

STANDARD JAWS SELF CENTRING CHUCKS

TYPE SJ



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

MATERIAL COMPOSITION:

BODY

C I 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 alloy steel, Hardness 40-45 Hrc.

SPECIAL FEATURES

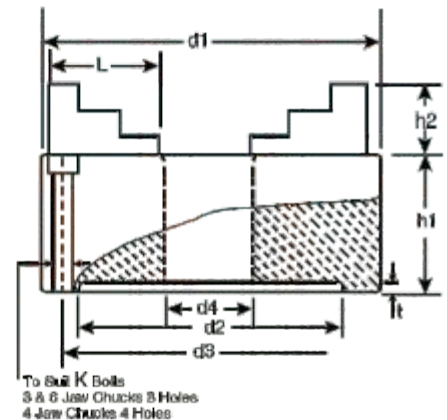
BODY : Jaw ways Hardened and ground.

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



DIMENSIONS IN MM

Nominal Size d_1	d_2 H_7	P.C.D		d_4 Min.	h_1 Max.	h_2 Max.	t Min.	L	K	Size of Sq. Key for Chuck	Approx. Wt. in Kgs.			
		d_3	Tol. on d_3								SJ3	SJ4	SJ6	Large Bore
80	56	67	± 0.2	16	44	12	3	32	M6	6	1.6	2.0	-	-
100	70	83	± 0.25	20	50	18	3	41	M8	8	2.5	3.0	-	-
125	95	108	± 0.25	33	57	21	4	48	M8	9	4.5	5.0	6.0	-
160	125	140	± 0.3	42	67	29	4	65	M10	10	8.0	9.0	10.0	-
200	160	176	± 0.3	55	75	31	4	80	M10	11	14.0	15.0	16.0	-
250	200	224	± 0.35	76	85	36	5	98	M12	12	27.0	28.0	30.5	-
315	260	286	± 0.4	107	87	36	5	118	M12	14	38.5	41.0	44.0	-
400	330	362	± 0.4	150	110	51	5	160	M16	17	87.0	88.0	93.0	175.0
500	420	458	± 0.4	200	120	65	7	194	M16	16	150.0	162.0	223.0	225.0
630	545	586	± 0.4	275	135	65	7	248	M16	19	246.0	307.0	338.0	335.0

CHUCKS WITH BACK PLATE ALSO AVAILABLE