

WHICH BTC® CHUCK DO YOU NEED?

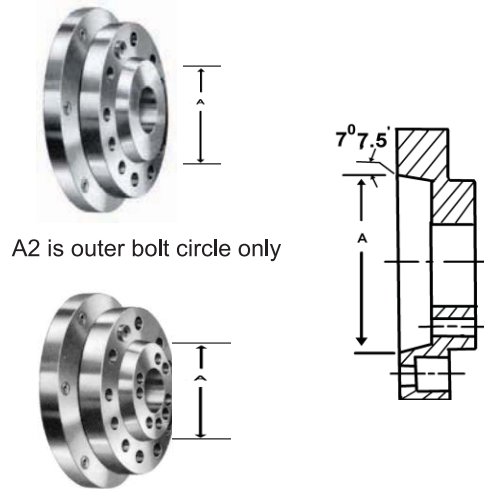
American Standard Type A

Spindles

How do you determine what type of chuck and mounting you require? Here are the questions that your distributor will ask you.

What mounting do you need?

- Determine the spindle type from the chart on the right.
- Measure the major diameter of the taper. Match to the chart for your spindle type.
- For threaded spindles you need the threads per inch.
- Chucks with A2 mounting will fit both A1 and A2 spindle nose.**



A2 is outer bolt circle only

A1 is inner and outer bolt circle

Spindle Nose	"A" Dia.
A-4	2.50
A-5	3.25
A-6	4.19
A-8	5.50
A-11	7.75
A-15	11.25

What accuracy and repeatability is required?

- High precision - ZERO SET® chucks .0005 TIR on duplicate parts.
- General I.D. or O.D. work - Three jaw self centering chucks .003 TIR.

What size of chuck?

- For scroll chucks do not exceed the swing diameter over the cross slide.
- For independent chucks the next larger size may work.

How many jaws do you need?

- Two jaw - Square work or Special applications.
- Three jaw - Conventional machining.
- Four jaw - Square and offset work.
- Six jaw - 2nd operation or thin wall parts.

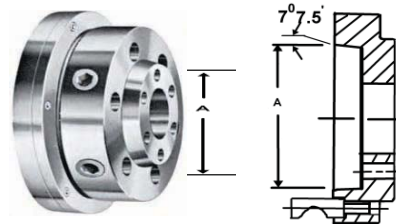
What type of jaws do you need?

- The most common are the top reversible jaws. They can be used for both I.D. or O.D. work, and production work. They also can be adapted to soft jaws or special top tooling.
- Solid jaws are typically used for toolroom applications.

Spindle run out?

- Use an indicator to check the spindle for radial or axial runout.
- Reduce play in spindle to minimum.
- Spindle runout allowable:
 - 3" to 16" .00012" max
 - 18" to 32" .0002" max.

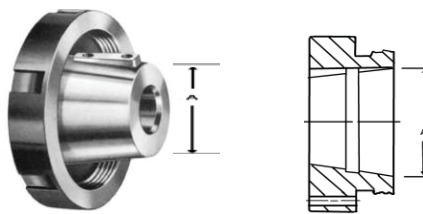
Camlock Type D



Spindle Nose	"A" Dia.	Cam Dia.
D-3	2.13	9/16
D-4	2.50	5/8
D-5	3.25	3/4
D-6	4.19	7/8
D-8	5.50	1
D-11	7.75	1 3/16
D-15	11.25	1 3/8

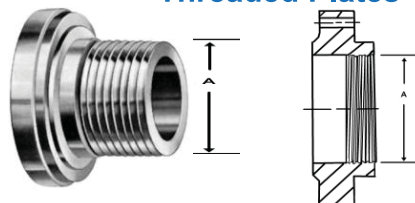
Camlock stud length is adjustable

Long Taper Key Drive



Spindle Nose	"A" Dia.
L-00	2.75
L-0	3.25
L-1	4.13
L-2	5.25
L-3	6.50

Threaded Plates



Spindle Nose	"A" Dia.
1"-8	1.00
1"-10	1.00
1 1/2"-8	1.50
1 3/4"-8	1.75
2 1/4"-8	2.25
2 3/8"-6	2.38
2 3/4"-8	2.75

Mounting Plates also available for Hardinge style threaded and tapered spindles. Special mountings available, call for quotation.