



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

# Workholding Catalog





Our time proven quality and reliability lies in our history of [European craftsmanship and engineering](#). Toolmex’s European factories are ISO 9001 certified and manufacture to international standards.

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

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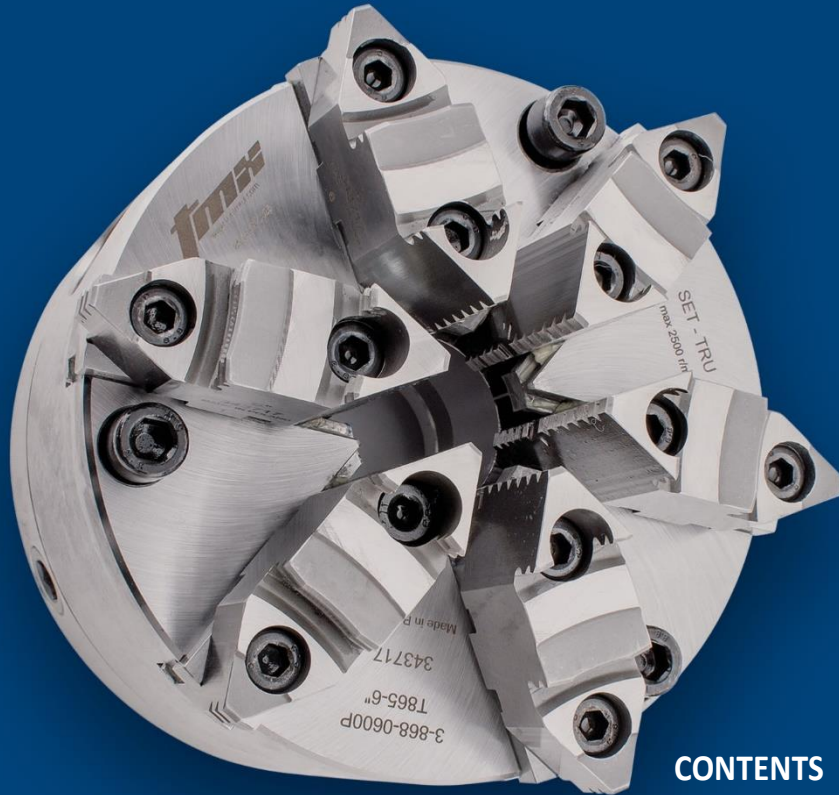


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# Selection Guide

DESIGNED AND ENGINEERED FOR PRECISION

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## Lathe Chuck Safety Conditions

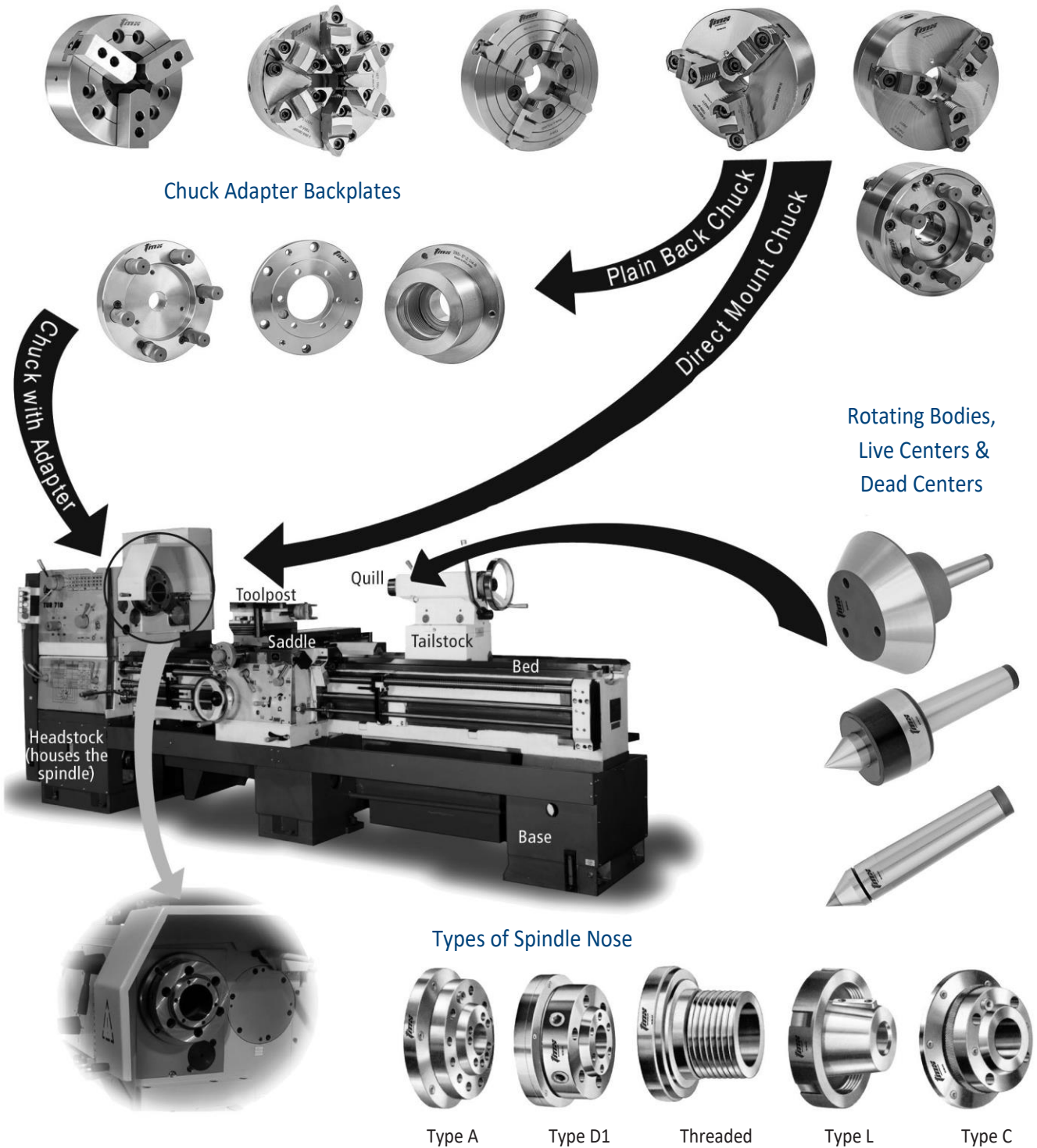
- Due to chuck rotating speeds and cutting forces during machining, care should be taken to ensure the proper and safe use of your TMX chuck
- Cleaning should be done often for safety purposes as well as to provide a long work life for your chuck
- Proper maintenance ensures longer life of the product



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

- Do not start the lathe until all is clear. A collision between the chuck and lathe will cause damage to both
- Do not use the chuck on heavy work where the chuck jaws project appreciably from the chuck body. Refer to the tables to select the correct size chuck for the application
- Do not clamp long work pieces in the chuck without additional support as this can cause heavy damage to the lathe and work environment. Refer to the table for safety parameters
- Always remove the chuck wrench before starting the machine
- Do not remove the safety spring from the chuck wrench
- Never operate the chuck if any parts are damaged, missing, or cracked
- Do not tamper with the chuck. If an inaccuracy is found, check the spindle nose or backplate for true-running and make sure there is no dirt or foreign matter between the mounting faces
- Never exceed maximum speed (RPM) of the chuck. The MAX RPM is stamped on the chuck face. Refer to the table for recommended maximum speeds for self-centering chucks
- Periodically inspect and service chucks for wear to avoid inadequate workholding conditions
- Be sure top jaws are securely bolted to the master jaws
- Never do any unauthorized chuck modifications
- Always keep your chuck clean and lubricated

## Application of Chucks & Centers



## Manual Chuck Selection Worksheet

(Email to support@tmxtools.com)

### Chuck Parameters

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

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

### Chuck Diameter

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

### Type of Chuck ✓

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

### Number of Jaws ✓

2	
3	
4	
6	

### Type of Chuck Jaws ✓

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

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

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

### Additional Notes:

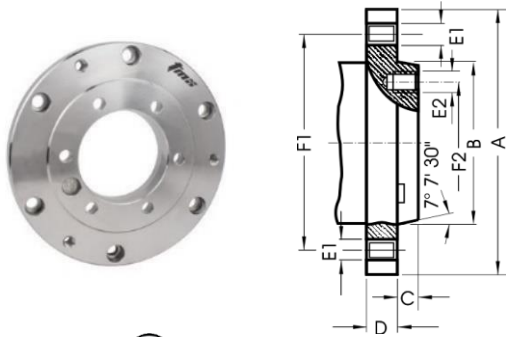
## Determining the Proper Spindle Type and Size

TMX Chucks meet all of the requirements of ASA Standard B5.9-1960. For spindle nose accuracy (T.I.R.) see page 7

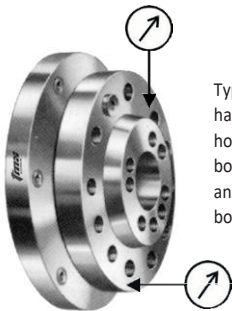
### Selecting the chuck mounting from the following types:

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

## Spindle Type A1 and A2, DIN55026, ISO 702-1



Spindle Nose	F1	F2	B	C max	Metric Thread E1 = E2	UNC-3B Thread E1 = E2
A-4	3.2500	-	2.5005 + .0005	.4375	M10	7/16-14
A-5	4.1250	2.4374	3.2505 + .0005	.5625	M10	7/16-14
A-6	5.2500	3.2500	4.1880 + .0005	.6250	M12	1/2-13
A-8	6.7500	4.37500	5.50075 + .0005	.6875	M16	5/8-11
A-11	9.2500	6.5000	7.75075 + .0005	.7500	M20	3/4-10
A-15	13.0000	9.7500	11.251 + .001	.8125	M24	7/8-9
A-20	18.2500	14.5000	16.251 + .001	.8750	M24	1-8
A-28	25.5000	20.8750	23.001 + .001	1.000	M30	1 1/4-7

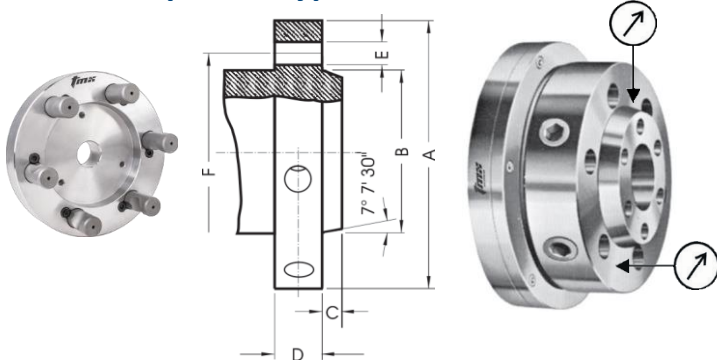


Type A1 has tapped holes on both inner and outer bolt circles



Type A2 does not have holes in the inner bolt circle

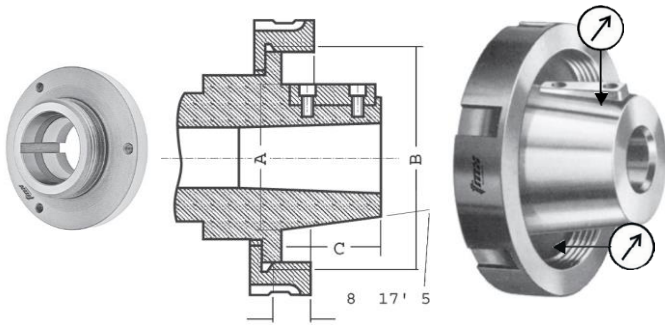
## Camlock Spindle Type D1



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

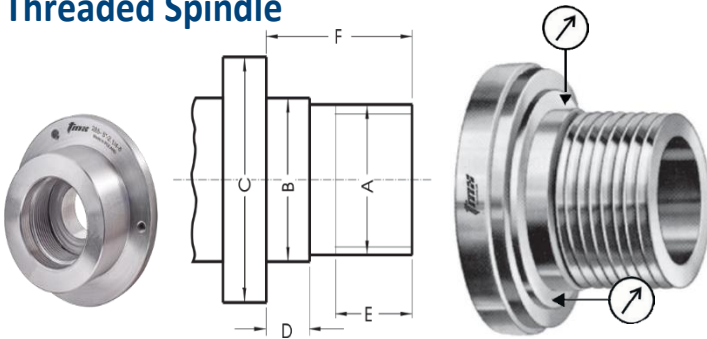


## Long Taper Key Drive, Spindle Type L



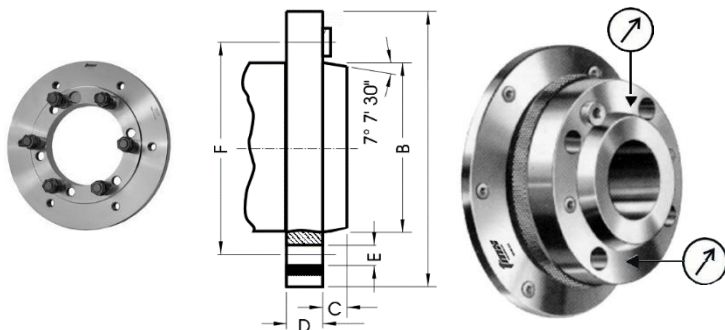
Spindle Nose	B	C	A	Key
L00	3 3/4" - 6"	2	2.750	3/8 x 3/8 x 1 1/2
L0	4 1/2" - 6"	2 3/8	3.250	3/8 x 3/8 x 1 3/4
L1	6" - 6"	2 7/8	4.125	5/8 x 5/8 x 2 3/8
L2	7 3/4" - 5"	3 3/8	5.250	3/4 x 3/4 x 2 7/8
L3	10 3/8" - 4"	3 7/8	6.500	1 x 1 x 3 1/4

## Threaded Spindle



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

## German Standard DIN 55027, Spindle Type C

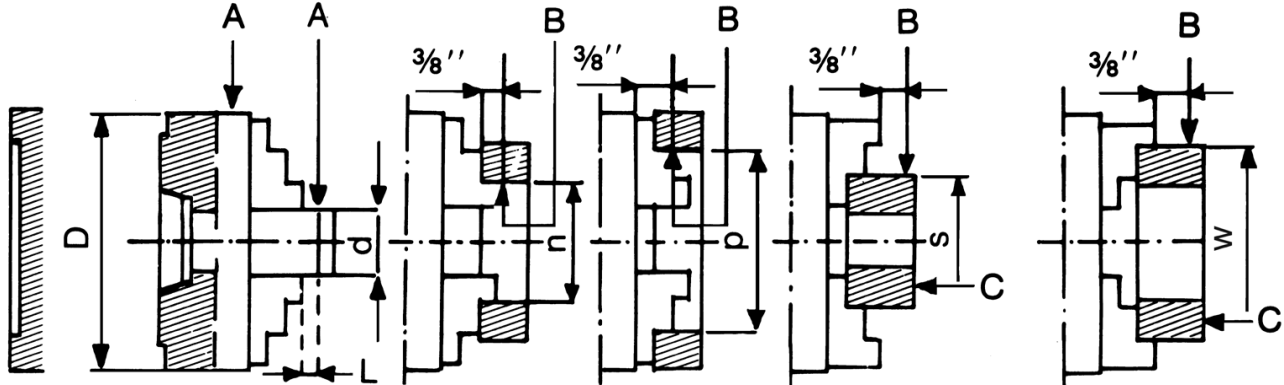


Spindle Nose	F	B	C max	E	# of Holes
C-4	3.2500	2.5005	.4331	.83	3
C-5	4.1250	3.2505	.5118	.83	4
C-6	5.2500	4.1880	.5512	.91	4
C-8	6.7500	5.50075	.6299	1.14	4
C-11	9.2520	7.75075	.7087	1.42	6



## Self-Centering Scroll Chuck Accuracy

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

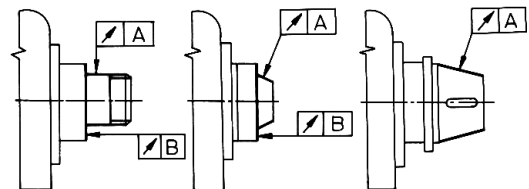


Chuck Size	d			L	n	p	s	with solid jaws	with 2-piece jaws	Radial Runout		Axial Runout C
	1	2	3							A	B	
3-1/2"	0.39	-	0.55	1.57	1.57	2.36	1.38	2.48	-	0.0008	0.001	0.0006
4"	0.39	0.55	0.71	1.57	1.57	2.95	1.97	3.15	-	0.0008	0.001	0.0006
5"	0.71	0.98	1.18	2.36	1.97	3.94	2.44	3.94	4.72	0.0012	0.0014	0.0008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

## Permissible Spindle Runout

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

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

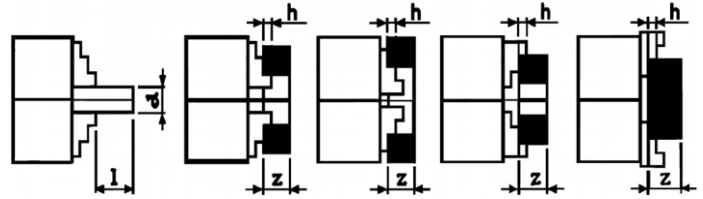


Chuck Diameter	Spindle Runout
3" - 16"	.00012" max
20" - 25"	.0002" max

## Safe Operating Parameters

Conditions:

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



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

## Total Gripping Force of all Scroll Chucks

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

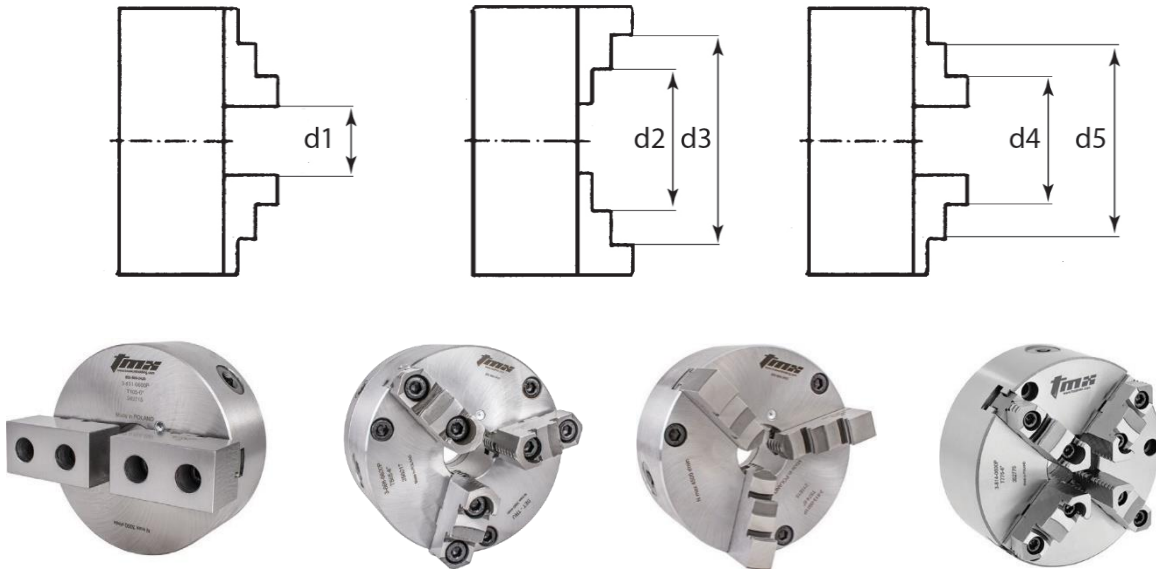
## Recommended Maximum Speeds for Scroll Chucks

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

## Value of Unbalancing for Scroll Chucks

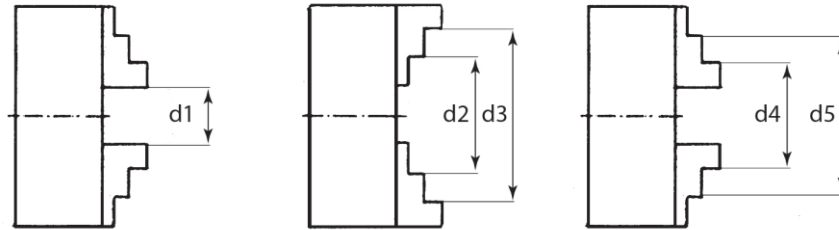
Chuck Diameter	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Unbalancing (ounce-inch)	0.15	0.22	0.32	0.44	0.62	0.87	1.25	1.94	4.16	8.88

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



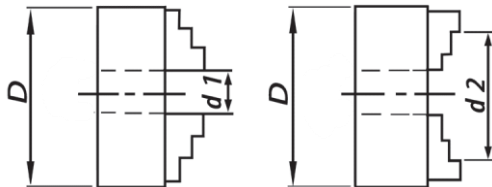
Chuck Size		2-1/3"	3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"	31-1/2"
Solid Jaws	d1	.02-.95	.08-1.06	.118 - 1.30	.118 - 1.97	.118 - 2.52	.157 - 3.54	.197 - 4.65	.394 - 5.16	.39-7.09	.79-9.25	1.18-13.19	5.9-18.98
	d2	.79-1.65	.87-1.81	1.26 - 2.44	1.54 - 3.27	1.97 - 4.21	2.36 - 5.71	3.03 - 7.40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

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



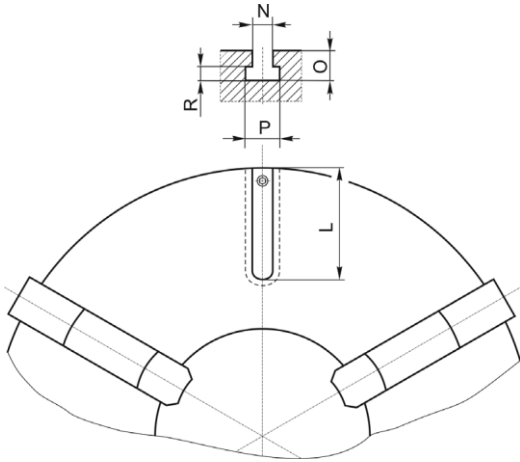
ChuckSize		4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
SolidJaws	d1	.118 - 1.299	.236 - 1.69	.315 - 2.51	.315 - 3.54	.47 - 4.65	.47 - 5.16	-	-	-
	d2	1.259 - 2.440	1.65 - 3.07	2.05 - 4.21	2.52 - 5.71	3.23 - 7.40	3.74 - 8.46	-	-	-
	d3	2.440 - 3.661	3.27 - 4.72	4.02 - 6.30	5.20 - 7.87	6.50 - 9.84	7.56 -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

## Clamping Ranges for 4-Jaw Independent Chucks



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

## Standard T-Slot Dimensions



### 3 Jaw Scroll Chucks

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

### 4 Jaw Independent Chucks

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

### 3 Jaw Oil Country Scroll Chucks

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

### 4 Jaw Oil Country Independent Chucks

Chuck Size	# of T-Slots	MM				
		L	N	O	P	R
25in (630mm)	4	Full length	22	45 - 38	37	16
28in (700mm)	4	Full length	22	45 - 38	37	16
32in (800mm)	4	Full length	22	45 - 38	37	16
36in (900mm)	4	Full length	22	45 - 38	37	16
40in (1000mm)	4	Full length	22	45 - 38	37	16

**Notes:**



# Manual Lathe Chucks

DESIGNED AND  
MANUFACTURED IN  
EUROPE

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## Manual Lathe Chucks

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

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

### Bodies

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

### Jaws

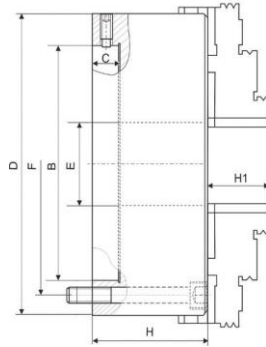
- 2-Piece Hard Reversible American Standard Tongue and Groove Jaw System are made of high quality alloy steel then hardened to 50 HRC and ground
- Jaws hardened to 50 HRC
- Jaw teeth are “softer” than the rest of the jaw to allow for a slight flex which will extend the life of the master jaw
- Solid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

### Adapter Plates

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







## Super Precision SET-TRU™ Chucks

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

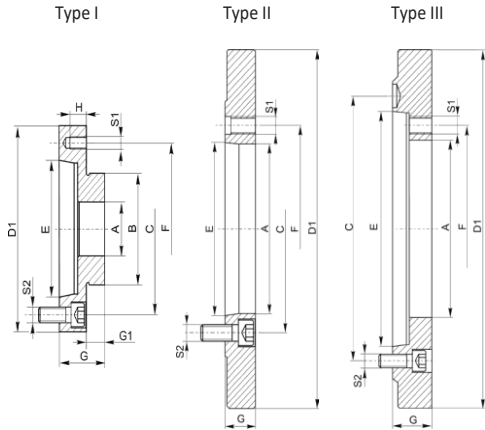
- Forged Steel Body
- Fine adjustment with 4 micro adjustment screws
- 2-Piece Hard Reversible American Standard Tongue and Groove Jaw System
- Compatible with Rotary Table Packages (see page 19)
- Chucks 20" and above have T-Slots (for standard specifications see page 11)

### Each Chuck Provided With

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

Chuck Size	Item Number	# of Jaws	B	C	D	Thru-Hole (E)	F	H	H1	Gripping Force (daN)	Max RPMs	Weight (lb.)
5	3-866-0500P	3	2.16	0.59	4.92	1.37	4.25	2.83	1.57	2400	5500	15
6	3-866-0600P		3.38	0.70	6.30	1.65	5.51	3.48	1.73	3100	4600	29
8	3-866-0800P		4.33	0.78	7.87	2.16	6.92	3.89	1.77	3700	4000	50
10	3-866-1000P		5.70		9.84	2.99	8.81	4.29	2.05	4600	3500	81
12	3-866-1200P		7.08	12.40	4.05	11.26	4.66	2.24	5500	2800	138	
16	3-866-1600P		11.78	0.86	15.75	5.35	6.75	5.11	2.63	6500	2000	222
20	3-866-2000P		16.03	1.18	19.69	7.48	9.25	6.29	3.15	7200	1300	396
25	3-866-2500P				24.80	9.92	13.00	6.89	3.42	8000	1000	716
6	3-847-0600P	4	3.38	0.70	6.30	1.65	5.51	3.48	1.73	3100	4600	29
8	3-847-0800P		4.33	0.78	7.87	2.16	6.92	3.89	1.77	3700	4000	50
10	3-847-1000P		5.70		9.84	2.99	8.81	4.29	2.05	4600	3500	81
12	3-847-1200P		7.08	12.40	4.05	11.26	4.66	2.24	5500	2800	138	
16	3-847-1600P		11.78	0.86	15.75	5.35	6.75	5.11	2.63	6500	2000	222
5	3-868-0500P	6	2.16	0.59	4.92	1.37	4.25	2.83	1.57	2400	3800	15
6	3-868-0600P		3.38	0.70	6.30	1.65	5.51	3.48	1.73	3100	3200	29
8	3-868-0800P		4.33	0.78	7.87	2.16	6.92	3.89	1.77	3700	2800	50
10	3-868-1000P		5.70		9.84	2.99	8.81	4.29	2.05	4600	2400	81
12	3-868-1200P		7.08	12.40	4.05	11.26	4.66	2.24	5500	1900	138	
16	3-868-1600P		11.78	0.86	15.75	5.35	6.75	5.11	2.63	6500	1400	222
20	3-868-2000P		16.03	1.18	19.69	7.48	9.25	6.29	3.15	7200	900	396
25	3-868-2500P				24.80	9.92	13.00	6.89	3.42	8000	700	716

## Super Precision SET-TRU™ Backplates

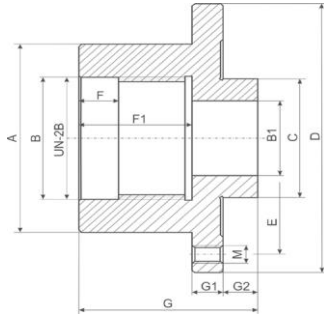


### Type A2 Steel Backplates for Super Precision SET-TRU™ Chucks

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

Chuck Size	Item Number	Taper Size	Type	Thru-Hole A	B	C	D1	E	F	G	G1	H	S1	S2 (Metric Bolts)	S2 (Inch Bolts)	Weight (lb.)		
5	3-874-054P	4	I	1.37	2.16	3.25	4.92	2.50	4.25	1.41	0.55	0.86	M8	M10		4.8		
	3-874-055P	5				4.12	5.11	3.25								4.1		
	3-874-056P	6				5.25	6.37	4.19								7.7		
6	3-874-064P	4	I	1.65	3.38	3.25	6.29	2.50	5.51	1.77	0.62	1.08	M10	M10		6.8		
	3-874-065P	5				4.12		3.25								0.82	7.2	
	3-874-066P	6				5.25		4.19								1.02	9.7	
8	3-874-084P	4	I	2.16	4.33	3.25	7.87	2.50	6.92	1.29	0.66	0.57	M10	M10		9.2		
	3-874-085P	5				4.12		3.25								1.04	13.6	
	3-874-085PI							7/16-14										
	3-874-086P	6				5.25		4.19								1.77	17.1	
10	3-874-105P	5	I	2.99	5.70	4.12	9.84	3.25	8.81	1.49	0.74	0.68	M12	M10		17.4		
	3-874-105PI							7/16-14										
	3-874-106P	6				5.25		4.19								1.81	20.2	
	3-874-106PI							1/2-13										
	3-874-108P					8		6.75										5.50
12	3-874-126P	6	I	4.05	7.08	5.25	12.40	4.19	11.25	1.49	0.74	0.68	M16	M12		35.2		
	3-874-128P	8				6.75		5.50								1.81	41.2	
	3-874-129P	11				9.25		7.75								2.16	31.5	
16	3-874-166P	6	II	4.05	-	5.25	11.75	4.19	6.74	1.37	-	1.37	M16	M12		28.2		
	3-874-168P	8	6.75	5.50		1.45		36.5										
	3-874-169P	11	III	5.35		9.25		7.75								1.88	1.10	M20
20	3-874-208P	8	II	5.35	-	6.75	16.02	5.50	9.25	1.41	-	1.22	M20	M16		60.8		
	3-874-209P	11		7.59		9.25		7.75								1.41	M20	76.2
	3-874-215P	15	III	7.48		13		11.25								2.04	1.18	M24
25	3-874-258P	8	II	5.35	-	6.75	16.02	5.50	13.00	1.41	-	1.22	M20	M16		60.8		
	3-874-259P	11		7.59		9.25		7.75								1.41	M20	65.2
	3-874-260P	15		9.92		13		11.25								2.04	2.04	M24

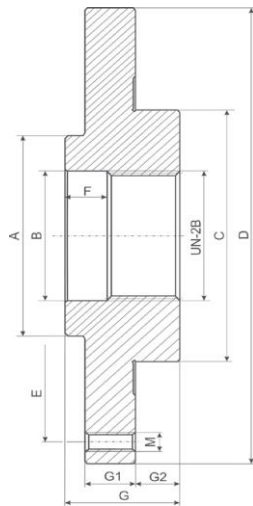
Type I



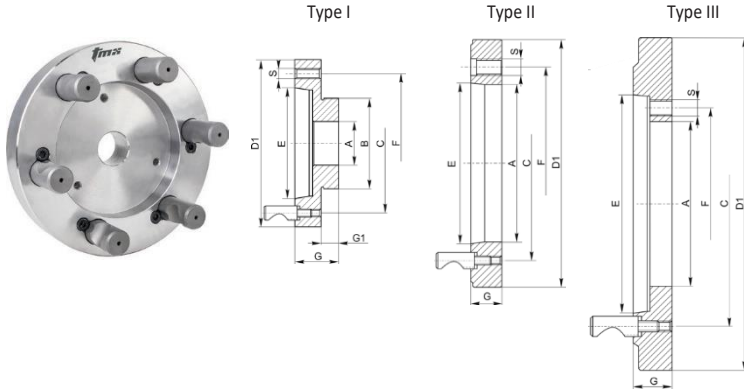
## Threaded Steel Backplates for Super Precision SET-TRU™ Chucks

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

Type II



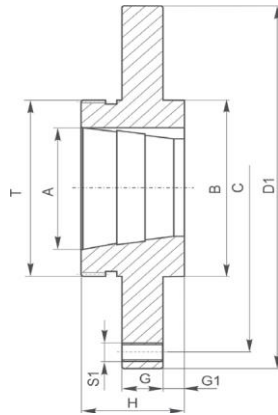
Chuck Size	Item Number	Type	UN-2B	A	B	B1	C	D	E	F	F1	G	G1	G2	M	Weight (lb.)	
5	3-876-052P	II	1.1/2"-8	2.68	1.52	-	2.17		4.25	0.51	-	1.54	0.51	0.55	3xM8	3.50	
	3-876-054P	I	2.3/16"-10	3.46	2.20	1.38				0.63	1.85	2.91				6.40	
	3-876-056P		2.1/4"-8		2.26					2.91	6.40						
6	3-876-062P	II	1.1/2"-8	2.68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



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

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

Chuck Size	Item Number	Taper Size	Type	Thru-Hole A	B	C	D1	E	F	G	G1	S	Weight (lb.)
5	3-875-053P	3	I	1.37	2.16	2.77	4.92	2.13	4.25	1.57	0.55	M8	5.9
	3-875-054P	4				3.25		2.50		1.65			5.7
	3-875-055P	5				4.12		3.25		1.73			6.8
	3-875-056P	6				5.25		4.19		1.92			13.0
	3-875-058P	8				6.75		8.66		5.50			2.04
6	3-875-063P	3	I	1.65	3.38	2.77	6.29	2.13	5.51	1.81	0.62	M10	10.8
	3-875-064P	4				3.25		2.50		1.65			9.9
	3-875-065P	5				4.12		3.25		1.73			13.0
	3-875-066P	6				5.25		4.19		1.92			24.9
	3-875-068P	8				6.75		8.66		5.50			2.12
8	3-875-083P	3	I	2.02	4.33	2.77	7.87	2.13	6.92	1.29	0.66	M10	10.3
	3-875-084P	4		2.16		3.25		2.50		1.85			15.8
	3-875-085P	5				4.12		3.25		2.00			17.6
	3-875-086P	6				5.25		4.19		2.16			19.8
	3-875-088P	8				6.75		8.66		5.50			2.16
10	3-875-104P	4	I	2.38	5.70	3.25	9.84	2.50	8.81	1.49	0.74	M12	18.9
	3-875-105P	5		2.99		4.12		3.25		1.76			
	3-875-106P	6		3.01		5.25		4.19		2.08			28.4
	3-875-108P	8				6.75		5.50		2.36			32.4
12	3-875-126P	6	I	4.05	7.08	5.25	12.40	4.19	11.25	1.49	0.74	M16	28.4
	3-875-128P	8				6.75		5.50		2.24			47.8
	3-875-129P	11				9.25		7.75		2.51			52.9
16	3-875-166P	6	II	4.05	-	5.25	11.75	4.19	6.74	1.37	-	M16	25.7
	3-875-168P	8	5.35	6.75		5.50		1.49		26.2			
	3-875-169P	11		III		9.25		7.75		1.88			38.5
20	3-875-208P	8	II	5.35	-	6.75	16.02	5.50	9.25	1.49	-	M20	73.8
	3-875-209P	11	7.59	9.25		7.75		1.73		77.8			
	3-875-215P	15		III		13.00		11.25		2.04			83.3
25	3-875-258P	8	II	5.35	-	6.75	16.02	5.50	13.00	1.49	-	M20	73.8
	3-875-259P	11		7.59		9.25		7.75		1.73			77.8

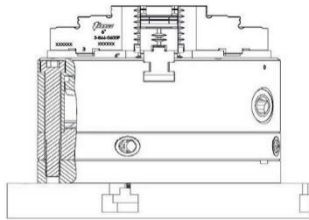
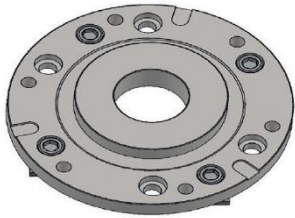


## Type L Steel Backplates for Super Precision SET-TRU™ Chucks

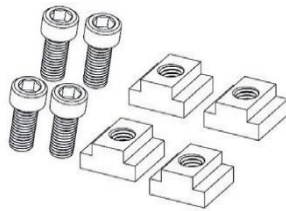
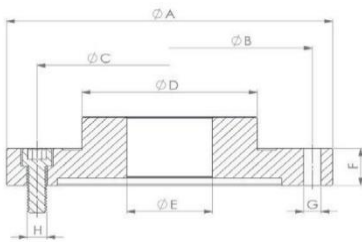
- Designed for use with TMX Super Precision SET-TRU™ Chucks
- All backplates are made of hardened steel
- Backplates are fully machined

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

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



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



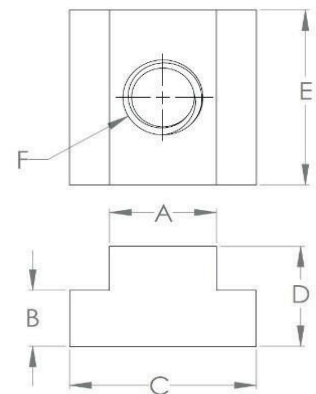
### Base Plate

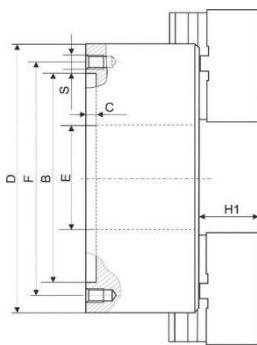
Chuck Size	Base Plate									Chuck Mounting Bolt	Use with Chuck
	Item Number	A	B	C	D	Thru-Hole E	F	G	H		
6	3-872-606P	6.29	5.51	5.11	3.38	1.65	0.78			3x M10x1.5	3-866-0600P
8	3-872-608P	7.87	6.92	6.33	4.33	2.16	0.86	3 x M10x1.5	4 x 3/8-16 UNC	3x M10x1.5	3-866-0800P
10	3-872-610P	9.84	8.81	8.18	5.70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

### T-Slot Nut

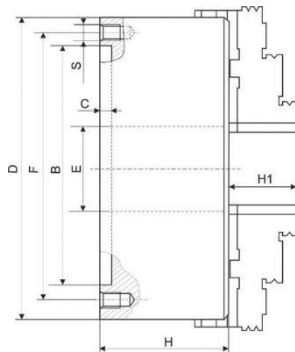
Chuck Size	T-Slot Nut						
	Item Number	A	B	C	D	E	F*
6	3-706-3816	0.50	0.28	0.87	0.50	0.87	4x 3/8-16 UNC
8							
10	3-706-1213	0.62	0.34	1.00	0.62	1.12	4x 1/2-13 UNC
12							
16	3-706-5811	0.68	0.43	1.12	0.75	1.25	4x 5/8-11 UNC
20	3-706-3410	0.87	0.56	1.50	1.00	1.50	4x 3/4-10 UNC

F\* - T-Nut is fully threaded.





Type I



Type II

## Precision Scroll Chucks

### 2, 3 & 4-Jaw – Self-Centering

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

#### Each Chuck Provided With

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

Chuck Size	Item Number	Jaw Type	# of Jaws	Type	B	C	D	Thru- Hole E	F	H	H1	S	Max RPMs	Gripping Force (daN)	Weight (lb.)
6	3-831-0600P	2 Pc with Soft Top Jaws	2	I	4.92	0.15	6.30	1.65	5.51	2.53	1.69	6xM10	3600	2400	22
8	3-831-0800P				6.29		7.87	2.16	6.92	2.95	1.77		3000	2900	39
10	3-831-1000P				7.87		9.84	2.99	8.81	3.34	2.08		2500	3600	64
12	3-831-1200P				10.23	12.40	4.05	11.25	3.70	2.24	6xM16	2000	4400	111	
16	3-831-1600P				12.99							15.75	5.35	14.25	4.13
5	3-820-0500P	2 Pc with Hard Top Jaws	3	II	3.74	0.15	4.92	1.25	4.25	2.20	1.57	3xM8	5500	2400	11
6	3-820-0600P				4.92		6.30	1.65	5.51	2.53	1.73	6xM10	4600	3100	22
8	3-820-0800P				6.29		7.87	2.16	6.92	2.95	1.77		4000	3700	39
10	3-820-1000P				7.87	9.84	2.99	8.81	3.34	2.05	6xM12		3500	4600	64
12	3-820-1200P				10.23	12.40	4.05	11.25	3.70	2.24	6xM16	2800	5500	111	
16	3-820-1600P				12.99							15.75	5.35	14.25	4.13
20	3-820-2000P				16.53	19.69	7.48	18.03	4.72	3.14	6xM16	1300	7200	322	
25	3-820-2500P				21.45							24.80	9.92	23.07	5.31
32	3-820-3200P				28.74	31.50	10.55	29.92	6.10	3.66	6xM20	764	13000	902	
40	3-820-4000P				35.82						39.37	15.35	37.40	6.46	3.66
5	3-841-0500P	2 Pc with Hard Top Jaws	4	II	3.74	0.15	4.92	1.25	4.25	2.20	1.57	3xM8	5500	2400	11
6	3-841-0600P				4.92		6.30	1.65	5.51	2.53	1.73	6xM10	4600	3100	22
8	3-841-0800P				6.29		7.87	2.16	6.92	2.95	1.77		4000	3700	39
10	3-841-1000P				7.87	9.84	2.99	8.81	3.34	2.05	6xM12		3500	4600	64
12	3-841-1200P				10.23	12.40	4.05	11.25	3.70	2.24	6xM16	2800	5500	111	
16	3-841-1600P				12.99							15.75	5.35	14.25	4.13
20	3-841-2000P				16.53	19.69	7.48	18.03	4.72	3.14	6xM16	1300	7200	322	



## Front & Back Mount Precision Scroll Chucks

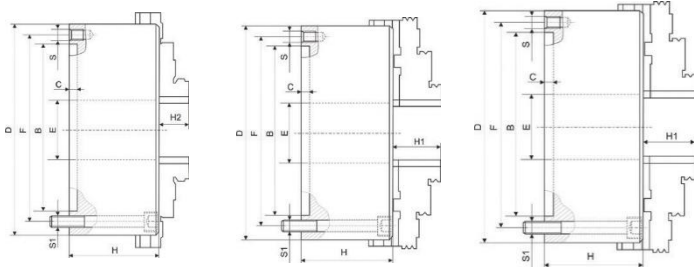
### 3 & 4-Jaw – Self-Centering



Type I

Type II

Type III



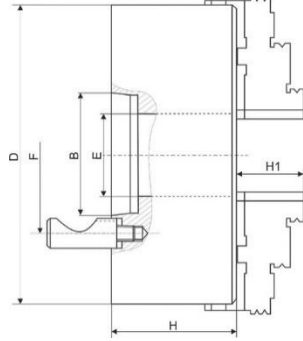
- Forged Steel Body
- Can be mounted directly on 3/6 slot rotary tables or on a base plate when the rotary table has 3/6 or 4/8 T-slots
- Compatible with Rotary Table Packages (see page 19)
- Base plates are designed for use with all rotary tables and other devices where back mounting chucks cannot be used
- These chucks can also be mounted to a rough machined backplate, but will require machining of bolt hole patterns and projections for finished assembly
- Chucks 20" and above have T-Slots (for standard sizes see page 11)

#### Each Chuck Provided With

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

Chuck Size	Item Number	Jaw Type	# of Jaws	Type	B	C	D	Thru- Hole E	F	H	H1/H2	S	S1	Max RPM	Gripping Force (daN)	Weight (lb.)				
3	3-813-0301P	Solid	3	I	2.20	0.11	3.15	0.63	2.63	1.73	0.51	3xM6	3xM6	7000	1000	3				
4	3-813-0401P				2.75		0.78	3.26	1.96	0.66	3xM8			3xM8	6300	1700	6			
5	3-813-0501P				3.74		1.26	4.25	2.20	0.78					3xM10	3xM10	5500	2400	11	
6	3-813-0601P				4.92	0.15	6.30	1.65	5.51	2.53	1.29	3xM12	3xM12	4600			3100	22		
8	3-813-0801P				6.29		2.16	6.92	2.95	1.14	3xM16			3xM16	4000	3700	39			
10	3-813-1001P				7.87	0.19	9.84	2.99	8.81	3.34		1.33	3xM16		3xM16	3500	4600	64		
12	3-813-1201P				10.23		4.05	11.26	3.70	1.63	2800	5500		111						
5	3-813-0500P	2pc	3	II	3.74	0.15	4.92	1.26	4.25	2.20	1.57	3xM8	3xM8	5500	2400	11				
6	3-813-0600P				4.92		1.65	5.51	2.53	1.73	3xM10						3xM10	4600	3100	22
8	3-813-0800P				6.29		2.16	6.92	2.95	1.77										
10	3-813-1000P				7.87	0.19	9.84	2.99	8.81	3.34	2.05	3xM16	3xM16	2800	5500	111				
12	3-813-1200P				10.23		4.05	11.26	3.70	2.24	6xM16						6xM16	2000	6500	189
16	3-813-1600P				12.99	0.27	15.75	5.35	14.25	4.13		2.63	1300	7200	322					
20	3-813-2000P				16.53		7.48	18.03	4.72	3.15	1000	8000				556				
25	3-813-2500P	21.45	9.92	23.07	5.31	3.42	1300	7200	322											
6	3-814-0600P	2pc	4	III	4.92	0.15	6.30	1.65	5.51	2.53	1.73	3xM10	3xM10	4600	3100	22				
8	3-814-0800P				6.29		2.16	6.92	2.95	1.77	3xM12						3xM12	3500	4600	64
10	3-814-1000P				7.87		0.19	9.84	2.99	8.81										
12	3-814-1200P				10.23	4.05		11.26	3.70	2.24	2000	6500	189							
16	3-814-1600P				12.99	0.27	15.75	5.35	14.25	4.13				2.63	1300	7200	322			
20	3-814-2000P				16.53		7.48	18.03	4.72	3.15	1300	7200	322							





## Type D1 Direct Mount Precision Scroll Chucks

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

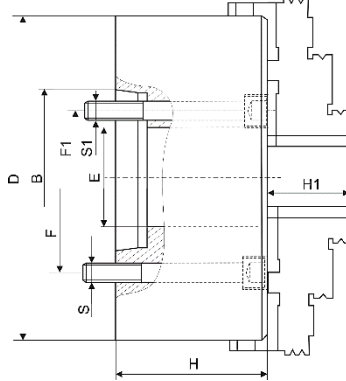
- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible American Standard Tongue and Groove Jaw System
- Chucks 20" and above have T-Slots (for standard T-slot dimensions see page 11)

Each Chuck Provided With

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

Chuck Size	Item Number	Taper Size	B	D	Thru- Hole E	F	H	H1	Max RPM	Gripping Force (daN)	Weight (lb.)	Camlock Studs		
												Qty	Dia (in)	Thread
8	3-823-0834P	D1-4	2.50	7.87	2.16	3.25	3.87	1.77	4000	3700	50	3	5/8	M10x1
	3-823-0836P	D1-6	4.18			5.25	4.25				52	6	7/8	M16x1.5
10	3-823-1036P	D1-6	4.18	9.84	2.99	5.25	4.60	2.05	3500	4600	86	6	7/8	M16x1.5
	3-823-1038P	D1-8	5.50			6.74	4.70				88		1	M20x1.5
12	3-823-1236P	D1-6	4.18	12.40	4.05	5.25	5.05	2.24	2800	5500	153	6	7/8	M16x1.5
	3-823-1238P	D1-8	5.50			6.74					150		1	M20x1.5
	3-823-1239P	D1-11	7.75			9.25	5.37				151		1-3/16	M22x1.5
16	3-823-1636P	D1-6	4.18	15.75	5.35	5.25	5.49	2.63	2000	6500	260.9	6	7/8	M16x1.5
	3-823-1638P	D1-8	5.50			6.74					261		1	M20x1.5
	3-823-1639P	D1-11	7.75			9.25	5.80				261		1-3/16	M22x1.5
20	3-823-2038P	D1-8	5.50	19.69	5.35	6.08	3.15	1300	7200	433	6	1	M20x1.5	
	3-823-2039P	D1-11	7.75		7.48	6.39				424		1-3/16	M22x1.5	
25	3-823-2539P	D1-11	7.75	24.80	7.48	9.25	6.92	3.42	1000	8000	748	6	1-3/16	M22x1.5

## Type A Direct Mount Precision Scroll Chucks



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

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

Each Chuck Provided With

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

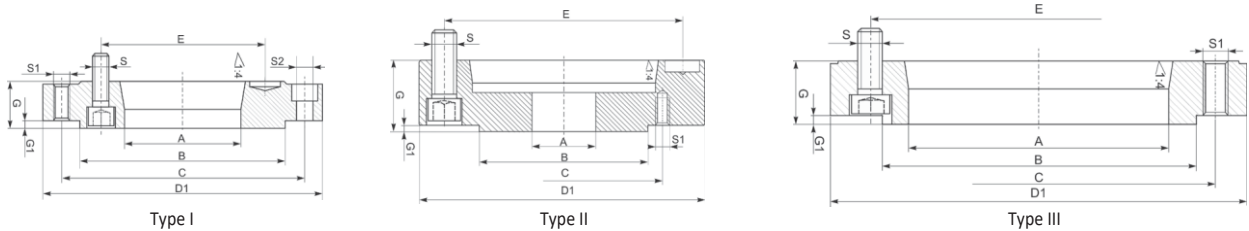
Chuck Size	Item Number	Taper Size	B	D	Thru-Hole (E)	F	F1	H	H1	S	S1	Max RPM	Weight (lb.)
16	3-821-1628P	A2-8	4.18	15.75	5.35	6.74	6.50	5.37	2.63	6xM16	6xM20	2000	246
	3-821-1629P	A1-11	7.75										
20	3-821-2028P	A2-8	5.50	19.69	5.35	6.74		5.96	3.15	6xM16		1300	414
	3-821-2029P	A2-11	7.75		7.48	9.25				6xM20			
	3-821-2030P	A2-15	-		-	-				6xM24			
25	3-821-2529P	A2-11	7.75	24.80	7.48	9.25		6.73	3.42	6xM20		1000	726
	3-821-2530P	A2-15	11.25		9.92	13.00				6xM24			
32	3-821-3211P	A2-11	28.74	31.50	10.70	29.92		6.10	3.66	6xM20		765	900
	3-821-3215P	A2-15								6xM24			
40	3-821-4015P	A2-15	35.82	39.37	15.35	37.40		6.49	3.66	6xM24		610	1600

## Steel Backplates for Precision Scroll Chucks



### Type A Steel Backplates for Precision Scroll Chucks

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

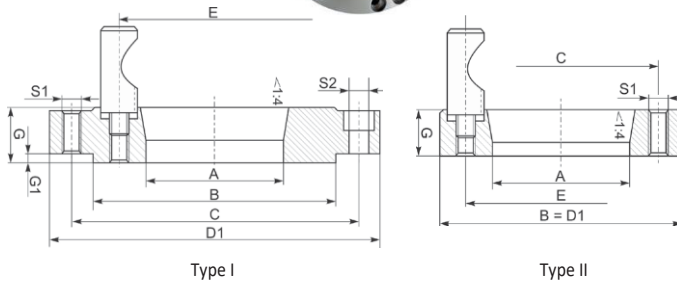


Chuck Size	Item Number	Taper Size	Type	Thru-Hole A	B	C	D1	E	G	G1	S (Metric)	S (Inch)	S1	S2	Weight (lb.)			
4	3-873-043P	3	I	2.02	2.75	3.26	3.93	2.77	0.86	0.09	3xM10		3xM8	-	4			
5	3-873-053P	3	I	2.02	3.74	4.25	4.92	2.77	0.86	0.13	3xM10		3xM8	3x8.4	5.30			
	3-873-054P	4	II	2.39				3.25										
	3-873-055P	5		3.12				4.12								1.02		
	3-873-056P	6	III	1.41				5.25								1.57	6xM12	
6	3-873-063P	3	I	2.02	4.92	5.51	6.29	2.77	0.86	0.13	3xM10		3xM10	6x10.5	9.3			
	3-873-064P	4		2.39				3.25										
	3-873-065P	5		3.12				4.12										
	3-873-066P	6	II	4.05				5.25								0.98	3xM12	
8	3-873-084P	4	I	2.39	6.29	6.92	7.87	3.25	0.86	0.13	6xM10		3xM10	6x10.5	18			
	3-873-085P	5		3.12				4.12								7/16-14		
	3-873-085PI																	
	3-873-086P	6		4.05				5.25									6xM12	
10	3-873-105P	5	I	3.12	7.87	8.81	9.84	4.12	1.10	0.17	6xM10		3xM12	6x13.0	27			
	3-873-105PI															7/16-14		
	3-873-106P	6		4.05				5.25								0.96	6xM12	
	3-873-106PI															1/2-13		
	3-873-108P			8				5.35								6.74	1.10	6xM16
12	3-873-126P	6	I	4.05	10.23	11.25	12.40	5.25	1.29	0.17	6xM12		3xM16	6x17.0	49			
	3-873-128P	8		5.35				6.74								6xM16		
	3-873-129P	11		II				7.59								9.25	1.49	6xM20
16	3-873-166P	6	I	4.05	12.99	14.25	15.74	5.25	1.41	0.17	6xM12		3xM16	6x17.0	93			
	3-873-168P	8		5.35				6.74								6xM16		
	3-873-169P	11		7.59				5.25								6xM20		
20	3-873-208P	8	I	5.35	16.53	18.03	19.68	6.74	1.41	0.17	6xM16		3xM16	6x17.0	130			
	3-873-209P	11		7.59				5.25							6xM20	120		
	3-873-215P	15		11.07				13							6xM24	115		
25	3-873-258P	8	I	5.35	21.45	23.07	24.80	6.74	1.65	0.23	6xM16		6xM16	6x17.0	205			
	3-873-259P	11		7.59				9.25								6xM20		
	3-873-260P	15		11.07				13								6xM24	242	
32	3-873-329P	11	-	7.59	14.96	13	14.96	5.25	1.77	-	6xM20		6xM24	-	89			
	3-873-330P	15		11.07				13							1.57	6xM24	69	

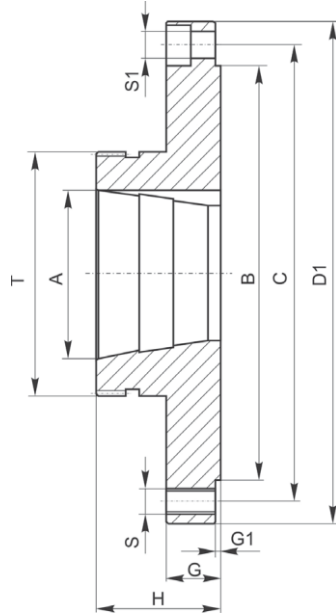


## Type D Steel Backplates for Precision Scroll Chucks

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



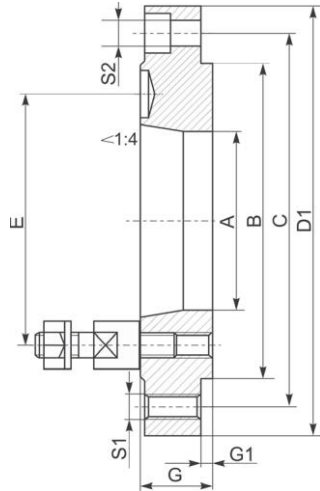
Chuck Size	Item Number	Taper Size	Type	Thru-Hole A	B	C	D1	E	G	G1	S1	S2	Weight (lb.)		
5	3-878-053P	3	I	2.02	3.74	4.25	4.92	2.77	1.02	0.13	3xM8	3x8.4	3.0		
	3-878-054P	4		2.39				3.25							
	3-878-055P	5		1.65				4.12						1.25	
	3-878-056P	6		2.75				6.88						5.25	1.53
	3-878-058P	8						8.66						6.74	1.67
6	3-878-063P	3	I	2.01	4.92	5.51	6.29	2.77	1.06	0.13	3xM10	6x10.5	5.7		
	3-878-064P	4		2.39				3.25					5.5		
	3-878-065P	5		3.12				4.12					1.18	4.8	
	3-878-066P	6		4.05				6.61					5.25	1.43	4.1
8	3-878-084P	4	I	2.39	6.29	6.92	7.87	3.25	1.06	0.13	3xM10	6x10.5	9.0		
	3-878-085P	5		3.12				4.12					1.18	7.7	
	3-878-086P	6		4.05				5.25					1.49	7.9	
10	3-878-105P	5	I	3.12	7.87	8.81	9.84	4.12	1.18	0.17	3xM12	6x13.0	17.8		
	3-878-106P	6		4.05				5.25					1.43	16.7	
	3-878-108P	8		5.35				6.74					1.53	14.7	
12	3-878-126P	6	I	4.05	10.23	11.25	12.40	5.25	1.53	0.17	3xM16	6x17.0	33.2		
	3-878-128P	8		5.35				6.74					30.8		
	3-878-129P	11		7.59				9.25					1.85	26.8	
16	3-878-166P	6	I	4.05	12.99	14.25	15.74	5.25	1.53	0.17	3xM16	6x17.0	62.1		
	3-878-168P	8		5.35				6.74					59.3		
	3-878-169P	11		7.59				9.25					1.85	54.4	
20	3-878-208P	8	I	5.35	16.53	18.03	19.68	6.74	1.53	0.17	3xM16	6x17,0	97.6		
	3-878-209P	11		7.59				9.25					1.85	92.8	
25	3-878-258P	8	I	5.35	21.45	23.07	24.80	6.74	1.53	0.23	3xM16	6x17.0	186.9		
	3-878-259P	11		7.59				9.25					1.85	180.5	
	3-878-265P	15		11.07				13					1.96	163.1	
	3-878-330P	15	II	11.07	13	1.96	71.2								



## Type L Steel Backplates for Precision Scroll Chucks

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

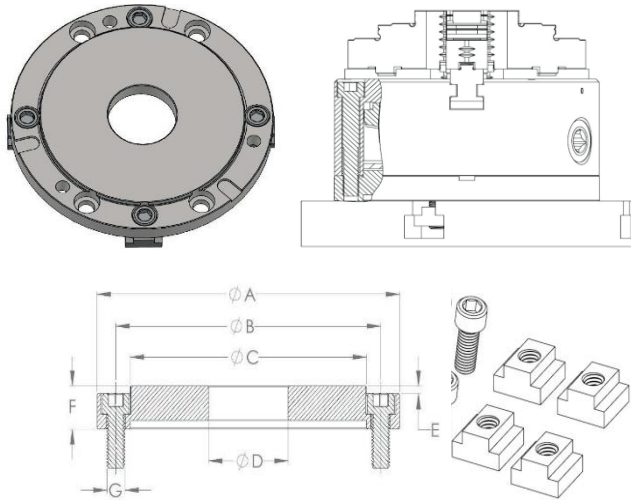
Chuck Size	Item Number	Taper Size	A	B	C	D1	G	G1	H	S1	S2	T	Weight (lb.)
6	3-879-061P	L00	2.75	4.92	5.51	6.29	0.70	0.13	2.12	3xM10	6xØ11	3.3/4-6 UNS	7.4
	3-879-062P	L0	3.25						2.51			4.1/2-6 UNS	9.0
8	3-879-081P	L00	2.75	6.29	6.92	7.87	0.70	0.13	2.12	3xM10	6xØ11	3.3/4-6 UNS	18.9
	3-879-082P	L0	3.25	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



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

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

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



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

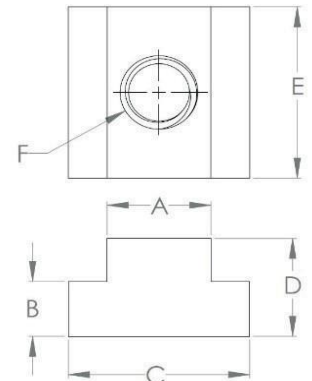
- Designed for TMX Front Mount Self-Centering
- Precision Scroll Chucks (Chuck part numbers start with 3-813 and 3-814)
- Ideal for use on milling and drilling machines as well as on rotary tables with 3/6 and 4/8 slots
- Base plates are supplied with four mounting bolts with T-nuts
- Chucks are sold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

### Base Plate

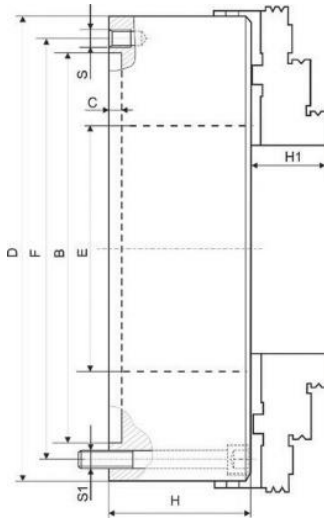
Chuck Size	Base Plate								Chuck Mounting Bolt	For use with Chuck
	Item Number	A	B	C	Thru-Hole D	E	F	G		
6	3-872-306P	6.29	5.51	4.92	1.65	0.13	0.78	4x 3/8-16 UNC	3x M10x1.5	3-813-0600P
8	3-872-308P	7.87	6.92	6.29	2.16		0.86			3-813-0800P
10	3-872-310P	9.84	8.81	7.87	2.99	0.17	0.98	4x 1/2-13 UNC	3x M12x1.75	3-813-1000P
12	3-872-312P	12.40	11.25	10.23	4.05		1.18			3-813-1200P
16	3-872-316P	15.74	14.25	12.99	5.35		1.25	4x 5/8-11 UNC	6x M16x2.0	3-813-1600P
20	3-872-320P	19.68	18.03	16.53	7.48		1.37	4x 3/4-10 UNC		3-813-2000P

### T-Slot Nut

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



F\* - T-Nut is fully threaded.



## Extra Large Thru-Hole Precision Scroll Chucks

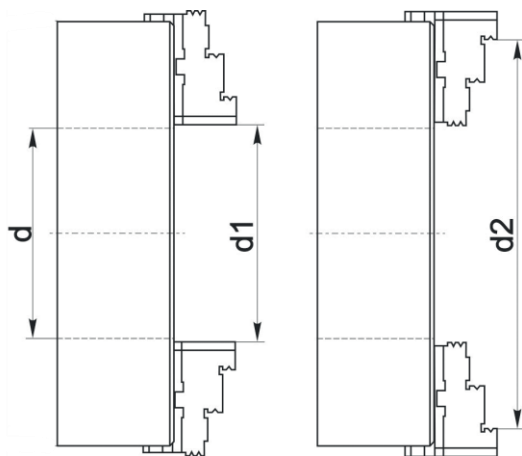
### 3-Jaw – Self-Centering

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

### Each Chuck Provided With

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

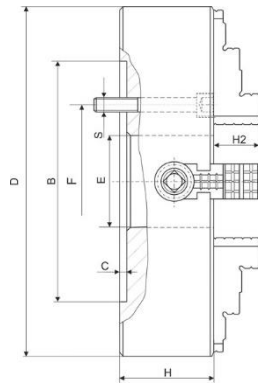
Chuck Size	Item Number	B	C	D	Thru-Hole E	F	H	H1	S	S1	Max RPM	Gripping Force (daN)	Weight (lb.)
12	3-819-1200P	10.23	0.19	12.40	5.70	11.26	3.81	2.24	3xM16	3xM16	1400	5500	103
16	3-819-1600P	14.25	0.23	15.75	8.66	15.00	4.13	2.63	6xM12	6xM12	1000	6500	143
20	3-819-2000P	18.18	0.31	19.69	12.60	18.95	4.48	3.15	6xM16	6xM16	800	7200	264
26	3-819-2600P	22.83	0.27	25.98	15.98	24.40	5.31	3.42	6xM16	6xM16	600	7700	508



## Clamping Ranges

Item Number	Thru-Hole d	d1 (min-max)	d2 (max)
3-819-1200P	5.70	1.57-5.70	12.40
3-819-1600P	8.66	5.43-8.66	15.98
3-819-2000P	12.59	10.39-12.59	20.31
3-819-2600P	15.98	13.74-15.98	24.8



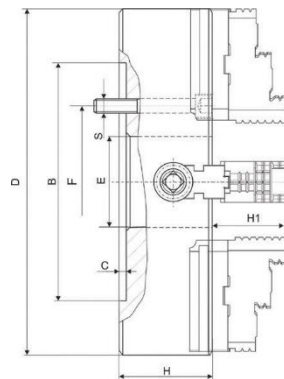


Type I

## Independent Chucks

### 4-Jaw Plain Back

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



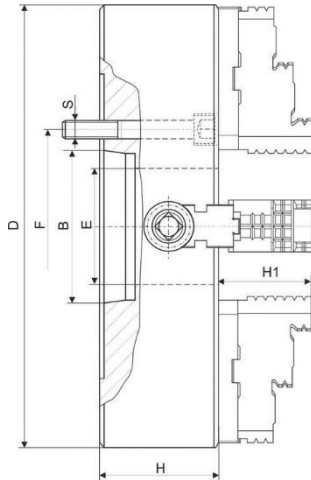
Type II

### Each Chuck Provided With

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

Chuck Size	Item Number	Jaw Type	Type	B	Thru-Hole E	C	D	F	H	H1/H2	S	Max RPM	Weight (lb.)
4	3-855-0401P	Solid	I	3.12	0.98	0.09	3.94	2.12	1.57	0.67	4xM8	3800	6
5	3-855-0501P			2.74	1.02		4.92		1.69			3500	
6	3-855-0601P			3.25	1.65		6.30	2.75	0.79	4xM10	3200	11	
8	3-855-0800P	2pc	II	4.33	1.96	0.19	7.87	3.25	2.85	1.82	4xM10	2500	38
10	3-855-1000P			5.90	2.55	0.27	9.84	4.12	3.05	2.37	4xM12	2000	58
12	3-855-1200P			6.88	3.14		12.40	5.25	3.42	2.39	4xM16	1500	107
16	3-855-1600P			7.87	3.93	0.39	15.75	6.74	3.62	2.84		1100	189
20	3-855-2000P			10.62	4.92	0.47	19.69	9.25	4.21	3.85	4xM20	700	333
25	3-855-2500P			6.29	24.80	5.00	550		633				
32	3-855-3200P			9.84	5.31	0.19	31.50	8.66	4.92	3.30	8xM24	764	990
36	3-855-3600P			5.51	35.43		5.31		679			1350	
40	3-855-4000P			5.90	39.37	5.51	611	1740					
48	3-855-4800P			11.81	47.24	9.84	509	2300					
55	3-855-5500P			6.29	55.12	5.90	437	3530					

60	3-855-6000P						59.06		6.49		8xM30	407	4320
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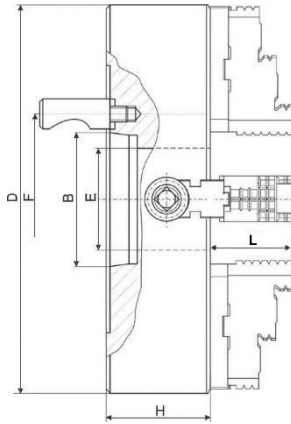
## Type A2 Direct Mount Independent Chucks

- 4-Jaw – No Need for Machining - No Adapter Plate Required
- Forged Steel Body
- Comes standard with 2-Piece Hard Reversible American Standard Tongue and Groove Jaw System
- Chucks 10" and above have T-Slots (for standard T-slot dimensions see page 11)

### Each Chuck Provided With

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

Chuck Size	Item Number	Taper Size	B	Thru-Hole E	D	F	H	H1	S	Max RPM	Weight (lb.)
6	3-856-0615P	A2-5	3.25	1.65	6.14	4.13	2.2	0.79(Solid)	4xM10	3200	11
8	3-856-0816P	A2-6	4.18	1.96	7.87	5.25	2.85	1.77	4xM12	2500	38
10	3-856-1016P	A2-6	4.18	2.55	9.84	5.25	3.05	2.05	4xM12	2000	58
	3-856-1018P	A2-8	5.50			6.74			4xM16		
12	3-856-1216P	A2-6	4.18	3.14	12.40	5.25	3.42	2.24	8xM12	1500	107
	3-856-1218P	A2-8	5.50			6.74			4xM16		
16	3-856-1616P	A2-6	4.18	3.93	15.75	5.25	3.62	2.63	8xM12	1100	189
	3-856-1618P	A2-8	5.50			6.74			4xM16		
	3-856-1619P	A2-11	7.75			9.25			4xM20		
20	3-856-2018P	A2-8	5.50	4.92	19.69	6.74	4.21	3.14	8xM16	700	333
	3-856-2019P	A2-11	7.75			9.25			8xM20		
	3-856-2020P	A2-15	11.25			13.00			4xM24		
25	3-856-2519P	A2-11	7.75	6.29	24.80	9.25	5.0	3.42	8xM20	550	633
	3-856-2520P	A2-15	11.25			13.00			4xM24		
28	3-856-2811P	A2-11	7.75	4.72	27.56	9.25	4.72	2.83	12xM20	873	715
32	3-856-3211P	A2-11	7.75	5.31	31.50	9.25	4.92	2.83	12xM20	764	990
	3-856-3215P	A2-15	11.25			13.00			12xM24		
36	3-856-3611P	A2-11	7.75	5.51	35.43	9.25	5.31	2.83	12xM20	679	1353
	3-856-3615P	A2-15	11.25			13.00			12xM24		
40	3-856-4011P	A2-11	7.75	5.90	39.37	9.25	5.51	3.14	12xM20	611	1738
	3-856-4015P	A2-15	11.25			13.00			12xM24		
	3-856-4020P	A2-20	16.25			18.25					
48	3-856-4811P	A2-11	7.75	6.29	47.24	9.25	5.70	3.14	12xM20	509	2299
	3-856-4815P	A2-15	11.25			13.00			12xM24		
	3-856-4820P	A2-20	16.25			18.25					
55	3-856-5511P	A2-11	7.75	6.29	55.12	9.25	5.90	3.14	12xM20	437	3531
	3-856-5515P	A2-15	11.25			13.00			12xM24		
	3-856-5520P	A2-20	16.25			18.25					
60	3-856-6015P	A2-15	11.25	6.29	59.06	13.00	6.49	3.14	12xM24	407	4312
	3-856-6020P	A2-20	16.25			18.25					

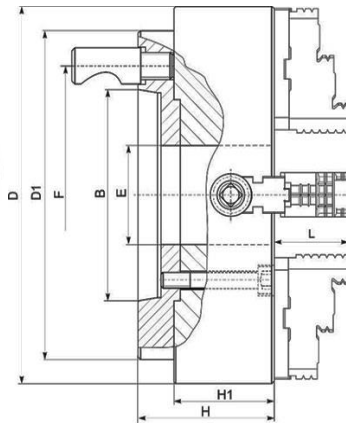


Type I

## Type D1 Mount Independent Chucks

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

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



Type II

Each Chuck Provided With

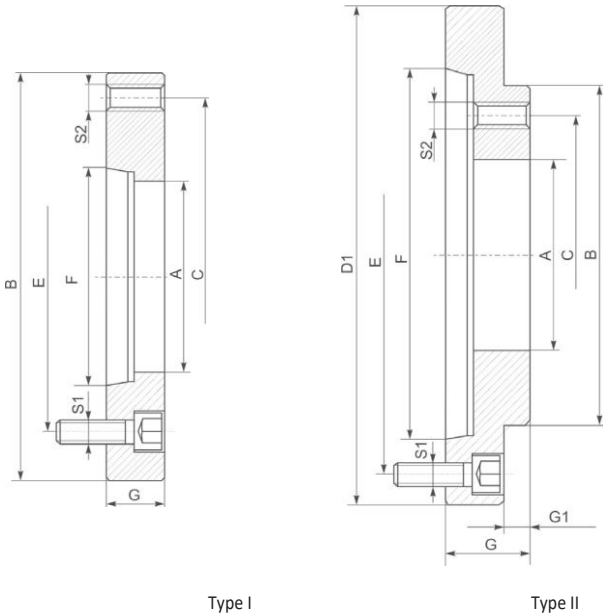
- 1 Set of Hard Master Jaws
- 1 Set of Reversible Hard Top Jaws
- 1 Chuck Wrench
- 1 Set of Camlock Studs
- 1 Set of Camlock Set Screws
- Eyebolts for chucks 16" and larger

Chuck Size	Item Number	Type	Taper Size	D	D1	B	Thru-Hole E	F	H	H1	L	Max RPM	Weight (lb.)	Camlock Studs						
														Qty	Diameter (in)	Thread				
8	3-857-0833P	I	D1-3	7.87		2.12	1.96	2.78	2.85		1.77	2500	38	3	9/16	M10x1				
	3-857-0834P		D1-4			2.50		3.25							5/8					
	3-857-0835P*	II	D1-5			5.75	3.25	1.97	4.13						4.31		2.85	47	6	3/4
	3-857-0836P*		D1-6			7.13	4.19	5.25	4.23						7/8					
10	3-857-1036P	I	D1-6	9.84		4.18	2.55	5.25	3.09		2.05	2000	58	6	7/8	M16x1.5				
	3-857-1038P*	II	D1-8			8.86		5.50							2.56		6.75	4.59	3.09	82
12	3-857-1236P		D1-6	12.40		4.18	3.15	5.25	3.42		2.24	1500	107	6	7/8	M16x1.5				
	3-857-1238P		D1-8			5.50		6.74							1		M20x1.5			
16	3-857-1636P		D1-6	15.75		4.18	3.93	5.25	3.62		2.63	1100	189	6	7/8	M16x1.5				
	3-857-1638P		D1-8			5.50		6.74							1		M20x1.5			
	3-857-1639P		I			D1-11		7.75							9.25		1-3/16	M22x1.5		
20	3-857-2038P		D1-8	19.69		5.50	4.92	6.74	4.21		3.15	700	333	6	1	M20x1.5				
	3-857-2039P		D1-11			7.75		9.25							1-3/16		M22x1.5			
25	3-857-2538P		D1-8	24.80		5.50	6.29	6.74	5.00		3.42	550	633	6	1	M20x1.5				
	3-857-2539P		D1-11			7.75		9.25							1-3/16		M22x1.5			

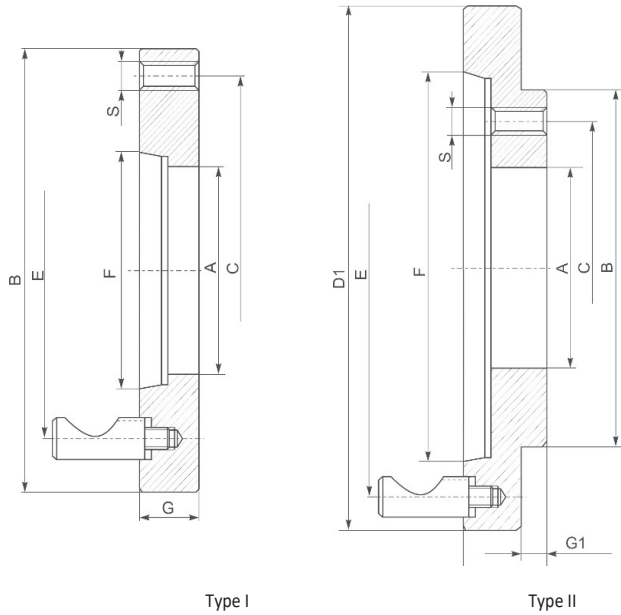
\* Indirect mount chucks

## Fully Finished Adapters for Independent Chucks

### Independent Chuck Fully Finished A Type Adapters



Chuck Size	Item Number	Taper Size	Type	Thru- Hole A	B	C	D1	E	G	F	G1	S1	S2	Weight (lb.)
6	3-873-9065P	A2-5	II	1.65	3.25	2.75	5.23	4.12	1.39	3.25	0.11	6x7/16/-14	M10	6.4
8	3-873-9085P	A2-5	II	1.96	4.33	3.25	5.23	4.12	1.49	3.25	0.21	4x7/16-14	M10	6.7
	3-873-9086P	A2-6					6.49	5.25	1.25	4.19		6x1/2-13		7.8
10	3-873-9105P	A2-5	I	2.55	5.90	4.12	-	4.12	1.06	3.25	-	8x7/16/-14	M12	6.2
	3-873-9106P	A2-6	II	2.55	5.90	4.12	6.49	5.25	1.57	4.19	0.29	6x1/2-13		10.2
	3-873-9108P	A2-8					8.26	6.74	1.49	5.50		6x5/8-11		15.6
12	3-873-9126P	A2-6	I	3.11	6.88	5.25	-	5.25	1.37	4.19	-	8x1/2-13	M16	10.4
	3-873-9128P	A2-8	II	3.14			8.26	6.74	1.59	5.50	0.29	6x5/8-11		16.4
	3-873-9129P	A2-11					11.02	9.25	1.92	7.75		6x3/4-10		37.8
16	3-873-9166P	A2-6	I	4.05	7.87	6.74	-	5.25	1.18	4.19	-	6x1/2-13	M16	11.8
	3-873-9168P	A2-8	I	3.93			-	6.74	1.39	5.50	-	6x5/8-11		12.2
	3-873-9169P	A2-11	II				11.02	9.25	1.79	7.75	0.41	6x3/4-10		28.9
	3-873-8165P	A2-15		14.96			13.00	2.55	11.25	6x7/8-9		88.9		
20	3-873-9208P	A2-8	I	4.92	10.62	9.25	-	6.74	1.37	5.50	-	6x5/8-11	M20	22.9
	3-873-9211P	A2-11					9.25	1.79	7.75	6x3/4-10	21.8			
	3-873-9215P	A2-15	II	14.96	13.00	2.04	11.25	0.49	6x7/8-9	66.7				
25	3-873-92508P	A2-8	I	5.35	10.62	9.25	-	6.74	1.25	5.50	-	6x5/8-11	M20	23.3
	3-873-92511P	A2-11	II	6.29			11.02	9.25	1.49	7.75	0.49	6x3/4-10		24.2
	3-873-92515P	A2-15					14.96	13.00	2.14	11.25		6x7/8-9		66.7
	3-873-92520P	A2-20	20.47	18.25			2.36	16.25	6x1-8	140.0				
32	3-873-93211P	A2-11		7.59	14.96	13.00	-	9.25	1.57	7.75	-	6x3/4-10	M24	57.8

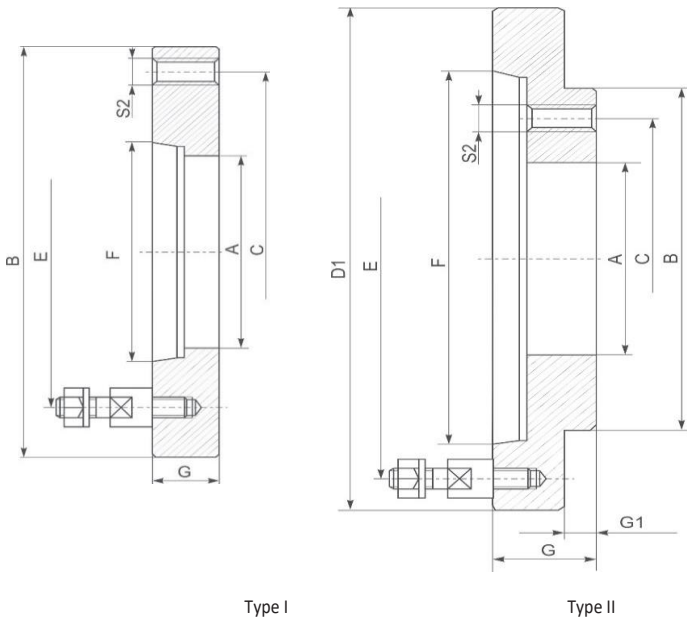


## Independent Chuck Fully Finished D Type Adapters



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

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



Chuck Size	Item Number	Taper Size	Type	Thru- Hole A	B	C	D1	E	F	G	G1	S2	Weight (lb.)
6	3-921-0660P	6	II	1.65	3.25	2.75	6.69	5.25	4.18	1.33	0.11	M10	6.2
8	3-921-0860P	6	II	1.96	4.33	3.25	6.69	5.25	4.18	1.33	0.21	M10	7.7
10	3-921-1060P	6	II	2.55	5.90	4.12	6.49	5.25	4.18	1.39	0.29	M12	9.7
	3-921-1080P	8					8.66	6.75	5.50	1.49			14.3
12	3-921-1260P	6	I	3.15	6.89	5.25	-	5.25	4.18	1.29	-	M16	9.9
	3-921-1280P	8	II				8.26	6.75	5.50	1.59	0.29		20.9
16	3-921-1680P	8	II	3.94	7.87	6.75	8.66	6.75	5.50	1.10	0.43	M16	10.6
20	3-921-2080P	8	I	4.92	10.63	9.25	-	6.75	5.50	1.18	-	M20	24.7

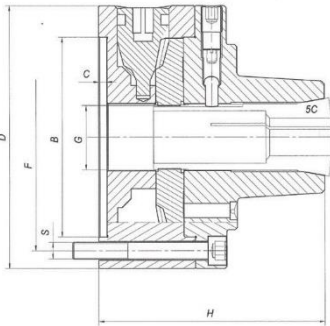
TMX 5C and 16C collets  
available on [www.tmxtools.com](http://www.tmxtools.com)

## 5C & 16C Collet Chucks

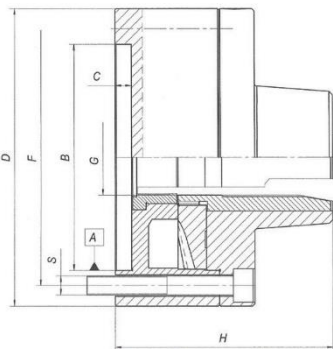
- Forged Steel Body
- All forged steel bodies
- Tru-Length type features fixed collet position for fast and accurate workpiece changes.
- Super Precision SET-TRU™ type offers fine adjustment with 4 micro-adjustment screws for outstanding repeatability



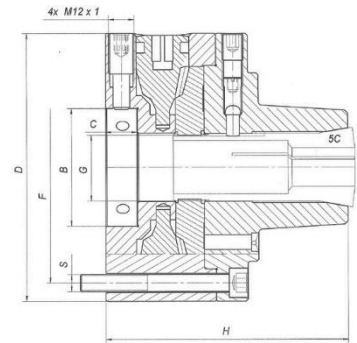
3-862-0501P  
5C Standard



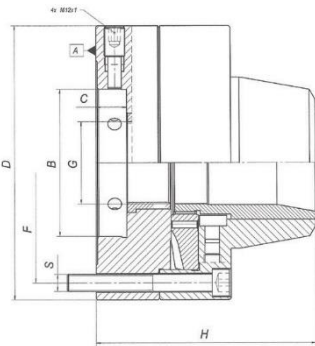
3-862-0503P  
5C TRU-Length



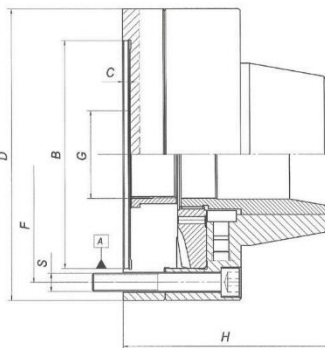
3-862-0505P  
5C Super Precision SET-TRU™



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



3-862-0601P  
16C TRU-Length



Chuck Size	Item Number	Collet Size	Type	B	C	D	F	H	G	S1	Max RPM	Weight (lb.)
5	3-862-0501P	5C	Standard	3.74	0.15	4.921	4.25	4.23	1.239"-20	3xM8x65	6000	10
	3-862-0503P		TRU-Length		0.27			3.62	1.239"-20			11
	3-862-0505P		Super Precision SET-TRU™		2.16			0.59	4.48			1.239"-20
6	3-862-0601P	16C	TRU-Length	4.92	0.15	6.299	5.51	4.50	M47.5x1.75	3xM10x70	6000	21
	3-862-0605P		Super Precision SET-TRU™ and TRU-Length	3.38	0.70			5.05	M47.5x1.75			3xM8x85





## Fully Machined Adapters for Collet Chucks

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

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

Super Precision SET-TRU™	Standard & Tru-Length	Spindle Mount	Collet Size
3-874-065P	3-873-065P	A2-5	16C
3-874-066P	3-873-066P	A2-6	
3-875-063P	3-878-063P	D1-3	
3-875-064P	3-878-064P	D1-4	
3-875-065P	3-878-065P	D1-5	
3-875-066P	3-878-066P	D1-6	
3-875-068P	-	D1-8	
F3-8733-879-9061P	3-879-061P	L00	
3-879-9062P	3-879-062P	L0	
3-876-062P	3-871-062P	1.1/2-8	
3-876-064P	-	2.3/16-10	
3-876-066P	3-871-063P	2.1/4-8	

# Oil Country Chucks

LARGE DIAMETER,  
EXTRA HEAVY DUTY



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## Oil Country Chucks

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

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

### Heavy Duty Construction

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

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

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

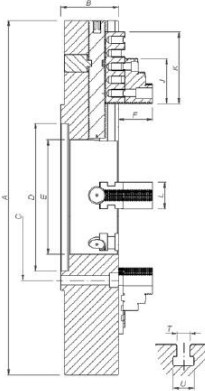
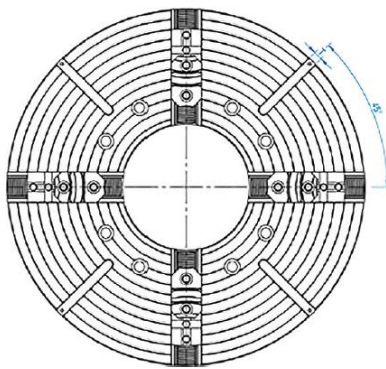
### Exceptional Accuracy

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

### Available Options

- 3-Jaw Scroll and 4-Jaw Independent Chucks
- Direct Mount for A2 and D1 Spindles
- Large Bore (Thru-Hole) Options
- 16-40" standard with larger sizes upon request
- Plain Back chucks available upon request
- All chucks have T-slots (for standard specifications see page 11)
- Extra-Large Bore (Thru-Hole) option4-Jaw Extra Heavy Duty Independent Chucks





## A2 Direct Mount 4-jaw Independent Chucks, Extra Large Thru-Hole

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

### Each Chuck Provided With

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

Chuck Size	Spindle Mount	Item Number	A	B	C	D	Thru- Hole (E)	F	J	K	L	T	T- Slots	M	Max RPM	Max Torque on Key Da.N.M	Gripping Force (daN)	Weight (lb.)*
18	A2-11	3-859-1811P	17.72	5.75	9.25	7.75	6.73	3.270	5	6.5	2.36	0.71	4x18	Ø40	1350	40	2750	230
	A2-15	3-859-1815P			13.00	11.25	7.28											
21	A2-11	3-859-2111P	20.87	5.75	9.25	7.75	7.56	3.270	5	6.5	2.36	0.71	4x18	Ø40	1150	50	3125	470
	A2-15	3-859-2115P			13.00	11.25	7.28											
24	A2-11	3-859-2411P	23.62	6.10	9.25	7.75	7.56	3.620	5	7.99	2.95	0.87	4x22	Ø50	1019	60	3750	661
	A2-15	3-859-2415P			13.00	11.25	11.06											
	A2-20	3-859-2420P			18.25	16.25	12.6											
28	Recessed	3-859-2800P	27.56	6.30	20.50	22	16	3.740	5	7.99	2.95	0.87	4x22	Ø50	873	60	3750	825
	A2-15	3-859-2815P		13.00	11.25	10.51	3.620											
	A2-20	3-859-2820P		18.25	16.25	12.6	3.620											
32	A2-15	3-859-3215P	31.50	6.50	13.00	11.25	10.51	3.620	5	7.99	2.95	0.87	4x22	Ø50	764	70	4750	1191
	A2-20	3-859-3220P			18.25	16.25	12.6											
	A2-20	3-859-3222P			18.25	16.25	14.75											
36	A2-15	3-859-3615P	35.43	6.50	13.00	11.25	11.06	3.620	5	7.99	2.95	0.87	4x22	Ø50	679	70	4750	1543
	A2-20	3-859-3620P			18.25	16.25	14.56											
40	Recessed	3-859-4000P	39.37	6.50	31.50	27.56	22	3.820	5	7.76	2.92	0.87	4x22	Ø50	611	70	4750	1800
	A2-15	3-859-4015P			13.00	11.25	10.51	3.620		9.45	2.95							
	A2-20	3-859-4020P			18.25	16.25	14.56	3.620		9.45	2.95							
	A2-28	3-859-4028P			25.50	23.00	20.87	3.620		9.45	2.95							

All dimensions in inches (in) unless otherwise specified.

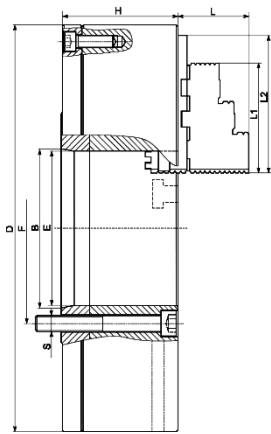
\*Weights are approximate



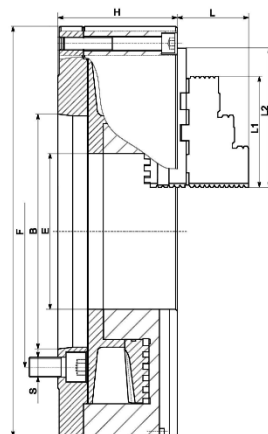
## 3-Jaw Extra Heavy Duty Scroll Chucks

Type A2 Mount, Extra Large Thru-Hole

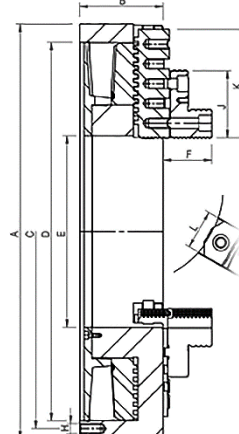
- Fully finished type A mount – No need for machining
- All forged steel bodies are hardened to 28 HRC providing improved durability and rigidity
- All bearing surfaces are carefully hardened and machined at high tolerances.
- Each scroll is balanced.
- Extra Heavy Duty 2 piece Hard Reversible American Standard Tongue and Groove jaws made of high quality alloy steel then hardened
- Large Thru-Hole
- All chucks have T-Slots (for standard T-slot dimensions see page 11)
- Made in Europe



Type I



Type II



Type III

Each Chuck Provided With

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

Type	Chuck Size	Spindle Mount	Item Number	B	D	Thru-Hole (E)	F	H	L	L1	L2	S	Max RPM	Max Torque on key Da.N.m	Gripping Force (daN)	Weight (lb.)*
I	20	A2-11	3-825-2011P	19.69	5.87	9.25	7.75	7.48	3.43	5.32	6.65	6xM20	1000	40	12500	560
II		A2-15	3-825-2025P			13	11.25	8.07								6xM24

Type	Chuck Size	Spindle Mount	Item Number	A	B	C	D	Thru-Hole (E)	F	J	K	L	Max RPM	Max Torque on key Da.N.m	Gripping Force (daN)	Weight (lb.)*				
III	25	A2-15	3-825-2515P	24.80	6.61	13	11.25	11.06	3.27	5	6.5	2.36	970	40	12500	650				
		A2-20	3-825-2520P		6.69	14.5	16.25	12.52												
	28	A2-11	3-825-2811P	27.56	6.81	13	11.25	11.06	3.62	5.12	8.58	2.95	873	70	13500	816				
		A2-15	3-825-2815P														6.89	14.5	16.25	12.52
	32	A2-15	3-825-3215P	31.5	7.01	13	11.25	11.06	3.62	5.12	9.84	2.95	764	75	13000	992				
		A2-20	3-825-3220P														7.09	18.25	16.25	12.55
	36	A2-15	3-825-3615P	35.43	7.48	13	11.25	11.06	3.62	5.12	9.84	2.95	679	75	12500	1433				
		A2-20	3-825-3620P														18.25	16.25	16.06	
	40	A2-15	3-825-4015P	39.37	7.48	18.25	16.25	16.06	3.62	5.12	9.84	2.95	611	90	12000	1720				
		A2-20	3-825-4020P														7.64	25.5	23	18.5
		A2-28	3-825-4028P																	

\*Weights are approximate.



# VTL Chucks

VERTICAL TURNING  
LATHE CHUCKS

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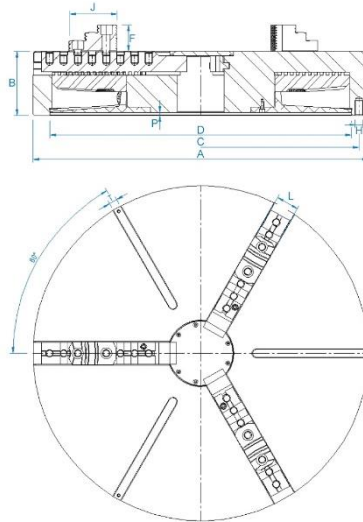
## VTL Chucks

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

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



Custom Mounting Options available.



### 3 & 4-Jaw VTL Scroll Chucks Self-Centering

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

#### Each Chuck Provided With

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

### 3-Jaw

# of Jaws	Chuck Size	Part Number	A	B	C	D	F	H	J	L	P	T-Slots (no x throat width mm)	Max Torque on Key Da.N.M	Gripping Force DAN	Max RPM	Weight (lb.)*	Clamping Range		
																	Ø Max	Ø Min	
3	25	3-826-2500P	24.80	5.51	23.07	21.46	3.19	6xM16	5.06	1.77	0.28								
	28	3-826-2800P	27.56	6.38	25.98	24.80	2.80	6xM20	5.00	2.36	0.31	3x18	70	11700	873	739	27.56	7.09	
	32	3-826-3200P	31.50	6.57	29.92	28.74		6xM22									31.50		
	36	3-826-3600P	35.43	6.77	33.46	31.89		6xM22									35.43		
	40	3-826-4000P	39.37	7.87	37.40	35.83	2.80	6xM24	5.12	2.95	0.39	3x18	140	15500	611	1590	39.37	7.87	
	48	3-826-4800P	47.24														47.24		
	52	3-826-5200P	51.18														470	3674	48.43
	55	3-826-5500P	55.12														437	4079	55.12
	63	3-826-6300P	62.99	41.34			3.15	6xM30				6x22			382	6173	62.99	9.45	
71	3-826-7100P	70.87	70.87														340		9480

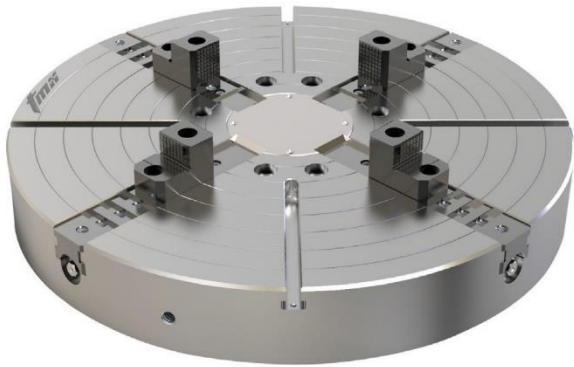
All dimensions in inches (in) unless otherwise specified. \*Weights are approximate. Custom Mounting Options available.

### 4-Jaw

# of Jaws	Chuck Size	Part Number	B	C	D	F	H	J	L	P	T-Slots (no x throat width mm)	Max Torque on Key Da.N.M	Gripping Force DAN	Max RPM	Weight (lb.)*	Clamping Range		
																Ø Max	Ø Min	
4	28	3-842-2800P	6.38	25.98	24.80	2.80	6xM20	5.00	2.36	0.31	4x18	70	11700	873	750	27.56	7.09	
	32	3-842-3200P	6.57	29.92	28.74											31.50		
	36	3-842-3600P	6.77	33.46	31.89											35.43		
	40	3-842-4000P	7.87	37.40	35.83	2.80	6xM24	5.12	2.95	0.39	4x18	140	15500	611	1609	39.37	7.87	
	48	3-842-4800P														509	2712	47.24
	52	3-842-5200P														470	3740	48.43
	55	3-842-5500P														437	4189	55.12
	63	3-842-6300P	41.34			3.15	6xM30				8x22			382	6327	62.99	9.45	
71	3-842-7100P	70.87														340		9700

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





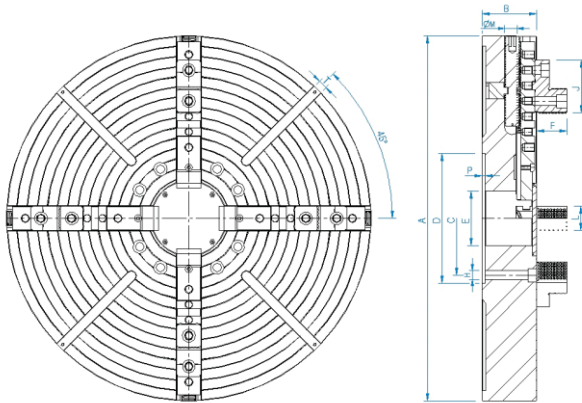
## VTL Independent Chucks

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

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

#### Each Chuck Provided With

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



## Plain Back Independent VTL Chucks

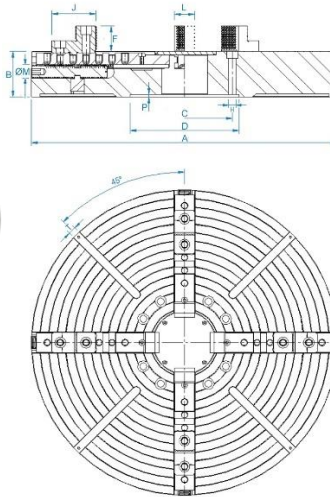
Chuck Size	Part Number	A	B	C	D	F	H	J	L	M Ø Screw	T- Slots (no x throat width mm)	Max Torque on Key Da.N.M	Gripping Force DAN	Max RPM	Weight* (lb.)	Clamping Range	
																Ø Max	Ø Min
24	3-858-2400P		5.31	9.25	11.81	2.91	8xM20	5.12	2.36	40	4x22	60	4000	970	529	23.62	7.09
28	3-858-2800P															27.56	
32	3-858-3200P		5.31	13.00	14.96	2.91	8xM24	5.12	2.36	40	4x22	70	4500	764	1124	31.50	7.09
40	3-858-4000P		5.91	13.00	14.96	3.07	8xM24	5.12	2.95	50	4x22	90	6250	611	1874	39.37	7.87
48	3-858-4800P		6.30	18.25	20.47	3.07	8xM24	5.12	2.95	50	4x22	90	6250	509	2646	47.24	9.45
55	3-858-5500P		6.69	18.25	20.47	3.07	8xM24	5.12	2.95	50	4x22	90	6250	437	3748	55.12	9.45
63	3-858-6300P		7.28	25.50	28.35	4.02	8xM30	7.09	3.54	64	8x28	110	7000	382	5732	62.99	9.45
71	3-858-7100P															70.87	
79	3-858-7900P															78.74	

All dimensions in inches (in) unless otherwise specified.

\*Weights are approximate.

All above diameters are also available with A type mounts.

Custom Mounting Options available.



## Type A2 Direct Mount VTL Independent Chucks

4-Jaw – No Adapter Plate Required

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

Each Chuck Provided With

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

## Type A Direct Mount

Chuck Size	Spindle Mount	Part Number	B	C	D	F	H	J	L	M Ø Screw	T- Slots (no x throat width mm)	Max Torque On Key Da.N.M	Gripping Force DAN	Max RPM	Weight (lb.)*	Clamping Range	
																Ø Max	Ø Min
24	A2-8	3-858-2408P	5.31	9.25	11.81	2.91	8XM20	5.12	2.36	40	4x22	60	4000	970	529	23.62	7.09
	A2-11	3-858-2411P															
28	A2-8	3-858-2808P	5.31	9.25	11.81	2.91	8XM20	5.12	2.36	40	4x22	60	4000	873	838	27.56	7.09
	A2-11	3-858-2811P															
32	A2-11	3-858-3211P	5.31	13.00	14.96	2.91	8XM24	5.12	2.36	40	4x22	70	4500	764	1124	31.5	7.09
	A2-15	3-858-3215P															
36	A2-11	3-858-3611P	5.31	13.00	14.96	2.91	8XM24	5.12	2.36	40	4x22	70	4500	679	1378	35.43	7.09
	A2-15	3-858-3615P															
40	A2-11	3-858-4011P	5.91	13.00	14.96	3.07	8XM24	5.12	2.95	50	4x22	90	6250	611	1874	39.37	7.84
	A2-15	3-858-4015P															
	A2-20	3-858-4020P															
48	A2-11	3-858-4811P	6.3	18.25	20.47	3.07	8XM24	5.12	2.95	50	4x22	90	6250	509	2646	47.24	9.45
	A2-15	3-858-4815P															
	A2-20	3-858-4820P															
55	A2-11	3-858-5511P	6.69	18.25	20.47	3.07	8XM24	5.12	2.95	50	4x22	90	6250	437	3748	55.12	9.45
	A2-15	3-858-5515P															
	A2-20	3-858-5520P															
60	A2-15	3-858-6015P	6.89	25.50	28.35	3.07	8XM30	5.12	2.95	50	4x22	90	6250	407	4718	59.06	9.45
	A2-20	3-858-6020P															
63	A2-15	3-858-6315P	7.28	25.50	28.35	4.02	8XM30	7.09	3.54	64	8x28	1110	7000	382	5732	62.99	9.45
	A2-20	3-858-6320P															
71	A2-15	3-858-7115P	7.28	25.50	28.35	4.02	8XM30	7.09	3.54	64	8x28	110	7000	340	6900	70.87	9.45
	A2-20	3-858-7120P															
	A2-28	3-858-7128P															
79	A2-15	3-858-7915P	7.87	25.50	28.35	4.02	8XM30	7.09	3.94	64	8x28	110	7000	306	9259	78.74	9.45
	A2-20	3-858-7920P															
	A2-28	3-858-7928P															

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

Notes:

# Chuck Packages for Rotary Tables, Indexers and Trunnions



## Chuck Packages for Rotary Tables, Indexers and Trunnions

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

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

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

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

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

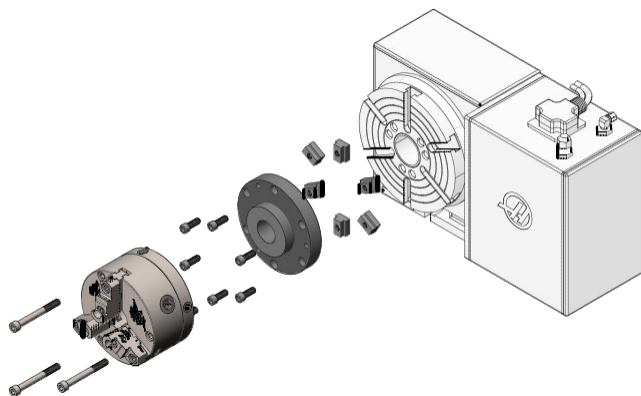


Image courtesy of Haas Automation, Inc.\*

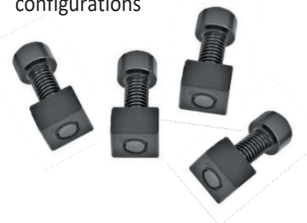


Image courtesy of DMG Mori\*



T-Nuts and Mounting Bolts are included

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



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



# Power Chucks

DESIGNED AND  
ENGINEERED FOR  
PRECISION

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

TMX

also offers a full line of off the shelf accessories and supplies.

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

#### Interchangeable Top Tooling

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

#### Durable

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

#### High Gripping Force

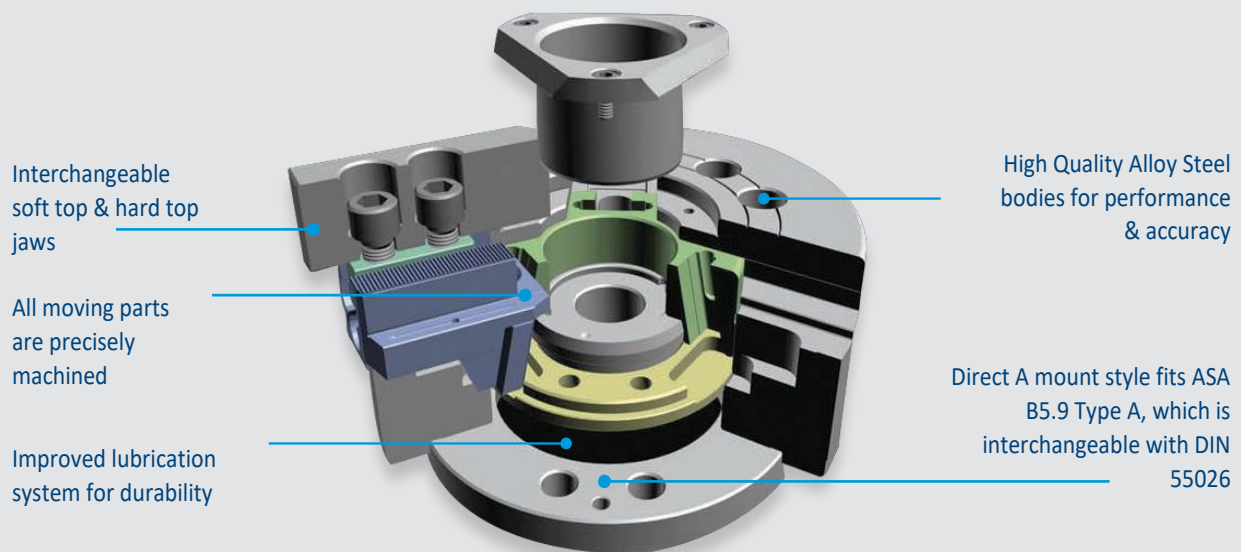
- By increasing dynamic gripping force, work efficiency and safety have been greatly improved

#### High Speed

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

#### Lightweight

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



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

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



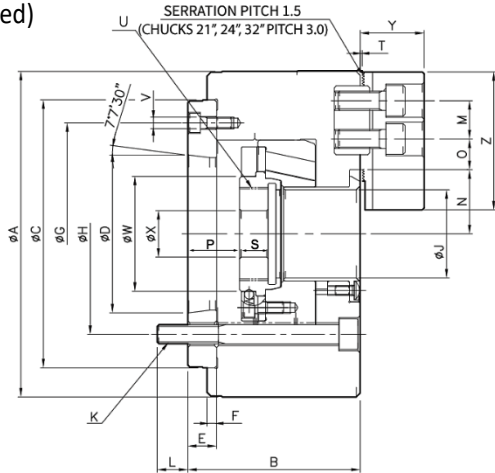
Chuck Size	Part Number	Spindle Nose	Thru Hole J	Jaw Stroke	Plunger Stroke	Gripping Dia Max	Gripping Dia Min	Max Permissible Input Force	Max Static Gripping Force	Max RPM	Weight (lb.)	Moment of Inertia
												lb*ft <sup>2</sup>
in								lbf				
6	3-781-0650	A2-5	1.811	0.2165	0.5118	6.6535	0.5118	5500	14137	6000	30	0.0512
8	3-781-0860	A2-6	2.0472	0.2992	0.7087	8.2677	0.4331	8976	21113	5000	52	0.1454
10	3-781-1060	A2-6	3.0315	0.3346	0.7874	10	1.2205	11220	28028	4200	88	0.2642
10	3-781-1080	A2-8										
12	3-781-1260	A2-6	3.5827	0.4016	0.9449	11.9685	1.3386	13015	33000	3300	141	0.6267
12	3-781-1280	A2-8										
15	3-781-1580	A2-8	4.6457	0.4173	0.9055	15	1.1811	15928	40381	2500	280	1.9539
15	3-781-1511	A2-11										
18	3-781-1811	A2-11	4.6457	0.4173	0.9055	17.7165	1.1811	15928	40381	2000	392	3.912
21	3-781-2115	A2-15	5.5118	0.4173	0.9055	20.8661	3.3070	20189	52494	1700	542	7.5782
21	3-781-2120	A2-20										
24	3-781-2415	A2-15	6.4961	0.4094	0.9055	24.0157	4.3307	20189	52494	1400	670	13.5998
24	3-781-2420	A2-20										
32	3-781-3215	A2-15	9.449	0.709	1.339	39.496	5.984	22425	53820	1200	1203	12.4938
32	3-781-3220	A2-20										

Technical dimensions on next page

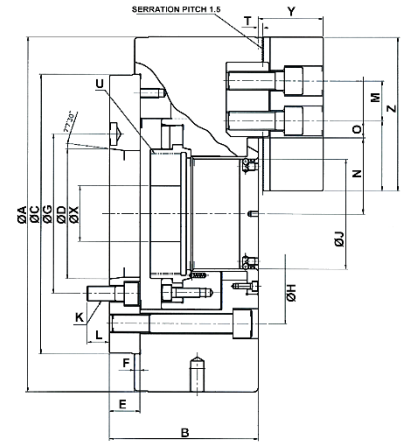
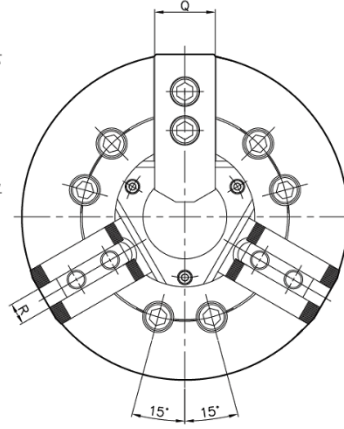


## 3-Jaw Large Thru-Hole A2 Mount Chucks

(continued)



Type I



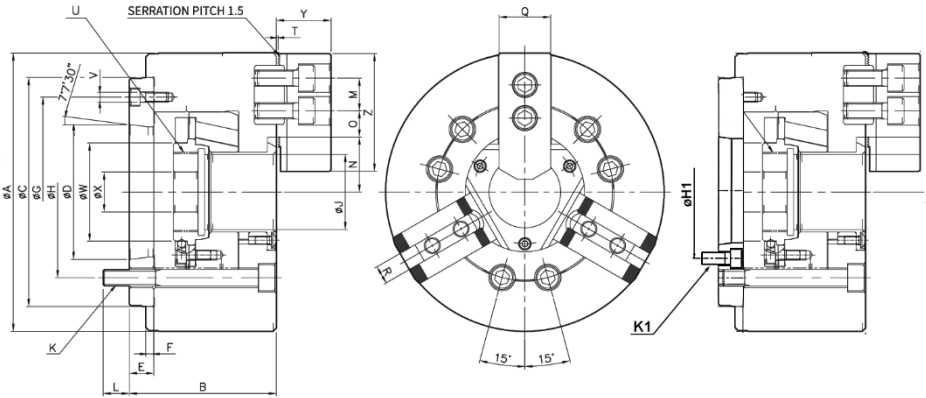
Type II

### Dimensions

Chuck Size	Part Number	Spindle Mount	Type	A	B	C	D	E	F	G	H	J	K	L	M	N max	N min
6	3-781-0650	A2-5	I	6.6535	3.5433	5.5118	3.2505	0.5906	0.1969	4.5669	4.1260	1.8110	6-M10	0.6299	0.7874	1.3189	1.2087
8	3-781-0860	A2-6		8.2677	4.0551	6.6929	4.1880	0.6693	0.1969	5.9055	5.2520	2.0472	6-M12	0.7087	0.9843	1.6417	1.4921
10	3-781-1060		II	10.0000	4.7638	8.6614	4.1880	1.0236	0.1969	5.2520	6.7480	3.0315	6-M16	0.945	1.1811	2.1457	1.9803
10	3-781-1080	I	4.4488		5.5007		0.7087	7.4803		6-M12			0.7087	2.4449		2.2323	
12	3-781-1260	A2-6	II	11.9685	5.3150	8.6614	4.1880	1.0236	0.2362	5.2520	9.2520	4.6457	6-M12	0.7087	1.6929	3.2283	3.0197
12	3-781-1280	I	5.0000	5.5007	0.7087		7.4803	6-M16		0.9450			3.2283	3.0197			
15	3-781-1580	A2-8	II	15.0000	6.2992	11.8110	7.7507	0.8661	0.2362	6.7480	13.0000	5.5118	6-M20	1.1024	1.6929	3.2283	3.0197
15	3-781-1511	A2-11	I	17.7165	5.8661					14.9606						10.2362	9.2520
18	3-781-1811					II	20.8661	6.3386	14.9606		11.2510	1.0630	0.2362	18.2520	13.0000		
21	3-781-2115	A2-15	I	20.8661	6.3386	14.9606	16.251	1.0630		0.2362	18.2520			13.0000		6.4961	6-M22
21	3-781-2120	A2-20	II	24.0157	6.6929		14.9606		11.2510		1.0630	0.2362	18.2520		13.0000		
24	3-781-2415	A2-15	I	24.0157	6.6929	14.9606		16.251	1.0630	0.2362			18.2520	13.0000		6.4961	6-M22
24	3-781-2420	A2-20	II	31.496	7.3228		20.472	11.251			1.6535	0.2362	13.0000		18.2520		
32	3-781-3215	A2-15	II	31.496	7.3228	20.472		16.251	1.6535	0.2362			18.2520	18.2520		9.449	6-M24
32	3-781-3220	A2-20	I	31.496	7.3228		20.472	16.251			1.6535	0.2362	18.2520		18.2520		

Chuck Size	Part Number	O max	O min	P max	P min	Q	R	S	T	U max	V	W	X	Y	Z
6	3-781-0650	0.9055	0.3937	1.0630	0.5512	1.2205	0.4724	0.7480	0.0787	M55x2	3-M6	2.3622	0.7874	1.2992	2.5984
8	3-781-0860	1.0630		1.3189	0.6102	1.5354	0.5512	0.8071		M60x2		2.5984	1.1811	1.5354	3.3858
10	3-781-1060	1.2205	0.4724	1.0827	0.2953	1.7323	0.6299	1.0630	0.0787	M85x2	3-M8	3.7008	1.1811	1.811	4.331
10	3-781-1080													1.7717	0.5906
12	3-781-1260	1.7717	0.5906	1.1024	0.1575	1.9685	0.8268	1.1024	0.0787	M130x2	3-M10	5.4724	2.3622	2.7559	6.4961
12	3-781-1280														
15	3-781-1580	2.9055	0.7205	1.2992	0.3937	2.4409	0.8661	1.5354	0.1969	M155x3	3-M12	6.5354	3.1496	2.8740	7.0866
15	3-781-1511														
18	3-781-1811	4.6260	0.8465	1.8504	0.9449	2.5591	0.9843	1.5748	0.1969	M175x3	3-M12	7.3622	3.1496	2.8740	7.0866
21	3-781-2115														
21	3-781-2120	4.6260	0.8465	1.8504	0.9449	2.5591	0.9843	1.5748	0.1969	M175x3	3-M12	7.3622	3.1496	2.8740	7.0866
24	3-781-2415														
24	3-781-2420	4.6260	0.8465	1.8504	0.9449	2.5591	0.9843	1.5748	0.1969	M175x3	3-M12	7.3622	3.1496	2.8740	7.0866
32	3-781-3215														
32	3-781-3220	4.6260	0.8465	1.8504	0.9449	2.5591	0.9843	1.5748	0.1969	M175x3	3-M12	7.3622	3.1496	2.8740	7.0866
32	3-781-3220														

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



Type I

Type II

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

Chuck Size	Part Number	Spindle Nose	Type	Thru Hole	Jaw Stroke	Plunger Stroke	Gripping Dia Max	Gripping Dia Min	Max Permissible Input Force	Max Static Gripping Force	Max RPM	Weight (lb.)	Moment of Inertia
													lb*ft <sup>2</sup>
6	3-771-0650	A2-5	I	2.0866	0.2165	0.5118	6.6535	0.5118	5622	14167	6000	30	0.0512
8	3-771-0860	A2-6	I	2.5984	0.2992	0.7087	8.2677	0.4331	8598	21159	5000	52	0.1454
10	3-771-1060	A2-6	II	3.2283	0.3346	0.7847	10	1.2205	11244	26986	4200	88	0.2642
	3-771-1080	A2-8	I										
12	3-771-1211	A2-11	I	4.055	0.402	0.945	12.402	1.772	12342	33000	3000	121	0.6042
	3-771-1280	A2-8	II										
21	3-771-2115	A2-15	I	6.555	0.417	0.906	20.866	3.228	20189	49412	1700	525	7.3324

### Dimensions

Chuck Size	Part Number	A	B	C	D	E	F	G	H	H1	J	K	K1	L	M	N max	N min
6	3-771-0650	6.6929	3.5827	5.5118	3.2505	0.5906	0.1969	4.5669	4.1260		2.0866	6-M10		0.6299	0.7874	1.4567	1.3480
8	3-771-0860	8.2677	4.3701	6.6929	4.1880	1.0236		5.9055	5.2520		2.5984	6-M12		0.8268	0.9843	1.8189	1.6693
10	3-771-1060	10.0000	4.7638	8.6614	4.1880	1.0236	0.1969	6.7480	6.7480	5.252	3.2283	6-M16	6-M12	0.9449	1.1811	2.2154	2.0551
	3-771-1080		4.4488		5.5007	0.7087						6-M16					
12	3-771-1211	12.402	4.961	11.811	7.751	1.339	0.2362	10.236	9.252	6.7480	4.055	6-M20	6-M16	1.102	1.181	2.702	2.502
	3-771-1280		5.3937		5.5007	1.2992						6-M20					
21	3-771-2115	20.866	6.85	14.961	11.251	1.575	0.2362	13.00	6.555		6.555	6-M22		1.299	2.362	4.406	4.197

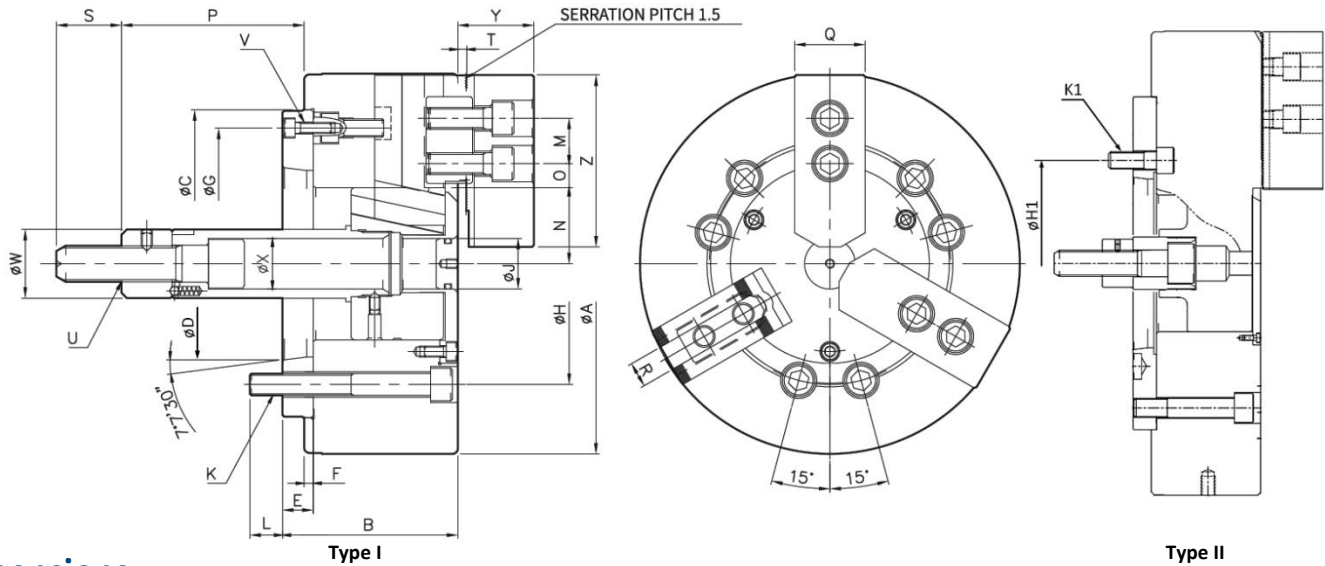
Chuck Size	Part Number	O max	O min	P max	P min	Q	R	S	T	U max	V	W	X	Y	Z
6	3-771-0650	0.8268	0.3150	1.0630	0.5512	1.2205	0.4724	0.7480	0.0787	M60x2	3-M6	2.5984	0.7874	1.3189	2.8346
8	3-771-0860	0.9154	0.4035	1.2992	0.5906	1.5354	0.5512	0.8071		M80x2	6-M12	3.4646		1.5354	3.7402
10	3-771-1060	1.2205	0.4724	1.0827	0.2953	1.7323	0.6299	1.0630	0.0787	M90x2	3-M8	3.8583	1.1811	1.7717	4.3307
	3-771-1080														
12	3-771-1211	1.772	0.541	1.181	0.236	1.929	0.827	1.181	0.098		3-M10	4.882	2.598	2.02	4.37
	3-771-1280														
21	3-771-2115	2.878	0.535	0.433	-0.472	2.559	0.984	1.535	0.197	M180x3	3-M12	7.736	3.15	2.874	7.087

## 3-Jaw Closed Center Chucks A2 Mount



Chuck Size	Part Number	Spindle Nose	Jaw Stroke	Plunger Stroke	Gripping Dia Max	Gripping Dia Min	Max Permissible Input Force	Max Static Gripping Force	Max RPM	Weight (lb.)	Moment of Inertia
											lb*ft <sup>2</sup>
					lb		lbf				
6	3-761-0605	A2-5	0.362	0.787	6.496	0.748	4263.6	14137.2	6000	30.8	0.0409
8	3-761-0806	A2-6	0.346	0.827	8.268	0.906	6283.2	17952	6000	59.4	0.1209
10	3-761-1008	A2-8	0.413	1.181	11.969	1.024	9312.6	25806	6000	88	0.2682
12	3-761-1208	A2-8	0.413	1.181	11.969	1.024	9312.6	35230.8	6000	145.2	0.6165
15	3-761-1508	A2-8	0.63	1.378	15	2.362	18396.4	77860.2	6000	211.2	1.4724
15	3-761-1511	A2-11									
18	3-761-1808	A2-8	0.63	1.378	17.717	5.512	18396.4	77860.2	6000	288.2	1.9841
18	3-761-1811	A2-11									
21	3-761-2111	A2-11	0.63	1.378	20.866	3.228	18396.4	61243.6	6000	435.6	3.9306
21	3-761-2115	A2-15									
24	3-761-2411	A2-11	0.63	1.378	24.016	6.693	18396.4	61243.6	6000	490.6	1.416
24	3-761-2415	A2-15									

## 3-Jaw Closed Center Chucks A2 Mount (continued)

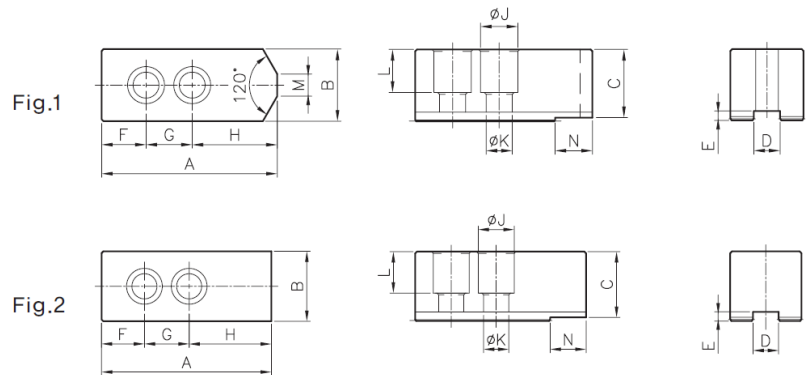


### Dimensions

Chuck Size	Part Number	Type	A	B	C	D	E	F	G	H	H1	J	K	K1	L	M
6	3-761-0605	I	6.654	3.307	5.512	3.251	0.591	0.197	4.567	4.126		0.906	6-M10		0.551	0.787
8	3-761-0806	I	8.268	3.819	6.693	4.188	0.669	0.197	5.906	5.252		1.102	6-M12		0.709	0.984
10	3-761-1008	I	10	4.016	8.661	5.501	0.709	0.197	7.48	6.748		1.339	6-M16		0.984	1.181
12	3-761-1208	I	11.969	4.646	8.661	5.501	0.709	0.236	7.48	6.748		1.535	6-M16		0.984	1.181
15	3-761-1508	II	15	5.5512	11.811	6.748	1.2992	0.236	10.236	9.252	6.748	1.063	6-M20	6-M16	0.906	1.693
15	3-761-1511	I		5.118		7.751	0.866									
18	3-761-1808	II	17.717	5.5512	11.811	7.751	1.2992	0.236	10.236	9.252	6.748	1.063	6-M20	6-M16	0.906	1.693
18	3-761-1811	I		5.118			0.866									
21	3-761-2111	II	20.866	5.748	14.961	7.751	1.063	0.236	13	13	9.252	1.063	6-M22	6-M20	1.102	2.362
21	3-761-2115	I														
24	3-761-2411	II	24.016	5.748	14.961	7.751	1.063	0.236	13	13	9.252	1.063	6-M22	6-M20	1.102	2.362
24	3-761-2415	I														

Chuck Size	Part Number	N max	N min	O max	O min	P max	P min	Q	R	S	T	U max	V	W	X	Y	Z
6	3-761-0605	1.614	1.445	0.512	0.276	3.406	2.618	1.22	0.472	1.417	0.157	M16x2.0	3-M6	1.26	1.26	1.378	2.835
8	3-761-0806	1.823	1.65	0.886	0.354	4.331	3.504	1.535	0.551	1.417	0.197	M20x2.5	3-M6	1.496	1.496	1.693	3.74
10	3-761-1008	2.012	1.839	1.209	0.441	5.512	4.528	1.732	0.63	1.417	0.197	M20x2.5	3-M8	1.496	1.732	1.969	4.331
12	3-761-1208	1.22	2.193	1.917	0.500	5.709	4.528	1.969	0.709	1.417	0.197	M20x2.5	3-M8	1.496	1.969	2.126	4.37
15	3-761-1508	2.874	2.559	2.154	0.618	3.228	1.85	1.969	1.004	2.165	0.197	M30x3.5	3-M10	2.165	2.362	2.362	5.315
15	3-761-1511																
18	3-761-1808	4.193	3.878	1.909	0.913	2.756	1.378	1.969	1.004	2.165	0.197	M30x3.5	3-M10	2.165	2.362	2.374	5.315
18	3-761-1811																
21	3-761-2111	3.386	3.071	3.681	1.083	2.756	1.378	2.559	0.984	2.165	0.236	M30x3.5	3-M12	2.165	2.362	2.795	7.087
21	3-761-2115																
24	3-761-2411	4.902	4.606	3.681	1.083	2.756	1.378	2.559	0.984	2.165	0.236	M30x3.5	3-M12	2.165	2.362	2.795	7.087
24	3-761-2415																

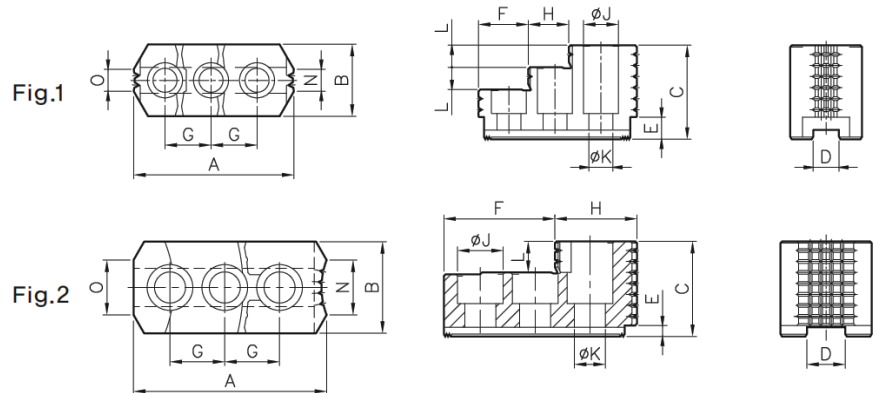
## Soft Top Jaws



Chuck Size	Part Number	Fig.	Serration	A	B	C	D	E	F	G	H	J	K	L	M	N
6"	3-788-306	1	1.5x60°	2.8346	1.2205	1.2402	0.4724	0.1969	0.5906	0.7874	1.4567	0.6890	0.4331	0.7677	0.4724	0.5906
8"	3-788-308			3.7402	1.4567	1.4764	0.5512		0.7874	0.9843	1.9685	0.7874	0.5512	0.8858		0.5906
10"	3-788-310			4.3307	1.7323	1.752	0.6299		1.1811	1.1811				1.122		
12"	3-788-312	2	1.5x60°	4.3701	1.9291	1.9488	0.8268	0.1969	0.8268	1.1811	2.3622	0.9843	0.6693	1.2402	-	-
15 & 18"	3-788-315			6.4961	2.3228	2.3425	0.8661	0.315	1.8504	1.6929	2.9528	1.2598	0.8661	1.4173		
21"	3-788-321		7.0866	0.9843			0.374	1.5748	2.3622	3.1496						



## Hard Top Jaws



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

## T-Nuts

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



## Draw Tube Nut Blanks

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

# Centers & Rotating Bodies

DESIGNED AND  
MANUFACTURED IN  
EUROPE



## CONTENTS

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## Centers & Rotating Bodies

### Live Centers

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



### Dead Centers

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

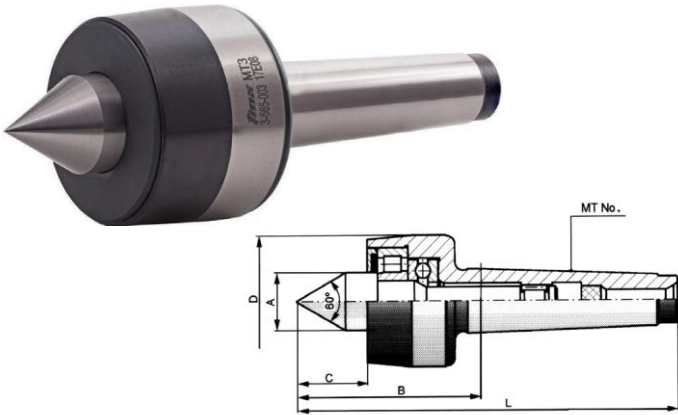


### Rotating Bodies

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



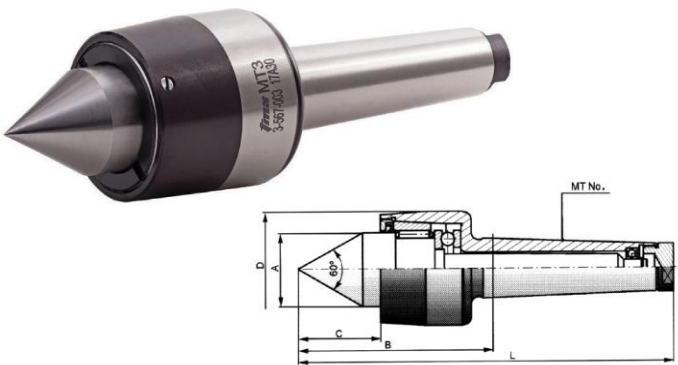




## Precision & Super Precision Live Centers

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

Morse Taper	Precision		Super Precision		Max Weight of workpiece	Point Diameter A	Projection Length B	Point Length C	Diameter D	Overall Length L	Max RPM	Weight (lb.)
	Item Number	TIR	Item Number	TIR								
1	3-565-001P	0.0003	3-565-101P	0.0002	220	0.59	1.97	0.7	1.5	4.07	5000	1
2	3-565-002P		3-565-102P	0.0001	460	0.70	2.22	0.87	1.57	4.47	5000	1
3	3-565-003P		3-565-103P		925	0.98	2.95	1.12	2.2	6.14	4000	2
4	3-565-004P		3-565-104P	1850	1.10	3.21	1.24	2.52	7.24	3000	4	
5	3-565-005P	0.0004	3-565-105P	0.0002	4400	1.61	4.23	1.77	3.35	9.33	2500	8
6	3-565-006P		3-565-106P		7700	2.48	5.96	2.52	5.12	13.13	2000	26



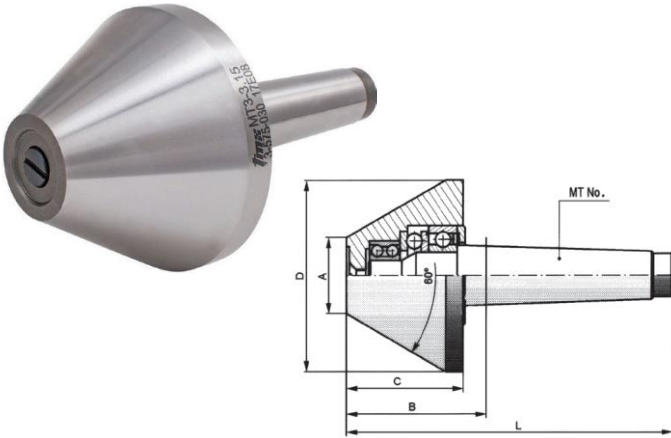
## Ultra Precision Adjustable Live Centers

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

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

## Bull Head Live Centers

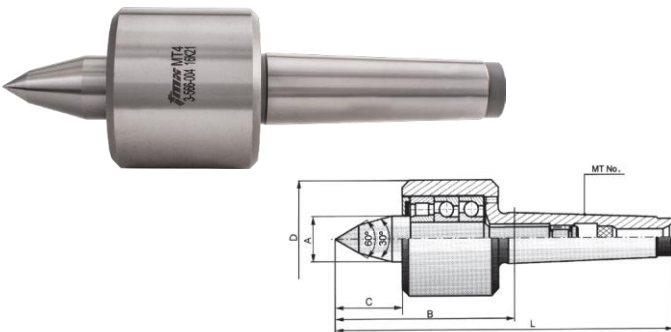
- Centers are designed to hold pipe and hollow work
- Triple bearing design
- Three matched bearings are preloaded at the factory
- Good thrust and radial capabilities
- Bearings are protected by a special seal
- Head is made of high quality Alloy Steel and heat treated to RC 61-63
- 60 degree head angle



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

## NC Quad-Bearing Live Centers

- Heavy duty
- High speed
- 7000 to 6000 RPM



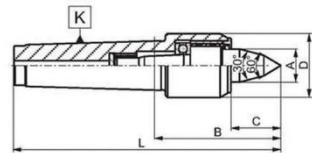
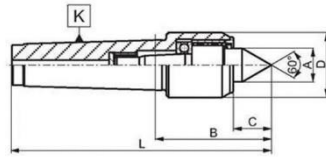
Morse Taper	Part Number	T.I.R.	Point Diameter A	Projection Length B	Point Length C	Diameter D	Overall Length L	Max RPM	Max Weight of Workpiece	Weight (lb.)
4	3-566-004P	0.0002	1.10	4.58	1.91	2.76	8.62	7000	2200	6
5	3-566-005P	0.0002	1.57	5.87	2.64	3.47	11.00	6000	4400	11



3-560 Series Slim Casing



3-561 Series Extended Point



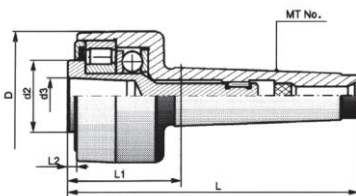
## Slim Casing Live Centers

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

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



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



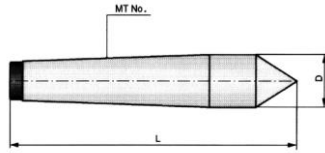
## Live Centers with Interchangeable Inserts

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

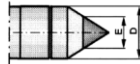
Morse Taper	Set Part Number	Body Only Part Number	T. I.R.	Diameter D	d2	d3	Overall Length L	Projection Length L1	L2	Max Weight of Workpiece (lb.)	RPM Max	Weight without insert (lb.)
2	3-570-002P	3-570-102P	0.0008	1.57	0.71	0.28	4.055	1.54	0.177	220	5000	1
3	3-570-003P	3-570-103P	0.0008	2.20	0.98	0.47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



3-555 Series Ball  
Bearing Steel



3-550 Series Carbide  
Tipped



## Dead Centers

### Carbide Tipped & Steel

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

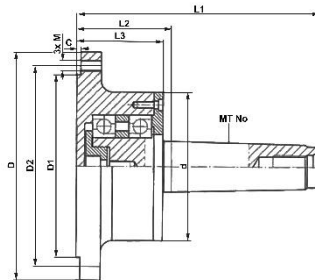
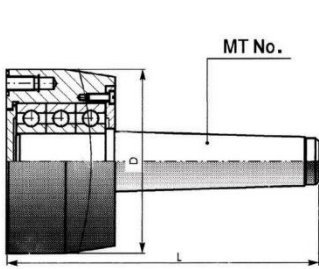
Morse Taper	Ball Bearing Steel Part Number	Carbide Tipped Part Number	Overall Length L	Diameter D	Point Diameter E	Weight (lb.)
1	3-555-005P	3-550-005P	3.15	0.48	0.28	0
2	3-555-010P	3-550-010P	3.94	0.71	0.28	0
3	3-555-015P	3-550-015P	4.92	0.95	0.43	1
4	3-555-020P	3-550-020P	6.30	1.24	0.55	2
5	3-555-025P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



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



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



## Rotating Bodies

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

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

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

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

Chuck/ Head Diameter	Morse Taper	Part Number	T.I.R.	Point Length C	Dia D	Boss Size <sup>1</sup>	Bolt Circle Dia d2	Overall Length L1	Gage Length L2	Projection Length L3	Hole Thread Size M	Max RPM	Max Workpiece Weight (lb.)	Weight (lb.)
8	5	3-573-085P	0.0008	0.138	7.874	6.299	6.929	9.212	4.291	3.858	M10	2800	550	49
	6	3-573-086P						11.378						
10	5	3-573-105P	0.0008	0.138	9.843	7.874	8.819	9.212	4.291	3.858	M12	2500	1100	49
	6	3-573-106P		0.177				11.378						



3-813



3-814



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

Compatible with Front Mount Scroll Chucks

Notes:

# Milling Machine Vises



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## Milling Machine Vises

### Single Station Vises

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

### Double Station Vises

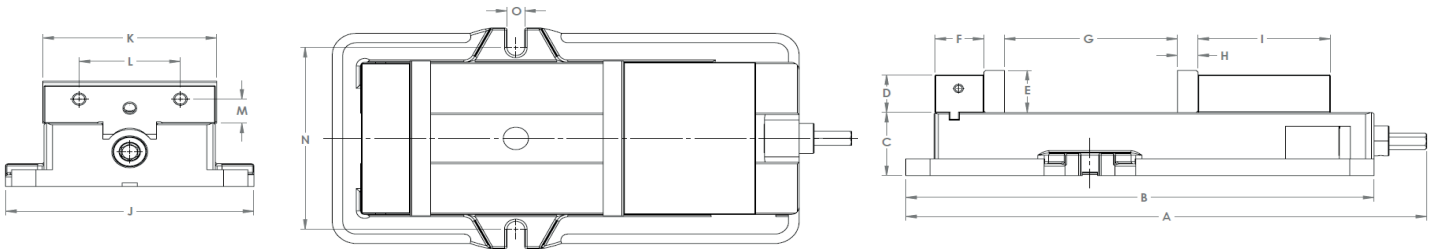
- Provides 6 different holding positions. Vise can hold two different workpieces with same force at same time
- To avoid lift and deflection, the clamping force ensures same clamping force to hold two different size or shape workpieces
- The anti-elevate mechanism and automatic return ensures the workpiece does not deflect and lift
- Rigid and tensile ductile iron ASTM A536 Grade 80-55-06 (80,000PSI) vise body. Slide surface flame hardened to HS65° to maintain accuracy. 1050 Steel jaw-plate has been carburizing heat treated the hardness to HRC54°
- Design simplifies the evacuation of chips
- U.S.A. patented





## Single Station Vises

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



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

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

## Materials and Torque Specifications

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

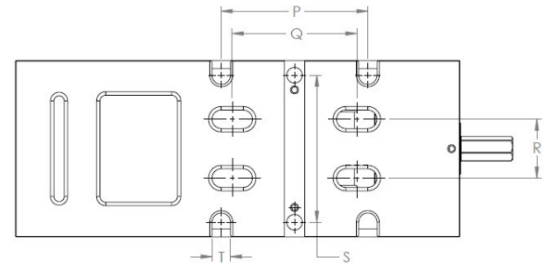
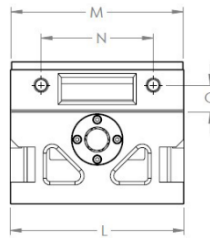
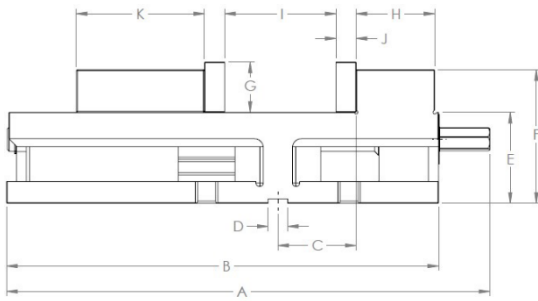
Part Number	Torque (ft.lbs)	Clamping Force (lb.)	Body	Jaws	Wt (lb.)
3-220-0068	14	1349	Ductile Iron	Hardened Steel	80
	29	1798			
	43	3822			
	57	5395			
	72	7194			
	87	8992			
	116	10791			

Part Number	Torque (ft.lbs)	Clamping Force (lb.)	Body	Jaws	Wt (lb.)
3-220-0081	14	2248	Ductile Iron	Hardened Steel	150
	29	3147			
	43	4496			
	57	6295			
	72	8093			
	87	9442			
	116	10791			

## Wellock Versatile Vise



- Unique characteristics prevent lift of workpiece and provides high accuracy
- Two operating positions for Vertical Machine Center, lay down & upright
- One horizontal operating position for Horizontal Machining Center
- Material of MG/MGR: ASTM A536 Grade 80-55-06



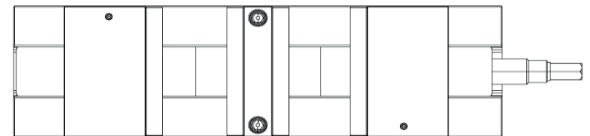
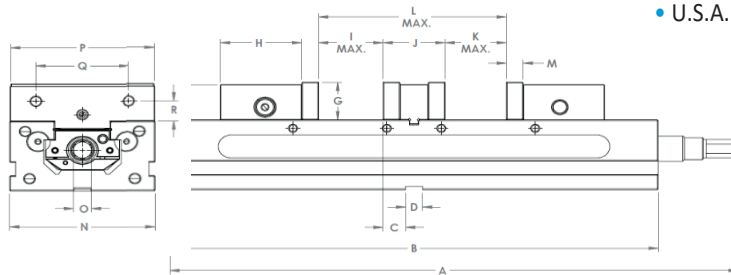
Part Number	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T	Wt(lb.)
3-227-006	16.96	15.15	2.75	0.68	3.19	4.67	1.76	2.75	6.41	0.71	4.50	6.00	5.96	3.87	0.94	5.00	4.25	2.00	5.00	0.63	68.2

## Materials and Torque Specifications

Part Number	Torque (ft.lb.)	Clamping Force (lb.)	Body	Jaws	Wt (lb.)
3-227-006	14	899	Ductile Iron	Hardened Steel	68.2
	29	2698			
	43	4047			
	57	5620			
	72	7194			
	87	8992			
	101	10791			

## Double Station Vises

- Provides 6 different holding positions. Vise can hold two different workpieces with same force at same time
- To avoid lift and deflection, the clamping force ensures same clamping force to hold two different size or shape workpieces
- The anti-elevate mechanism and automatic return ensures the workpiece does not deflect and lift
- Rigid and tensile ductile iron ASTM A536 Grade 80-55-06 (80,000PSI) vise body. Slide surface flame hardened to HS65° to maintain accuracy. 1050 Steel jaw-plate has been carburizing heat treated the hardness to HRC54°
- Design simplifies the evacuation of chips
- U.S.A. patented



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

## Materials and Torque Specifications

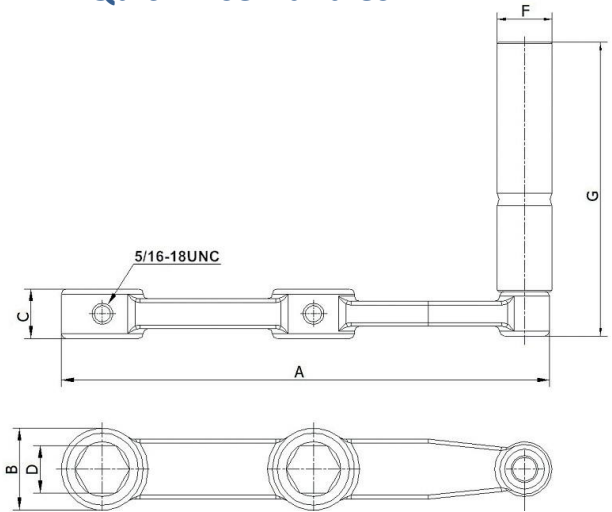
Part Number	Torque (ft.lbs)	Clamping Force (lb.)	Body	Jaws	Weight (lb.)
3-224-004	7	450	Ductile Iron	Hardened Steel	44.0
	14	1124			
	22	1461			
	29	1798			
	36	2249			
	43	2698			
	51	3147			
	57	3822			
	65	4271			
72	4946				

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

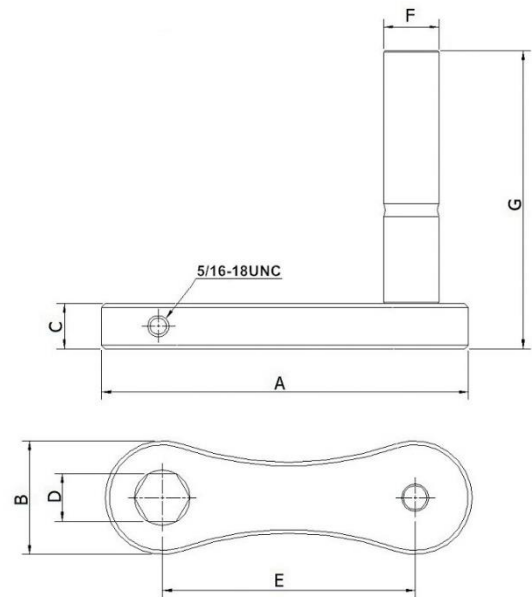
## Quick Vise Handles



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



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



## Swivel Base for Milling Machine Vise



Vise Size	Part Number
6"	3-220-66
8"	3-220-88



# Workholding Catalog

