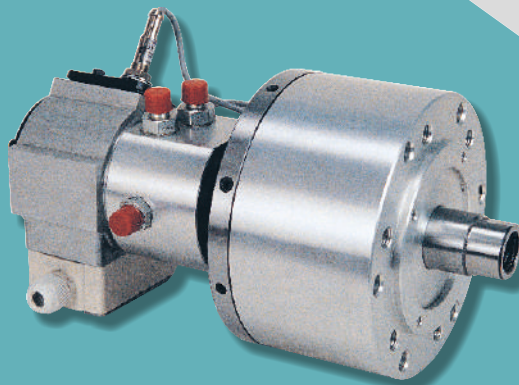
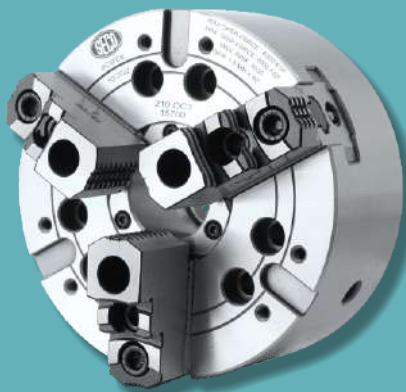


SINCE 1958

Only The Best



67 YEARS
GLORIOUS SERVICE

An ISO 9001:2015 Company

POWER CHUCKS | MANUAL CHUCKS | ROTARY CYLINDERS | SOFT JAWS

Only The Best



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CHUCKS

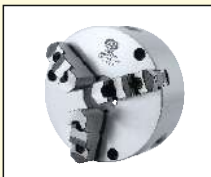
SJ



1

**Standard Jaws
Self Centring
Chucks**

MTJ



2

**Master Gripping
Self Centring
Chucks**

MTJS



3

**Master Gripping
Self Centring
Special Chucks**

AS



4

**Accuracy
Adjustable Trugrip
Self Centring Chucks**

DP



5

**Dust Proof
Self Centring
Chucks**

IC



6

**4 Jaws
Independent
Chucks**

BMTJ



7

**Bison Type
Master Gripping
Self Centring Chucks**

AD



8

**Euro AD Type
Front Mounting Set Tru
Self Centring Chucks**

OCK/OCKK



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**Open Centre / Hollow
Plain Back &
Direct Mounting
Power Chuck**

OCK/OCKK



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**Open Centre / Hollow
Plain Back &
Direct Mounting
Power Chuck**

OC/OCB



11

**Open Centre / Hollow
Plain Back & Direct Mounting
Power Chuck**

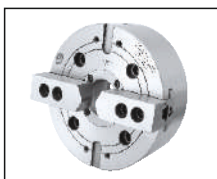
OCELB



12

**Open Centre
Extra Large Bore
Power Chuck**

OCLS



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**Open Centre
Long Stroke
Power Chuck**

CC



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**Close Centre
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JCC



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NCBC



25 Compact High Speed Close Bore Hydraulic Rotary Cylinder

HCC



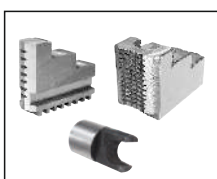
26 Close Centre (Non Through Hole) High Speed Rotary Cylinder

BACK PLATES



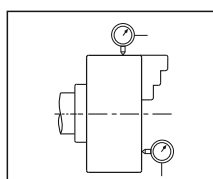
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SPARES



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29 Technical Specifications

Special Features

Applicable for
SJ, MTJ, AS, DP, BMTJ & AD Chucks

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MATERIAL COMPOSITION:

BODY

CI BODY: High tensile, wear resistant cast iron alloyed with chrome and manganese, hardness 180-210 Bhn.

SG IRON BODY: 500/7 grade of SG Iron, hardness 180-210 Bhn

STEEL BODY: Medium carbon steel of 600 mpa tensile strength.

JAWS: Case hardening steel with tough core, hardness 56-60 Hrc.

PINION: Case hardening alloy steel hardness 42-50 Hrc.

SCROLL: Forged high strength wear resistant case hardening

SPECIAL FEATURES:

BODY : Jaw ways hardened and ground.

JAWS : Jaws teeth precision ground from both sides

SCROLL : Scroll threads precision ground from both sides.
hardness 40-45 Hrc.

PARTS : Interchangeable

RUNOUT : Less than 0.04 from 160 mm onwards



SJ

STANDARD JAWS SELF CENTRING CHUCKS

Scroll operated self centring chuck with 2 sets of jaws (Reverse and Forward) is widely used in mass production.

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CHUCKS



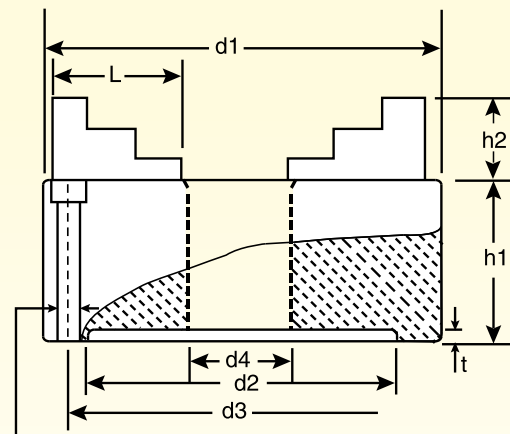
3 JAWS



4 JAWS



6 JAWS



To Suit K Bolts
3 & 6 Jaw Chucks 3 Holes
4 Jaw Chucks 4 Holes

DIMENSIONS IN MM

Nominal Size d1	80	100	125	160	200	230	250	315	400	500	630
d2 h7	56	70	95	125	160	190	200	260	330	420	545
P. C. D.	d3	67	83	108	140	176	210	224	286	362	586
	Tol. on d3	± 0.20	± 0.25	± 0.25	± 0.30	± 0.30	± 0.40	± 0.35	± 0.40	± 0.40	± 0.40
d4 Min.	Standard	16	20	33	42	55	80	76	107	150	275
	Large Bore	-	-	-	-	-	-	-	112	175	325
h1 Max.	44	50	58	67	75	75	85	87	108.0	120	135
h2 Max.	12	18	21	29	31	52	36	36	51	65	65
t Min.	3	3	4	4	4	4	5	5	5	7	7
L	32	41	52	65	80	103	98	118	160	180	225
K	M6	M8	M8	M10	M10	M10	M12	M12	M16	M16	M16
Size of Sq Key for Chuck	6	8	9	10	11	11	12	14	16	16	19
Approx. Weight in kgs.	SJ 3	1.6	2.0	5.0	8.0	15.0	19.0	26.0	39.0	87.0	250.0
	SJ 4	2.0	3.0	5.5	9.0	18.0	22.0	27.5	41.0	88.0	260.0
	SJ 6	-	-	6.5	11.0	24.0	30.5	30.5	44.0	93.0	275.0

CHUCKS WITH BACK PLATE ALSO AVAILABLE

MTJ MASTER GRIPPING SELF CENTRING CHUCKS

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CHUCKS

The two piece design of Jaws of this chuck offers wide range of application. Different sets of top jaws, suitable for different jobs mountable on some base jaws are solution to numerous odd problems. Standard provision of top hard reversible set and soft set of jaws make this Chuck versatile for precision machining and mass production.



3 JAWS



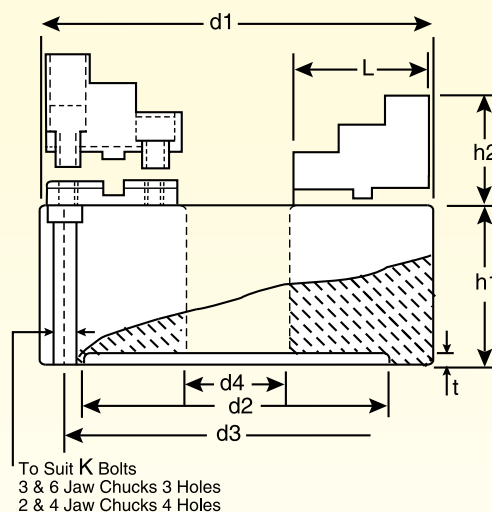
2 JAWS



4 JAWS



6 JAWS



DIMENSIONS IN MM

Nominal Size d1	125	160	200	230	250	315	400	500	630
d2 h7	95	125	160	190	200	260	330	420	545
P. C. D.	d3	108	140	176	210	224	286	362	458
	Tol. on d3	± 0.25	± 0.30	± 0.30	± 0.40	± 0.35	± 0.40	± 0.40	± 0.40
d4 Min.	Standard	33	42	55	80	76	107	150	200
	Large Bore	-	-	-	-	-	112	175	225
h1 Max.	58	67	75	75	85	87	108	120	135
h2 Max.	37	44	52	52	61	63	77	65	65
t Min.	4	4	4	4	5	5	5	7	7
L	55	72	85	103	103	123	165	155	155
K	M8	M10	M10	M10	M12	M12	M16	M16	M16
Size of Sq Key for Chuck	9	10	11	11	12	14	16	16	19
Approx. Weight in kgs.	MTJ 3	5.0	8.0	15.0	19.0	27.5	41.0	168.0	250.0
	MTJ 4	5.5	9.0	18.0	22.0	30.0	43.5	178.0	260.0
	MTJ 6	-	11.0	24.0	28.0	33.0	48.0	198.0	275.0

CHUCKS WITH BACK PLATE ALSO AVAILABLE

MTJ SPECIAL MASTER GRIPPING SELF CENTRING CHUCKS

MASTER GRIPPING SELF CENTRING CHUCK is an FIE FOUNDATION AWARD WINNER CHUCK in IMTEX 2015. designed to take heavy loads on horizontal and vertical lathes. The two piece design of the jaws of this chuck makes it versatile product for rough matching with top hard jaws and precision matching with soft jaws

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CHUCKS



MTJ 1000

SPECIAL FEATURES

BODY : Knob & Jaw ways Hardened and ground.

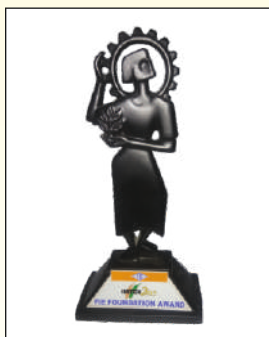
JAWS : Jaws Teeth Precision ground from both sides

SCROLL : Scroll threads precision ground from both sides. Hardness 40-45 Hrc.

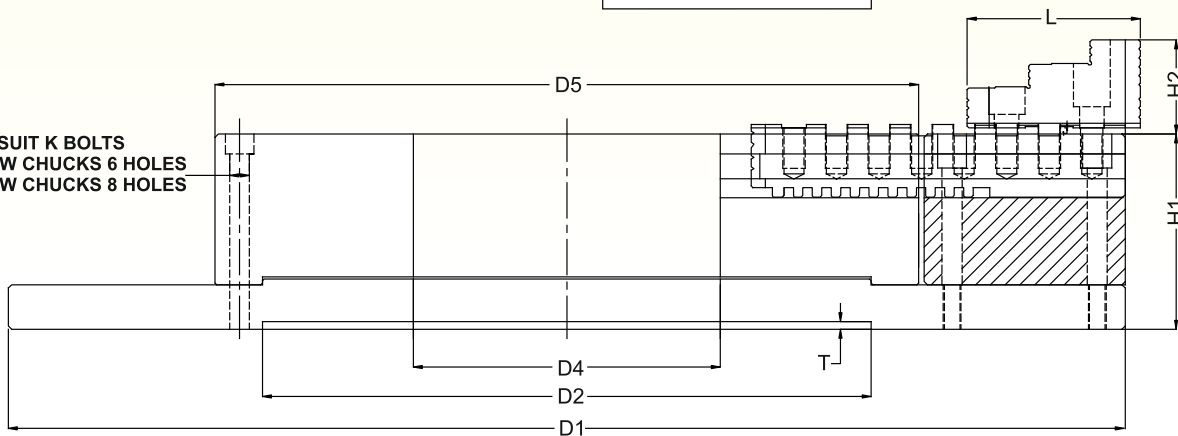
PARTS : Interchangeable

RUNOUT : 0.15 mm Max.

4 Jaws & 6 Jaws Chucks are also Available



TO SUIT K BOLTS
3 JAW CHUCKS 6 HOLES
4 JAW CHUCKS 8 HOLES



DIMENSIONS IN MM

Nominal Size D1	D2 H7	D3 PCD	D4	D5	H1 Max	H2 Max	T Min	L	K	Size of Square	Large Bore	Approx Weight in kgs.	
												3 Jaw	4 Jaw
800	545	586 ± 0.4	275	630	175	90	7	206	M16	19	325	385	406
900	545	586 ± 0.4	275	630	175	90	7	206	M16	19	325	465	528
1000	545	586 ± 0.4	275	630	175	90	7	206	M16	19	325	550	650

AS

ACCURACY ADJUSTABLE TRUGRIP SELF CENTRING CHUCKS

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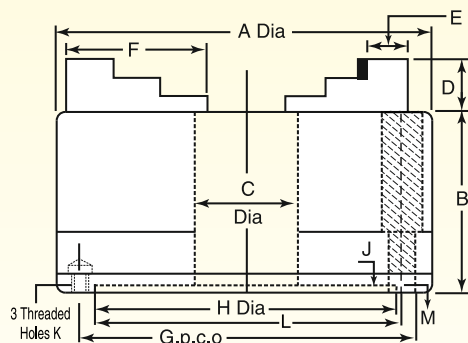
CHUCKS



3 JAWS



6 JAWS



- Accuracy Adjustable within 0.005 mm. and repeatability within 0.013 mm. Tool room Accuracy in Production.
- Costly fixtures eliminated.
- Inexpensive to install.

APPLICATIONS

- Cylindrical & Internal Grinders
- Tool & Cutter Grinder
- Precision Lathes
- Dividing Heads

6 JAWS TRUGRIP CHUCKS

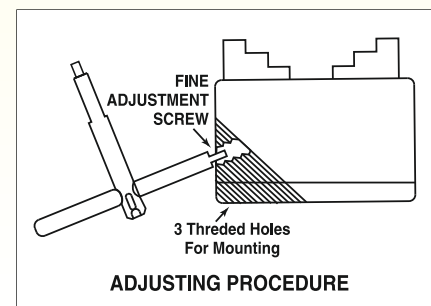
- Soft Metals Gripped firmly without undue marking.
- Fragile Components such as rings and tubes to be held Securely with Less Pressure and minimum distortion.

ADJUSTING PROCEDURE

Hold the workpiece in this chuck in normal manner. Slacken the adjusting screws with dual purpose key provided. Place the dial Indicator against workpiece and rotate the chuck till lowest reading is obtained. The adjusting screws nearest to low reading is then tightened until dial indicator needle moves half the total eccentricity reading. The same procedure is repeated till the desired level of concentricity is achieved. All adjusting screws then finally be checked for tightness. No further adjustment is required for repetitive machining of similar jobs of same dia which is possible within 0.013 mm accuracy. Always use NOMINATED PINION for repetitive gripping accuracy

LIMITATION:

TRUGRIP Chucks are slightly unbalanced due to adjustment feature and may cause spindle vibration at high speed.



DIMENSIONS IN MM

Nominal Size	A	B	C	D	E	F	G	H	J	K	L	M	Wt. in kgs.	
													3 JAW	6 JAW
80	80	56	16	12	10.5	32	67	56	3	M6	-	-	2.5	-
100	100	65	20	18	14	41	83	70	3	M8	-	-	4.5	-
125	125	75	33	21	15	52	108	95	4	M8	-	-	6.0	7.0
160	160	85	42	29	18	65	140	125	4	M10	142	M8	10.5	11.5
200	200	95	55	31	22	80	176	160	4	M10	180	M8	13.0	17.5
250	250	110	76	36	28.5	98	224	200	5	M12	224	M12	34.5	38.0
315	315	117	107	36	28.5	118	286	260	5	M12	286	M12	45.0	48.0

*Front Mounting chucks available on request

DP

DUST PROOF SELF CENTRING CHUCKS

Dust Proof chuck is an Original SECO design which is a result of continuous research and development. It solves the major problem of chip entry into the scroll of the chuck preventing frequent break down. This increases productivity by 60% as DP chucks are not required to be cleaned daily.

Only The Best



CHUCKS



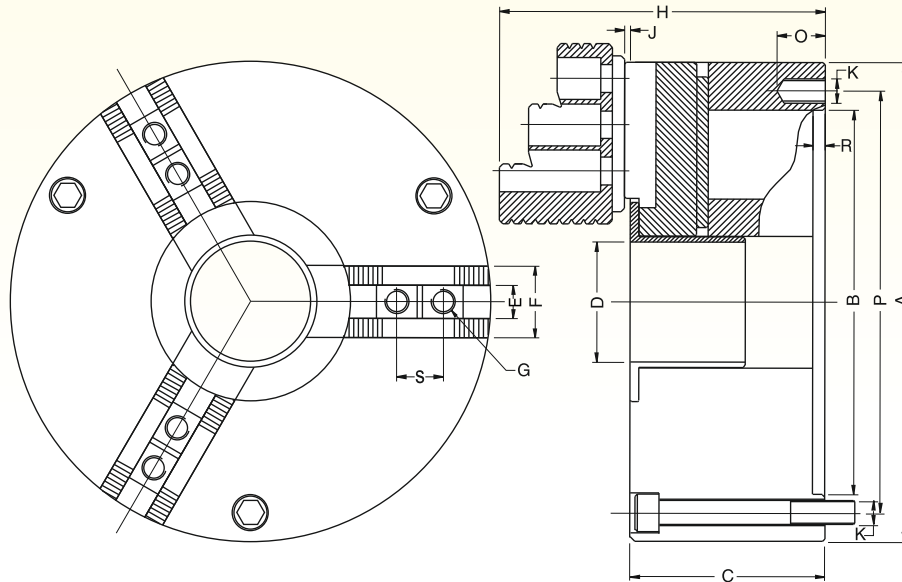
SPECIAL FEATURES:

- 1.5 x 60 deg. Serrated Master Jaws like Power Chucks
- Top soft jaws and Top Hard Jaws interchangeable with Power chucks
- Sealed for chips and Dust into the scroll
- Limited movement of master Jaws with stroke range per jaws from 10mm to 12mm
- Assured Long life and Higher productivity

Note: All DP type chucks are made from 500/7 Grade SGI Body



IMTEX 2005



DIMENSIONS IN MM

A	B H7	P	C	D	E H7	F	G	H	J	K	O	R	S	Weight
160 mm	125	140	71	37	12	30	M10	118	2	M10	20	4	20	10.0
200 mm	160	176	81	50	14	34	M12	136	3	M10	20	4	25	18.0
250 mm	200	224	95	70	16	42	M12	148	3	M12	24	5	30	30.0
315 mm	260	286	100	100	21	45	M16	160	3	M12	32	5	30	42.0

Back Mounting is not a standard feature

IC

4 JAWS INDEPENDENT CHUCKS

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TECHNICAL FEATURES

BODY:

High strength cast iron alloyed with manganese and chrome (SG Iron optional)

JAWS:

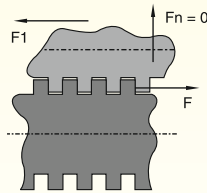
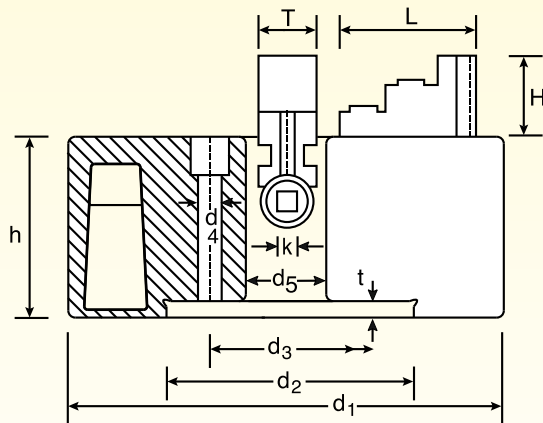
Case hardened and precision ground at gripping face and jaw ways.

OPERATING SCREW:

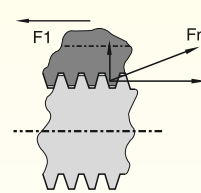
- Case hardened alloy steel for strength and wear resistance.
- Square thread for **HIGH GRIPPING FORCE**

THRUST BEARING

Case hardened alloy steel so designed to provide maximum strength and life to working parts



Seco System



Others System

F : Force applied
Fn : Force lost
F1 : Gripping Force
SECO SYSTEM $F1 = F$
Others System $F1 = F - Fn$
 $F1 < 20\%F$

DIMENSIONS IN MM

Model	d1	d2	d3	d4	d5	t	h	k	T	L	H	Max. rpm	Clamping Capacity	Weight. in Kg
160 IC	160	125	140	M10	45	6	70	8	24	55	22	750	6 160	10
200 IC	200	95	82.6	M10	50	6	83	10	29	75	31	750	12 200	17
250 IC	250	125	104.8	M10	60	8	83	10	29	85	34	600	18 250	20
305 IC	305	160	133.4	M12	75	10	94	12	34	110	44	600	18 305	34
350 IC	350	160	133.4	M12	85	10	94	12	34	110	44	600	18 350	40
400 IC	400	200	171.4	M16	100	12	102	14	40	120	60	600	25 400	60
450 IC	450	200	171.4	M16	100	12	102	14	40	120	60	600	25 450	75
500 IC	520	260	235	M20	127/177	18	110	14	47	150	85	450	55 500	107
630 IC	625	260	235	M20	177/355	18	110	14	47	150	85	450	55 600	140
630 ICEHD	630	385	330.2	M22	270	12	157	22	70	208	81	400	140 600	170
800 IC	800	655/385	603/330.2	M18/M22	270/535	12	165	22	70	208	81	350	100 800	350

DIMENSIONAL DATA (Light Weight) For Grinding Machines

100 ICLW	100	89.0	75.0	M8	25.4	3	35	5	10.5	31	16	750	4	100	2
150 ICLW	155	82.5	69.8	M8	40	5	45	7	17	55	20	750	4	150	4.5
200 ICLW	200	95	82.6	M10	45	5	50	7	19	64	24	750	4	200	8.5

BMTJ

BISON TYPE MASTER GRIPPING SELF CENTRING CHUCKS

The two piece design of Jaws of this chuck offers wide range of application. Different sets of top jaws, suitable for different jobs mountable on some base jaws are solution to numerous odd problems. Standard provision of top hard reversible set and soft set of jaws make this Chuck versatile for precision machining and mass production.

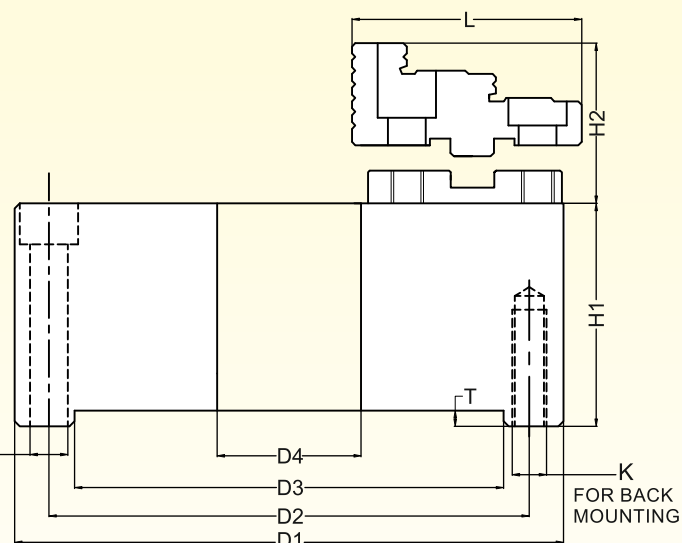
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EURO



TO SUIT BOLTS
3 & 6 JAW CHUCKS
3 HOLES
4 JAW CHUCK
4 HOLES



Dimensions in mm

Model		B125 MTJ3	B160 MTJ3	B200 MTJ3	B250 MTJ3	B315 MTJ3	B400 MTJ3	500 MTJ3	630 MTJ3
D1		125.0	160.0	200.0	250.0	315.0	400.0	500.0	630.0
D2		108.0	140.0	176.0	224.0	286.0	362.0	458.0	586.0
D3		95.0	125.0	160.0	200.0	260.0	330.0	420.0	545.0
D4	Standard	32.0	42.0	55.0	76.0	103.0	136.0	200.0	275.0
	Large Bore	-	52.0	65.0	95.0	-	-	225.0	325.0
H1		56.0	65.0	75.0	85.0	94.0	105.0	120.0	135.0
H2		40.0	43.0	45.0	53.0	57.0	67.0	88.0	88.0
K		M8	M10	M10	M12	M16	M16	M16	M16
L		56.0	67.0	80.0	95.0	110.0	127.0	155.0	155.0
T		4.0	4.0	4.0	5.0	5.0	5.0	5.0	7.0
Wt in Kgs		5.0	10.0	17.5	29.0	50.0	90.0	165.0	250.0
RPM	SGI Body	4000	3600	3000	2500	2000	1600	1000	800
	Steel Body	5500	4600	4000	3500	2800	2000	1200	1000

Note : All BMTJ chucks available in SGI & Steel Body

AD

SECO EURO AD TYPE FRONT MOUNTING SET TRU SELF CENTRING CHUCKS

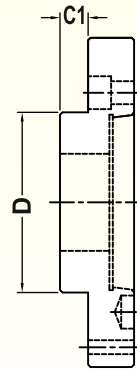
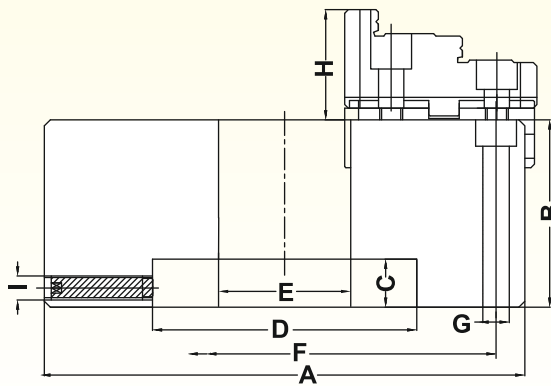
SECO EURO AD type chucks are high precision chucks with adjustment feature based on four adjusting screws. These chucks have two piece jaws can be adjusted true within 0.003mm and can achieve a repeatability of 0,013mm on production jobs of same diameter. These chucks are manufactured only SGI and Steel Body to meet high speed and High performance requirements of not only conventional machines but also CNC lathes & Rotary tables

Only The Best

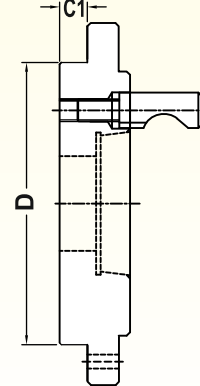


SPECIAL FEATURES:

- Easy adjustment procedure
- Easy maintenance
- Front mounting makes it ideal choice for Rotary Tables for VMC



A2 TYPE
BACK PLATE



D1 TYPE
BACK PLATE

Dimensions in mm

Model	A	B	C	C1	D H8	E	F	G	H	Weight in kgs	RPM	
											SGI Body	Steel Body
B125 AD	125.0	71.5	15.0	14.0	55.0	35.0	108.0	3XM8	40.0	5.0	4000	5500
B160 AD	160.0	68.6	17.0	16.0	86.0	42.0	140.0	3XM10	43.0	9.1	3600	4600
B200 AD	200.0	78.0	18.0	17.0	110.0	59.0	176.0	3XM10	45.0	15.5	3000	4000
B250 AD	250.0	89.0	20.0	19.0	145.0	76.0	224.0	3XM12	53.0	26.2	2500	3500
B315 AD	315.0	96.2	20.0	19.0	180.0	103.0	286.0	3XM16	56.0	46.5	2000	2800
B400 AD	400.0	123.0	20.0	20.0	299.2	136.0	362.0	3XM16	67.0	90.0	1600	2000

OCDK/OCDK

OPEN CENTRE / HOLLOW LARGE BORE & DIRECT MOUNTING POWER CHUCK

SECO Open centre wedge hook chucks with thru hole are ideal for high speed chucking, bar chucking and universal machining. OCDK chucks come fitted with back plate ready to mount on the machine.

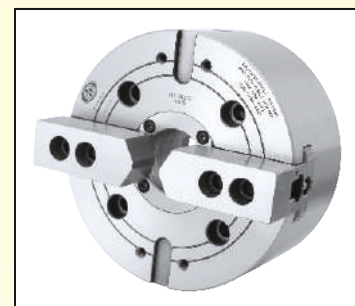
Only The Best



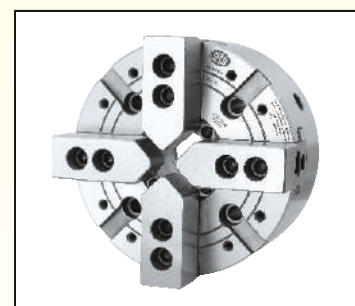
POWER



3 JAWS



2 JAWS



4 JAWS

DIMENSIONS IN MM

Sizes in mm	MAX. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Operating Force (Max. kgf)	Gripping Force (Max. kgf)	Weight in kgs.
110	8000	2.75	10	1400	2900	8.0
135	7000	2.75	10.5	1700	3500	9.0
170	6000	2.75	12	2200	5800	12.0
210	5000	3.75	16	3500	8700	22.0
254	4200	4.4	19	4350	11000	35.0
305	3300	5.3	23	5600	14000	57.0
380/400	2500	5.3	25	7200	18000	120.0/125.0
450	2000	5.3	25	7200	18000	148.0
530	1700	5.3	25	9100	23000	190.0
610	1400	5.3	25	9100	23000	260.0

Chucks can be supplied with back plate of other International Standards on demand

KITAGAWA B200 Compatible

OCDK/OCDK

OPEN CENTRE / HOLLOW LARGE BORE & DIRECT MOUNTING POWER CHUCK

SPECIAL FEATURES:

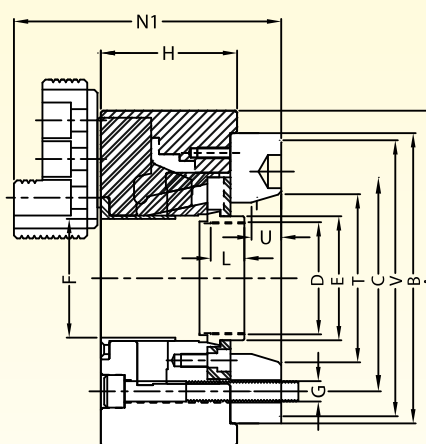
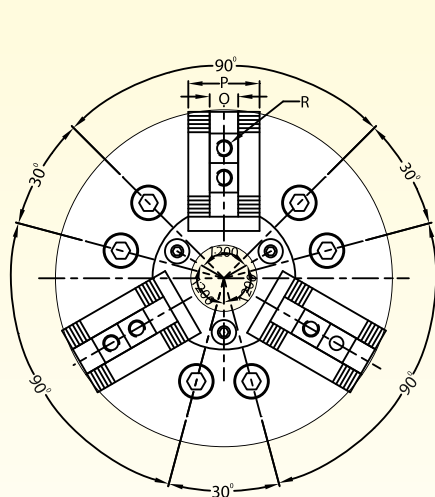
- High Speed
- Constant accuracy & high endurance
- Strong Gripping
- Balanced

LARGE BORE Available in 2, 3 & 4 Jaw configurations

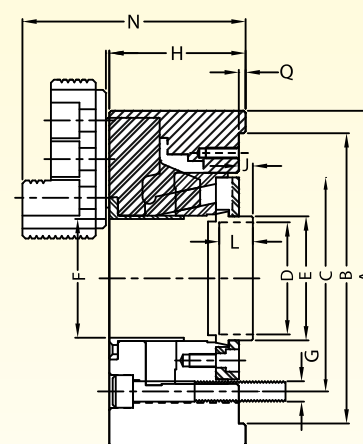
Only The Best



POWER



OCDK (Direct Mounting)



OCDK (Plain Back)

DIMENSIONS IN MM

A	110	135	170	210	254	305	380/400	450	530	610
B	85	110	140	170	220	220	300	300	380	380
Taper Nose	A2-3	A2-4	A2-5	A2-6	A2-8	A2-8	A2-11	A2-11	A2-15	A2-15
C	70.6	82.6	104.8	133.4	171.4	171.4	235	235	330.2	330.2
D	M32x1.5	M36x2	M55x2	M60x2	M85x2	M100x2	M130x2	M130x2	M155x3	M175x3
E	38	48	60	66	94	108	139	139	170	195
F	26	33	45	52	75	91	117.5	117.5	140	165
G	3xM10	3xM10	6xM10	6xM12	6xM16	6xM16	6xM20	6xM20	6xM22	6xM22
H	60	63	81	91	100	110	131	131	140	149
J	Min.	14.50	-2.30	-11.00	-14.50	-10.50	-8.00	-10.50	-10.50	-13.50
	Max.	24.50	8.20	1.00	1.50	8.50	15.0	14.50	14.50	11.00
L	27.50	25	20	20	20	35	39	39	41	41
N	90	96	117	144	156	182	221	222	232	241
N1	98	105	127	155	169	194	238	238	250	257
O H7	10	10	12	14	16	21	24	24	25	25
P	27	27	32	37	42	52	62	62	65	65
Q	4	4	5	5	5	6	6	6	6	6
R	M8	M8	M10	M12	M12	M16	M20	M20	M20	M20
T	53.975	65.513	82.563	106.375	139.719	139.719	196.869	196.869	285.78	285.78
U	12	12	15	16	18	18	20	20	21	22

Standard 1.5mm x 60° till 450 mm;
Serration 3mm x 60° for 530 & 610mm

NOTE : 1/16" x 90° optional till 450mm;
 1/16" x 90°, 3/32" x 90°,
 1.5mm x 60° optional for 530 & 610mm

OC/OCD

OPEN CENTRE / HOLLOW PLAIN BACK & DIRECT MOUNTING POWER CHUCK

SECO open centre wedge hook chucks with thru hole are ideal for high speed chucking, bar chucking, and universal machining. OCD chucks come fitted with back plate ready to mount on the machine.

Only The Best



POWER

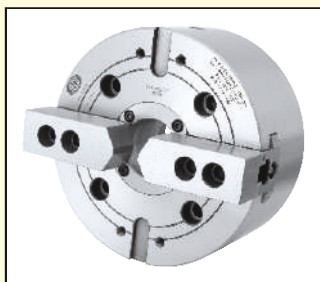
SPECIAL FEATURES:

- High Speed
- Constant accuracy & high endurance
- Strong Gripping

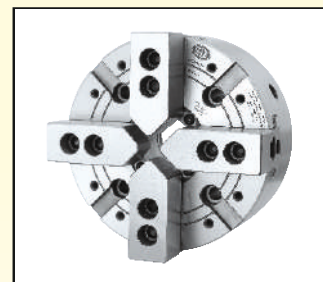
Available in 2, 3 & 4 Jaw configurations



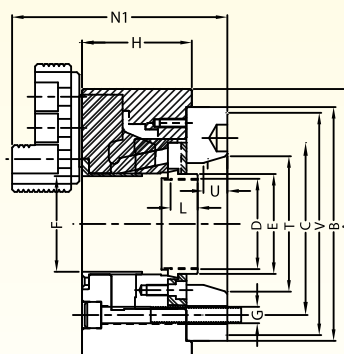
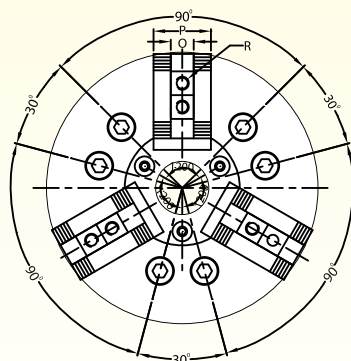
3 JAWS



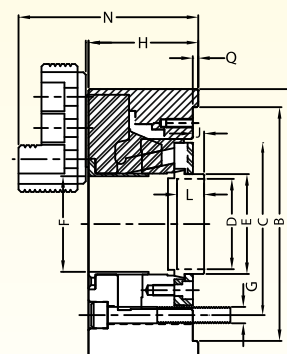
2 JAWS



4 JAWS



OCD (Direct Mounting)



OC (Plain Back)

DIMENSIONS IN MM

A	B H6	Taper Nose	C	D	E	F	G	J		H	L	M	N	N1	O H7	P	Q	R	T	U
								Min.	Max.											
135	110	A2-4	82.6	M36 X 2	48	33	M10	-2.30	8.30	63	25	1.5	96	105	10	27	4	M8	65.513	12
170	140	A2-5	104.8	M42 X 1.5	48	45	M10	-11.30	2.30	81	38	2	117	127	12	32	5	M10	82.563	15
200	170	A2-6	133.4	M55 X 2	62	48	M12	-1.10	18.0	91	26	2	146	165	17	40	6	M12	106.38	16
250	220	A2-8	171.4	M72 X 2	79	68	M16	-2.0	18.0	94	25	2	150	170	21	45	6	M16	139.72	18
305	220	A2-8	171.4	M100 X 2	108	91	M16	-8.0	15.0	110	35	4	182	194	21	52	6	M16	139.72	18

Standard Serration - 1/16" X 90°

NOTE:- 1.5mm X 60° Serrations are optional

Size	Max. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Weight in kgs.	Operating Force (Max Kgf)	Gripping Force (Max Kgf)
135	7000	2.75	10	10	1700	3500
170	6000	2.75	12	12	2200	6000
200	5000	4.50	19	21	3500	8700
250	4200	5.30	20	35	4350	11000
305	3300	5.30	23	50	5600	14000

GMT PHNC Series Compatible

OCELB

Only The Best

OPEN CENTRE EXTRA LARGE BORE POWER CHUCK

SECO Open Centre Extra Large Bore wedge hook chucks with thru hole are ideal for large diameter bar machining and universal machining. These chucks come fitted with back plate ready to mount on the machine.

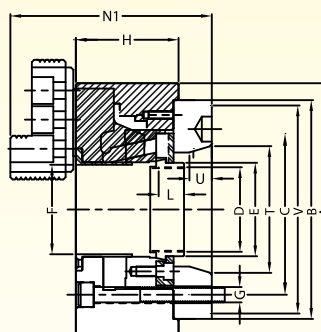
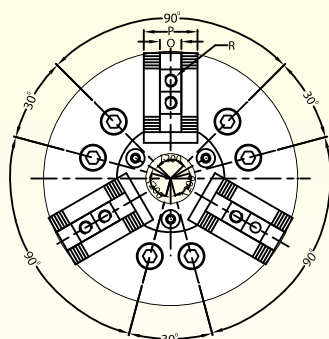


SPECIAL FEATURES:

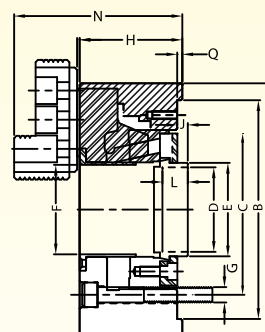
- High Speed
- Constant accuracy & high endurance
- Strong Gripping
- Extra Large Bore

Available in 2, 3 & 4 Jaw configurations

3 JAWS



OCD (Direct Mounting)



OC (Plain Back)

DIMENSIONS IN MM

A	Taper Nose	B H6	C	D	E	F	G	J		H	L	M	N	N1	O H7	P	Q	R	T	U
								Min.	Max.											
170	A2-5	140	104.8	M60 X 2	65	52	M10	-11.0	1.0	81	20	2	117	127	12	32	5	M10	82.563	15
210	A2-6	170	133.4	M75 X 2	80	66	M12	-14.5	1.5	91	20	2	144	155	14	37	5	M12	106.38	16
254	A2-8	220	171.4	M98 X 2	123	91	M16	-10.5	8.0	100	20	2	156	169	16	42	6	M12	139.72	18
315	A2-11	300	235	M115 X 2	123	106	M20	-8.0	15.0	110	37	3	182	194	21	52	6	M16	196.87	20
325	A2-11	300	235	M136 X 2	123	127	M20	-8.0	15.0	110	34	3	182	194	21	52	6	M16	196.87	20
400	A2-15	380	330.2	M162 X 2	171.5	150	M22	-10.5	14.5	131	39	5	221	238	24	62	6	M20	285.78	22
530	A2-15	380	330.2	M 200 X 2	215	185	M22	-13.5	11.0	140	41	6	232	250	25	65	5	M20	285.78	22

Standard Serration - 1.5mm X 60°

NOTE: 1/16 X 90° Serration is optional

Size	Max. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Weight in kgs.	Operating Force (Max Kgf)	Gripping Force (Max Kgf)
170	6000	2.75	12	12	2200	5800
210	5000	3.75	16	20	3500	8700
254	4200	4.4	19	35	4350	11000
315	3200	5.3	23	57	5600	14000
325	3200	5.3	23	65	5600	14000
400	2000	5.3	25	125	7200	18000
530	1700	5.3	25	150	9100	23000

OCLS

OPEN CENTRE LONG STROKE POWER CHUCK

SECO Open Centre Long Stroke Wedge Hook Chucks with thru hole are ideal for those jobs which need long jaw opening. These Chucks come fitted with back plate ready to mount on the machine.

Only The Best



POWER

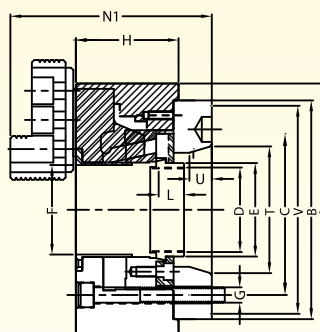
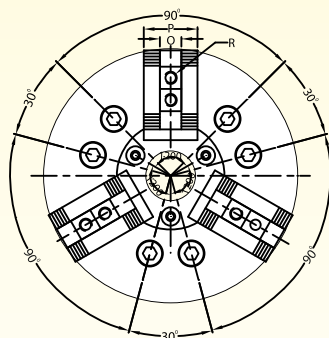


SPECIAL FEATURES:

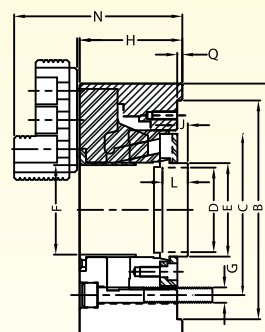
- High Speed
- Constant accuracy & high endurance
- Strong Gripping
- Long Stroke

Available in 2, 3 & 4 Jaw configurations

2 JAWS



OCD (Direct Mounting)



OC (Plain Back)

DIMENSIONS IN MM

A	Taper Nose	B H6	C	D	E	F	G	J		H	L	M	N	N1	O H7	P	Q	R	T	U
								Min.	Max.											
135	A2-4	110	82.6	M36 X 2	48	33	M10	-2.3	8.7	74	25	1.5	107	115	10	27	4	M8	65.513	12
170	A2-5	140	104.8	M55 X 2	60	45	M10	-11.5	11.5	92	20	2	127	135	12	32	5	M10	82.563	15
200	A2-6	170	133.4	M55 X 2	62	48	M12	-8.0	22.0	100	28	2	155	165	17	40	6	M12	106.375	16
210	A2-6	170	133.4	M60 X 2	66	52	M12	-16.9	12.1	102	26	3	155	166	14	37	5	M12	106.375	16
250	A2-8	220	171.4	M72 X 2	79	68	M16	0.0	30.0	105	28	3	162	174	21	45	6	M16	139.719	18
254	A2-8	220	171.4	M85 X 2	94	75	M16	-8.5	21.5	112	20	3	168	180	16	42	6	M12	139.719	18
305	A2-8	220	171.4	M100 X 2	108	91	M16	-8.0	28.0	122	30	5	194	206	21	52	6	M16	139.719	18

Standard Serration - 1.5mm X 60° for 135, 170, 210, 254, 305 diameter chucks; 1/16 X 90° is Optional

Standard Serration - 1/16 X 90° for 200, 250 diameter chucks.

Size	Max. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Weight in kgs.	Operating Force (Max Kgf)	Gripping Force (Max Kgf)
135	7000	4.5	20	11	1700	3500
170	6000	6.0	23	14	2200	5800
200	5000	7.5	30	24	3500	8700
210	5000	6.7	28	28	3500	8700
250	4200	7.5	30	38	4300	11000
254	4200	7.5	30	38	4300	11000
305	3200	9.0	36	61	5600	14000

CC

CLOSE CENTRE POWER CHUCKS

SECO close centre wedge hook type power chucks are cost effective solution for universal machining where thru-hole is not essential.

Only The Best

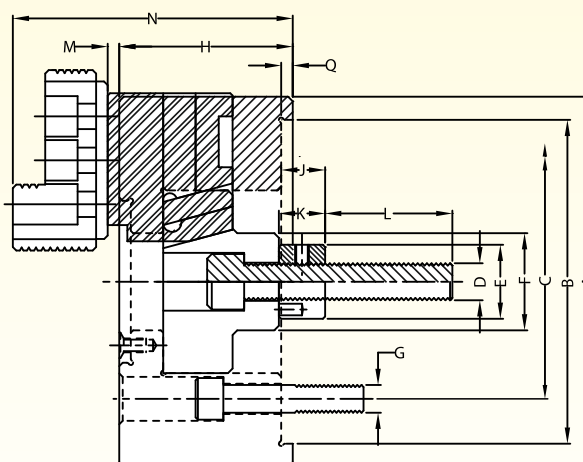
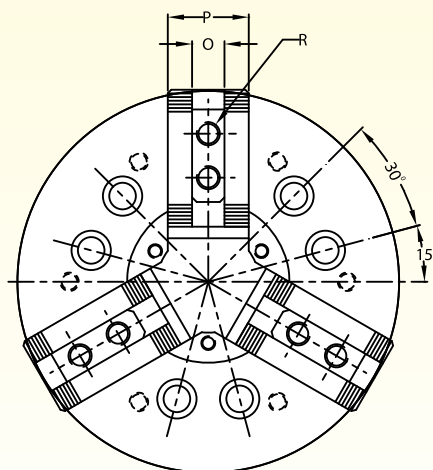


POWER



SPECIAL FEATURES:

- Constant accuracy & high endurance
 - Strong Gripping
- Available in 2, 3 & 4 Jaw configurations



DIMENSIONS IN MM

A	BH6	C	D	E	F	G	J		H	K	L	M	N	OH7	P	Q	R
							Min.	Max.									
125	115	82.6	M12	24	35	M10	22	39	59	20	55	9	100	10	25	4	M8
160	140	104.8	M16	32	42	M10	19	40	75	20	55	5	114	12	35	5	M10
200	170	133.4	M20	36	52	M12	19	41	90	20	55	6	148	17	40	6	M12
250	220	133.4/171.4	M20	36	52	M12/M16	19	40	97	20	55	3	155	21	45	6	M16
315	220/300	171.4/235	M20	36	60	M16/M18	16	42	105	20	50	4	171	21	45	6	M16

Standard Serration - 1/16" X 90°

NOTE:- 1.5mm X 60° Serrations are optional

Size	Max. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Weight in kgs.	Operating Force (Max Kgf)	Gripping Force (Max Kgf)
125	3000	3.5	17	8	600	1200
160	4000	5	19	12	2000	4000
200	3800	5	19	21	3500	7000
250	2500	5	20	38	5000	10000
315	2000	5	20	53	5000	10000

Direct mounting option available

JCC

JAW COMPENSATION CHUCKS

SECO Jaw compensation chuck is ideal for between centre high speed, high load machining. The floating jaws while providing necessary grip does not dislocate the centre of the work piece. The chuck can easily be changed into an ordinary close centre chuck by replacing the centre retaining cartridge. Spring loaded centre also available.

Only The Best



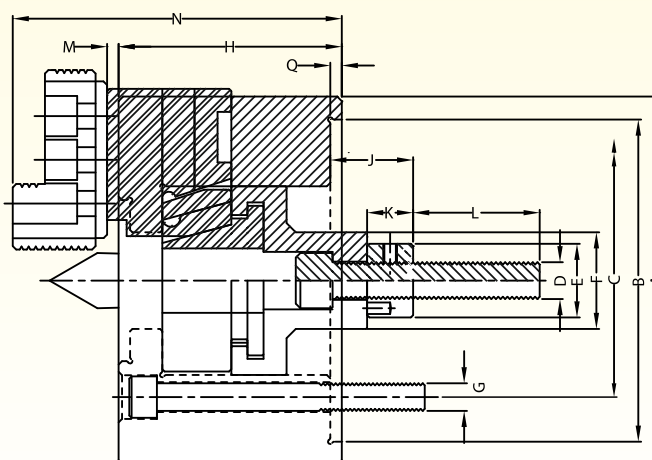
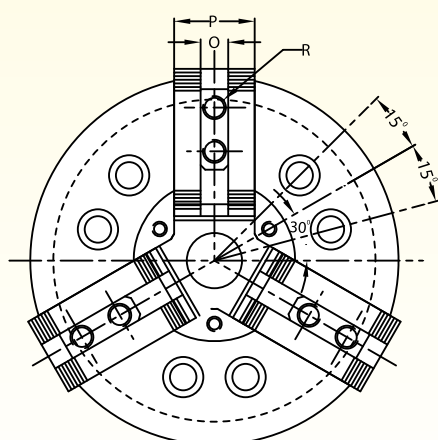
POWER



SPECIAL FEATURES:

- Constant accuracy & high endurance
- Compensating Jaws
- Strong Gripping

Available in 2, 3 & 4 Jaw configurations



DIMENSIONS IN MM

A	BH6	C	D	E	F	G	J		H	K	L	M	N	OH7	P	Q	R
							Min.	Max.									
160	140	104.8	M16	32	42	M10	37	55	97	20	55	5	140	12	35	5	M10
200	170	133.4	M20	36	52	M12	33	57	109	20	55	6	165	17	40	6	M12
250	220	133.4/171.4	M20	36	52	M12/M16	50	70	116	20	55	3	174	21	45	6	M16
315	220/300	171.4/235	M20	36	60	M16/M18	48	68	120	20	50	4	178	21	45	6	M16

Standard Serration - 1/16" X 90°

NOTE:- 1.5mm X 60° Serrations are optional

Size	Max. RPM	Jaw Stroke (Per Jaw)	Plunger Stroke (Max.)	Weight in kgs.	Operating Force (Max Kgf)	Gripping Force (Max Kgf)
160	3000	5	19	17	2000	4000
200	2800	5	19	26	3500	7000
250	2200	5	19	45	5000	9000
315	1800	5	19	60	5000	10000

Direct mounting option available

JCCBL/CCBL

UNIVERSAL BALL LOCK CHUCK

SECO Universal Ball Lock chuck is the ideal option gripping all jobs which need high gripping force. Its unique ball joint applies diametric and axial clamping at the same time make it a powerful gripping equipment. Its Jaw compensation version is an excellent equipment for between centre machining of uneven forged components.

Only The Best

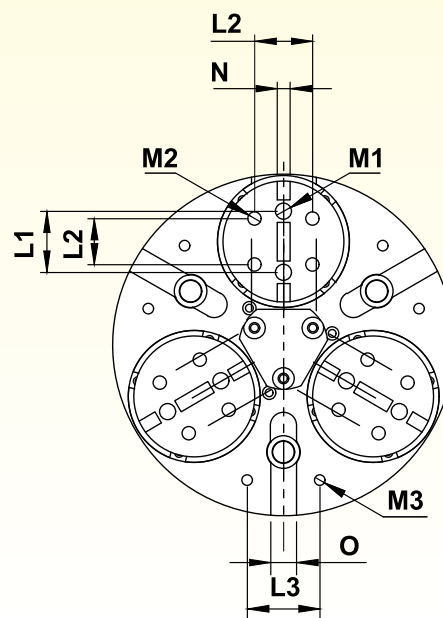
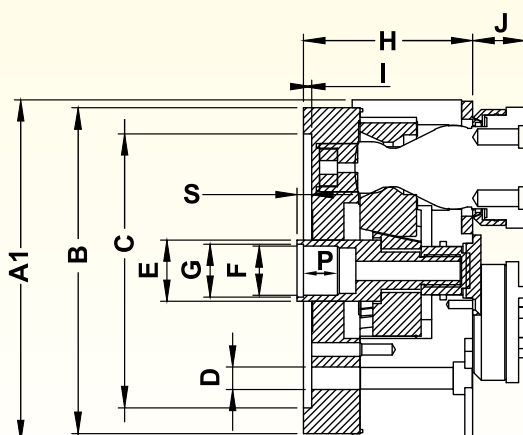


POWER



Special Features:

- Suitable solution castings and forgings
- Minimal chucking surface required
- Comes with multiple insert options to handle all kinds of jobs



Dimensions in mm

Model	A1	B	C	D	E	F	G	H	I	J	L ¹	L ²	L ³	M ¹	M ²	M ³	O	P
170 CCBL/JCCBL	173	140	104.8	11.5	36	M28 X 1.5	29	88	5	27	32	24	36	M10/16	M8/14	M8/17	16	21
210 CCBL/JCCBL	212	170	133.4	13.5	38	M32 X 1.5	33	105	5	33	38	32	45	M12/18	M10/14	M8/17	16	25
250 CCBL/JCCBL	254	220	171.4	17.5	48	M38 X 1.5	39	112	5	33	44.4	36	60	M12/18	M10/14	M8/17	16	25
315 CCBL/JCCBL	315	220	171.4	17.5	48	M38 X 1.5	39	112	5	33	44.4	36	60	M12/18	M10/14	M10/19	16	25

Model	Max. RPM	Jaw Stroke (Per Jaw)	Angular Jaw Stroke (in deg)	Plunger Stroke (in mm)	Pull Down Movement (in mm)	Jaw Compensation for JCCBL (in mm)	Max. Gripping Force (in kgf)	Max. Operating Force (in kgf)	Weight (in kgs)
170 CCBL/JCCBL	5000	5.3	5.2	21	0.1	±1	4400	1800	15
210 CCBL/JCCBL	4500	6.3	5.2	25	0.1	±1.5	6000	2500	27
250 CCBL/JCCBL	3800	7	4.9	25	0.1	±2.5	9600	4000	41
315 CCBL/JCCBL	3000	7	4.9	25	0.1	±2.5	9600	4000	66

SCC

STATIONARY CHUCK WITH IN - BUILT CYLINDER

SECO Stationary Chuck with in-built Cylinder is an ideal option for VMC machines due to its compact designs. Multiple Chucks can be used on one table

Only The Best



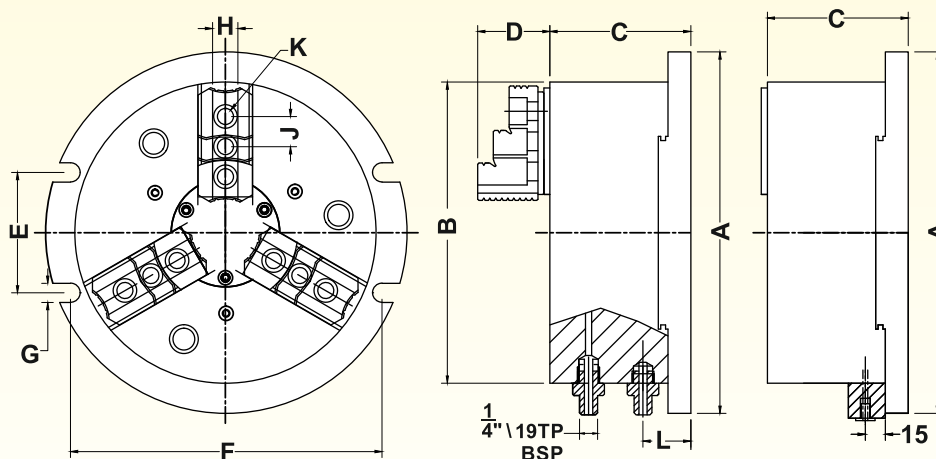
POWER



3 JAWS

SPECIAL FEATURES:

- High Gripping Force.
- Compact Design
- Easy & Convenient Front T-slot Mounting
- Available in 2-Jaw, 3- Jaw & 4- Jaw Configurations



DIMENSIONS IN MM

SIZE	A	B	C	D	E	F	G	H	J	K	L
170	205	165	93	37	100	159	14	12	20	M10	32.0
210	250	210	113	54	100	215	16	14	25	M12	32.0
254	300	254	113	60	100	258	16	16	30	M12	35.0
305	350	305	120	70	100	312	16	21	30	M16	35.0

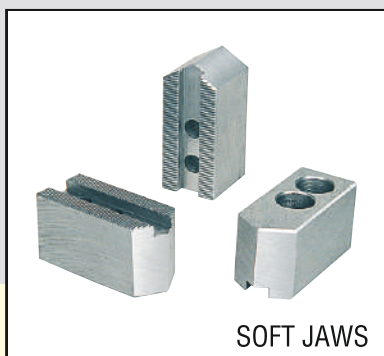
Note : Open bore stationary chuck also available

SIZE	Piston Dia	Plunger Stroke	Stroke Per/Jaw	Weight in kgs	Operating Force kgf	Gripping Force kgf	Max./ input Pressure kg/cm ²
170	120	14	2.75	20	2200	5800	25
210	150	16	3.75	36	3500	8700	25
254	160	16	3.75	42	4300	11000	30
305	200	16	4.0	55	5600	14000	30

Pneumatically operated chuck also available

JAWS for POWER CHUCK

SOFT & TOP HARD JAWS



SOFT JAWS



HARD JAWS

Only The Best



POWER

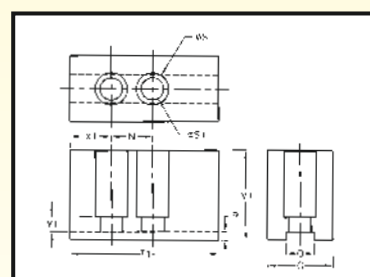
SOFT JAWS

SIZE	G	N	Q-H7	R	S	S1	T1	V1	X1	Y1	Serrations
125/135 mm	25	15	10	4.5	13.5	9.5	60	30	16	6	1/16" x 90°/ 1.5mm x 60°
160 mm	31	19	12	5	17.5	11.5	75	38	15	7	1/16" x 90°
170 mm	31	20	12	5	17.5	11.5	75	38	15	7	1.5mm x 60°
200 mm	38	19	17	5	19.5	13.5	85	45	19	10	1/16" x 90°
210 mm	38	25	14	5	19.5	13.5	85	38	19	10	1.5mm x 60°
250 mm	45	25	21	6	25.4	17.5	110	60	25	11	1/16" x 90°
254 mm	45	30	16	6	25.4	17.5	110	50	25	11	1.5mm x 60°
305 mm	50	30	21	6	25.4	17.5	120	60	30	13	1.5mm x 60°
315 mm	45	25	21	6	25.4	17.5	120	60	30	13	1/16" x 90°
380-450 mm	62	43	22	8	32.0	22.0	165	66	35	16	1.5mm x 60°
530/610 mm	65	60	25	9	33.0	22.0	180	70	40	16	3mm x 60°

SOFT JAWS

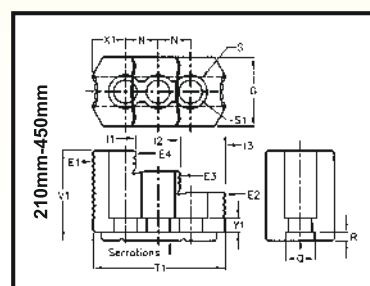
(Steel & Aluminium)

Soft jaws for all kinds & makes of chucks both in 1.5mm X 60° & 1/16 X 90° are available



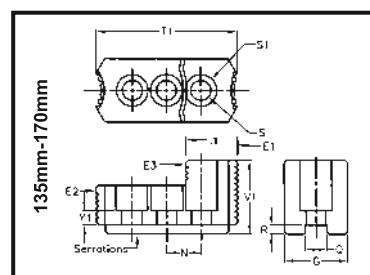
TOP HARD JAWS

SIZE	G	N	Q-H7	R	S	S1	T1	V1	X1	Y1	Serrations
125/135 mm	25.5	15	10	4.5	13.5	9.5	61	30	11.5	6	1/16" x 90°/ 1.5mm x 60°
160 mm	31	19	12	5	17.5	11.5	68.5	35	13.5	8	1/16" x 90°
170 mm	31	20	12	5	17.5	11.5	70	35	13.5	4	1.5mm x 60°
200 mm	40	19	17	5	19.5	13.5	77	52	19	8	1/16" x 90°
210 mm	40	25	14	5	19.5	13.5	85	51	16.5	8	1.5mm x 60°
250 mm	45	25	21	6	25.4	17.5	95	55	24	8	1/16" x 90°
254 mm	40	30	16	5	19.5	13.5	100	54	20	8	1.5mm x 60°
305 mm	50	30	21	5	25.4	17.5	103	59	21.5	13	1.5mm x 60°
315 mm	45	25	21	6	25.4	17.5	103	58	32	8	1/16" x 90°
380-450 mm	62	43	22	8	32.0	22.0	149	86	32	13	1.5mm x 60°
530/610 mm	65	60	25	9	33.0	22.0	180	90	30	16	3mm x 60°



CLAMPING RANGE

SIZE	E1	E2	E3	E4	I1	I2	I3
135 mm	15-60	15-30	80-135	-	60-115	-	-
170 mm	22-72	22-40	80-169	-	62-136	-	-
210 mm	25-99	25-102	74-152	124-210	70-150	116-190	166-200
254 mm	28-104	41-124	123-206	205-254	76-160	156-242	236-250
305 mm	42-170	56-195	135-275	220-305	84-218	236-250	228-315
380 mm	50-200	50-195	175-320	245-385	155-295	220-365	50-195
450 mm	50-260	50-260	175-385	245-450	155-360	220-440	50-260
530 mm	90-300	90-300	225-420	333-530	190-420	318-530	90-300
610 mm	115-325	115-325	250-500	358-610	225-500	343-610	115-325



NOTE : Any Jaws can be supplied with serrations 1.5mm X 60° or 1/16 X 90° as a special case

HYCC

HYDRAULIC COLLET CHUCKS

SECO Collet Chucks is cost effective solution for machining of components which are prone to deformation, surface damage. Quick clamping and de-clamping help achieve high production.

Only The Best

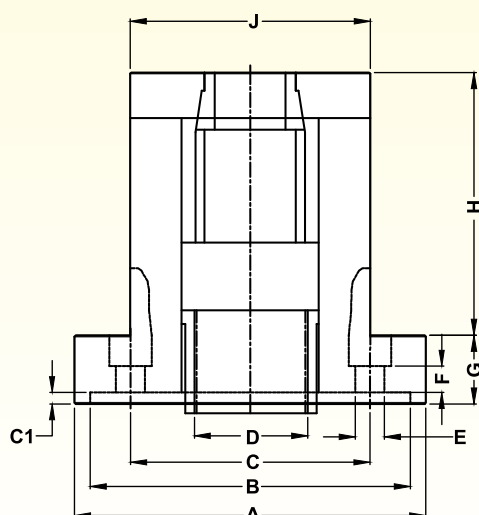


P O W E R



Special Features:

- Constant accuracy and High endurance
- Strong Gripping and Self Adjusting Ability for minor dimensional variation
- Conveniently replaces a power chuck on a CNC Lathe."



Dimensions in mm

Model	A	B	C	C1	D	E	F	G	H	J
HYCC A25	124	110	82.6	4.0	M38X1.5	11.5	11.5	50	77	80
HYCC A42	154	140	104.8	5.0	M52X2	11.5	11.5	30	95	105
HYCC A60	185	170	133.4	5.0	M60X2	13.5	11.5	30	115	140

Model	Max. RPM	Max. Holding Capacity	Max. Operating Force kgf	Max. Gripping Force kgf
HYCC A25	8000	25	2500	5000
HYCC A42	7000	42	2500	5000
HYCC A60	6000	60	3000	6000

SCH

SELF-CONTAINED COLLET CHUCK

SECO Front Mounted Self-Contained Cylinder Through Hole Collet Chuck is a very cost-effective accurate precision chucking solution for automats manual lathes, 4th axis rotary tables on VMCs. It eliminates many components like draw tubes, mounting plates etc.

Only The Best

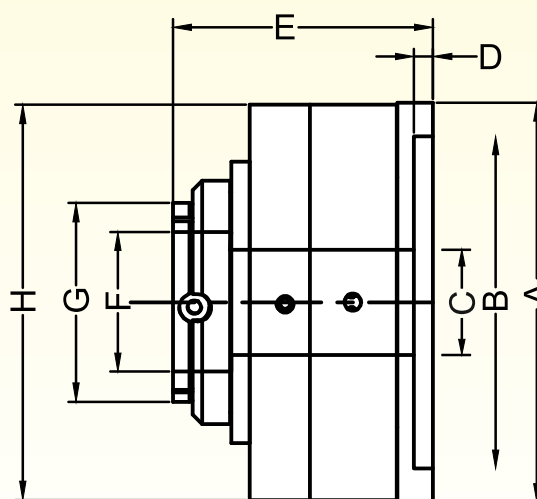
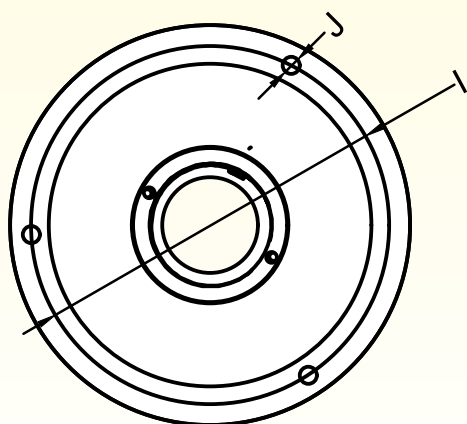


POWER



SPECIAL FEATURES:

- High gripping force due to large piston
- Through hole for auto-feed facility
- Easy & Convenient Front Mounting
- Jaw Type Clamping Possible with collet pads



Dimensions in mm

MODEL	A	B	C	D	E	F	G	H	I (PCD)	J
SCH-25	135	100	25	4	102	45	68	138	115	M8 x 3
SCH-40	192	155	45	4.5	126	65	94	190	172	M10 x 3
SCH-70	192	155	68	5	141	105	136	211	172	M10 x 3

MODEL	Operatating Pressure Kgf/CM ²	Max. RPM	Max.Capacity (Through Hole)	Piston Area CM ²	Gripping Force Kgf	Weight in Kgs.
SCH-25	10-25	1800	25-32	56	2500	6
SCH-40	10-20	1600	45-50	85	4000	13
SCH-70	10-20	1400	68-90	117	5150	18

GUIDELINES REGARDING CUTTING AND GRIPPING FORCE

The advancement of technology has enabled us to produce machines with ultra high speed. The high speed cutting technology has posed new challenges for the chucking equipment. The work holding at higher speeds needs chucking equipment with the competent gripping force.

Only The Best



The gripping force of the chuck depends upon various factors such as:

Lubrication conditions

Size, shape and finish of the job

Gripping surface of the jaws

Draw bar pull Centrifugal forces applied at higher speed

The Weight of top and base jaws

Each of the above factors has its own role in determining the gripping force of the Chuck. However the influence of centrifugal force on gripping force of a chuck needs better understanding by the user so that he can select cutting speeds and feeds precisely for optimum productivity.

It is advisable for the chuck user to understand the following formula for calculating centrifugal force:

$$C.F. = \frac{0.102 \times G \times r \times (\pi \times n)^2}{30}$$

Where,

G = weight of base jaws and top jaws

r = the radius of center of gravity

n = Operating speed

C.F. = centrifugal force

After having calculated the centrifugal force, the available chucking force at a given speed can be found with the help of following equation:-

$$GF_1 = GF_2 \pm CF$$

Where

GF1 = Gripping force at a given speed

GF2 = Gripping force when the chuck is in a stationary stage

CF = Centrifugal force.

+(Plus) for internal gripping and - (minus) for external gripping.

It is advisable that the chucking force at a given speed should be at least 1.5/2.0 times the cutting forces depending upon the constructional rigidity/fragility of the job.

For more details see operating manual

Elements of Power Chucking System

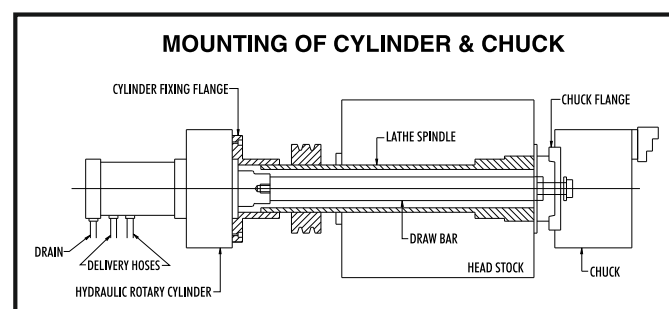
Power chucking system consists of Power Chuck.

Power source (Hydraulic or Pneumatic Revolving Cylinder).

Draw Bar.

Power Pack.

Schematic arrangement of a hydraulic Chuck and Cylinder is shown in the figure



OBC

OPEN CENTRE (Through Hole) SUPER HIGH SPEED ROTARY CYLINDER

Only The Best

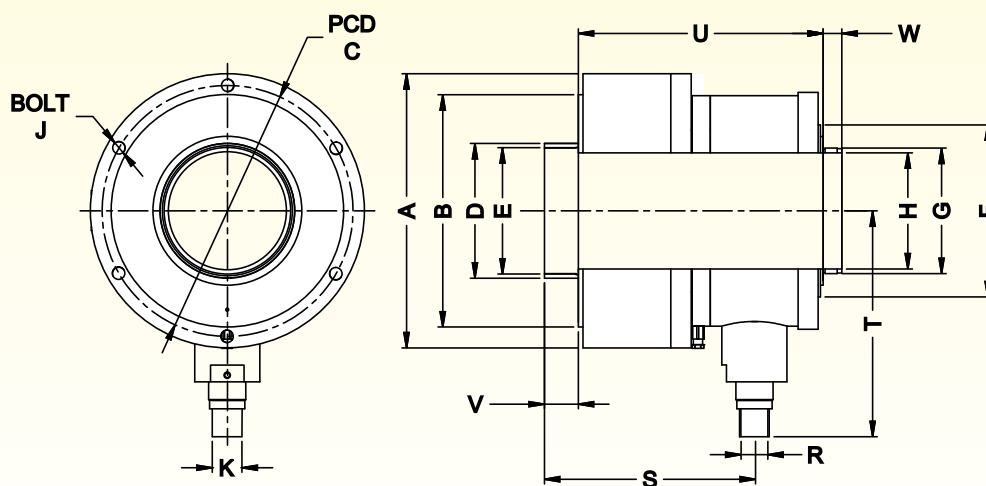


POWER



SPECIAL FEATURES:

- Light Weight
- Large Bore
- High Speed
- Small & Compact
- Dynamically Balanced



Dimensions in mm

MODEL	A	B	PCD	D	E	F	G	H	J
OBC 100	135	100	118	64	M42x2	110	48	33	M8 x 6
OBC 200	215	160	190	110	M98x2	145	99	91	M10 x 12
OBC 250	295	250	190	145	M138x2	185	145	127	M12 x 6

MODEL	K	R	S	T	U	V Min.	V Max.	W Max.
OBC 100	25	17	153.5	144.5	170.5	-6	19	48
OBC 200	32	25	158	176	211	-3	22	40
OBC 250	32	25	206.5	207	260	-4	36	60

MODEL	Piston Dia	Push Side CM ²	Pull Side CM ²	Piston Stroke	Push Side KN (kgf)	Pull Side KN (kgf)	Max.Operating Pressure kg/cm ²	Max. Speed RPM	Moment Inertia 1(kgf.m ²)	Weight in kgs	Total Leakage (L/Min.)
OBC 100	100	71	68.5	25	24(2529)	23(2447)	40.8	8000	0.011	8.6	3
OBC 200	200	252	234	25	95(9585)	88(8973)	40.8	3800	0.015	37	4.5
OBC 250	250	310	298	40	119(121340)	113(11788)	40.8	1800	0.545	62	7

OBC 100 & 200 are front mounting & OBC 250 is back mounting cylinder

NOBC

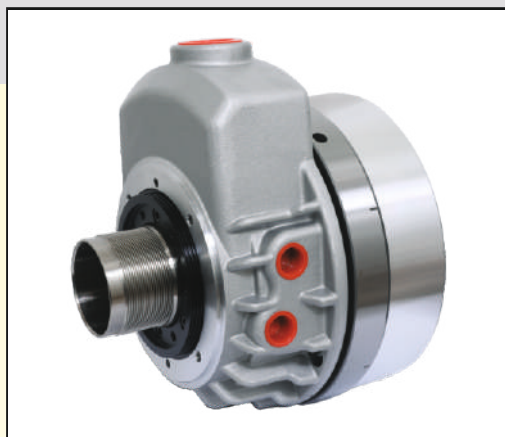
COMPACT HIGH SPEED THROUGH BORE HYDRAULIC ROTARY CYLINDER

SECO NOBC model large through hole high speed Rotary Cylinder with inbuilt safety valves suitable for new CNC machines as well as for Replacement of cylinder on existing machine.

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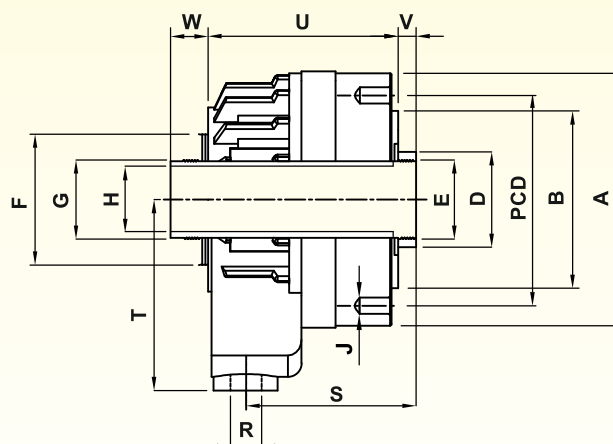
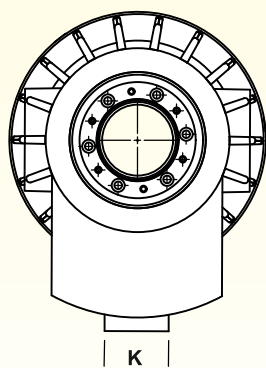


POWER



Special Features:

- Compact and light weight design for reliability and high speed.
- Large through Hole for higher bar capacity
- Inbuilt safety valves
- Stroke control with proximity switches



Dimensions in mm

MODEL	A	B	PCD	D	E	F	G	H	J
NOBC 120	155	100	130	65	M55x2	116	M52x1.5	46	M10x12
NOBC 160	190	130	170	70	M60x2	130	M52x2	52	M10x12
NOBC 180	215	160	190	95	M85x2	160	M84x2	75	M10x12

MODEL	K	R	S	T	U	V Min.	V Max.	W Min.
NOBC 120	47	25	155	140	170	-6	12	20
NOBC 160	47	25	145	140	175	-11	14	21.5
NOBC 180	47	25	156.5	160	196	-10	20	28

MODEL	Piston Dia	Push Side CM ²	Pull Side CM ²	Piston Stroke	Push Side KN (kgf)	Pull Side KN (kgf)	Max.Operating Pressure kg/cm ²	Max. Speed RPM	Moment Inertia 1(kgf.m ²)	Weight in kgs	Total Leakage (L/Min.)
NOBC 120	125	100	89	18	38 (3875)	33 (3365)	40.8	7000	0.019	11.9	3.0
NOBC 160	155	161	150	25	60 (6118)	56 (5710)	40.8	6200	0.032	16.5	3.9
NOBC 180	180	198	183	25	75(7546)	69 (7036)	40.8	5500	0.065	23.5	4.2

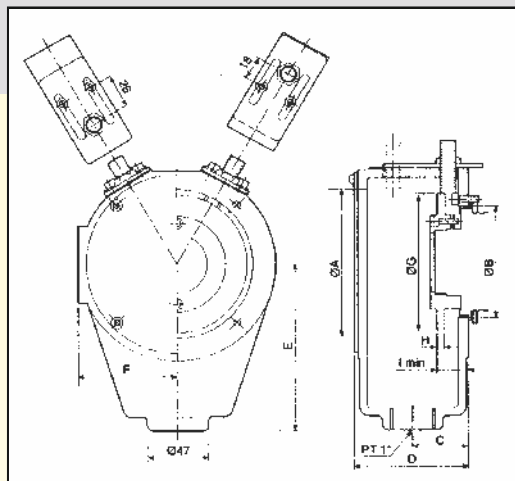
CLC

HOPEN CENTRE HOLLOW (Through Hole) HYDRAULIC CYLINDER COOLENT COLLECTOR

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POWER

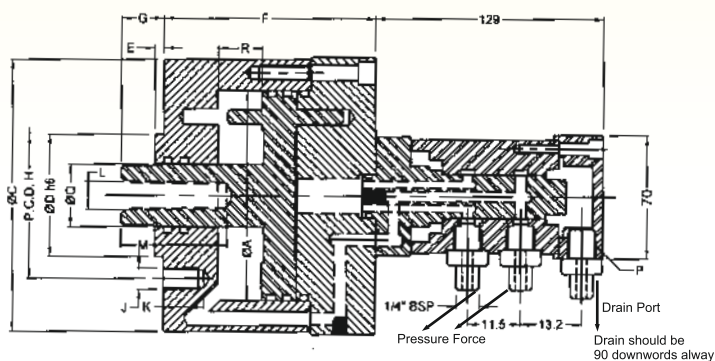
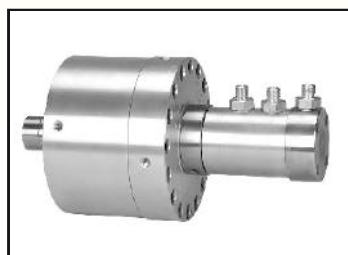


Dimensions in mm

Model	A	B	C	D	E	F	G	H	I min.	Maching Cylinder
CLC 120	125	94	36	120	64.5	94	107	6	23	NOBC120
CLC 160	138	105	44	130	74.0	105	147	6	23	NOBC160
CLC 180	185	145	49	160	94.5	145	147	6	23	NOBC180

CBC Hydraulic Close Centre ROTATING CYLINDER

SECO Close Centre Rotating Cylinders Suitable for CNC and AUTO chucking lathes. Years of trouble free service assured



Dimensions in mm

Model	A	C	D H6	E	F	G Min.	G Max.	H PCD	J	K	L	M	P	Q	R	Weight in Kgs.	Draw Bar Pull in KgF at 25 kg/cm ²	RPM
CBC 60	60	95	60	5	84	24	49	75	4 X M8	20	M12	50	3/8" BSP	25	25	5	1000	4000
CBC 90	90	125	70	5	121	24	49	95	4 X M10	20	M14	50	3/8" BSP	30	25	6.8	1400	4000
CBC 120	120	160	70	5	121	24	49	95	4 X M12	20	M16	50	3/8" BSP	36	25	9	2600	4000
CBC 160	160	200	95	5	126	24	54	145	4 X M16	25	M24	50	3/8" BSP	36	30	13.8	4800	3000
CBC 200	200	240	125	5	126	24	54	170	6 X M16	25	M24	50	3/8" BSP	36	30	20	7600	2500
CBC 250	250	302	125	5	160	39	89	170	6 X M16	25	M24	50	3/8" BSP	36	30	28	10400	2000

NCBC

COMPACT HIGH SPEED CLOSE BORE HYDRAULIC ROTARY CYLINDER

SECO NCBC model are compact high speed close bore rotary cylinders suitable for CNC/Automats/SPM machines. Available with or without safety valves. Option for proximity switches for stroke control.

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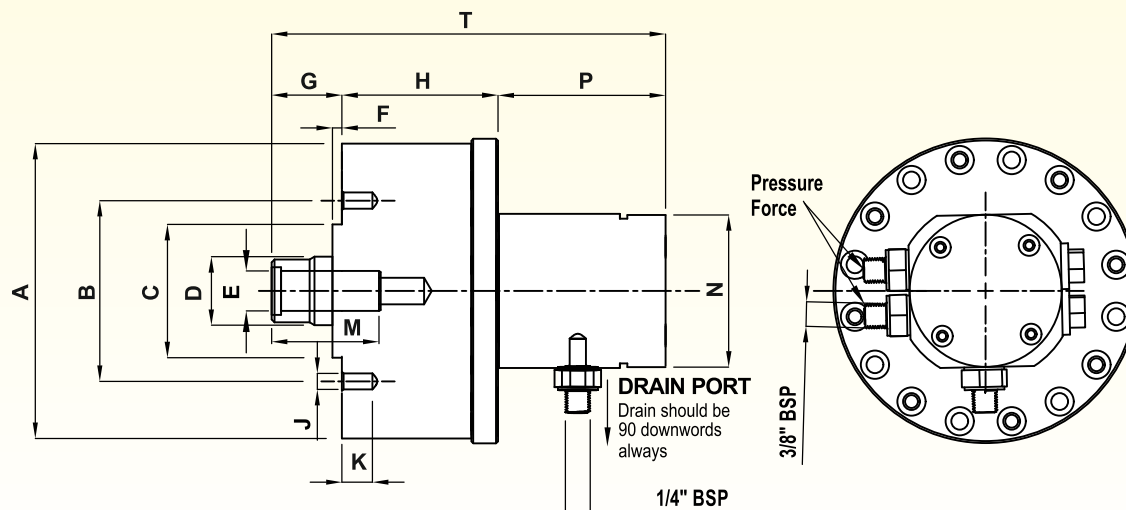


POWER



Special Features:

- Compact and light weight design for reliability and high speed.
- Inbuilt safety valves optional.
- Stroke control through proximity switches optional.



Dimensions in mm

MODEL	A	B	C	D	E	F	G		H	J	K
							Min.	Max.			
NCBC 90	125	95	70	30	M14X2	5	20	37	91	M10X4	20
NCBC 120/LS*	155	95	70	36	M16X2	5	20	37/50	91/104	M12X4	20
NCBC 160	200	145	95	36	M24X2	5	20	45	110	M16X4	25

MODEL	M	N	P	T Min.	Piston Dia	Piston Stroke	Weight in kgs. app.	Draw Bar Pull in kgs. at 25kg/cm ²	RPM
NCBC 90	55	80	88	213	90	17	7.8	1400	7000
NCBC 120/LS*	55	80	88	213/226	120	17/30	10	2600	6000
NCBC 160	55	80	88	224	160	30	14.8	4800	5500

* Long Stroke

HCC

CLOSE CENTRE (Non through hole) HIGH SPEED ROTARY CYLINDER

Only The Best

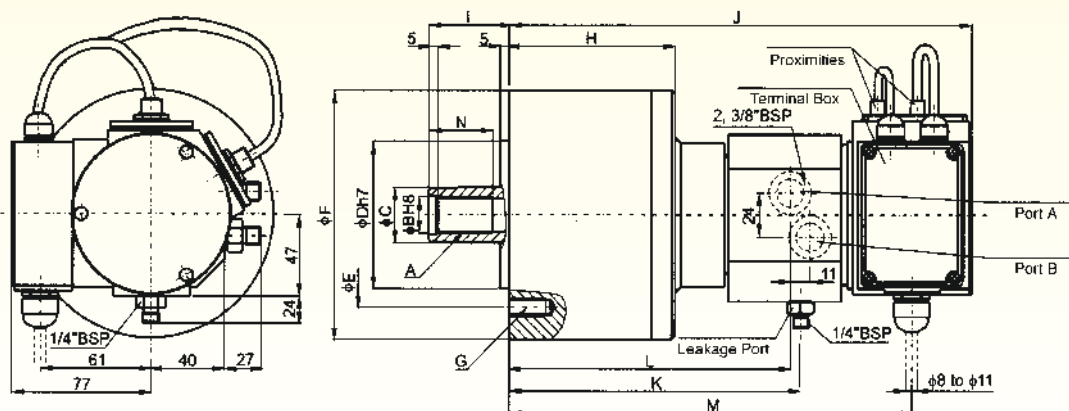


POWER



SPECIAL FEATURES:

- Compact design
- High speed
- Dynamically balanced
- In built safety mechanisms
With safety check valves



DIMENSIONS IN MM

MODEL	A	B H8	C	D H7	E	F	G	H	I		J	K	L	M	N	O	P	Q
									max	min								
HCC 120	M24 X 3.0	25	35	110	130	162	6-M12X24	101	51	26	261.5	166	162	227	44	6-M10 X 105	15	142
HCC 160	M30 X 3.5	31	45	110	130	190	12-M12X24	106	56	26	266.5	177	167	232	45	6-M10 X 100	15	170

MODEL	Max Pull in kg	Pull Area in cm ²	Piston Dia in mm	Piston Travel in mm	RPM max	Max Leakage at 30 Bar and 50° L/min	Weight in Kgs.	Moment Inertia in Kg-M ²
HCC 120	4000	113	125	25	6000	0.8	12	0.0264
HCC 160	5700	160	150	30	5500	0.8	15	0.0530

Proximity switches optional

BACK PLATES

For KIRLOSKAR, HMT, PSG
& Other Lathes

Only The Best



CHUCKS



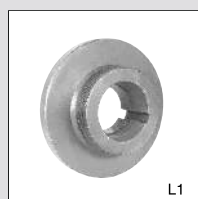
A1,A2



D1



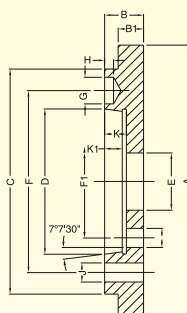
DIN
55027/22



L1

A1, A2 TYPE

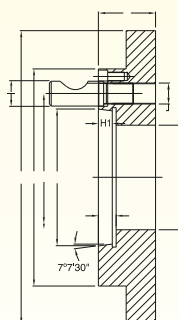
SIZE	4	5	6	8	11	15
A	160, 200, 250	160, 200, 250	200, 250, 315	250, 315, 400	315, 400, 600	315, 400, 500, 630
B	33.0	35.0	35.0	45.0	45.0	50.0
C	117	146	165	210	280	380
D	63.513	82.563	106.375	139.719	196.869	285.775
E (Max)	61.0	79.0	103.0	136.0	193.0	282.0
F (A2)	82.6	104.8	133.4	171.4	235.0	330.2
F1 (A1)	-	61.90	82.6	111.10	165.10	247.6
G	14.7	16.3	19.45	24.20	29.4	35.7
H	6.5	6.5	6.5	8.0	10.0	10.0
J	12.0	12.0	14.0	18.0	20.0	24.0
K	-	15.0	16.0	18.0	20.0	21.0
K1	10.0	12.0	13.0	14.0	16.0	17.0



A-1, A-2

D1 TYPE

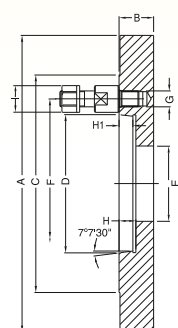
SIZE	4	5	6	8	11	15
A	160, 200, 250	160, 200, 250	200, 250, 315	250, 315, 400	315, 400, 600	400, 500, 630
B	33.0	35.00	40.0	45.0	50.0	55
C	117	146	181	222	298	403
D	63.513	82.563	106.375	139.719	196.869	285.775
E (Max)	61.0	79.0	103.0	136.0	193.0	282.0
F	82.6	104.8	133.4	171.4	235.0	330.2
G	M-10x1	M-12x1	M-16x1.5	M-20x1.5	M-22x1.5	M-24x1.5
H	13	15	16	18	20	21
H1	10	12	13	14	16	17
I	15.9	19	22.2	25.4	30.2	34.9



D-1

DIN TYPE

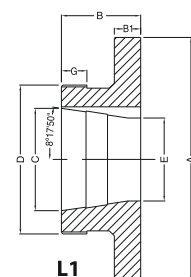
SIZE	4	5	6	8	11	15
A	160, 200, 250	160, 200, 250	200, 250, 315	250, 315, 400	315, 400, 600	400, 500, 630
B	33.0	35.00	40.0	45.0	50.0	55
C	117	146	165	222	290	380
D	63.525	82.563	106.375	139.719	196.885	285.80
E (Max)	61.0	79.0	103.0	136.0	193.0	282.0
F	85	104.8	133.4	171.4	235.0	330.2
G	M-10	M-10	M-12	M-16	M-20	M-24
H	13	16	17	19	21	22
H1	10	12	13	14	16	18
I	19.5	19.5	21.5	27	34	41



DIN

L1 TYPE

SIZE	A	B	B1	C	D	E	G
L0	160, 200, 250, 315	63.5	28	82.55	4.1/4x6	66	15
L1	200, 250, 315, 400	76.2	28	104.78	6x6	84.5	16



L1

SPARES

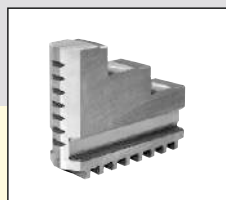
**SJ, MTJ, AS & DP CHUCKS
POWER CHUCKS,
INDEPENDENT CHUCKS &
BACK PLATES**

Only The Best



CHUCKS

**FOR
SJ, MTJ, AS &
DP CHUCKS**



FORWARD JAW



REVERSE JAW



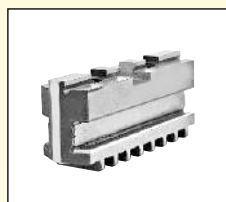
PINION & PIN



SCROLL



OPERATING KEY



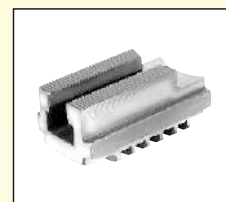
BASE/MASTER JAW



TOP SOFT JAW



TOP HARD JAW



BASE JAW DP CHUCK



THREADED SOFT JAW



TOP JAW DP CHUCK



**ADJUSTING SCREW
For AS CHUCK WEDGE**



**HEMISPHERE BALL
For AS CHUCK**



BACK COVER PLATE

**FOR
POWER
CHUCKS**



BASE JAW



WEDGE

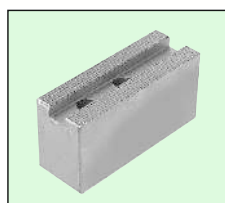


TOP HARD JAW



CAM LOCK

**FOR
INDEPENDENT
CHUCKS**



TOP SOFT JAW



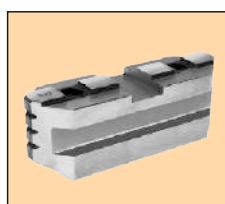
SPINDLE NUT



SPINDLE NUT PLATE



CAM LOCK STUD



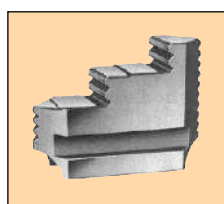
BASE HARD JAW



THRUST BEARING



OPERATING SCREW



**HARD
REVERSIBLE JAWS**



**BACK PLATE STUD
For DIN 55027/22 18**

TECHNICAL SPECIFICATIONS

Only The Best



CHUCKS

MAXIMUM SPEED For Manual Self Centring Chucks

CHUCK SIZE	CAST IRON BODY	S.G IRON BODY	STEEL BODY
80 mm	4000	5600	7000
100 mm	3300	4800	5500
125 mm	2700	3800	4500
160 mm	2000	2500	3200
200 mm	1600	2200	2800
250 mm	1300	2000	2400
315 mm	1000	1500	1900
400 mm	850	1200	1500
500 mm	650	1000	1200
630 mm	545	800	1000

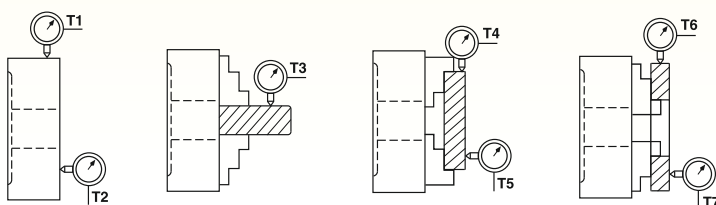
CAUTIONS :

- It is better to use chucks at 75% of the maximum RPM.
- Gripping force can drop due to centrifugal force if jaws are changed by user. In such cases users should be access the speed or consult us.
- Older chucks should be operated at low RPM as there is possibility of loss of gripping force due to wear & tear.

CLAMPING RANGE of 3 Jaws Manual Self Centring Chucks

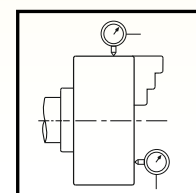
SIZE									
d1	d5min.	d6max.	d7min.	d8max.	d9max.	d10min.	d11min.	d12max.	d13ma
80	2	27	22	69	91	2	25	71	91
100	3	34	28	87	115	3	31	93	115
125	3	46	35	112	148	3	33	120	148
160	3	62	43	154	200	3	48	160	200
200	4	84	50	194	250	4	56	200	250
250	5	108	66	240	310	5	70	250	310
315	10	145	70	299	385	10	90	315	385
400	20	198	85	380	480	20	125	400	480
500	35	280	110	480	600	35	132	500	600
630	50	390	130	610	750	50	190	630	750

TEST SPECIFICATIONS of Manual Self Centring Chucks

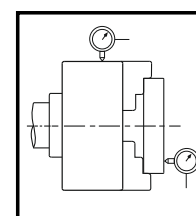


Chuck Dia in MM	T1,T2	T3	T4	T5	T6	T7
80-125	0.025	0.075	0.04	0.025	0.04	0.025
160-250	0.03	0.04	0.04	0.03	0.04	0.03
315-400	0.04	0.075	0.06	0.04	0.06	0.04
500-630	0.06	0.10	0.075	0.05	0.075	0.05

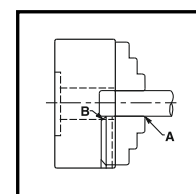
NOMINAL SIZE CHUCK		TEST -A	TEST-B	TEST-C
OVER	UPTO & INCLUDING	PERMISSIBLE DEVIATION	PERMISSIBLE DEVIATION	PERMISSIBLE DEVIATION
----	200	0.050	0.050	.04 FILLER GAUGE SHALL NOT PASS AT POINT A & POINT B
200	400	0.100	0.050	
400	630	0.125	0.125	
630	800	0.150	0.150	
800	1000	0.200	0.200	



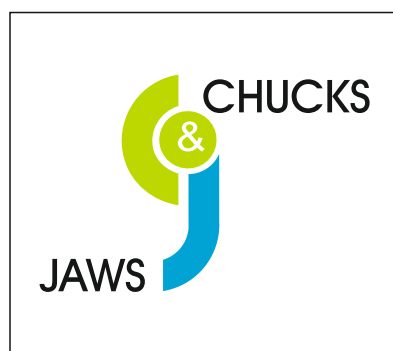
TEST-A



TEST-B



TEST-C



Only The Best



CHUCKS



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