSF-08/RC/ A6 Dimensions





Technical Data KSF-10/RC

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-6, A2-8, A2-11 as well as other spindle mounting plates are available.

No. of Jaws	Repeating Accuracy[1]	Through Hole Diam-eter	Jaw Stroke (on Diameter)	Actuator Stroke	Max Draw Tube Force	Max Clamping Force	Max Speed[2]	Chuck Weight[3]	Moment of Inertia[4]
3	.0004"/ .01mm	3.228" / 82mm	.335" / 8.5mm	.787" / 20mm	11,240 lb/ 50 kN	11,240 lb/ 50 kN	4,500 rpm	88.2lb/ 40.0kg	31.1lb-ft^2 / 1.31kg-m^2

1 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
2 With standard top jaws at max draw tube force.
3 With standard top jaws and A2-8 spindle mounting plate.
4 With standard top jaws and A2-8 spindle mounting plate.


Drawings
PAGE 11

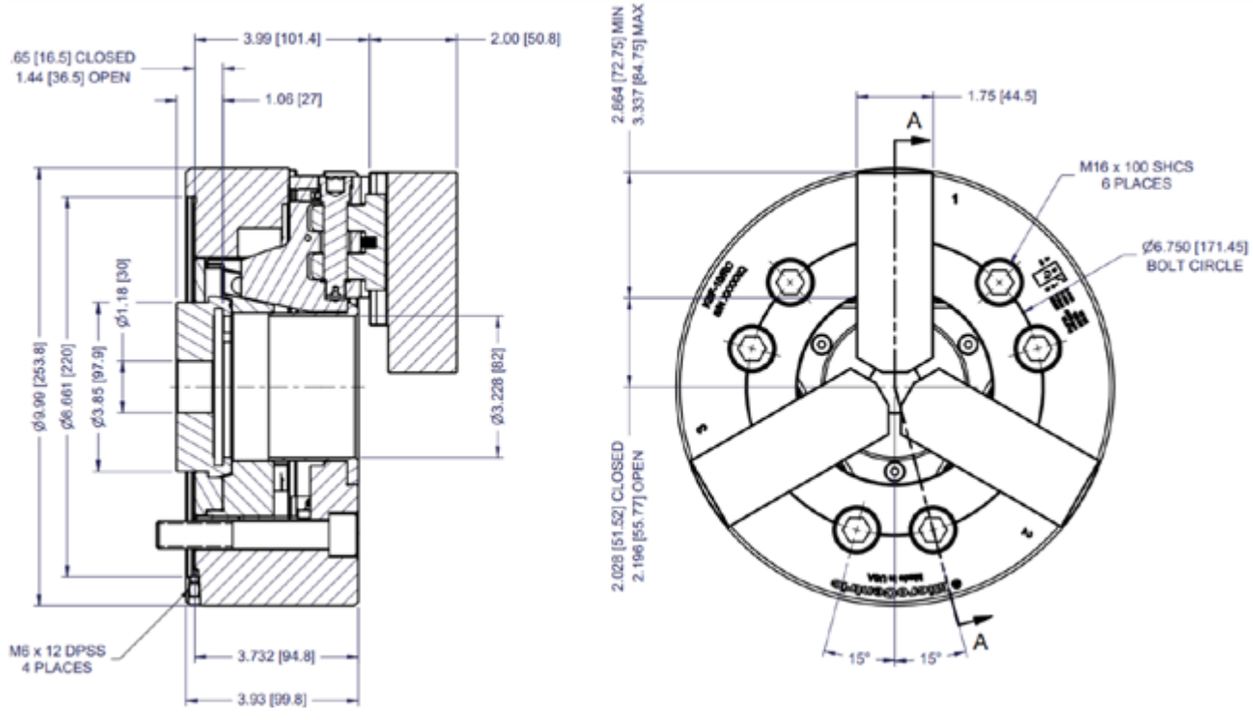

Top Jaws
PAGE 16


Accessories
PAGE 18

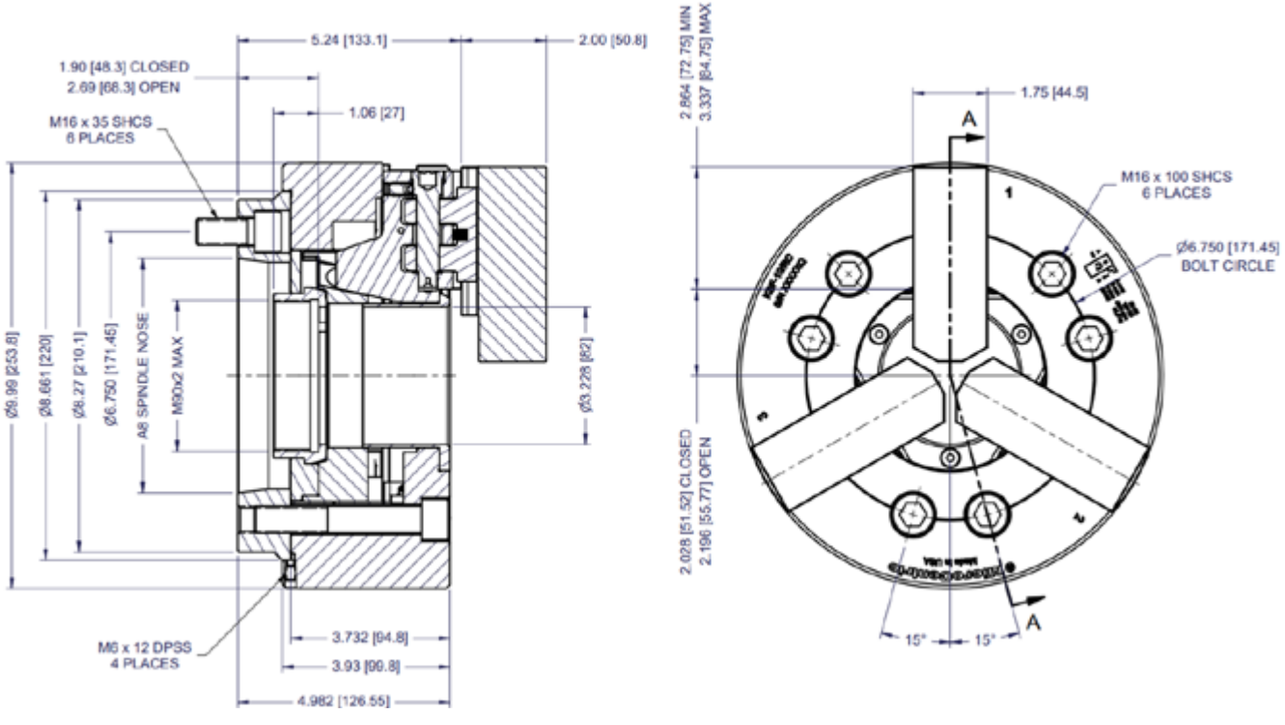
KSF-10/ RC Drawings

Back to Content

KSF-10/RC Dimensions

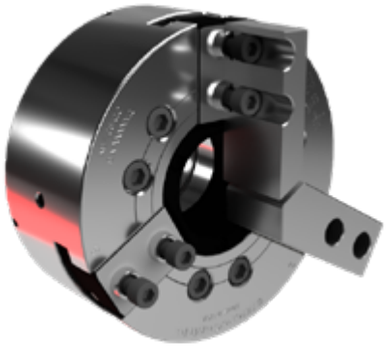


KSF-10/RC/ A6 Dimensions



Technical Data KSF-08/QC

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-5, A2-6, A2-8 as well as other spindle mounting plates are available.

No. of Jaws	Repeating Accuracy[1]	Through Hole Diam-eter	Jaw Stroke (on Diameter)	Actuator Stroke	Max Draw Tube Force	Max Clamping Force	Max Speed[2]	Chuck Weight[3]	Moment of Inertia[4]
3	.0001" / 0.0025mm	3.228" / 82mm	.335" / 8.5mm	.787" / 20mm	11,240 lb/ 50 kN	26,970lb/ 120kN	4,500 rpm	88.2lb/ 40.0kg	31.1lb-ft^2 / 1.31kg-m^2

1 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
2 With standard top jaws at max draw tube force.
3 With standard top jaws and A2-6 spindle mounting plate.
4 With standard top jaws and A2-6 spindle mounting plate.

Drawings
PAGE 13

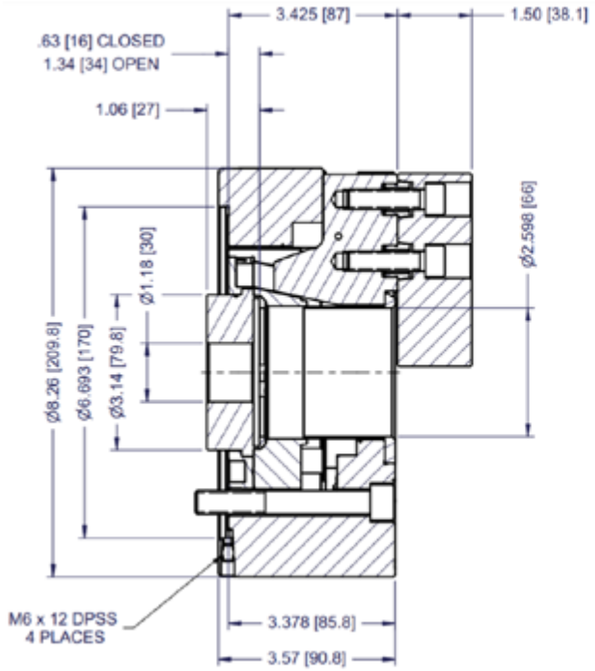
Top Jaws
PAGE 17

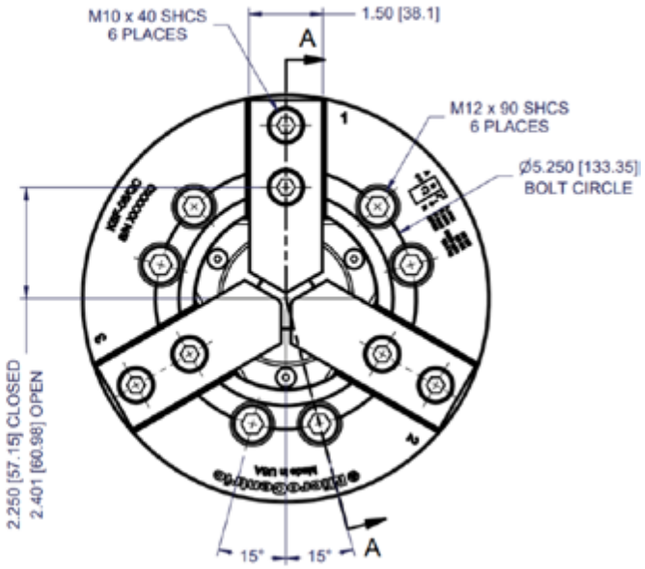
Accessories
PAGE 18

KSF-08/ QC Drawings

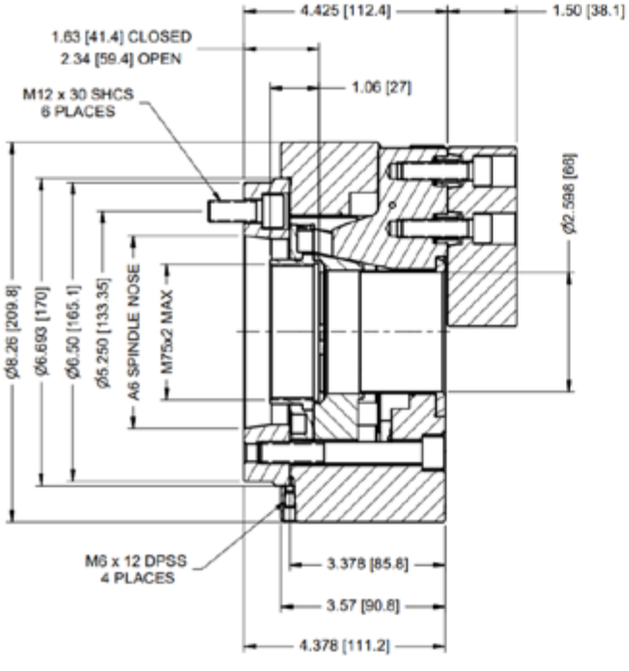
Back to Content

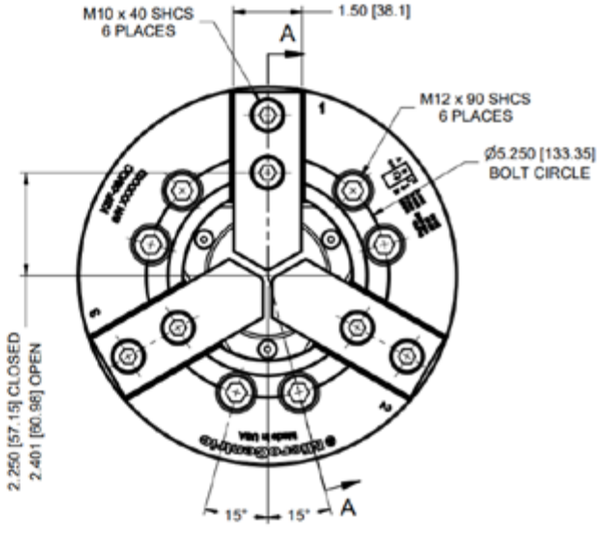
KSF-08/QC Dimensions





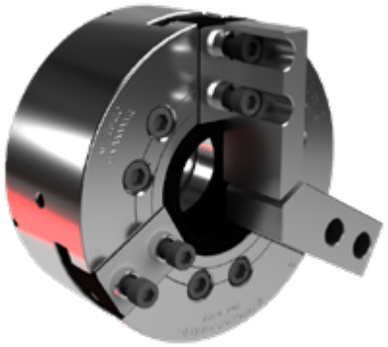
KSF-08/QC/ A6 Dimensions





Technical Data KSF-10/ QC

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-6, A2-8, A2-11 as well as other spindle mounting plates are available.

No. of Jaws	Repeating Accuracy[1]	Through Hole Diam-eter	Jaw Stroke (on Diameter)	Actuator Stroke	Max Draw Tube Force	Max Clamping Force	Max Speed[2]	Chuck Weight[3]	Moment of Inertia[4]
3	.0001" / 0.0025mm	3.228" / 82mm	.335" / 8.5mm	.787" / 20mm	11,240 lb / 50 kN	26,970lb / 120kN	4,500 rpm	88.2lb/ 40.0kg	31.1lb-ft^2 / 1.31kg-m^2

1 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
2 With standard top jaws at max draw tube force.
3 With standard top jaws and A2-8 spindle mounting plate.
4 With standard top jaws and A2-8 spindle mounting plate.

Drawings
PAGE 15

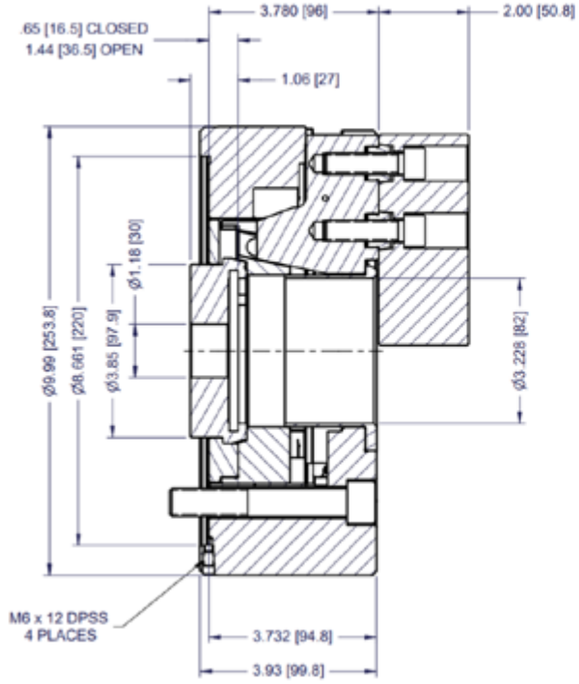
Top Jaws
PAGE 17

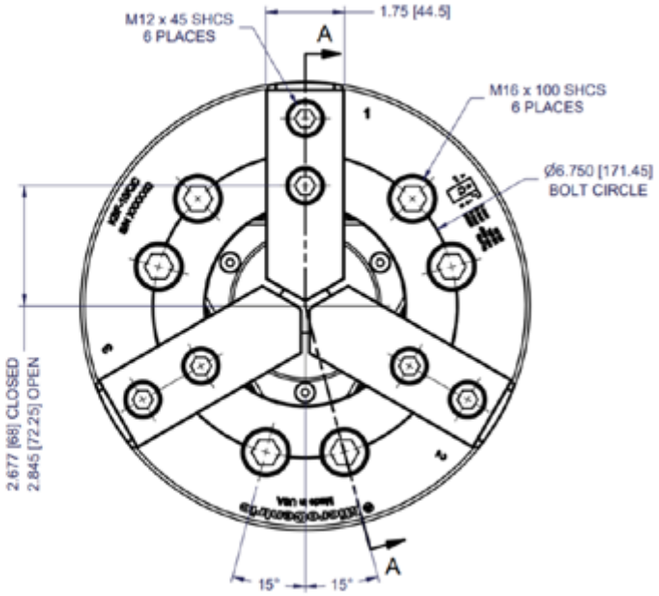
Accessories
PAGE 18

KSF-10/ QC Drawings

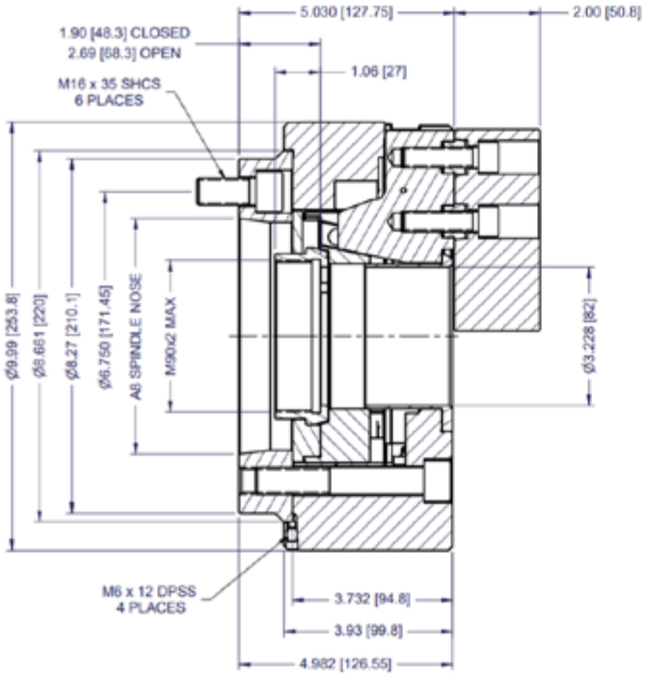
Back to Content

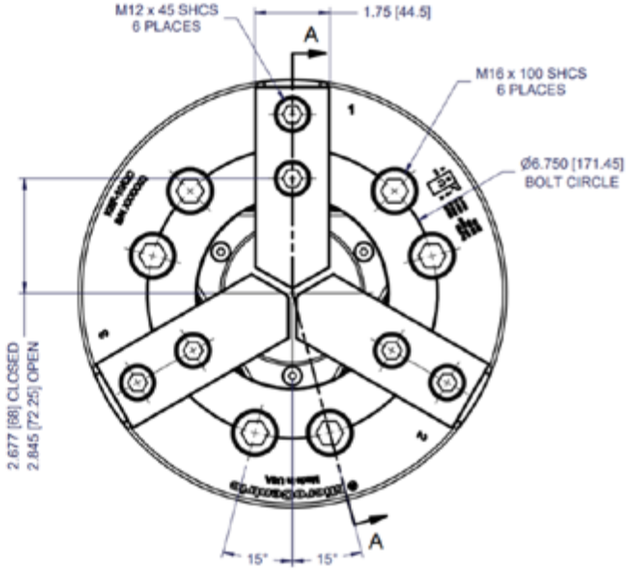
KSF-10/QC Dimensions





KSF-10/QC/ A6 Dimensions

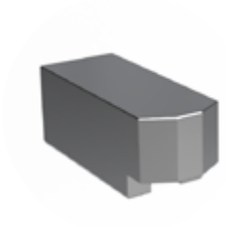




Top Jaws Rapid Change

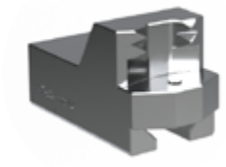
Back to Content

Blank RC Rapid Change Top Jaws



Model	Material	A	B	C	Weight
Size KSF-08/ RC					
RK8-150S	1045	1.50" / 38.1mm	3.80" / 96.5mm	1.50" / 38.1mm	2.0lb/ 0.9kg
RK8-200S				2.00" / 50.8mm	2.8lb/ 1.3kg
RK8-300S				3.00" / 76.2mm	4.4lb/ 2.0kg
Size KSF-10/ RC					
RK10-200S	1045	1.75" / 44.5mm	4.57" / 116.1mm	2.00" / 50.8mm	3.9lb/ 1.8kg
RK10-300S				3.00" / 76.2mm	6.1lb/2.8kg

Blank RC Rapid Change Claw Top Jaws



Model	Material	OD Clamp Range	ID Clamp Range	Weight
Size KSF-08/ RC				
CLAW 1	4150	0.91-2.28" / 23-58mm	8.86-10.47" / 225-266mm	1.41 lb/ 0.64 kg
CLAW 2		2.20-3.74" / 56-95mm	7.36-8.98" / 187-228mm	1.31 lb/ 0.59 kg
CLAW 3		3.62-5.16" / 92-131mm	6.06-7.68" / 154-195mm	1.23 lb/ 0.56 kg
CLAW 4		5.00-6.57" / 127-167mm	4.69-6.26" / 119-159mm	1.25 lb/ 0.57 kg
Size KSF-10/ RC				
CLAW 1	4150	0.91-2.76" /23-70mm	10.75-12.87" /273-327mm	2.21 lb /1.00 kg
CLAW 2		2.68-4.69" /68-119mm	8.86-10.94" /225-278mm	2.04 lb /0.93 kg
CLAW 3		4.57-6.57" /116-167mm	7.13-9.21" /181-234mm	1.88 lb /0.85 kg
CLAW 4		6.42-8.50" /163-216mm	5.24-7.28" /133-185mm	1.81 lb / 0.82 kg

Blank RC Rapid Change Step Top Jaws

Model	Material	OD Clamp Range	ID Clamp Range	Weight
Size KSF-08/ RC				
STEP JAW	4150	0.32-7.28" / 8-185mm	3.90-9.76" / 99-248mm	2.60 lb/ 1.18 kg
Size KSF-10/ RC				
STEP JAW	4150	0.47-9.45" / 12-240mm	3.78-10.59" / 96-269mm	3.35 lb/ 1.52 kg

Top Jaws Precision Change

Back to Content

Blank QC Precision Change Top Jaws

Model	Material	A	B	C	Weight
Size KSF-08/ QC					
QK8-150S	A-2	1.50" / 38.1mm	3.90" / 99.1mm	1.50" / 38.1mm	2.1lb/ 1.0kg
QK8-200S				2.00" / 50.8mm	2.8lb/ 1.3kg
QK8-300S				3.00" / 76.2mm	4.1lb/ 1.9kg
Size KSF-10/ QC					
QK10-200S	A-2	1.75" / 44.5mm	4.70" / 119.4mm	2.00" / 50.8mm	3.9lb/ 1.8kg
QK10-300S				3.00" / 76.2mm	6.9lb/3.1kg

Accessories KSF Chuck

Back to Content

Grease& Lubricant

Chuck Lubricant

Kluber ALTEMP Q NB 50, a white lubricating paste, enhances sliding characteristics, maintains constant clamping force, prevents stick-slip, and protects against fretting and tribo-corrosion, while resisting oils and water soluble cutting fluids, recommended for KSF chucks.

- Kluber ALTEMP Q NB 50/080 (80g tube)
- Kluber ALTEMP Q NB 50/600 (600g cartridge)
- Kluber ALTEMP Q NB 50/750 (7500g cartridge)

Grease Guns

The P-1 is a lever operated cartridge style grease gun with a tip suited to the fittings on KSF chuck models

Model

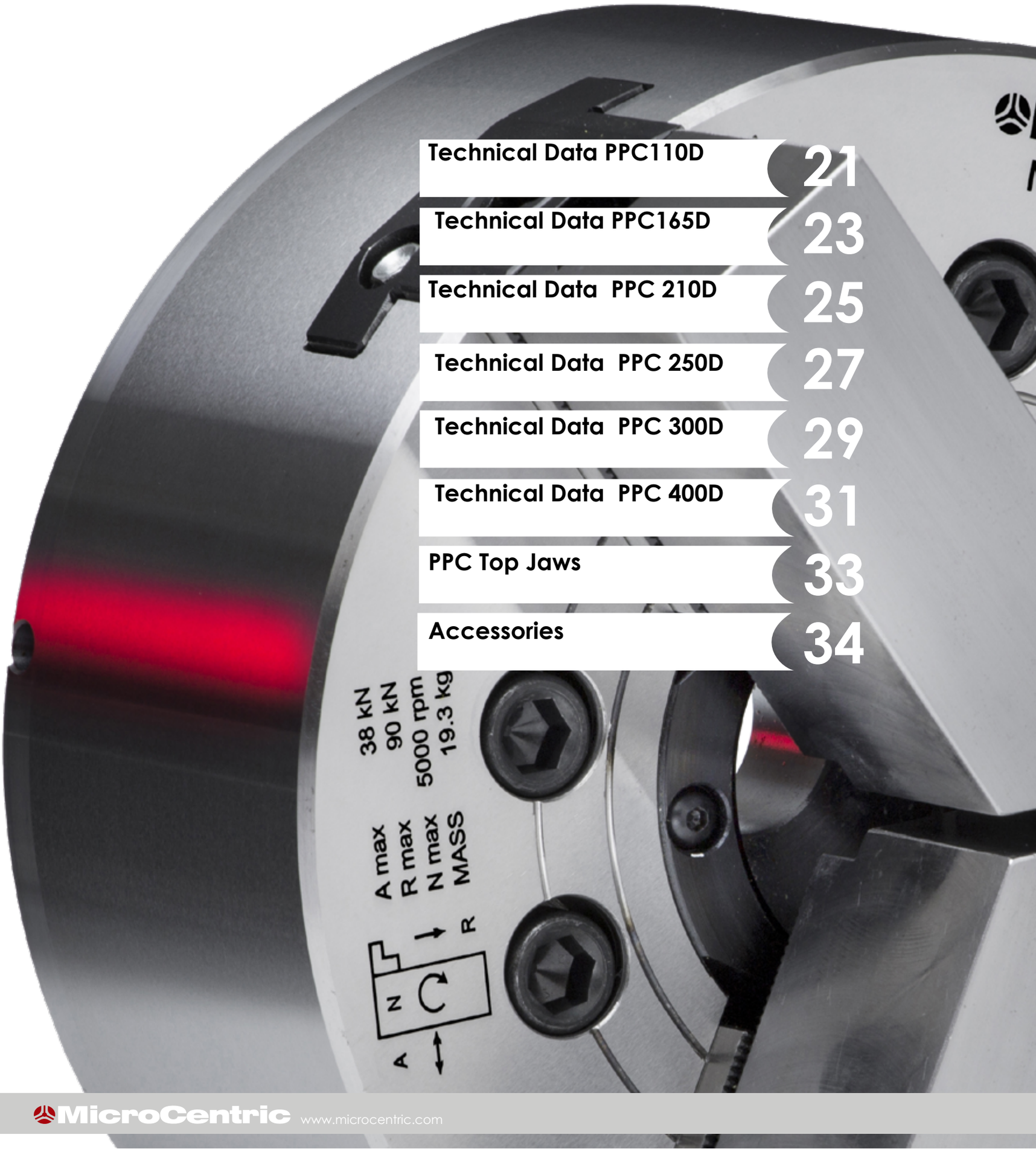
- P-1 (14oz/ 414ml)

Loading Rings

Chuck	Description	Model	Application
KSF-08/ RC	Loading rings are used to set the chuck in a clamping position for machining top jaws. CR loading rings are a cam design which provide easy adjustment of the loading position for OD clamping. LR loading rings are used for ID clamping jaws.	CR-KR8 LR-KR8	OD Clamping ID Clamping
KSF-10/ RC		CR-KR10 LR-KR10	OD Clamping ID Clamping
KSF-08/ QC		CR-KQ8 LR-KQ8	OD Clamping ID Clamping
KSF-10/ QC		CR-KQ10 LR-KQ10	OD Clamping ID Clamping

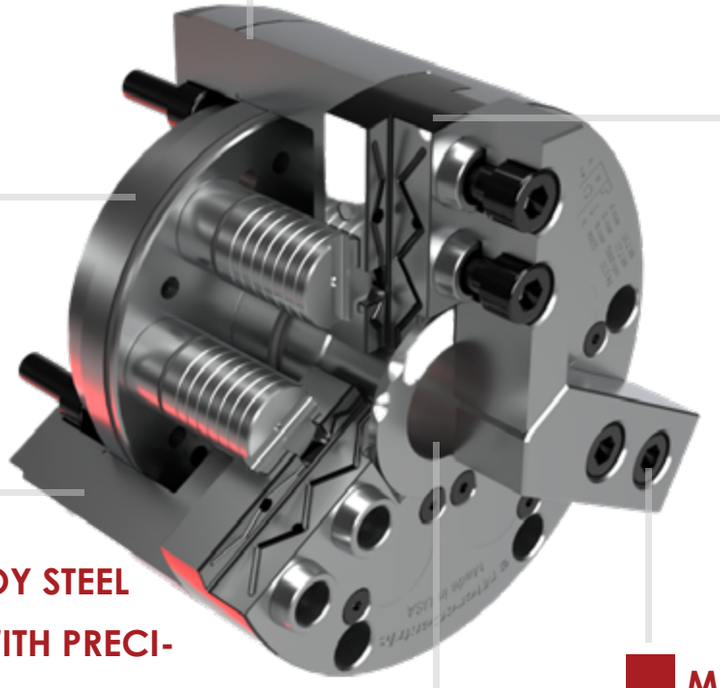
PPC Precision Power Chucks

Back to Content



HARDENED & PRECISION GROUND ALLOY STEEL SPINDLE ADAPTER PLATE

DRAW TUBE ADAPTER TO FIX EXISTING DRAW TUBE



PRECISION GROUND & LAPPED MASTER JAWS TO FIT EACH JAW SLOT IN THE CHUCK BODY

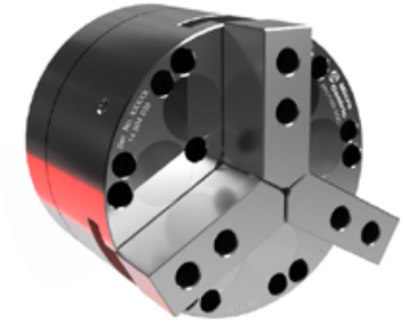
HARDENED ALLOY STEEL CHUCK BODY WITH PRECISION GROUND JAW SLOTS

MICROCENTRIC PATENTED QC PRECISION CHANGE JAW SYSTEM

THROUGH HOLE

Technical Data PPC110D

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-4, A2-5, A2-6 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC110D-3/QC	3	.0001" / 0.0025mm	1.063" / 27mm	.120" / 3.0mm	.340" / 8.6mm	2,090 lb/ 9.3 kN	4,600 lb/ 20.5kN	6,000 rpm	7.0 lb/ 3.2kg	13 lb-ft2 / 0.005 kg-m2
PPC110D-2/QC	2					1,390 lb/ 6.2kN	3,065 lb/ 13.6kN			
PPC110D-3/DP	3					2,090 lb/ 9.3kN	4,600 lb/ 20.5kN			
PPC110D-2/DP	2					1,390 lb/ 6.2kN	3,065 lb/ 13.6kN			
PPC110D-2/DP	3			.180" / 4.6mm		2,090 lb/ 9.3kN	3,760 lb/ 16.7kN	5,000 rpm		
PPC110DL-3/DP	3									

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 22

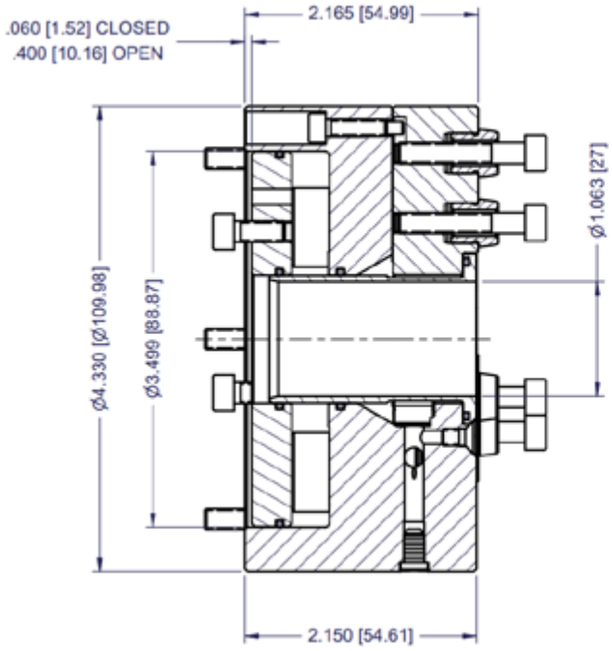
Top Jaws
PAGE 33

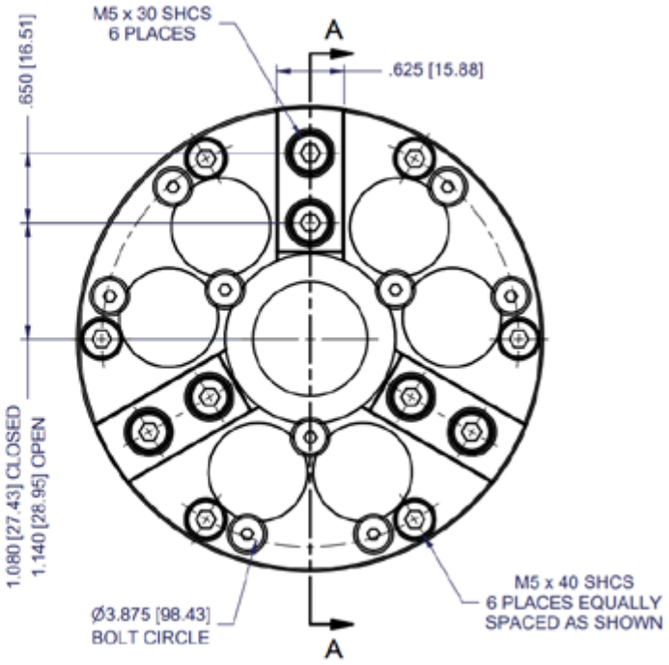
Accessories
PAGE 34

PPC110D Drawings

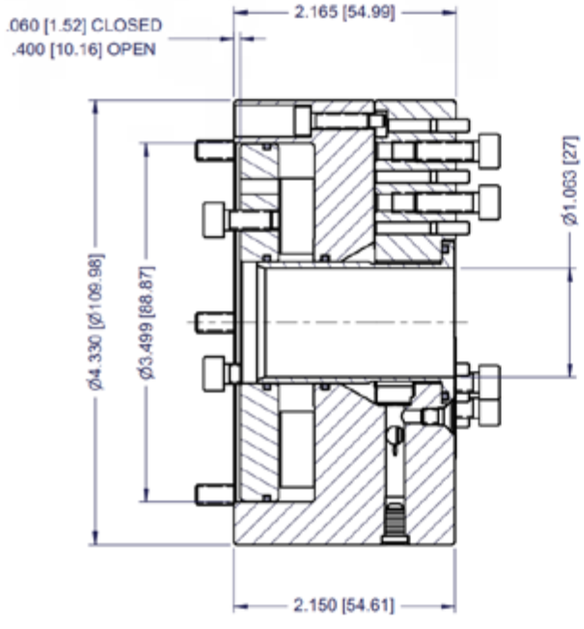
Back to Content

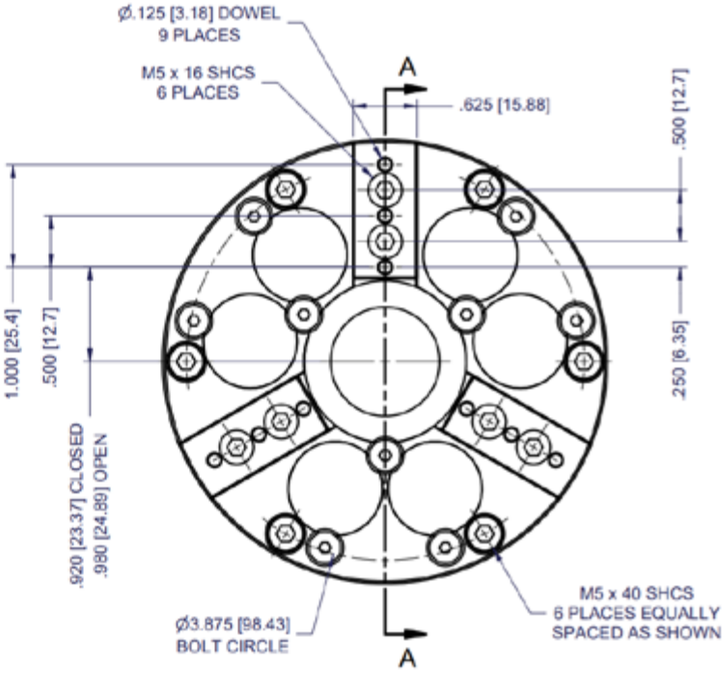
PPC110D-3/QC Dimensions





PPC110D-3/DP Dimensions





Technical Data PPC165D

Back to Content

Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-5, A2-6, A2-8 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC165D-3/QC	3	.0001"/ 0.0025mm	1.375"/ 35mm	.180"/ 4.6mm	.510"/ 13.0mm	3,640 lb/ 16.2 kN	8,370 lb/ 37.2 kN	5,000 rpm	25.2 lb/ 11.4 kg	.99 lb-ft2 / 0.04 kg-m2
PPC165D-2/QC	2					2,425 lb/ 10.8 kN	5,330 lb/ 23.7 kN			
PPC165DL-3/QC	3			.270"/ 6.9mm		3,640 lb/ 16.2 kN	6,840 lb/ 30.4 kN	4,000 rpm		
PPC165DL-2/QC	2					2,425 lb/ 10.8 kN	4,515 lb/ 20.1 kN			

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 24

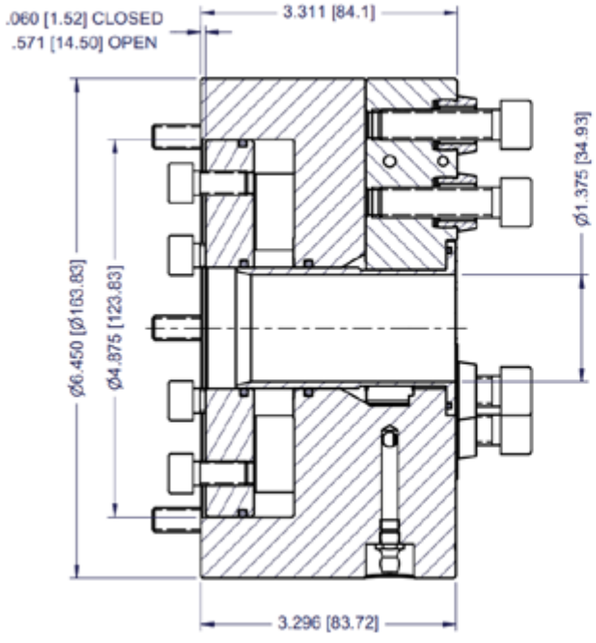
Top Jaws
PAGE 33

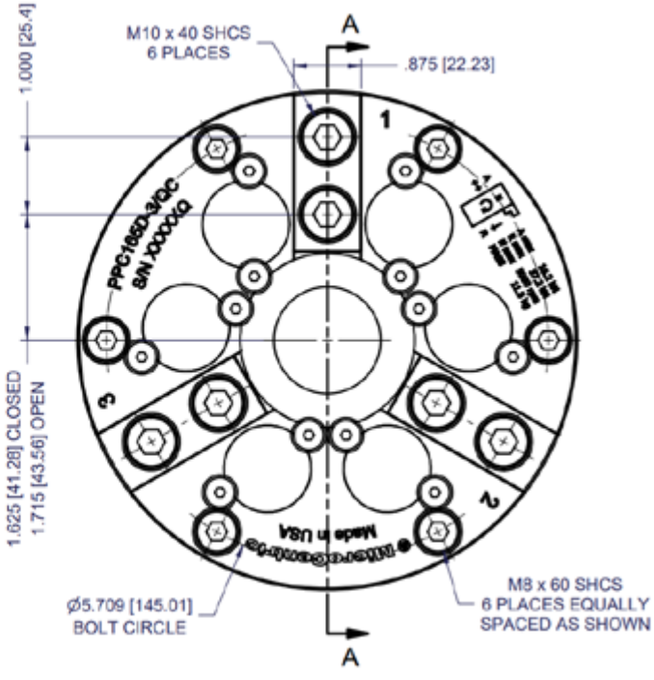
Accessories
PAGE 34

PPC165D Drawings

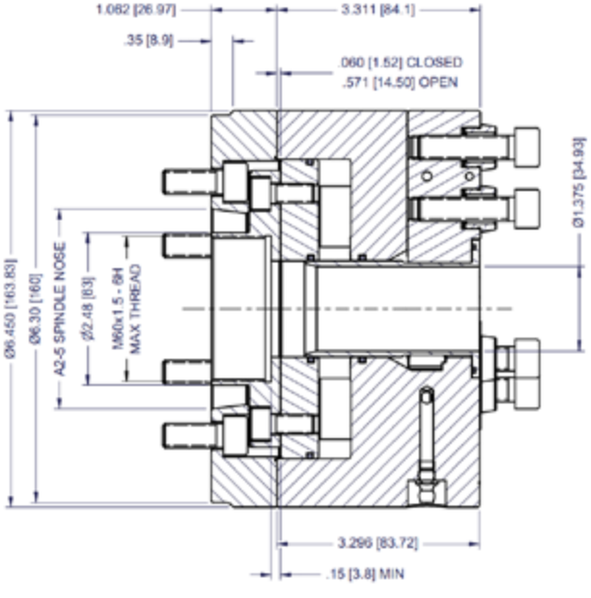
Back to Content

PPC165D-3/QC Dimensions

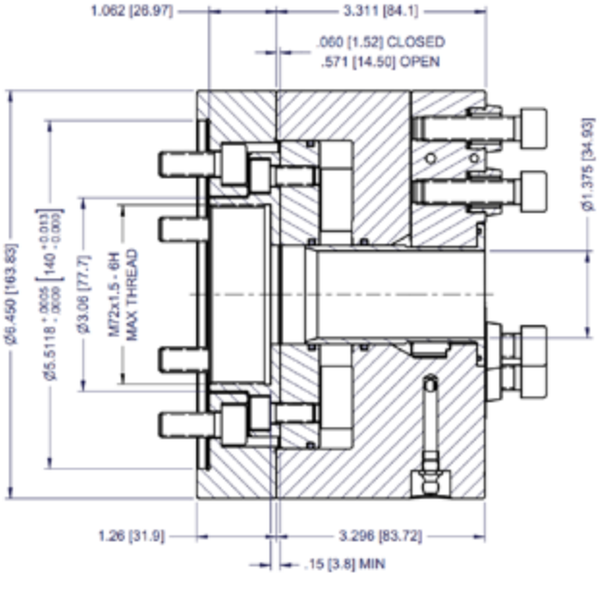




PPC165D-3/QC/A5 Dimensions

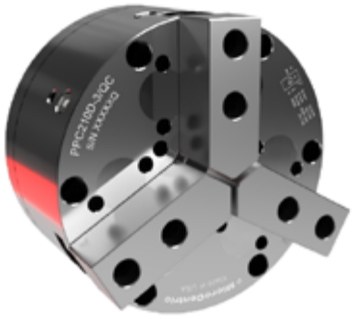


PPC165D-3/QC/140 Dimensions



Technical Data PPC210D

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-5, A2-6, A2-8 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC210D-3/QC	3	.0001"/ 0.0025mm	2.050" / 52mm	.220" / 5.6mm	.630" / 16.0mm	5,840 lb/ 26.0 kN	13,430 lb/ 59.7 kN	4,500 rpm	44.3 lb/ 20.1 kg0	2.87 lb-ft2 / 0.12 kg-m2
PPC210D-2/QC	2					3,890 lb/ 17.3 kN	8,950 lb/ 39.8 kN			
PPC210DL-3/QC	3			.340" / 8.6mm		5,840 lb/ 26.0 kN	10,510 lb/ 46.8 kN	3,500 rpm		
PPC210DL-2/QC	2					3,890 lb/ 17.3 kN	7,000 lb/ 31.1 kN			

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 26

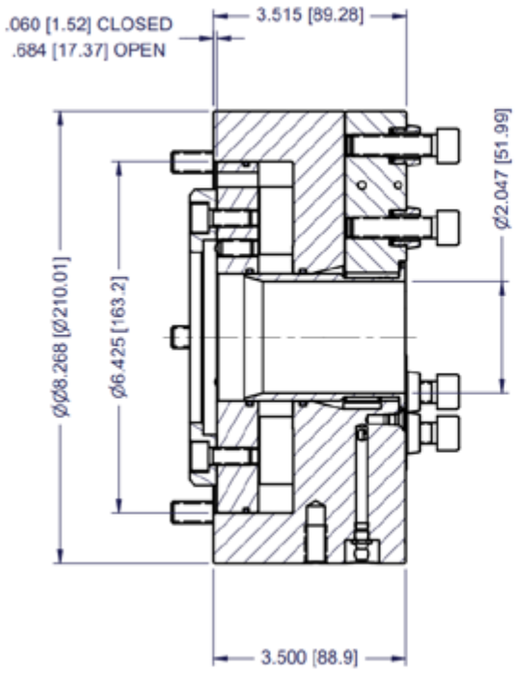
Top Jaws
PAGE 33

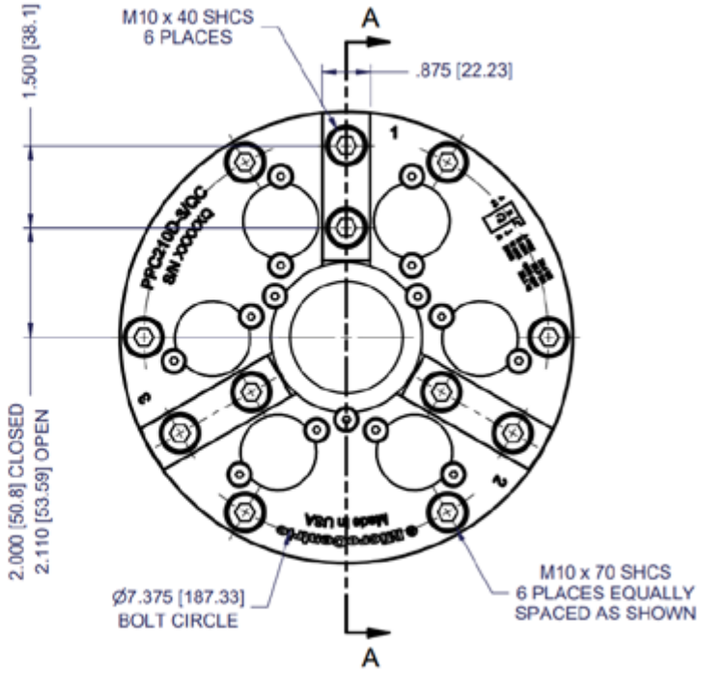
Accessories
PAGE 34

PPC210D Drawings

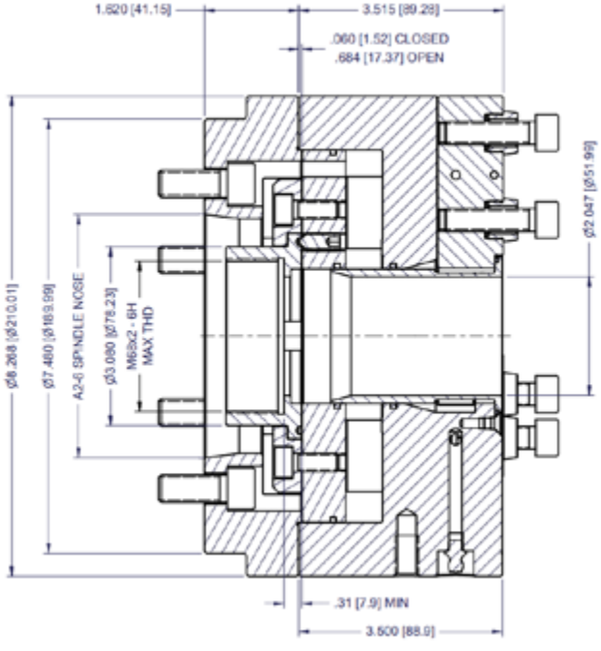
Back to Content

PPC210D-3/QC Dimensions

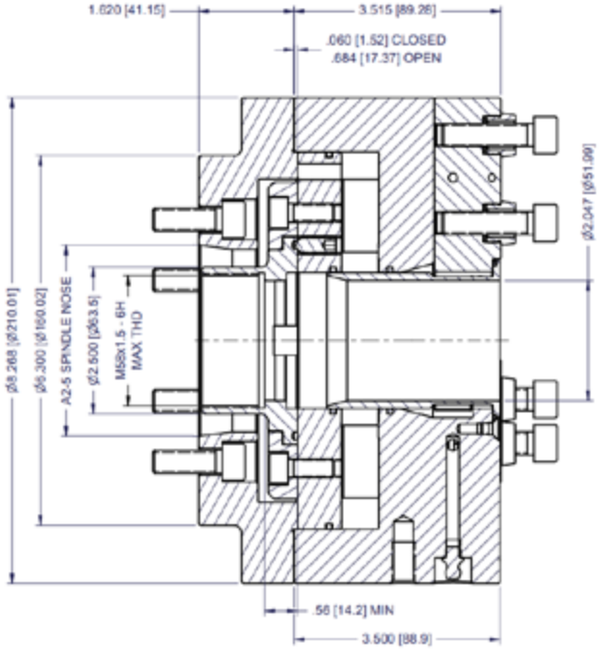




PPC210D-3/QC/A6 Dimensions

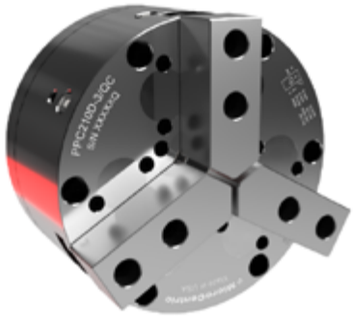


PPC210D-3/QC/A5 Dimensions



Technical Data PPC250D

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-6, A2-8, A2-11 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC250D-3/QC	3	.0002"/ 0.005mm	2.600"/ 66mm	.250"/ 6.3mm	.380" / 9.6mm	7,100 lb/ 31.6 kN	16,330 lb/ 72.6 kN	3,500 rpm	74.2 lb/ 33.7 kg	7.03 lb-ft2 / 0.30 kg-m2
PPC250D-2/QC	2					4,730 lb/ 21.0 kN	10,875 lb/ 48.4 kN			
PPC250DL-3/QC	3			.380"/ 9.6mm		7,100 lb/ 31.6 kN	12,780 lb/ 56.8 kN	2,500 rpm		
PPC250DL-2/QC	2					4,730 lb/ 21.0 kN	8,515 lb/ 37.9 kN			

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 28

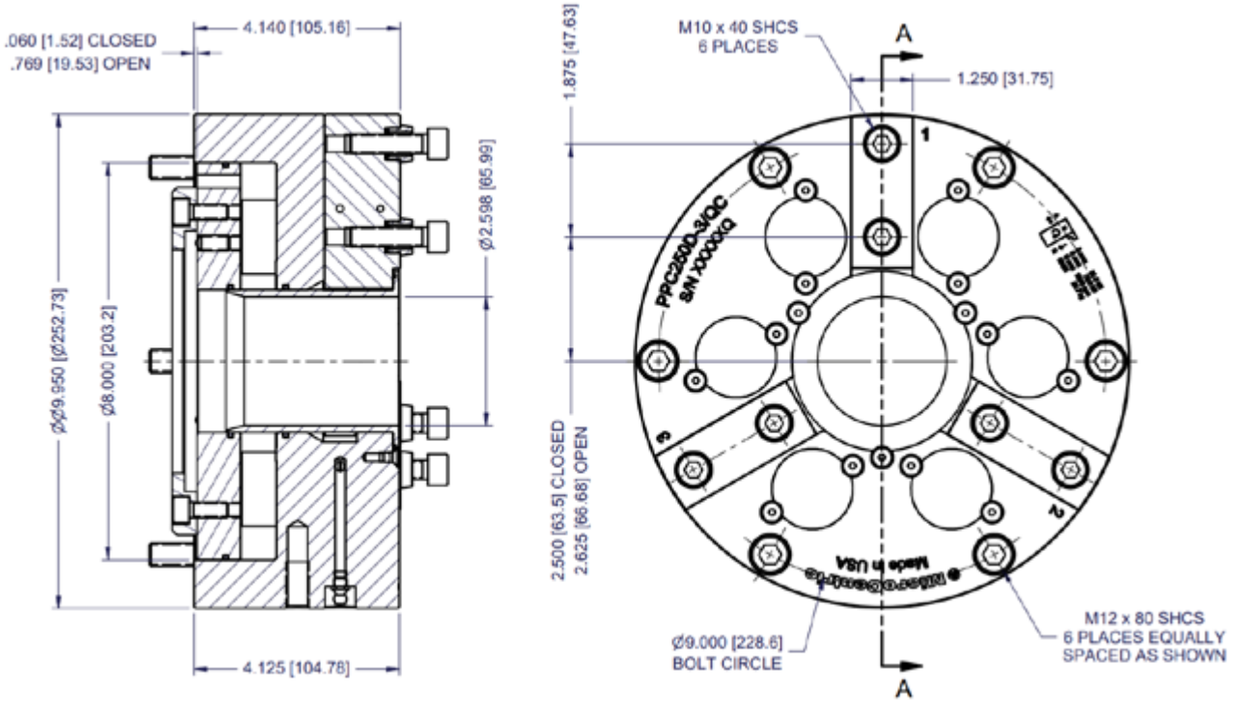
Top Jaws
PAGE 33

Accessories
PAGE 34

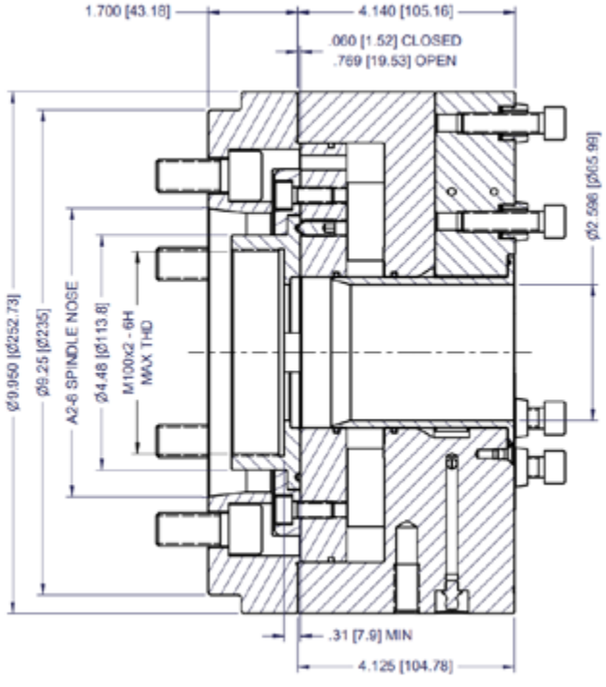
PPC250D Drawings

Back to Content

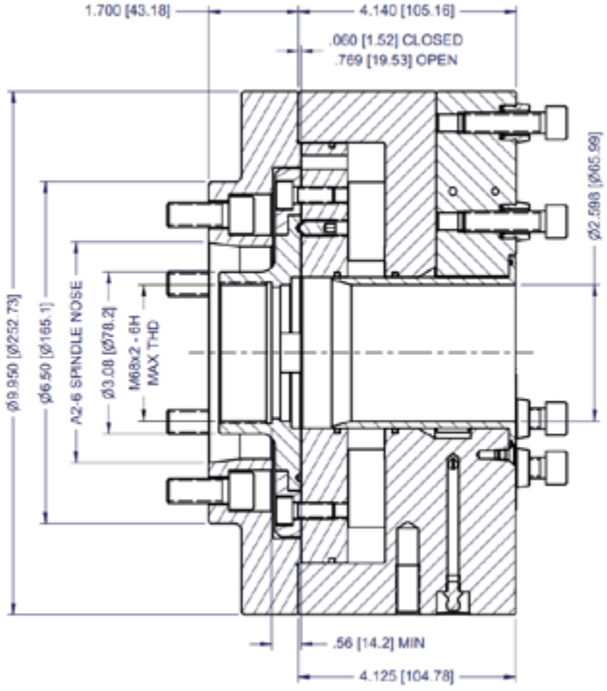
PPC250D-3/QC Dimensions



PPC250D-3/QC/A8 Dimensions

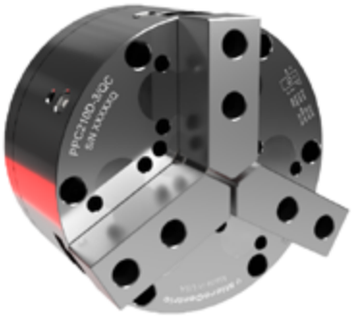


PPC250D-3/QC/A6 Dimensions



Technical Data PPC300D

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-8, A2-11 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC300D106-3/QC	3	.0002"/ 0.005mm	4.170"/ 106mm	.250"/ 6.3mm	.710" / 18.0mm	8,270 lb/ 36.8 kN	21,580 lb/ 95.9 kN	2,800 rpm	100.8 lb/ 45.7 kg	14.5 lb-ft2 / 0.61 kg-m2
PPC300D106-2/QC	2					5,510 lb/ 24.5 kN	14,240 lb/ 63.6 kN			
PPC300DL106-3/QC	3			.380"/ 9.6mm		8,270 lb/ 36.8 kN	16,830 lb/ 74.9 kN	2,000 rpm		
PPC300DL106-2/QC	2					5,510 lb/ 24.5 kN	11,110 lb/ 49.4 kN			

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 30

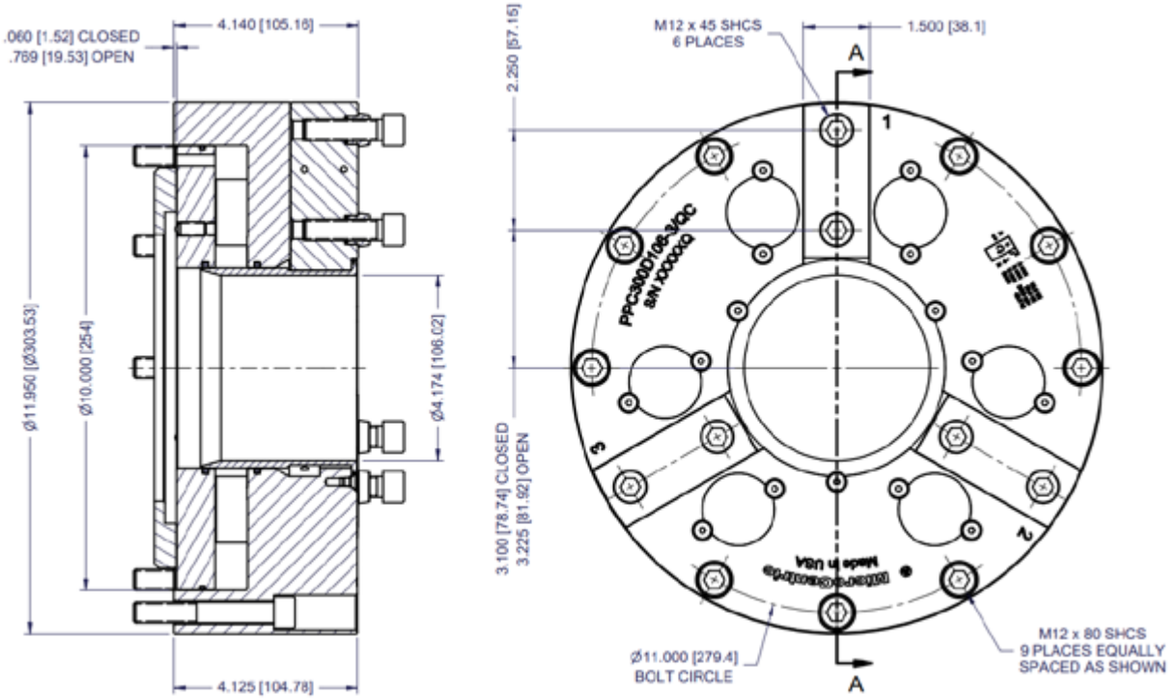
Top Jaws
PAGE 33

Accessories
PAGE 34

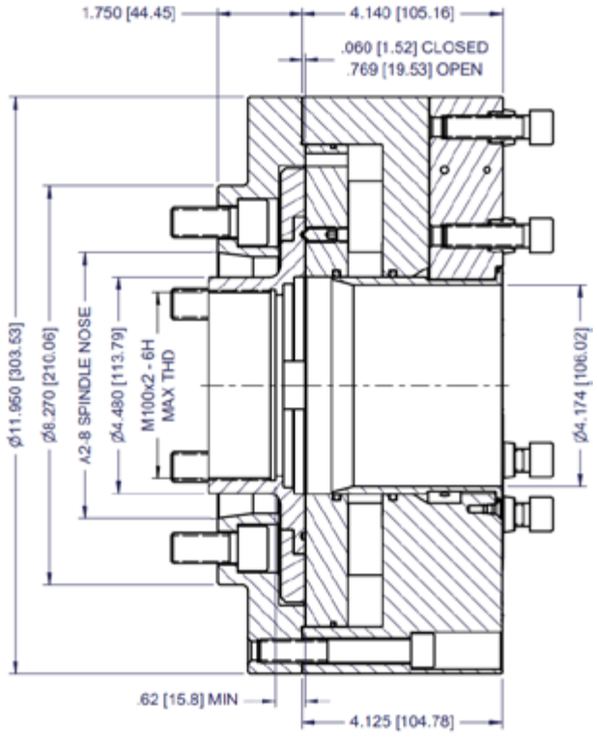
PPC300D Drawings

Back to Content

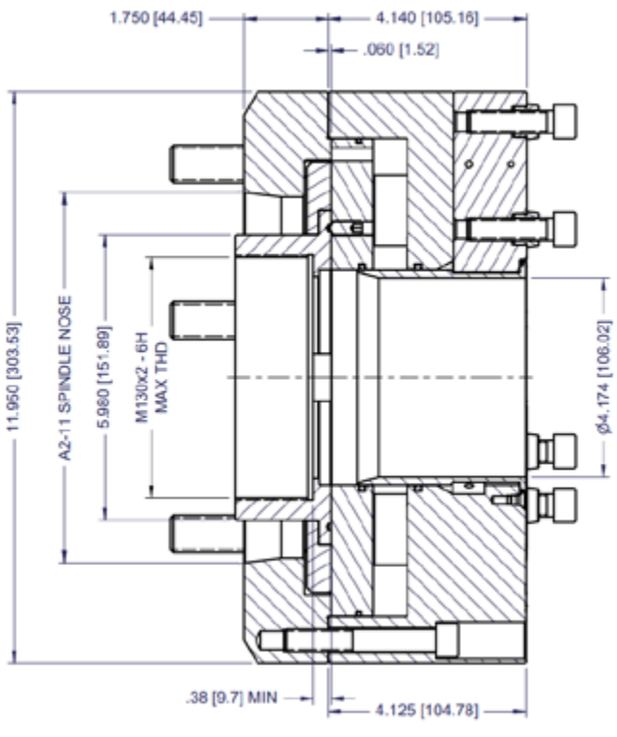
PPC300D106-3/QC Dimensions



PPC300D106-3/QC/A8 Dimensions

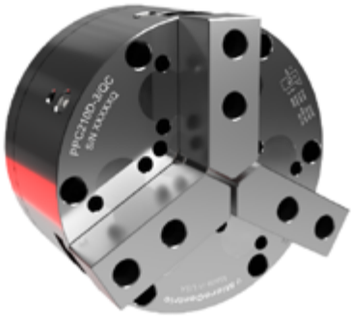


PPC300D106-3/QC/A11 Dimensions



Technical Data PPC400D

Back to Content



Features

- Precision fit master jaws to minimize jaw lift
- Hardened chuck body, actuators, and master jaws, for long term accuracy and performance

Standard Accessories

- Blank draw tube adapter
- 1 set blank top jaws
- Chuck lubricant, and grease guns are sold separately.

Threaded Draw Tube Adapters & Spindle Mounting Plates

- Threaded draw tube adapters are furnished on request
- A2-8, A2-11, A2-15 as well as other spindle mounting plates are available.

Chuck Model	No. of Jaws	Repeating Accuracy[1]	Through Hole Diameter	Jaw Stroke[2]	Actuator Stroke	Max Draw Bar Force	Max Clamping Force[3]	Max Speed[4]	Chuck Weight[5]	Moment of Inertia[6]
PPC400D-3/QC	3	.0002"/ 0.005mm	34.625"/ 117.5mm	.250"/ 6.3mm	.710" / 18.0mm	13,490 lb/ 60 kN	35070.2/ 156 kN	2,000 rpm	186.9 lb/ 84.8 kg	45.8 lb-ft2/ 1.93 kg-m2
PPC400DL-3/QC	3			.380"/ 9.6mm			27201.8lb / 121.8 kN	1,800 rpm		

1 Accuracy is the total indicator reading (radial and lateral runout of a master gage measured 1.00" (25.4mm from the top face of the standard top jaw at 1/2 max draw tube force.
2 Total jaw stroke.
3 Total clamping force.
4 With standard top jaws at max draw tube force.
5 Without top jaws and spindle mounting plate.
6 Without top jaws and spindle mounting plate.

Drawings
PAGE 32

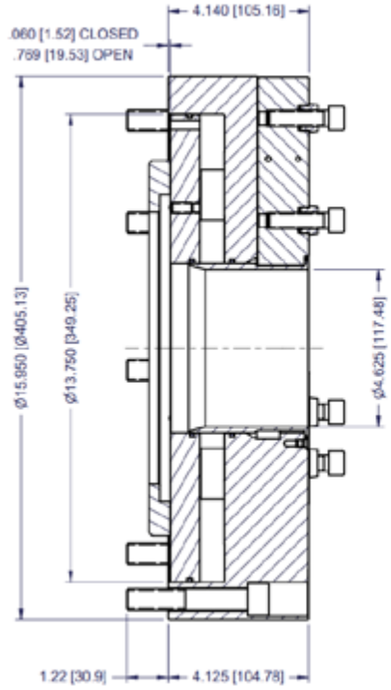
Top Jaws
PAGE 33

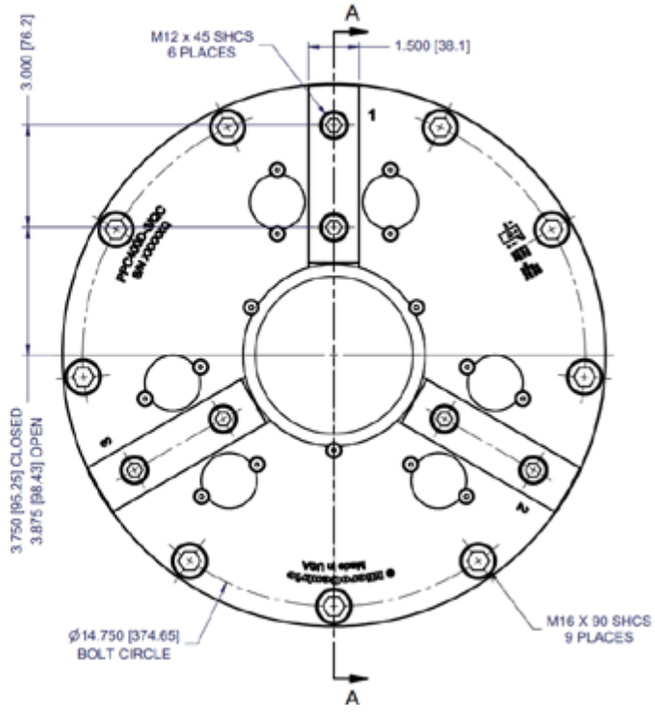
Accessories
PAGE 34

PPC400D Drawings

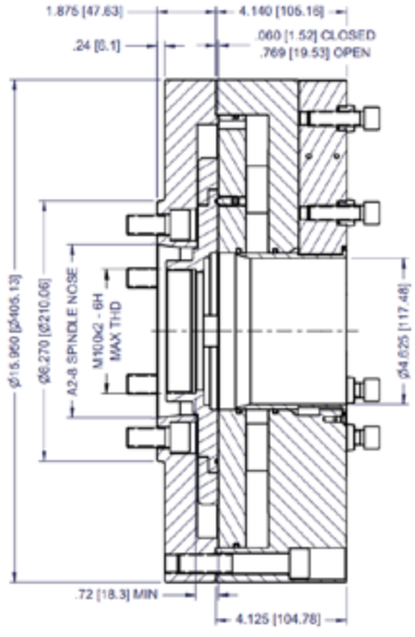
Back to Content

PPC400D-3/QC Dimensions

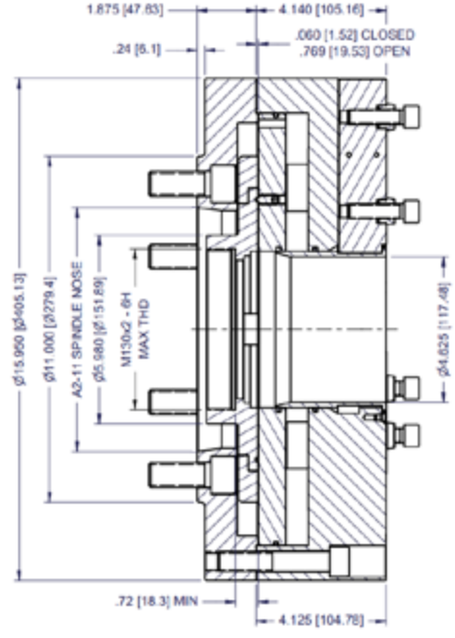




PPC400D-3/QC/A8 Dimensions



PPC400D-3/QC/A11 Dimensions



PPC Top Jaws

Back to Content

Blank QC Precision Change Top Jaws

Model	Material	A	B	C	Weight
Size PPC110D					
QP4-150S	A-2	0.75" / 19mm	2.12" / 54mm	1.50" / 38mm	0.59 lb/ 0.27kg
QP4-200S				2.00" / 50mm	0.78 lb/ 0.35 kg
Size PPC165D					
QP6-200S	A-2	1.25" / 32mm	3.22" / 82mm	2.00" / 50mm	1.8 lb/ 0.82kg
QP6-300S				3.00" / 76mm	2.7 lb/ 1.2kg
Size PPC210D					
QP8-200S	A-2	1.50" / 38mm	4.00" / 102mm	2.00" / 50mm	2.9 lb/ 1.3kg
QP8-300S				3.00" / 76mm	4.4 lb/ 2.0 kg
Size PPC250D					
QP10-200S	A-2	1.50" / 38mm	4.88" / 124mm	2.00" / 50mm	3.7 lb/ 1.7kg
QP10-300S				3.00" / 76mm	5.5 lb/ 2.5kg
Size PPC300D					
QP12-200S	A-2	1.50"/ 38mm	5.88"/ 149mm	2.00"/50mm	6.0 lb/ 2.7kg
QP12-300S				3.00"/76mm	9.0 lb/ 4.1kg
Size PPC400D					
QP16-200S	A-2	2.50"/ 63mm	7.25"/ 184mm	2.00"/50mm	9.8 lb/ 4.5 kg
QP16-300S				3.00"/ 76mm	14.7 lb/ 6.7 kg

QC Jaw Turning Fixture

Chuck	Turning Fixture Model
PPC110D-3/QC	QC/JTF-P110D-3
PPC110D-2/QC	QC/JTF-P110D-2
PPC110D-3/DP	DP/JTF-P110D-3
PPC110D-2/DP	DP/JTF-P110D-2
PPC165D-3/QC	QC/JTF-P165D-3
PPC165D-2/QC	QC/JTF-P165D-2
PPC210D-3/QC	QC/JTF-P210D-3
PPC210D-2/QC	QC/JTF-P210D-2
PPC250D-3/QC	QC/JTF-P250D-3
PPC250D-2/QC	QC/JTF-P250D-2
PPC300D-3/QC	QC/JTF-P300D-3
PPC300D-2/QC	QC/JTF-P300D-2
PPC400D-3/QC	QC/JTF-P400D-3

Accesories

Back to Content

Grease& Lubricant

Chuck Lubricant

Kluber ALTEMP Q NB 50, a white lubricating paste, enhances sliding characteristics, maintains constant clamping force, prevents stick-slip, and protects against fretting and tribo-corrosion, while resisting oils and water soluble cutting fluids, recommended for KSF chucks.

- Kluber ALTEMP Q NB 50/080 (80g tube)
- Kluber ALTEMP Q NB 50/600 (600g cartridge)
- Kluber ALTEMP Q NB 50/750 (7500g cartridge)

Grease Guns

The H-1 is a pump style oil gun with an internal reservoir and includes a tip suited to the grease fittings on PPC110 up to PPC400D models.

Model

- H-1 (14oz/ 414ml)

Loading Rings

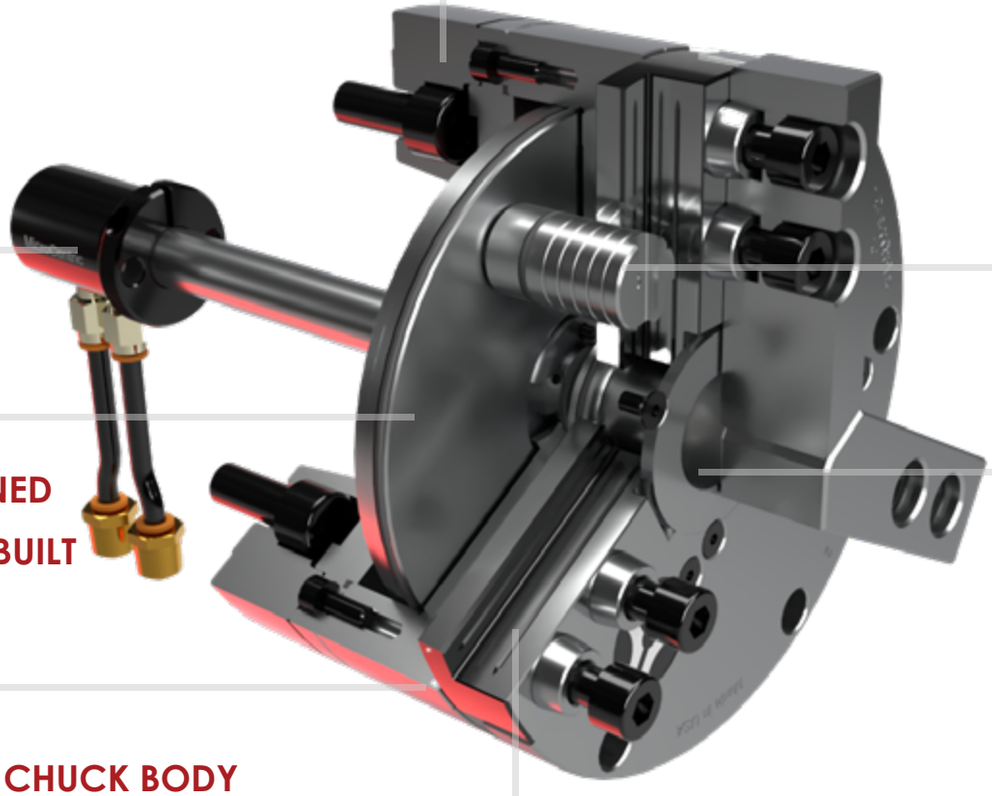
Chuck	Description	Model	Application
PP110D	Loading rings are used to set the chuck in a clamping position for machining top jaws. CR loading rings are a cam design which provide easy adjustment of the loading position for OD clamping. LR loading rings are used for ID clamping jaws.	CR-P4 LR-P4	OD Clamping ID Clamping
PPC165D		CR-P6 LR-P6	OD Clamping ID Clamping
PPC210D		CR-P8 LR-P8	OD Clamping ID Clamping
PPC250D		CR-P10 LR-P10	OD Clamping ID Clamping
PPC300D		CR-P12 LR-P12	OD Clamping ID Clamping
PPC400D		CR-P16 LR-P16	OD Clamping ID Clamping

Precision Air Chucks

Back to Content

HARDENED & PRECISION GROUND ALLOY STEEL SPINDLE ADAPTER PLATE

AIR TUBE ASSEMBLY WITH ROTARY JOURNAL



SIDE ACTUATOR DESIGN WITH OPTION FOR THROUGH HOLE

SELF-CONTAINED DESIGN WITH BUILT IN PISTON

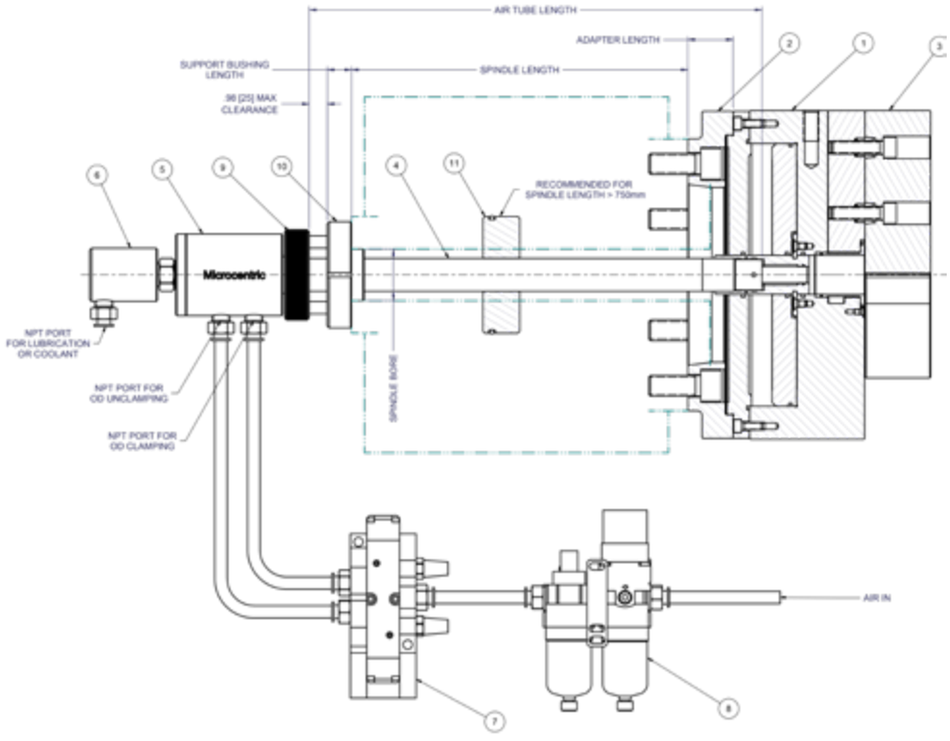
CENTER RECESS WITH COOLANT THROUGH

MEEHANITE CHUCK BODY WITH PRECICION GROUND JAW SLOTS

PRECISION GROUND & LAPPED MASTER JAWS TO FIT EACH JAW SLOT IN THE CHUCK BODY

Air Chuck System Assembly

Back to Content

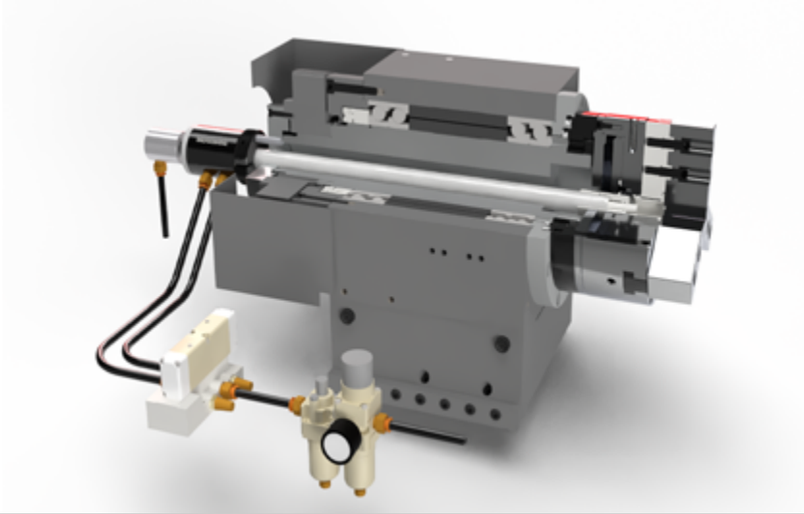


Parts List	
Item	Title
1	Air Chuck
2	Adapter
3	Top Jaw
4	Air Tube
5	Air Rotary Journal
6	Rotary Union[1]

Parts List	
7	Valve (Manual/ Electronic)
8	Filter Regulator Lubricator (FRL) with Gage
9	Knurled Ring
10	Support Bushing
11	Center Support Bushing[2]

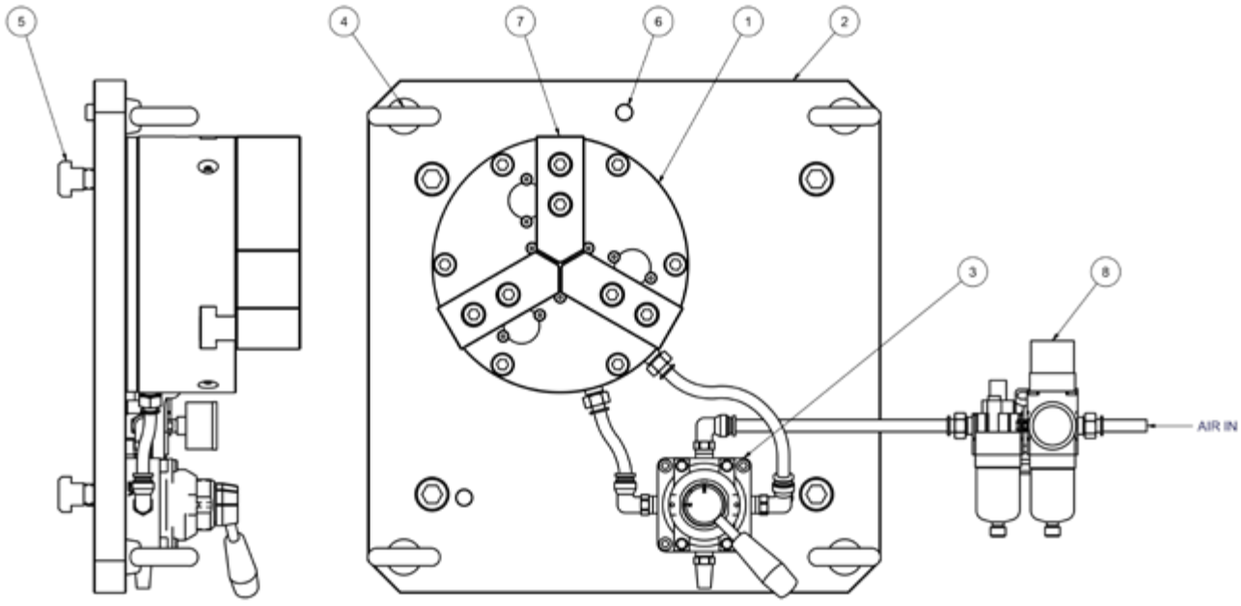
1 OPTIONAL. FOR COOLANT, LUBRICANTION, AIR SENSING, OR AIR BLAST.

2 RECOMMENDED FOR SPINDLE LENGTHS > 750mm



Non- Rotating Air Chuck System Assembly

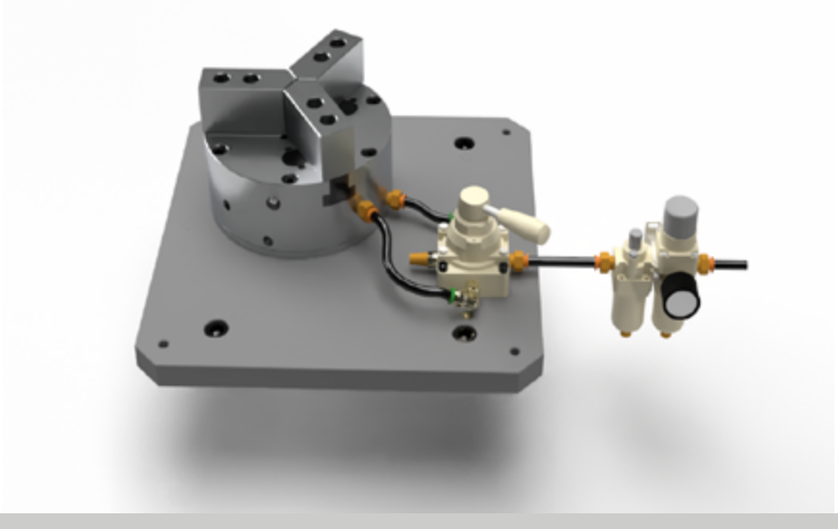
Back to Content



Parts List	
Item	Title
1	Non Rotating Air Cuck
2	Mounting Plate[1]
3	Control Valve (Manual/ Electric)
4	Lifting Eye Bolt[1]

Parts List	
5	T-Nut[1]
6	Dowel[1]
7	Top Jaw Blank
8	Filter Regulator Lubricator (FRL)

1 IF MOUNTING PLATE IS ORDERED



Precision Air Chucks

Back to Content

Rotating Air Chucks

Sizes
3"/ 80mm- 10" / 250mm

Rotating air chucks are ideal for precision turning and cylindrical grinding applications that require close concentricity, squareness, and parallelism tolerances. Variable clamping force enables clamping of thin-walled and other fragile parts with minimal distortion. All models, except the 3-50, feature a coolant or air passage through the center of the chuck.

Stationary Air Chucks

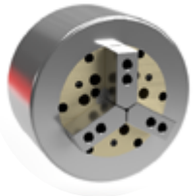
Sizes
3"/ 80mm- 10" / 250mm

Stationary air chucks are ideal for milling, drilling, tapping, and other applications requiring a compact self-contained workholding fixture. Air is supplied directly into the side of the chuck body, and the chuck can be mounted directly to the machine table or pallet. Through holes are available on all models.

Long Stroke Air Chucks

Sizes
4"/ 100mm- 10" / 250mm

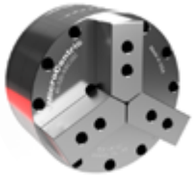
Long stroke air chucks feature extended jaw opening for load clearance or to clamp a range of diameters without changing top jaws. Long stroke chucks are available in rotating and stationary configurations. Their high accuracy makes them ideal for clamping headed workpieces for turning, grinding, or milling/drilling applications. Special models with total jaw stroke of .500" (12.7mm), .750" (19.1mm), and 1.000" (24.5mm) are also available. Please call for information.



HST High Speed Air Chucks

Sizes
4"/ 100mm,6"/ 150mm,8"/ 200mm

HST High Speed Air Chucks feature a titanium chuck body and are actuated by a patented external wedge design that maintains clamping force at high spindle speeds without counterweights. This revolutionary design minimizes the effects of centrifugal force resulting in consistent clamping force throughout the chuck's rpm range.

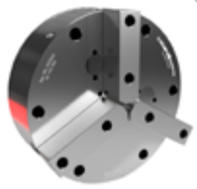


Sealed Air Chucks

Sizes
3"/ 80mm- 6" / 150mm

Sealed air chucks feature a stainless steel cover that seals the jaw slides. This design prevents contamination from grit and swarf and minimizes chuck maintenance for high volume production operations. Sealed air chucks are available in rotating and stationary configurations and are ideal for cylindrical grinding operations as well as machining abrasive materials such as powdered metal, ceramic, or carbide.

QC precision located top jaw system is standard on sealed air chucks.



Large Diameter Air Chucks

Sizes
12"/ 300mm,14"/ 350mm,
16"/ 400mm, 20"/ 500mm

Large Diameter Air Chucks offer high accuracy and adjustable clamping force for machining large diameter precision and thin-walled workpieces. Large Diameter chucks are availalbe in three jaw as well as two and six jaw configurations. Large Diameter models with extended jaw stroke, air ports on OD of chuck body for stationary applications, and other special configurations are quoted upon request.

Technical Data Rotating Air Chucks

Back to Content

Rotating air chucks are ideal for precision turning and cylindrical grinding applications that require close concentricity, squareness, and parallelism tolerances. Variable clamping force enables clamping of thin-walled and other fragile parts with minimal distortion. All models, except the 3-50, feature a coolant or air passage through the center of the chuck.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Max Speed[3]	Chuck Weight[4]
3 inch / 80mm	3-50-3	3	.00005" / 0.0012mm	.050" / 1.3mm	920 lb/ 4.1 kN	100 psi / 0.7 Mpa	6,000	3.0 lb/ 1.4 kg
	3-50C-3							
4 inch / 100mm	4-40-3	3	.00005" / 0.0012mm	.040" / 1.0mm	1,520 lb/ 6.8 kN	100 psi / 0.7 Mpa	6,000	6.1 lb/ 2.8 kg
	4-120-3			.120" / 3.0mm				6.9 lb/ 3.1kg
	4-360-3			.360"/ 9.1mm	1,300 lb/ 5.8 kN		4,000	7.9 lb/ 3.6 kg
6 inch / 150mm	6-40-3	3	.00005" / 0.0012mm	.040" / 1.0mm	3,820 lb/ 17.0 kN	100 psi / 0.7 Mpa	4,000	14.1 lb/ 6.4 kg
	6-120-3			.120" / 3.0mm				15.9 lb/ 7.2 kg
	6-360-3			.360"/ 9.1mm	3,275 lb/ 14.6 kN		3,000	18.3 lb/ 8.3 kg
8 inch / 200mm	8-120-3	3	.00005" / 0.0012mm	.120" / 3.0mm	6,570 lb/ 29.2 kN	100 psi / 0.7 Mpa	3,500	42.2 lb/ 19.1 kg
	8-360-3			.360"/ 9.1mm	5,630 lb/ 25.1 kN		2,500	45.2 lb/ 20.5 kg
10 inch / 250mm	10-220-3	3	.00005" / 0.0012mm	.220" / 5.6mm	10,330 lb/ 46.0 kN	100 psi / 0.7 Mpa	3,000	75.2 lb/ 34.1 kg
	10-400-3			.400"/ 10.2mm	8,850 lb/ 39.4 kN		2,000	

1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Maximum rpm s influenced by air pressure and mass of top jaws
4 Without top jaws and spindle mounting plate

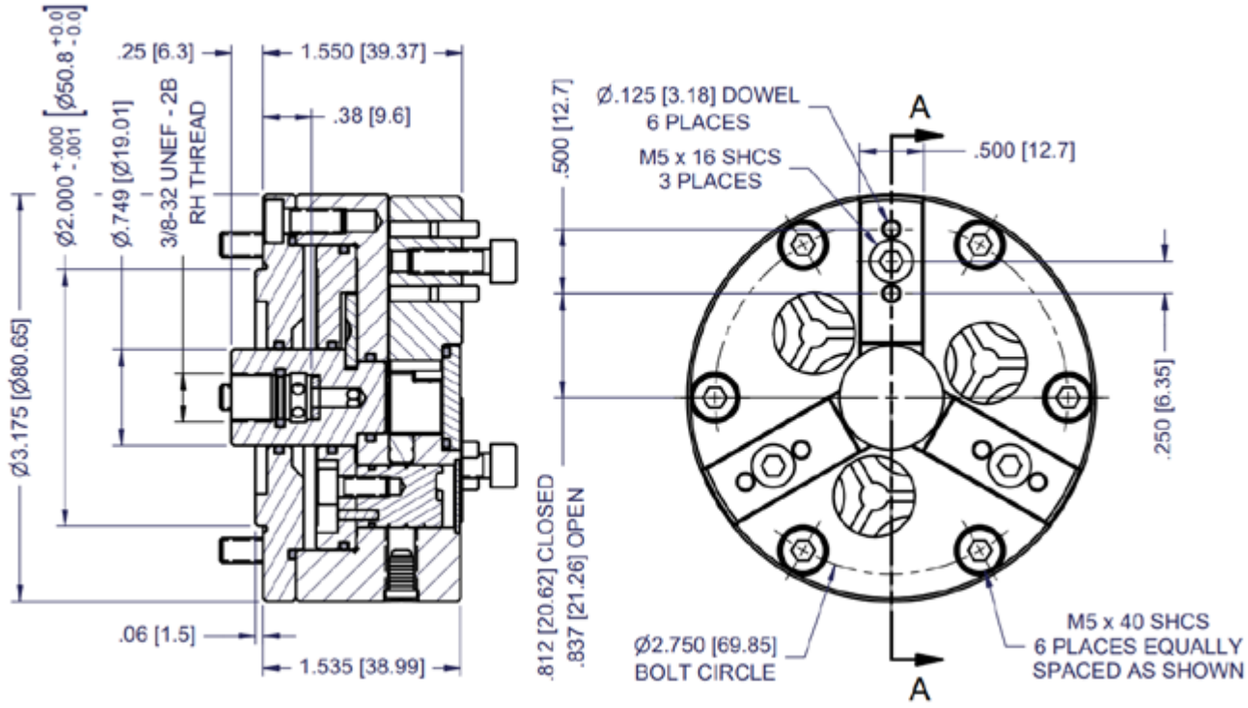
Drawings
PAGE 41

Top Jaws
PAGE 88

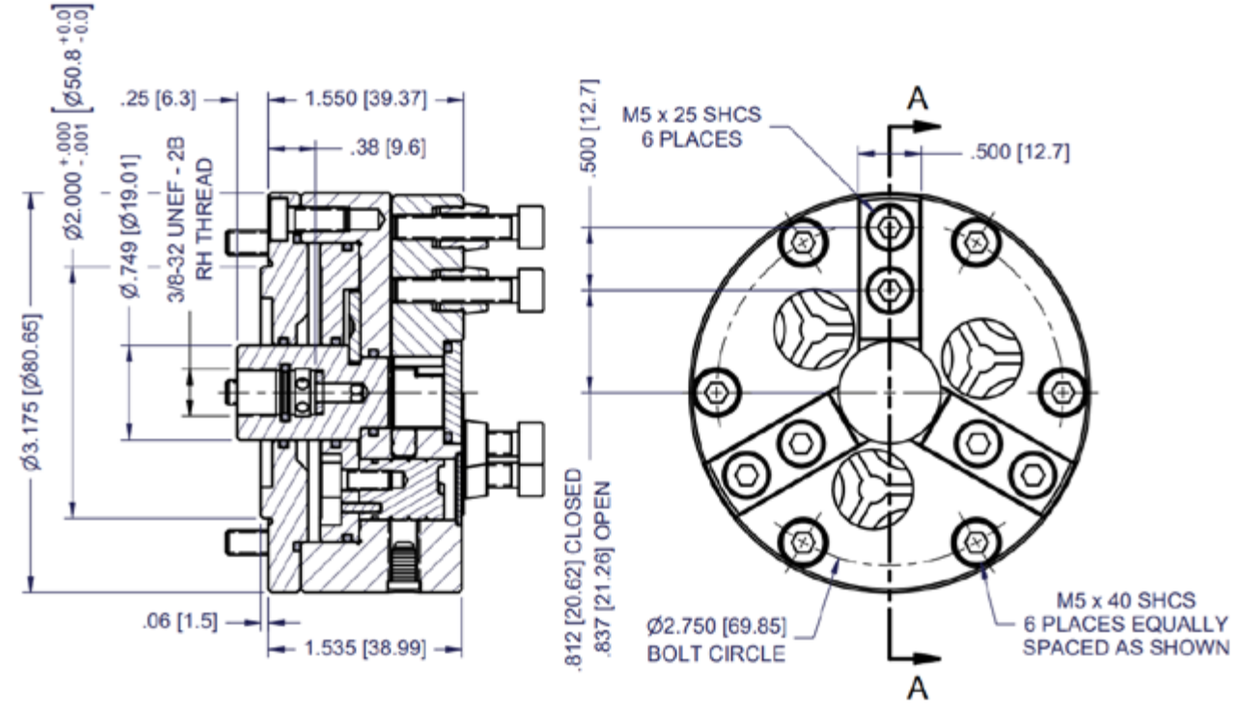
Rotating Air Chucks Drawings

Back to Content

3-50-3 Dimensions



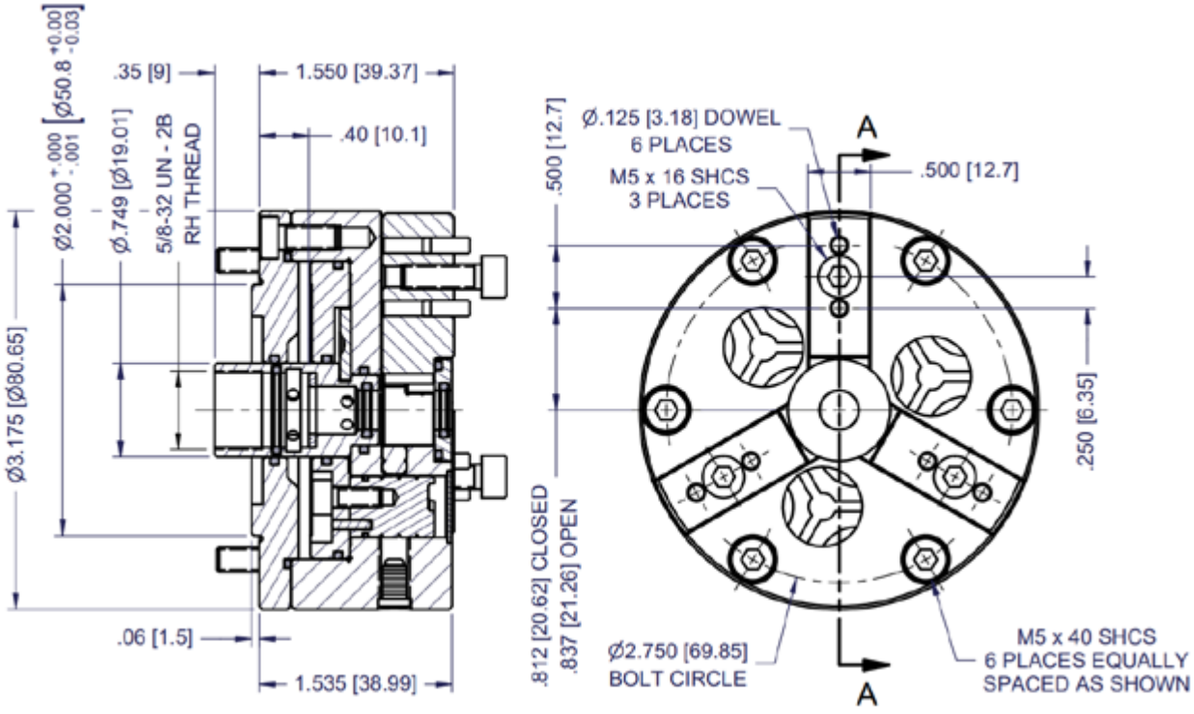
3-50-3/QC Dimensions



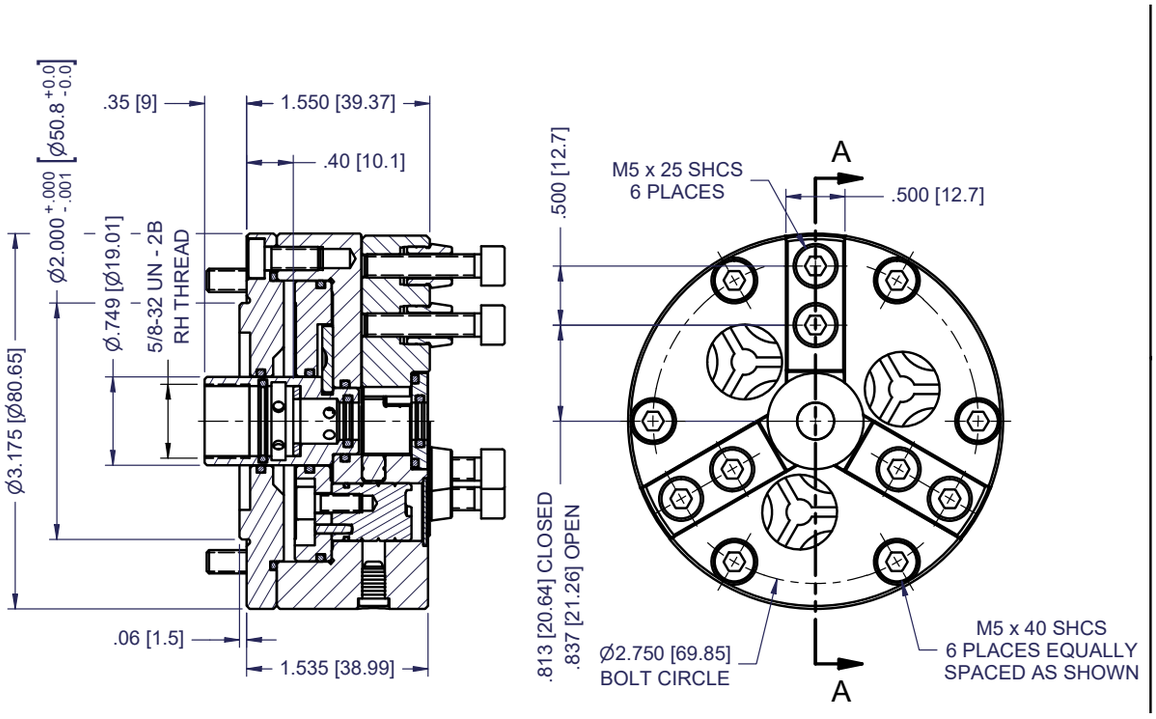
Rotating Air Chucks Drawings

Back to Content

3-50C-3 Dimensions



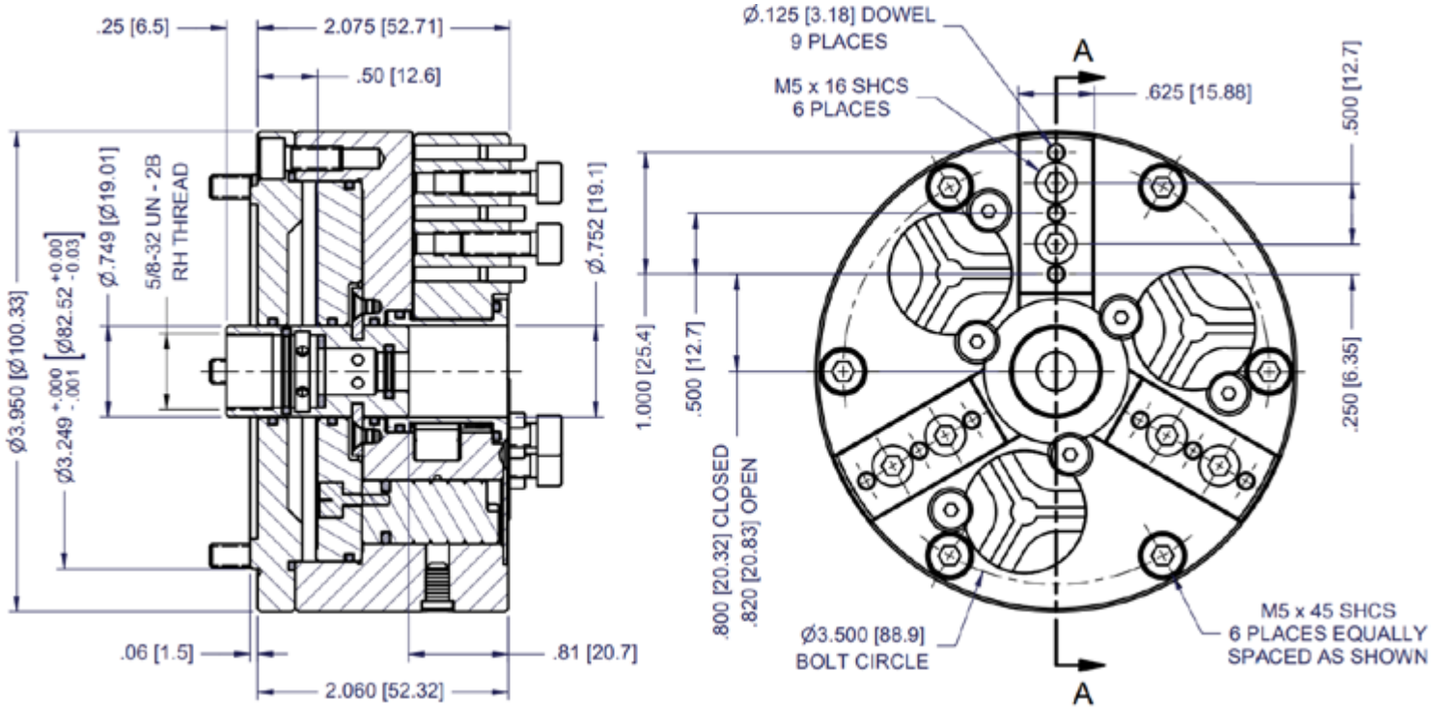
3-50C-3/QC Dimensions



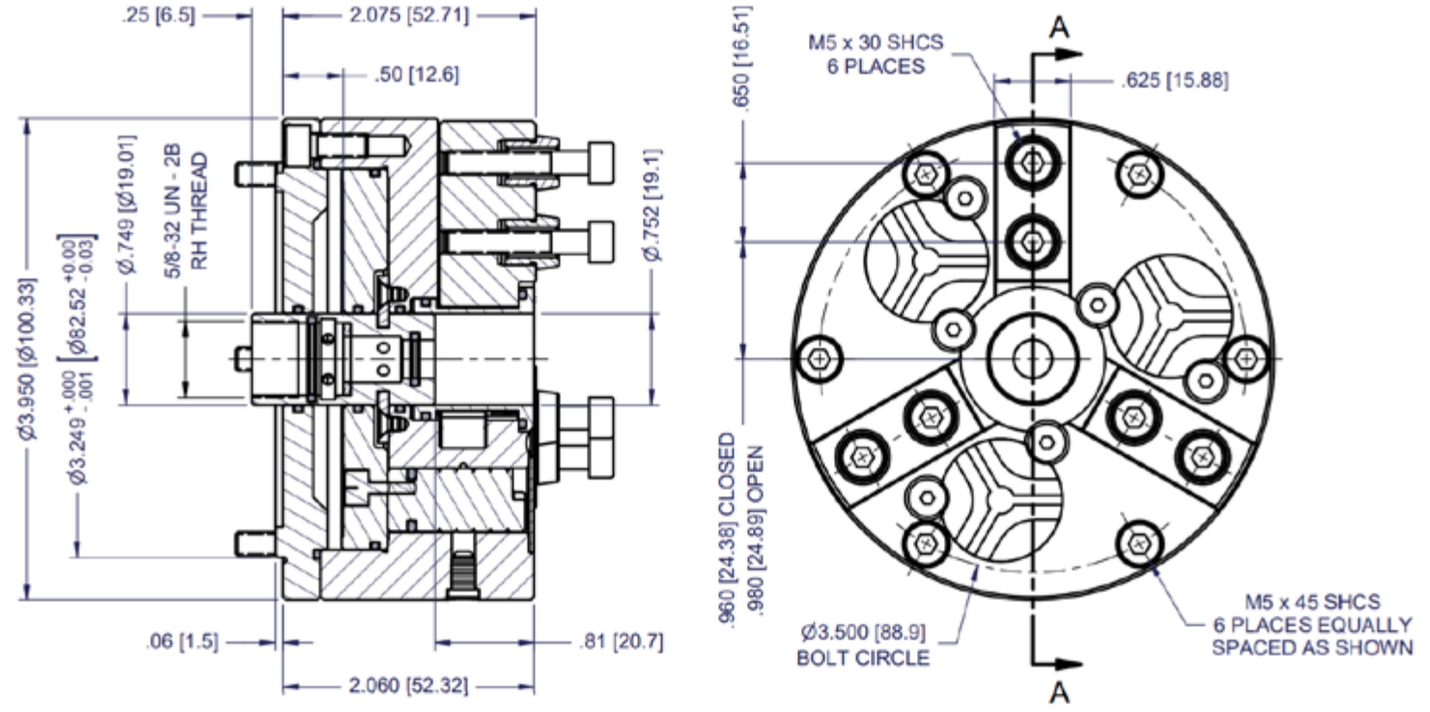
Rotating Air Chucks Drawings

Back to Content

4-40-3 Dimensions



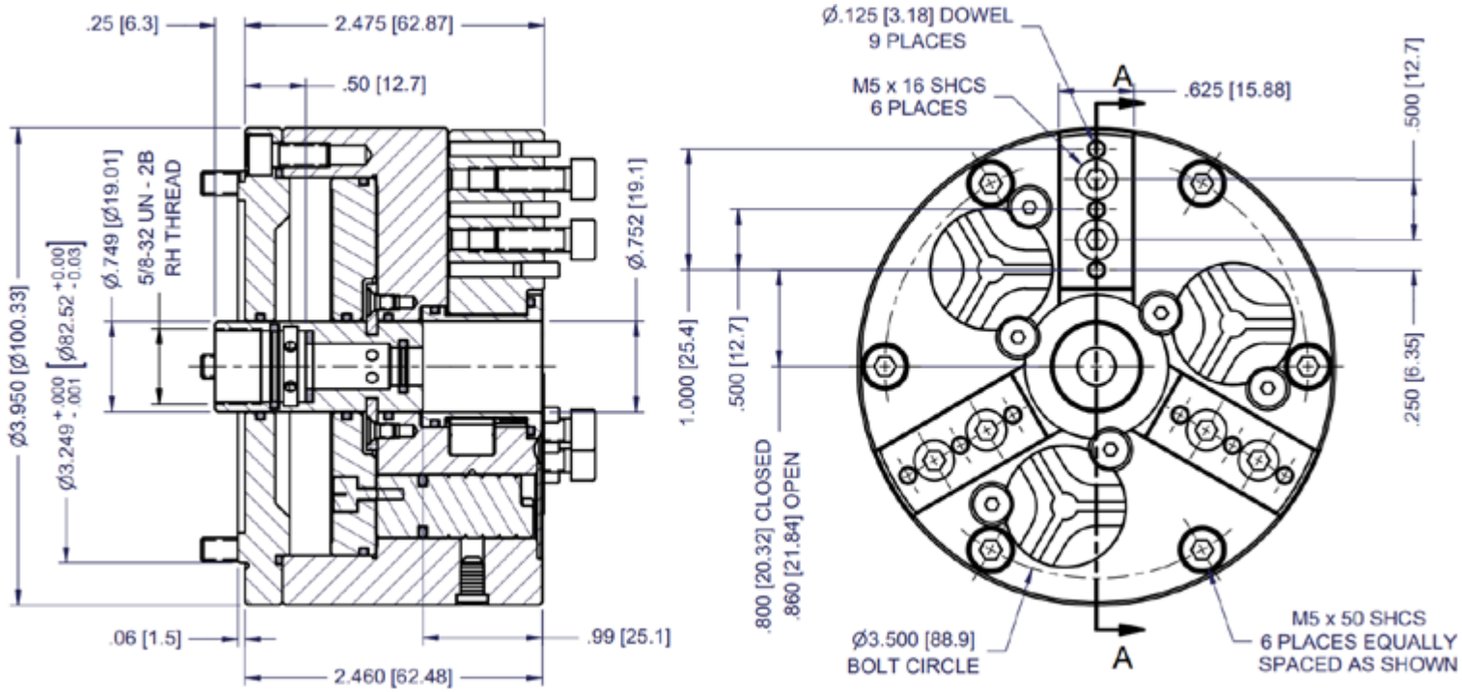
4-40-3/QC Dimensions



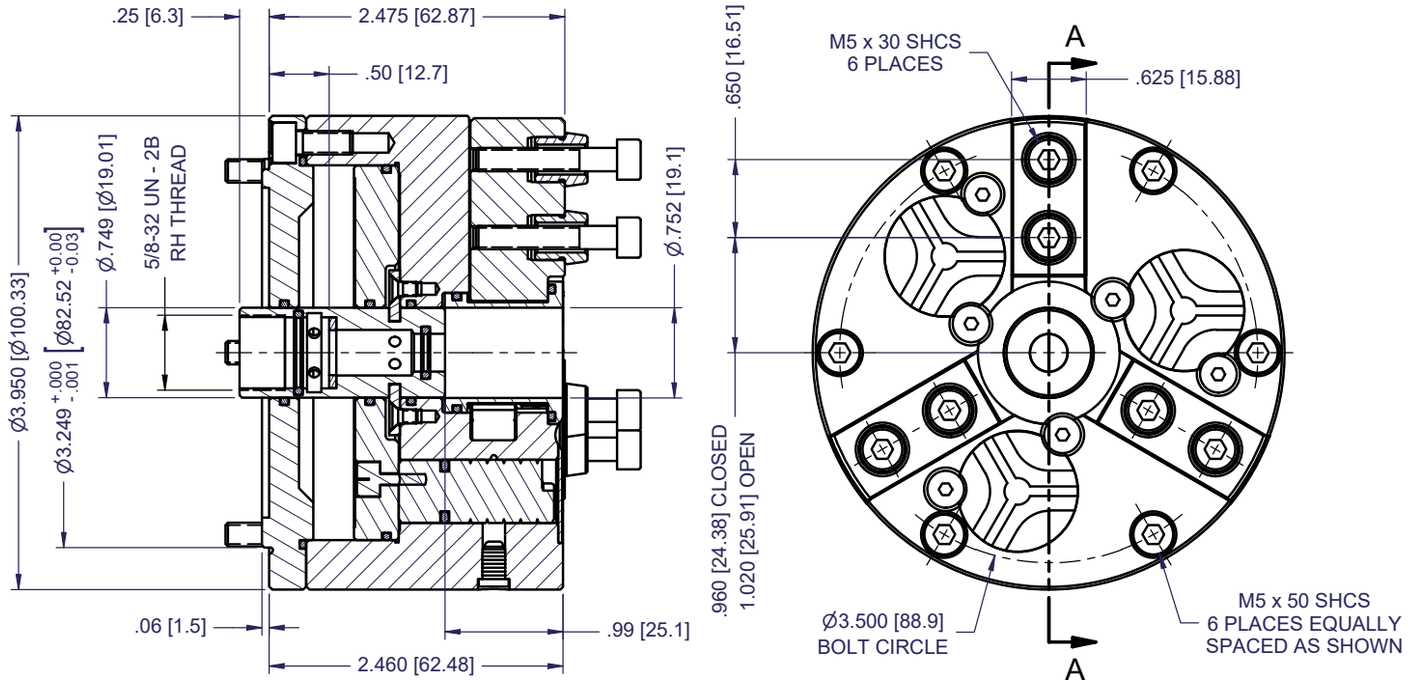
Rotating Air Chucks Drawings

Back to Content

4-120-3 Dimensions



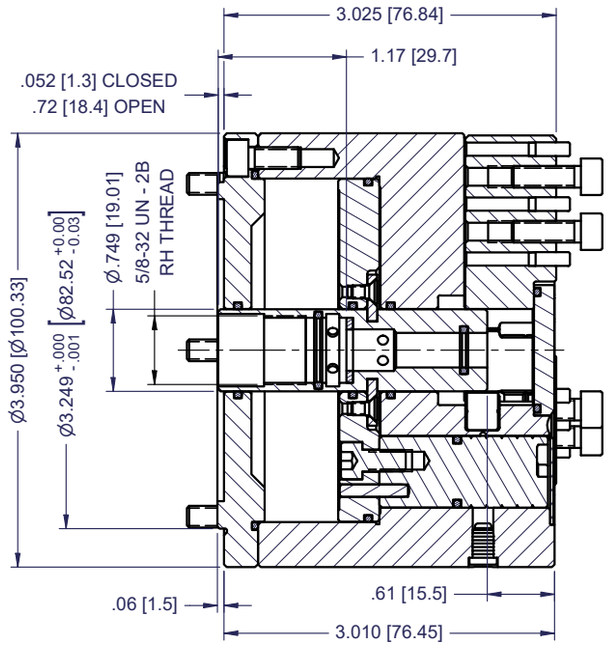
4-120-3/QC Dimensions

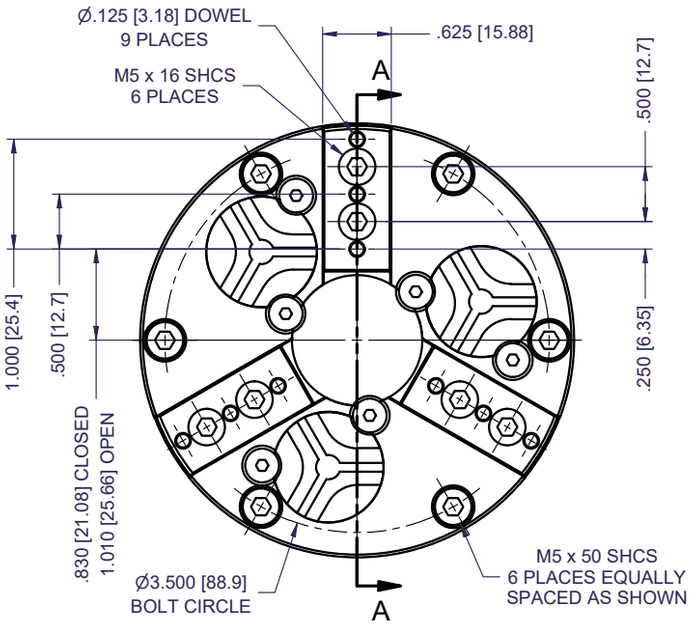


Rotating Air Chucks Drawings

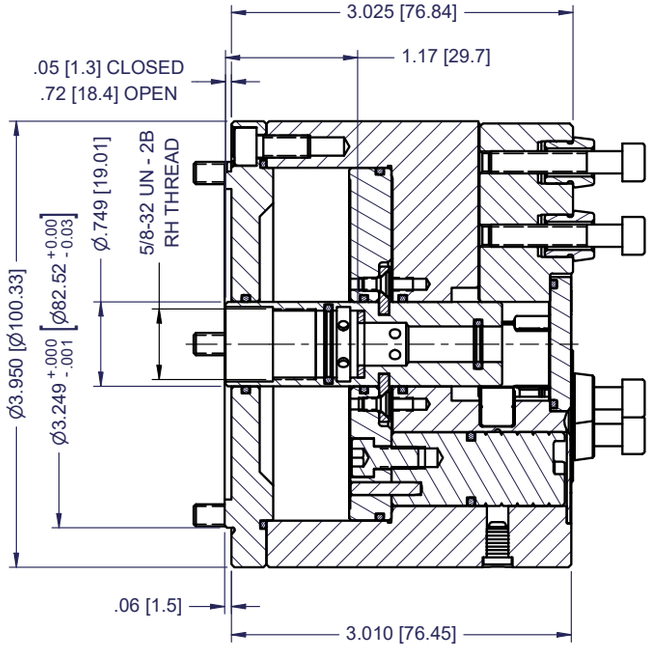
Back to Content

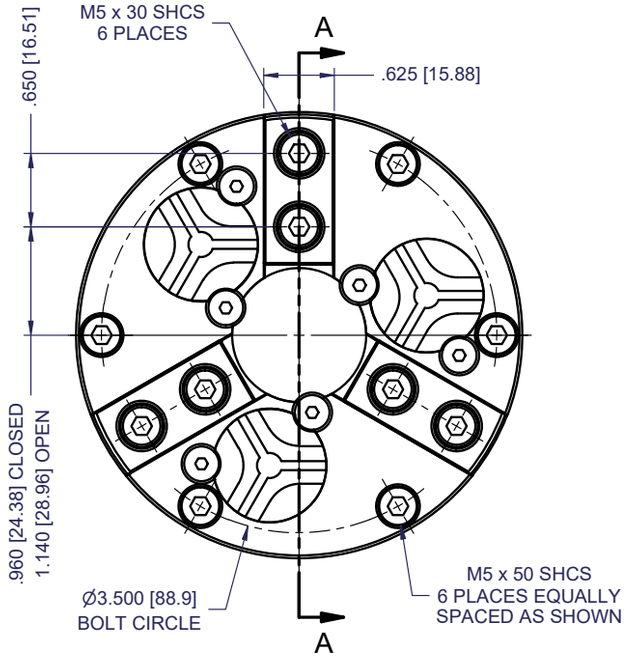
4-360-3 Dimensions





4-360-3/QC Dimensions

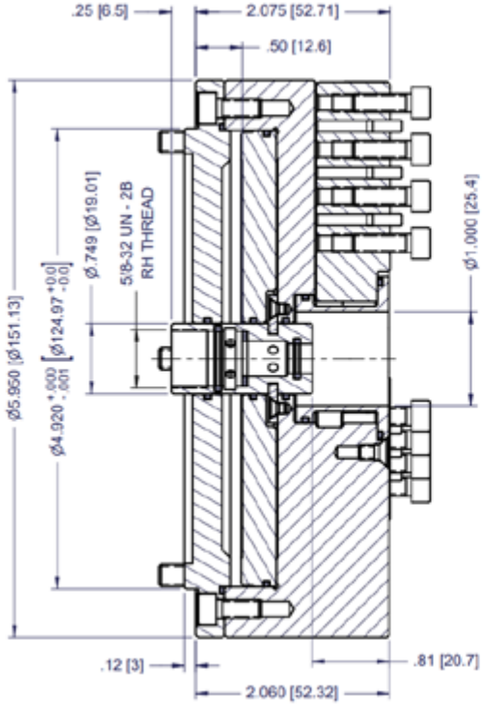


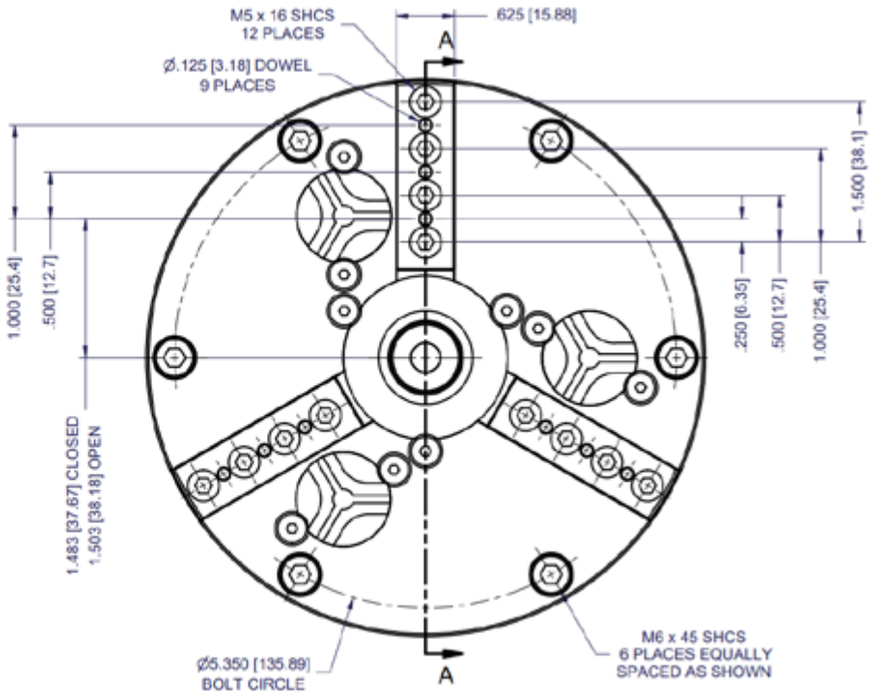


Rotating Air Chucks Drawings

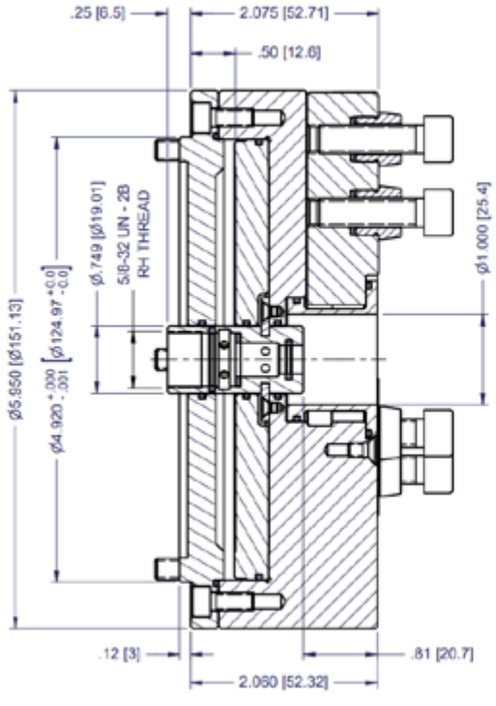
Back to Content

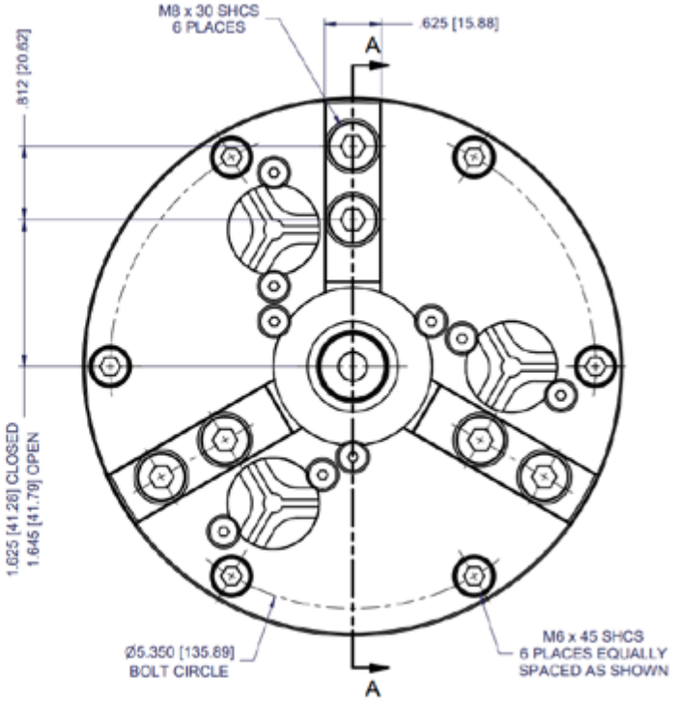
6-40-3 Dimensions





6-40-3/QC Dimensions

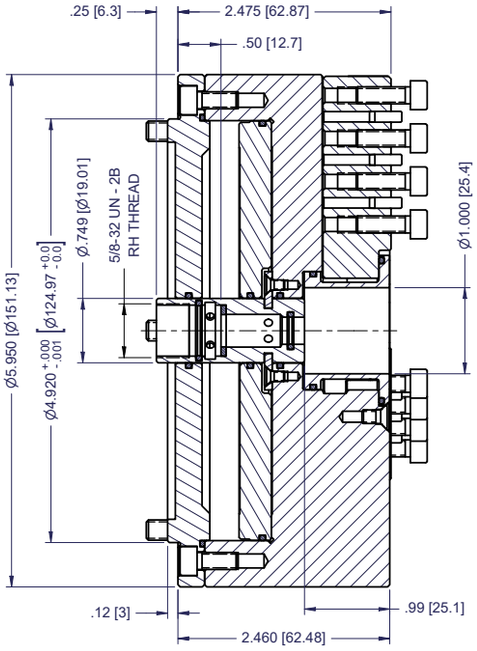


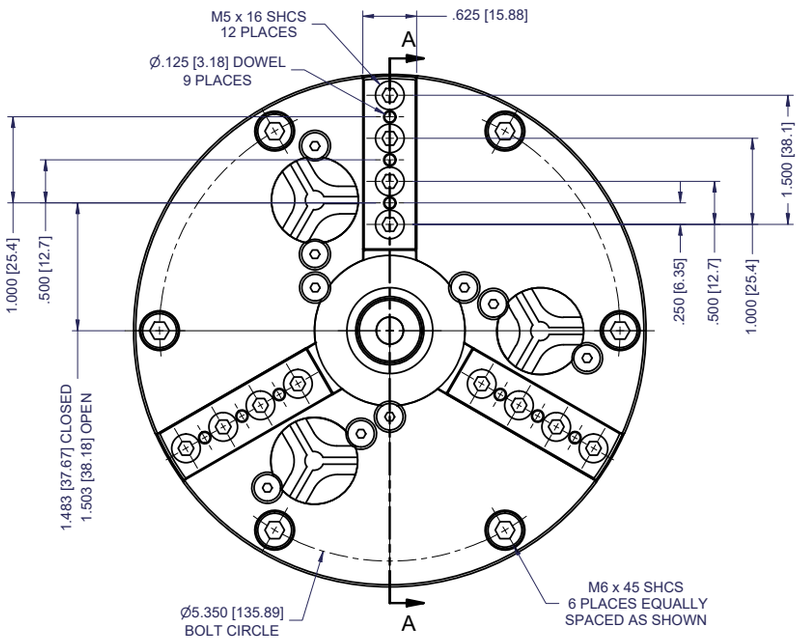


Rotating Air Chucks Drawings

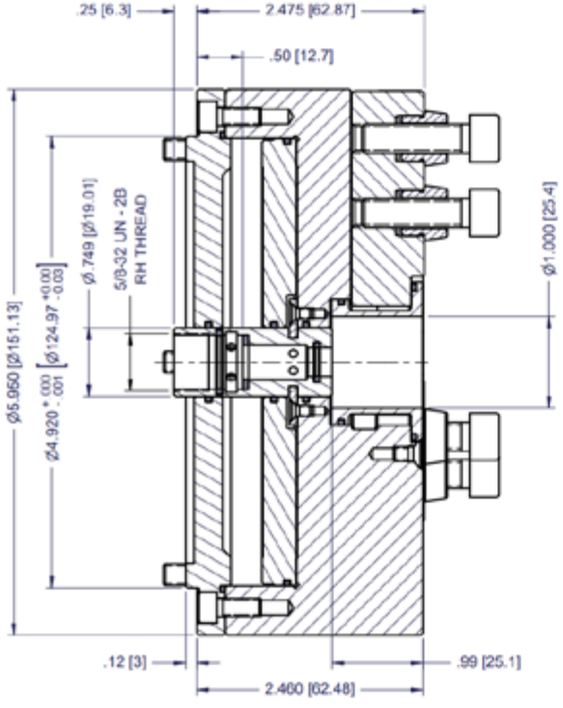
Back to Content

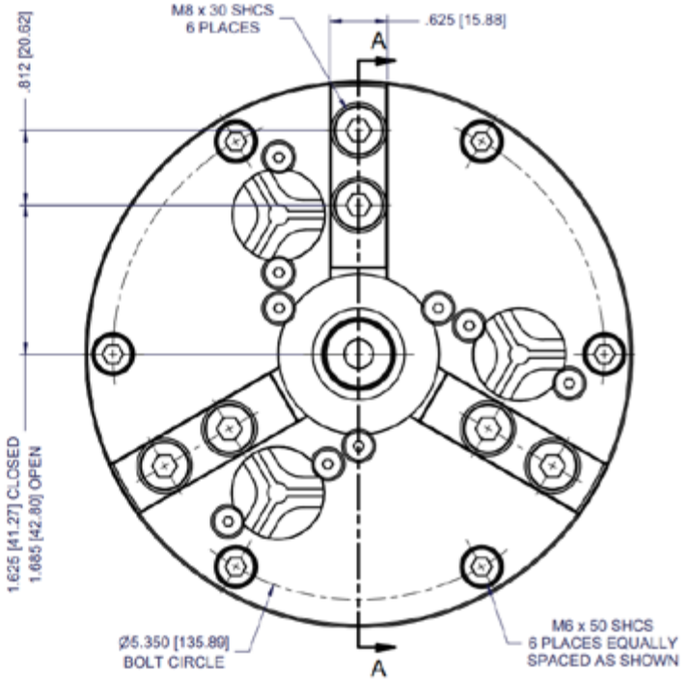
6-120-3 Dimensions





6-120-3/QC Dimensions

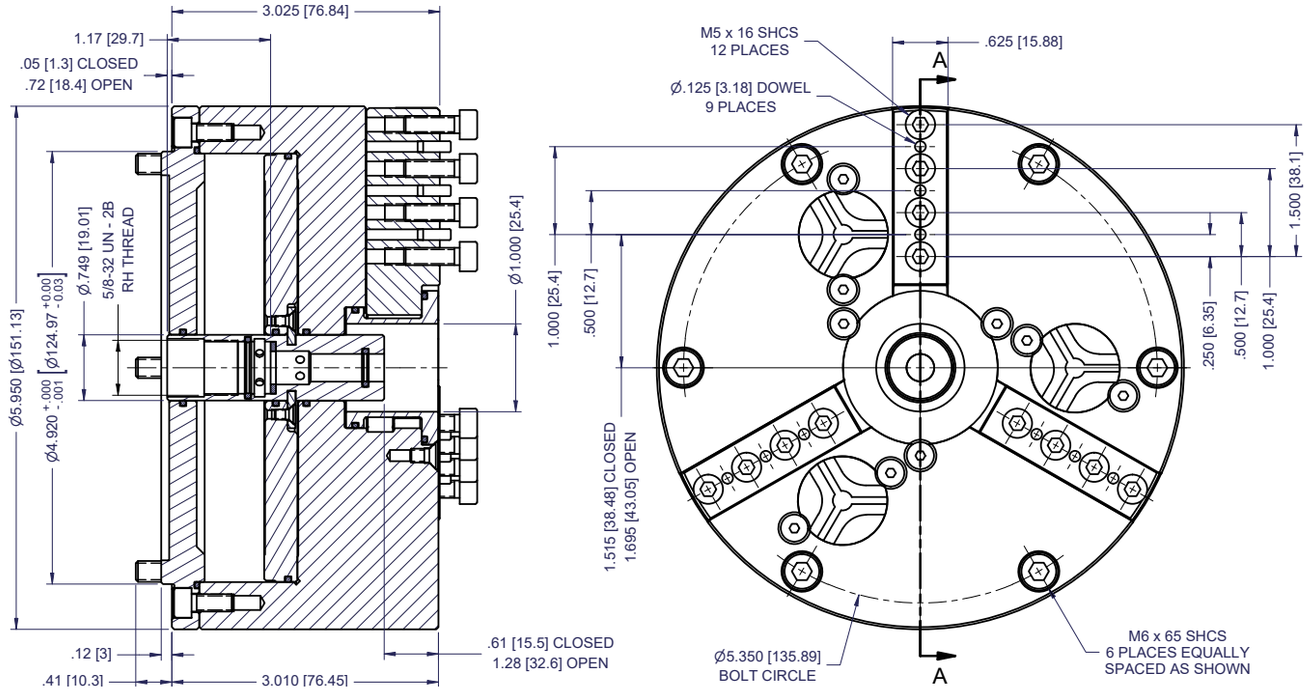




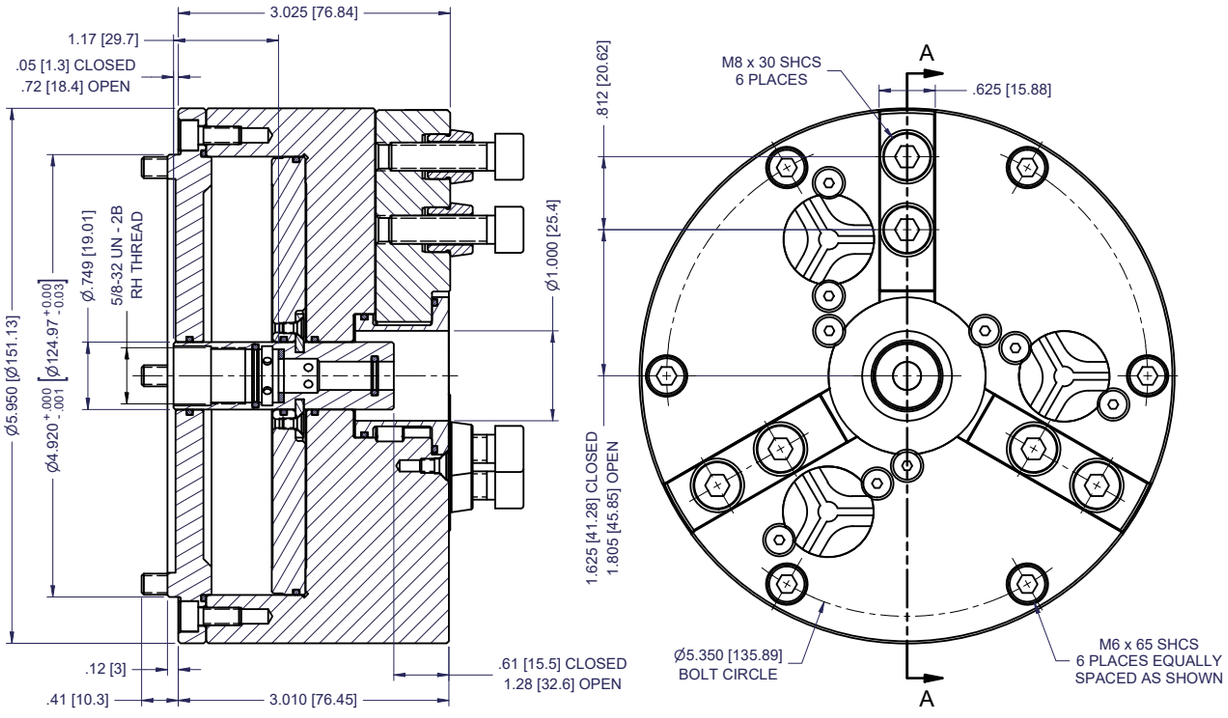
Rotating Air Chucks Drawings

Back to Content

6-360-3 Dimensions



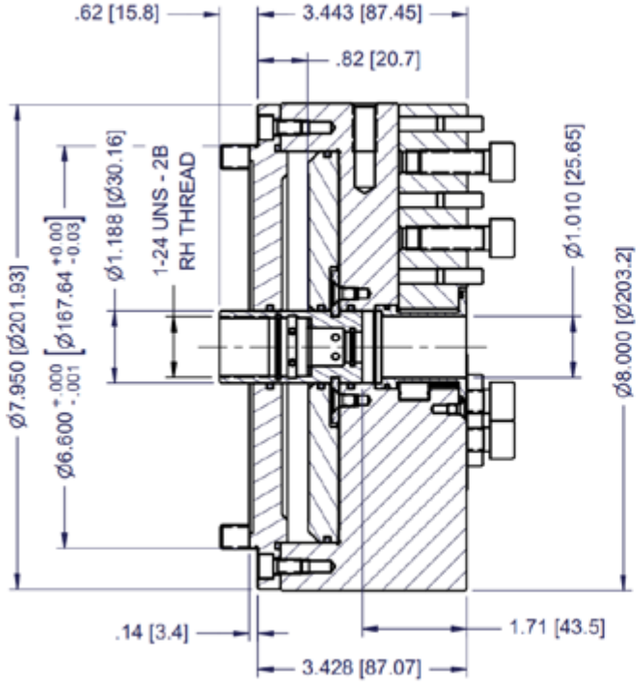
6-360-3/QC Dimensions

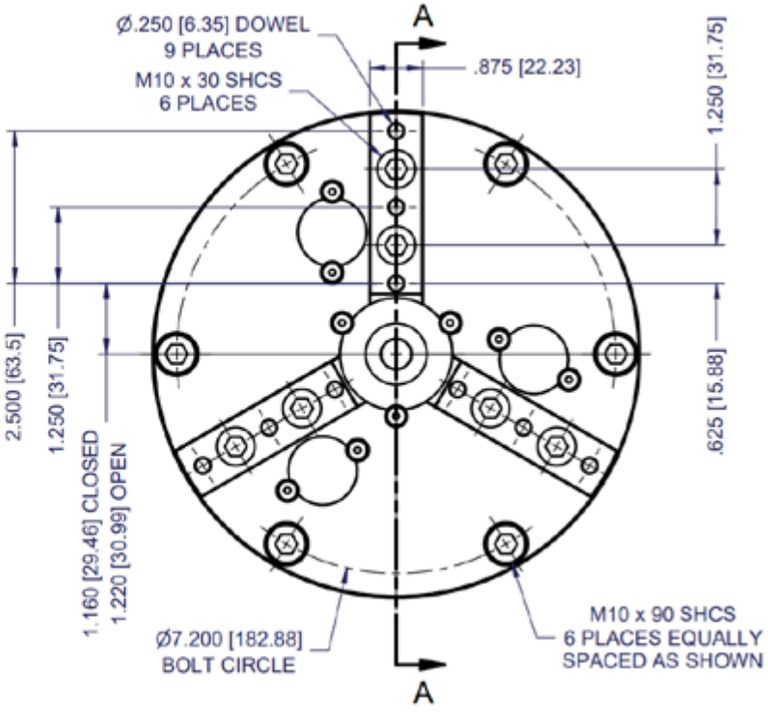


Rotating Air Chucks Drawings

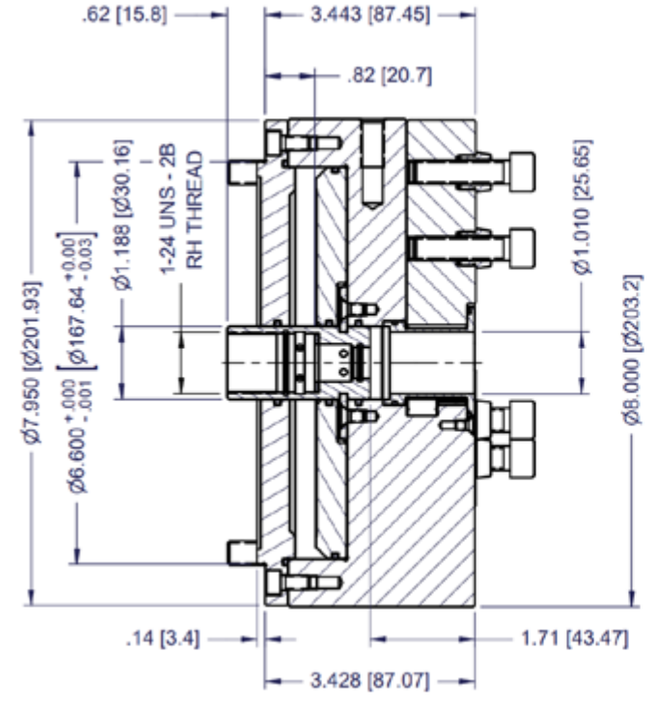
Back to Content

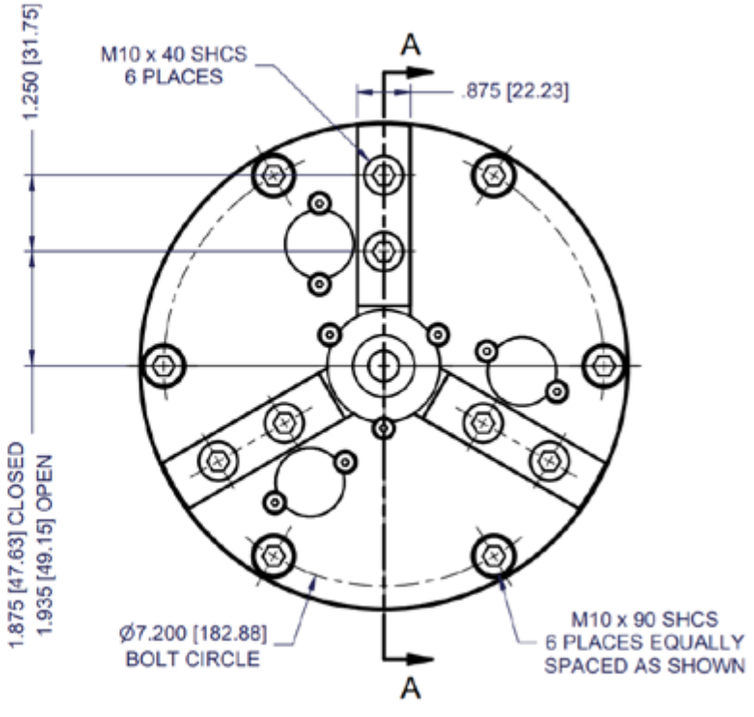
8-120-3 Dimensions





8-120-3/QC Dimensions

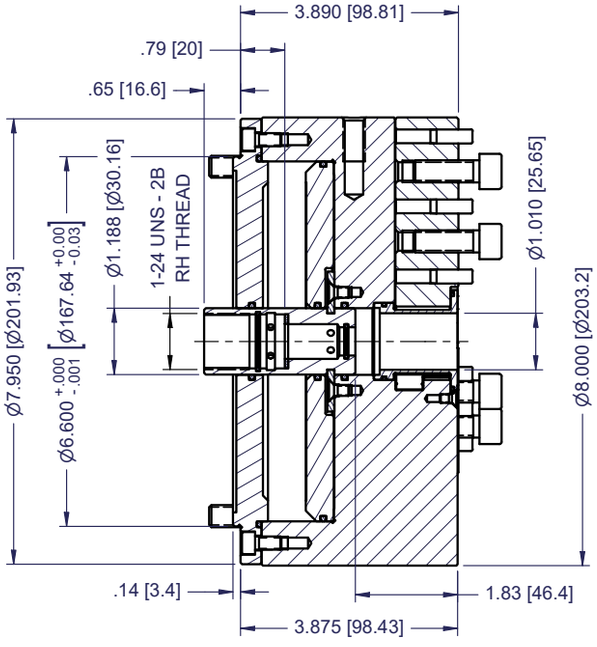


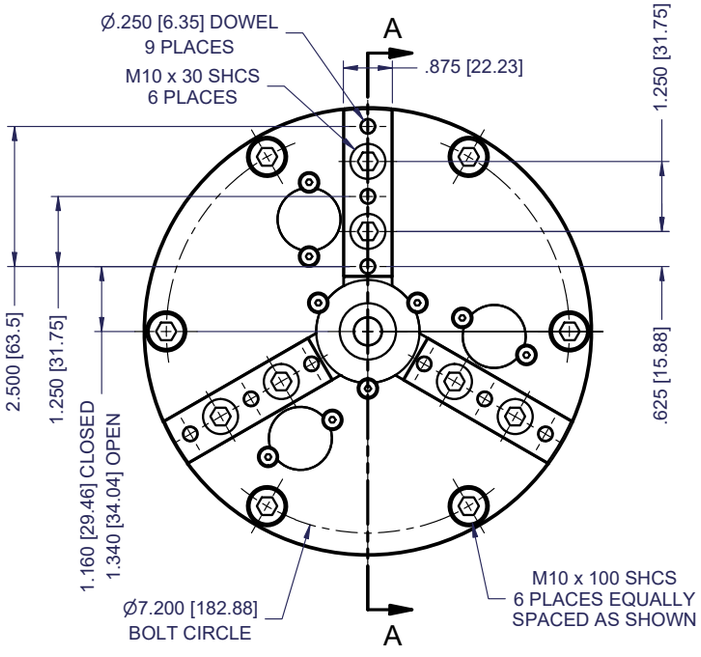


Rotating Air Chucks Drawings

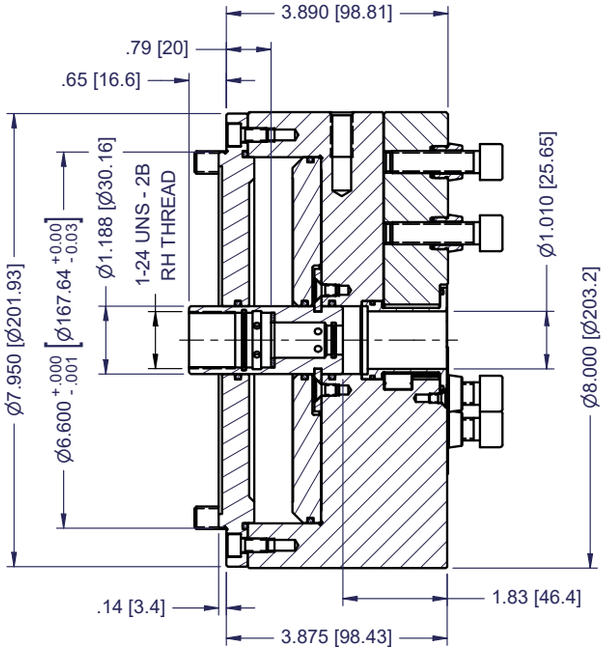
Back to Content

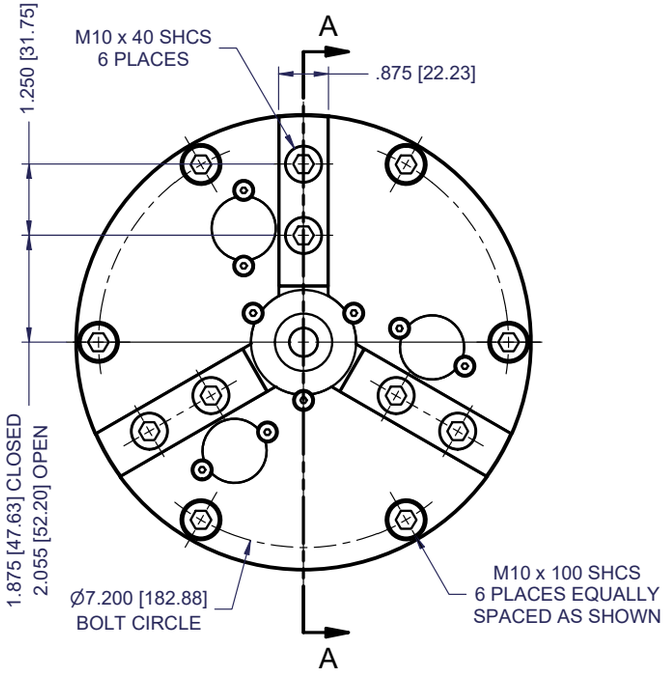
8-360-3 Dimensions





8-360-3/QC Dimensions

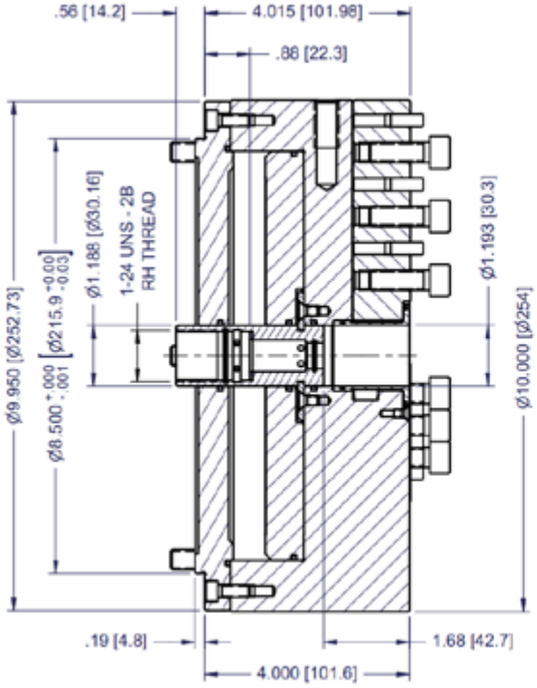


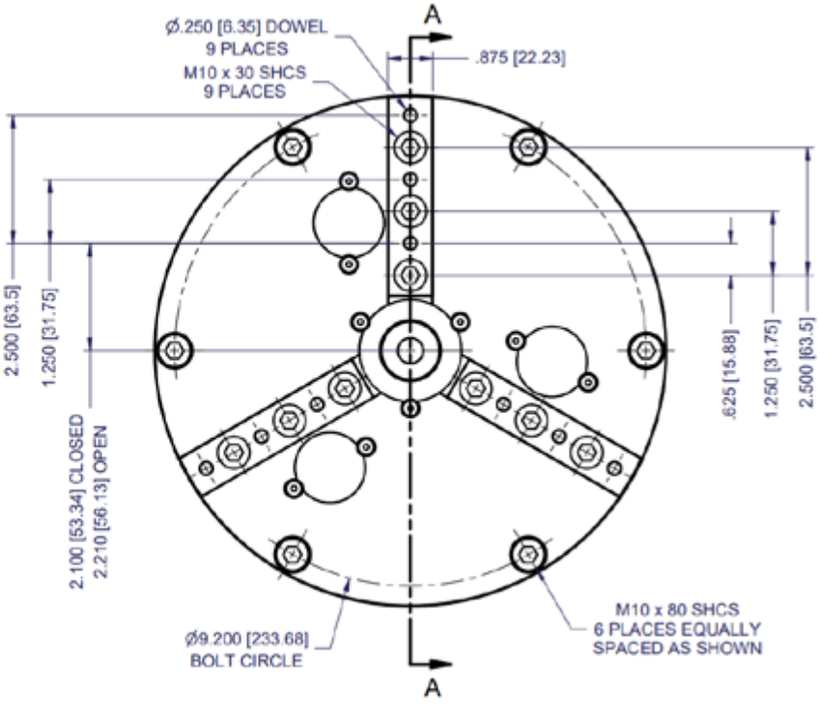


Rotating Air Chucks Drawings

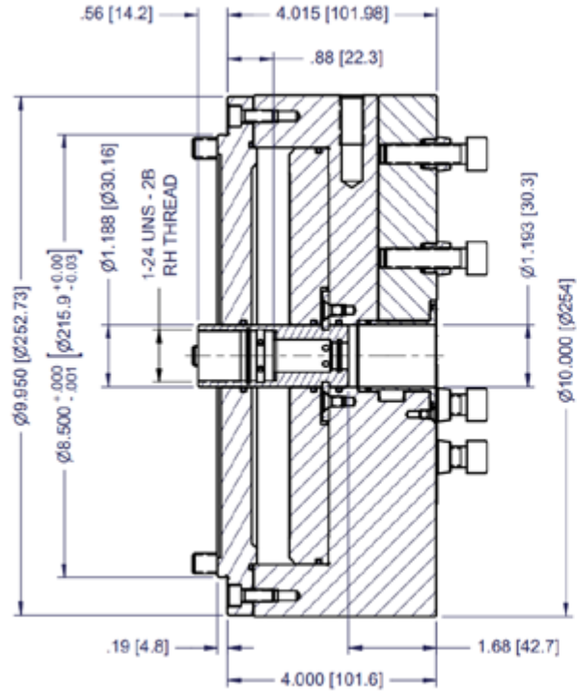
Back to Content

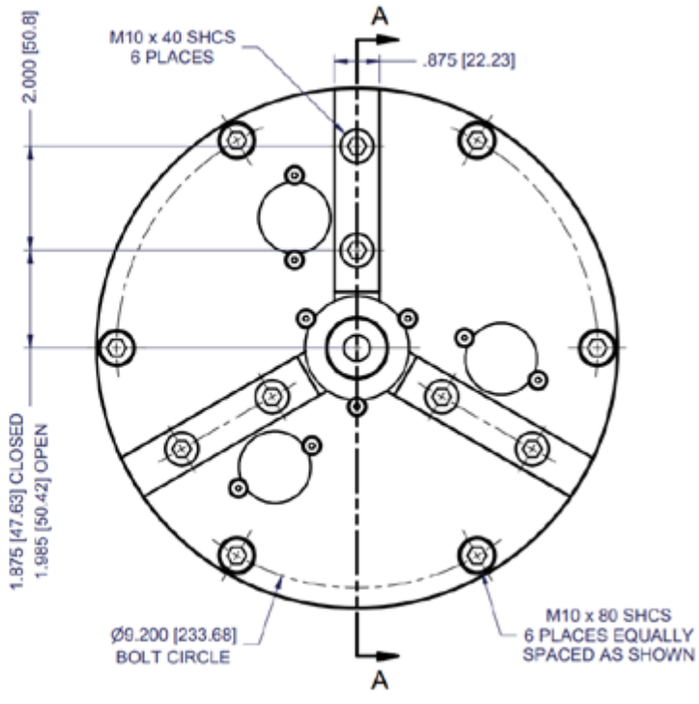
10-220-3 Dimensions





10-220-3/QC Dimensions

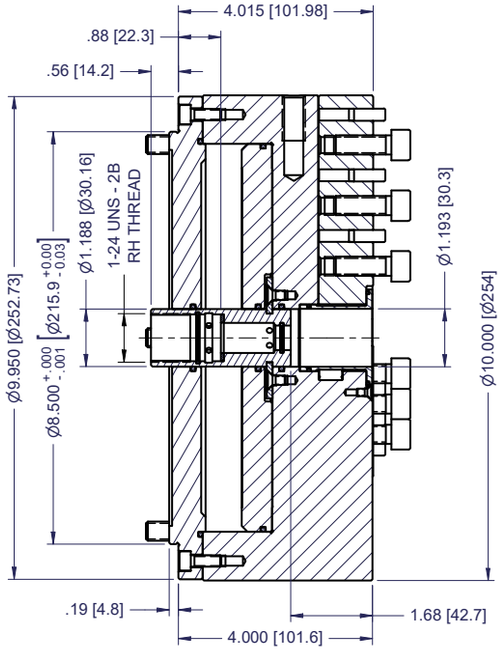


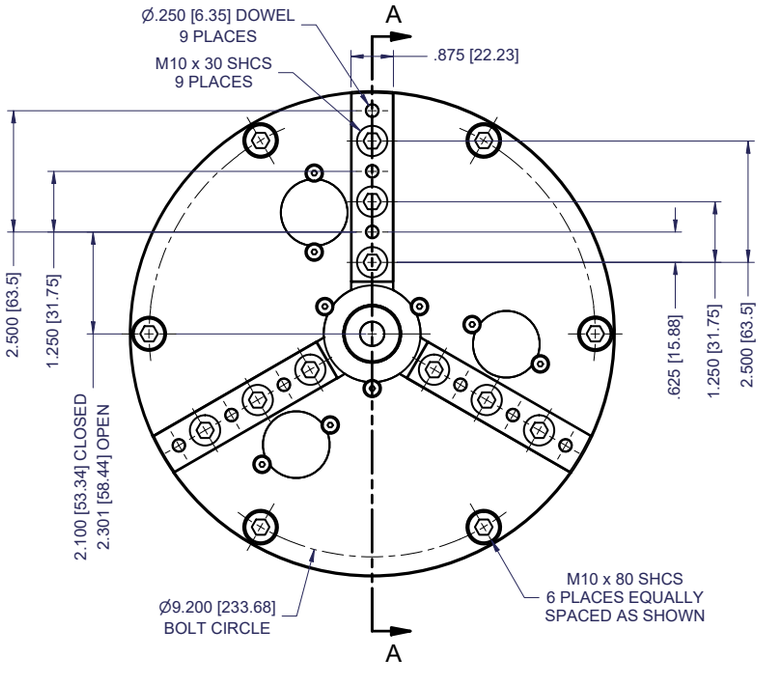


Rotating Air Chucks Drawings

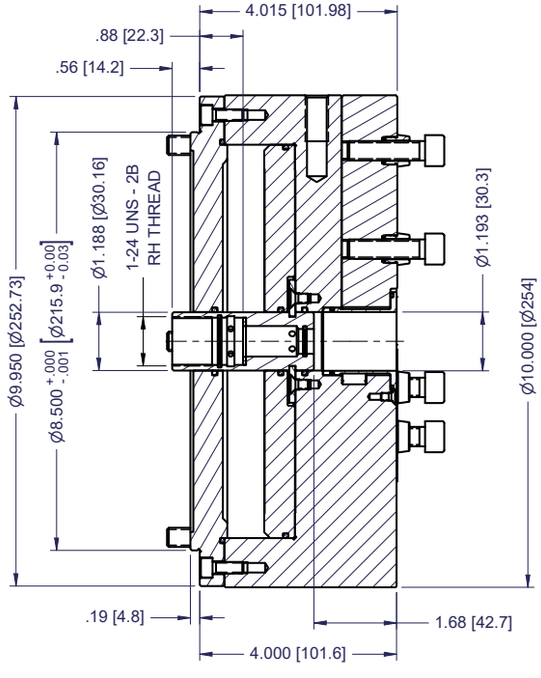
Back to Content

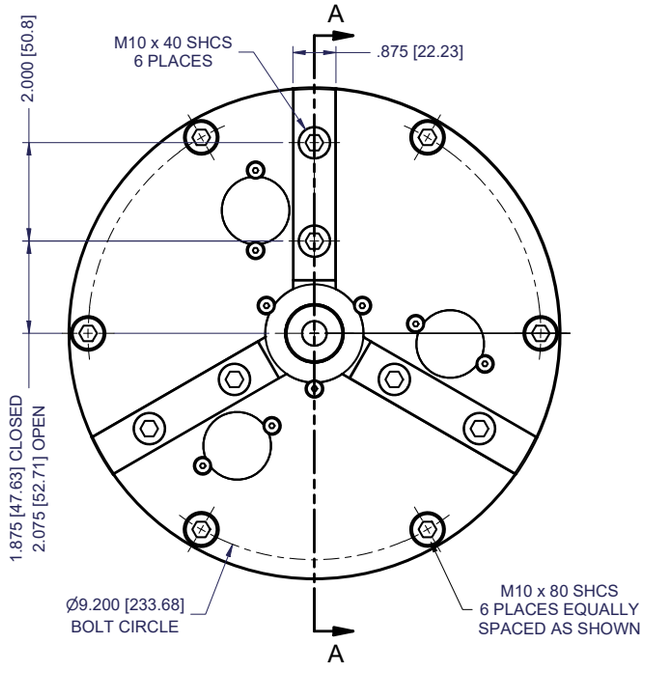
10-400-3 Dimensions





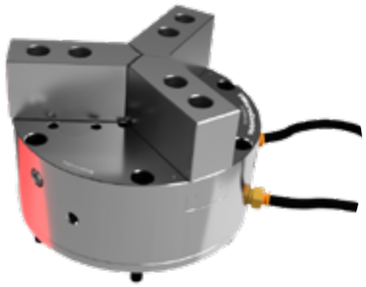
10-400-3/QC Dimensions





Technical Data Stationary Air Chucks

Back to Content



Stationary air chucks are ideal for milling, drilling, tapping, and other applications requiring a compact self-contained workholding fixture. Air is supplied directly into the side of the chuck body, and the chuck can be mounted directly to the machine table or pallet. Through holes are available on all models.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Through Hole	Chuck Weight[3]
3 inch / 80mm	3-50NR-3	3	.00005" / 0.0012mm	.050" / 1.3mm	920 lb/ 4.1 kN	100 psi / 0.7 Mpa	N/A	3.0 lb/ 1.4 kg
	3-50NR12-3						.475" / 12mm	
4 inch / 100mm	4-120NR-3	3	.00005" / 0.0012mm	.120" / 3.0mm	1,520 lb/ 6.8 kN	100 psi / 0.7 Mpa	N/A	6.9 lb/ 3.1 kg
	4-120NR19-3				1,485 lb/ 6.6 kN		.750" / 19.1mm	6.8 lb/ 3.1 kg
	4-360NR-3			.360"/ 9.1mm	1,300 lb/ 5.8 kN		N/A	8.1 lb/ 3.7 kg
6 inch / 150mm	6-40NR-3	3	.00005" / 0.0012mm	.040"/ 1.0 mm	3,820 lb/ 17.0 kN	100 psi / 0.7 Mpa	1.0"/ 25.4 mm	14 lb/ 6.4 kg
	6-40NR34-3				5,730 lb/ 25.2 kN		1.330"/ 33.8 mm	13 lb/ 5.7 kg
	6-120NR-3			.120" / 3.0mm	3,820 lb/ 17.0 kN		N/A	15.9 lb/ 7.2 kg
	6-120NR34-3				3,550 lb/ 15.8 kN		1.330" / 33.8mm	15.4 lb/ 7.0 kg
	6-360NR-3			.360"/ 9.1mm	3,275 lb/ 14.6 kN		N/A	18.4 lb/ 8.4 kg
8 inch / 200mm	8-120NR-3	3	.00005" / 0.0012mm	.120" / 3.0mm	6,570 lb/ 29.2 kN	100 psi / 0.7 Mpa	N/A	42.2 lb/ 19.1 kg
	8-120NR50-3				5,730 lb/ 25.2 kN		2.000" / 50.8mm	40.5 lb/ 18.4 kg
	8-360NR-3			.360"/ 9.1mm	5,630 lb/ 25.1 kN		N/A	45.7 lb/ 20.7 kg
10 inch / 250mm	10-220NR-3	3	.00005" / 0.0012mm	.220" / 5.6mm	10,330 lb/ 46.0 kN	100 psi / 0.7 Mpa	N/A	75.2 lb / 34.1 kg
	10-220NR76-3				8,670 lb / 38.6 kN		3.000" / 76.2mm	69.0 lb / 31.3 kg
	10-400NR-3			.400"/ 10.2mm	8,850 lb/ 39.4 kN		N/A	74.0 lb/ 33.6 kg

1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Without top jaws and spindle mounting plate

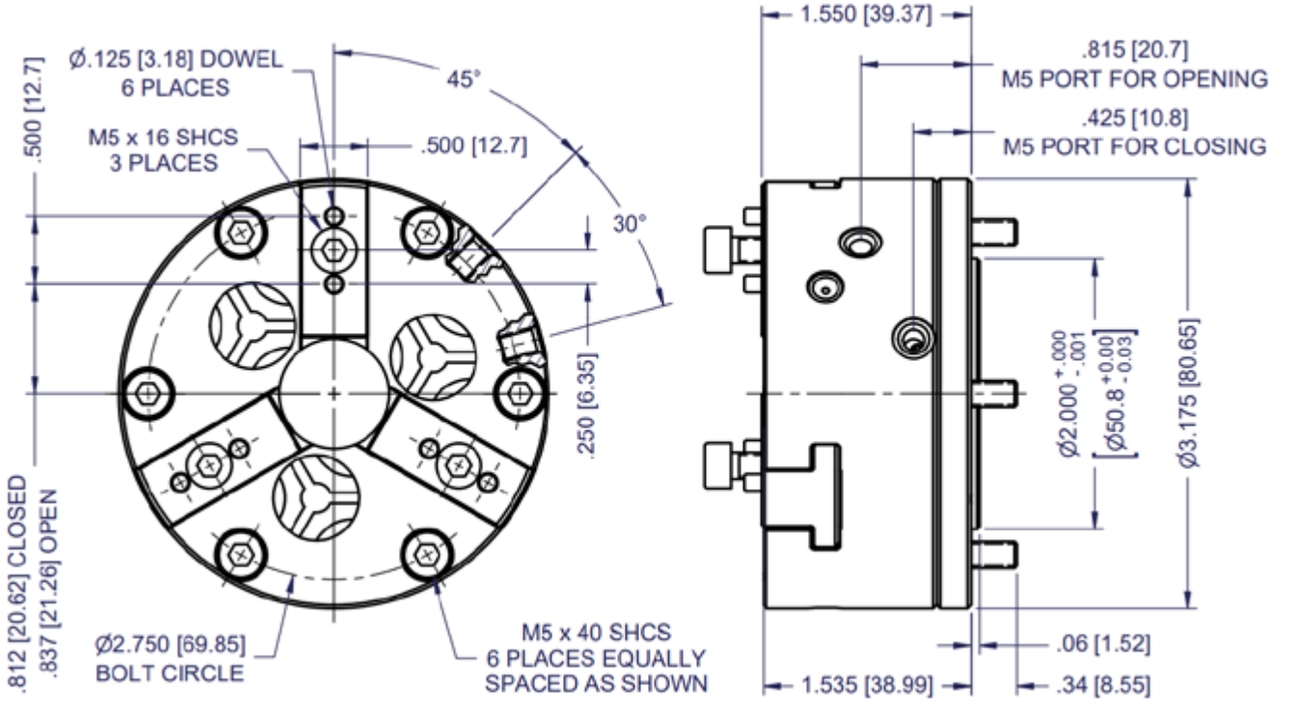
Drawings
PAGE 54

Top Jaws
PAGE 88

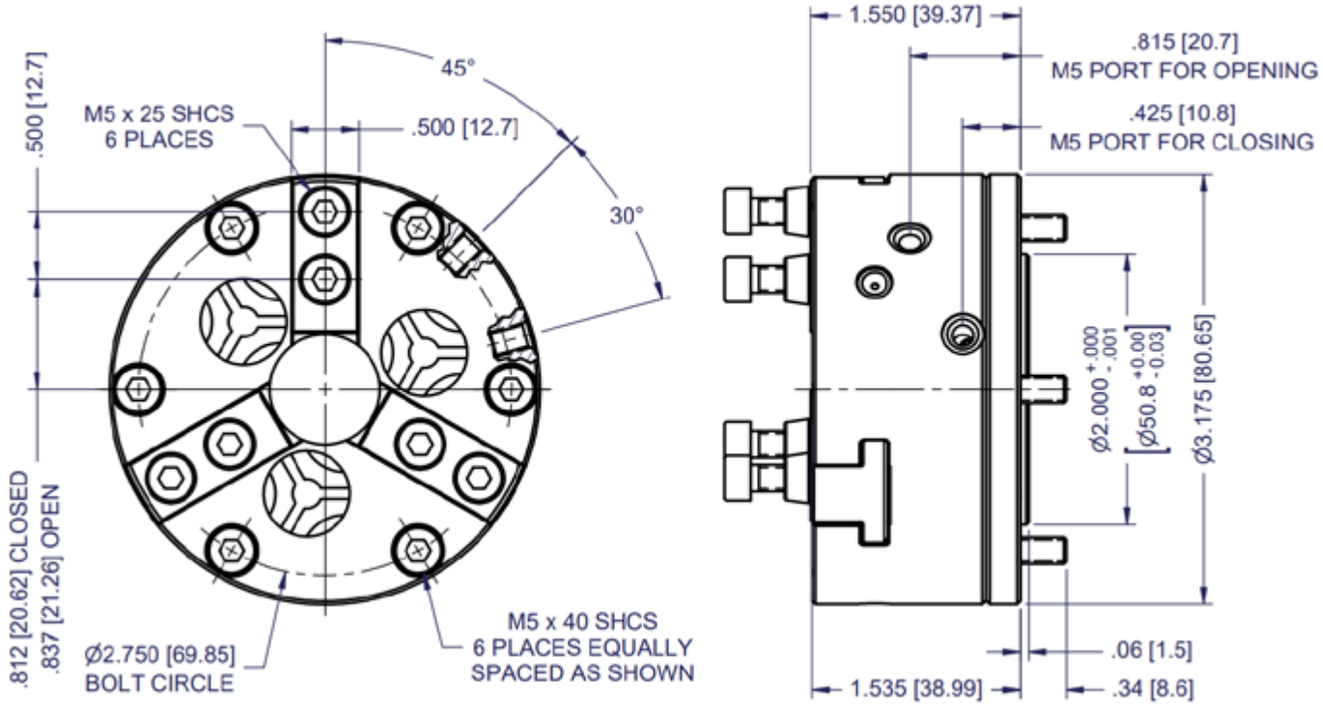
Stationary Air Chucks Drawings

Back to Content

3-50NR-3 Dimensions



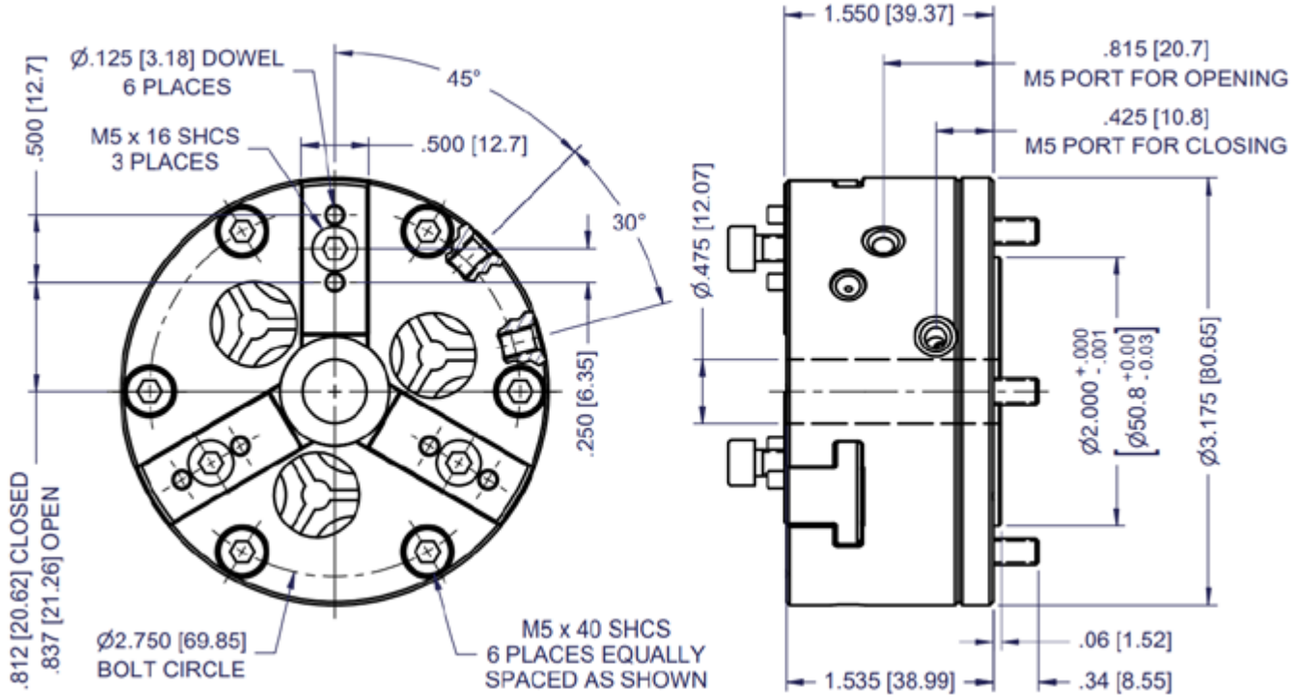
3-50NR-3 Dimensions



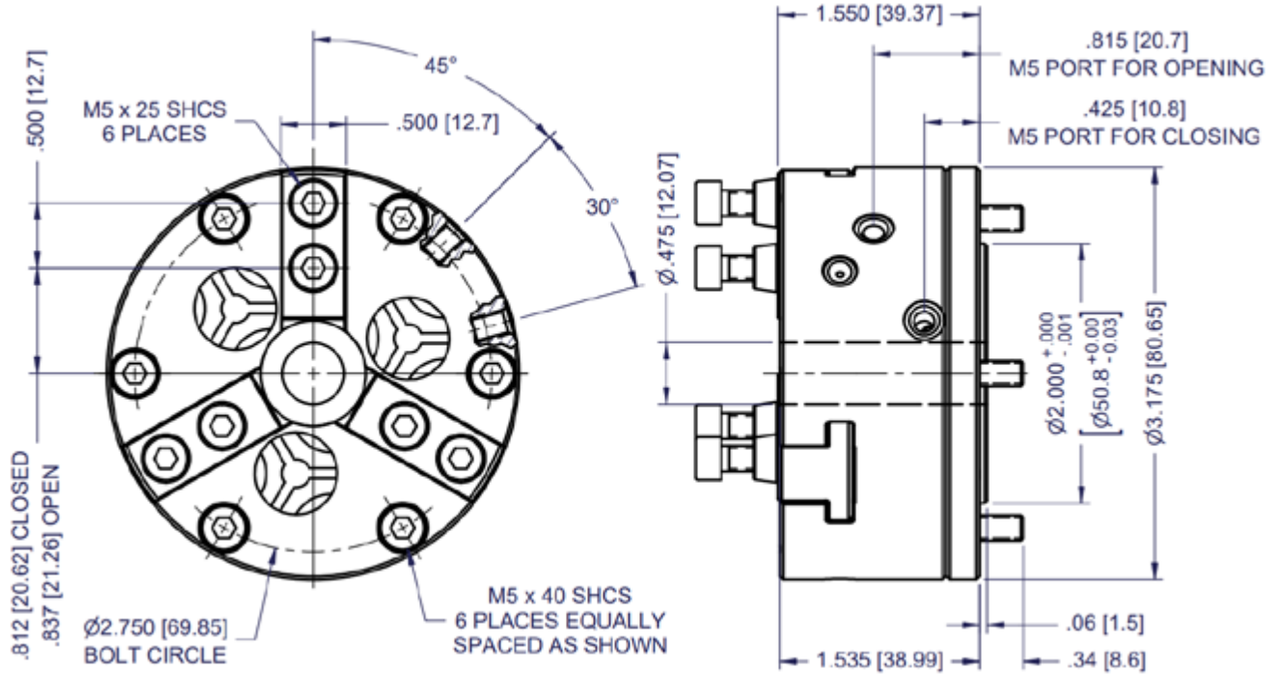
Stationary Air Chucks Drawings

Back to Content

3-50NR12-3 Dimensions



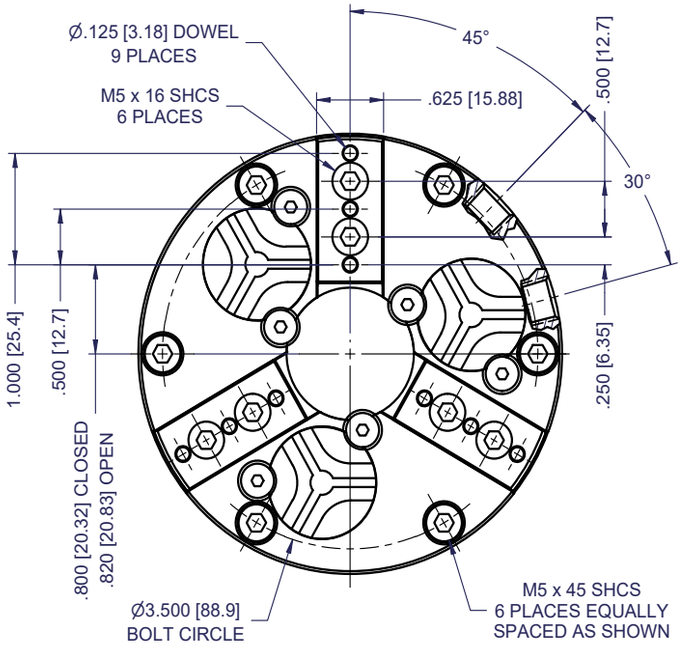
3-50NR12-3/QC Dimensions

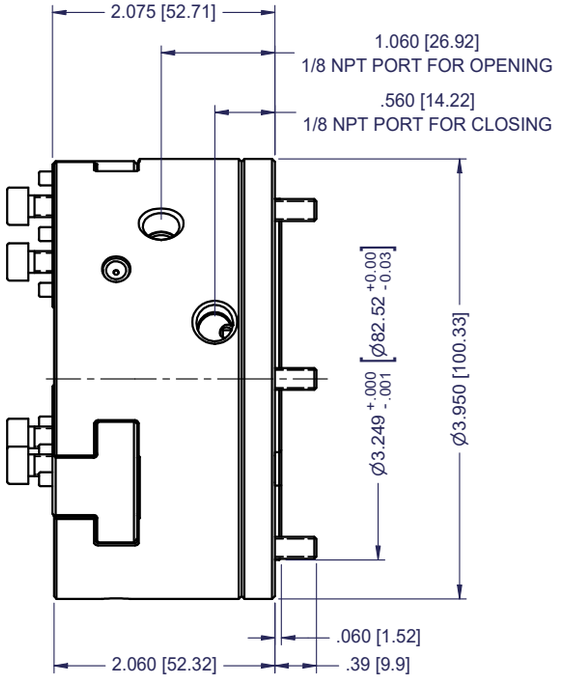


Stationary Air Chucks Drawings

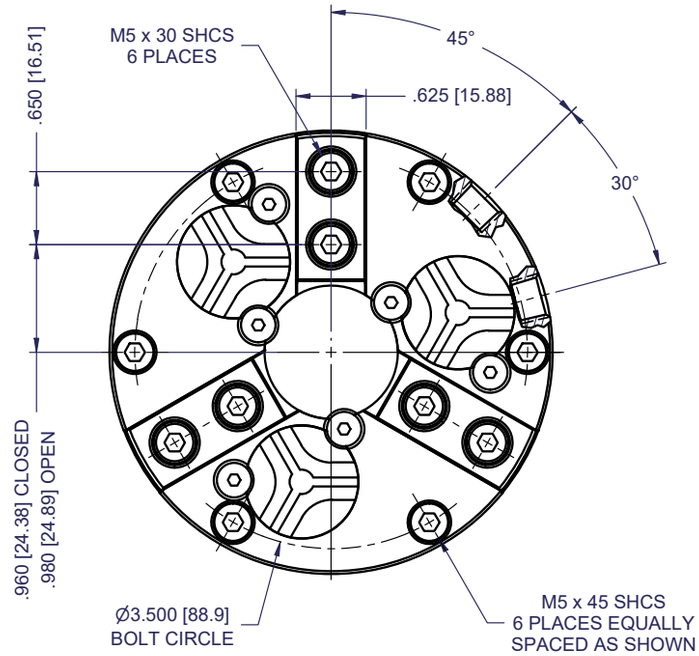
Back to Content

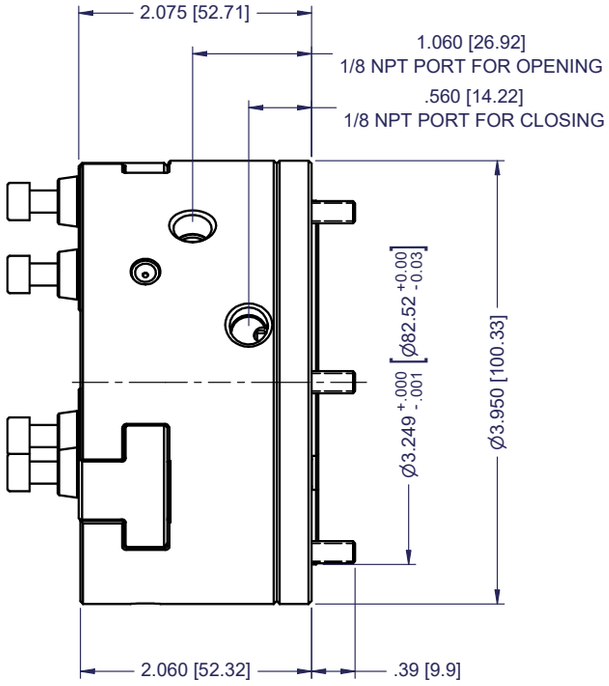
4-40NR-3 Dimensions





4-40NR-3/QC Dimensions

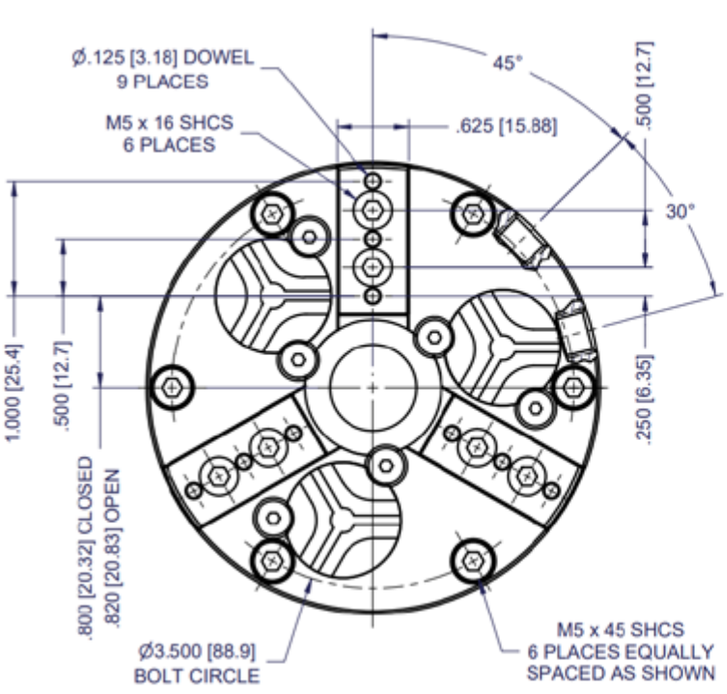


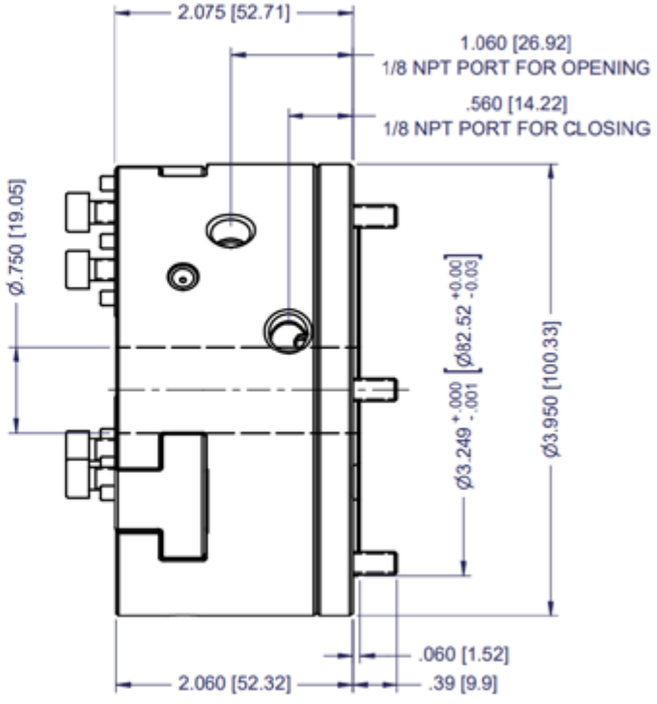


Stationary Air Chucks Drawings

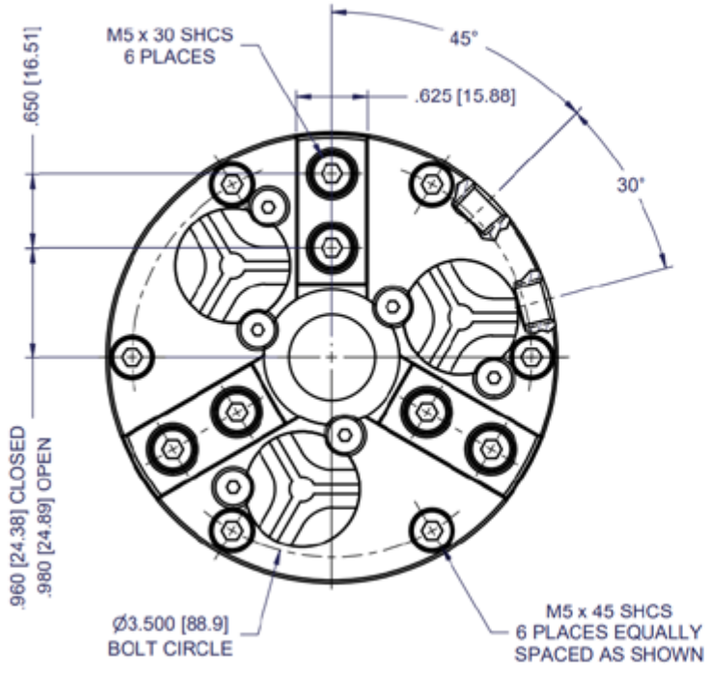
Back to Content

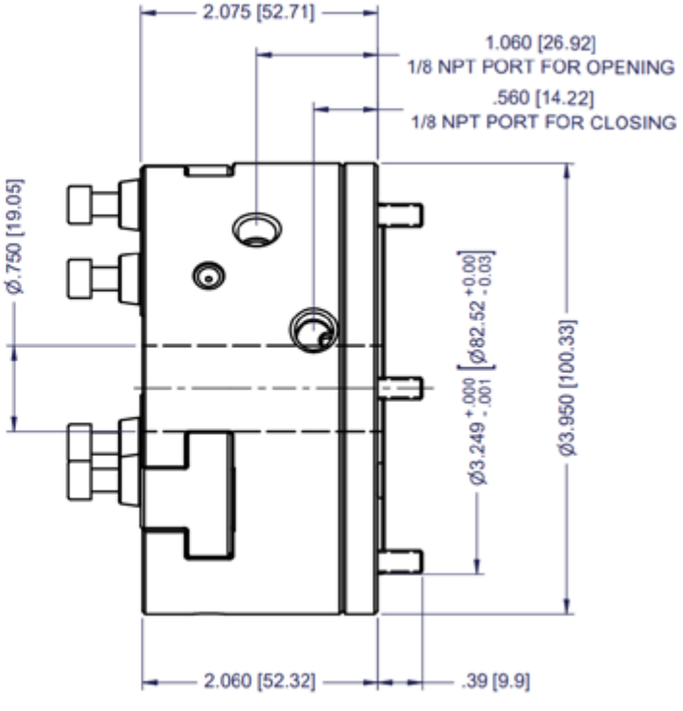
4-40NR19-3 Dimensions





4-40NR19-3/QC Dimensions

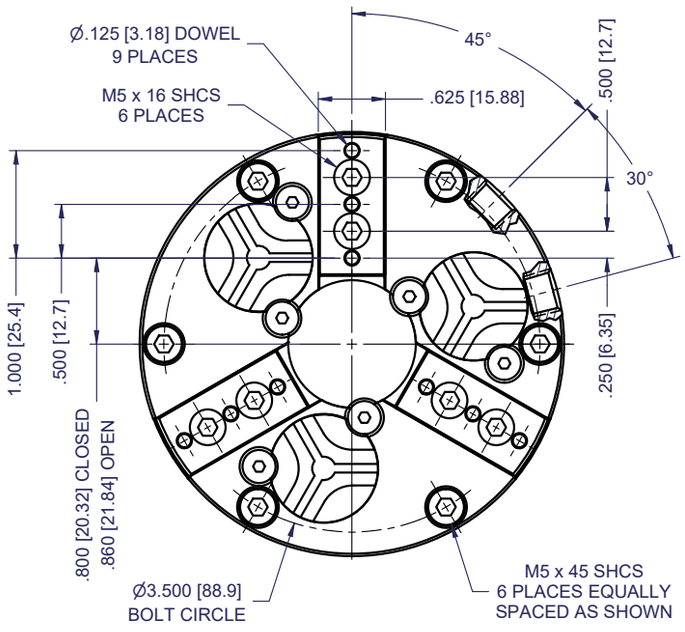


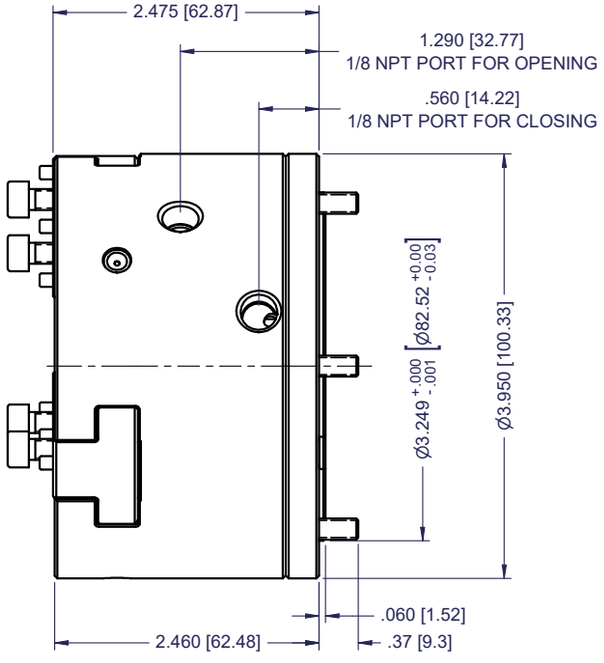


Stationary Air Chucks Drawings

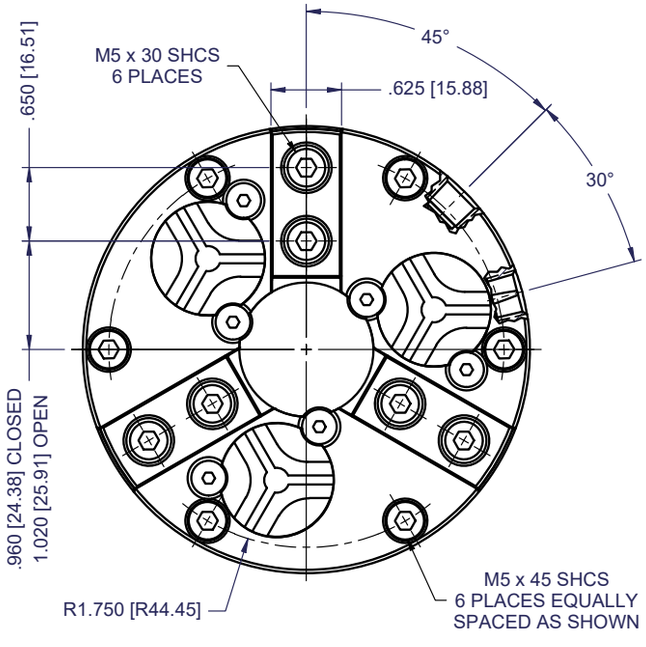
Back to Content

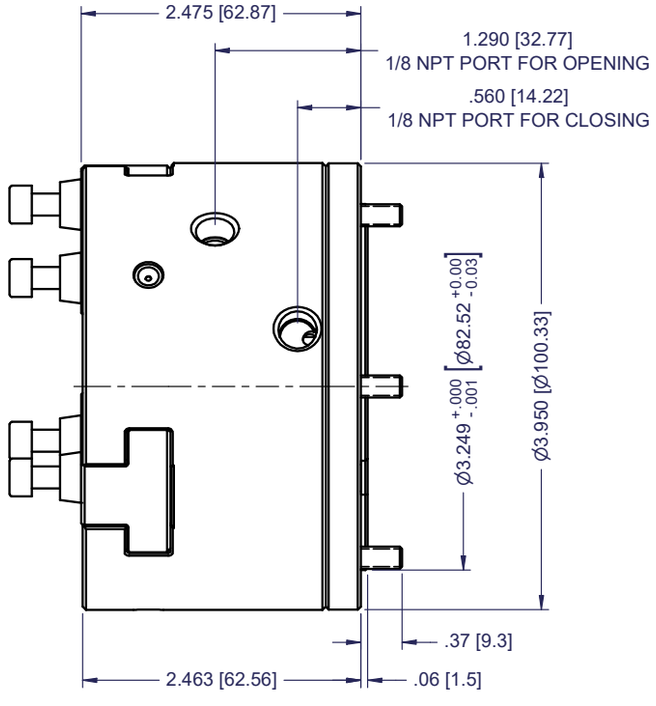
4-120NR-3 Dimensions





4-120NR-3/QC Dimensions

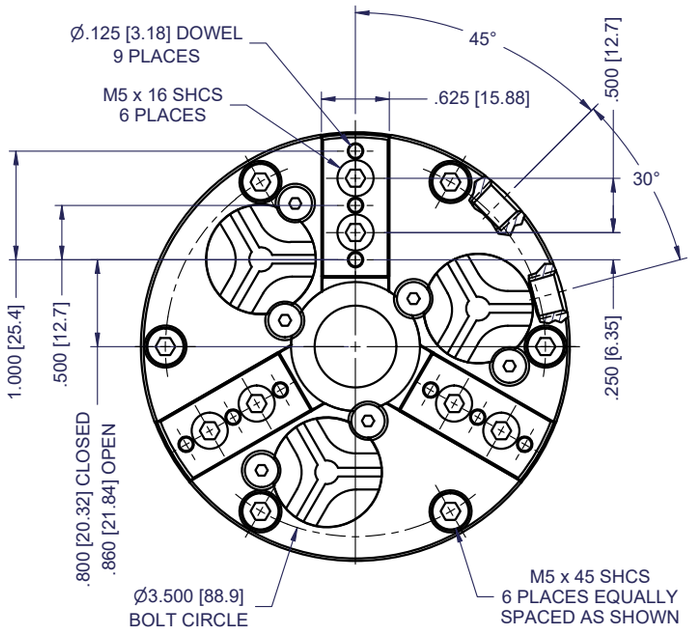


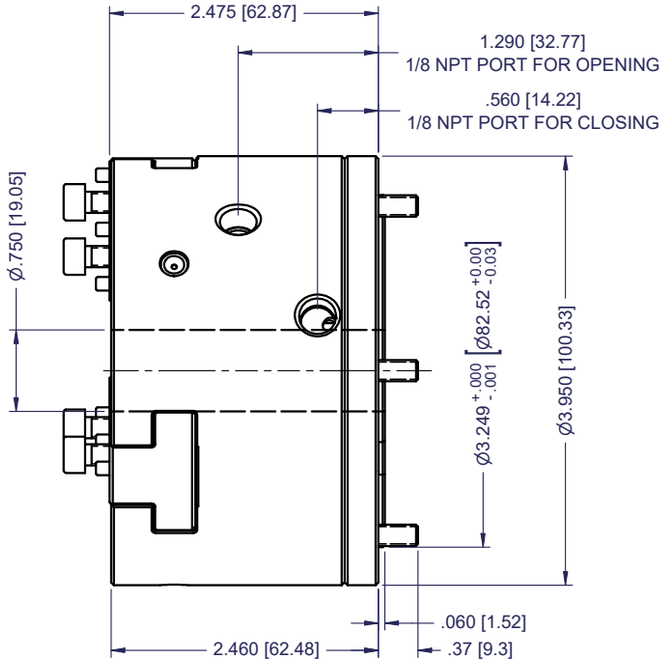


Stationary Air Chucks Drawings

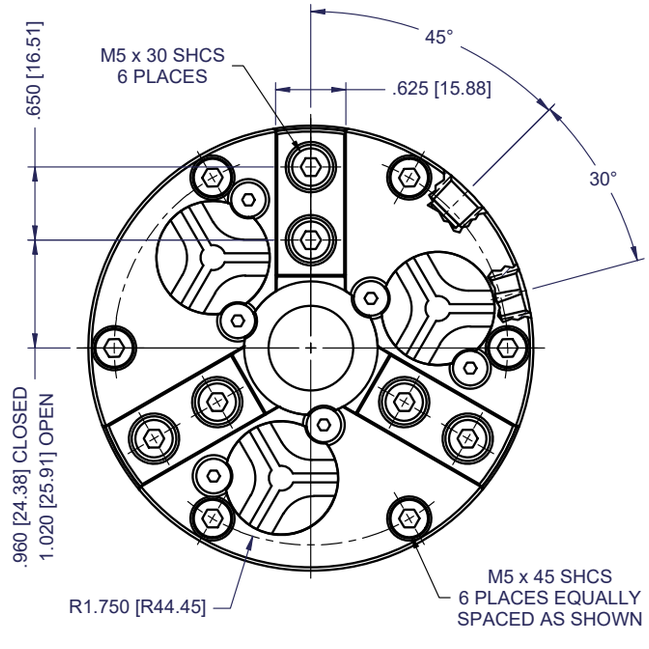
Back to Content

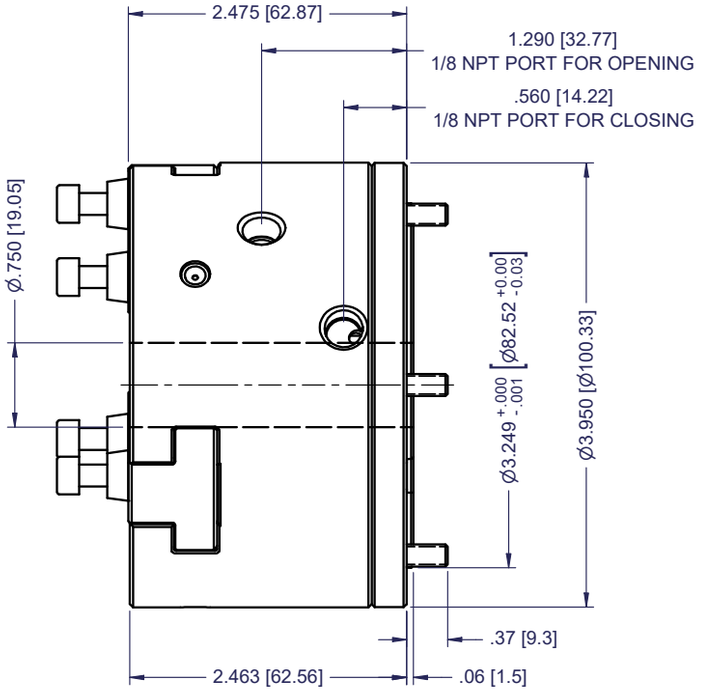
4-120NR19-3 Dimensions





4-120NR19-3/QC Dimensions

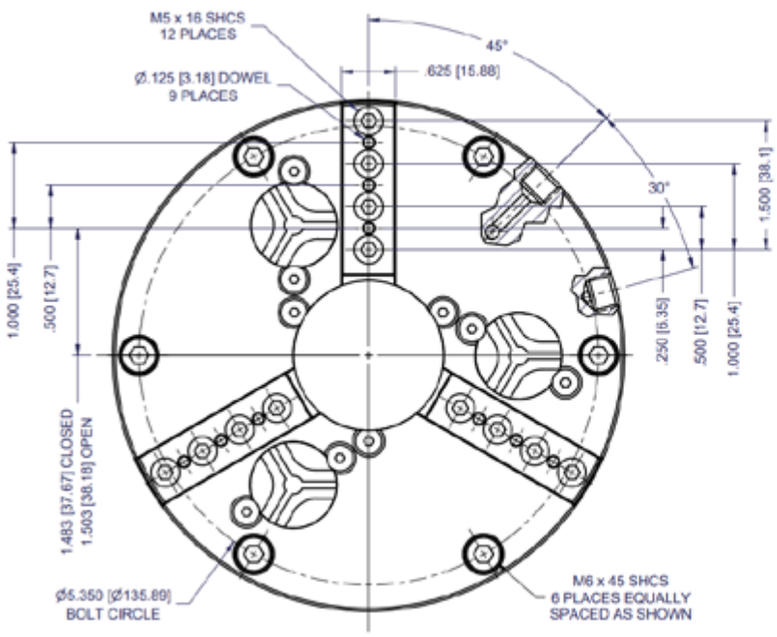


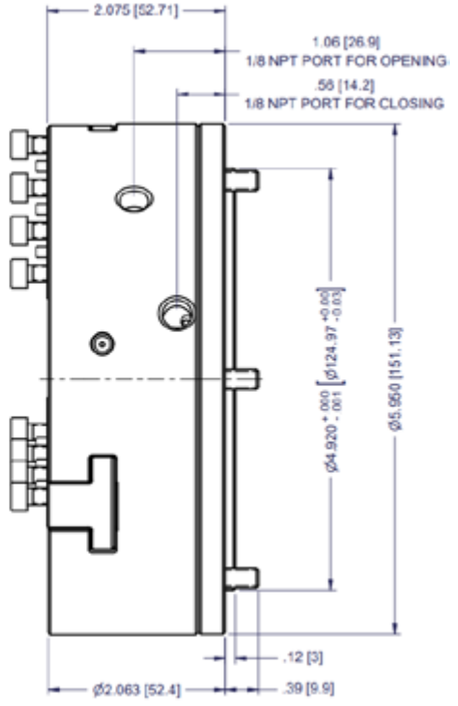


Stationary Air Chucks Drawings

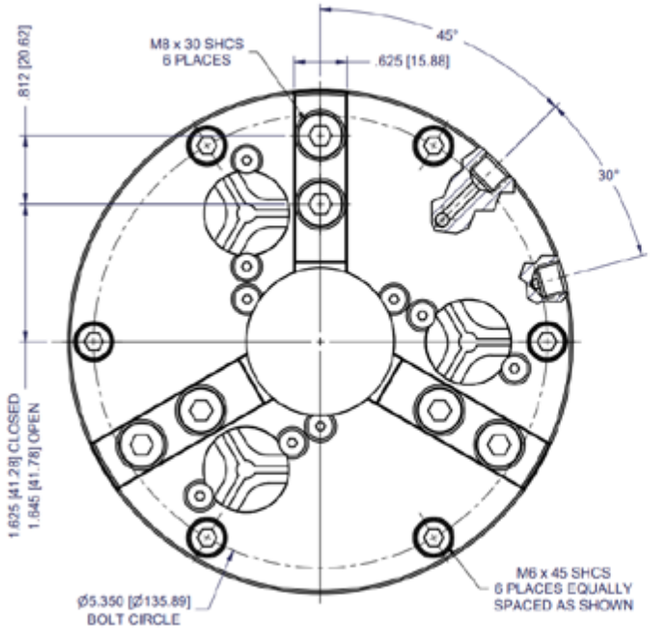
Back to Content

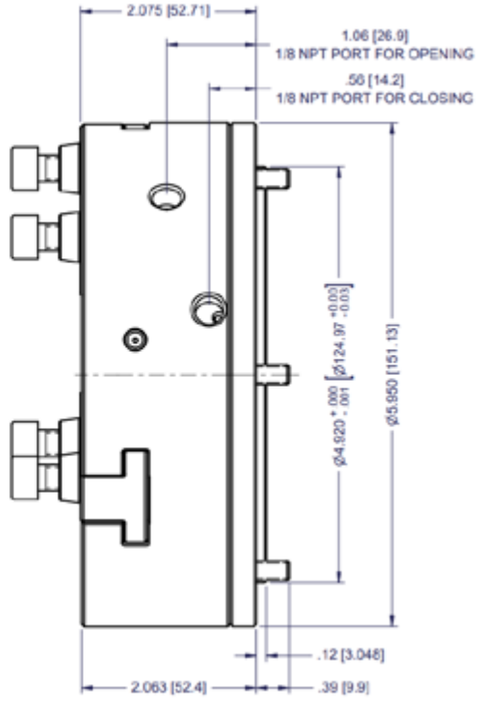
6-40NR-3 Dimensions





6-40NR-3/QC Dimensions

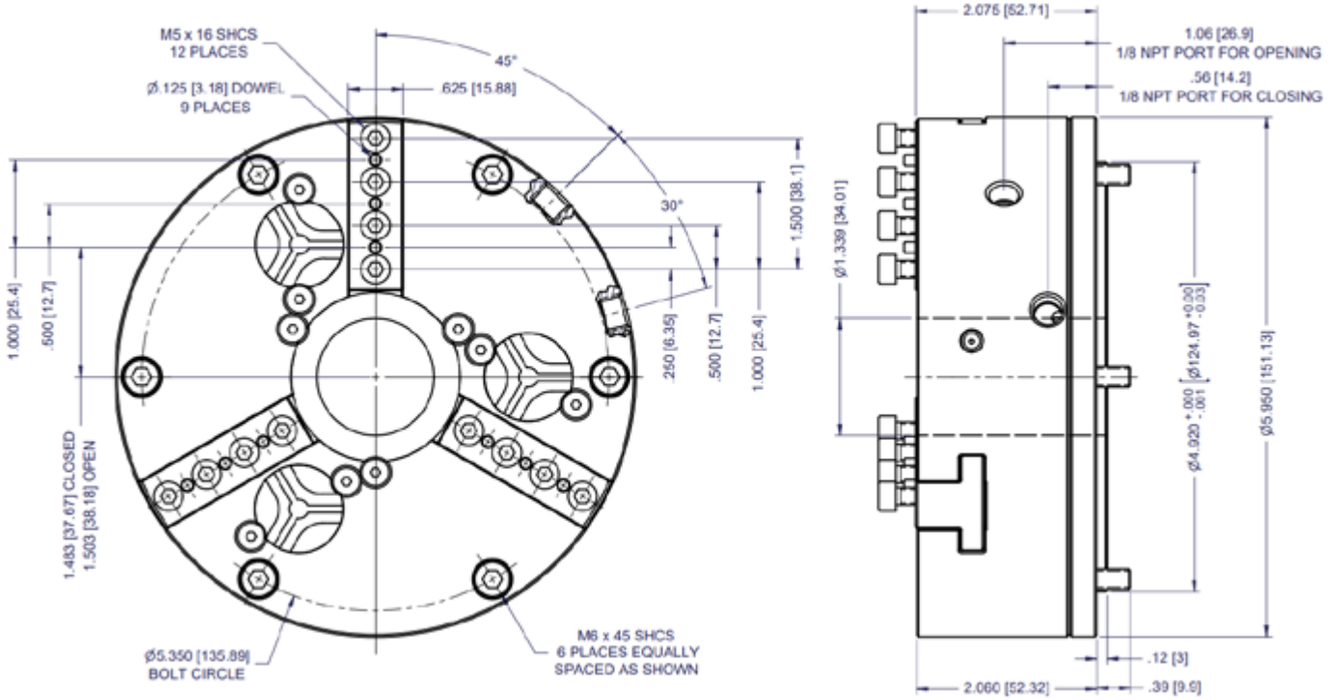




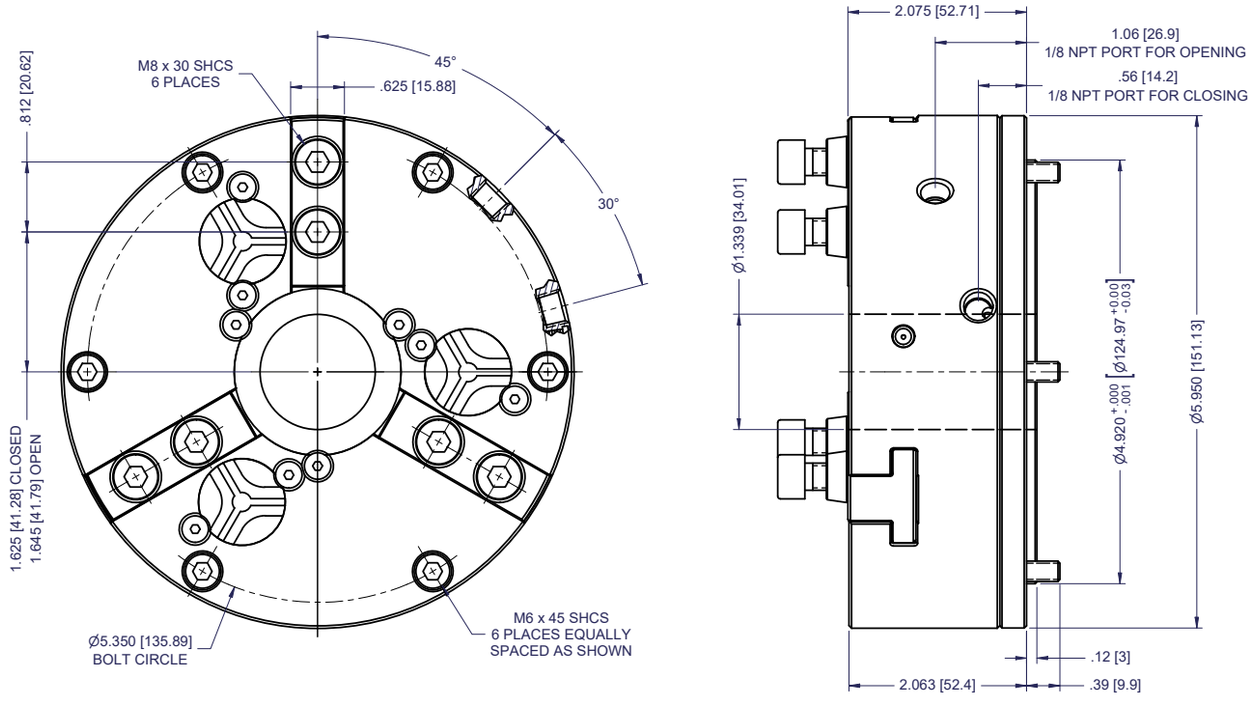
Stationary Air Chucks Drawings

Back to Content

6-40NR34-3 Dimensions



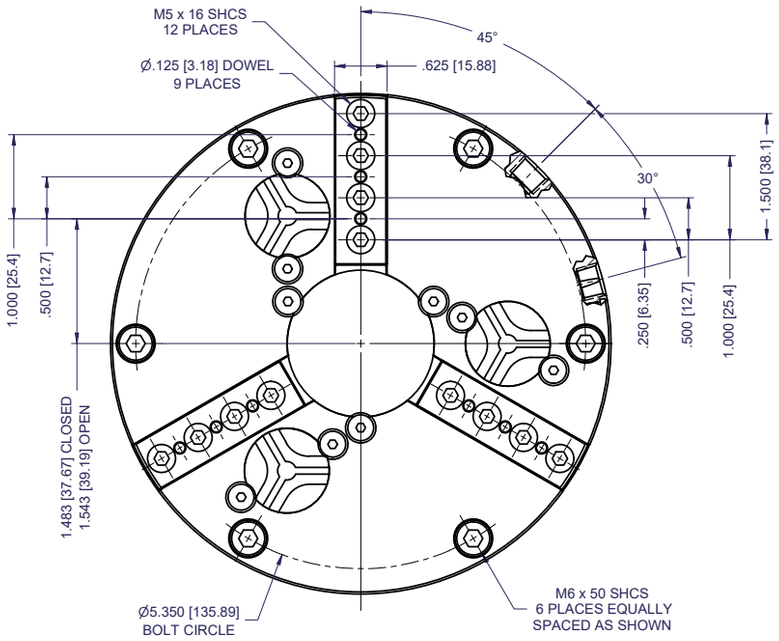
6-40NR34-3/QC Dimensions

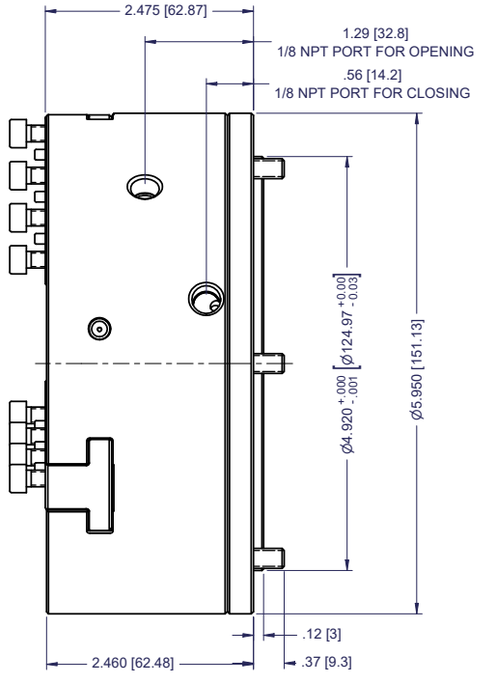


Stationary Air Chucks Drawings

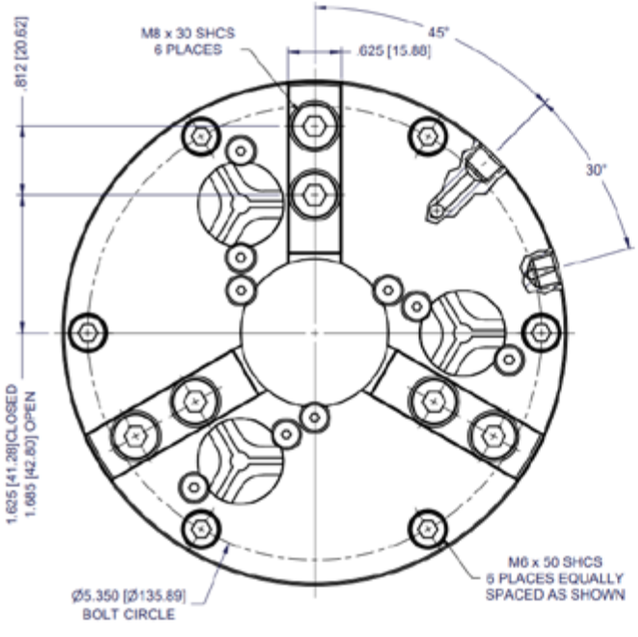
Back to Content

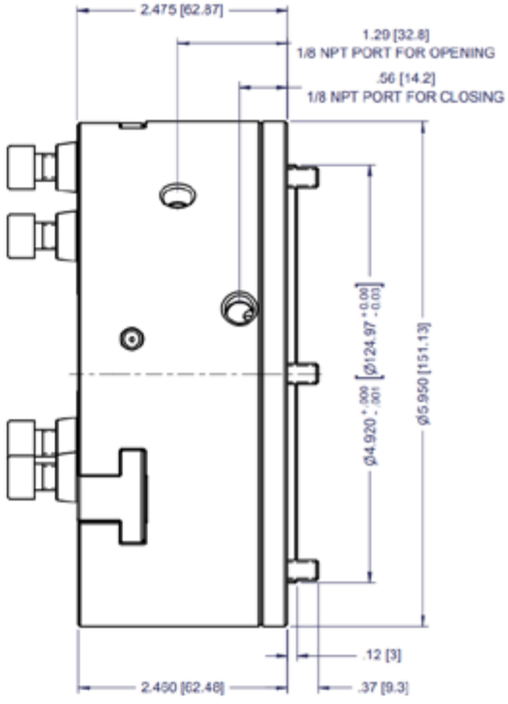
6-120NR-3 Dimensions





6-120NR-3/QC Dimensions

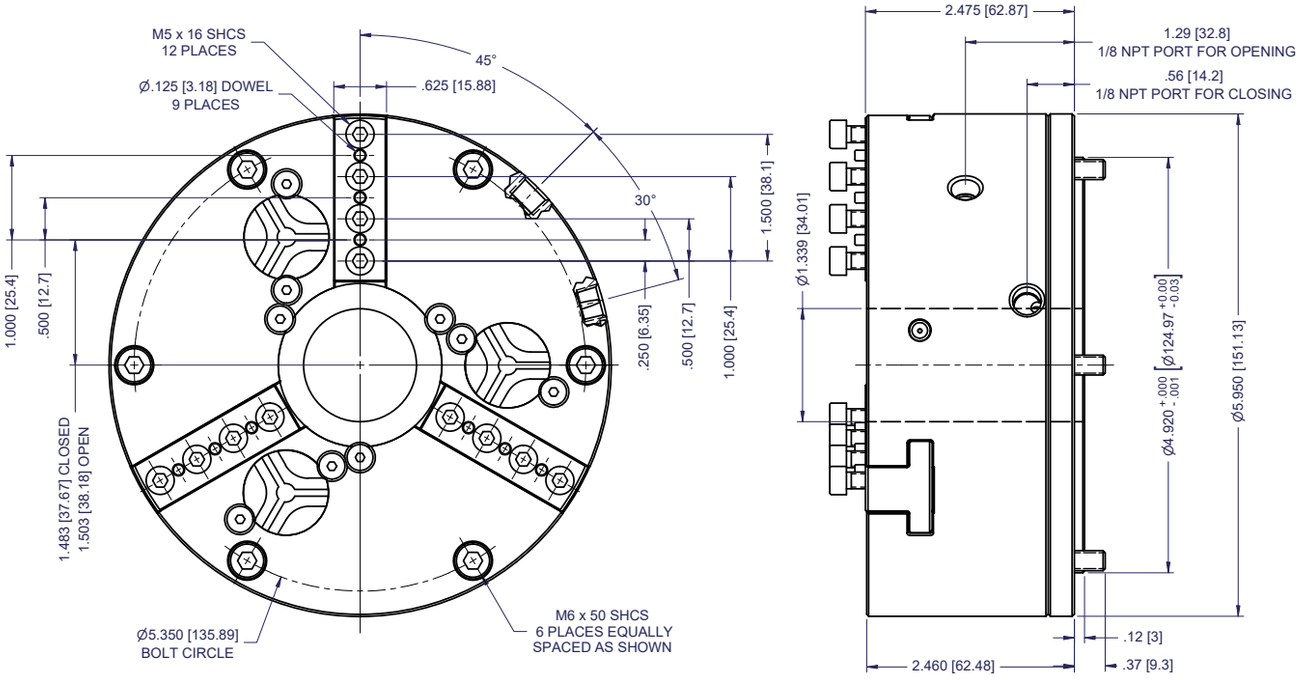




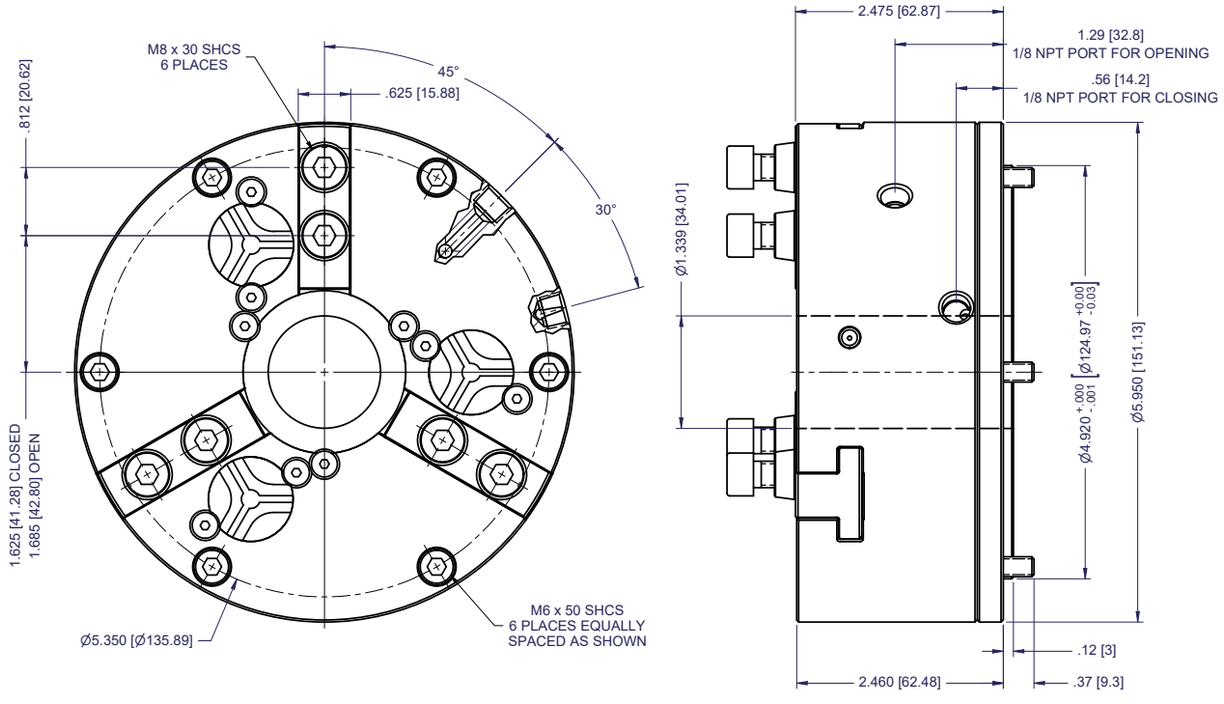
Stationary Air Chucks Drawings

Back to Content

6-120NR34-3 Dimensions



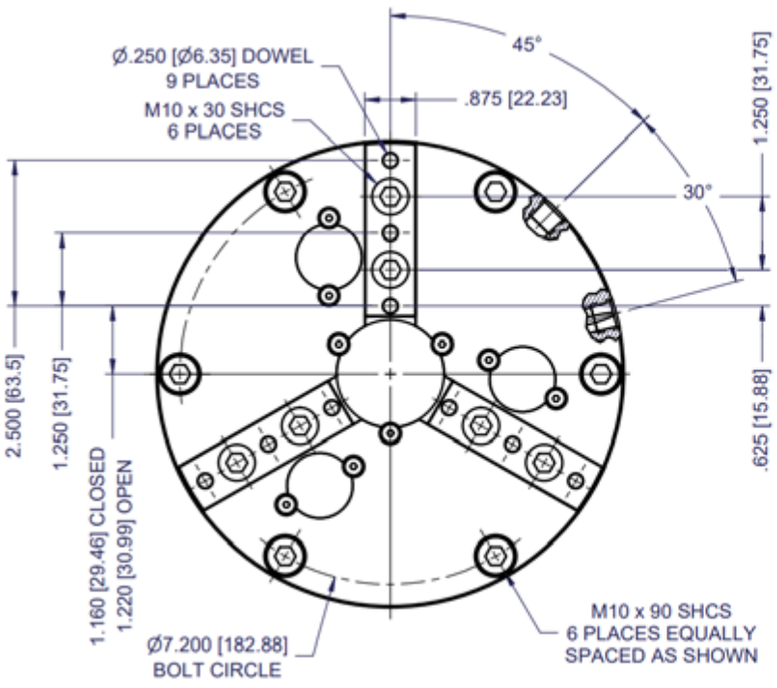
6-120NR34-3/QC Dimensions

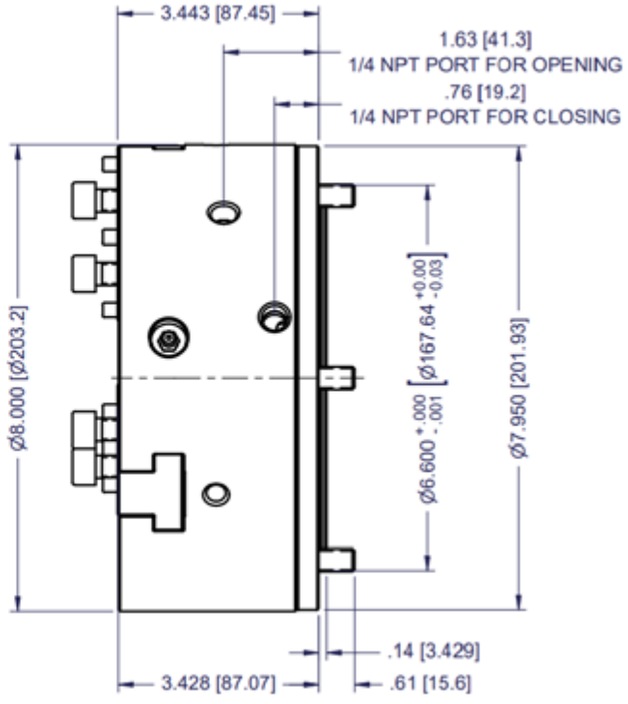


Stationary Air Chucks Drawings

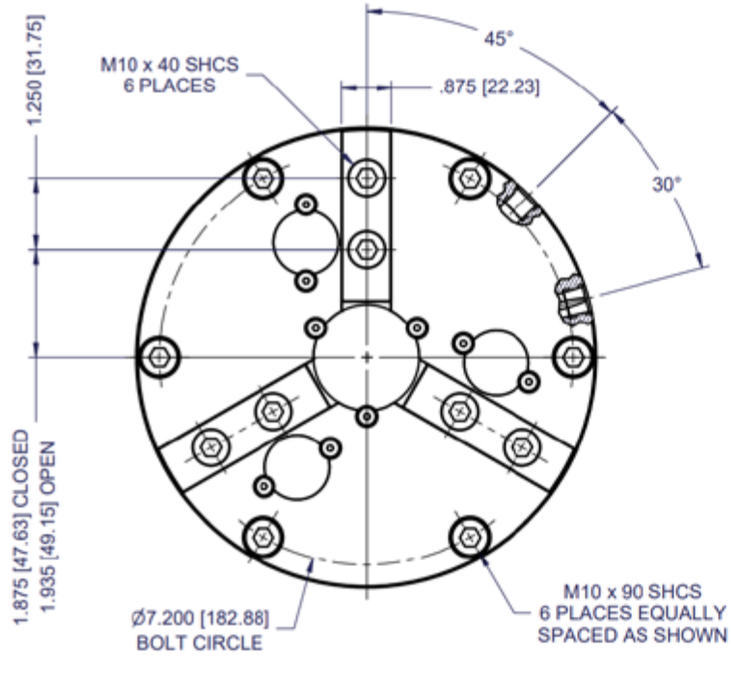
Back to Content

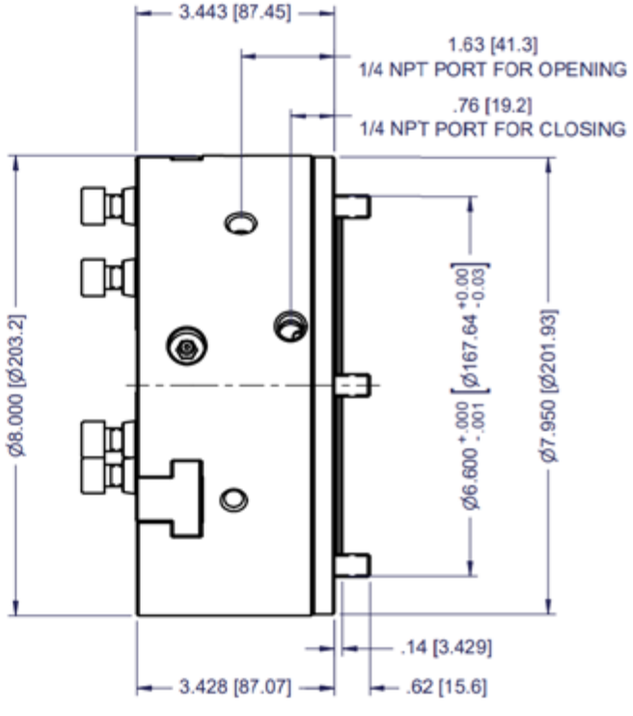
8-120NR-3 Dimensions





8-120NR-3/QC Dimensions

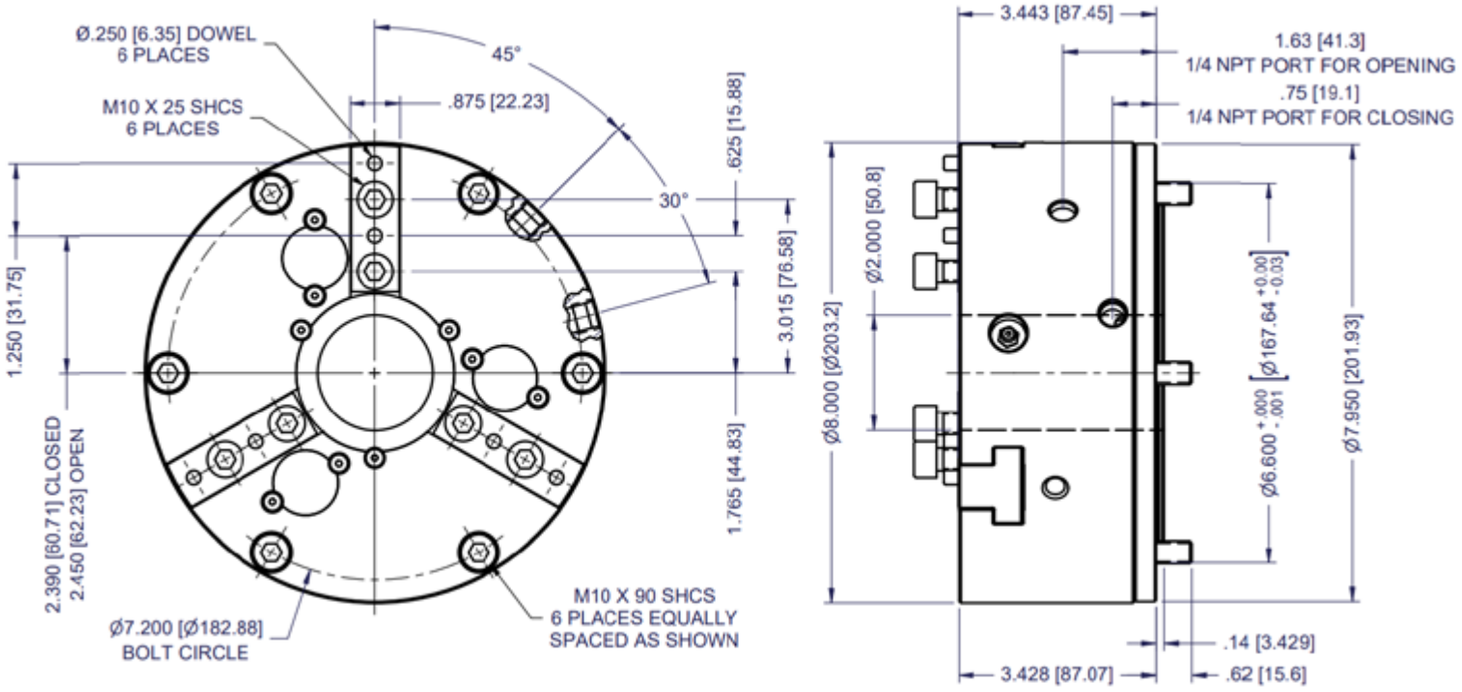




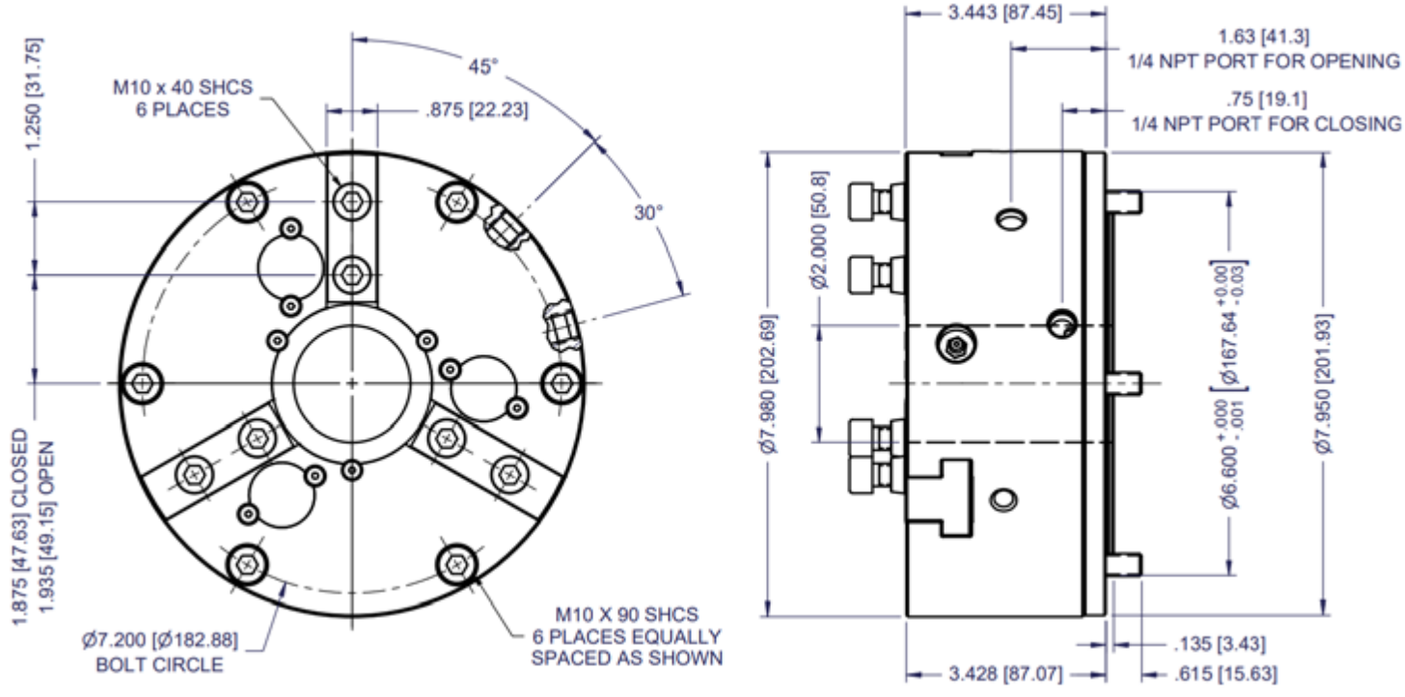
Stationary Air Chucks Drawings

Back to Content

8-120NR50-3 Dimensions



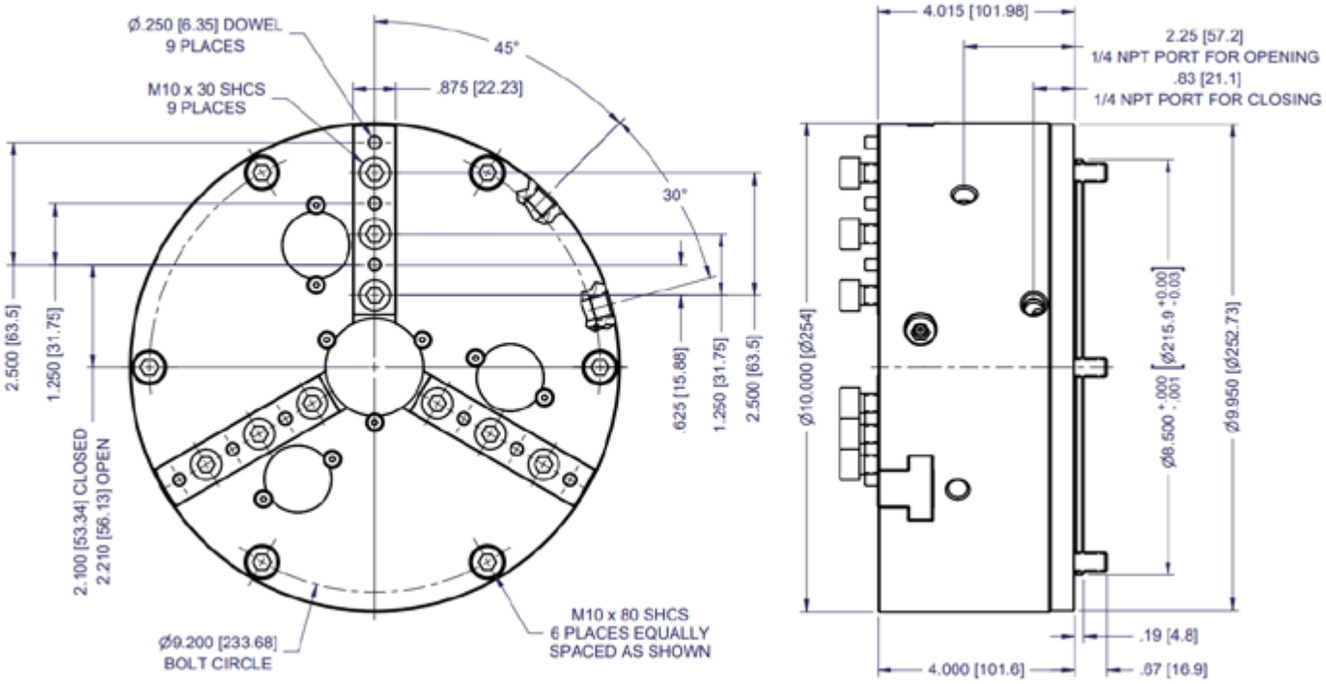
8-120NR50-3/QC Dimensions



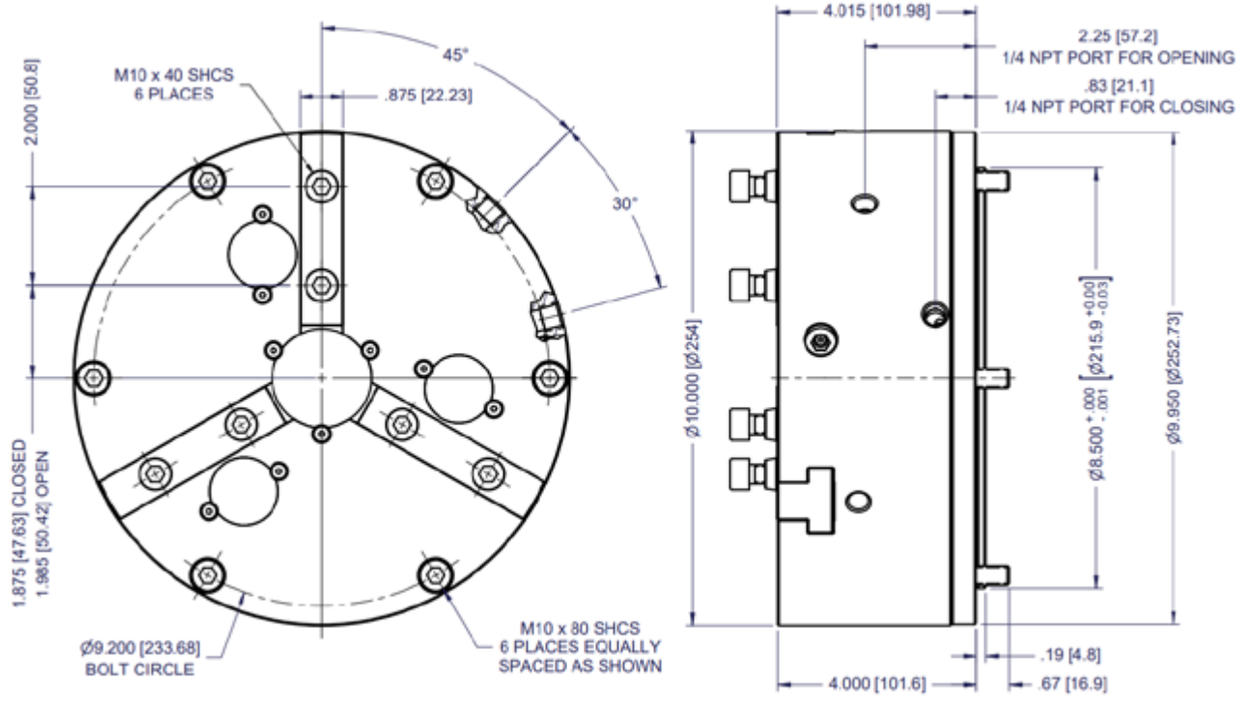
Stationary Air Chucks Drawings

Back to Content

10-220NR-3 Dimensions



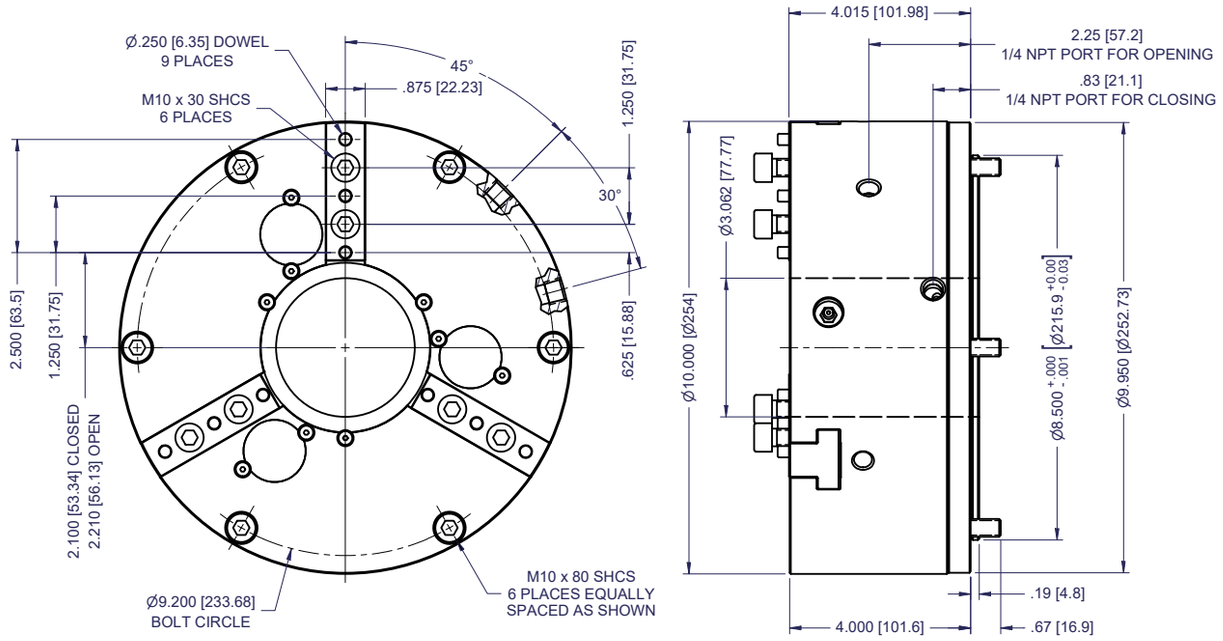
10-220NR-3/QC Dimensions



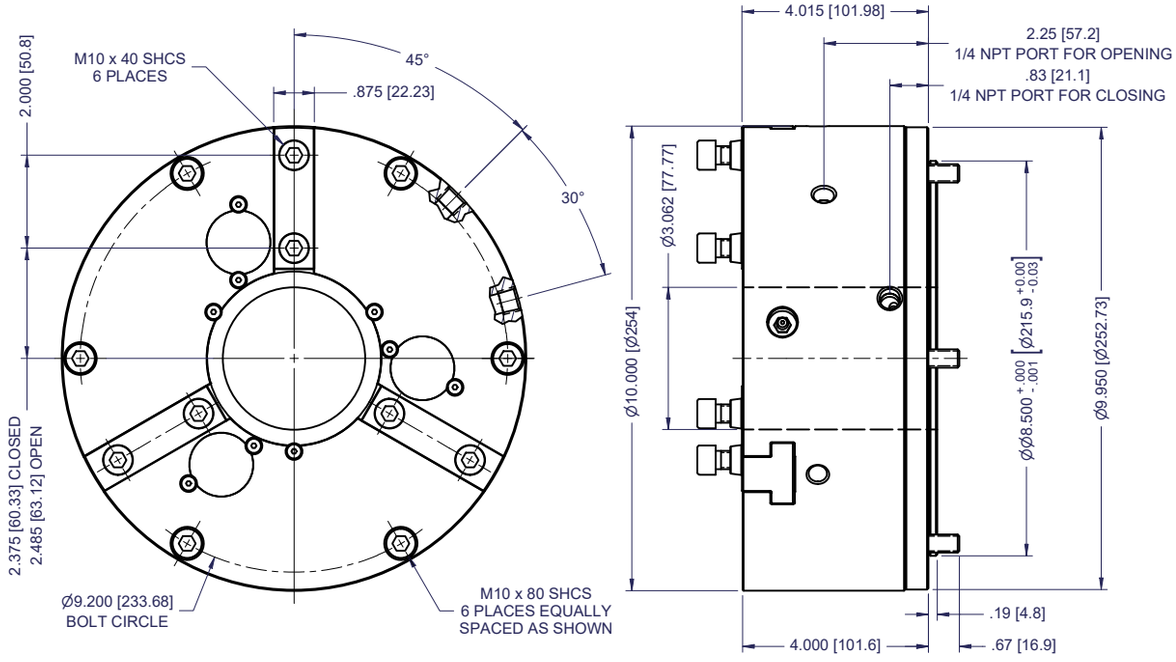
Stationary Air Chucks Drawings

Back to Content

10-220NR77-3 Dimensions



10-220NR77-3/QC Dimensions



Technical Data Long Stroke Air Chucks

Back to Content

Long stroke air chucks feature extended jaw opening for load clearance or to clamp a range of diameters without changing top jaws. Long stroke chucks are available in rotating and stationary configurations. Their high accuracy makes them ideal for clamping headed workpieces for turning, grinding, or milling/ drilling applications. Special models with total jaw stroke of .500" (12.7mm), .750" (19.1mm), and 1.000" (24.5mm) are also available. Please call for information.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Max. Speed[3]	Chuck Weight[4]
4 inch / 100mm	4-500-3	3	.00005"/ 0.0012mm	.500"/ 12.7mm	1,090 lb/ 4.8 kN	100 psi / 0.7 Mpa	4,000	7.9 lb / 3.6 kg
6 inch / 150mm	6-500-3	3	.00005" / 0.0012mm	.500"/ 12.7mm	2,730 lb/ 12.1 kN	100 psi / 0.7 Mpa	3,000	18.3 lb / 8.3 kg
8 inch / 200mm	8-750-3	3	.00005" / 0.0012mm	.750"/ 19.0mm	4,670 lb/ 20.8 kN	100 psi / 0.7 Mpa	2,500	45.2 lb / 20.5 kg

1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Maximum rpm s influenced by air pressure and mass of top jaws
4 Without top jaws and spindle mounting plate

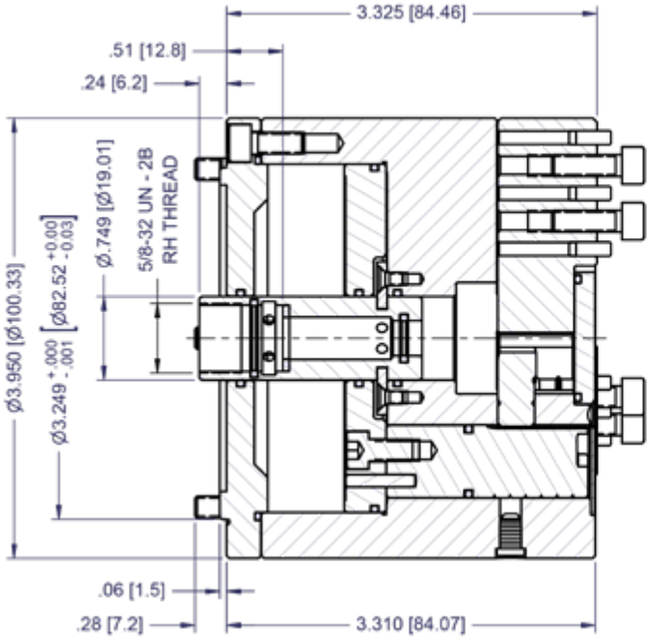
Drawings
PAGE 69

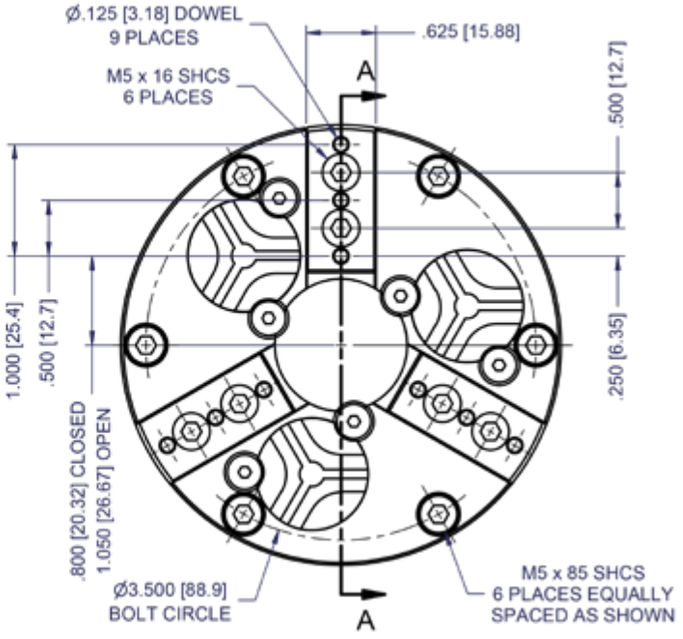
Top Jaws
PAGE 88

Long Stroke Air Chucks Drawings

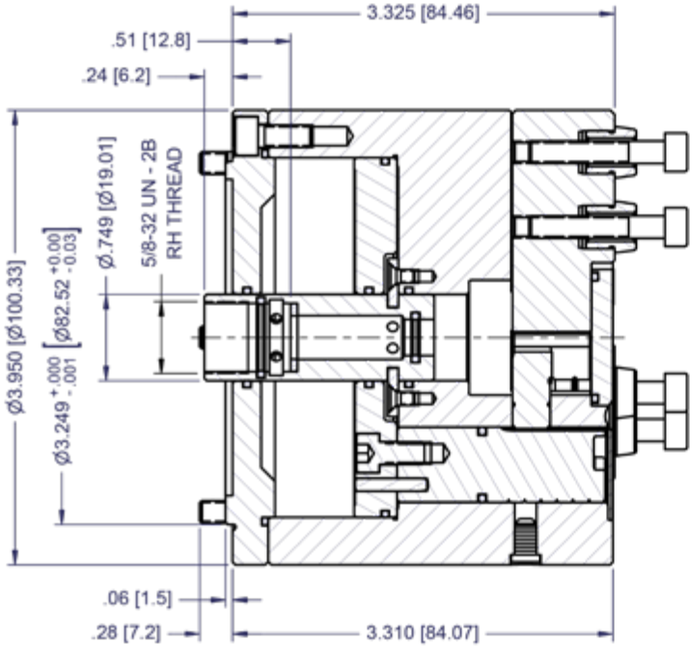
Back to Content

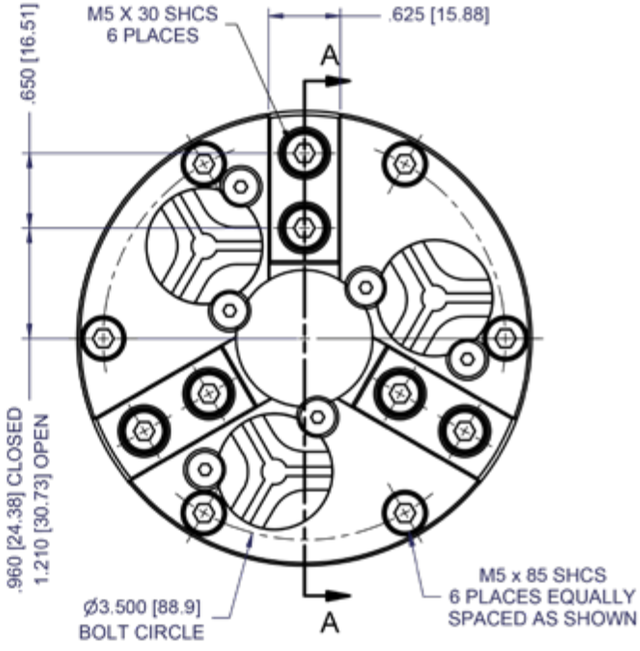
4-500-3 Dimensions





4-500-3/QC Dimensions

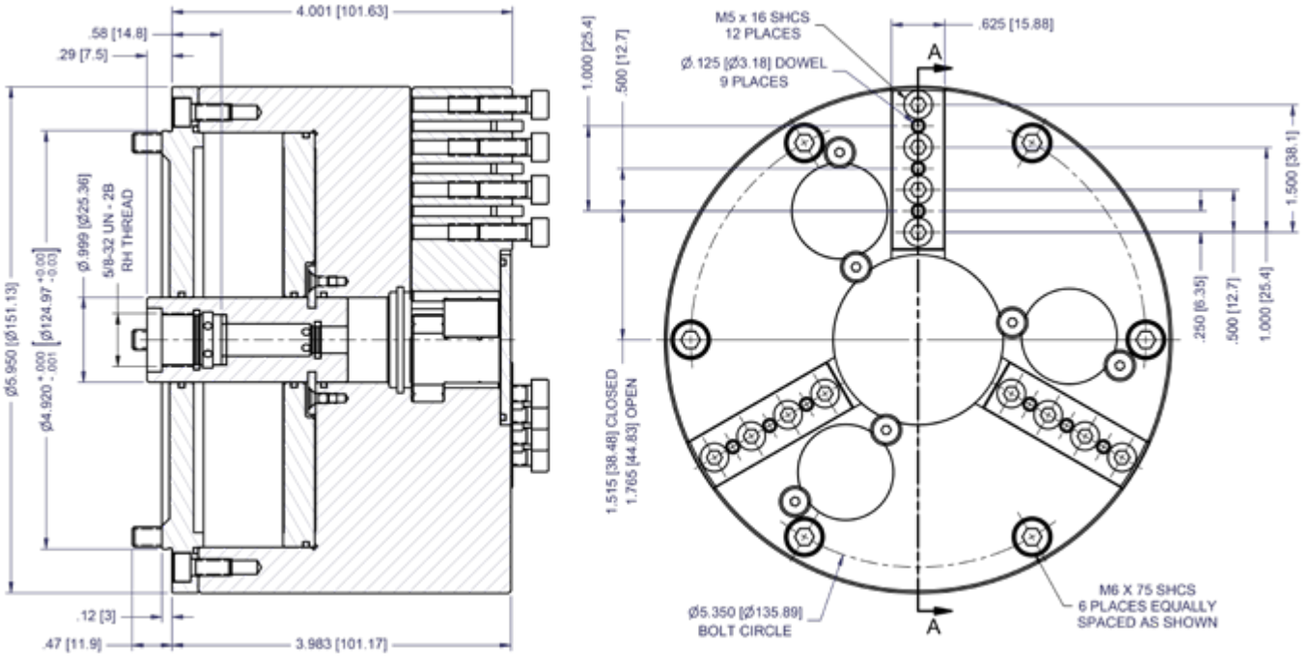




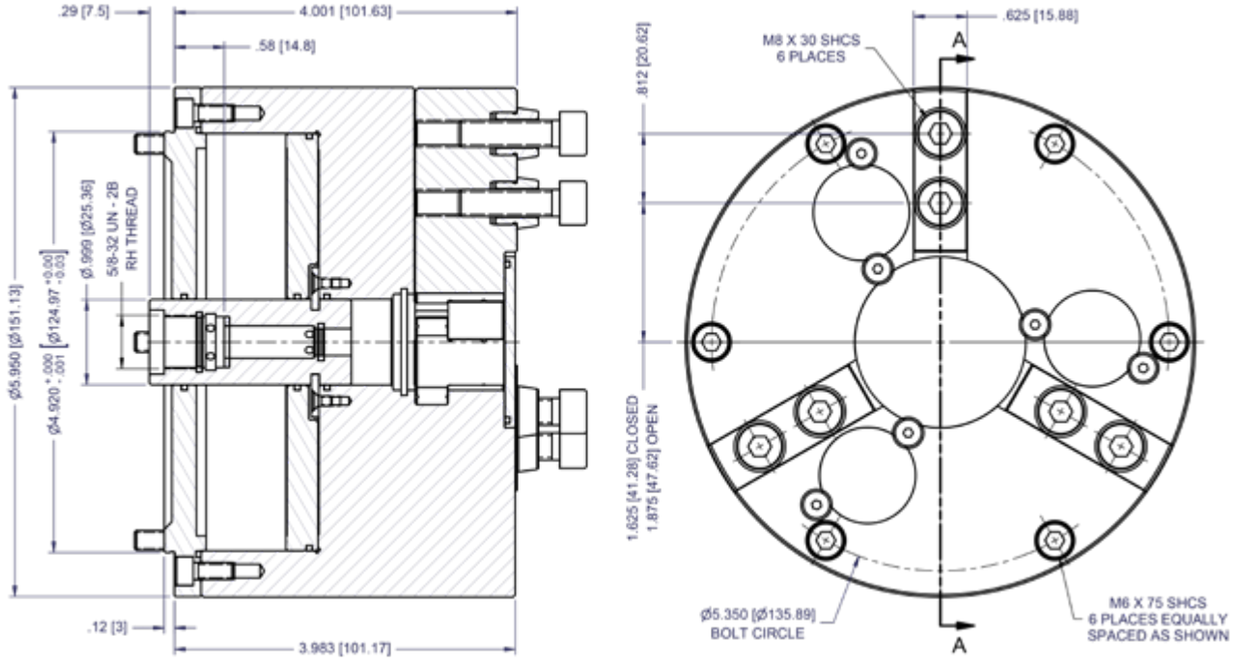
Long Stroke Air Chucks Drawings

Back to Content

6-500-3 Dimensions



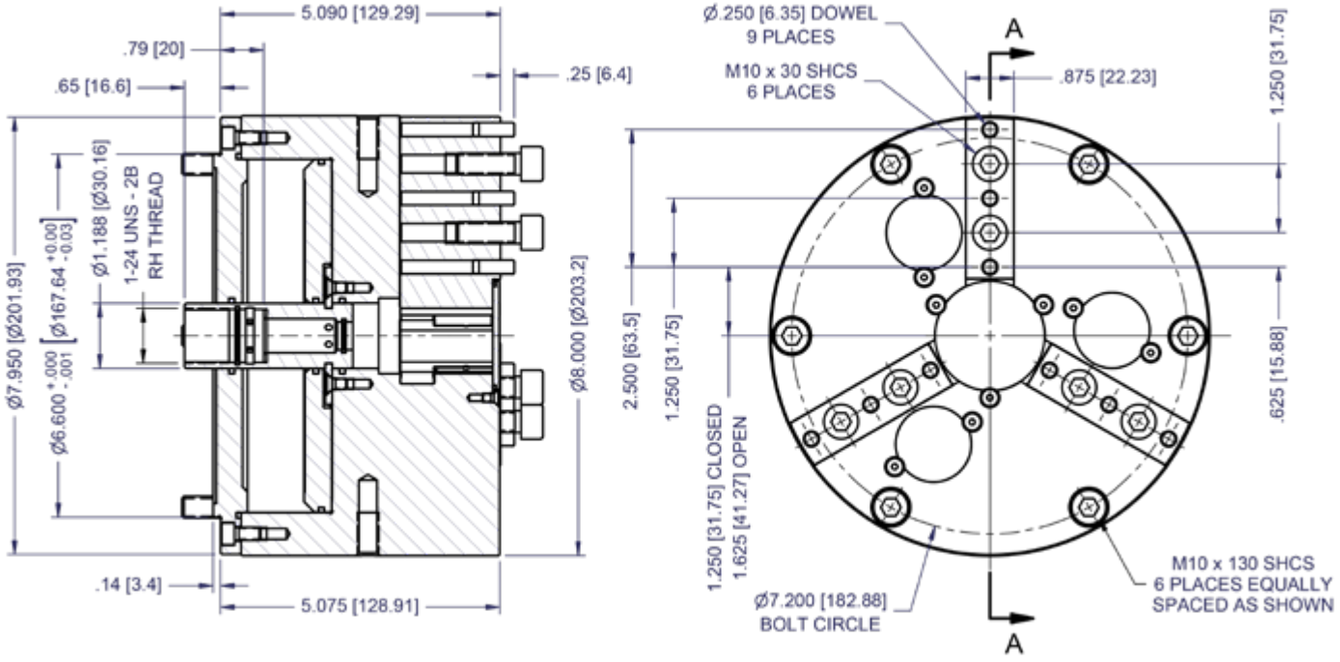
6-500-3/QC Dimensions



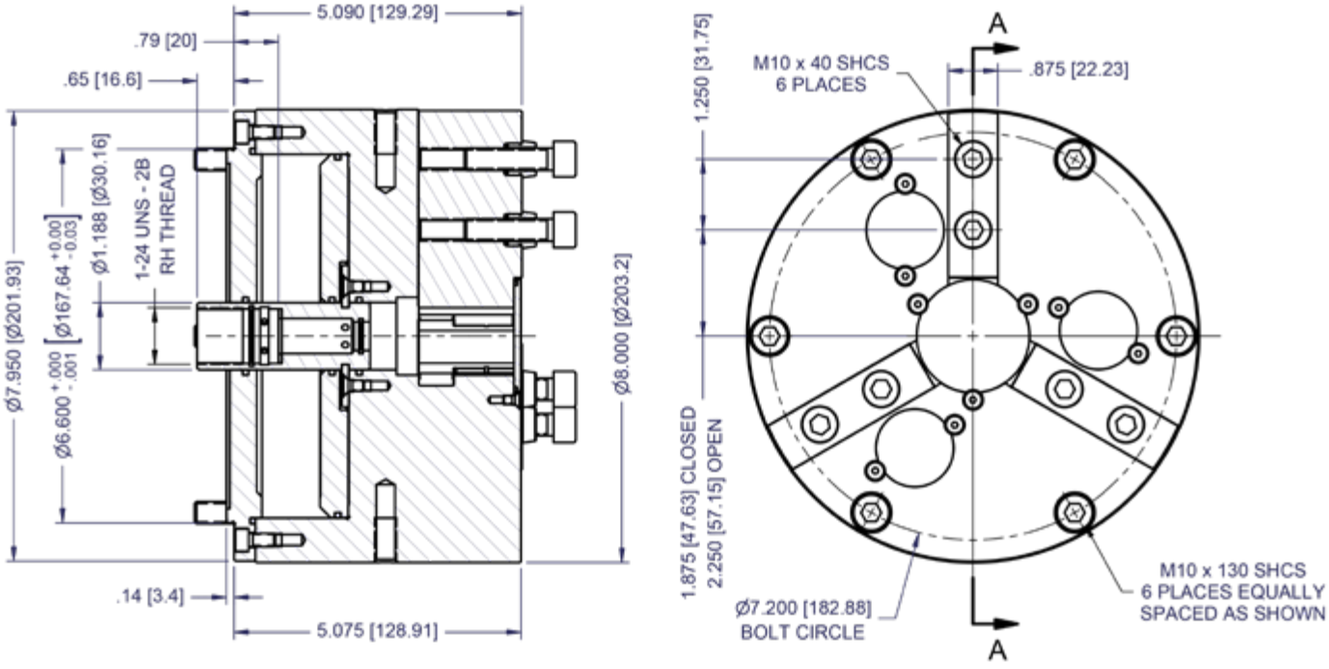
Long Stroke Air Chucks Drawings

Back to Content

8-750-3 Dimensions

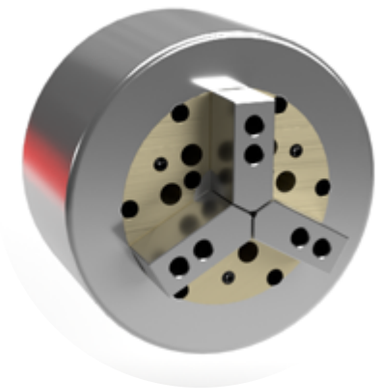


8-750-3/QC Dimensions



Technical Data High Speed Air Chucks

Back to Content



HST High Speed Air Chucks feature a titanium chuck body and are actuated by a patented external wedge design that maintains clamping force at high spindle speeds without counterweights. This revolutionary design minimizes the effects of centrifugal force resulting in consistent clamping force throughout the chuck's rpm range.

HST chucks are available in standard, HS, and BP models. The HS models are dynamically balanced and feature MicroCentric's patented NR50 non-rotating air tube system. The NR50 design eliminates vibration caused by rotating air at higher spindle speeds, thus enhancing a machine's surface finish, and roundness capability.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Max Speed[3]	Chuck Weight[4]
3 inch / 80mm	HST3-3	3	.0001" / 0.0025mm	.080" / 2.0mm	2,550 lb / 11.3 kN	100 psi / 0.7 Mp	6,000 rpm	5.9 lb / 2.7 kg
	HST3-3/HS						10,000 rpm	
4 inch / 100mm	HST4-3	3	.0001" / 0.0025mm	.100" / 2.5mm	3,150 lb / 14.0 kN	100 psi / 0.7 Mpa	6,000 rpm	11.8 lb / 5.4 kg
	HST4-3/HS						9,000 rpm	
6 inch / 150mm	HST6-3	3	.0001" / 0.0025mm	.100" / 2.5mm	5,800 lb / 25.8 kN	100 psi / 0.7 Mpa	6,000 rpm	22.5 lb / 10.2 kg
	HST6-3/HS						8,000 rpm	

1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Maximum rpm s influenced by air pressure and mass of top jaws
4 Without top jaws and spindle mounting plate

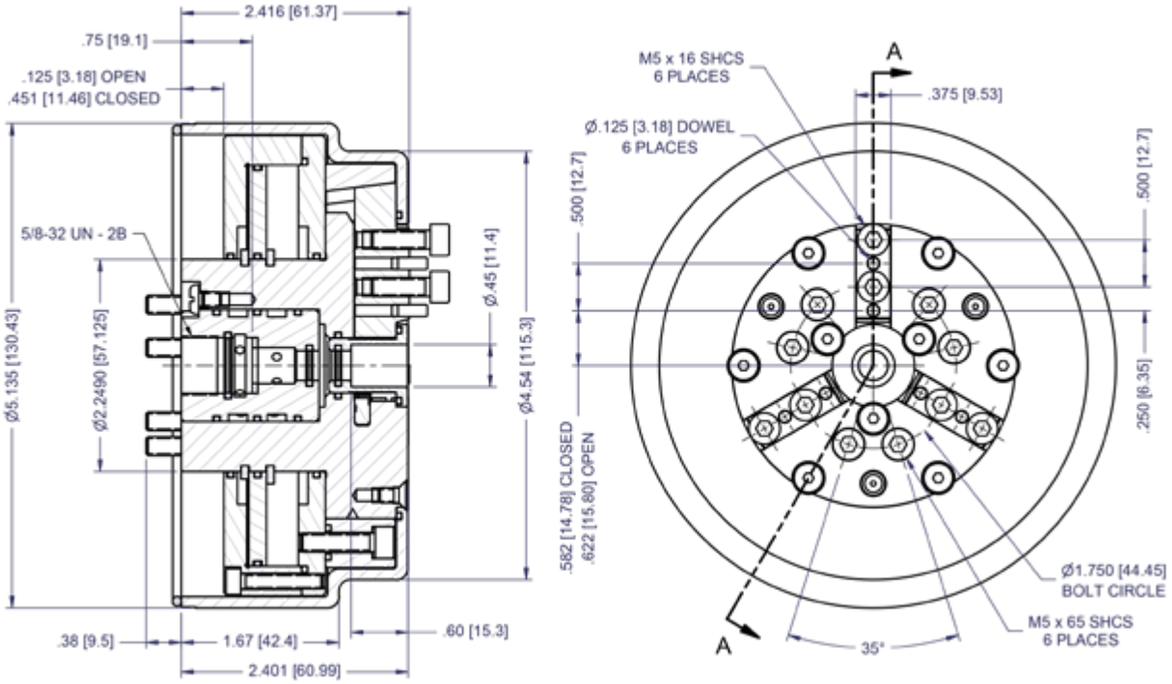
Drawings
PAGE 73

Top Jaws
PAGE 88

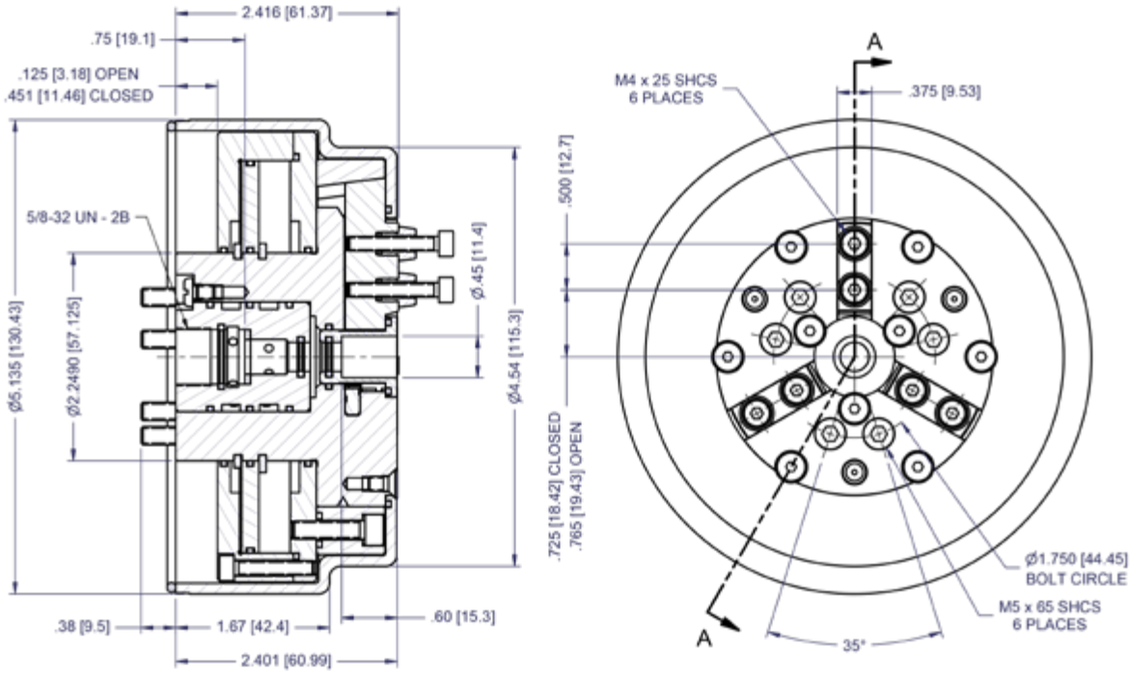
High Speed Air Chucks Drawings

Back to Content

HST3-3 Dimensions



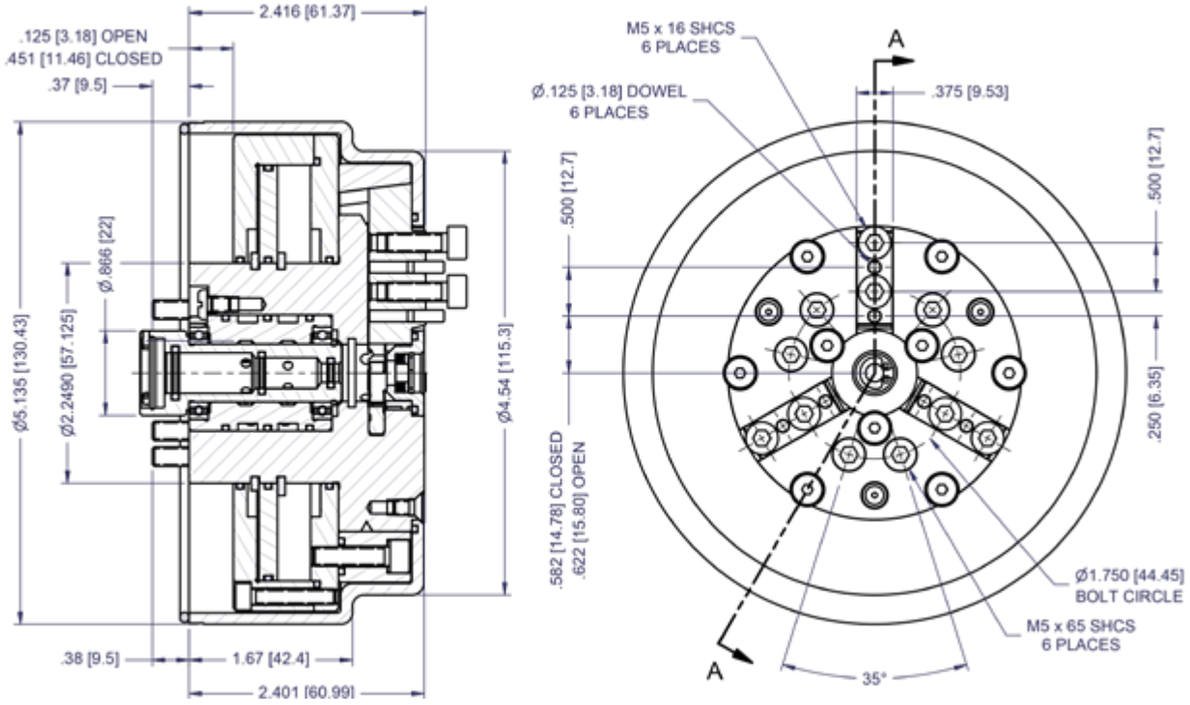
HST3-3/QC Dimensions



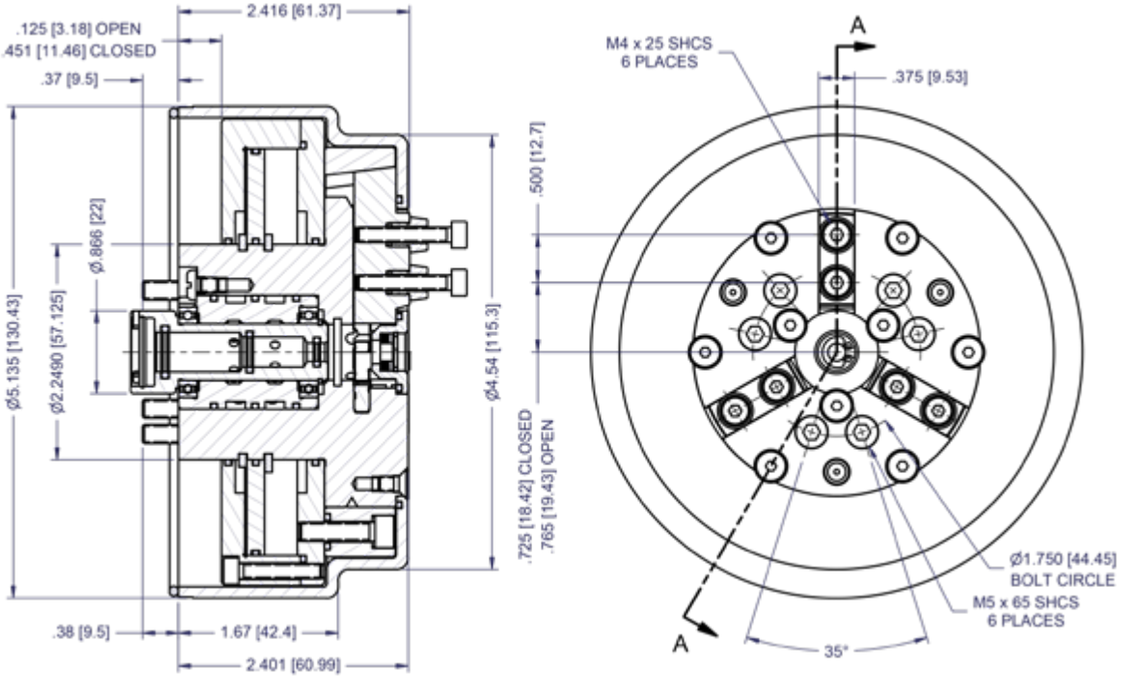
High Speed Air Chucks Drawings

Back to Content

HST3-3-HS Dimensions



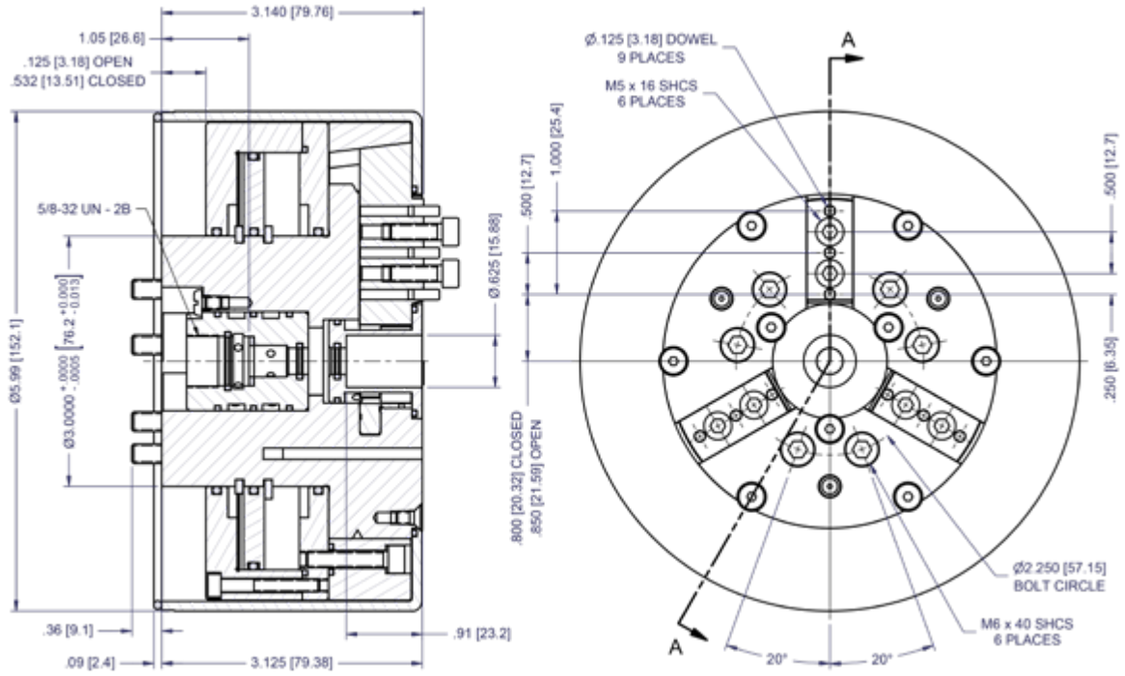
HST3-3- HS/QC Dimensions



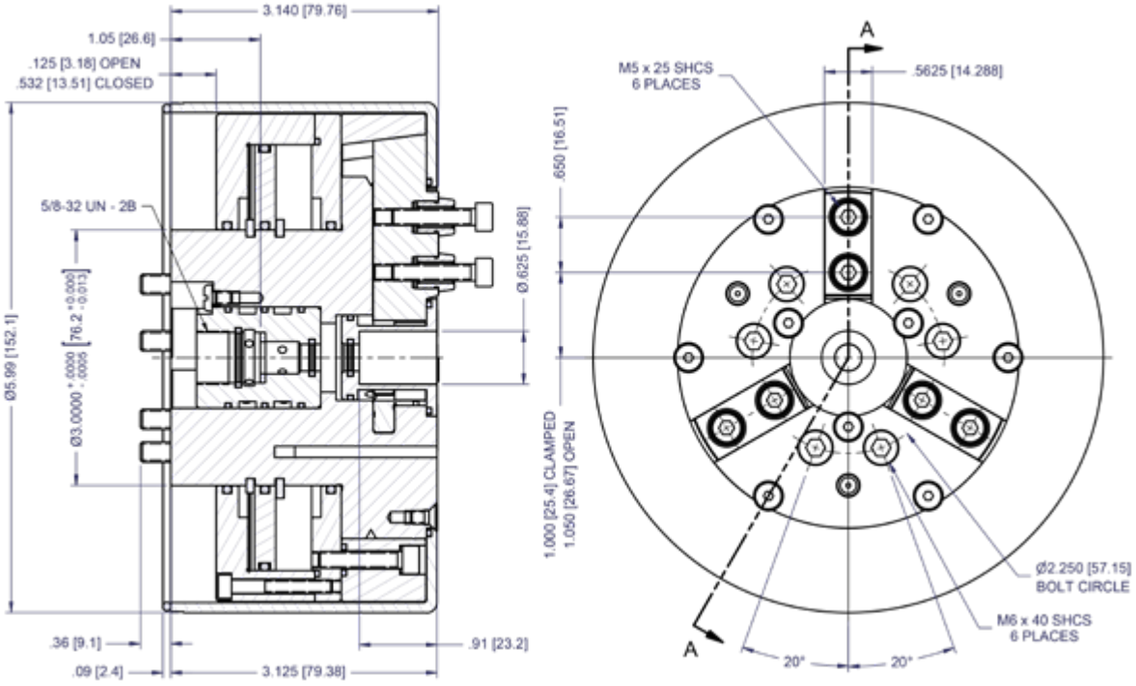
High Speed Air Chucks Drawings

Back to Content

HST4-3 Dimensions



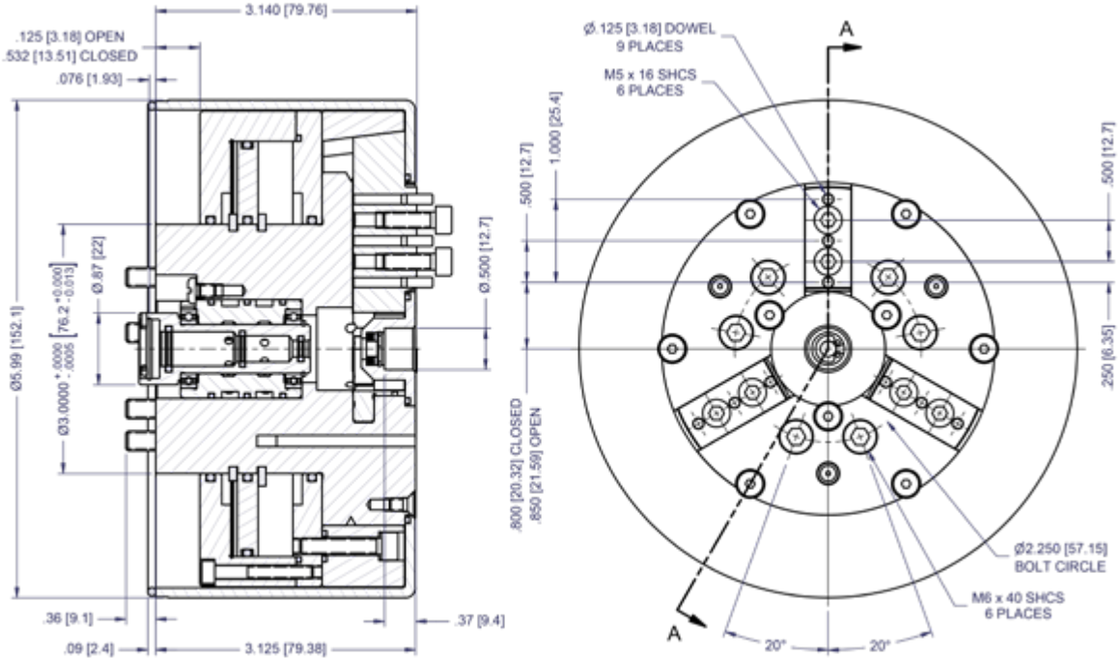
HST4-3/QC Dimensions



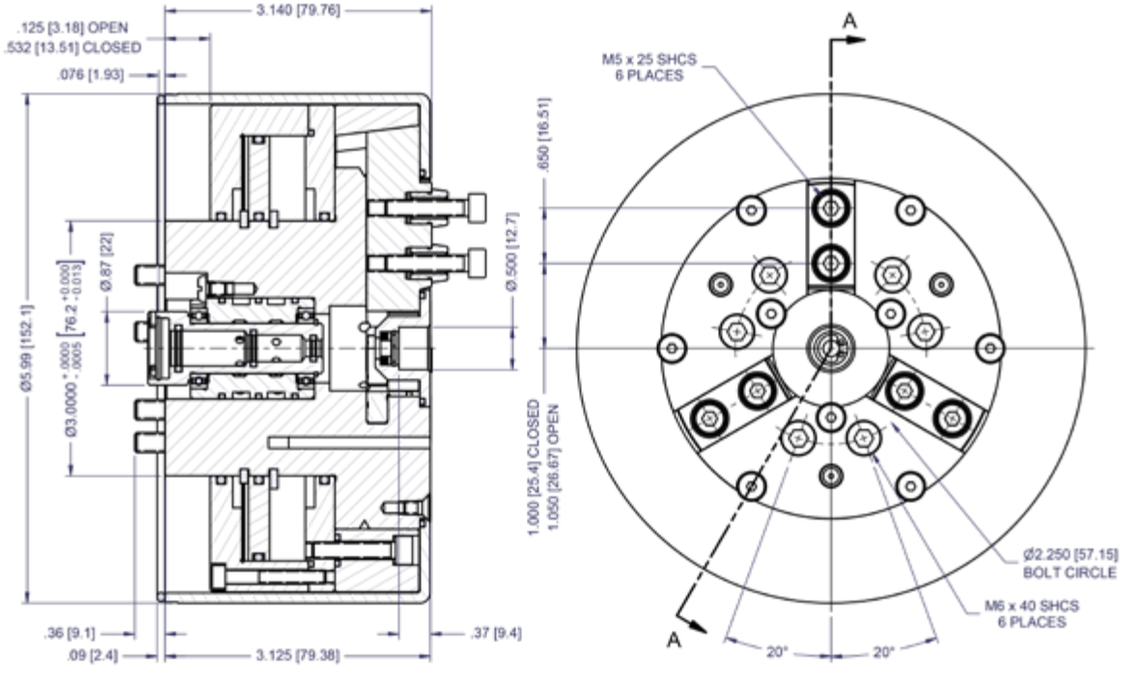
High Speed Air Chucks Drawings

Back to Content

HST4-3-HS Dimensions



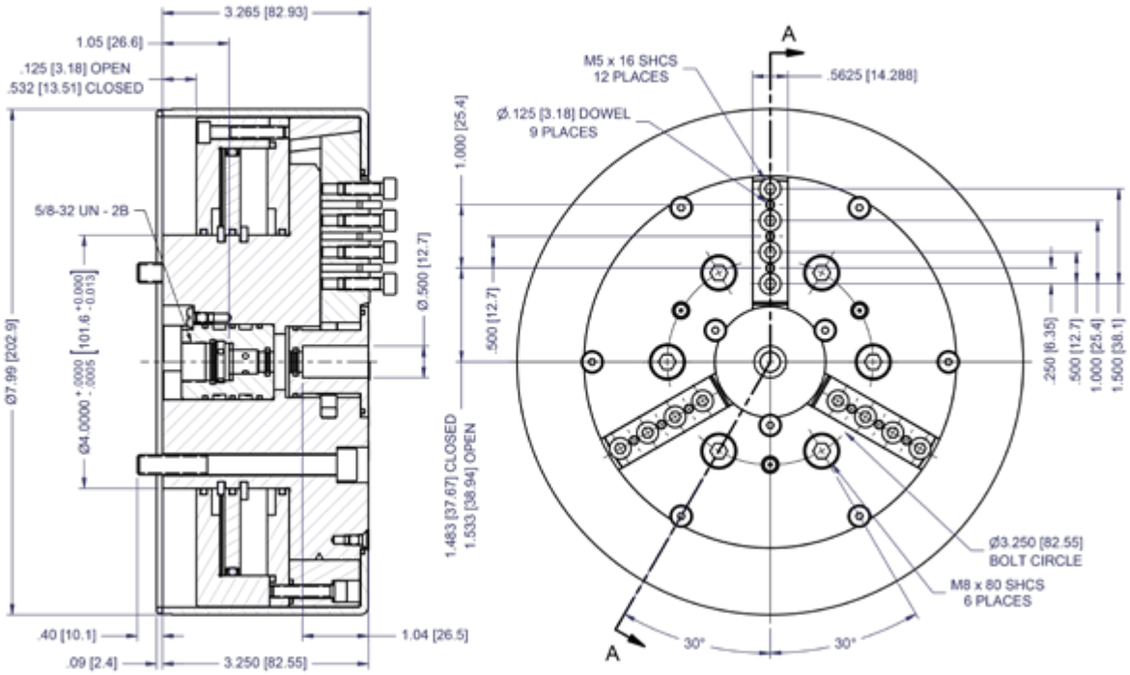
HST4-3-HS/QC Dimensions



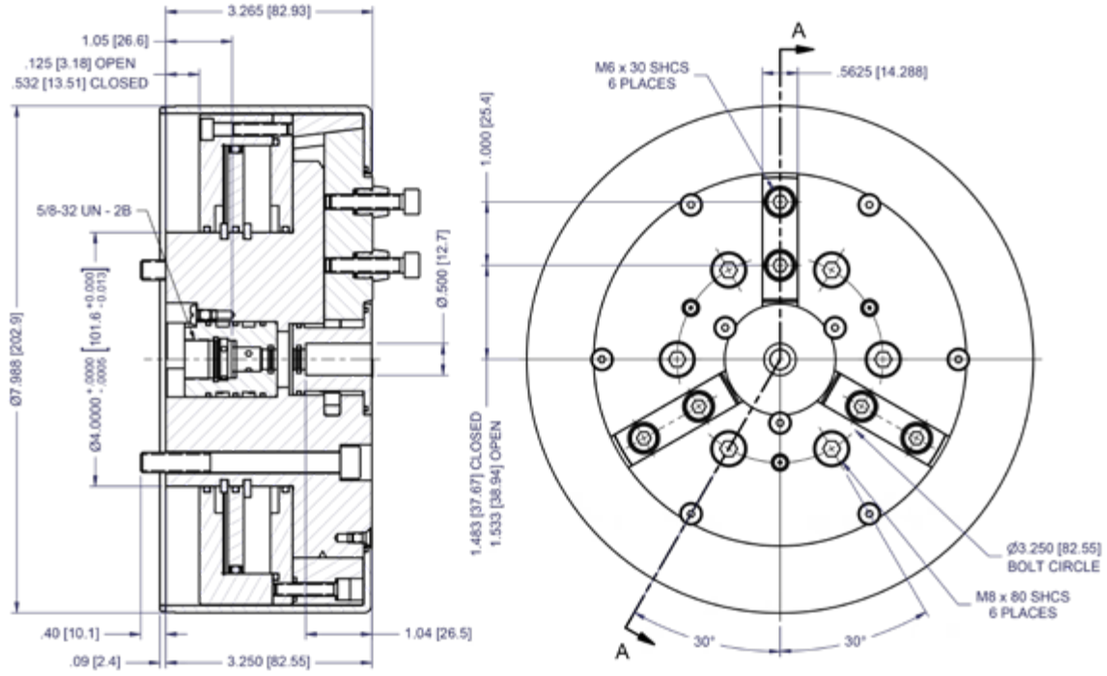
High Speed Air Chucks Drawings

Back to Content

HST6-3 Dimensions



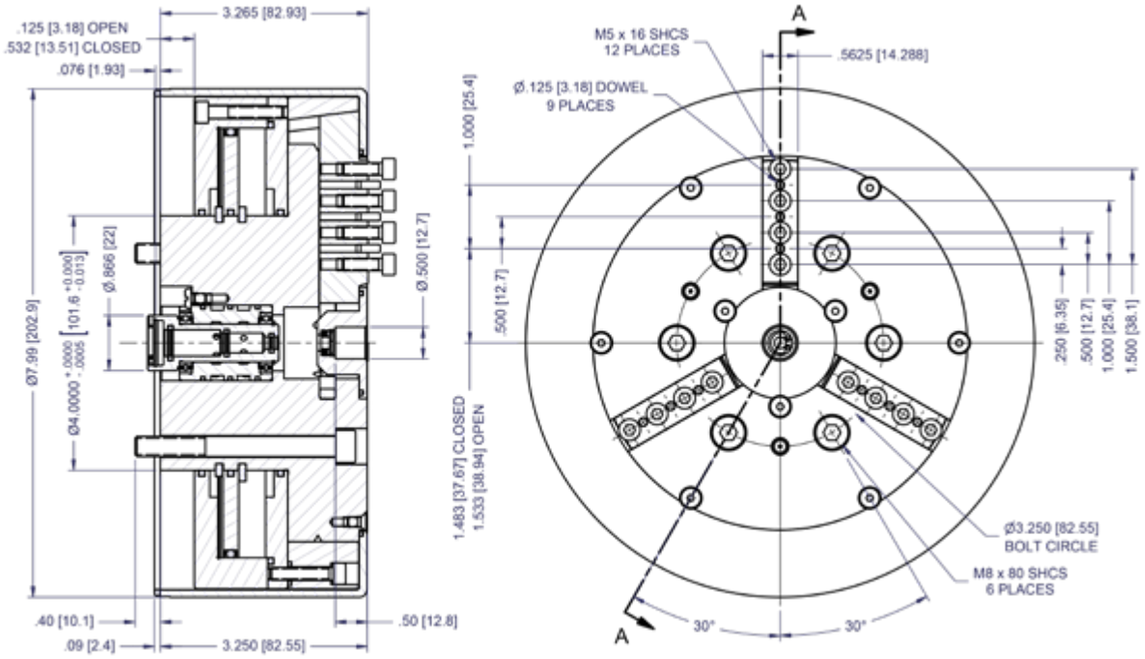
HST6-3/QC Dimensions



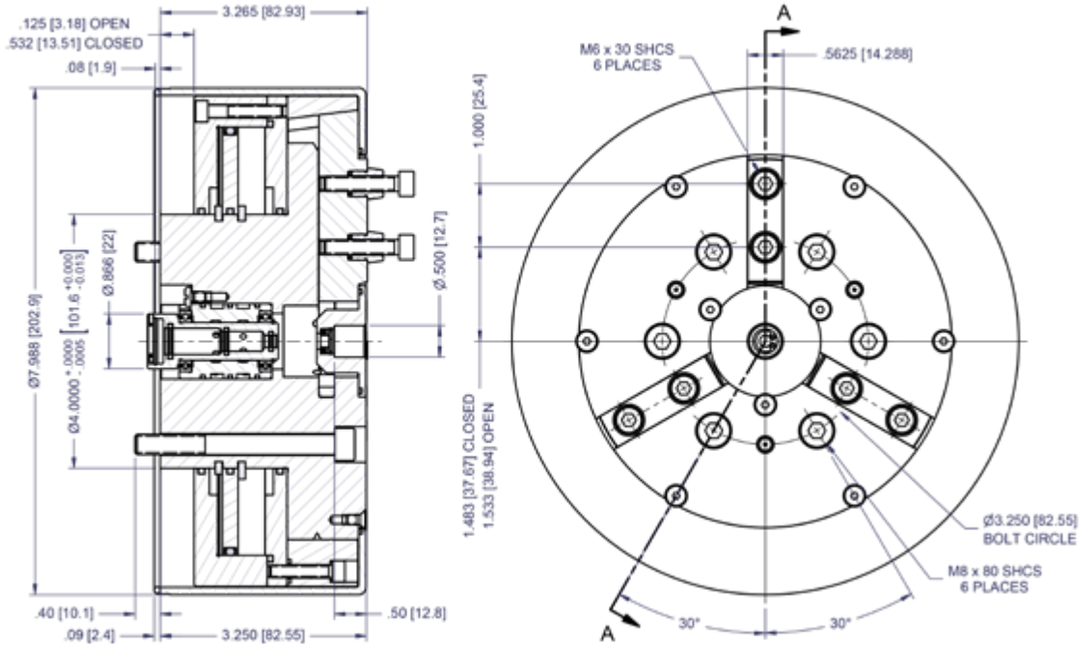
High Speed Air Chucks Drawings

Back to Content

HST6-3-HS Dimensions

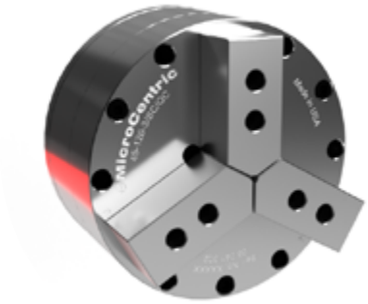


HST6-3-HS/QC Dimensions



Technical Data Sealed Air Chucks

Back to Content



Sealed air chucks feature a stainless steel cover that seals the jaw slides. This design prevents contamination from grit and swarf and minimizes chuck maintenance for high volume production operations. Sealed air chucks are available in rotating and stationary configurations and are ideal for cylindrical grinding operations as well as machining abrasive materials such as powdered metal, ceramic, or carbide.

QC precision located top jaw system is standard on Sealed Air Chucks.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Max Speed[3]	Chuck Weight[4]
3 inch / 80mm	SC/34-50-3/ QC	3	.00005" / 0.0012mm	.050" / 1.3mm	1,520 lb / 6.8 kN	100 psi / 0.7 Mpa	6,000 rpm	4.2 lb / 1.9 kg
4 inch / 100mm	SC/45-120-3/ QC	3	.00005" / 0.0012mm	.120" / 3.0mm	2,710 lb / 12.1 kN	100 psi / 0.7 Mpa	6,000 rpm	9.5 lb / 4.3 kg
6 inch / 150mm	SC/67-120-3/ QC	3	.00005" / 0.0012mm	.120" / 3.0mm	5,710 lb / 25.4 kN	100 psi / 0.7 Mpa	4,000 rpm	20.4 lb / 9.3 kg

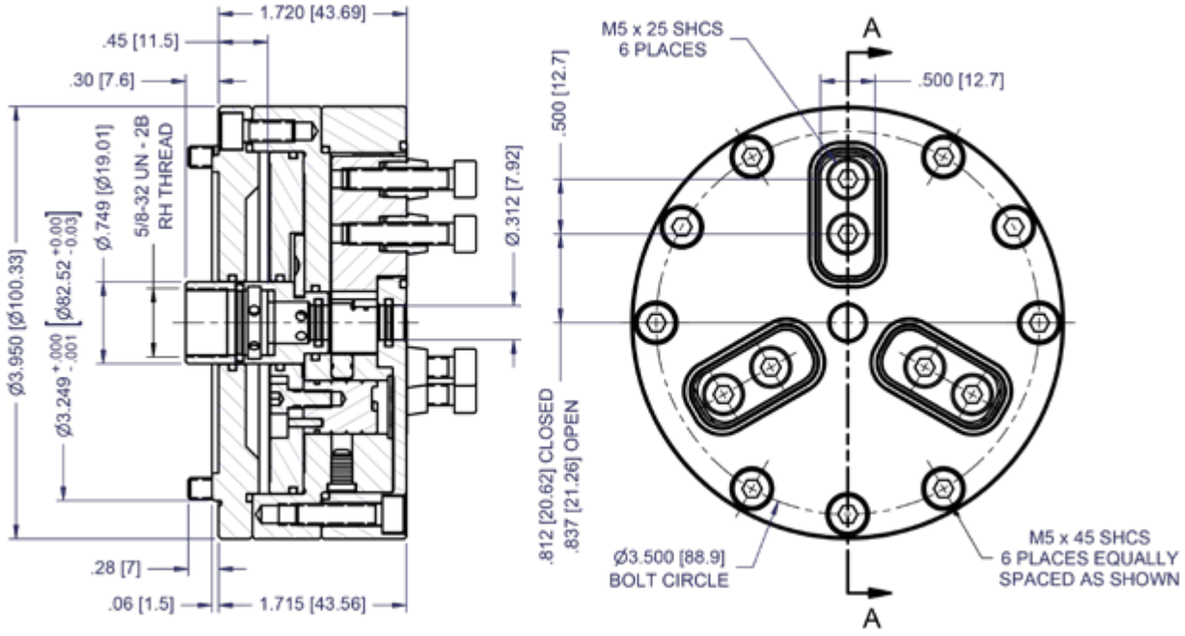
1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
3 Maximum rpm s influenced by air pressure and mass of top jaws
4 Without top jaws and spindle mounting plate

Drawings
PAGE 80

Top Jaws
PAGE 88

Back to Content

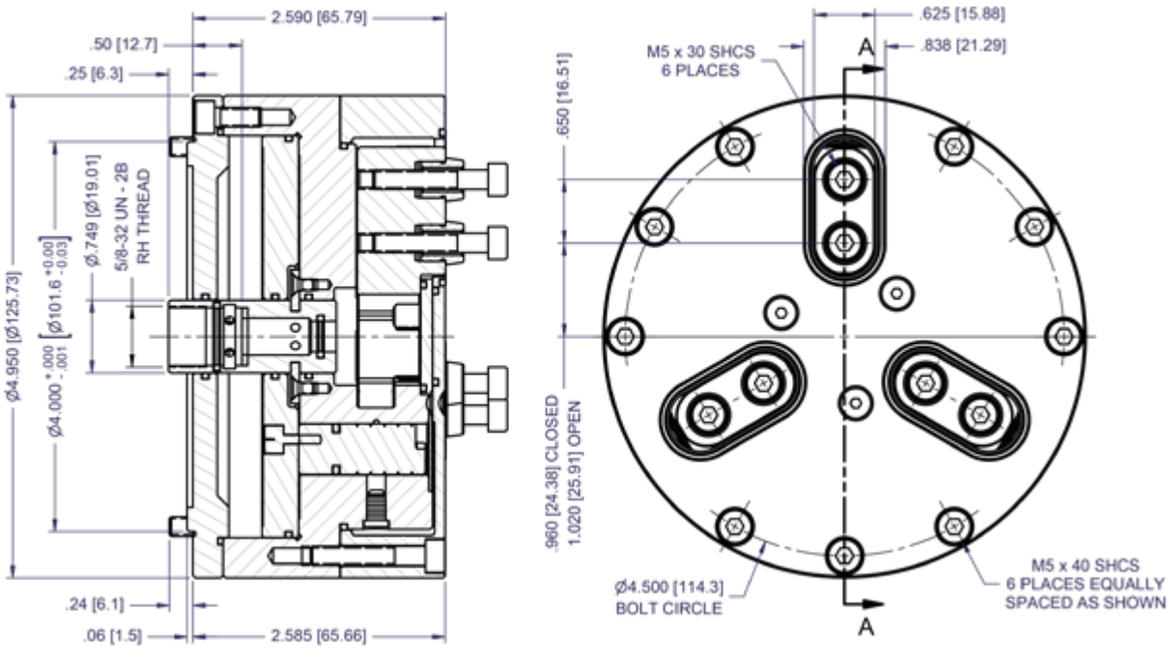
SC/ 34-50-3/QC Dimensions



Sealed Air Chucks Drawings

Back to Content

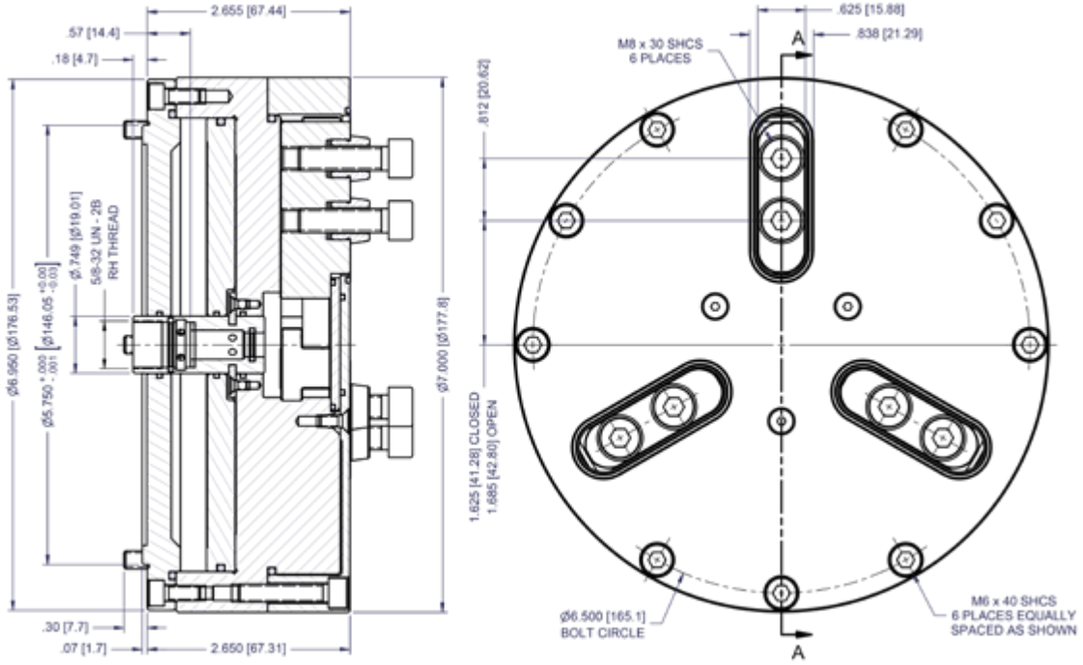
SC/ 45-120-3/QC Dimensions



Sealed Air Chucks Drawings

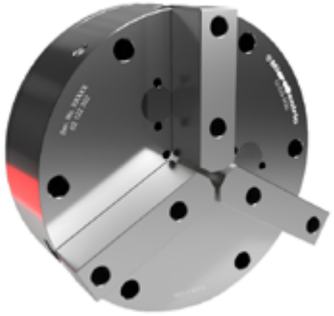
Back to Content

SC/ 67- 120-3/QC Dimensions



Technical Data Large Diameter Air Chucks

Back to Content



Large Diameter Air Chucks offer high accuracy and adjustable clamping force for machining large diameter precision and thin-walled workpieces. Large Diameter chucks are availalbe in three jaw as well as two and six jaw configurations. Large Diameter models with extended jaw stroke, air ports on OD of chuck body for stationary applications, and other special configurations are quoted upon request.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Maximum Air Pressure	Max Speed[3]	Chuck Weight[4]
12 inch / 300mm	12-220-3	3	.0002" / 0.005mm	.220" / 5.6mm	13,125 lb / 58.4 kN	100 psi / 0.7 Mpa	2,250 rpm	110 lb / 49.9 kg
	12-400-3			.400" / 10.2mm	11,250 lb / 50.1 kN		1,850 rpm	
14 inch / 350mm	14-400-3	3	.0002" / 0.005mm	.400" / 10.2mm	17,690 Lb / 78.7 kN	100 psi / 0.7 Mpa	1,850 rpm	156 lb / 70.8 kg
16 inch / 400mm	16-400-3	3	.0002" / 0.005mm	.400" / 10.2mm	20,160 lb / 89.7 kN	100 psi / 0.7 Mpa	1,500 rpm	257 lb / 116.6 kg

1 2 jaw configurations available for all air chuck sizes, 6 jaw configurations available on 10 inch / 250 mm models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" (25 mm) from the face of a standard top jaw
3 Maximum rpm s influenced by air pressure and mass of top jaws
4 Without top jaws and spindle mounting plate

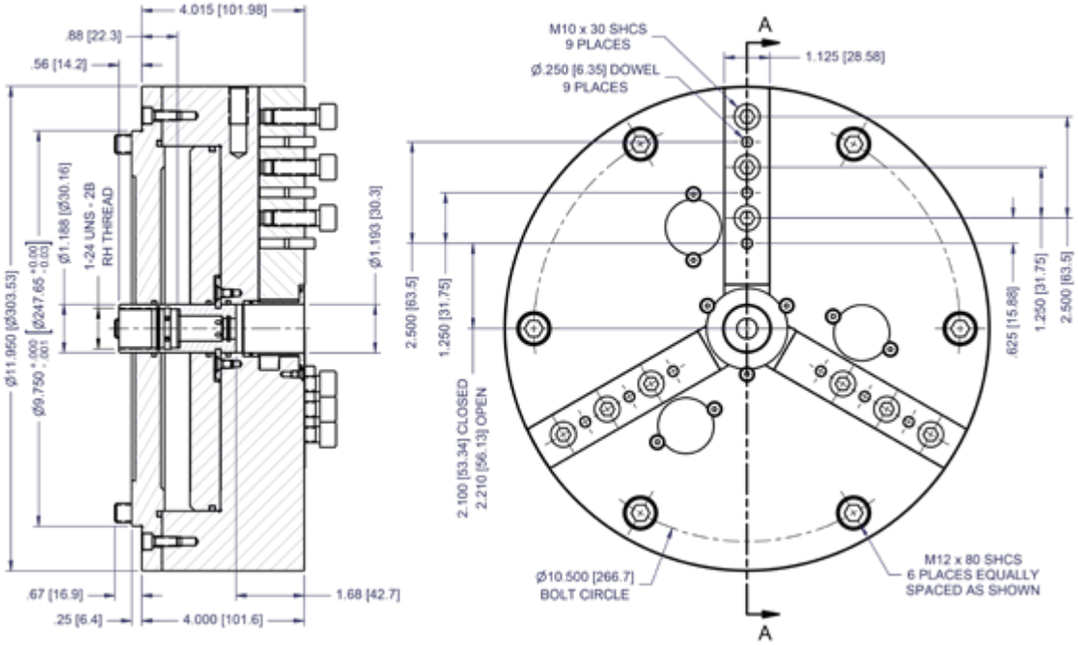
Drawings
PAGE 84

Top Jaws
PAGE 88

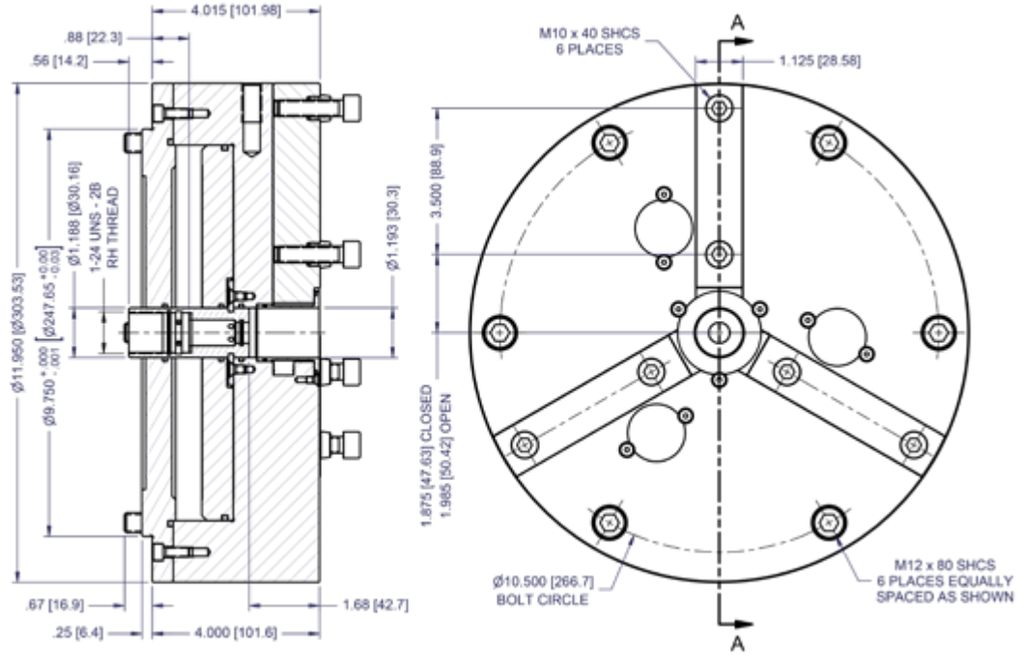
Large Diameter Air Chucks Drawings

Back to Content

12-220-3 Dimensions



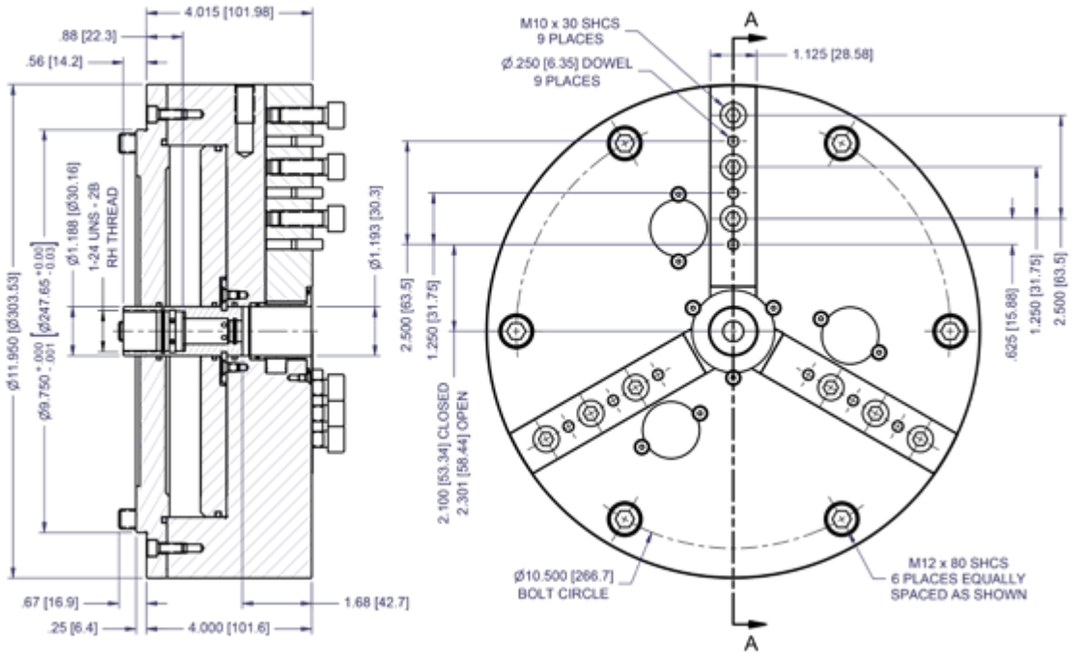
12-220-3/ QC Dimensions



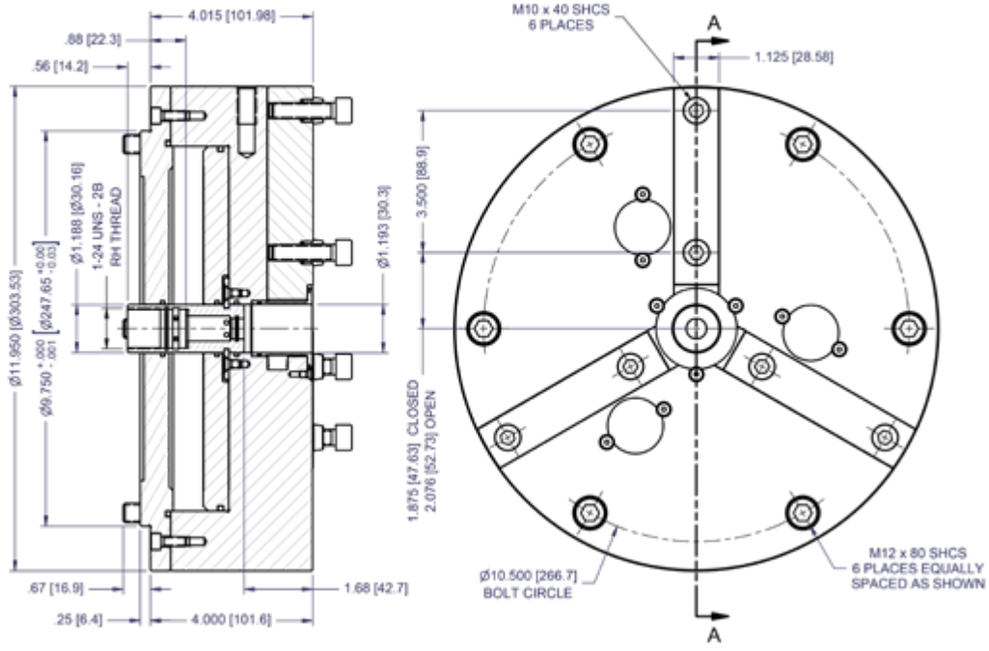
Large Diameter Air Chucks Drawings

Back to Content

12-400-3 Dimensions



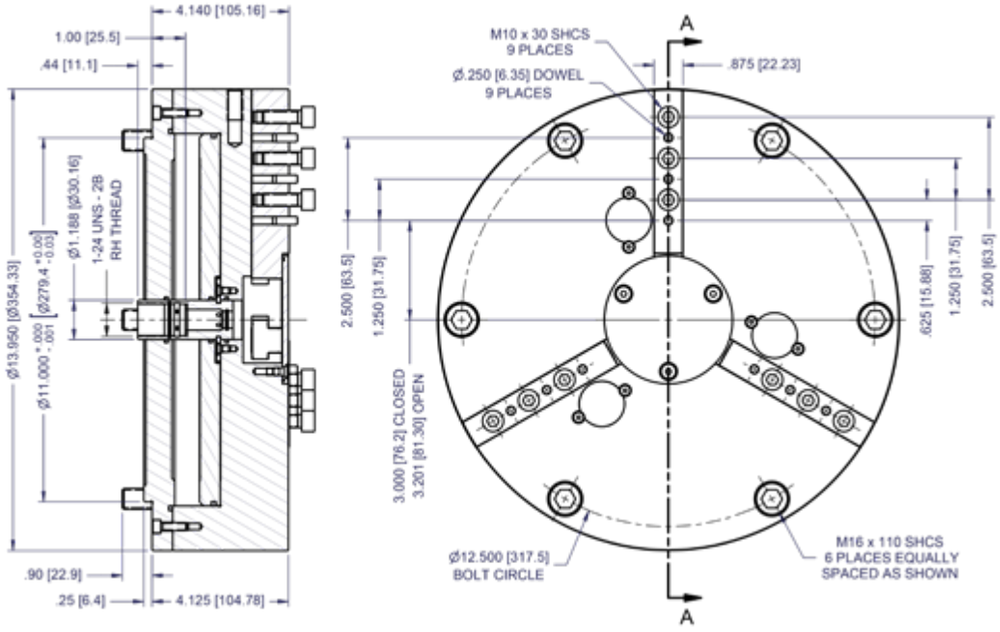
12-400-3/ QC Dimensions



Large Diameter Air Chucks Drawings

Back to Content

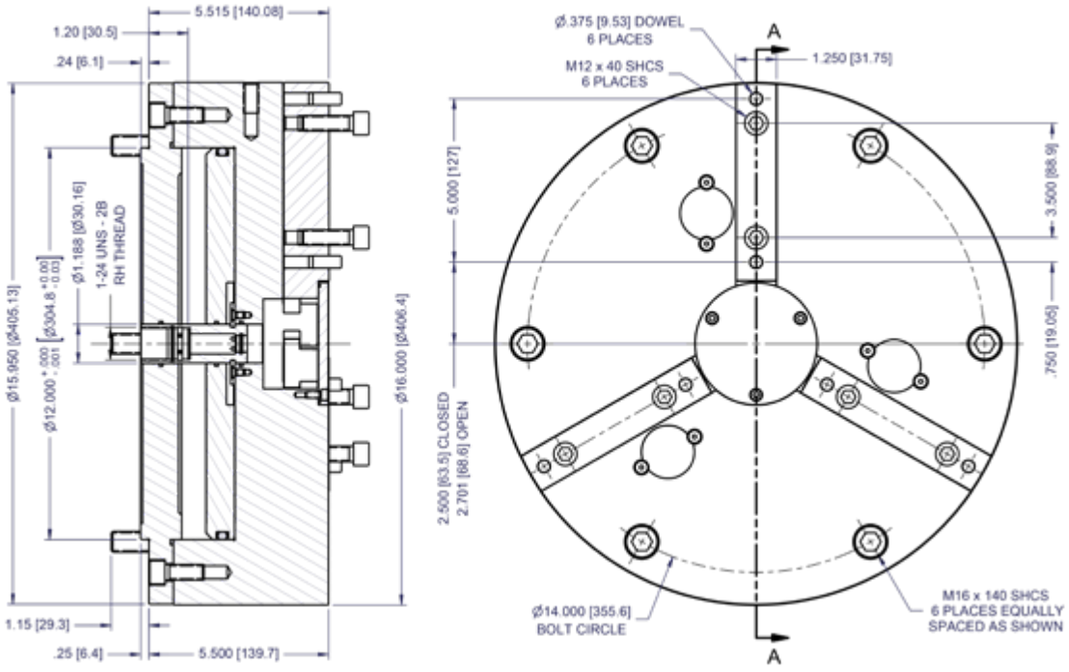
14-400-3 Dimensions



Large Diameter Air Chucks Drawings

Back to Content

16-400-3 Dimensions



Air Chuck Blank Top Jaws

Back to Content

Jaw Model	Material	A	B	C	Weight
Size 3 Inch					
3-100A	2024	.75" / 19.1mm	1.55" / 39.4mm	1.00" / 25.4mm	.1 lb / .05 kg
3-100S	1018			2.00" / 50.8mm	.3 lb / .13 kg
3-200S					.6 lb / .27 kg
Size HST 3 Inch					
V3-100A	2024	.75" / 19.1mm	1.52" / 38.6mm	1.00" / 25.4mm	.1 lb / .05 kg
V3-100S	1018				.3 lb / .13 kg
V3-150S				1.50" / 38.1mm	.4 lb / .18 kg
Size 4 Inch & HST 4 Inch					
4-100A	2024	.75" / 19.1mm	1.93" / 49.0mm	1.00" / 25.4mm	.1 lb / .05 kg
4-200A				2.00" / 50.8mm	.2 lb / .10 kg
4-100S	1018			1.00" / 25.4mm	.4 lb / .16 kg
4-150S				1.50" / 38.1mm	.5 lb / .24 kg
4-200S				2.00" / 50.8mm	.7 lb / .32 kg
Size 6 Inch & HST 6 Inch					
6-100A	2024	1.00" / 25.4mm	2.96" / 75.2mm	1.00" / 25.4mm	.3 lb / 14 kg
6-200A				2.00" / 50.8mm	.5 lb / 23 kg
6-300A				3.00" / 76.2mm	.7 lb / .34 kg
6-100S	1018			1.00" / 25.4mm	.7 lb / .32 kg
6-150S				1.50" / 38.1mm	1.1 lb / .5 kg
6-200S				2.00" / 50.8mm	1.5 lb / 68 kg
6-300S				3.00" / 76.2mm	2.2 lb / 1.0 kg
Size 8 Inch					
8-200A	2024	1.50" / 38.1mm	3.95" / 100.3mm	2.00" / 50.8mm	1.1 lb / .50 kg
8-300A				3.00" / 76.2mm	1.5 lb / .68 kg
8-200S	1018			2.00" / 50.8mm	2.9 lb/ 1.3 kg
8-300S				3.00" / 76.2mm	4.3 lb / 1.9 kg
Size 10 Inch					
10-200A	2024	1.50" / 38.1mm	4.95" / 125.7mm	2.00" / 50.8mm	1.2 lb / .55 kg
10-300A				3.00" / 76.2mm	1.8 lb / .82 kg
10-200S	1018			2.00" / 50.8mm	3.6 lb / 1.6 kg
10-300S				3.00" / 76.2mm	5.3 lb / 2.4 kg
Size 12 Inch					
12-200A	2024	1.50" / 38.1mm	5.72" / 145.3mm	2.00" / 50.8mm	1.5 lb / .68 kg
12-200S	1018			2.00" / 50.8mm	4.3 lb / 1.9 kg
12-300S				3.00" / 76.2mm	6.4 lb / 2.9 kg

Air Chuck Blank Pie Top Jaws

Back to Content

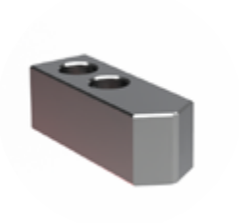
Jaw Model	Material	A	B	C	Weight
Size 3 Inch					
3-101A	2024	3.18" / 80.6mm	1.00" / 25.4mm	.62" / 15.1mm	.6 lb / .27 kg
3-101S	8620				1.8 lb / .82 kg
Size HST 3 Inch					
V3-101A	2024	3.05" / 77.5mm	1.00" / 25.4mm	.62" / 15.1mm	.5 lb / .23 kg
V3-101S	8620				1.6 lb / .73 kg
Size 4 Inch & HST 4 Inch					
4-101A	2024	3.95" / 100.3mm	1.00" / 25.4mm	.62" / 15.1mm	1.0 lb / .45 kg
4-201A			2.00" / 50.8mm		2.0 lb / .9 kg
4-101S	8620		1.00" / 25.4mm		2.9 lb / 1.3 kg
4-151S			1.50" / 38.1mm		4.3 lb / 2.0 kg
Size 6 Inch & HST 6 Inch					
6-101A	2024	5.95" / 151.1mm	1.00" / 25.4mm	.88" / 22.4mm	2.4 lb / 1.1 kg
6-201A			2.00" / 50.8mm		4.8 lb / 2.2 kg
6-101S	8620		1.00" / 25.4mm		7.0 lb / 3.2 kg
6-151S			1.50" / 38.1mm		10.4 lb / 4.7 kg
6-201S			2.00" / 50.8mm		13.9 lb / 6.3 kg
Size 8 Inch					
8-201A	2024	7.95" / 201.9mm	2.00" / 50.8mm	1.25" / 31.8mm	8.8 lb / 4.0 kg
8-201S	8620				25.2 lb / 11.5 kg
Size 10 Inch					
10-201A	2024	9.95" / 252.7mm	2.00" / 50.8mm	1.25" / 31.8mm	14.1 lb / 6.4 kg
10-201S	8620				40.9 lb / 18.6 kg

Jaw Turning Fixture

Chuck	Fixture Model	Outside dia.	Thickness
3 inch	JTF-3	3.25" / 82.5mm	.50" / 12.7mm
HST3	JTF-3V	3.25" / 82.5mm	1.20" / 30.5mm
4 inch	JTF-4	4.25" / 108mm	1.00" / 25.4mm
6 inch	JTF-6	6.25" / 158.8mm	1.00" / 25.4mm
8 inch	JTF-8	8.50" / 216mm	1.25 / 31.7mm
10 inch	JTF-10	10.00" / 254mm	1.75" / 44.5mm

Air Chuck Blank QC Top Jaws

Back to Content



Jaw Model	Material	A	B	C	Weight
Size 4 Inch					
Q4-100S	A-2	.75" / 19.0mm	1.93" / 49.0mm	1.00" / 25.4mm	.4 lb / .18 kg
Q4-150S				1.50" / 38.1mm	.5 lb / .22 kg
Q4-200S				2.00" / 50.8mm	.7 lb / .31 kg
Size 6 Inch					
Q6-100S	A-2	1.00" / 25.4mm	2.96" / 74.4mm	1.00" / 25.4mm	.7 lb / .31 kg
Q6-150S				1.50" / 38.1mm	1.0 lb / .45 kg
Q6-200S				2.00" / 50.8mm	1.4 lb / .63 kg
Q6-300S				3.00" / 76.2mm	2.1 lb / .95 kg
Size 8 Inch					
Q8-200S	A-2	1.50" / 38.1mm	3.95" / 100.3mm	2.00" / 50.8mm	2.9 lb / 1.3 kg
Q8-300S				3.00" / 76.2mm	4.3 lb / 1.9 kg
Size 10 Inch					
Q10-200S	A-2	1.50" / 38.1mm	4.95" / 125.7mm	2.00" / 50.8mm	3.7 lb / 1.7 kg
Q10-300S				3.00" / 76.2mm	5.6 lb / 2.5 kg

Jaw Turning Fixture

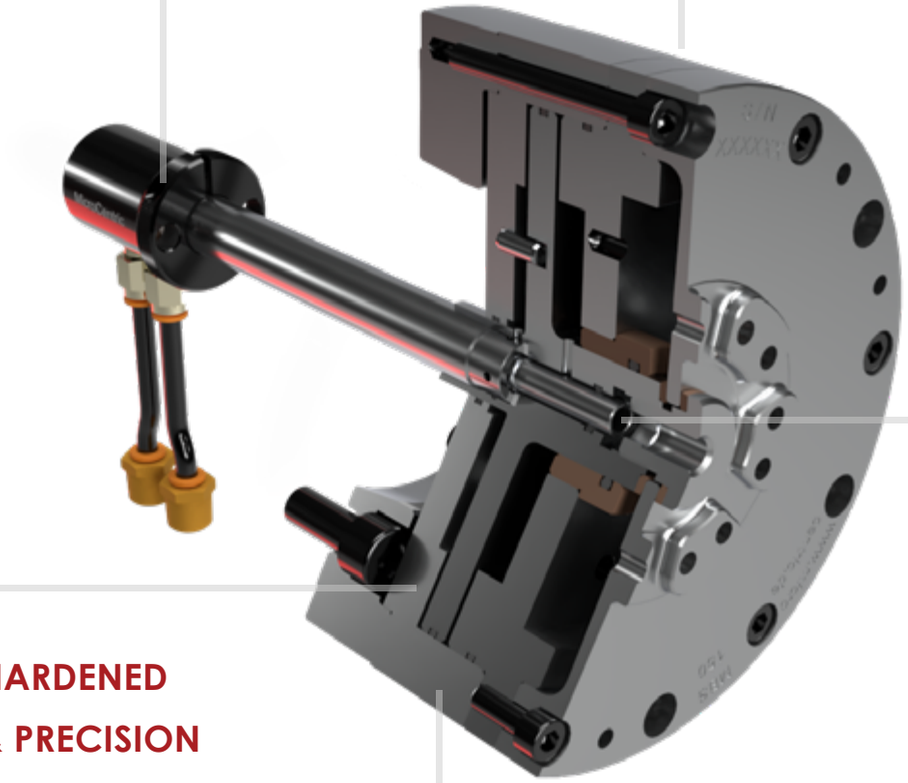
Chuck	Fixture Model	Outside dia.	Thickness
4 inch	QC/JTF-4	4.125" / 104.8mm	1.281" / 32.5mm
6 inch	QC/JTF-6	6.50" / 165.1mm	1.125" / 28.6mm
8 inch	QC/JTF-8	7.95" / 201.9mm	1.25" / 31.7mm
10 inch	QC/JTF-10	9.95" / 252.7mm	1.25" / 31.7mm

Diaphgram Chucks

Back to Content

AIR TUBE ASSEMBLY WITH ROTARY JOURNAL

AIR CYLINDER WITH BUILT-IN PISTON



COOLANT THROUGH DESIGN

HARDENED & PRECISION GROUND ALLOY STEEL SPINDLE ADAPTER PLATE

HARDENED & PRECISION GROUND ALLOY STEEL CHUCK BODY

Diaphragm Chucks

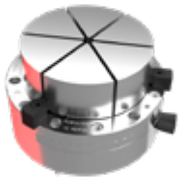
Back to Content

MBS- L

Sizes
3.19 -11.57"

MBS-L: Rotating Self-Contained

Self-contained design with built-in air cylinder for rotating applications. Actuated by an air tube assembly with rotary union through machine spindle.



MBS- N

Sizes
3.19 -11.57"

MBS-N: Stationary Self-Contained

Self-contained design with built-in air cylinder for stationary applications. Air is supplied through ports on OD of chuck body or back cover.

MBS- Z

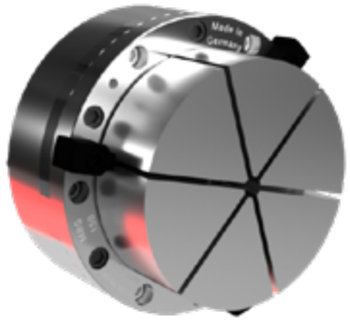
Sizes
3.19 -11.57"

MBS-Z: Draw Tube Actuated

Actuated by an external hydraulic or pneumatic cylinder mounted to the rear of the machine spindle. Modular design that includes a spindle mounting plate and draw tube adapter.

Technical Data MBS- L Chucks

Back to Content



Design

Self-contained design with built-in air cylinder. Air is supplied to the chuck by a multi passage air tube assembly with a rotary coupling. Coolant through the spindle capability is standard.

Application

OD and ID chucking for cylindrical grinding, turning, and hard turning. Ideal for workpieces requiring high concentricity, and/or close round ness. Ideal for fragile parts which are easily distorted, and applications requiring high spindle speeds.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Max Air Pressure	Max Speed[3]	Chuck Weight[4]
3.19 in/ 80 mm	MBS/L-80	6	.0001 in/ .0025 mm	.060 in/ 1.5 mm	510 lbf/ 232 kgf	100 psi/ .69 Mpa	8,000 rpm	3.3 lb/ 1.5 kg
4.02 in/ 102 mm	MBS/L-100				1,560 lbf/ 709 kgf		7,000 rpm	6.5 lb/ 3.0 kg
5.00 in/ 127 mm	MBS/L-125				3,640 lbf/ 1,655 kgf		6,500 rpm	10.4 lb/ 4.7 kg
5.98 in/ 152 mm	MBS/L-150				6,090 lbf/ 2,768 kgf		6,000 rpm	14.3 lb/ 6.5 kg
8.03 in/ 204 mm	MBS/L-200				10,950 lbf/ 4,977 kgf		4,500 rpm	29.1 lb/ 13.2 kg
10.00 in/ 254 mm	MBS/L-250			.080 in/ 2 mm	17,090 lbf/ 7,768 kgf		3,500 rpm	64.5 lb/ 29.3 kg
11.57 in/ 294 mm	MBS/L-300				27,470 lbf/ 12,486 kgf		3,000 rpm	96.1 lb/ 43.7 kg

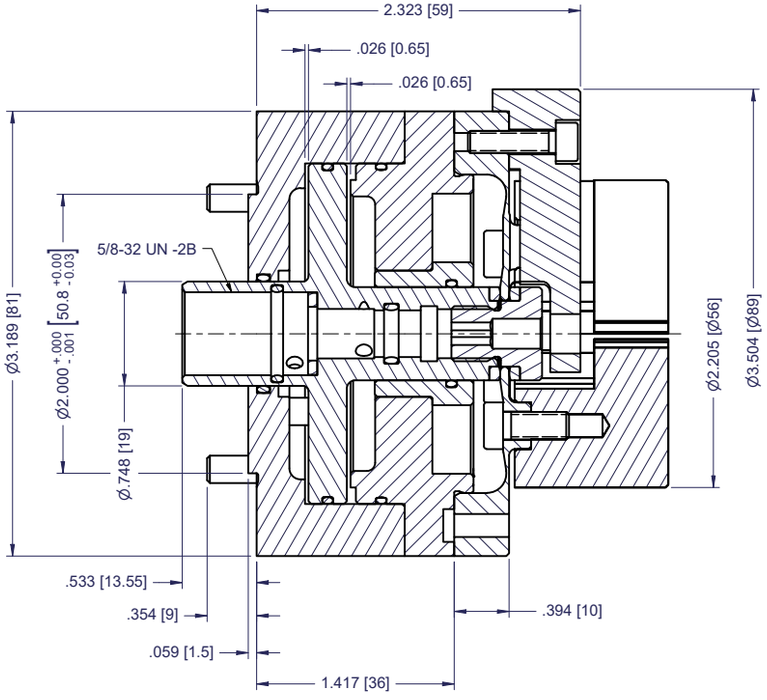
1 6 jaws is standard. 2 to 6 jaw configurations available for all models.
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Max. rpm is influenced by input pressure and mass of top jaws.
4 Weight of chuck body and diaphragm

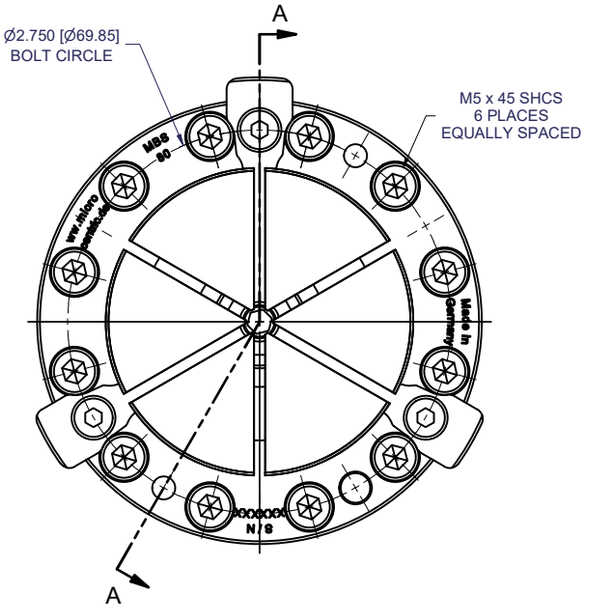
Drawings
PAGE 95

MBS- L Chucks Drawings

Back to Content

MBS/L-80 Dimensions

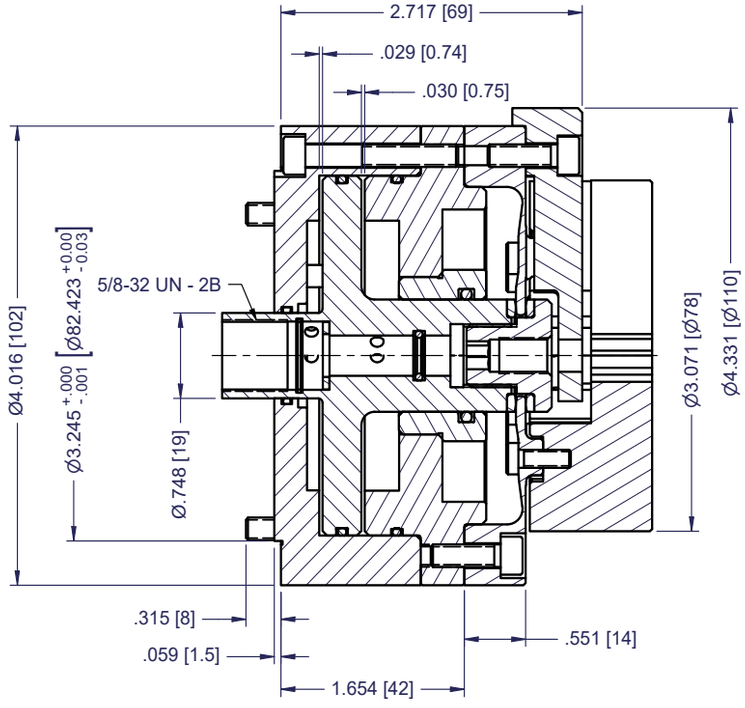


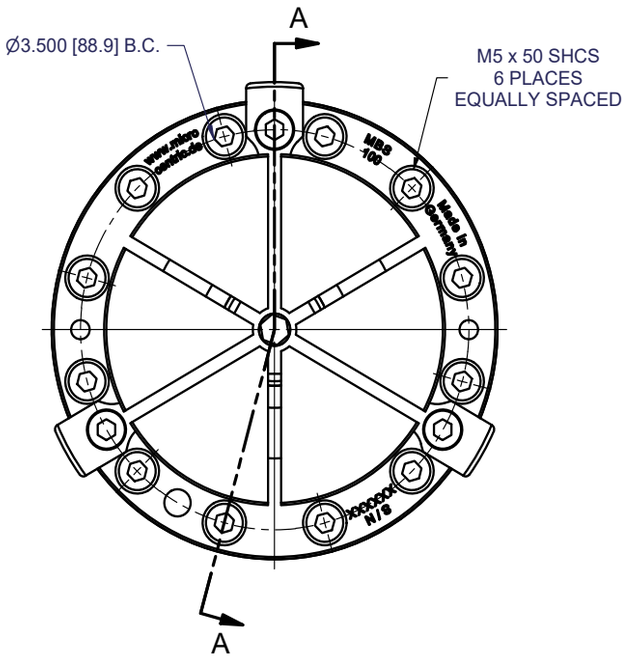


MBS- L Chucks Drawings

Back to Content

MBS/L-100 Dimensions

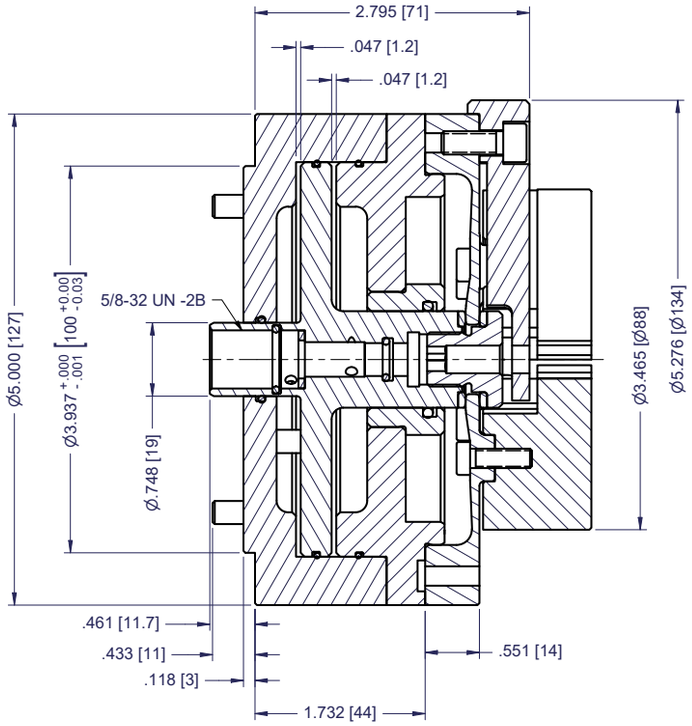


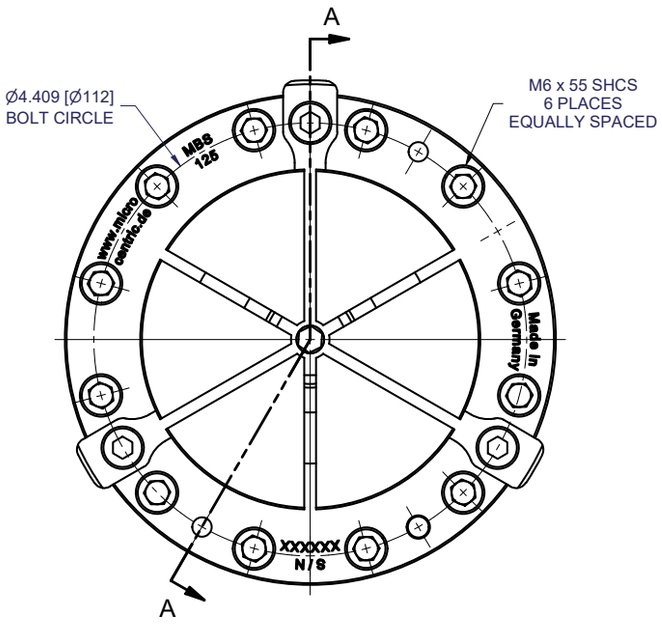


MBS- L Chucks Drawings

Back to Content

MBS/L-125 Dimensions

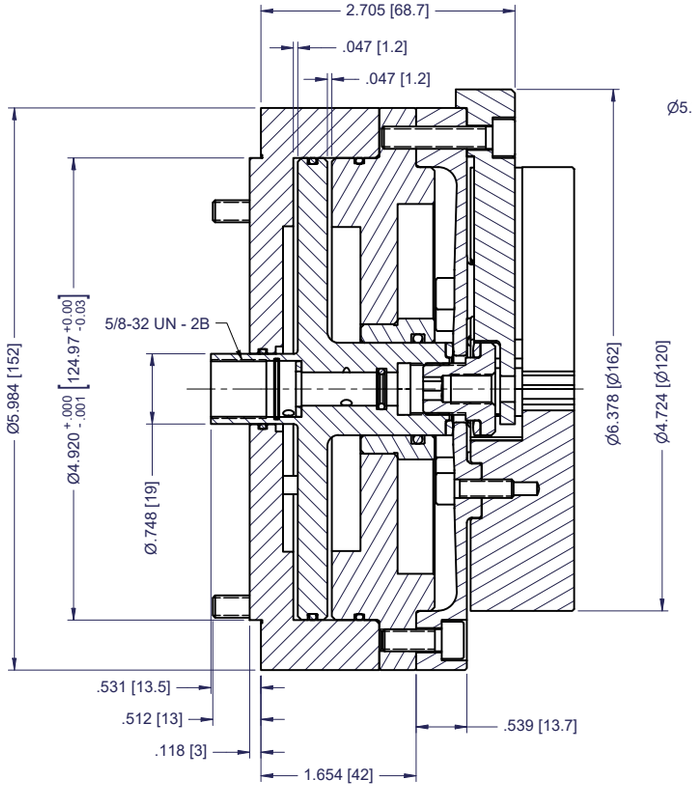


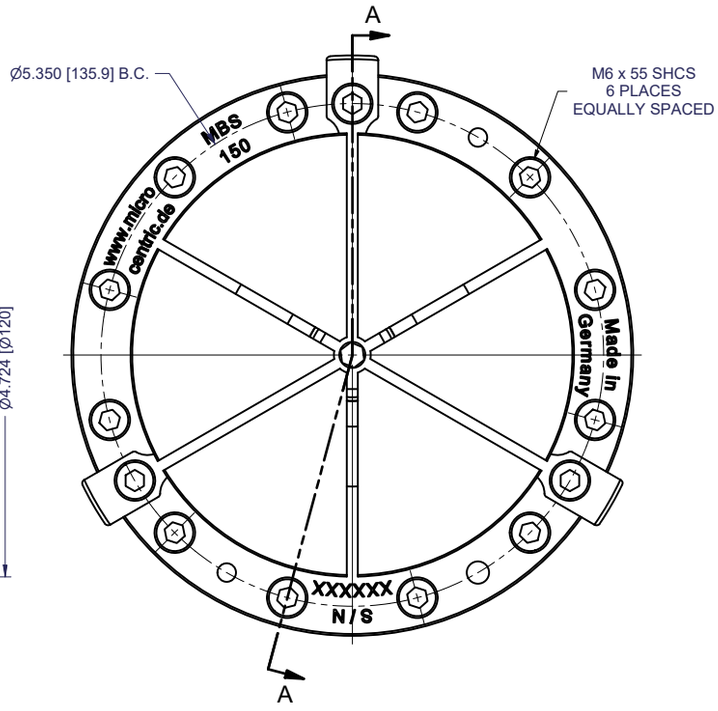


MBS- L Chucks Drawings

Back to Content

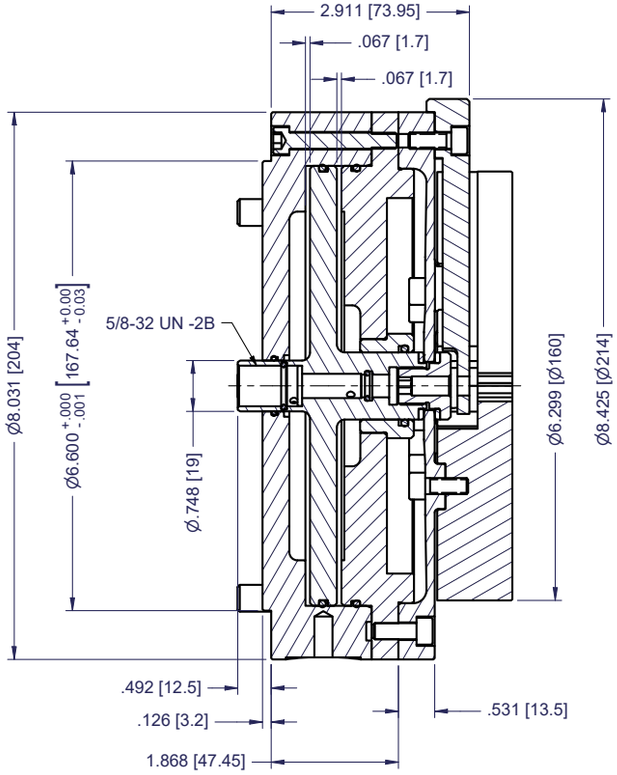
MBS/L-150 Dimensions

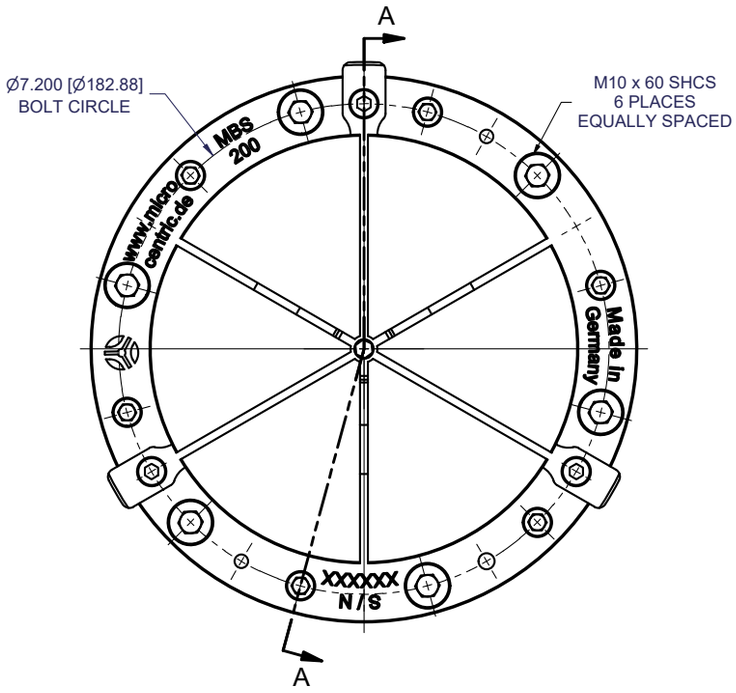




Back to Content

MBS/L-200 Dimensions

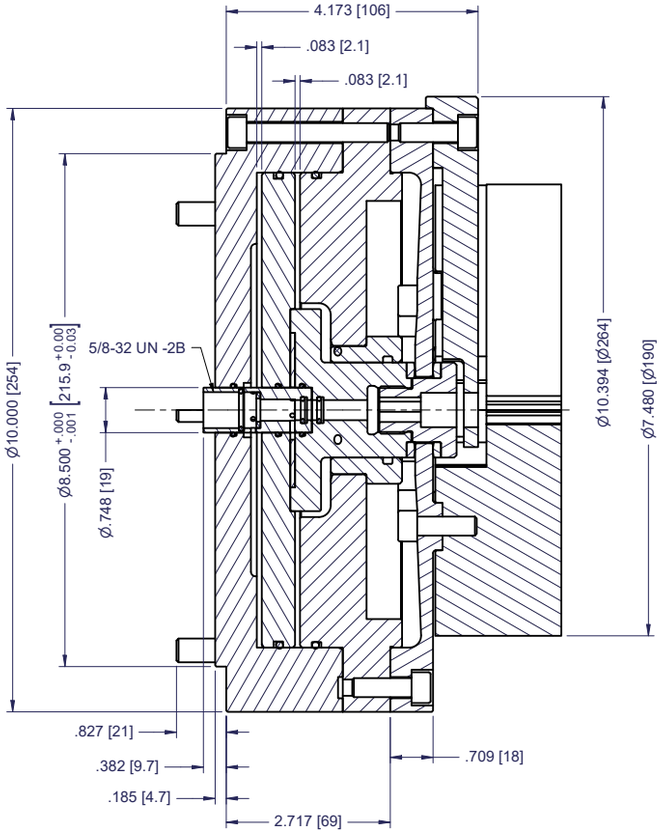


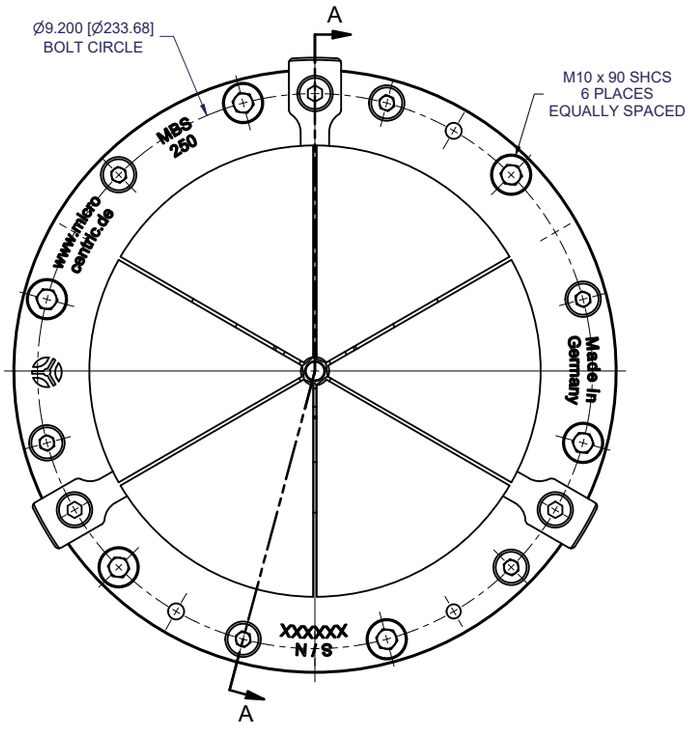


MBS- L Chucks Drawings

Back to Content

MBS/L-250 Dimensions

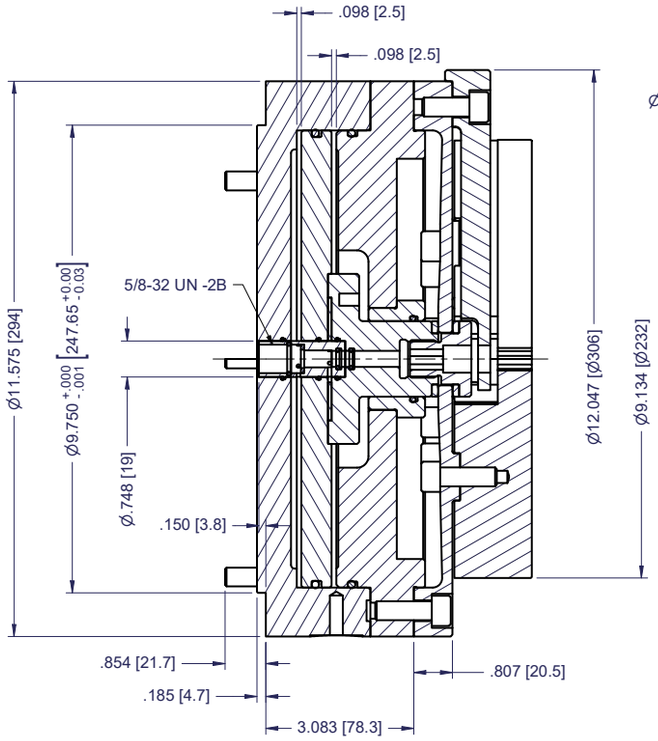


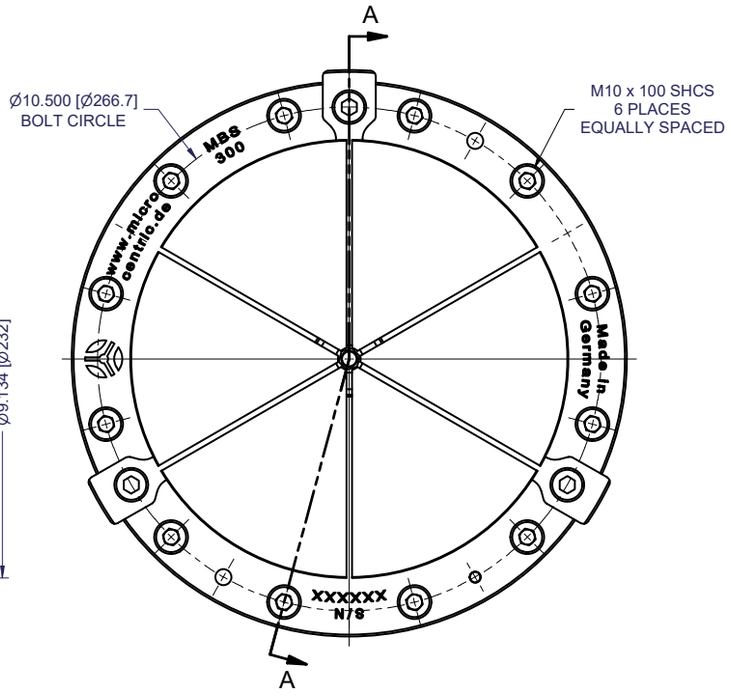


MBS- L Chucks Drawings

Back to Content

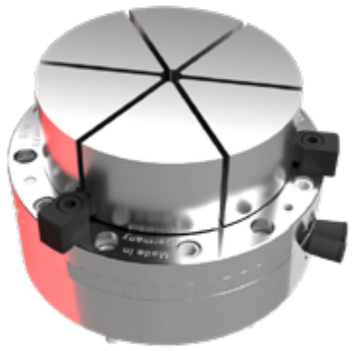
MBS/L-300 Dimensions





Technical Data MBS- N Chucks

Back to Content



Design

Self-contained design with built-in air cylinder. Air ports are located on the side of the chuck body for stationary use.

Application

OD and ID chucking for milling, drilling, inspection, or any other non- rotating application requiring high concentricity and/or close workpiece roundness. The inherent spring characteristic of the diaphragm allows workpieces to be clamped without continuous air supply for pallet and tombstone applications.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Max Air Pressure	Chuck Weight[3]
3.19 in/ 80 mm	MBS/N-80	6	.0001 in/ .0025 mm	.060 in/ 1.5 mm	510 lbf/ 232 kgf	100 psi/ .69 Mpa	3.3 lb/ 1.5 kg
4.02 in/ 102 mm	MBS/N-100				1,560 lbf/ 709 kgf		6.5 lb/ 3.0 kg
5.00 in/ 127 mm	MBS/N-125				3,640 lbf/ 1,655 kgf		10.4 lb/ 4.7 kg
5.98 in/ 152 mm	MBS/N-150				6,090 lbf/ 2,768 kgf		14.3 lb/ 6.5 kg
8.03 in/ 204 mm	MBS/N-200			.080 in/ 2 mm	10,950 lbf/ 4,977 kgf		29.1 lb/ 13.2 kg
10.00 in/ 254 mm	MBS/N-250				17,090 lbf/ 7,768 kgf		64.5 lb/ 29.3 kg
11.57 in/ 294 mm	MBS/N-300				27,470 lbf/ 12,486 kgf		96.1 lb/ 43.7 kg

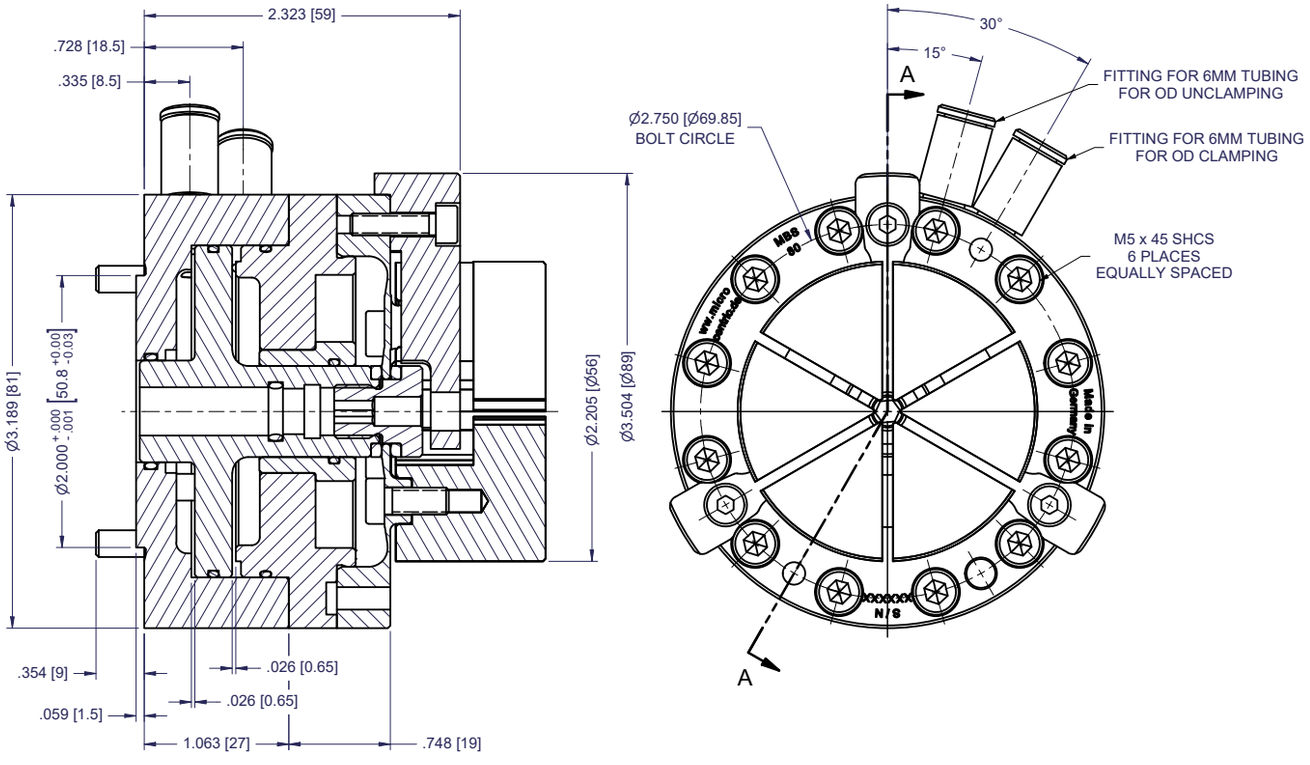
1 6 jaws is standard. 2 to 6 jaw configurations available for all models
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Weight of chuck body and diaphragm

Drawings
PAGE 103

MBS- N Chucks Drawings

Back to Content

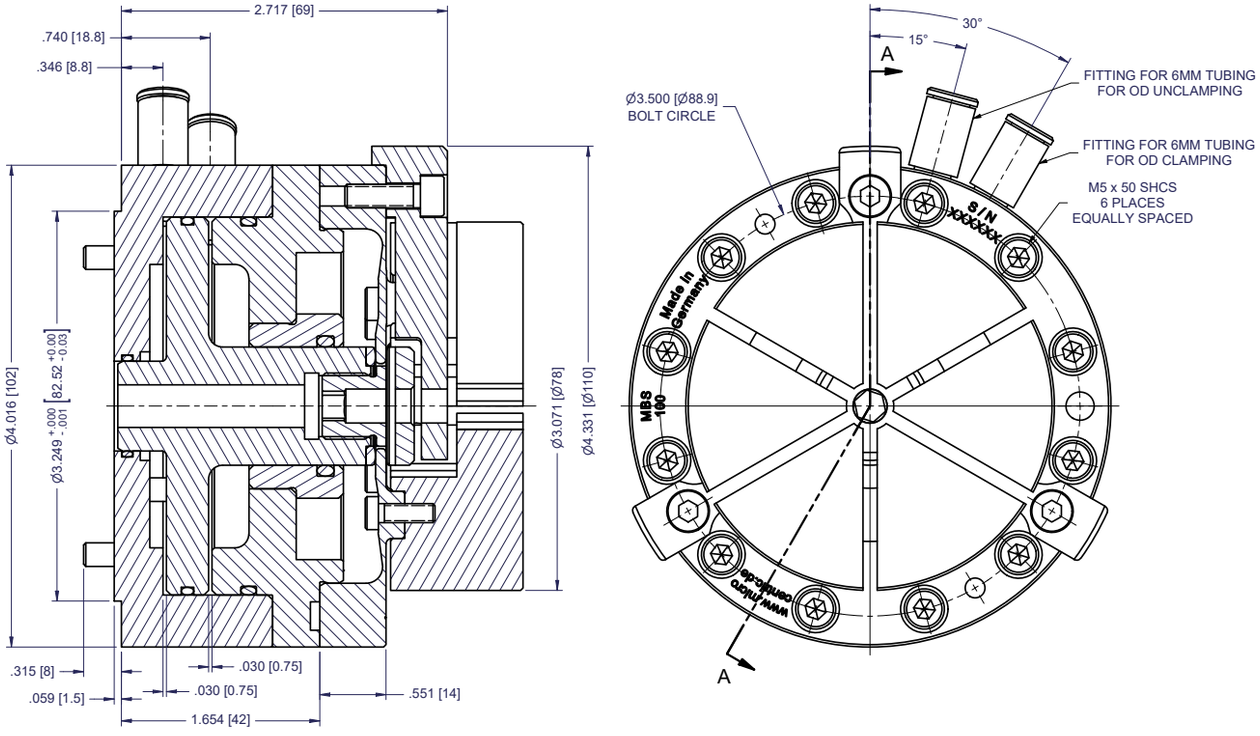
MBS/N-80 Dimensions



MBS- N Chucks Drawings

Back to Content

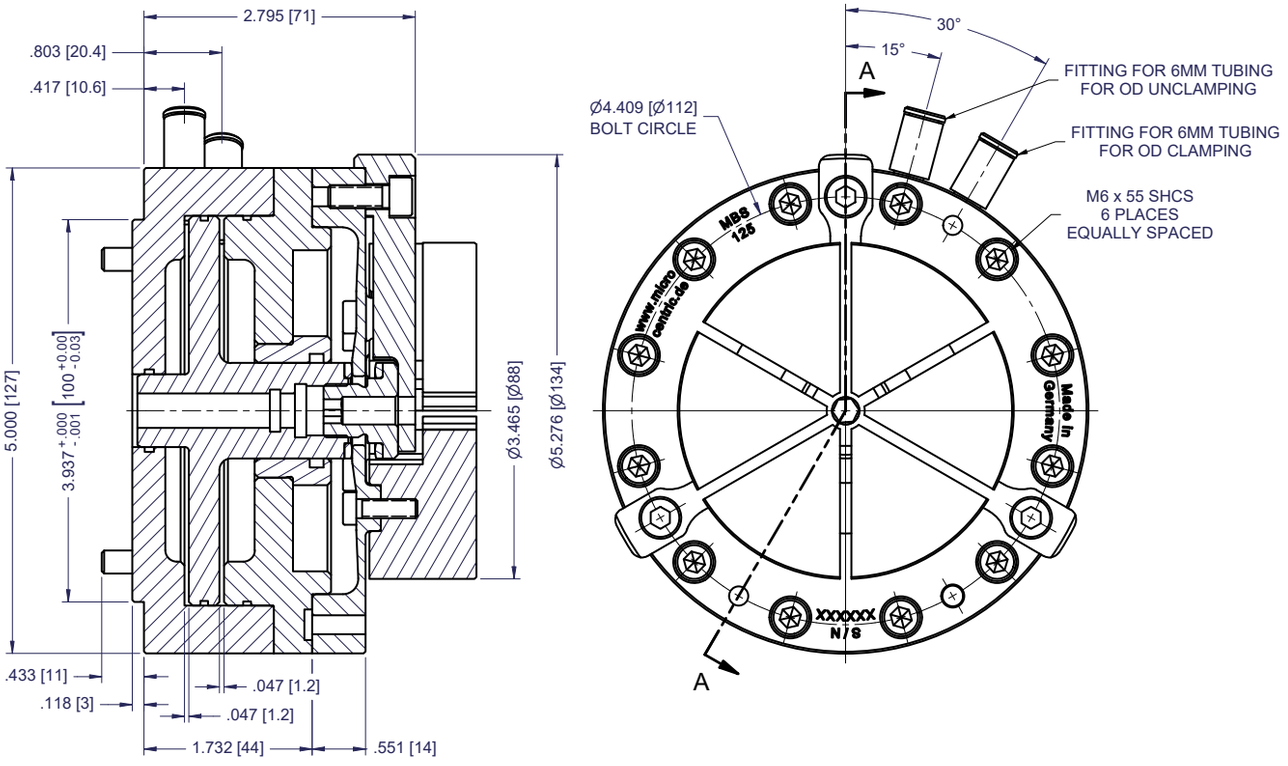
MBS/N-100 Dimensions



MBS- N Chucks Drawings

Back to Content

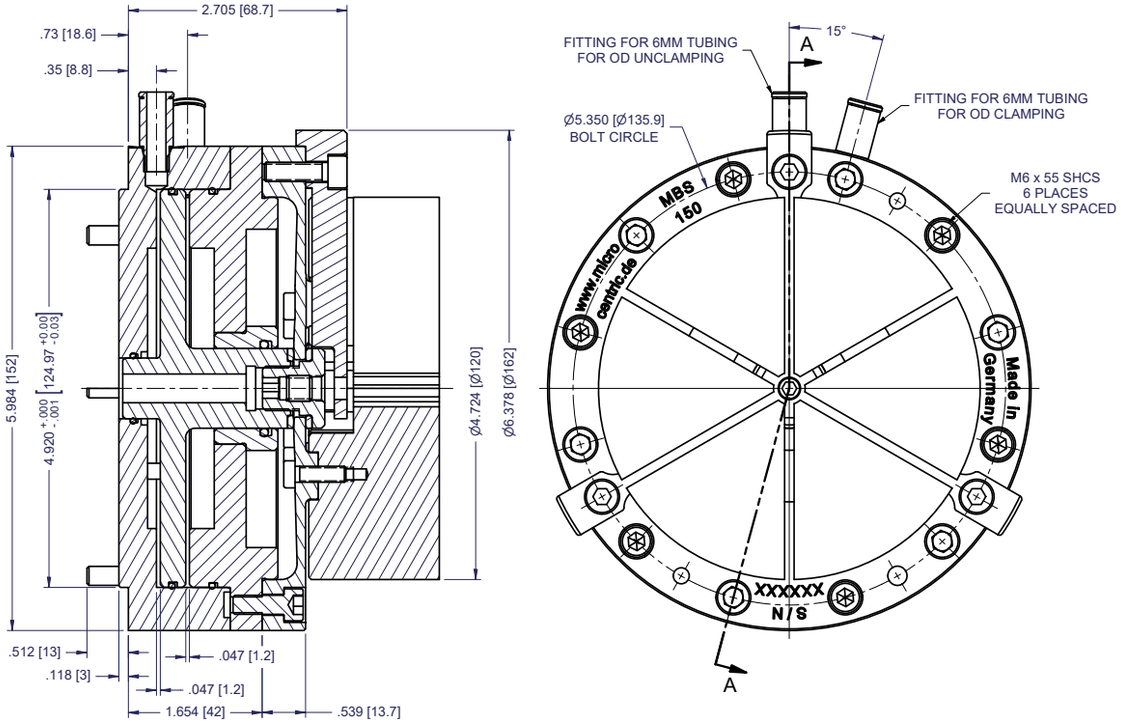
MBS/N-125 Dimensions



MBS- N Chucks Drawings

Back to Content

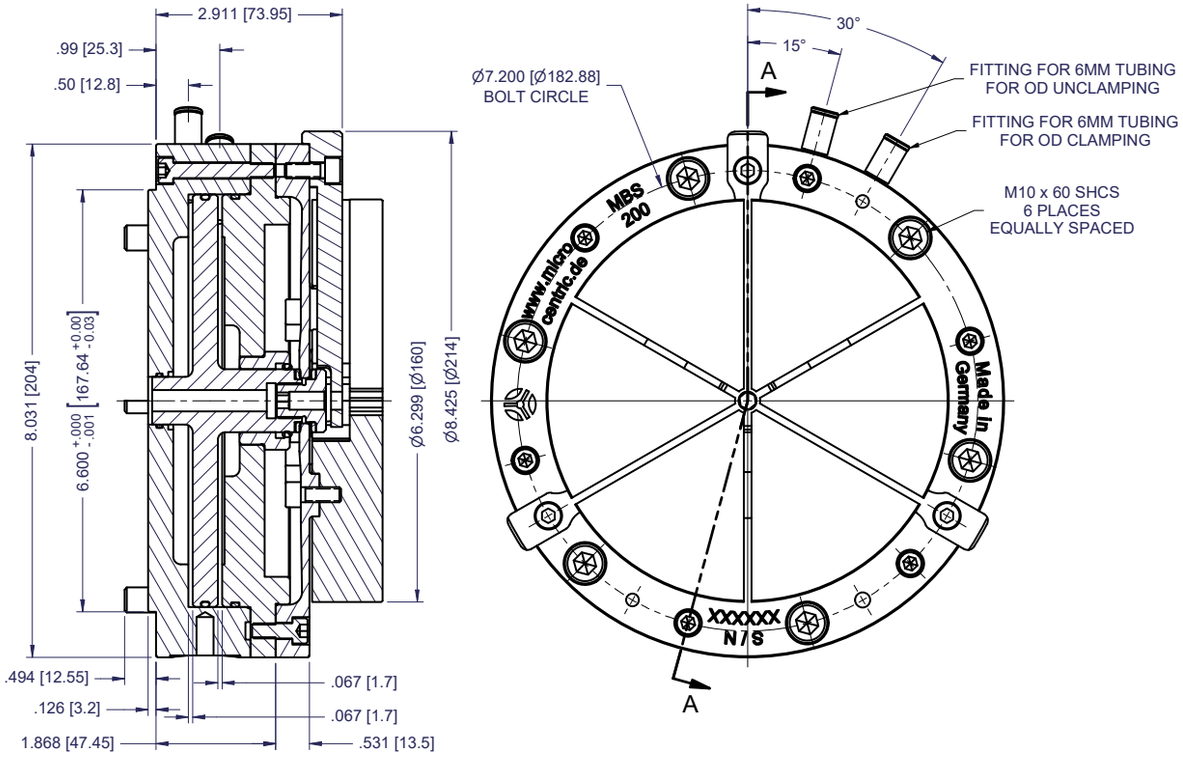
MBS/N-150 Dimensions



MBS- N Chucks Drawings

Back to Content

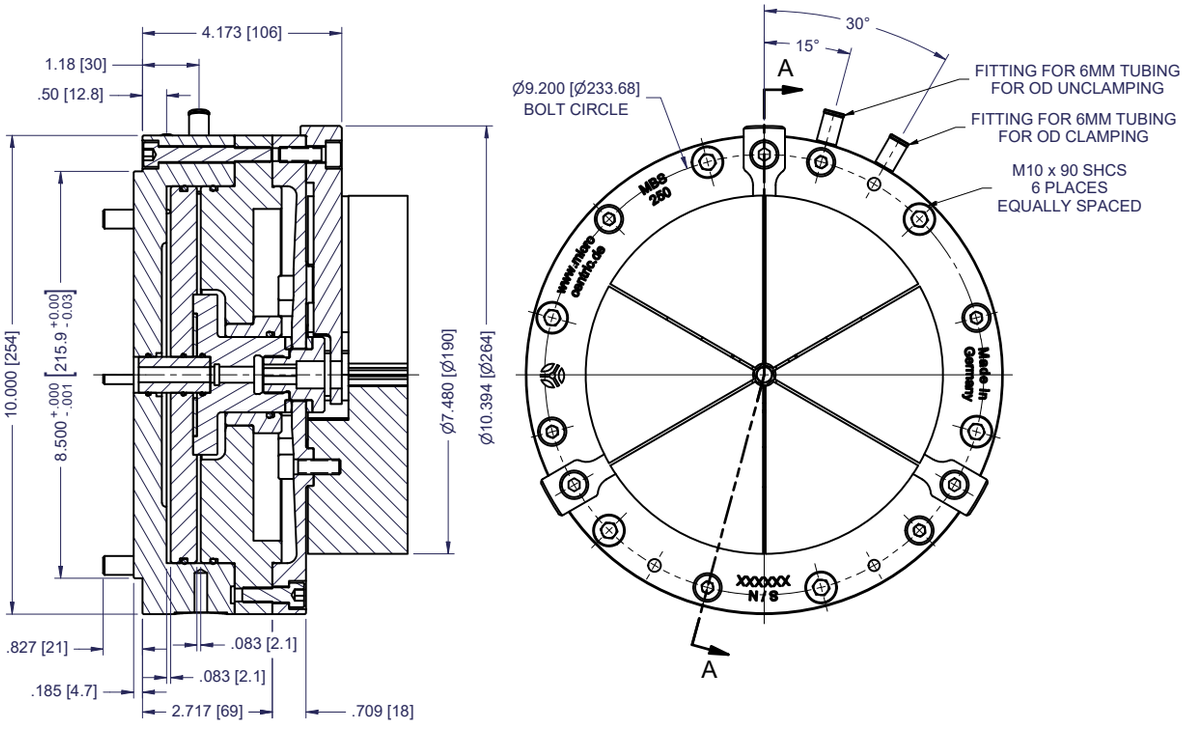
MBS/N-200 Dimensions



MBS- N Chucks Drawings

Back to Content

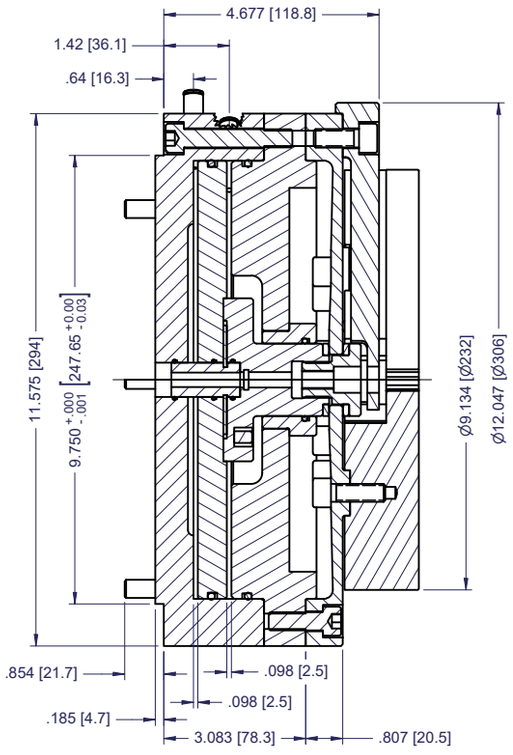
MBS/N-250 Dimensions

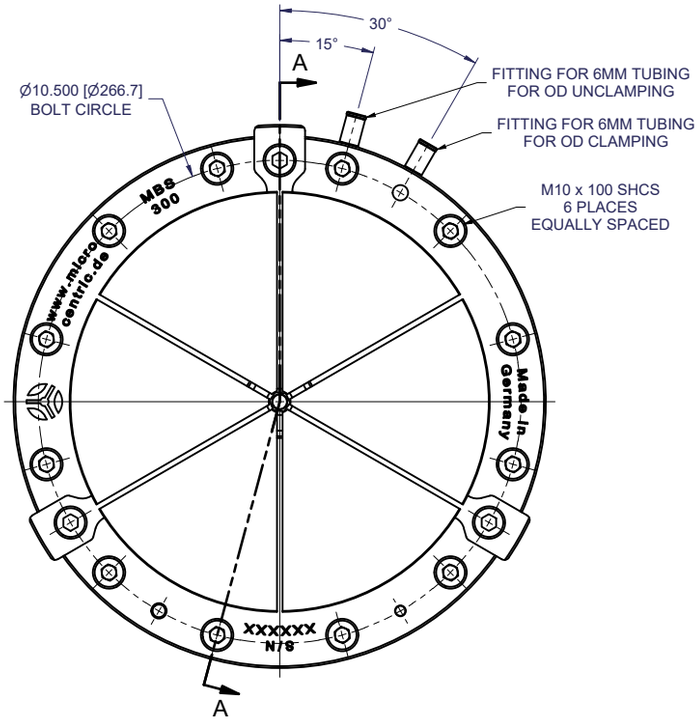


MBS- N Chucks Drawings

Back to Content

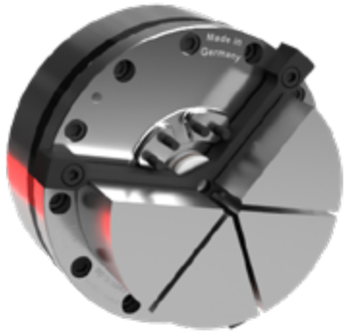
MBS/N-300 Dimensions





Technical Data MBS- Z Chucks

Back to Content



Design

Draw tube operated design. Can be actuated with either a hydraulic or pneumatic cylinder mounted at the rear of the machine spindle.

Application

OD and ID chucking for cylindrical grinding, turning, and hard turning. Ideal for workpieces requiring high concentricity, and applications requiring high chucking force and/or high spindle speeds.

Chuck Size	Chuck Model	No. of Jaws[1]	Repeating Accuracy[2]	Jaw Stroke (on Diameter)	Max Clamping Force	Max Speed[3]	Chuck Weight[4]
4.02 in/ 102 mm	MBS/Z-100	6	.0001 in/ .0025 mm	.060 in/ 1.5 mm	8,655 lbf/ 2,940 kgf	7,000 rpm	6.9 lb/ 3.1 kg
5.00 in/ 127 mm	MBS/Z-125				11,420 lbf/ 5,190 kgf	6,500 rpm	10.6 lb/ 4.8 kg
5.98 in/ 152 mm	MBS/Z-150				12,210 lbf/ 5,550 kgf	6,000 rpm	14.5 lb/ 6.6 kg
8.03 in/ 204 mm	MBS/Z-200			.080 in/ 2 mm	15,595 lbf/ 7,090 kgf	4,500 rpm	28.7 lb/ 13.0 kg
10.00 in/ 254 mm	MBS/Z-250				38,075 lbf/ 17,300 kgf	4,000 rpm	60.9 lb/ 27.7 kg
11.57 in/ 294 mm	MBS/Z-300				43,110 lbf/ 19,600 kgf	3,500 rpm	109.4 lb/ 49.7 kg

1 6 jaws is standard. 2 to 6 jaw configurations available for all models.
2 Chuck accuracy is defined as the total indicator reading (maximum radial and lateral runout) of a master gage measured 1.0" / 25 mm from the face of a standard top jaw
3 Max. rpm is influenced by input pressure and mass of top jaws.
4 Weight of chuck body and diaphragm

Please Note: MBS-Z Chucks are a highly specalised product that needs to be fitted onto each machine individually. Therefore there are no standard Drawings available.

Please contact us for more information.

Quick Change Collet Chucks

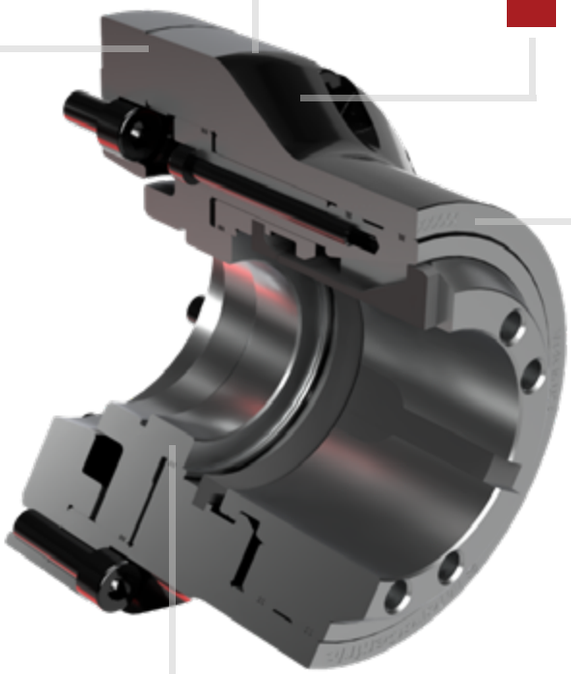
Back to Content

MODULAR DESIGN

- CHUCK BODY ASSEMBLY
- SPINDLE ADAPTER PLATE
- DRAW TUBE ADAPTER

SPINDLE ADAPTER PLATE

RADIAL ADJUSTING SCREWS



ALL COMPONENTS: HARDENED & PRECISION GROUND ALLOY STEEL

DRAW TUBE ADAPTER TO FIT EXISTING DRAW TUBE

Overview

Back to Content

NX Series - Low Profile Dead Length Design

The CB-NX series has a low-profile dead length design with a smaller nose diameter for optimal tool clearance. The collet is directly connected to the chuck body, eliminating Z-axis movement during clamping and preventing pull-back effects on the workpiece.

ND Series - Dead Length Design

The ND series, for collet sizes of 120mm+, has a dead length design, eliminating pull-back effects. The CB-ND includes radial adjusting screws for precise alignment, low-maintenance lubricated-for-life design, and allows mounting of stop plates and housings for end stops or part ejectors.

NB Series - Pull Back Design

In the CB-NB series collet chucks, the collet directly connects to the draw tube, maximizing clamping force efficiency. The Pull Back design ensures forces concentrate in the spindle direction for high accuracy and rigidity. It boasts a low-profile OD, radial adjusting screws for precise alignment, low-maintenance lubricated-for-life design, and hardened components for durability.

NDR Series - Pull to Close Dead Length Design

The patented CB-NDR is a Dead Length design for servo stop bar loaders. Unlike traditional chucks, it activates as the draw tube moves, preventing bar displacement. Features include Pull to Close Dead Length design, radial adjusting screws for precise alignment, low-maintenance lubricated-for-life design, and hardened components for durability.

NK Series - Combination Design for Bar & Chucking Work

The NK series chucks offer a pull-back design for versatile clamping and easy conversion. With a low-profile OD, radial adjusting screws, and hardened components, the CB-NK ensures precision and durability, with options for mounting stop plates and housings inside the chuck body.

NRB Series - Self Contained Pull Back Design for Stationary Applications

he NRB series features a hydraulically actuated Pull Back design for non-rotating applications. It draws the collet into the tapered seat, allowing part stops inside the chuck body. With a self-contained design, Pull Back mechanism, lubricated-for-life feature, and hardened components, it ensures accuracy. Non-rotating dead length designs are available on request.

Overview

Back to Content

AG Series - Compensating Pull Back Design Chucks

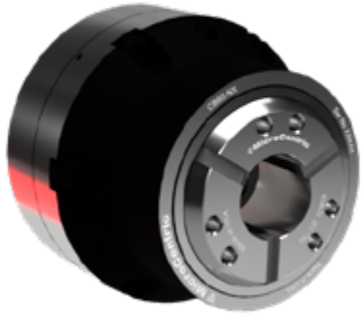
The CB-AG series collet chuck is a pull back design with a floating collet seat for machining shafts between centers. Centers or other part locators are mounted in the ID of the chuck. The floating collet seat can also be locked out to clamp parts on-center. Compact OD and short length compared to other compensating chuck designs provides greater rigidity.

WSF Series - Retractable Design

MicroCentric's retractable collet chuck allows full machining of shafts between centers. A face driver in the chuck's ID drives the shaft, supported by the tailstock. Upon activation, the collet clamps the turned diameter, securing the shaft end for OD machining. The WSF features radial adjusting screws for .0002" / 0.005mm precision, with hardened components for accuracy and longevity.

Technical Data CB-NX

Back to Content



- Low Profile Dead Length design
- Reduced diameter nose and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up tapered collet seat within .0002" / 0.005mm
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for
- Highest accuracy and long life
- Stop plates, stop housings, and ejectors can be mounted inside the chuck body for chucking applications

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB42-NX/A5	A2-5	42BZI	1.625"/42mm
CB42-NX/140	140mm	42BZI	1.625"/42mm
CB42-NX/A6	A2-6	42BZI	1.625"/42mm
CB52-NX/A5	A2-5	52BZI	2.000"/52mm
CB52-NX/140	140mm	52BZI	2.000"/52mm
CB52-NX/A6	A2-6	52BZI	2.000"/52mm
CB65-NX/A5	A2-5	65BZI	2.625/66mm
CB65-NX/140	140mm	65BZI	2.625/66mm
CB65-NX/A6	A2-6	65BZI	2.625/66mm
CB65-NX/A8	A2-8	65BZI	2.625/66mm
CB65-NX/A8-OS	A2-8	65BZI	2.625/66mm
CB80-NX/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NX/A8	A2-8	80BZI	3.250"/82.5mm
CB80-NX/A11	A2-11	80BZI	3.250"/82.5mm
CB100-NX/A6	A2-6	100BZI	4.000"/100mm
CB100-NX/A8	A2-8	100BZI	4.000"/100mm
CB100-NX/A11	A2-11	100BZI	4.000"/100mm

1 CB-NX Chucks with spindle adapters other than those listed above are quoted on request.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB42-NX Specifications

Back to Content

Collet Model 42BZI

Accuracy - Max Radial Runout*
0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
1.625" / 42mm

Collet Capacity - Min Clamping Diameter
.156" / 4mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
7,868 lb / 35 kN

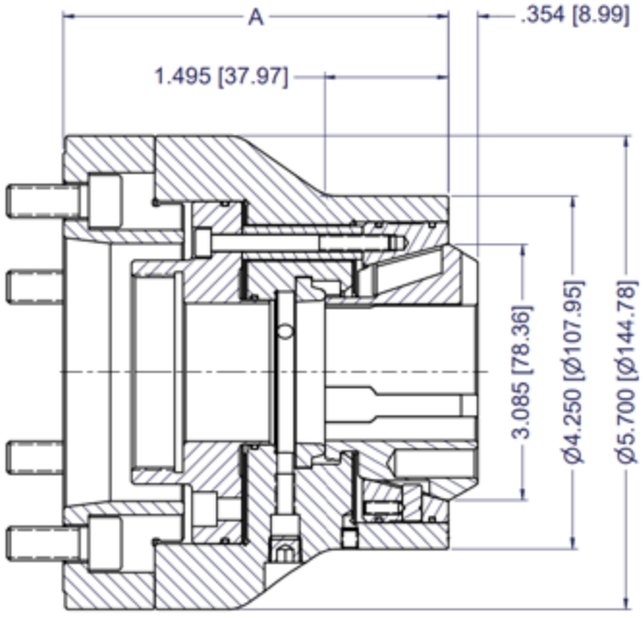
Max Clamping Force
17,985 lb / 80 kN

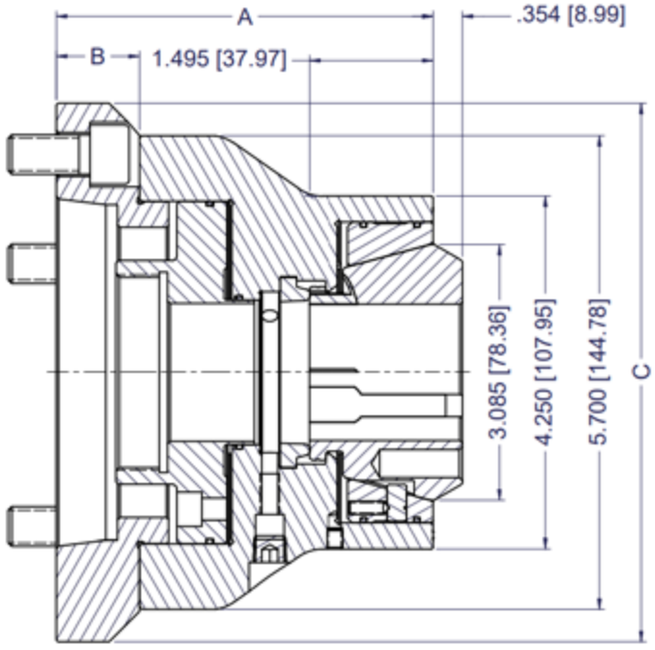
Maximum Speed
7,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB42-NX/A5	1	A2-5	4.643"/ 117.93mm	- -	- -	M60x2	20.32 lb/ 9.22 kg
CB42-NX/140	2	140mm	4.246"/ 107.85mm	.703"/ 17.86mm	5.950"/ 151.13mm	M60x2	19.30 lb/ 8.75 kg
CB42-NX/A6	2	A2-6	4.543"/ 115.39mm	1.000"/ 25.4mm	6.480"/ 164.59mm	M60x2/ M75x2 (2 pc)	20.33 lb/ 9.22 kg





Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB52-NX Specifications

Back to Content

Collet Model 52BZI

Accuracy - Max Radial Runout*
.0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
2.000" / 52mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
8,992 lb / 40 kN

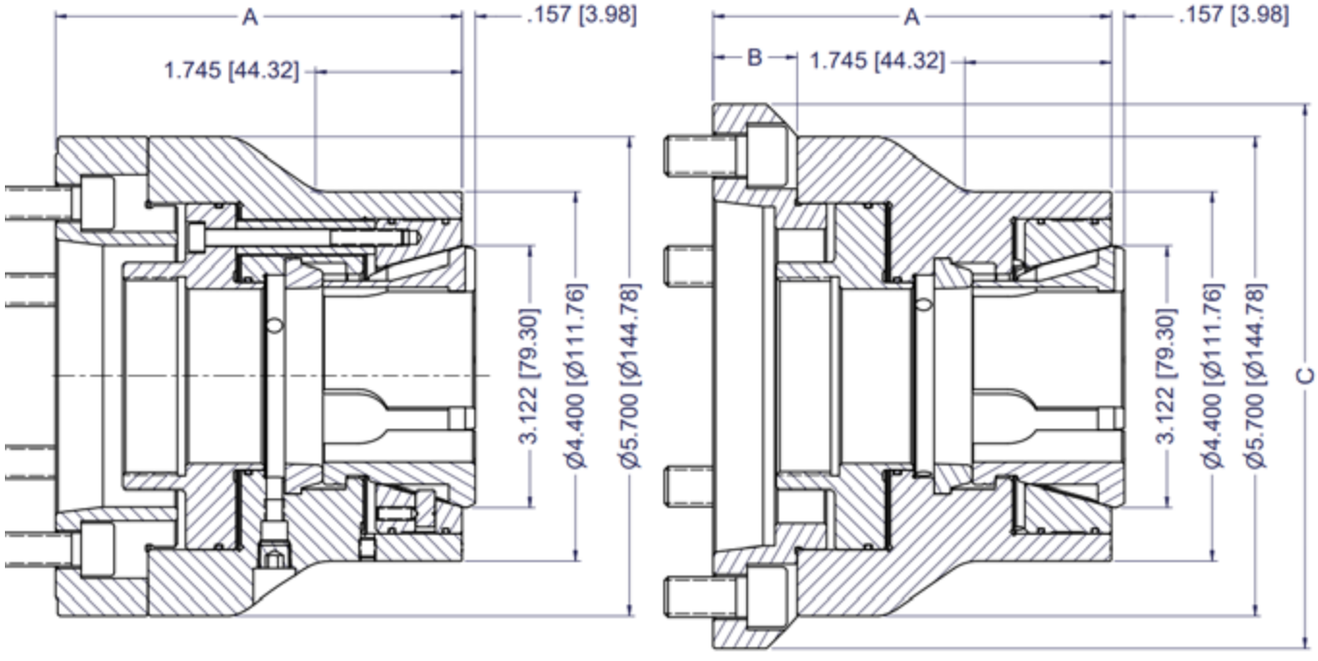
Max Clamping Force
21,132 lb / 94 kN

Maximum Speed
7,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB52-NX/A5	1	A2-5	4.840"/ 122.94 mm	- -	- -	M60x2	20.25 lb/ 9.19 kg
CB52-NX/140	2	140mm	4.443"/ 112.85 mm	.703"/ 17.86mm	5.950"/ 151.13mm	M60x2	19.21 lb/ 8.71 kg
CB52-NX/A6	2	A2-6	4.740"/ 120.40 mm	1.000"/ 25.4mm	6.480"/ 164.59mm	M60x2/ M75x2 (2 pcs)	20.22 lb/ 9.17 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB65-NX Specifications

Back to Content

Collet Model 65BZI

Accuracy - Max Radial Runout*
.0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
10,116 lb / 45 kN

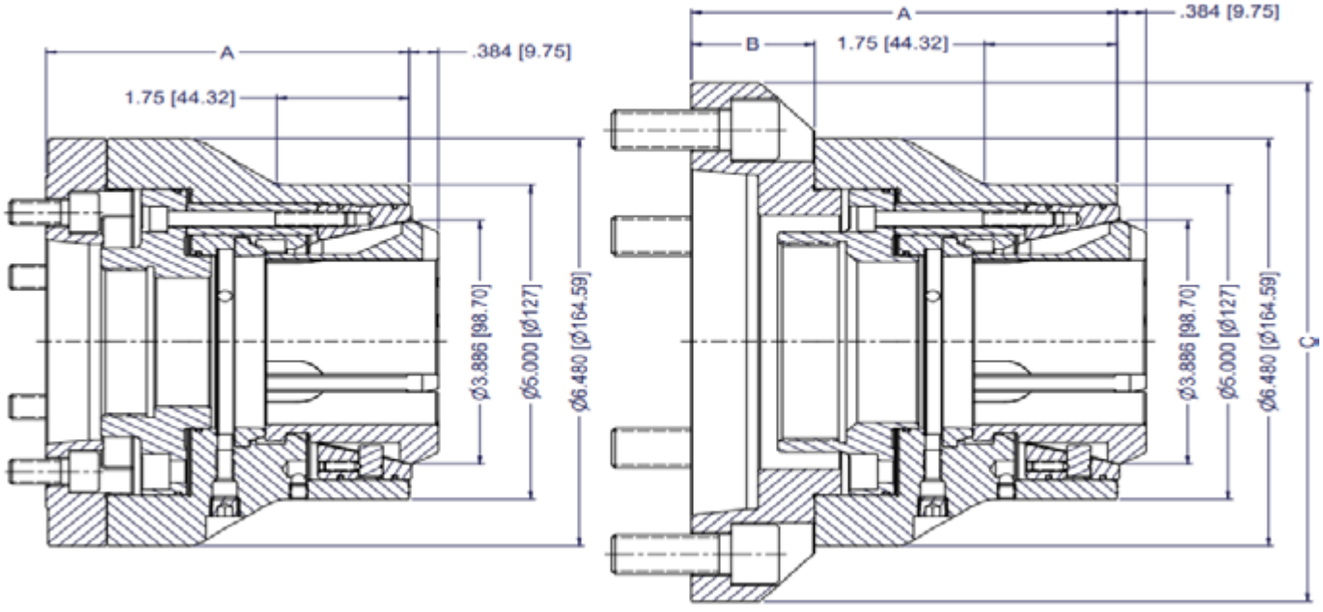
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB65-NX/A5	1	A2-5	4.780"/ 121.41mm	- -	- -	M60x2	25.9 lb/ 11.8 kg
CB65-NX/140	1	140mm	4.583"/ 116.41mm	- -	- -	M60x2	25.0 lb/ 11.3 kg
CB65-NX/A6	1	A2-6	5.330"/ 135.38mm	- -	- -	M80x2	27.7 lb/ 12.6 kg
CB65-NX/A8	2	A2-8	5.605"/ 142.37mm	1.625"/ 41.28mm	8.250"/ 209.55mm	M80x2	34.2 lb/ 15.5 kg
CB65-NX/A8-OS	2	A2-8	5.605"/ 142.37mm	1.625"/ 41.28mm	9.250"/ 234.95mm	M80x2/ M100x2 (2 pcs)	39.05 lb/ 17.71 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB80-NX Specifications

Back to Content

Collet Model 80BZI

Accuracy - Max Radial Runout*
.0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
11,240 lb / 50 kN

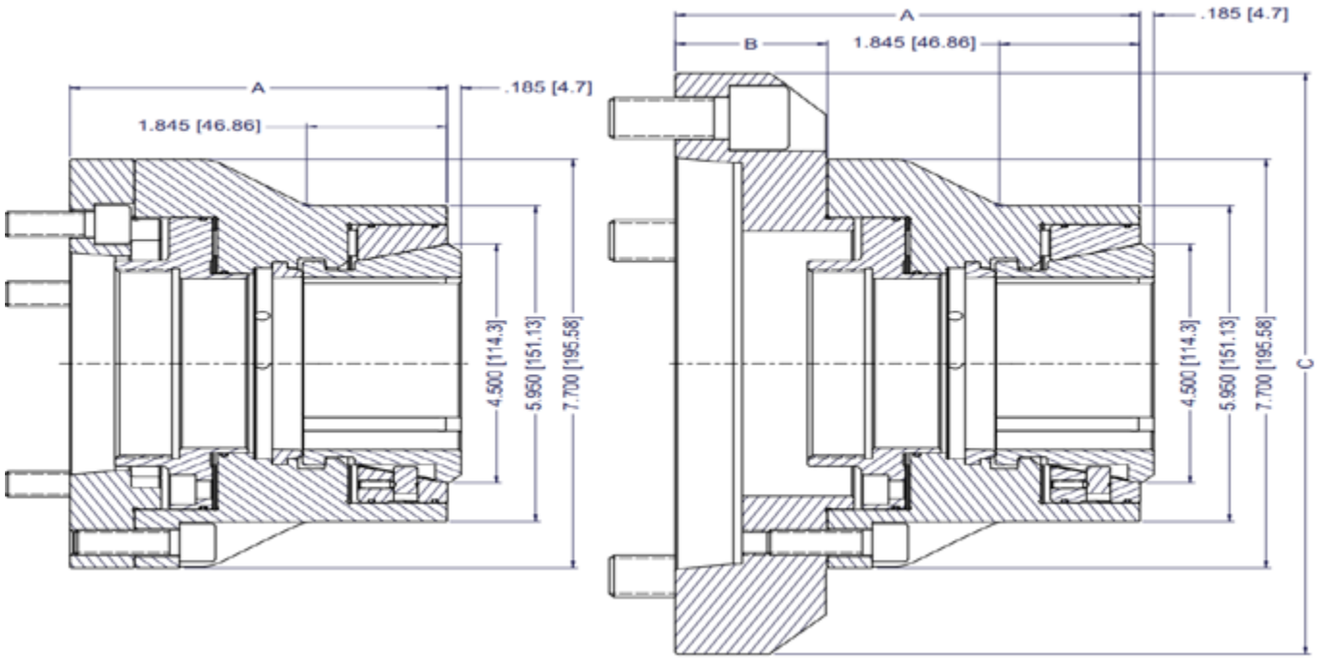
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
5,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB80-NX/A6	1	A2-6	4.960"/ 125.98 mm	- -	- -	M90x2	35.64 lb/ 16.16 kg
CB80-NX/A8	2	A2-8	5.210"/ 132.33 mm	1.105"/ 28.07 mm	8.250"/ 209.55mm	M100x2	37.65 lb/ 17.07 kg
CB80-NX/A11	2	A2-11	6.105"/ 155.07 mm	2.000"/ 50.80 mm	10.950"/ 278.13 mm	M100x2 115x2 (2 pcs)	59.54 lb/ 27.00 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB100-NX Specifications

Back to Content

Collet Model 100BZ

Accuracy - Max Radial Runout*
.001" / 0.025mm

Collet Capacity - Max Clamping Diameter
4.000" / 100mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
14,612 lb / 65 kN

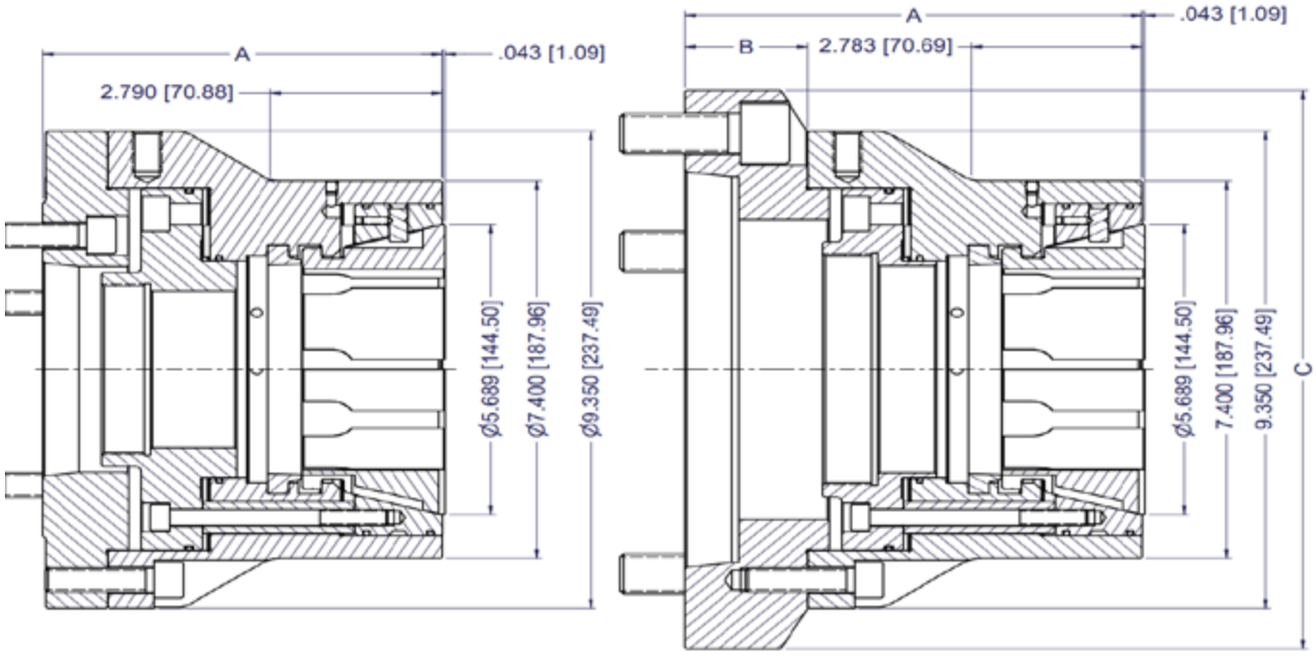
Max Clamping Force
33,721 lb / 150 kN

Maximum Speed
5,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB100-NX/A6	1	A2-6	6.500"/ 165.10 mm	- -	- -	M90x2	20.32 lb/ 9.22 kg
CB100-NX/A8	1	A2-8	6.600"/ 167.64 mm	- -	- -	M115x2	19.30 lb/ 8.75 kg
CB100-NX/A11	2	A2-11	7.440"/ 188.98 mm	2.000"/ 50.80 mm	10.950"/ 278.13 mm	M115x2	20.33 lb/ 9.22 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

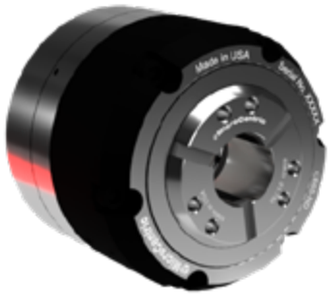
Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-ND

Back to Content



- Dead Length design
- Radial adjusting screws to true-up the chuck assembly within .0002" / 0.005mm
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life
- Stop plates and stop housings can be mounted inside the chuck body for chucking applications requiring end stops or part ejectors

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB120-ND/A6	A2-6	120BZI	4.720"/120mm
CB120-ND/A8	A2-8	120BZI	4.720"/120mm
CB120-ND/A11	A2-11	120BZI	4.720"/120mm
CB120-ND/A15	A2-15	120BZI	4.720"/120mm
CB140-ND/A8	A2-10	140BZI	5.510"/140mm
CB140-ND/A11	A2-11	140BZI	5.510"/140mm
CB140-ND/A15	A2-15	140BZI	5.510"/140mm
CB160-ND/A8	A2-8	160BZI	6.300"/160mm
CB160-ND/A11	A2-11	160BZI	6.300"/160mm
CB160-ND/A15	A2-15	160BZI	6.300"/160mm

1 CB-ND Chucks with spindle adapters other than those listed above are quoted on request.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB120-ND Specifications

Back to Content

Collet Model 120BZI

Accuracy - Max Radial Runout*
.002" / 0.05mm

Collet Capacity - Max Clamping Diameter
4.725" / 120mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
15,736 lb / 70 kN

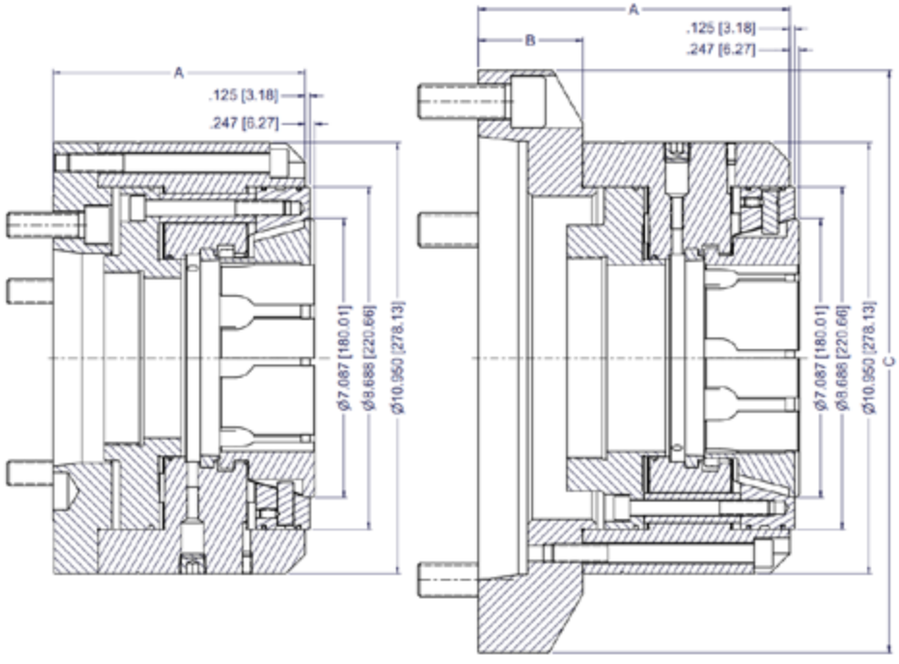
Max Clamping Force
35,969 lb / 160 kN

Maximum Speed
4,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB120-ND/A6	1	A2-6	6.385"/ 162.18 mm	- -	- -	M90x2	136.93 lb/ 62.10 kg
CB120-ND/A8	1	A2-8	6.385"/ 162.18 mm	- -	- -	M115x2	128.39 lb/ 58.23 kg
CB120-ND/A11	1	A2-11	6.735"/ 171.07 mm	- -	- -	M150x2	125.55 lb/ 56.94 kg
CB120-ND/A15	2	A2-15	7.885"/ 200.28 mm	2.650"/ 67.31 mm	14.950"/ 379.73 mm	M150x2	171.68 lb/ 77.86 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB140-ND Specifications

Back to Content

Collet Model 140BZI

Accuracy - Max Radial Runout*
.002" / 0.05mm

Collet Capacity - Max Clamping Diameter
5.591" / 142mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
315" / 8mm

Max Draw Tube Force
16,860 lb / 75 kN

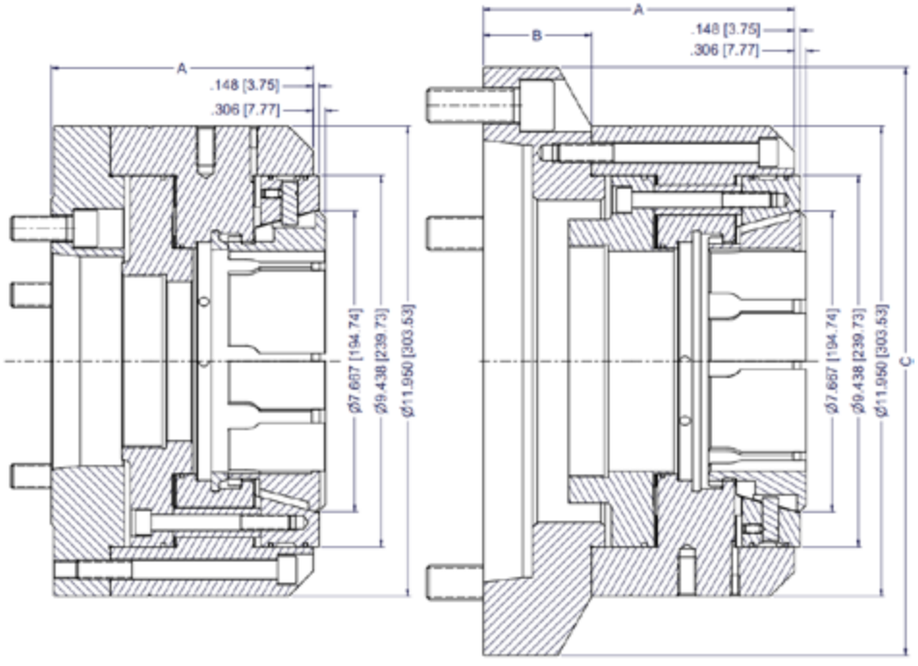
Max Clamping Force
38,218 lb / 170 kN

Maximum Speed
3,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB140-ND/A8	1	A2-8	6.648"/ 168.86 mm	- -	- -	M115x2	159.43 lb/ 72.30 kg
CB140-ND/A11	1	A2-11	7.138"/ 181.31 mm	- -	- -	M150x2	/157.53 lb 71.44 kg
CB140-ND/A15	2	A2-15	7.898"/ 200.61"	2.750"/ 69.85 mm	14.950"/ 379.73 mm	M150x2	190.45 lb/ 86.37 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB160-ND Specifications

Back to Content

Collet Model 42BZI

Accuracy - Max Radial Runout*
.002" / 0.05mm

Collet Capacity - Max Clamping Diameter
6.300" / 160mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
16,860 lb / 75 kN

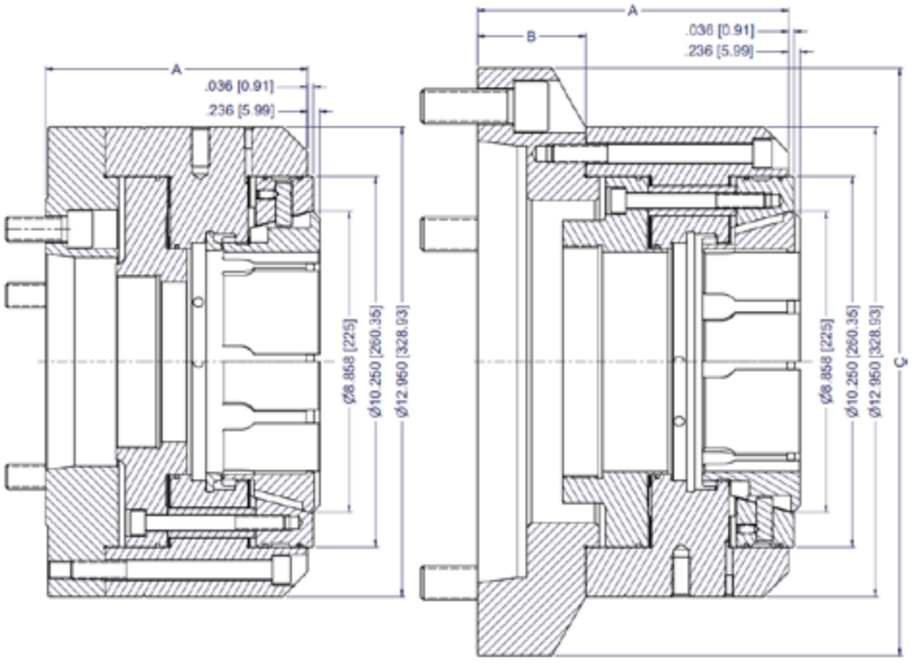
Max Clamping Force
38,218 lb / 170 kN

Maximum Speed
3,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB160-ND/A8	1	A2-8	7.115"/ 180.72 mm	- -	- -	M115x2	197.97 lb/ 89.78 kg
CB160-ND/A11	1	A2-11	7.365"/ 187.07 mm	- -	- -	M150x2	197.65 lb/ 89.64 kg
CB160-ND/A15	2	A2-15	8.115"/ 206.12 mm	2.750"/ 69.85 mm	14.950"/ 379.73 mm	M150x2	211.27 lb/ 95.81 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

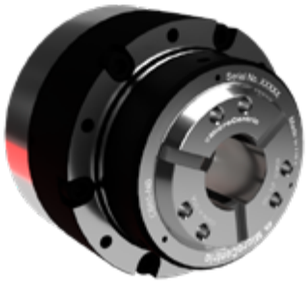
Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-NB

Back to Content



- Pull Back design maximizes the efficiency of the clamping system by concentrating all forces in the direction of the spindle for highest accuracy and greatest overall rigidity
- Low profile OD and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up the chuck assembly within .0002" / 0.005mm
- Lubricated for life design requires minimal maintenance
- All components hardened and precision

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB42-NB/A5	A2-5	42BZI	1.625"/42mm
CB42-NB/140	140mm	42BZI	1.625"/42mm
CB42-NB/A6	A2-6	42BZI	1.625"/42mm
CB52-NB/A5	A2-5	52BZI	2.000"/52mm
CB52-NB/140	140mm	52BZI	2.000"/52mm
CB52-NB/A6	A2-6	52BZI	2.000"/52mm
CB65-NB/A5	A2-5	65BZI	2.625/66mm
CB65-NB/140	140mm	65BZI	2.625/66mm
CB65-NB/A6	A2-6	65BZI	2.625/66mm
CB65-NB/A8	A2-8	65BZI	2.625/66mm
CB65-NB/A8-OS	A2-8	65BZI	2.625/66mm
CB80-NB/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NB/A8	A2-8	80BZI	3.250"/82.5mm
CB80-NB/A11	A2-11	80BZI	3.250"/82.5mm
CB100-NB/A6	A2-6	100BZI	4.000"/100mm
CB100-NB/A8	A2-8	100BZI	4.000"/100mm
CB100-NB/A11	A2-11	100BZI	4.000"/100mm
CB120-NB/A8	A2-8	120BZI	4.720"/120mm
CB120-NB/A11	A2-11	120BZI	4.720"/120mm
CB120-NB/A15	A2-12	120BZI	4.720"/120mm
CB140-NB/A8	A2-8	140BZI	5.510"/140mm
CB140-NB/A11	A2-11	140BZI	5.510"/140mm
CB140-NB/A15	A2-15	140BZI	5.510"/140mm

1 CB-NB Chucks with spindle adapters other than those listed above are quoted on request.

Changing Fixtures

PAGE 164

Collets

PAGE 153

Accessories

PAGE 165

CB42-NB Specifications

Back to Content

Collet Model 42BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
1.625" / 42mm

Collet Capacity - Min Clamping Diameter
.156" / 4mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
7,868 lb / 35 kN

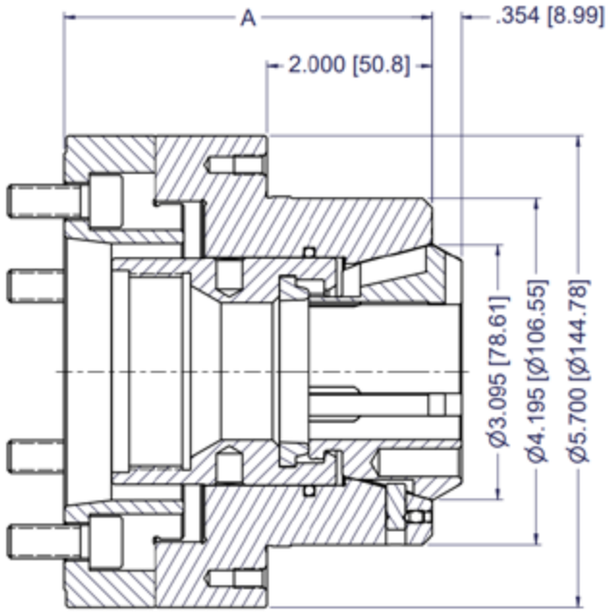
Max Clamping Force
17,985 lb / 80 kN

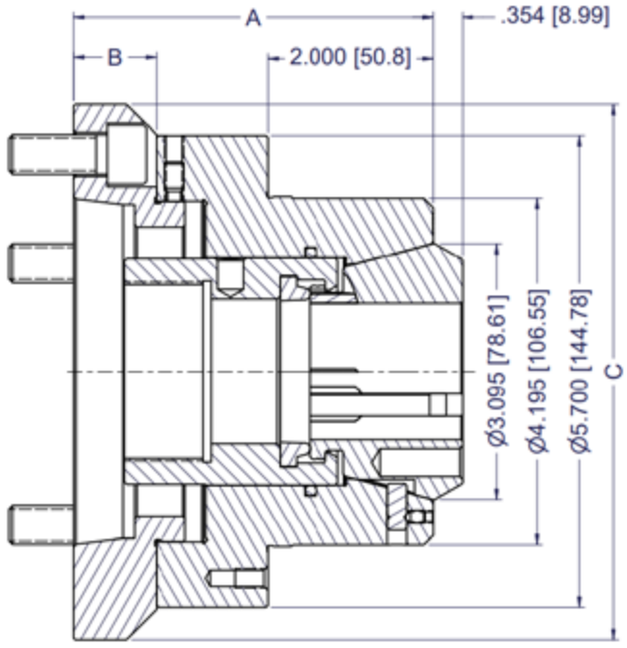
Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB42-NB/A5	1	A2-5	4.45"/ 113 mm	- -	- -	M60x2	19.43 lb/ 8.81 kg
CB42-NB/140	2	140mm	4.05"/ 102.9mm	.703"/ 17.86mm	5.950"/ 151.13mm	M60x2	18.40 lb/ 8.34 kg
CB42-NB/A6	2	A2-6	4.35"/ 115.39mm	1.000"/ 25.4mm	6.480"/ 164.59mm	M75x2	20.33 lb/ 9.22 kg





Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB52-NB Specifications

Back to Content

Collet Model 52BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
2.000" / 52mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
8,992 lb / 40 kN

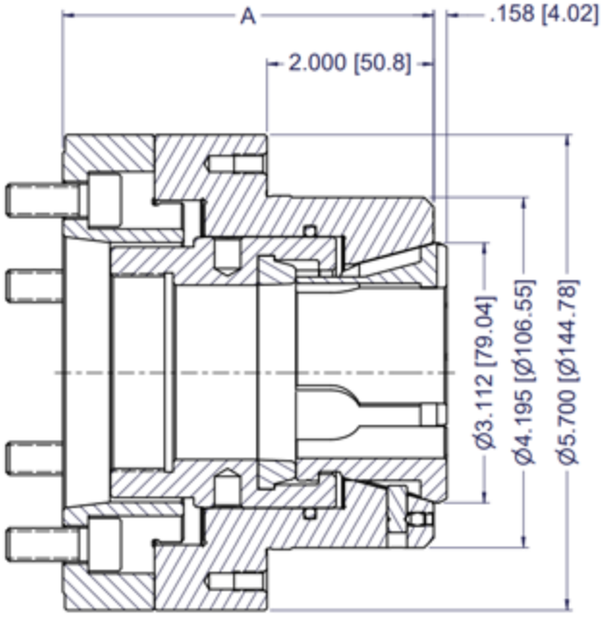
Max Clamping Force
21,132 lb / 94 kN

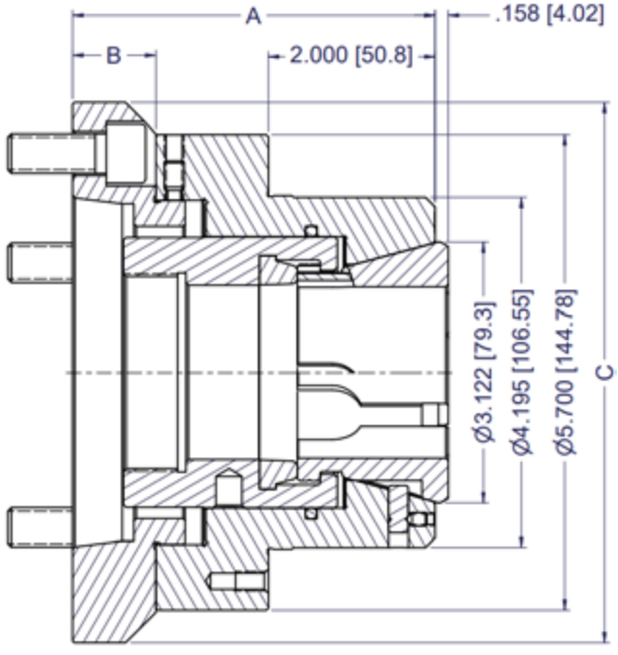
Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB52-NB/A5	1	A2-5	4.45"/ 113 mm	- -	- -	M68x2	18.62 lb/ 8.44 kg
CB52-NB/140	2	140mm	4.05"/ 102.9mm	.703"/ 17.86mm	5.950"/ 151.13mm	M68x2	17.58 lb/ 7.97 kg
CB52-NB/A6	2	A2-6	4.35"/ 115.39mm	1.000"/ 25.4mm	6.480"/ 164.59mm	M75x2	18.80 lb/ 8.53 kg





Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB65-NB Specifications

Back to Content

Collet Model 65BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
10,116 lb / 45 kN

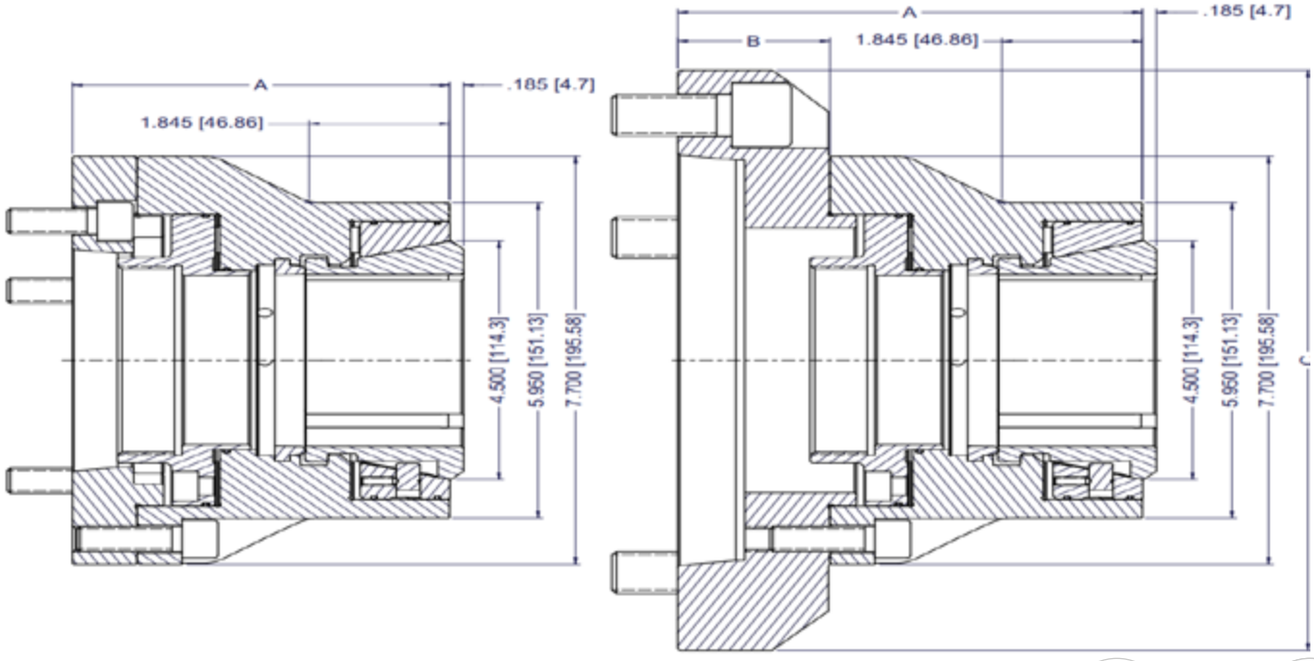
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB65-NB/A5	1	A2-5	4.300"/ 109.22mm	- -	- -	M70x2	25.83 lb/ 11.71 kg
CB65-NB/140	1	140mm	4.103"/ 104.22mm	- -	- -	M70x2	24.91 lb/ 11.30 kg
CB65-NB/A6	1	A2-6	4.850"/ 123.19mm	- -	- -	M85x2	27.58 lb/ 12.51 kg
CB65-NB/A8	2	A2-8	5.125"/ 130.18mm	1.625"/ 41.28mm	8.250"/ 209.55mm	M85x2	34.06 lb/ 15.45 kg
CB65-NB/A8-OS	2	A2-8	5.125"/ 130.18mm	1.625"/ 41.28mm	9.250"/ 234.95mm	M100x2	39.44 lb/ 17.89 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB80-NB Specifications

Back to Content

Collet Model 80BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
11,240 lb / 50 kN

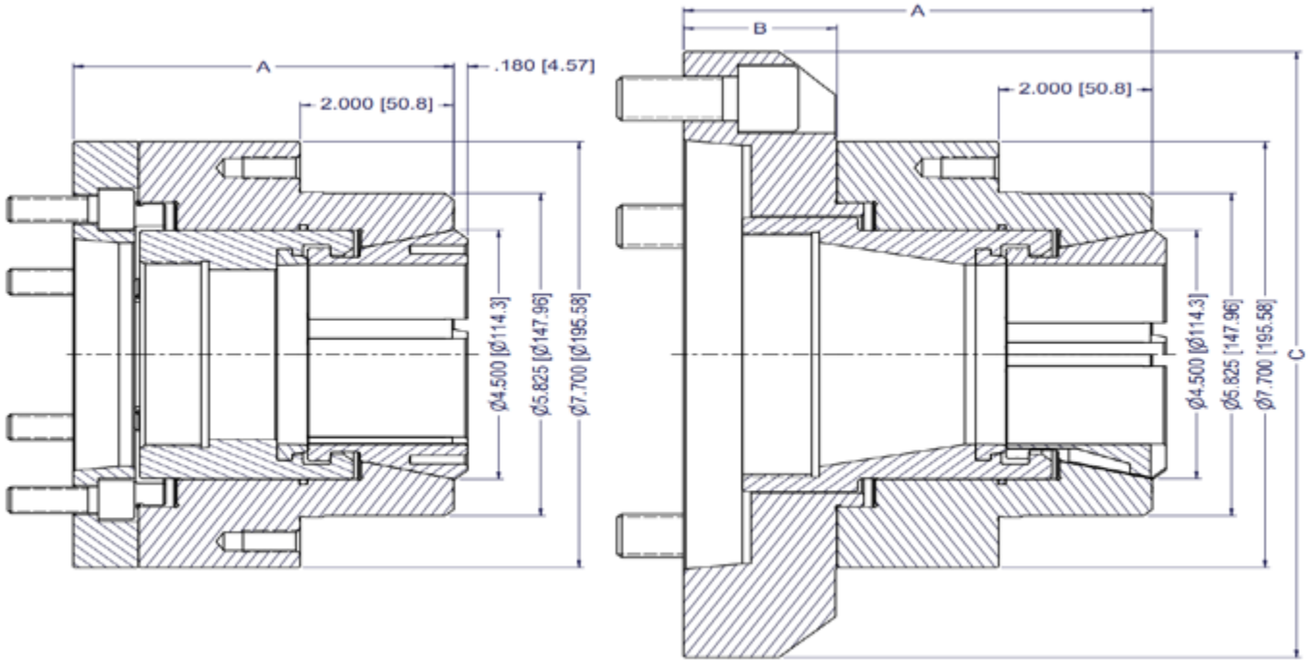
Max Clamping Force
25,853 lb / 115 kN

Maximum Speed
5,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB80-NB/A6	1	A2-6	4.960"/ 125.98 mm	- -	- -	M85x2	39.11 lb/ 17.74 kg
CB80-NB/A8	2	A2-8	5.210"/ 132.33 mm	1.105"/ 28.07 mm	8.250"/ 209.55mm	M105x2	40.79 lb/ 18.50 kg
CB80-NB/A11	2	A2-11	6.105"/ 155.07 mm	2.000"/ 50.80 mm	10.950"/ 278.13 mm	M115x2	63.92 lb/ 28.99 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB100-NB Specifications

Back to Content

Collet Model 100BZI

Accuracy - Max Radial Runout*
.0006" / 0.015mm

Collet Capacity - Max Clamping Diameter
4.000" / 100mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
14,612 lb / 65 kN

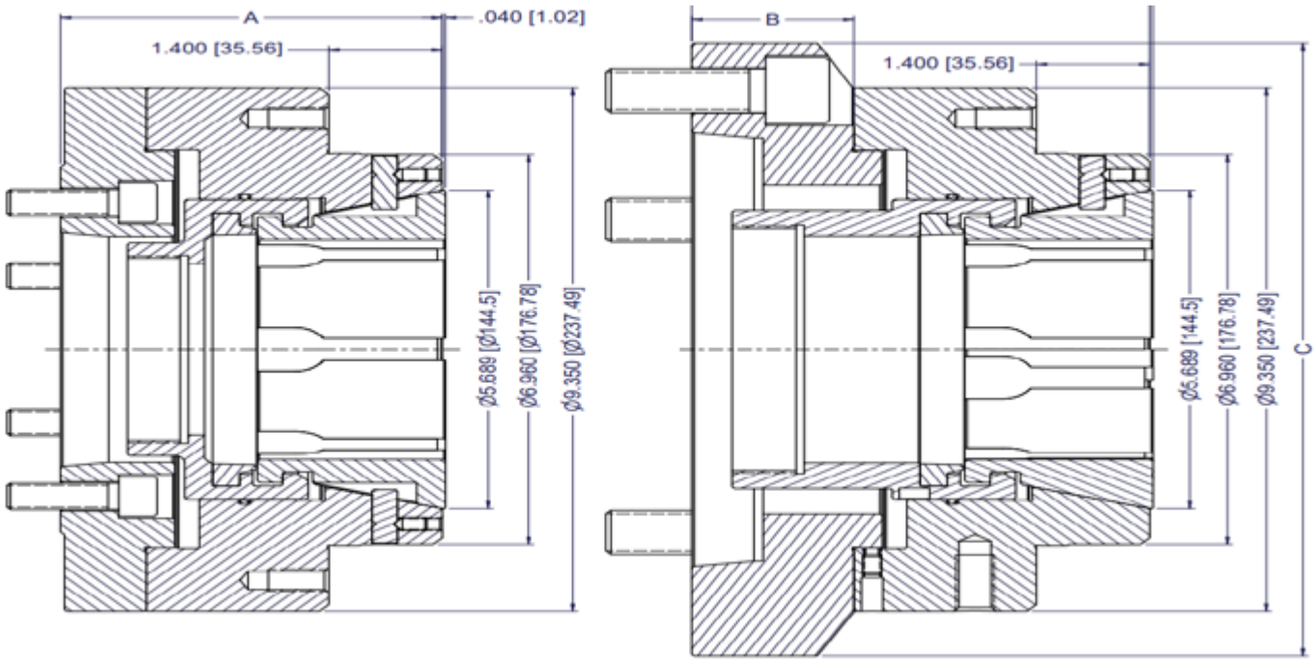
Max Clamping Force
33,721 lb / 150 kN

Maximum Speed
5,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB100-NB/A6	1	A2-6	4.710" 119.63mm	- -	- -	M85x2	57.67 lb 26.15 kg
CB100-NB/A8	1	A2-8	4.810" 122.17mm	- -	- -	M115x2	56.48 lb 25.61 kg
CB100-NB/A11	2	A2-11	5.650" 143.51 mm	2.000" 50.80 mm	10.950" 278.13 mm	M115x2	73.68 lb 33.41 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB120-NB Specifications

Back to Content

Collet Model 120BZI

Accuracy - Max Radial Runout*
.001" / 0.025mm

Collet Capacity - Max Clamping Diameter
4.725" / 120mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
15,736 lb / 70 kN

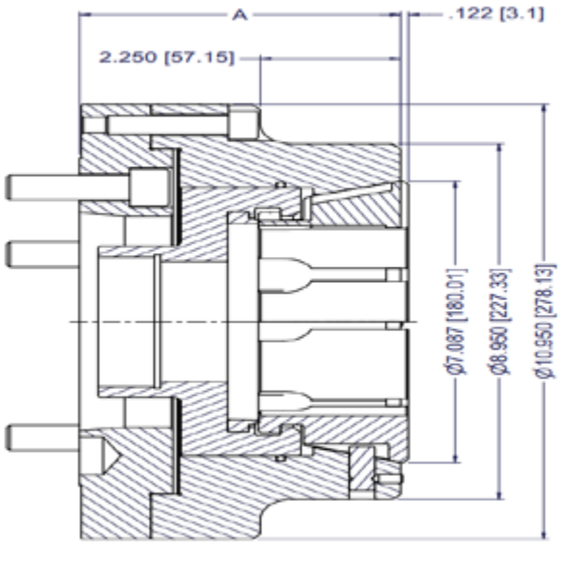
Max Clamping Force
35,969 lb / 160 kN

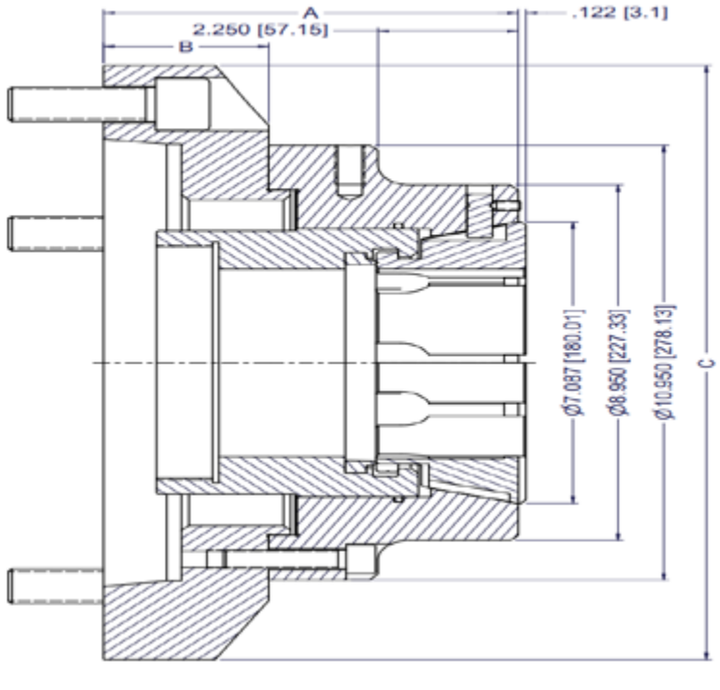
Maximum Speed
4,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB120-NB/A8	1	A2-8	5.150" 130.81 mm	- -	- -	M115x2	88.28 lb 40.04 kg
CB120-NB/A11	1	A2-11	5.500" 139.70 mm	- -	- -	M150x2	87.66 lb 39.76 kg
CB120-NB/A15	2	A2-15	6.650" 168.91 mm	2.650" 67.31 mm	14.950" 379.73 mm	M150x2	134.73 lb 61.10 kg





Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB140-NB Specifications

Back to Content

Collet Model 140BZI

Accuracy - Max Radial Runout*
.001" / 0.025mm

Collet Capacity - Max Clamping Diameter
5.591" / 142mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
16,860 lb / 75 kN

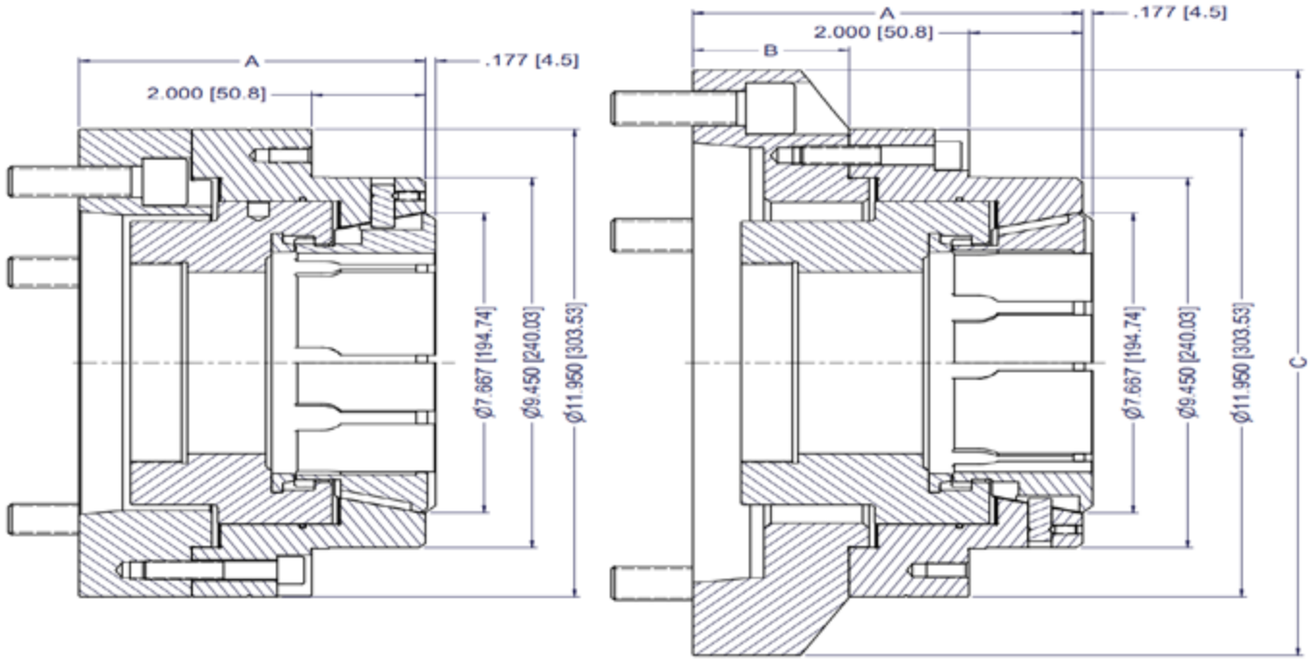
Max Clamping Force
38,218 lb / 170 kN

Maximum Speed
3,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB140-NB/A8	1	A2-8	5.605" 142.37 mm	- -	- -	M115x2	113.28 lb 51.37 kg
CB140-NB/A11	1	A2-11	6.095" 104.01 mm	- -	- -	M150x2	119.41 lb 54.15 kg
CB140-NB/A15	2	A2-15	6.855" 174.12 mm	2.650" 67.31 mm	14.950" 379.73 mm	M150x2	157.98 lb 71.65 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-NDR

Back to Content

- Pull to Close Dead Length design produces no pull back and will not push the bar off the servo stop
- Radial adjusting screws to true-up the chuck assembly within .0002" / 0.005mm
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB65-NDR/A5	A2-5	65BZI	2.625/66mm
CB65-NDR/140	140mm	65BZI	2.625/66mm
CB65-NDR/A6	A2-6	65BZI	2.625/66mm
CB65-NDR/A8	A2-8	65BZI	2.625/66mm
CB65-NDR/A8-OS	A2-8	65BZI	2.625/66mm
CB80-NDR/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NDR/A8	A2-8	80BZI	3.250"/82.5mm

1 CB-NDR Chucks with spindle adapters other than those listed above are quoted on request.

Changing Fixtures

PAGE 164

Collets

PAGE 153

Accessories

PAGE 165

CB65-NDR Specifications

Back to Content

Collet Model 65BZI

Accuracy - Max Radial Runout*
.0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.480" / 12.2mm

Max Draw Tube Force
8,990 lb / 40 kN

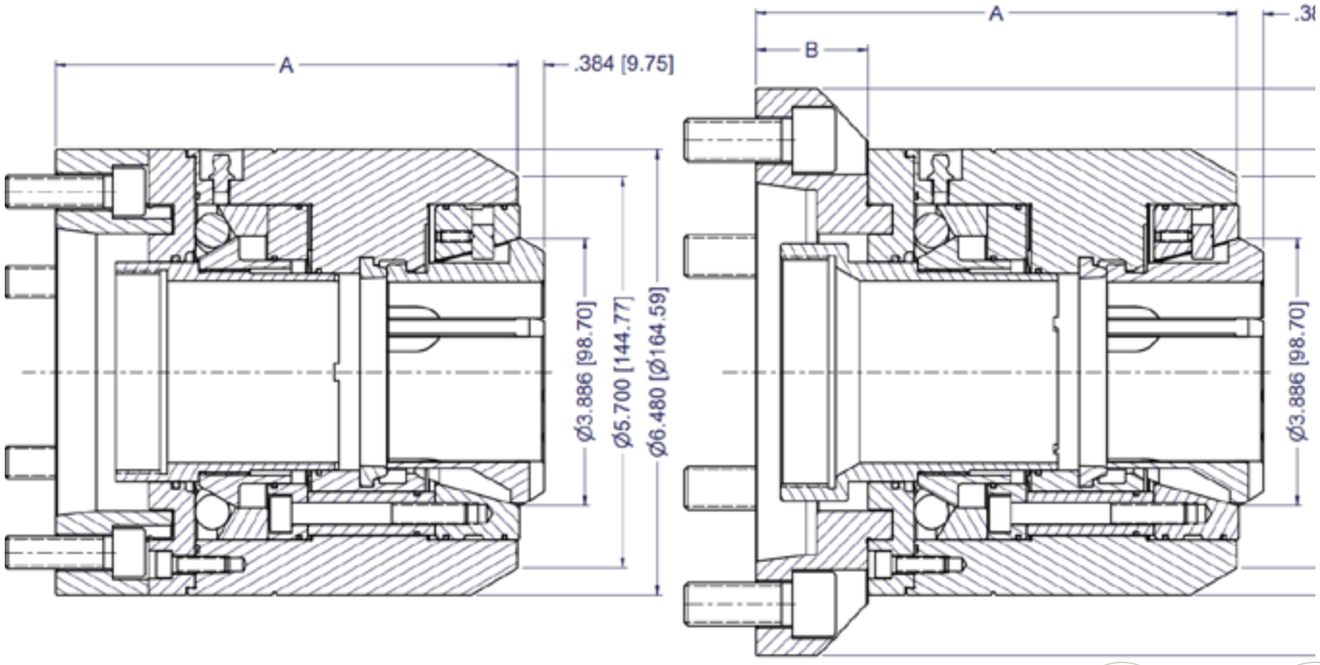
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB65-NDR/A5	1	A2-5	6.175"/ 156.85 mm	- -	- -	M60x2	44.73 lb/ 20.29 kg
CB65-NDR/140	1	140mm	5.985/ 152.02 mm	- -	- -	M75x2	42.16 lb/ 19.12 kg
CB65-NDR/A6	1	A2-6	6.725"/ 170.82 mm	- -	- -	M75x2	45.22 lb/ 20.51 kg
CB65-NDR/A8	2	A2-8	7.000"/ 177.80 mm	1.625"/ 41.28mm	8.250"/ 209.55mm	M85x2	52.56 lb/ 23.84 kg
CB65-NDR/A8-OS	2	A2-8	7.000" 177.80 mm	1.625" 41.28mm	8.250" 209.55mm	M90x2	52.12 lb/ 23.64 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB80-NDR Specifications

Back to Content

Collet Model 80BZI

Accuracy - Max Radial Runout*
.0008" / 0.020mm

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.480" / 12.2mm

Max Draw Tube Force
10,116 lb / 45 kN

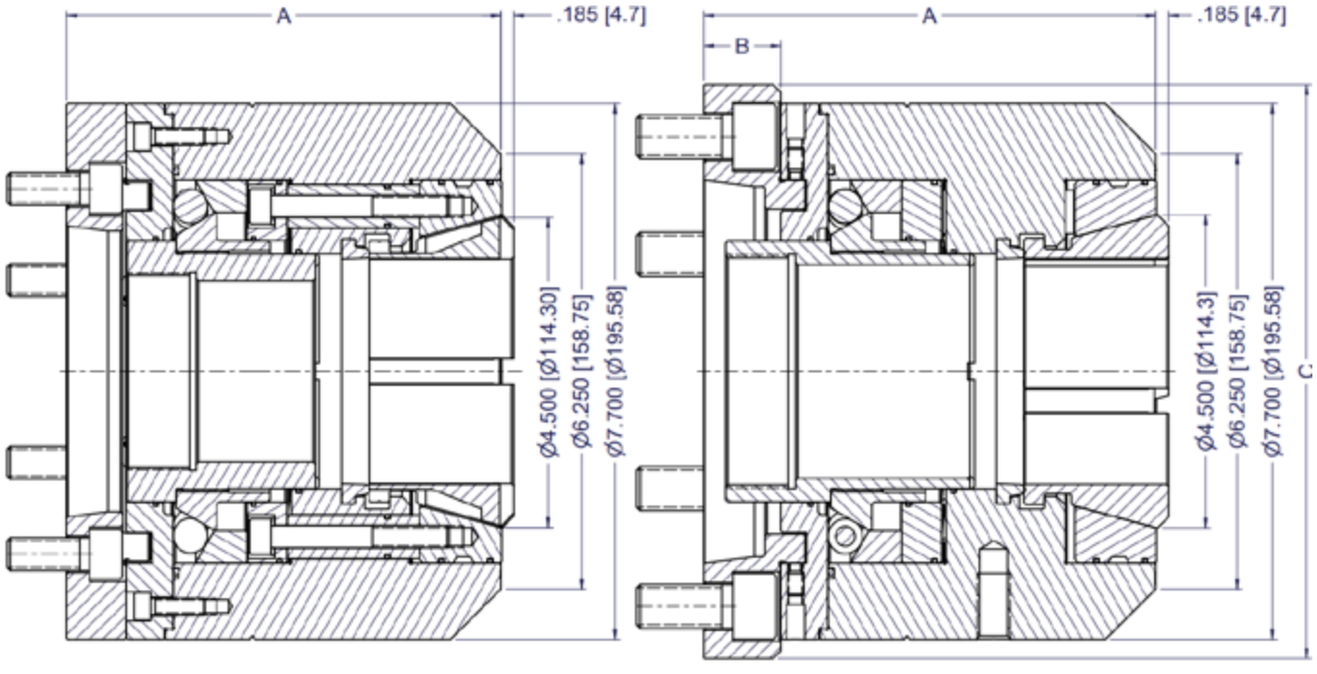
Max Clamping Force
25,853 lb / 115 kN

Maximum Speed
5,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB80-NDR/A6	1	A2-6	6.245"/ 158.62 mm	- -	- -	M80x2	61.67 lb/ 27.97 kg
CB80-NDR/A8	2	A2-8	6.500"/ 165.10 mm	1.105"/ 28.07 mm	8.250"/ 209.55mm	M90x2	62.83 lb/ 28.49 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-NK

Back to Content

- Pull Back design maximizes the efficiency of the clamping system by concentrating all forces in the direction of the spindle for highest accuracy and greatest overall rigidity
- Low profile OD and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up the chuck assembly within .0002" / 0.005mm
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life
- Removable stop plates and stop housings can be mounted inside the chuck body for chucking applications requiring end stops or part ejectors

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB42-NK/A5	A2-5	42BZI	1.625"/42mm
CB42-NK/140	140mm	42BZI	1.625"/42mm
CB42-NK/A6	A2-6	42BZI	1.625"/42mm
CB65-NK/A5	A2-5	65BZI	2.625/66mm
CB65-NK/140	140mm	65BZI	2.625/66mm
CB65-NK/A6	A2-6	65BZI	2.625/66mm
CB65-NK/A8	A2-8	65BZI	2.625/66mm
CB80-NK/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NK/A8	A2-8	80BZI	3.250"/82.5mm
CB100-NK/A6	A2-6	100BZI	4.000"/100mm
CB100-NK/A8	A2-8	100BZI	4.000"/100mm
CB100-NK/A11	A2-11	100BZI	4.000"/100mm

1 CB-NK Chucks with spindle adapters other than those listed above are quoted on request.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB42-NK Specifications

Back to Content

Collet Model 42BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
1.625" / 42mm

Collet Capacity - Min Clamping Diameter
.156" / 4mm

Through Capacity
1.420" / 36mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
7,868 lb / 35 kN

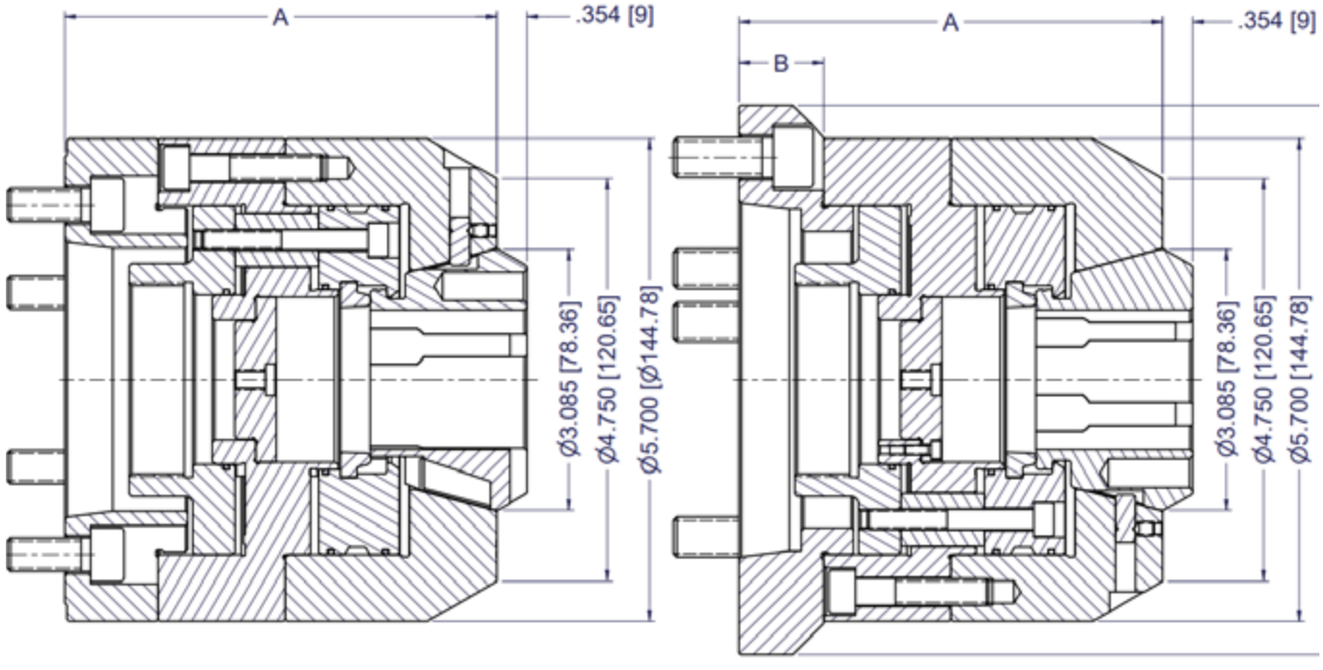
Max Clamping Force
17,985 lb / 80 kN

Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB42-NK/A5	1	A2-5	5.100"/ 129.54 mm	- -	- -	M60x2	28.84 lb/ 13.08 kg
CB42-NK/140	2	140mm	4.703"/ 119.46 mm	.703"/ 17.86mm	5.950"/ 151.13mm	M60x2	27.80 lb/ 12.61 kg
CB42-NK/A6	2	A2-6	5.000"/ 127.00 mm	1.000"/ 25.4mm	6.480"/ 164.59mm	M75x2	28.88 lb/ 13.10 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB65-NK Specifications

Back to Content

Collet Model 65BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Through Capacity
2.245" / 57mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
10,116 lb / 45 kN

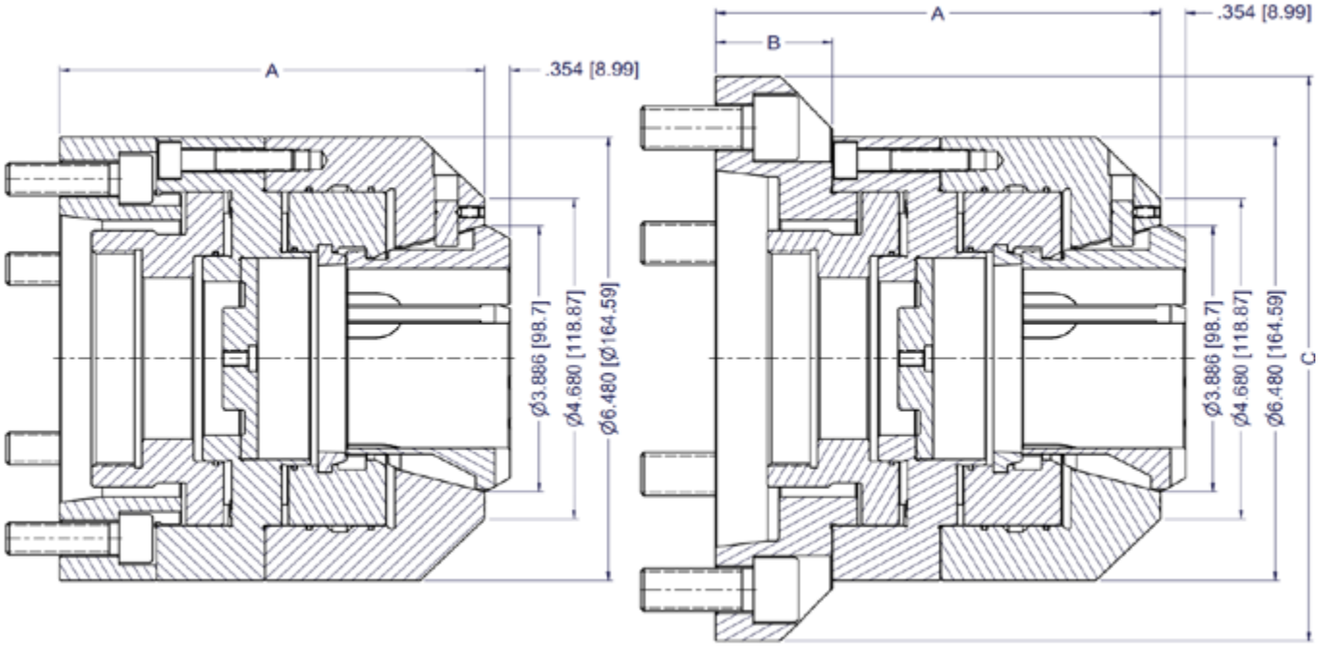
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
6,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB65-NK/A5	1	A2-5	5.375"/ 136.53 mm	- -	- -	M72x2	36.90 lb/ 16.73 kg
CB65-NK/140	1	140mm	5.178"/ 131.52 mm	- -	- -	M72x2	35.99 lb/ 16.32 kg
CB65-NK/A6	1	A2-6	5.925"/ 150.50 mm	- -	- -	M85x2	40.05 lb/ 18.16 kg
CB65-NK/A8	2	A2-8	6.200"/ 157.48 mm	1.625"/ 41.28mm	8.250"/ 209.55mm	M85x2	46.53 lb/ 21.10 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB80-NK Specifications

Back to Content

Collet Model 80BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Through Capacity
2.700" / 68mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

Max Draw Tube Force
11,240 lb / 50 kN

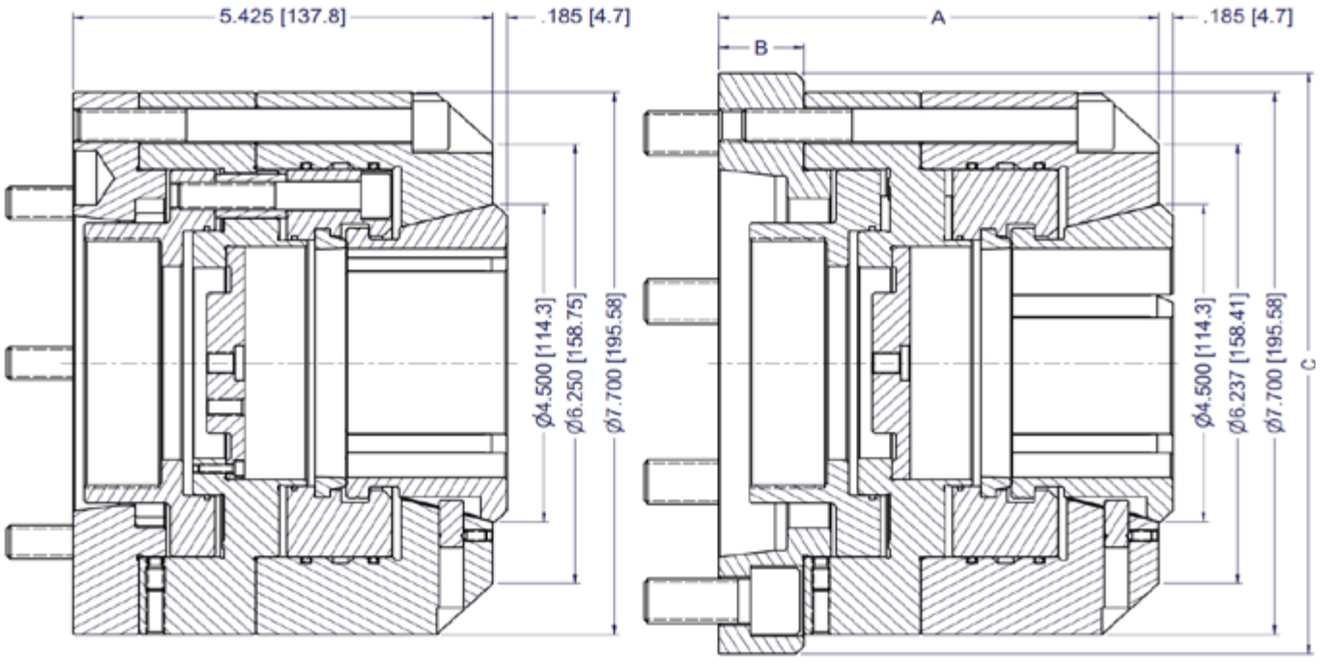
Max Clamping Force
25,853 lb / 115 kN

Maximum Speed
5,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB80-NK/A6	1	A2-6	5.425"/ 137.80 mm	- -	- -	M90x2	53.49 lb/ 24.26 kg
CB80-NK/A8	2	A2-8	5.680"/ 144.27 mm	1.105"/ 28.07 mm	8.250"/ 209.55mm	M90x2	55.50 lb/ 25.17 kg



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB100-NK Specifications

Back to Content

Collet Model 100BZI

Accuracy - Max Radial Runout*
.0006" / 0.015mm

Collet Capacity - Max Clamping Diameter
4.000" / 100mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Through Capacity
3.370" / 93mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
.315" / 8mm

Max Draw Tube Force
14,612 lb / 65 kN

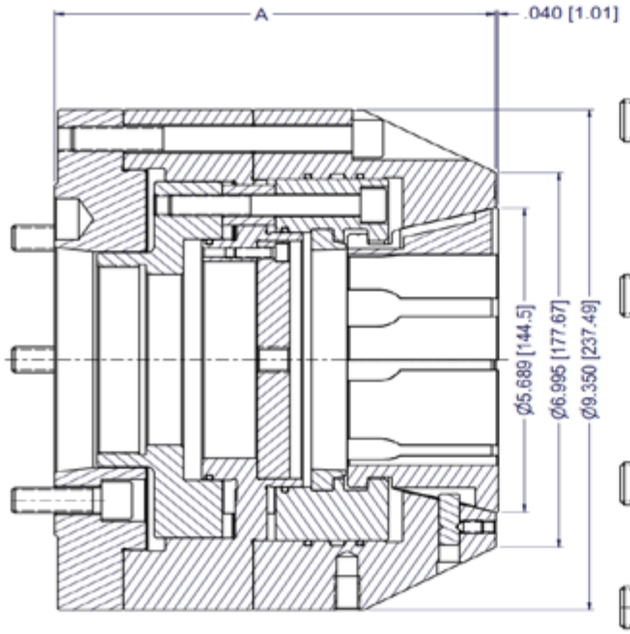
Max Clamping Force
33,721 lb / 150 kN

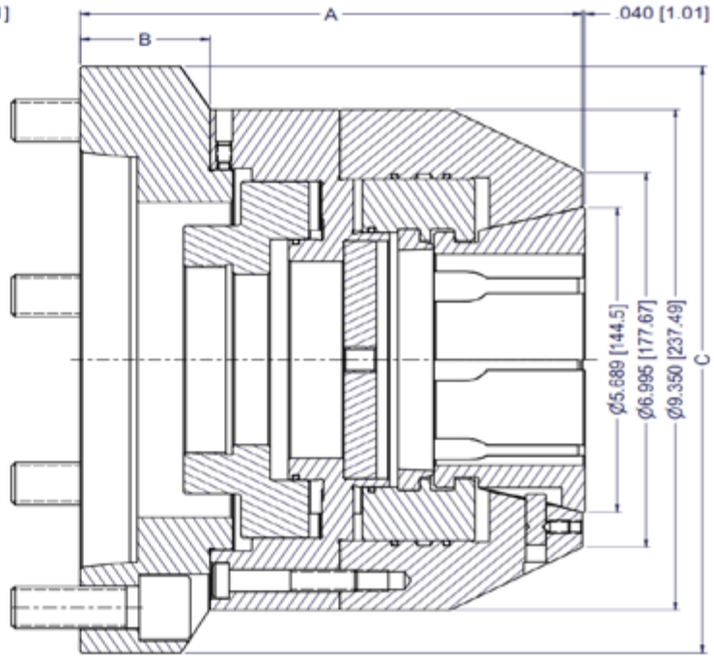
Maximum Speed
5,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
CB100-NK/A6	1	A2-6	6.790"/ 172.47 mm	- -	- -	M90x2	93.19 lb/ 42.26 kg
CB100-NK/A8	1	A2-8	6.890"/ 175.01 mm	- -	- -	M115x2	92.87 lb/ 42.12 kg
CB100-NK/A11	2	A2-11	7.730"/ 196.34 mm	2.000"/ 50.80 mm	10.950"/ 278.13 mm	M130x2	108.78 lb/ 49.33 kg





Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-NRB

Back to Content

- Self-contained design with built-in cylinder can be hydraulic or pneumatically actuated
- Pull Back design maximizes the efficiency of the clamping system by concentrating the chucking force in the direction of the machine table, in addition to drawing the workpiece against the part stop
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life

Chuck Model[1]	Collet Model	Collet Capacity
CB42-NRB	42BZI	1.625"/42mm
CB65-NRB	65BZI	2.625"/66mm
CB80-NRB	80BZI	3.250"/82.5mm
CB100-NRB	100BZI	4.000"/100mm
CB120-NRB	120BZI	4.720"/120mm

1 Non-rotating dead length designs are quoted on request.

Changing Fixtures

PAGE 164

Collets

PAGE 153

Accessories

PAGE 165

CB42-NRB Specifications

Back to Content

Collet Model 42BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
1.625" / 42mm

Collet Capacity - Min Clamping Diameter
.156" / 4mm

Collet Clamp Range
+/- .020" / 0.5mm

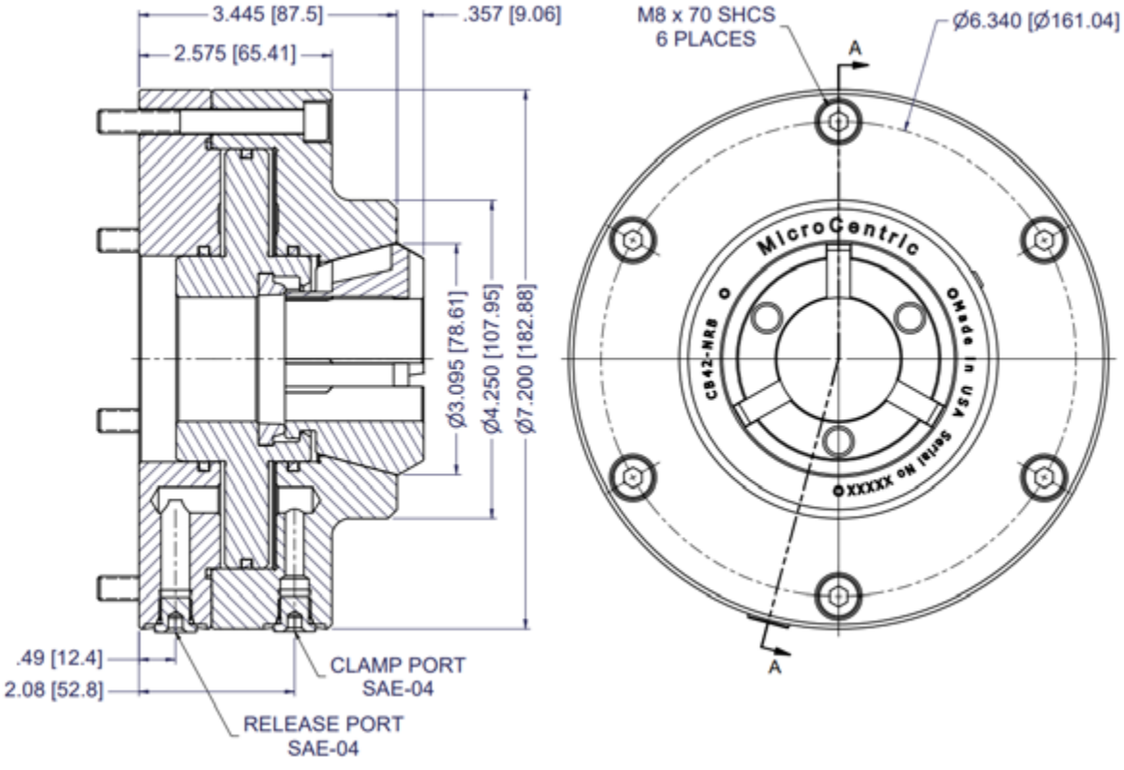
Max Clamping Force
17,985 lb / 80 kN

Max Hydraulic Pressure
420 psi / 2.9 Mpa

Weight
29.02 lb / 13.16 kg

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB65-NRB Specifications

Back to Content

Collet Model 65BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

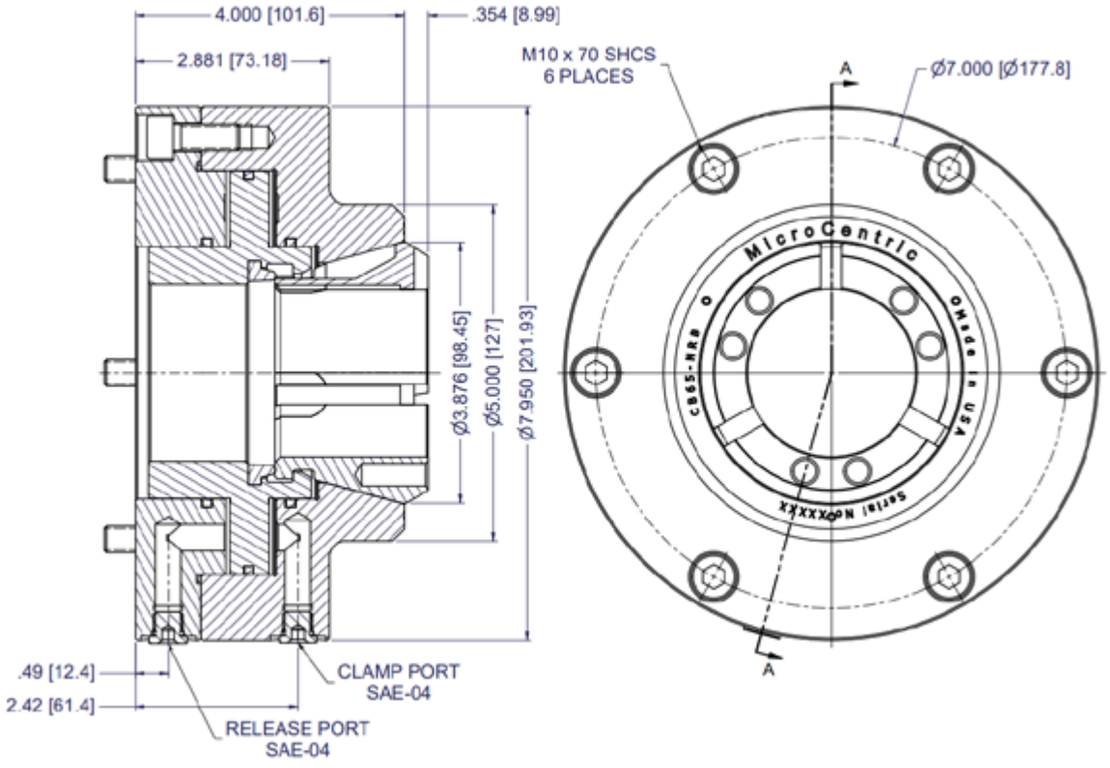
Max Clamping Force
23,605 lb / 105 kN

Max Hydraulic Pressure
580 psi / 4.0 Mpa

Weight
38.44 lb / 17.44 kg

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB80-NRB Specifications

Back to Content

Collet Model 80BZI

Accuracy - Max Radial Runout*
.0004" / 0.010mm

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Collet Clamp Range
+/- .020" / 0.5mm

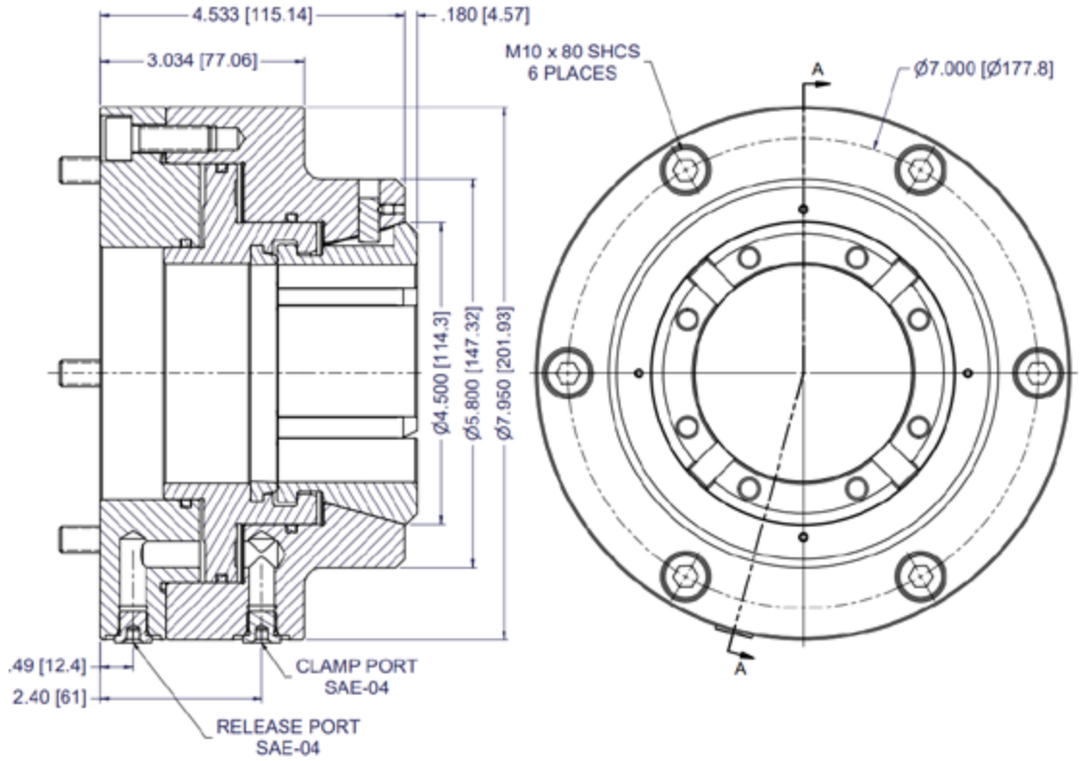
Max Clamping Force
25,853 lb / 115 kN

Max Hydraulic Pressure
760 psi / 5.2 Mpa

Weight
40.69 lb / 18.46 kg

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB100-NRB Specifications

Back to Content

Collet Model 100BZI

Accuracy - Max Radial Runout*
.0006" / 0.015mm

Collet Capacity - Max Clamping Diameter
4.000" / 100mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

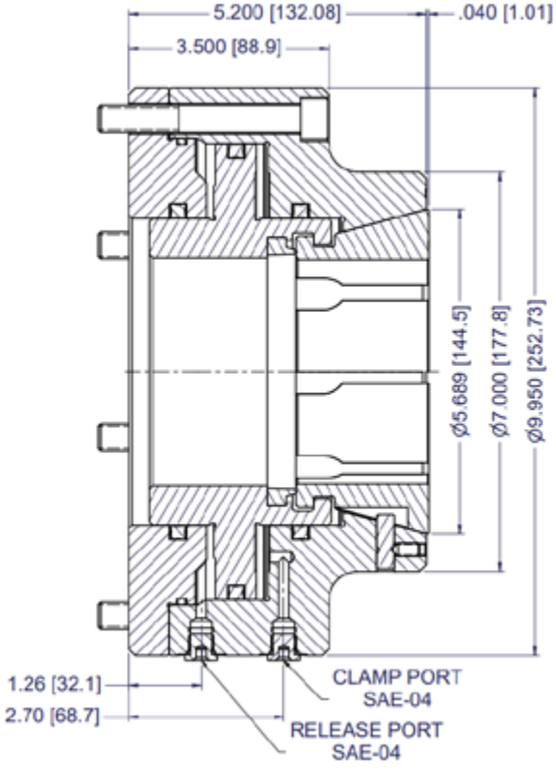
Max Clamping Force
33,721 lb / 150 kN

Max Hydraulic Pressure
530 psi / 3.7 Mpa

Weight
68.55 lb / 31.09 kg

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

CB120-NRB Specifications

Back to Content

Collet Model 120BZI

Accuracy - Max Radial Runout*
.001" / 0.025mm

Collet Capacity - Max Clamping Diameter
4.725" / 120mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

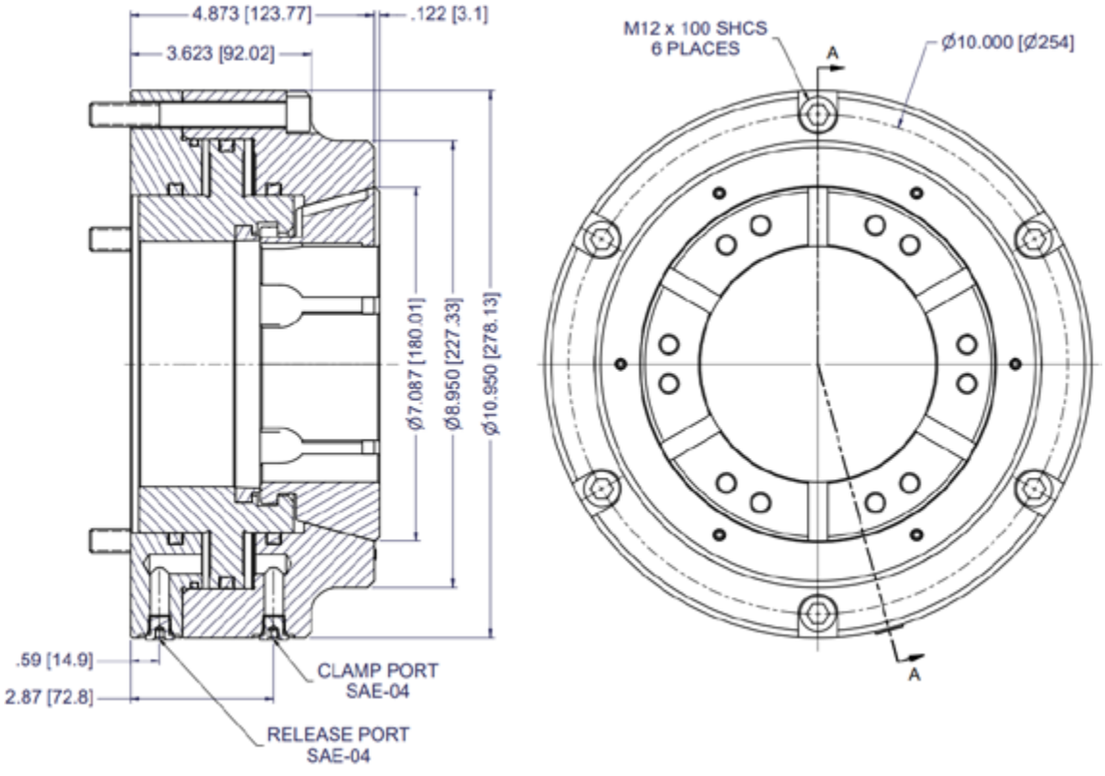
Max Clamping Force
35,969 lb / 160 kN

Max Hydraulic Pressure
550 psi / 3.8 Mpa

Weight
85.26 lb / 38.67kg

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

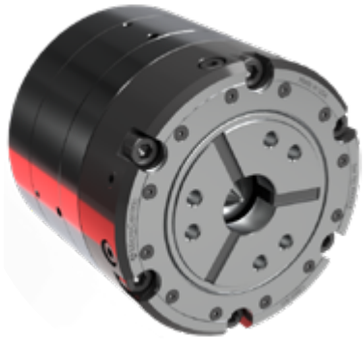
Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data CB-AG

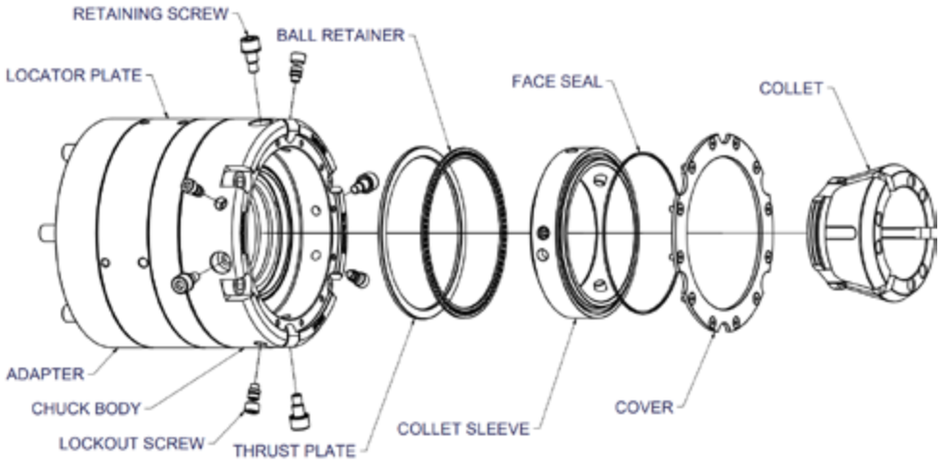
Back to Content



- 1.5mm / .060" total compensation
- Mounting in ID of chuck body for mounting locating centers
- Radial adjusting screws to true-up locating center within .0002" / 0.005mm
- Lubricated-for-life design requires minimal maintenance
- Compact design for greater rigidity
- Collet seat can be locked out for clamping parts on-center
- All components hardened and precision ground for highest accuracy and long life

Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
CB65-AG/A5	A2-5	65BZI	2.625/66mm
CB65-AG/140	140mm	65BZI	2.625/66mm
CB65-AG/A6	A2-6	65BZI	2.625/66mm
CB65-AG/A8	A2-8	65BZI	2.625/66mm

1 CB-AG Chucks with spindle adapters other than those listed above are quoted on request.



Changing Fixtures

PAGE 164

Collets

PAGE 153

Accessories

PAGE 165

CB65-AG Specifications

Back to Content

Collet Model 65BZI

Total Compensation
.060" / 1.50mm

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
.160" / 4mm

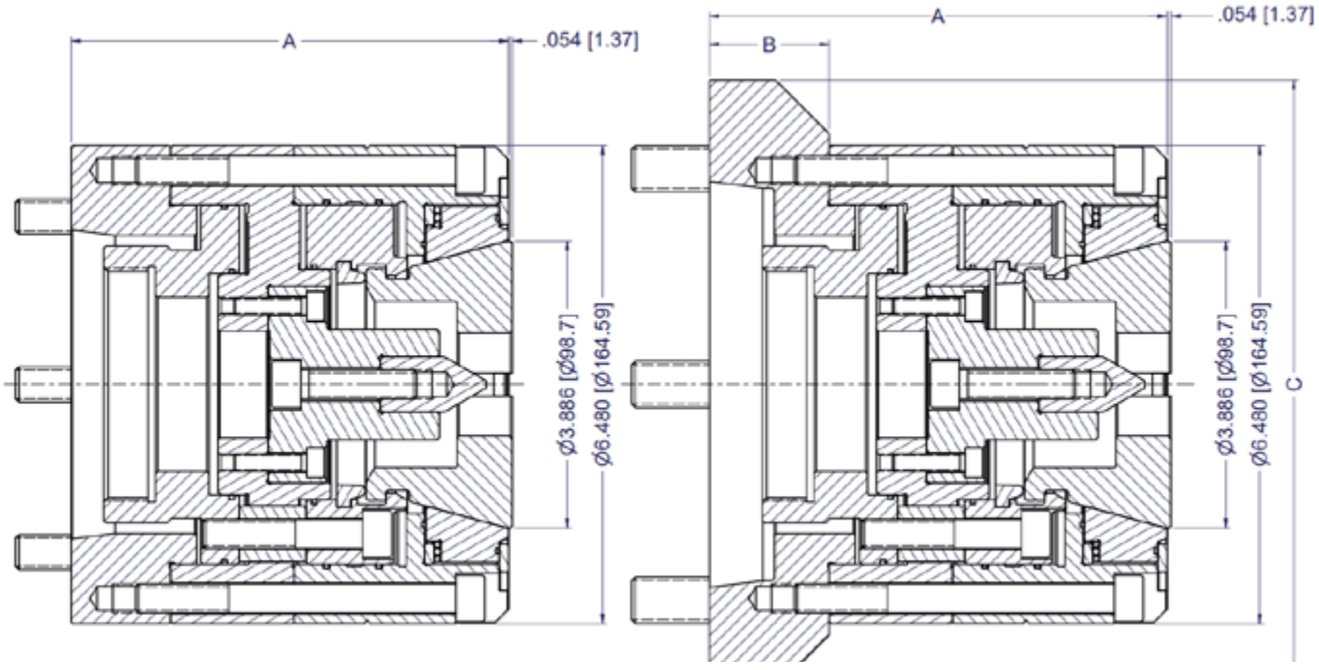
Max Draw Tube Force
10,116 lb / 45 kN

Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
4,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order



Maximum runout of workpiece measured 1.25" (32mm) from face of collet.

Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Technical Data WSF

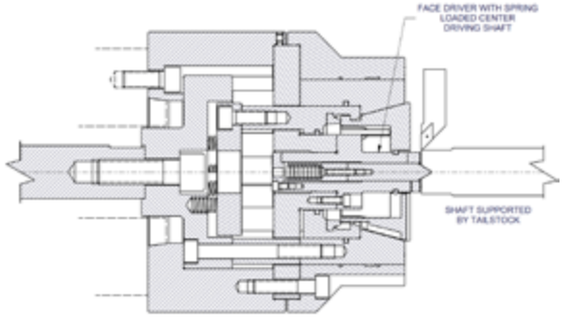
Back to Content

- Mounting for face driver in ID of chuck assembly
- Radial adjusting screws to true-up chuck assembly within .0002" / 0.005mm
- All components hardened and precision ground for highest accuracy and long life

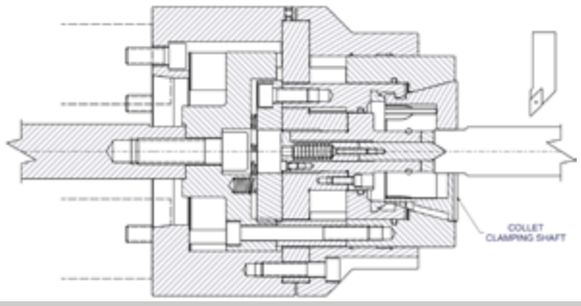
Chuck Model[1]	Spindle Nose	Collet Model	Collet Capacity
WSF-65/A6	A2-6	65BZI	2.625/66mm
WSF-65/A6	A2-6	65BZI	2.625/66mm
WSF-65/A8	A2-8	65BZI	2.625/66mm
WSF-65/A11	A2-11	65BZI	2.625/66mm
WSF-80/A6	A2-6	80BZI	3.250"/82.5mm
WSF-80/A8	A2-8	80BZI	3.250"/82.5mm
WSF-80/A11	A2-11	80BZI	3.250"/82.5mm
WSF-100/A8	A2-8	100BZI	4.000"/100mm
WSF-100/A11	A2-11	100BZI	4.000"/100mm

1 WSF Chucks with spindle adapters other than those listed above are quoted on request.

WSF Collet Chuck
Retracted



WSF Collet Chuck
Clamping Shaft



Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

WSF-65 Specifications

Back to Content

Collet Model 65BZI

Collet Capacity - Max Clamping Diameter
2.625" / 66mm

Collet Capacity - Min Clamping Diameter
.187" / 5mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
1.080" / 27.43mm

Max Draw Tube Force
10,116 lb / 45 kN

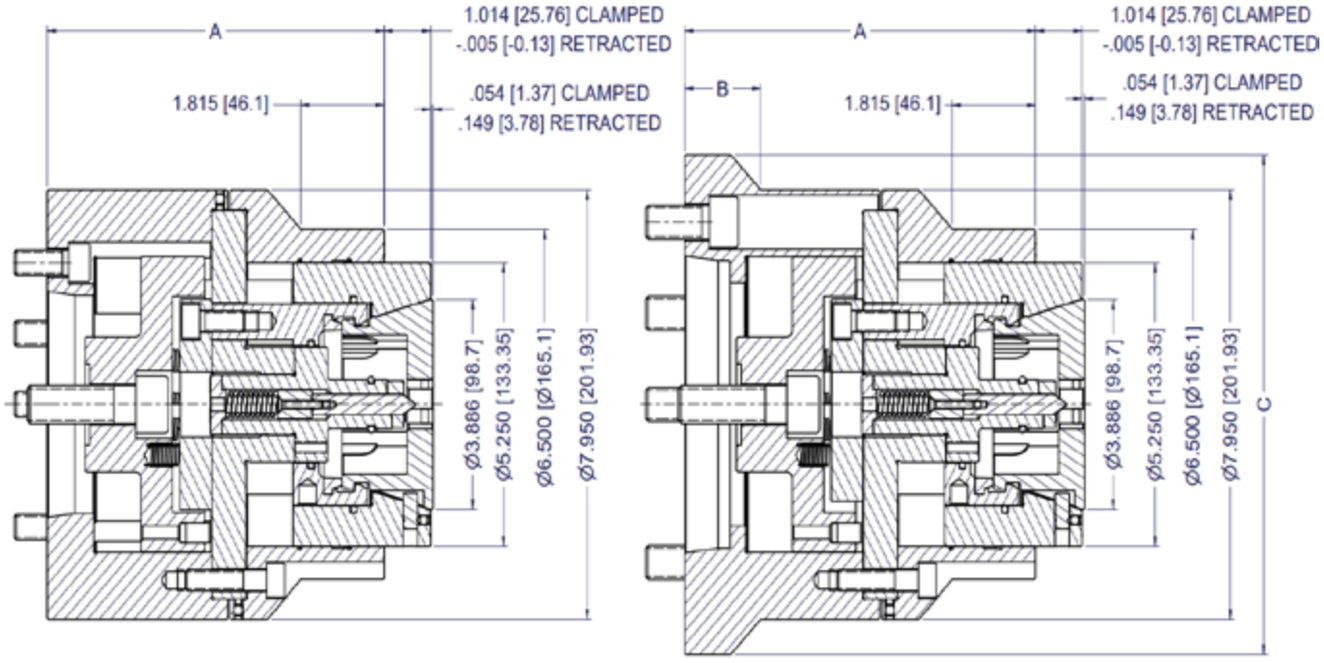
Max Clamping Force
23,605 lb / 105 kN

Maximum Speed
4,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	B	C	Chuck Weight
WSF-65/A5	1	A2-5	7.335" 186.31 mm	- -	- -	79.30 lb 35.96 kg
WSF-65/A6	1	A2-6	7.335" 186.31 mm	- -	- -	78.47 lb 35.59 kg
WSF-65/A8	2	A2-8	7.635" 193.93 mm	1.650" 41.91 mm	9.250" 234.95 mm	82.20 lb 37.28 kg
WSF-65/A11	2	A2-1	7.400" 187.96 mm	2.405" 61.09 mm	10.950" 278.13 mm	95.60 lb 43.36 kg



Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

WSF-80 Specifications

Back to Content

Collet Model 80BZI

Collet Capacity - Max Clamping Diameter
3.250" / 82.5mm

Collet Capacity - Min Clamping Diameter
.500" / 12mm

Collet Clamp Range
+/- .020" / 0.5mm

Chuck Stroke - Linear
1.341" / 34.06mm

Max Draw Tube Force
11,240 lb / 50 kN

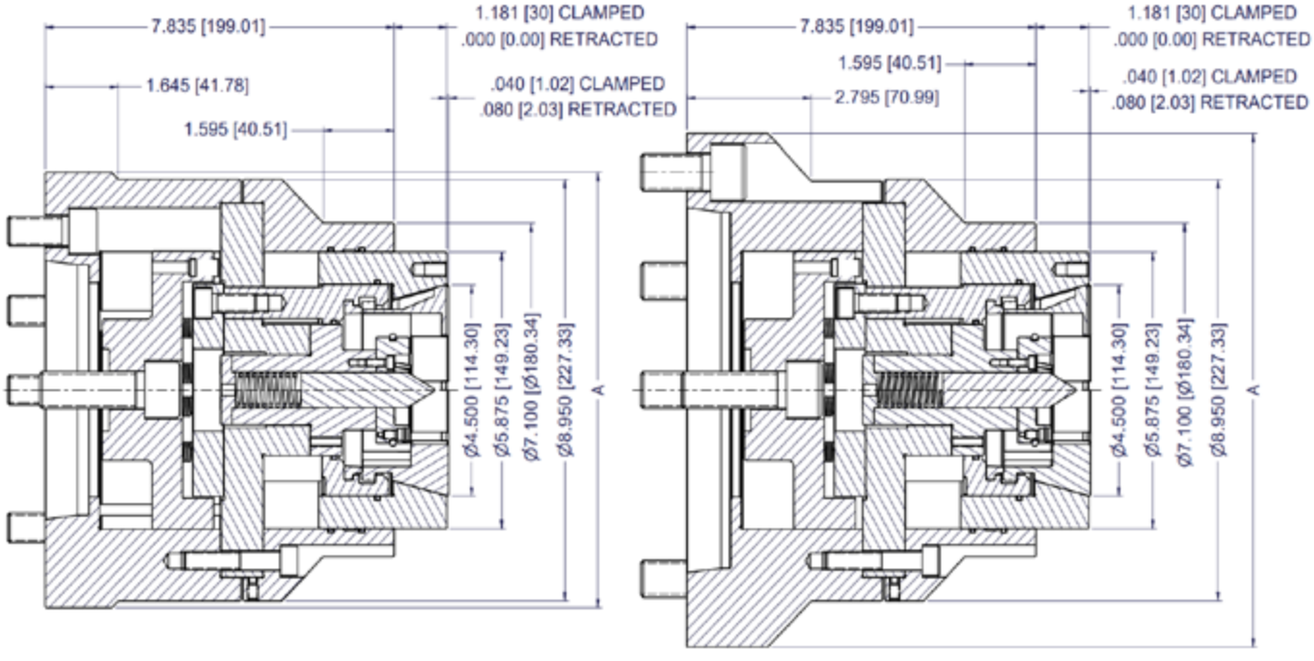
Max Clamping Force
25,853 lb / 115 kN

Maximum Speed
3,500 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	Chuck Weight
WSF-80/A6	1	A2-6	8.950" 227.33mm	102.91 lb 46.67 kg
WSF-80/A8	1	A2-8	9.250" 234.95mm	104.09 lb 47.21 kg
WSF-80/A11	2	A2-11	10.908" 277.05mm	115.59 lb 52.42 kg



Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

WSF-100 Specifications

Back to Content

Collet Model 100BZI

Collet Capacity - Max Clamping Diameter
4.000" / 100mm

Collet Capacity - Min Clamping Diameter
1.00" / 25mm

Collet Clamp Range
+/- .040" / 1mm

Chuck Stroke - Linear
1.750" / 44.45mm

Max Draw Tube Force
14,612 lb / 65 kN

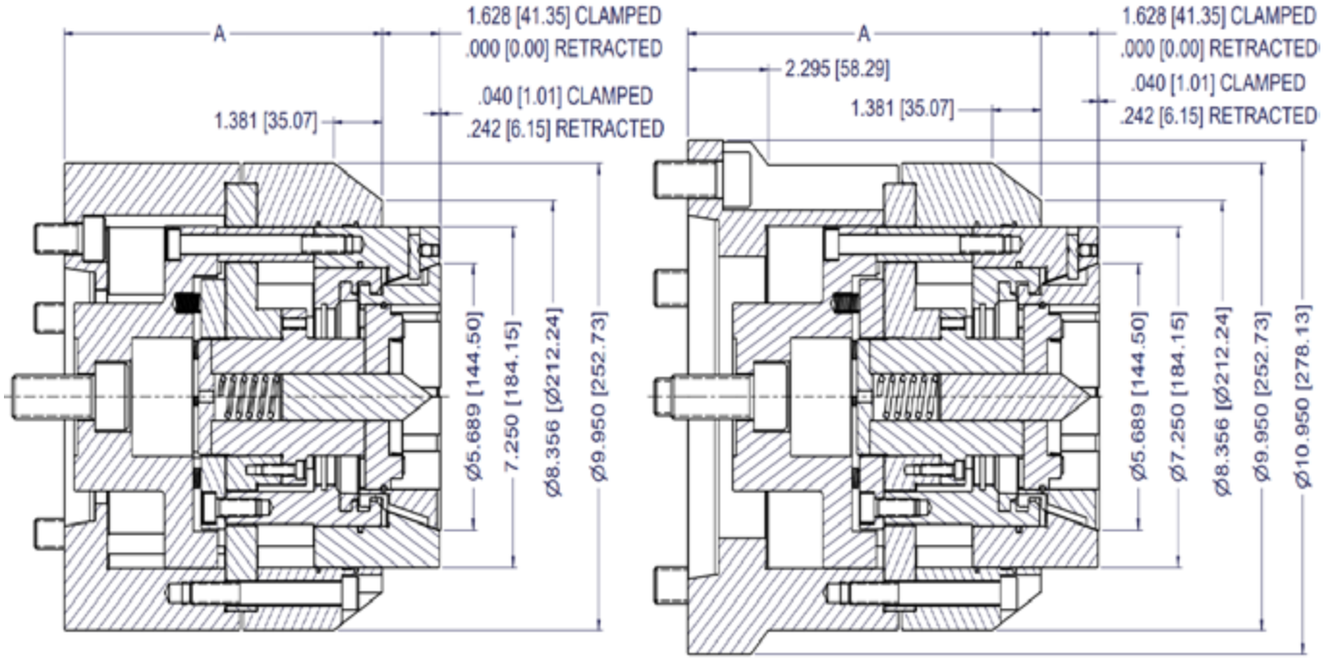
Max Clamping Force
33,721 lb / 150 kN

Maximum Speed
3,000 rpm

Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

Chuck Model	Fig.	Spindle Nose	A	Chuck Weight
WSF-100/A8	1	A2-8	9.065" 230.25mm	165.84 lb 75.21 kg
WSF-100/A11	2	A2-11	10.065" 255.65mm	174.96 lb 79.35 kg



Changing Fixtures
PAGE 164

Collets
PAGE 153

Accessories
PAGE 165

Quick Change Collets

01. Standard Collet

Recommended for bar and most chucking application

02. Reduced Nose

Recommended for chucking applications, when the clamping length is under .500" / 12.7mm

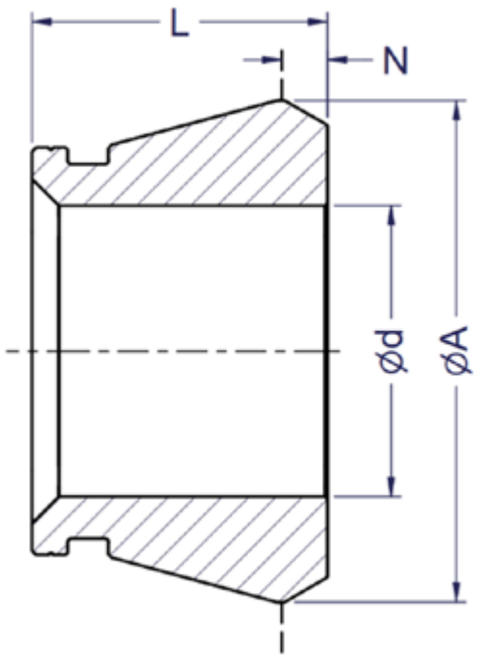
03. Machinable Collet

Can be machined to special bore diameters or other special configurations

One Piece Vulcanized Design

MicroCentric Quick Change Collets are hardened and precision ground segments held together by vulcanized rubber. The vulcanized design produces a seal that prevents chips and sludge from accumulating inside the collet chuck. MicroCentric's vulcanizing technology produces a permanent bond between rubber and metal.

Model	No. of Segments	ød max	øA	L	N	Range
SK42BZI	3	1.625"/ 42mm	3.085"/ 78.4mm	1.850" / 47mm	0.354"/ 9mm	+/- .020/ +/- 0.5mm
SK42BZI/G				1.550"/ 39.4mm	.055"/ 1.4mm	
SK52BZI		2.000"/ 52mm	3.122"/ 79.3mm	1.811" / 46mm	0.157"/ 4mm	
SK65BZI		2.625"/ 66mm	3.886"/ 98.7mm	2.284"/ 58mm	0.354"/ 9mm	
SK65BZI/G				1.984"/ 50.4mm	.055"/ 1.4mm	
SK80BZI	4	3.250"/ 82.5mm	4.500"/ 114.3mm	2.085"/ 53mm	0.181"/ 4.6mm	
SK100BZI	6	4.000"/ 101.5mm	5.689"/ 144.5mm	2.323"/ 59mm	0.039"/ 1mm	+/- .040"/ +/- 1.0mm
SK120BZI		4.725"/ 120mm	7.087"/ 180mm	2.402"/ 61mm	0.118"/ 3mm	
SK140BZI		5.551"/ 140mm	7.700"/ 195.6mm	2.480"/ 63mm	0.177"/ 4.5mm	
SK160BZI		6.300"/ 160mm	8.858"/ 225mm		0.197"/ 5mm	



Back to Content

SK42BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK42BZI	3	1.625" 42mm	3.085" 78.4mm	1.850" 47mm	0.354" 9mm	+/- .020 +/- 0.5mm

Configuration		Range
Round	RSR (Serrated)* RSM (Smooth)*	.312 - 1.625" / 8 - 42mm .187 - 1.625" / 5 - 42mm
Hex	HEX (Smooth)*	.187 - 1.406" / 5 - 36mm
Square	SQR (Smooth)	.250 - 1.125" / 6 - 28mm

SK42BZI/G Reduced Nose Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK42BZI/G	3	1.625" 42mm	3.085" 78.4mm	1.550" 39.4mm	.055" 1.4mm	+/- .020 +/- 0.5mm

Configuration		Range
Round	RSM (Smooth)	.187 - 1.625"/ 5 - 42mm
Hex	HEX (Smooth)	.187 - 1.406"/ 5 - 36mm
Square	SQR (Smooth)	.250 - 1.125"/ 6 - 29mm

SK42BZI/HSW Machinable Collets & AR42 Loading

Item	Description	Bore Size
SW42BZI	Machinable Collet	.312" / 8mm
AR42	Loading Ring	

The SK42BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or

configuration required. The AR42 loading ring is used to preload the collet during machining.

Back to Content

SK52BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK52BZI	3	2.000" 52mm	3.122" 79.3mm	1.811" 46mm	0.157" 4mm	+/- .020 +/- 0.5mm

Configuration		Range
Round	RSR (Serrated)* RSM (Smooth)*	.375 - 2.000"/ 9 - 52mm .187 - 2.000"/ 5 - 52mm
Hex	HEX (Smooth)*	.250 - 1.750"/ 6 - 45mm
Square	SQR (Smooth)	.250 - 1.437"/ 6 - 36mm

SK52BZI/HSW Machinable Collets & AR52 Loading Rings

Item	Description	Bore Size
SK52BZI/HSW	Machinable Collet	.312" / 8mm
AR52	Loading Ring	

The SK52BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or

configuration required. The AR52 loading ring is used to preload the collet during machining.

Back to Content

SK65BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK65BZI	3	2.625" 66mm	3.886" 98.7mm	2.284" 58mm	0.354" 9mm	+/- .020" +/- 0.5mm

Configuration		Range
Round	RSR (Serrated)* RSM (Smooth)*	.375 - 2.562"/ 9 - 65mm .187- 2.625"/ 5 - 66mm
Hex	HEX (Smooth)*	.250 - 2.250"/ 6 - 57mm
Square	SQR (Smooth)	.250 - 1.812"/ 6 - 46mm

SK65BZI/G Reduced Nose Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK65BZI/G	3	2.625" 66mm	3.886" 98.7mm	1.984" 50.4mm	.055" 1.4mm	+/- .020" +/- 0.5mm

Configuration		Range
Round	RSM (Smooth)	.187 - 2.625"/ 5 - 66mm
Hex	HEX (Smooth)	.250 - 2.250"/ 6 - 57mm
Square	SQR (Smooth)	.250 - 1.812"/ 6 - 46mm

SK65BZI S-Pad Master Collets

Collet Pad	Master Collet	Range
S-16	SK65BZI/G/S16	.125" - 1.650"/ 3.2 - 41.3mm
S-20	SK65BZI/S20	.125" - 2.000"/ 3.2 - 50.8mm
S-22	SK65BZI/S22	.125" - 2.250"/ 3.2 - 57.1mm

Master Collets are made from hardened alloy steel, and are precision ground to close tolerances to ensure accuracy and long term performance. Master collets are supplied with clamp screws.

PSK65BZI/HSW Machinable Collets & AR65 Loading Rings

Item	Description	Bore Size
SK65BZI/HSW	Machinable Collet	.312" / 8mm
AR65	Loading Ring	

The SK42BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or

configuration required. The AR42 loading ring is used to preload the collet during machining.

Back to Content

SK80BZI Quick Change Collet

Model	No. of Segments	ød max	øA	L	N	Range
SK80BZI	4	3.250" 82.5mm	4.500" 114.3mm	2.085" 53mm	0.181" 4.6mm	+/- .020" +/- 0.5mm

Configuration		Range
Round	RSR (serrated)* RSM (smooth)*	.750 - 3.250"/ 19 - 82.5mm .500 - 3.250" 12 - 82.5mm
Hex	HEX (smooth)*	.500 - 2.750"/ 12 - 71mm
Square	SQR (smooth)	.500 - 2.250"/ 12 - 58mm

SK80BZI S-Pad Master Collets

Collet Pad	Master Collet	Range
S-26	SK80BZI/S26	.125" - 2.650" 3.2 - 66.7mm
S-30	SK80BZI/S30	.125" - 3.000" 3.2 - 76.2mm

Master Collets are made from hardened alloy steel, and are precision ground to close tolerances to ensure accuracy and long term performance. Master collets are supplied with clamp screws.

SK80BZI/HSW Machinable Collets & AR80 Loading Rings

Item	Description	Bore Size
SK80BZI/HSW	Machinable Collet	.750" / 19mm
AR80	Loading Ring	

The SK80BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

Back to Content

SK100BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK100BZI	6	4.000" 101.5mm	5.689" 144.5mm	2.323" 59mm	0.039" 1mm	+/- .040" +/- 1.0mm

Configuration		Range
Round	RSR (serrated)* RSM (smooth)*	1.000 - 4.000"/ 25 - 101.5mm 1.000 - 4.000"/ 25 -101.5mm
Hex	HEX (smooth)*	1.250 - 3.375"/ 31 - 86mm
Square	SQR (smooth)	

SK100/65BZI & SK100/42BZI Master Collets

Collet Pad	Master Collet	Range
SK100/42BZI	Master Collet	.187 - 1.625" 5 - 42mm
SK100/65BZI	Master Collet	.187- 2.625" 5 - 66mm

The SK100BZI/65BZI and SK100/42BZI master collets contain an additional coupling in the ID of the master collet to allow for the use of SK65BZI and SK42BZI collets in collet chucks designed for SK100BZI Collets.

SK100BZI/HSW Machinable Collets & AR100 Loading Rings

Item	Description	Bore Size
SK100BZI/HSW	Machinable Collet	1.000" / 25.4mm
AR100	Loading Ring	

The SK80BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

Back to Content

SK120BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK120BZI	6	4.725" 120mm	7.087" 180mm	2.402" 61mm	0.118" 3mm	+/- .040" +/- 1.0mm

Configuration		Range
Round	RSR (serrated)* RSM (smooth)*	1.000 - 4.725"/ 25 - 120mm 1.000 - 4.725" 25 -120mm
Hex	HEX (smooth)*	1.250 - 4.062"/ 31 - 103mm
Square	SQR (smooth)	1.250 - 3.343"/ 31 - 85mm

SK120BZI/HSW Machinable Collets & AR120 Loading Rings

Item	Description	Bore Size
SK120BZI/HSW	Machinable Collet	1.500" / 38.1mm
AR120	Loading Ring	

The SK120BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

Back to Content

SK140BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK140BZI	6	5.551" 140mm	7.700" 195.6mm	2.480" 63mm	0/177" 4.5mm	+/- .040" +/- 1.0mm

Configuration		Range
Round	RSR (serrated)* RSM (smooth)*	1.000 - 5.510"/ 25 - 140mm 1.000 - 5.10" 25 -140mm
Hex	HEX (smooth)*	1.250 - 4.750"/ 31 - 121mm
Square	SQR (smooth)	1.250 - 3.906"/ 31 - 99mm

SK140BZI/HSW Machinable Collets & AR140 Loading Rings

Item	Description	Bore Size
SK140BZI/HSW	Machinable Collet	1.500" / 38.1mm
AR140	Loading Ring	

The SK140BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

Back to Content

SK160BZI Quick Change Collets

Model	No. of Segments	ød max	øA	L	N	Range
SK160BZI	6	6.300" 160mm	8.858" 225mm	2.480" 63mm	0.197" 5mm	+/- .040" +/- 1.0mm

Configuration		Range
Round	RSR (serrated)* RSM (smooth)*	1.000 - 6.300"/ 25 - 160mm 1.000 - 6.300" 25 -160mm
Hex	HEX (smooth)*	1.250 - 5.375"/ 31 - 136mm
Square	SQR (smooth)	1.250 - 4.500"/ 31 - 114mm

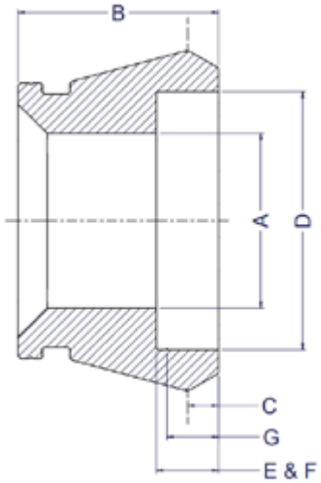
SK160BZI/HSW Machinable Collets & AR160 Loading Rings

Item	Description	Bore Size
SK160BZI/HSW	Machinable Collet	1.500" / 38.1mm
AR160	Loading Ring	

The SK160BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

Maximum Collet Counter Bores

Back to Content



				For Maximum Turning Diameter		For Maximum Clamping Depth			
Model	Through Capacity	Overall Length	Collet Protrusion Length	Maximum Turning Dia.	Maximum Turning Depth at Max. Dia.	Maximum Turning Dia. at Max Depth	Maximum Turning Depth	Minimum Turning Depth*	Minimum Clamping Depth of Workpiece
	A	B	C	D	E	D	E	F	G
SK42BZI	1.625"/ 42.0mm	1.850"/ 47.0mm	0.354"/ 9.0mm	2.441"/ 62.0mm	0.669"/ 17.0mm	1.772"/ 45.0mm	1,063"/ 27.0mm	0.610"/ 15.5mm	0.472"/ 12.0mm
SK42BZIG	1.625"/ 42.0mm	1.551"/ 39.4mm	0.055"/ 1.4mm	2.441"/ 62.0mm	0.370"/ 9.4mm	1.772"/ 45.0mm	0.764"/ 19.4mm	0.311"/ 7.9mm	0.173"/ 4.4mm
SK52BZI	2.000"/ 52.0mm	1.811"/ 46.0mm	0.157"/ 4.0mm	2.441"/ 62.0mm	0.551"/ 14.0mm	2.110"/ 53.6mm	0.709"/ 18.0mm	0.413"/ 10.5mm	0.276"/ 7.0mm
SK65BZI	2.625"/ 66.7mm	2.283"/ 58.0mm	0.354"/ 9.0mm	3.071"/ 78.0mm	0.748"/ 19.0mm	2.665"/ 67.7mm	1.339"/ 34.0mm	0.610"/ 15.5mm	0.472"/ 12.0mm
SK65BZIG	2.625"/ 66.7mm	1.984"/ 50.4mm	0.055"/ 1.4mm	3.071"/ 78.0mm	0.449"/ 11.4mm	2.665"/ 67.7mm	1.039"/ 26.4mm	0.311"/ 7.9mm	0.173"/ 4.4mm
SK80BZI	3.250"/ 82.5mm	2.087"/ 53.0mm	0.181"/ 4.6mm	3.583"/ 91.0mm	0.575"/ 14.6mm	3.287"/ 83.5mm	1.205"/ 30.6mm	0.437"/ 11.1mm	0.299"/ 7.6mm
SK100BZI	4.000"/ 101.5mm	2.323"/ 59.0mm	0.039"/ 1.0mm	4.606"/ 117.0mm	0.827"/ 21.0mm	4.114"/ 104.5mm	1.260"/ 32.0mm	0.394"/ 10.0mm	0.157"/ 4.0mm
SK120BZI	4.724"/ 120.0mm	2.402"/ 61.0mm	0.118"/ 3.0mm	5.984"/ 152.0mm	0.709"/ 18.0mm	5.551"/ 141.0mm	1.398"/ 35.5mm	0.374"/ 9.5mm	0.236"/ 6.0mm
SK140BZI	5.510"/ 140.0mm	2.480"/ 63.0mm	0.177"/ 4.5mm	6.693"/ 170.0mm	0.728"/ 18.5mm	5.669"/ 144.0mm	1.437"/ 36.5mm	0.492"/ 12.5mm	0.335"/ 8.5mm
SK160BZI	6.300"/ 160.0mm	2.480"/ 63.0mm	0.197"/ 5.0mm	8.268"/ 210.0mm	0.472"/ 12.0mm	7.362"/ 187.0mm	1.260"/ 32.0mm	0.472"/ 12.0mm	0.315"/ 8.0mm

*Minimum turning depth values apply to pull back style chucks only. For dead length chucks, minimum turning depth is equal to minimum clamping depth of workpiece.

Collet Changing Fixtures

Back to Content

A changing fixture is used to install and remove MicroCentric collets from the chuck. Pins in the pivoting jaws of the changing fixture are inserted into the holes on the face of the collet. When the changing fixture is actuated, the rear of the collet collapses and allows the collet to be coupled or uncoupled from the chuck.

CG Pistol Grip Fixture

The CG fixture is manually actuated and is available for 42, 52, 65, and 80mm size collets.

CP Pneumatic Fixture

The CP fixture is a self-contained pneumatic design available for all collets sizes up to 140mm.

CH Hydraulic Fixture

The CH fixture is a self-contained design actuated by the EN162 hydraulic pump. CH fixtures are available for 120, 140, and 160mm size collets.
It will need an Hydraulic Pump to actuate the changing fixture.

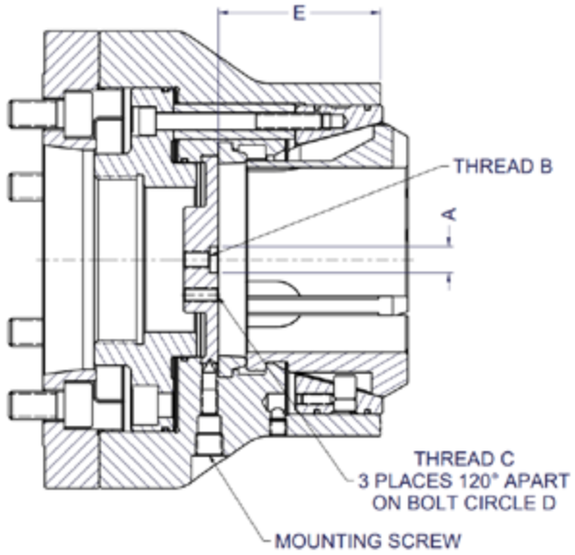
Changing Fixture	Type
SK42BZI Collets	
CP42	Pneumatic
CG42	Pistol Grip
SK52BZI Collets	
CG52	Pistol Grip
SK65 BZI Collets	
CP65	Pneumatic
CG65	Pistol Grip
SK80BZI Collets	
CP80	Pneumatic
CG80	Pistol Grip
SK100BZI Collets	
CP100	Pneumatic

Changing Fixture	Type
SK120BZI Collets	
CP120	Pneumatic
CH120 + EN162	Hydraulic + Hydraulic Pump
SK140BZI Collets	
CP140	Pneumatic
CH140 + EN162	Hydraulic + Hydraulic Pump
SK160BZI Collets	
CH160 + EN162	Hydraulic + Hydraulic Pump

Stop Plates

Back to Content

Stop plates are available for NX, ND, and NK chucks. Part stops are mounted to the front face of the stop plate to end stop workpieces inside the chuck.



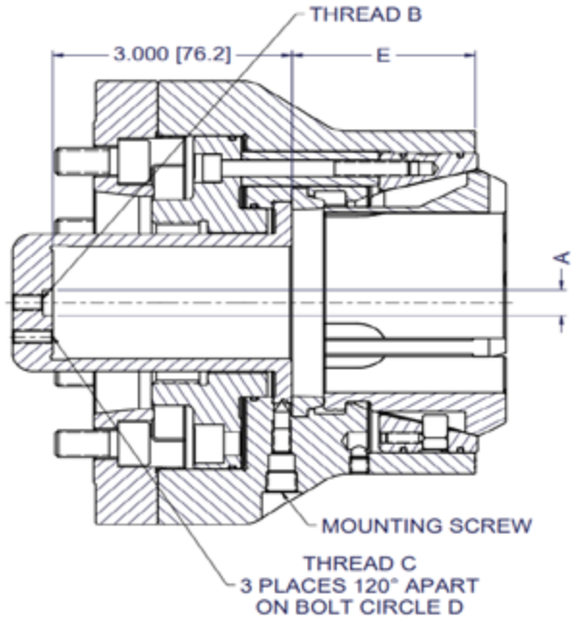
Model	Chuck	A	B	C	D	E
SP-42/D	CB42-NX/ND/NS	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	1.849"/ 46.96mm
SP-42/K	CB42-NK	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.606"/ 66.19mm
SP-52/D	CB52-NX	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.109"/ 53.57mm
SP-65/D	CB65-NX/ND/NS	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.296"/ 58.32mm
SP-65/K	CB65-NK	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	3.165"/ 80.39mm
SP-80/D	CB80-NX/ND	.500"/ 12.7mm	M8	M6	1.250"/ 31.75mm	2.296"/ 58.32mm
SP-80/K	CB80-NK	.500"/ 12.7mm	M8	M6	1.250"/ 31.75mm	3.205"/ 81.41mm
SP-100/D	CB100-NX/ND	0.600"/ 15.2mm	M10	M8	1.500"/ 38.1mm	2.830"/ 71.88mm
SP-100/K	CB100-NK	0.600"/ 15.2mm	M10	M8	1.500"/ 38.1mm	3.170"/ 80.52mm
SP-120/D	CB120-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.650"/ 67.31mm
SP-140/D	CB140-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.578" 65.48mm
SP-160/D	CB160-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.715"/ 68.96mm

Stop plates are made from alloy steel hardened and precision ground, and include a set of mounting screws.

Stop Housings

Back to Content

Stop housings are available for NX, ND, and NK chucks. Part stops are mounted to the inner face of the stop housing to end stop work-pieces deep inside the chuck. Stop housings deeper than 3.00" / 76mm, and stop housings with ejectors or special locators are quoted on request.



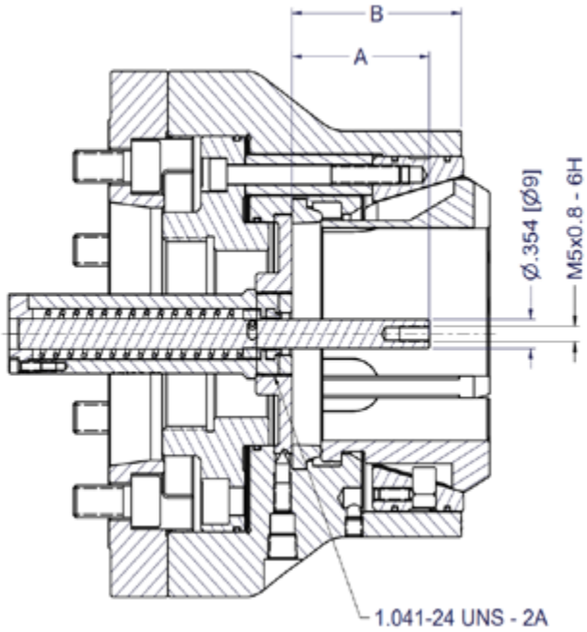
Model	Chuck	A	B	C	D	E
SH-42/D	CB42-NX/ND/NS	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	1.849"/ 46.96mm
SH-42/K	CB42-NK	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.606"/ 66.19mm
SH-52/D	CB52-NX	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.109"/ 53.57mm
SH-65/D	CB65-NX/ND/NS	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	2.296"/ 58.32mm
SH-65/K	CB65-NK	0.375"/ 9.5mm	M6	M5	1.000"/ 25.4mm	3.165"/ 80.39mm
SH-80/D	CB80-NX/ND	.500"/ 12.7mm	M8	M6	1.250"/ 31.75mm	2.296"/ 58.32mm
SH-80/K	CB80-NK	.500"/ 12.7mm	M8	M6	1.250"/ 31.75mm	3.205"/ 81.41mm
SH-100/D	CB100-NX/ND	0.600"/ 15.2mm	M10	M8	1.500"/ 38.1mm	2.830"/ 71.88mm
SH-100/K	CB100-NK	0.600"/ 15.2mm	M10	M8	1.500"/ 38.1mm	3.170"/ 80.52mm
SH-120/D	CB120-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.650"/ 67.31mm
SH-140/D	CB140-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.578"/ 65.48mm
SH-160/D	CB160-ND	0.600"/ 15.2mm	M10	M8	2.500"/ 63.5mm	2.715"/ 68.96mm

Stop plates are made from alloy steel hardened and precision ground, and include a set of mounting screws.

Ejector Assemblies

Back to Content

Spring cartridge ejector assemblies are available for NX, ND, and NK chucks. Ejectors with larger stroke and mounted deeper into the ID of the chuck are quoted on request.



Model	Chuck	A	B
AW42-20/D	CB42-NX/ND/NS	2.00" / 50.8mm	1.849" / 46.96mm
AW42-30/D	CB42-NX/ND/NS	3.00" / 76.2mm	1.849" / 46.96mm
AW42-20/K	CB42-NK	2.00" / 50.8mm	2.606" / 66.19mm
AW42-30/K	CB42-NK	3.00" / 76.2mm	2.606" / 66.19mm
AW52-20/D	CB52-NX	2.00" / 50.8mm	2.109" / 53.57mm
AW52-30/D	CB52-NX	3.00" / 76.2mm	2.109" / 53.57mm
AW65-20/D	CB65-NX/ND/NS	2.00" / 50.8mm	2.296" / 58.32mm
AW65-30/D	CB65-NX/ND/NS	3.00" / 76.2mm	2.296" / 58.32mm
AW65-20/K	CB65-NK	2.00" / 50.8mm	3.165" / 80.39mm
AW65-30/K	CB65-NK	3.00" / 76.2mm	3.165" / 80.39mm
AW80-20/D	CB80-NX/ND	2.00" / 50.8mm	2.296" / 58.32mm
AW80-30/D	CB80-NX/ND	3.00" / 76.2mm	2.296" / 58.32mm
AW80-20/K	CB80-NK	2.00" / 50.8mm	3.205" / 81.41mm
AW80-30/K	CB80-NK	3.00" / 76.2mm	3.205" / 81.41mm
AW100-20/D	CB100-NX/ND	2.00" / 50.8mm	2.830" / 71.88mm
AW100-30/D	CB100-NX/ND	3.00" / 76.2mm	2.830" / 71.88mm

Model	Chuck	A	B
AW100-20/K	CB100-NK	2.00" / 50.8mm	3.170" / 80.52mm
AW100-30/K	CB100-NK	3.00" / 76.2mm	3.170" / 80.52mm
AW120-20/D	CB120-ND	2.00" / 50.8mm	2.650" / 67.31mm
AW120-30/D	CB120-ND	3.00" / 76.2mm	2.650" / 67.31mm
AW140-20/D	CB140-ND	2.00" / 50.8mm	2.578" / 65.48mm
AW140-30/D	CB140-ND	3.00" / 76.2mm	2.578" / 65.48mm
AW160-20/D	CB160-ND	2.00" / 50.8mm	2.715" / 68.96mm
AW160-30/D	CB160-ND	3.00" / 76.2mm	2.715" / 68.96mm

Ejector assemblies are made from alloy steel hardened and precision ground alloy steel, and include an ejector mounting plate and a set of mounting screws.

Conventional Collet Chucks

Back to Content

MODULAR DESIGN

- CHUCK BODY ASSEMBLY
- SPINDLE ADAPTER PLATE
- DRAW TUBE ADAPTER

SPINDLE ADAPTER PLATE

RADIAL ADJUSTING SCREWS

ALL COMPONENTS: HARDENED & PRECISION GROUND ALLOY STEEL

DRAW TUBE ADAPTER TO FIT EXISTING DRAW TUBE

Conventional Collet Chucks

Back to Content

5C-ND Dead Length Collet Chucks

Introducing our advanced dead length chuck design with a reduced nose, ideal for full-size machines and sub spindles. Crafted from precision-ground hardened alloy steel components, our modular chuck design ensures adaptability to any machine spindle and draw tube configuration, with internal components sealed to prevent chip accumulation for sustained long-term performance.

5C-D Dead Length Collet Chucks

Introducing our advanced dead length chuck design featuring reduced diameter mounting, tailored for smaller machines and rotary tables. Crafted from precision-ground hardened alloy steel components, our modular chuck design guarantees adaptability to any machine spindle and draw tube configuration, with internal components sealed to prevent chip accumulation, ensuring enduring accuracy and long-term performance.

LD Air Cylinder for 5C-D Collet Chucks

Introducing our innovative air cylinder accessory, seamlessly mounted to the front of the machine spindle for improved functionality. Air supply is efficiently managed through a rotating air tube assembly, ensuring precise operation. With a versatile modular design adaptable to all machine spindle configurations, and constructed from hardened alloy steel components precision-ground for accuracy and longevity, our accessory guarantees optimal performance for diverse machining needs.

16C Dead Length Collet Chucks

Presenting our dead length chuck design boasting a reduced nose for enhanced versatility. Crafted with precision-ground hardened alloy steel components, each chuck ensures long-term performance with sealed internal components to prevent chip accumulation. Our modular chuck design seamlessly adapts to any machine spindle and draw tube configuration, guaranteeing precision and reliability across various applications.

3J-ND Dead Length Collet Chucks

Introducing our dead length chuck design featuring a reduced nose for optimal performance. Crafted with precision-ground hardened alloy steel components, each chuck ensures enduring accuracy, with internal sealing to prevent chip accumulation. Our modular chuck design adapts seamlessly to any machine spindle and draw tube configuration, providing unparalleled versatility and reliability.

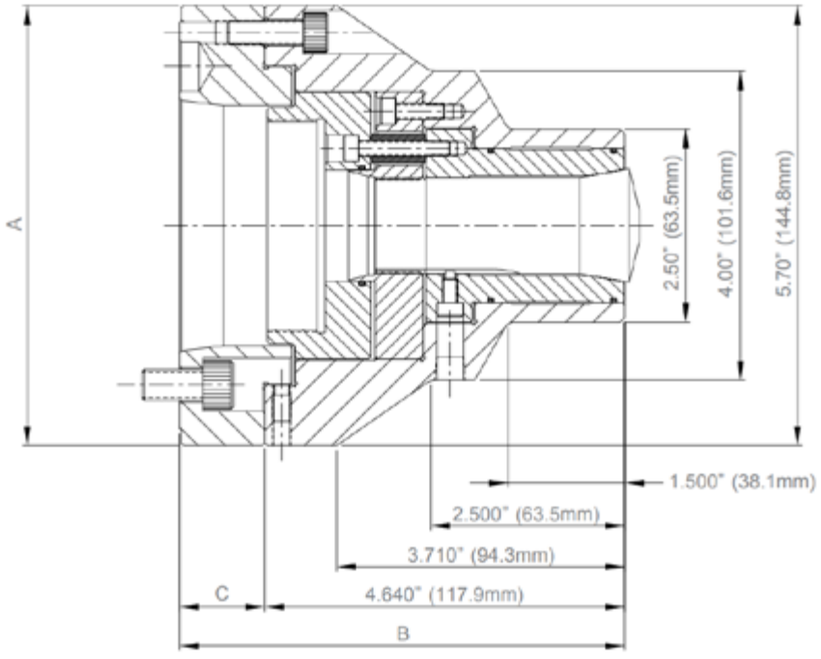
5C-ND Dead Length Collet Chucks

Back to Content

- Dead length design with reduced nose for full size machines and sub spindles
- All components are hardened alloy steel precision ground for accuracy and long term performance.
- Internal components are sealed to prevent chip accumulation inside chuck body
- Modular chuck design can be adapted to any machine spindle and draw tube configuration
- Call for spindle mountings not listed

Model[1]	Collet Model	Spindle Nose	Max. Speed	Through Capacity	Linear Chuck Stroke	Chuck Weight
CB5C-ND/A5	5C	A2-5	6,000 rpm	1.062 in/ 27 mm	0.078 in/ 2.0 mm	15.1 lb/ 6.7 kg
CB5C-ND/A6	5C	A2-6	6,000 rpm	1.062 in/ 27 mm	0.078 in/ 2.0 mm	15.3 lb/ 6.8 kg
CB5C-ND/8	5C	A2-8	6,000 rpm	1.062 in/ 27 mm	0.078 in/ 2.0 mm	23.5 lb/ 10.4 kg
CB5C-ND/140	5C	140mm	6,000 rpm	1.062 in/ 27 mm	0.078 in/ 2.0 mm	15.1 lb/ 6.7 kg

1 CB5C-ND Chucks with spindle adapters other than those listed above are quoted on request.



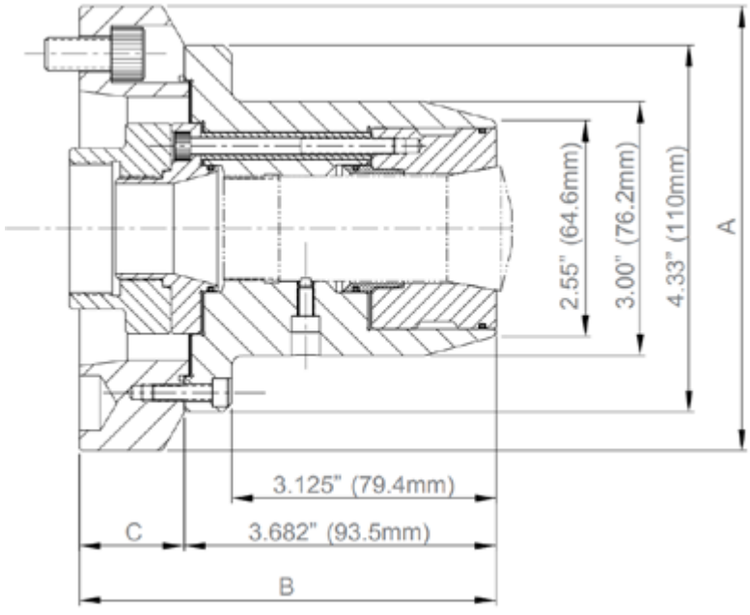
5C-D Dead Length Collet Chucks

Back to Content

- Dead length design with reduced diameter mounting for smaller machines and rotary tables
- All components are hardened alloy steel precision ground for accuracy and long term performance
- Internal components are sealed to prevent chip accumulation inside chuck body
- Modular chuck design can be adapted to any machine spindle and draw tube configuration
- Call for spindle mountings not listed

Model[1]	Collet Model	Spindle Nose	Max. Speed	Through Capacity	Linear Chuck Stroke	Chuck Weight
CB5C-D/A4	5C	A2-4	6,000 rpm	1.062 in 27 mm	0.078 in 2.0 mm	8.9 lb 4 kg
CB5C-D/A5	5C	A2-5	6,000 rpm	1.062 in 27 mm	0.078 in 2.0 mm	10.0 lb 4.4 kg
CB5C-D/85	5C	85mm	6,000 rpm	1.062 in 27 mm	0.078 in 2.0 mm	7.9 lb 3.5 kg
CB5C-D/110	5C	110mm	6,000 rpm	1.062 in 27 mm	0.078 in 2.0 mm	8.9 lb 4 kg
CB5C-D/140	5C	140mm	6,000 rpm	1.062 in 27 mm	0.078 in 2.0 mm	10.0 lb 4.4 kg

1 CB5C-D Chucks with spindle adapters other than those listed above are quoted on request.

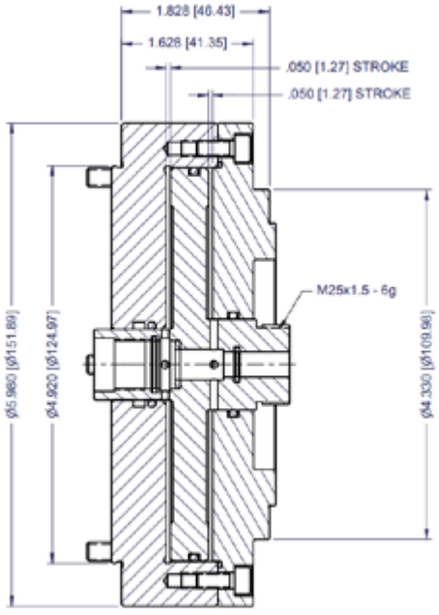


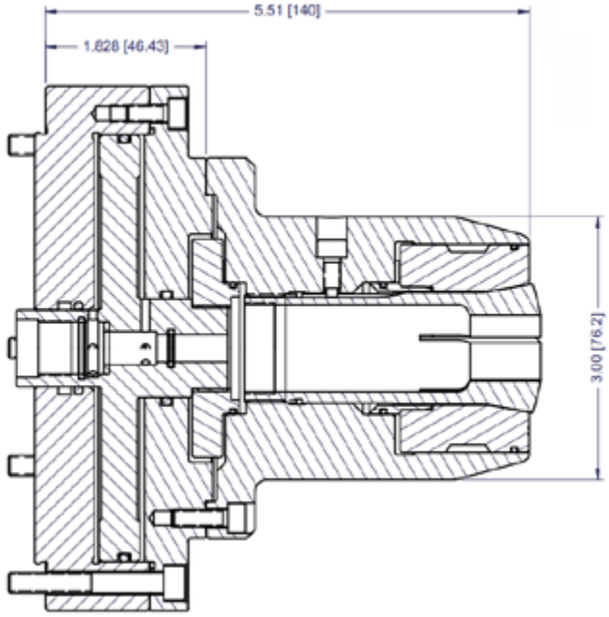
LD Air Cylinders for 5C-D Collet Chucks

Back to Content

- Low profile dead length collet chuck
- Air cylinder mounted to front of machine spindle
- Air is supplied to the air cylinder by a rotating air tube assembly
- Modular design can be adapted to all machine spindle configurations
- All chuck components made from hardened alloy steel, precision ground for accuracy and long term performance

Model	Max. Air Pressure	Draw Tube Force*	Piston Stroke	Draw Tube Stroke	Max Speed	Weight
LD-150	150 psi/ 10.5 kg/cm2	1,800 lb/ 816kg	.100"/ 2.54mm	.394"/ 10mm	6,000 rpm	13.4 lb/ 6.0kg





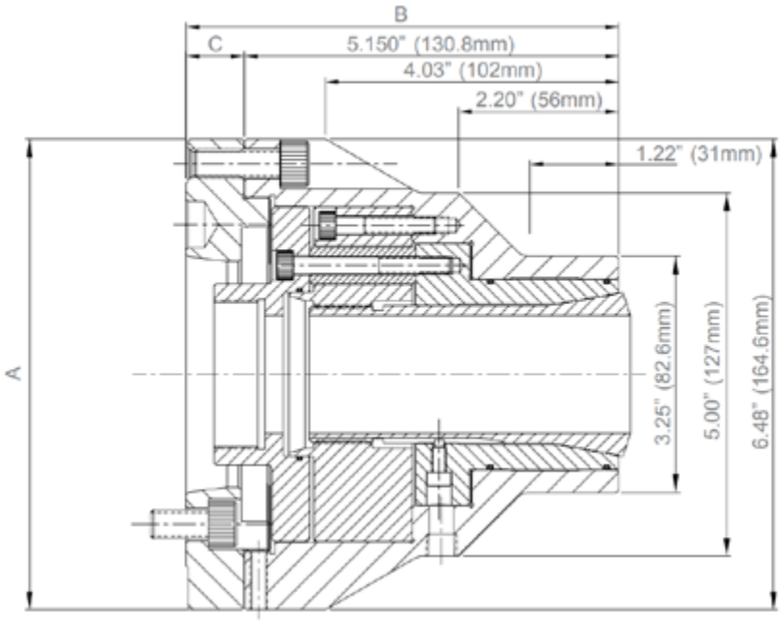
16C Dead Length Collet Chucks

Back to Content

- Dead length design with reduced nose
- All components hardened alloy steel precision ground for accuracy and long term performance
- Internal components are sealed to prevent chip accumulation inside chuck body
- Modular chuck design can be adapted to any machine spindle and draw tube configuration
- Call for spindle mountings not listed

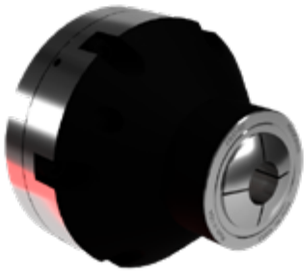
Model[1]	Collet Model	Spindle Nose	Max. Speed	Through Capacity	Draw Tube Stroke	Max. Draw Tube Force	Chuck Weight
CB16C-ND/A5	16C	A2-5	6,000 rpm	1.625"/ 41.2mm	.078"/ 2.0mm	5,400 lb/ 2.450kg	29.0 lb/13.1 kg
CB16C-ND/A6	16C	A2-6	6,000 rpm	1.625"/ 41.2mm	.078"/ 2.0mm	5,400 lb/ 2.450kg	30.2 lb/13.7 kg
CB16C-ND/A8	16C	A2-8	6,000 rpm	1.625"/ 41.2mm	.078"/ 2.0mm	5,400 lb/ 2.450kg	36.7 lb/16.6 kg
CB16C-ND/140	16C	140mm	6,000 rpm	1.625"/ 41.2mm	.078"/ 2.0mm	5,400 lb/ 2.450kg	29.0 lb/13.1 kg

1 CB16C-ND Chucks with spindle adapters other than those listed above are quoted on request.



3J-ND Dead Length Collet Chucks

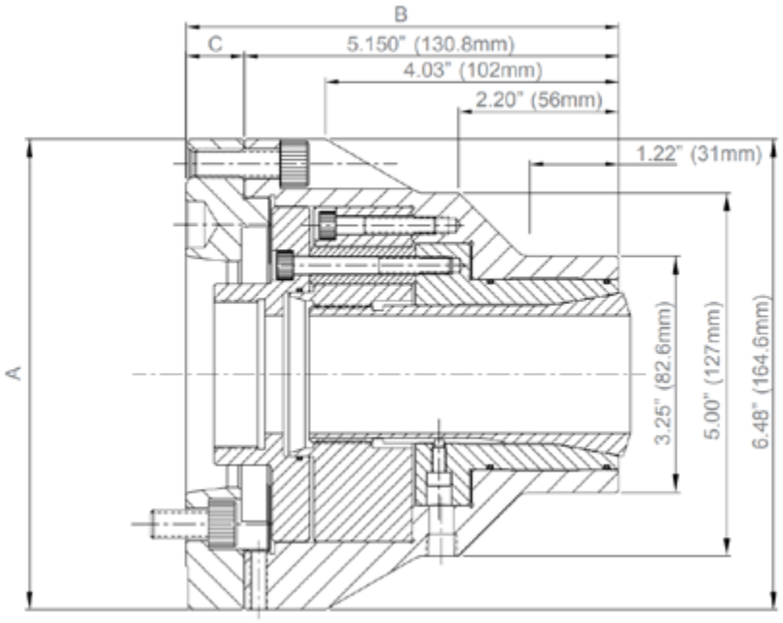
Back to Content



- Dead length design with reduced nose
- All components hardened alloy steel precision ground for accuracy and long term performance
- Internal components are sealed to prevent chip accumulation inside chuck body
- Modular chuck design can be adapted to any machine spindle and draw tube configuration
- Call for spindle mountings not listed
-

Model[1]	Collet Model	Spindle Nose	Max. Speed	Through Capacity	Linear Chuck Stroke	Chuck Weight
CB3J-ND/A5	3J	A2-5	6,000 rpm	1.750 in/ 44.4 mm	0.078 in/ 2.0 mm	28.8 lb/ 12.8 kg
CB3J-ND/A6	3J	A2-6	6,000 rpm	1.750 in/ 44.4 mm	0.078 in/ 2.0 mm	30.0 lb/ 13.3 kg
CB3J-ND/A8	3J	A2-8	6,000 rpm	1.750 in/ 44.4 mm	0.078 in/ 2.0 mm	36.5 lb/ 16.2 kg
CB3J-ND/140	3J	140mm	6,000 rpm	1.750 in/ 44.4 mm	0.078 in/ 2.0 mm	28.8 lb/ 12.8 kg

1 CB3J-ND Chucks with spindle adapters other than those listed above are quoted on request.



Back to Content

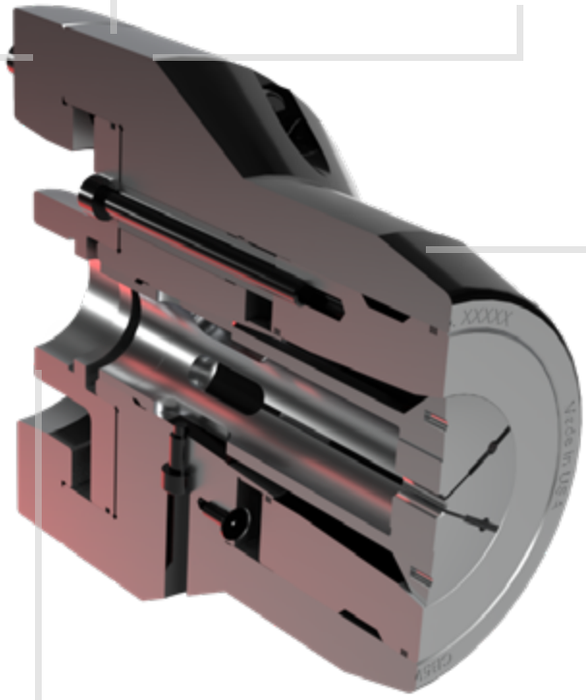
5W **178**

MODULAR DESIGN

- CHUCK BODY ASSEMBLY
- SPINDLE ADAPTER PLATE
- DRAW TUBE ADAPTER

SPINDLE ADAPTER PLATE

RADIAL ADJUSTING SCREWS



ALL COMPONENTS: HARDENED & PRECISION GROUND ALLOY STEEL

DRAW TUBE ADAPTER TO FIT EXISTING DRAW TUBE

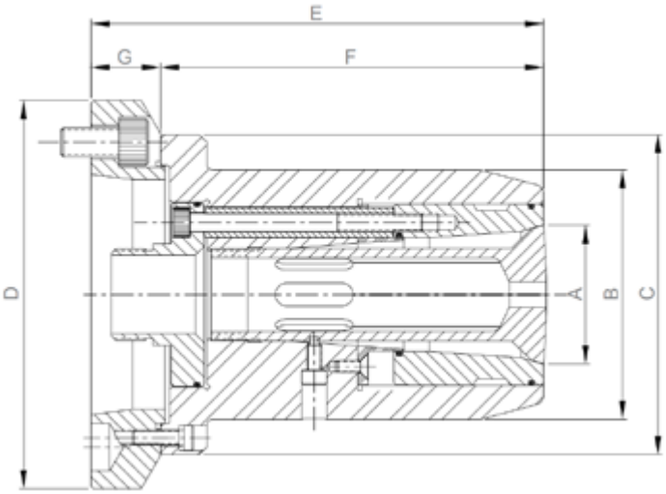
Wide Opening Collet Chucks

Back to Content

5W Wide Opening Collet Chucks

Model	Collet Model	Spindle Nose	Max. Speed	Through Capacity	Linear Chuck Stroke	Chuck Weight
CB5W-D/A4	5W	A2-4	6,000 rpm	1.062 in/ 27 mm	.370 in/ 9.4 mm	13.4 lb/ 6 kg
CB5W-D/A5	5W	A2-5	6,000 rpm	1.062 in/ 27 mm	.370 in/ 9.4 mm	14.6 lb/ 6.5 kg
CB5W-D/140	5W	140mm	6,000 rpm	1.062 in/ 27 mm	.370 in/ 9.4 mm	14.6 lb/ 6.5 kg

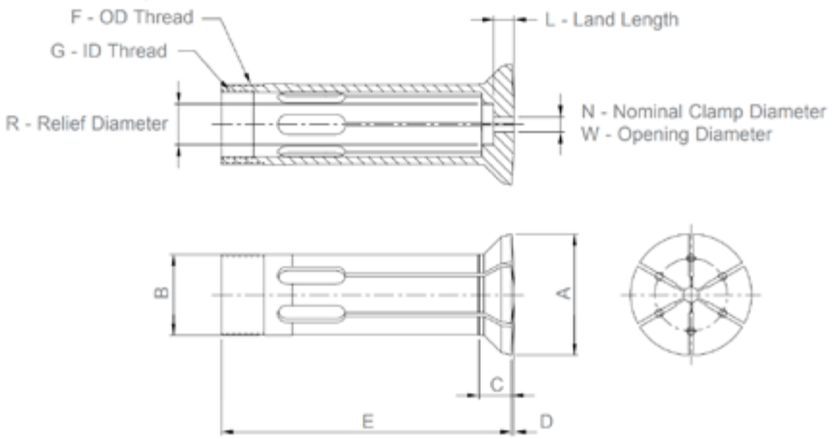
- 5W wide opening collets are designed to grip over the shoulder of headed parts
- Collets open up to .394" / 10mm above the nominal clamping diameter
- Six segmented double angle design collet with ID thread for mounting part stops or ejectors
- Dead length chuck design
- Chuck components are hardened alloy steel precision ground for accuracy and long term performance
- Internal components are sealed to prevent chip accumulation inside chuck body
- Modular chuck design can be adapted to any machine spindle and draw tube configuration.
- Call for spindle mountings not listed



Model	A	B	C	D	E	F	G
CB5W-D/A4	1.875"/ 47.6mm	3.375"/ 85.7mm	4.33"/ 110mm	4.33" / 110mm	6.120"/ 155.4mm	5.182"/ 131.6mm	0.938"/ 23.8mm
CB5W-D/A5	1.875"/ 47.6mm	3.375"/ 85.7mm	4.33"/ 110mm	5.25"/ 133.4mm	6.120"/ 155.4mm	5.182"/ 131.6mm	0.938"/ 23.8mm
CB5W-D/140	1.875"/ 47.6mm	3.375"/ 85.7mm	4.33"/ 110mm	5.25"/ 133.4mm	6.120"/ 155.4mm	5.182"/ 131.6mm	0.938"/ 23.8mm

Collet Dimensions

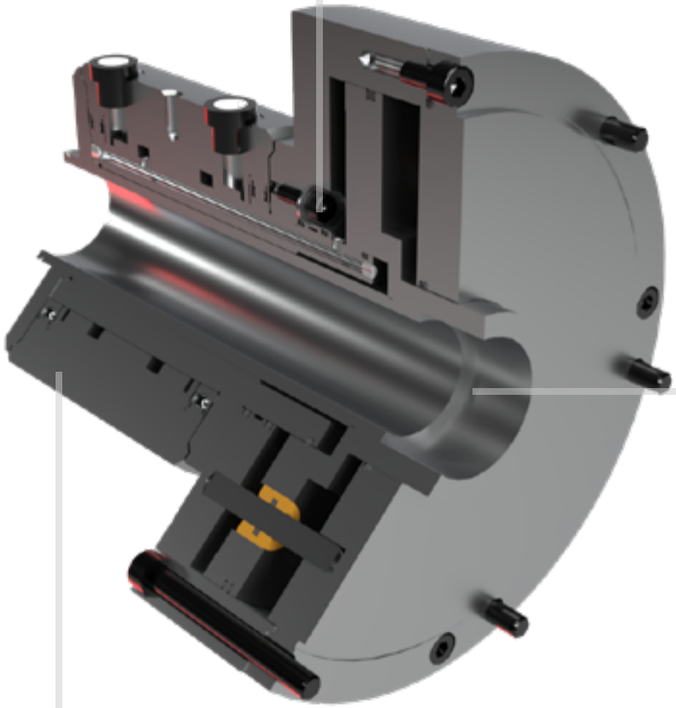
Model	A	B	C	D	E	F	G
5W	1.875"/ 47.6mm	1.250"/ 31.75mm	0.430"/ 10.9mm	0.039"/ 1.0mm	4.500"/ 114.3mm	1.238-20 RH	1.041-24 RH



Air Cylinders

Back to Content

SELF-CONTAINED DESIGN WITH BUILT-IN PISTON



THROUGH HOLE

ROTARY JOURNAL WITH PRECISION BEARINGS REQUIRES NO LUBRICATION

Air Cylinders

Back to Content




01. LDN Standard Through Hole Models

- Available in 6, 8, and 10 inch diameter models
- 1.102" / 28mm through hole
- Speeds to 6,000 rpm
- Clamping Force up to 5,200 lb / 2,360 kg

02. LDN/LV Through Hole with Lock Valve

- Built-in lock and release valves
- 7 inch diamter
- 1.102" / 28mm through hole
- Speeds up to 6,000 rpm
- Available with stroke control

03. LDN/RE Through Hole Models with Stroke Control

- Target and adjustable brackets for proximity switches
- Available in 6, 8, and 10 inch diameter models
- 1.102" / 28mm through hole
- Speeds up to 6,000 rpm

04. LDN/A Adjustable Draw Tube Models

- Adjustable draw tube to install collets and adjust tension tension on 5C spindles
- 6 inch diameter
- 1.063" / 27mm through hole
- 6,000 rpm
- 5C draw tubes available

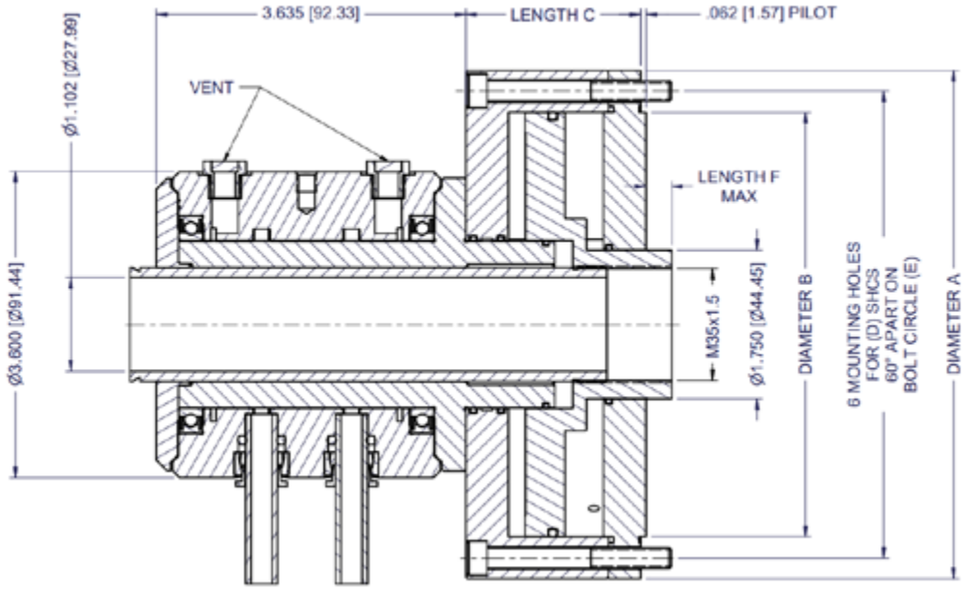
LDN Standard Through Hole Models

Model	Size	Through Hole	Piston Stroke	Max. Air Pressure	Draw Tube Force	Max. rpm	Weight
LDN-150	6 in/ 152 mm	1.102 in/ 28 mm	.394 in/ 10 mm	150 psi/ 10.5 kg/cm²	1,640 lbf/ 745 kgf	6,000	12 lb/ 5.5 kg
LDN-200	8 in/ 203 mm	1.102 in/ 28 mm	.710 in/ 18 mm	150 psi/ 10.5 kg/cm²	2,920 lbf/ 1,327 kgf	5,000	23 lb/ 10.5 kg
LDN-250	10 in/ 254 mm	1.102 in/ 28 mm	.710 in/ 18 mm	150 psi/ 10.5 kg/cm²	5,200 lbf/ 2,364 kgf	4,000	32 lb/ 14.5 kg

- Available in 6, 8, and 10 inch diameter models
- 1.102" / 28mm through hole
- Speeds to 6,000 rpm
- Clamping Force up to 5,200 lb / 2,360 kg

Options:

- Mounting Plates & Draw Tubes
- Proximity Switches
- Check Valves



Model	A	B	C	D	E	F
LDN-150	5.980"/ 151.89mm	4.995"/ 126.87mm	2.053"/ 52.15mm	M6	5.500"/ 139.70mm	.500"/ 12.7mm
LDN-200	7.980"/ 202.69mm	6.495"/ 164.97mm	3.186"/ 80.92mm	M8	7.250"/ 184.15mm	.355"/ 9mm
LDN-250	10.000"/ 254mm	8.495"/ 215.77mm	3.186"/ 80.92mm	M8	9.250"/ 234.95mm	.355"/ 9mm

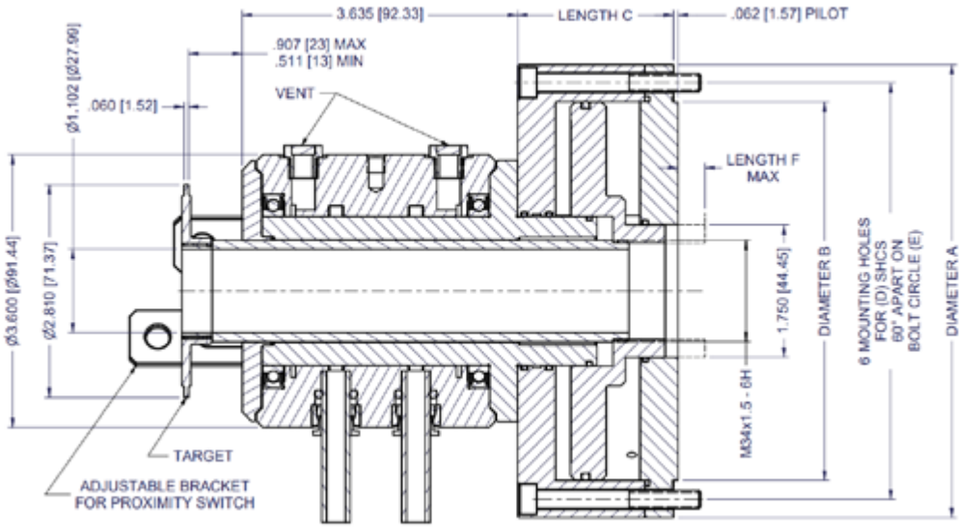
LDN/RE Through Hole Models with Stroke Control

Model	Size	Through Hole	Piston Stroke	Max. Air Pressure	Draw Tube Force	Max. rpm	Weight
LDN-150/RE	6 in152/ mm	1.102 in/ 28 mm	.394 in/ 10 mm	150 psi/ 10.5 kg/cm²	1,640 lbf/ 745 kgf	10,000	12 lb/ 5.5 kg
LDN-200/RE	8 in/ 203 mm	1.102 in/ 28 mm	.710 in/ 18 mm	150 psi/ 10.5 kg/cm²	2,920 lbf/ 1,327 kgf	5,000	23 lb/ 10.5 kg
LDN-250/RE	10 in/ 254 mm	1.102 in/ 28 mm	.710 in/ 18 mm	150 psi/ 10.5 kg/cm²	5,200 lbf/ 2,364 kgf	4,000	32 lb/ 14.5 kg

- Target and adjustable brackets for proximity switches
- Available in 6, 8, and 10 inch diameter models
- 1.102" / 28mm through hole
- Speeds up to 6,000 rpm

Options:

- Mounting Plates & Draw Tubes
- Proximity Switches
- Check Valves



Model	A	B	C	D	E	F
LDN-150/ RE	5.980"/ 151.89mm	4.995"/ 126.87mm	2.053"/ 52.15mm	M6	5.500"/ 139.70mm	.500"/ 12.7mm
LDN-200/ RE	7.980"/ 202.69mm	6.495"/ 164.97mm	3.186"/ 80.92mm	M8	7.250"/ 184.15mm	.355"/ 9mm
LDN-250/ RE	10.000"/ 254mm	8.495"/ 215.77mm	3.186"/ 80.92mm	M8	9.250"/ 234.95mm	.355"/ 9mm

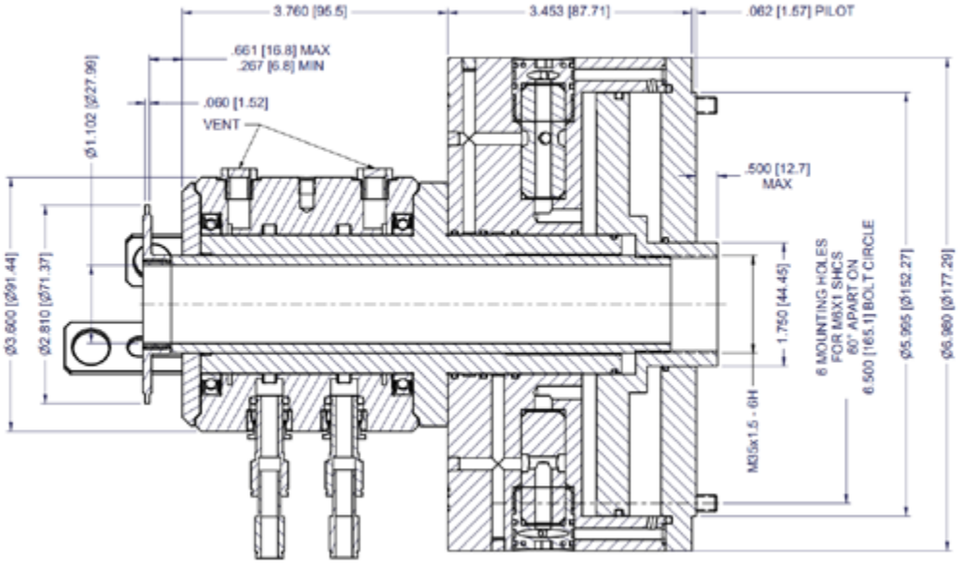
Model LDN-178/RE, LDN/LV Through Hole with Lock Valve

Size	7 in/ 177 mm
Through Hole	1.102 in/ 28 mm
Piston Stroke	.394 in/ 10 mm
Max. Air Pressure	150 psi/ 10.5 kg/cm²
Draw Tube Force1	2,520 lbf/ 1140 kgf
Max. rpm	6,000
Weight	24 lb/ 11 kg

- Built-in lock and release valves
- 7 inch diamter
- 1.102" / 28mm through hole
- Speeds up to 6,000 rpm
- Available with stroke control

Options:

- Mounting Plates & Draw Tubes
- Proximity Switches
- Check Valves

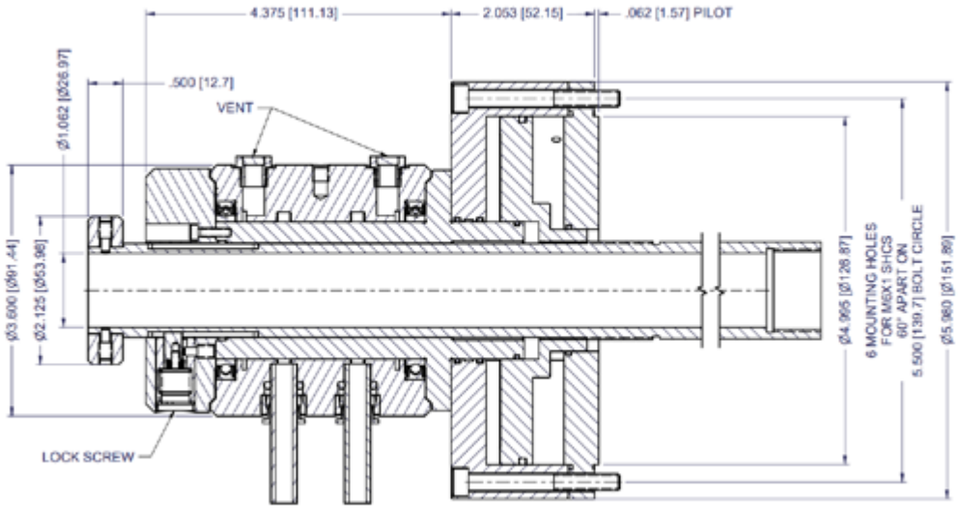


*Optional stroke control shown

Model LDZ/A-150, LDN/A Adjustable Draw Tube Models

Size	6 in/ 152 mm
Through Hole	1.063 in/ 27 mm
Piston Stroke	.394 in/ 10 mm
Max. Air Pressure	150 psi/ 10.5 kg/cm²
Draw Tube Force1	1,640 lbf/ 745 kgf
Max. rpm	6,000
Weight	14.5 lb/ 6.6 kg

- Built-in lock and release valves
- 7 inch diamter
- 1.102" / 28mm through hole
- Speeds up to 6,000 rpm
- Available with stroke control



Options:

- Mounting Plates & Draw Tubes
- Proximity Switches
- Check Valves

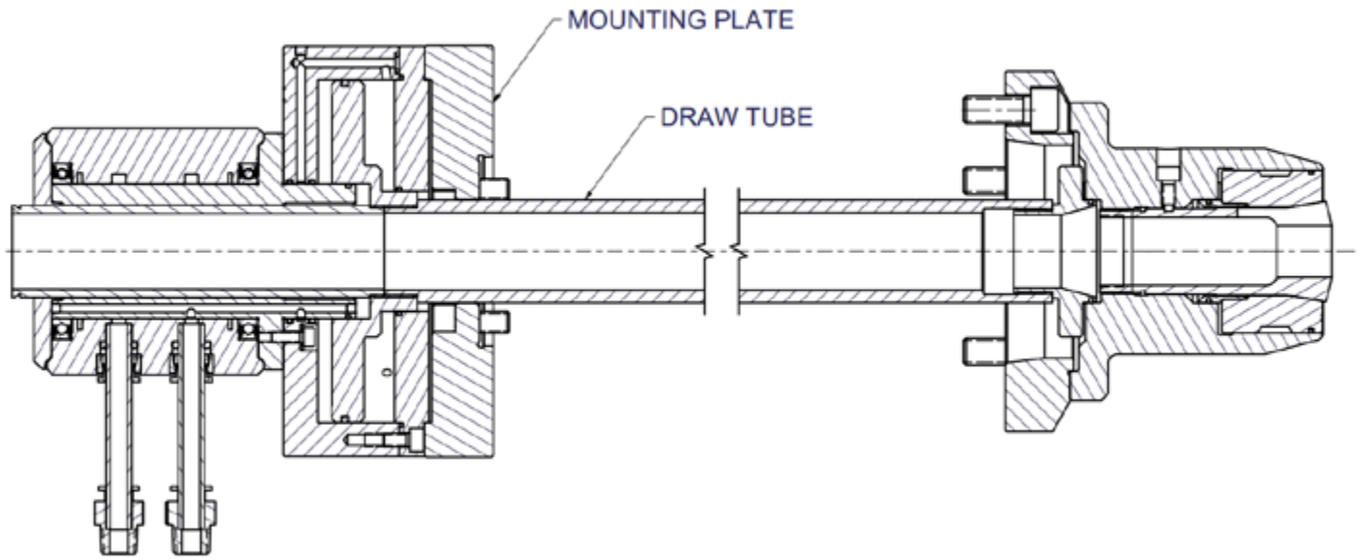
Accessories:

- End Cap for Spindle Liners
- End Caps for Rotary Air/Coolant Unions
- Operating Valves
- Operating Valves
- Rotary Union

Back to Content

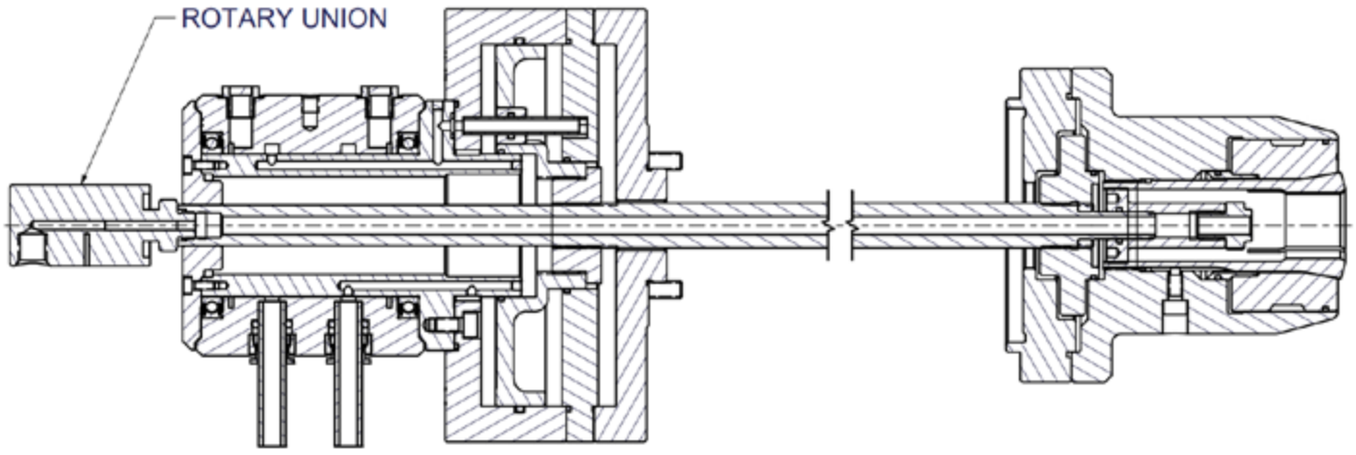
Mounting Plates and Draw Tubes

Spindle mounting plates and draw tubes to adapt LDN Air Cylinders to a specific machine spindle or rotary table are quoted on request.



Rotary Unions for Coolant/Air Thru

Rotary unions can be mounted to the rear of LDN Air Cylinders to supply coolant or air through the machine spindle to the workholding fixture.



Model FRL-15, Air Filter/Regulator/Lubricator Units

The FRL-15 is a combination air filter/regulator/lubricator unit that controls the air pressure to the chuck's built-in cylinder, and provides lubrication to the rotary air bearing assembly. This unit also filters contaminants from the air supply. Water that accumulates in the filter unit can be purged by a manual drain.

Each unit includes a pressure gage, as well as air hoses and fittings.

Fitting Size	1/4"-18 NPT
Max. Air Pressure	150 psi/ 12 kg/cm²
Operating Range	5 to 125 psi/ 0.5 to 9 kg/cm²

Rotary Union

A rotary union is required to supply coolant through the air tube assembly, or for the AL-Automatic Lubrication option. Rotary unions can be mounted to the rear of LDN Air Cylinders to supply coolant or air through the machine spindle to the workholding fixture.

The rotary union threads into the rear of the air tube and includes a hose and fittings.

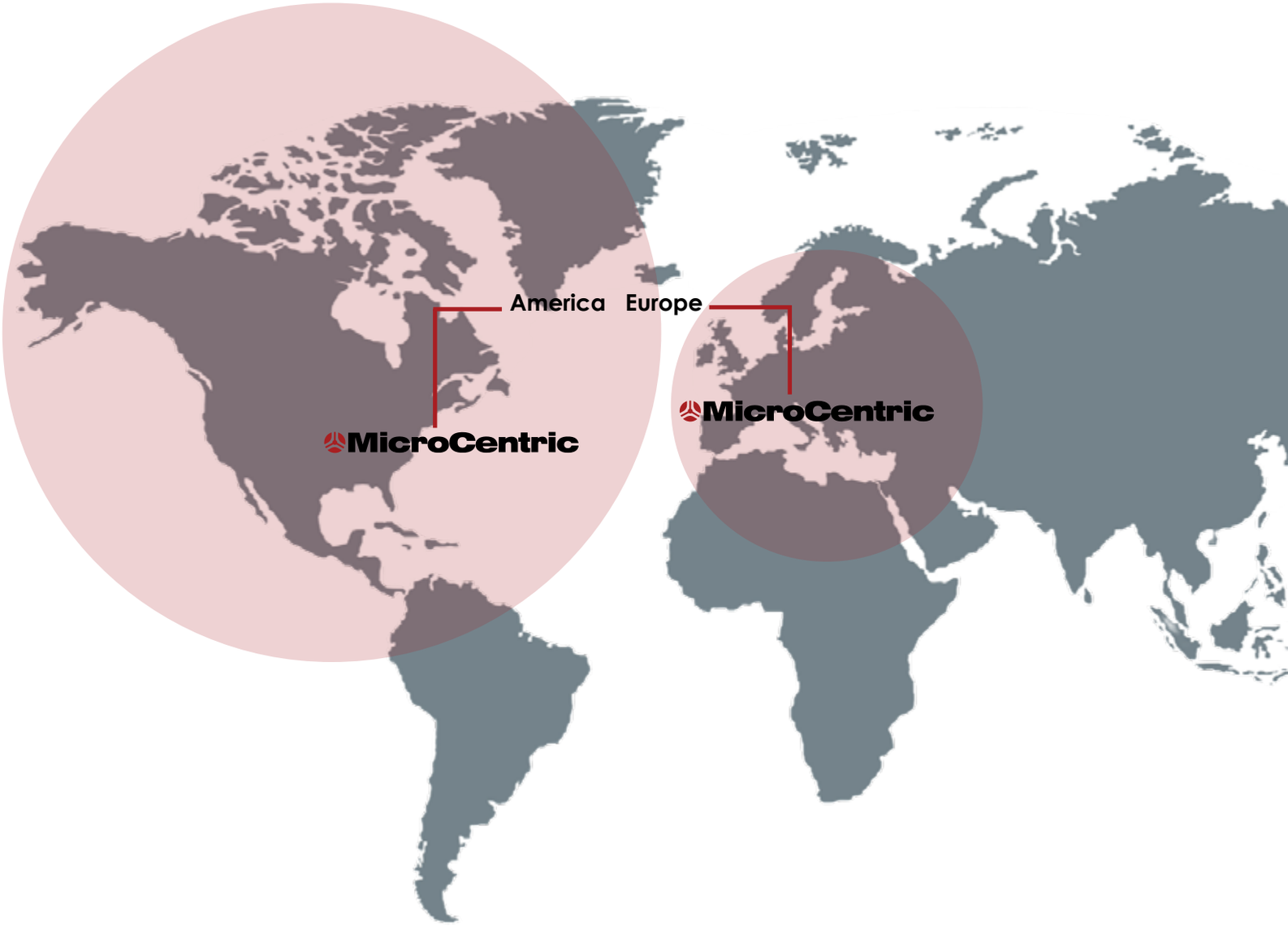
Model	Fitting Size (Inlet Port)	Rotor Thread	Max. Air Pressure	Max. Speed	Air Tube Model
RU-10	1/8"-27 NPT	3/8" - 32 UNEF	150 psi/ 10 kg/cm²	6,000 rpm	Model 50, Rotating Air Tubes
RU-20	1/4"-18 NPT	5/8" - 18 UNF	150 psi/ 10 kg/cm²	4,000 rpm	Model 82, Rotating Air Tubes

Operating Valves

The HV-10 is a 2 position manual hand valve that directs and exhausts air to open and close LDN Air Cylinders.

The FV-10 is a 2 position manual foot valve that directs and exhausts air to open and close LDN Air Cylinders.

Model	Port Size	Max Pressure	Handle Movement
HV-10	1/8" NPT	150 psi/ 10 kg/cm2	1/4 Turn
FV-10	1/4" NPT	150 psi/ 10 kg/cm2	N/A



Contact America

25 South Terminal Drive
11803 Plainview, NY
USA
E-mail: sales@microcentric.com
Telephone: 1-516-349-7220
www.microcentric.com

Contact Europe

MicroCentric GmbH
Ringstrasse 134, 70839 Gerlingen
Germany
E-mail: info@microcentric.de
Telephone: 0049 (0)7156 17819-0
www.microcentric.de