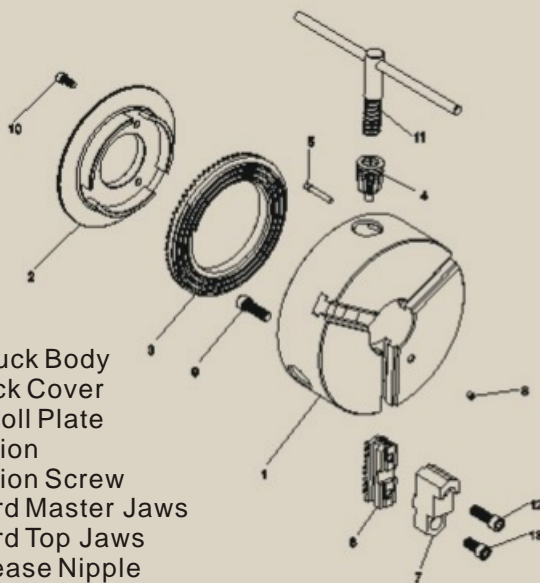


- These chucks can be used on all types of lathes, and on different kinds of milling ,drilling and CNC attachments.
- Chucks come with either American Standard two-piece tongue and groove jaws ,or two sets of hard solid OD & ID jaws.
- Plain Back & Direct Mount.
- Semi-steel body.
- Chuck body is made of high quality cast iron. All guide ways and bearing surfaces are precisely machined.
- Scroll plate is drop forged of fine alloy steel, and carefully case hardened. Thread flanks are ground on both sides.
- The jaw's teeth and guide ways are hardened and fully ground on both sides.
- Pinions are hardened and ground.



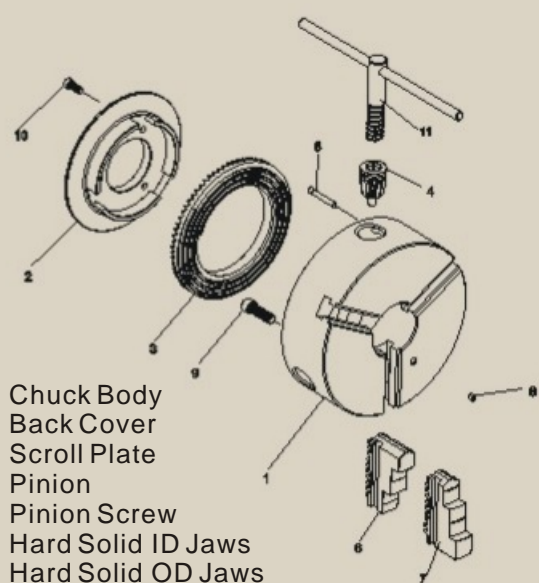
PS Series Universal Self-Centering Scroll Chucks
2-Jaw, 3-Jaw & 4-Jaw, Semi-Steel Body

■ Chucks with Two-Piece Reversible Jaws



1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Screw
6. Hard Master Jaws
7. Hard Top Jaws
8. Grease Nipple
9. Chuck Mounting Bolts
10. Back Cover Mounting Bolts
11. Chuck Wrench
- 12 & 13. Jaw Mounting Bolts

■ Chucks with Two Sets of OD & ID Hard Solid Jaws



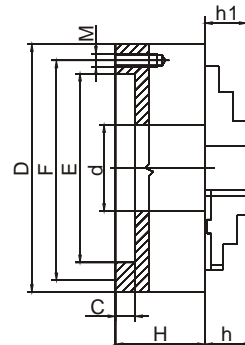
1. Chuck Body
2. Back Cover
3. Scroll Plate
4. Pinion
5. Pinion Screw
6. Hard Solid ID Jaws
7. Hard Solid OD Jaws
8. Grease Nipple
9. Chuck Mounting Bolts
10. Back Cover Mounting Bolts
11. Chuck Wrench

PS Series Universal Self-Centering Scroll Chucks

3-Jaw & 4-Jaw, Plain Back, Adapter Plates Required, Semi-Steel Body

Principal Dimensions - Back Mounting

Chuck Dia. D	F	E	d	C	H	h	h1	Adapter Mounting Bolts		
								Thread M	L	No. of Bolts
3-1/4"	2.6378	2.2047	0.6299	.1181	1.732	-	0.512	M6X1	0.98	3
4"	3.2677	2.7559	0.7874	.1181	1.969	-	0.669			
5"	4.2520	3.7402	1.2598	.1575	2.205	1.575	0.787			
6-1/4"	5.5118	4.9213	1.6535	.1575	2.539	1.693	1.26	M10 x 1.5	1.18	6
8"	6.9291	6.2992	2.1654	.1575	2.953	1.772	1.142			
10"	8.8189	7.8740	2.9921	.1969	3.347	2.087	1.339			
12-1/2"	11.2598	10.2362	4.0551	.1969	3.701	2.244	1.693	M12 x 1.75	1.57	6
15-3/4"	14.2519	12.9921	5.3543	.1969	4.134	2.693	2.165			
20"	18.0314	16.5354	7.7840	.2362	4.5276	3.504	2.205			
25"	23.0709	21.4567	10.2362	.2756	5.1575	3.465	2.756	M16 x 2	1.97	



3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Each chuck is provided with:

- 1 set of hard master jaws
- 1 set of hard top reversible jaws
- 1 set of mounting bolts
- 1 chuck wrench
- 2 hex keys
- 2 eye bolts with 16"-25" chucks
- 3 pinion design



Chuck Dia.	Hole Dia.	Max.Hole Enlargements	RPM max.	Model	Part No.
5"	1.2598	1.3465	3200	PS3-5"A	1-201-0500
6-1/4"	1.6535	1.9252	3000	PS3-6"A	1-201-0600
8"	2.1654	2.8189	2500	PS3-8"A	1-201-0800
10"	2.9921	3.5827	2000	PS3-10"A	1-201-1000
12-1/2"	4.0551	4.4882	1500	PS3-12"A	1-201-1200
15-3/4"	5.3543	5.7480	1000	PS3-16"A	1-201-1600
20"	7.7840	8.3465	700	PS3-20"A	1-201-2000
25"	10.2362	12.047	500	PS3-25"A	1-201-2500

3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Each chuck is provided with:

- 1 set of hard solid ID jaws
- 1 set of hard solid OD jaws
- 1 set of mounting bolts
- 1 chuck wrench
- 2 hex keys
- 2 eye bolts with 16"-25" chucks
- 3 pinion design



Chuck Dia.	Hole Dia.	Max.Hole Enlargements	RPM max.	Model	Part No.
3-1/4"	.6299	0.7087	4000	PS3-3"	1-202-0300
4"	.7874	0.9055	3500	PS3-4"	1-202-0400
5"	1.2598	1.3465	3200	PS3-5"	1-202-0500
6-1/4"	1.6535	1.9252	3000	PS3-6"	1-202-0600
8"	2.1654	2.8189	2500	PS3-8"	1-202-0800
10"	2.9921	3.5827	2000	PS3-10"	1-202-1000
12-1/2"	4.0551	4.4882	1500	PS3-12"	1-202-1200
15-3/4"	5.3543	5.7480	1000	PS3-16"	1-202-1600
20"	7.7840	8.3465	700	PS3-20"	1-202-2000
25"	10.2362	12.047	500	PS3-25"	1-202-2500

Chuck Dia.	Hole Dia.	Max.Hole Enlargements	RPM max.	Model	Part No.
5"	1.2598	1.3465	3200	PS4-5"A	1-203-0500
6-1/4"	1.6535	1.9252	3000	PS4-6"A	1-203-0600
8"	2.1654	2.8189	2500	PS4-8"A	1-203-0800
10"	2.9921	3.5827	2000	PS4-10"A	1-203-1000
12-1/2"	4.0551	4.4882	1500	PS4-12"A	1-203-1200
15-3/4"	5.3543	5.7480	1000	PS4-16"A	1-203-1600
20"	7.7840	8.3465	700	PS4-20"A	1-203-2000
25"	10.2362	12.047	500	PS4-25"A	1-203-2500

4-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Each chuck is provided with:

- 1 set of hard master jaws
- 1 set of hard top reversible jaws
- 1 set of mounting bolts
- 1 chuck wrench
- 2 hex keys
- 2 eye bolts with 16"-25" chucks
- 2 pinion design



Chuck Dia.	Hole Dia.	Max.Hole Enlargements	RPM max.	Model	Part No.
4"	.7874	0.9055	3500	PS4-4"	1-204-0400
5"	1.2598	1.3465	3200	PS4-5"	1-204-0500
6-1/4"	1.6535	1.9252	3000	PS4-6"	1-204-0600
8"	2.1654	2.8189	2500	PS4-8"	1-204-0800
10"	2.9921	3.5827	2000	PS4-10"	1-204-1000
12-1/2"	4.0551	4.4882	1500	PS4-12"	1-204-1200
15-3/4"	5.3543	5.7480	1000	PS4-16"	1-204-1600
20"	7.7840	8.3465	700	PS4-20"	1-204-2000
25"	10.2362	12.047	500	PS4-25"	1-204-2500

4-Jaw Scroll Chucks with Two Sets of Hard Sol

Each chuck is provided with:

- 1 set of hard solid ID jaws
- 1 set of hard solid OD jaws
- 1 set of mounting bolts
- 1 chuck wrench
- 2 hex keys
- 2 eye bolts with 16"-25" chucks
- 2 pinion design

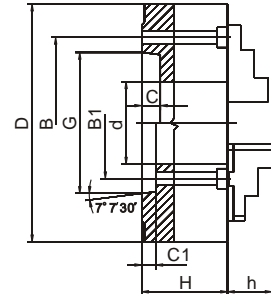


➔ 3-Jaw ,Type A1/A2, Direct Mount Self-Centering Scroll Chucks With Two Piece Hard Reversible Jaws

- Semi-steel body.
- Type A1 spindle has a 2 bolt hole pattern, inside (size B1) and outside the taper (size B). Either an A1 or A2 chuck will fit on it.
- Type A2 spindle has 1 bolt pattern, outside the taper (size B).only an A2 chuck will fit on it.



Type A



Chuck Dia.	Taper Size	Hole Dia.(d)	RPM max.	wt. lbs.	Model	Chuck Part No .	B (A2)	B1 (A1)	G	C/C1	H	h	Chuck Mounting Bolts			
													Thread	L	Qty.	Part NO.
6-1/4"	A1-5	1.6535	3000	22	PS3-6"/A1-5	1-211-0605	-	2.4374	3.2505	.563	3.2087	1.693	7/16-14	2-3/4	3	BA-06-05
8"	A1-5	1.6535	2500	42	PS3-8"/A1-5	1-211-0805	-	3.2500	4.1880	.625	3.5827	1.772	7/16-14	3-1/8		BA-08-05
	A1-6	2.1653			PS3-8"/A1-6	1-211-0806	-	3.2500	4.1880	.625	3.5827	1.772	1/2-13			BA-08-06
10"	A2-5	2.9921	2000	71	PS3-10"/A/A2-5	1-211-1005	4.1260	-	3.2505	.563	4.0748	2.087	7/16-14	4-1/8	BA-10-05	
	A1-6	2.1635			PS3-10"/A/A1-6	1-211-1006	-	3.2500	4.1880	.625			1/2-13	3-1/2	BA-10-06	
	A1-8	2.9921			PS3-10"/A/A1-8	1-211-1008	-	4.3750	5.5007	.688			5/8-11	3-1/2	BA-10-08	
12-1/2"	A2-6	4.0551	1500	121	PS3-12"/A/A2-6	1-211-1206	5.2520	-	4.1880	.630	4.6338	2.244	1/2-13	4-3/4	BA-12-06	
	A1-8	3.1496			PS3-12"/A/A1-8	1-211-1208	-	4.3750	5.5007	.688			5/8-11	4-3/16	BA-12-08	
15-3/4"	A2-6	4.0551	1000	203	PS3-16"/A/A2-6	1-211-1606	5.2520	-	4.1880	.630	5.0591	2.639	1/2-13	5	6	BA-16-06
	A2-8	5.3543			PS3-16"/A/A2-8	1-211-1608	6.7480	-	5.5007	.709			5/8-11	5		BA-16-08
	A1-11	5.1181			PS3-16"/A/A1-11	1-211-1611	-	6.5000	7.7507	.750			3/4-10	4-1/4		BA-16-11
20"	A2-11	7.5905	700	353	PS3-20"/A/A2-11	1-211-2011	9.2520	-	7.7507	.787	5.6693	3.5039	3/4-10	5-7/8	BA-20-11	
25"	A2-11	7.490	500	628	PS3-25"/A/A2-11	1-211-2511	9.2520	-	7.7507	.787	6.4961	3.4646	3/4-10	7-3/32	BA-25-11	
	A2-15	7.490			PS3-25"/A/A2-15	1-211-2515	13.000	-	11.251	.813			7/8-9	6	BA-25-15	

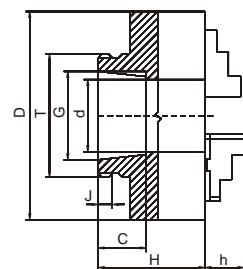
*C-C1, depth of counterbore.

➔ 3-Jaw ,Type L, Direct Mount Self-Centering Scroll Chucks With Two Piece Hard Reversible Jaws

- Semi- steel body.



Type L



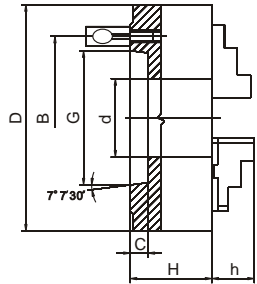
Chuck Dia.(D)	Taper Size	Hole Dia.(d)	RPM max*	wt. lbs.	Model	Chuck Part No .	Thread T	G	J	C	H	h
6-1/4"	L00	1.6535	3000	23	PS3-6"/A/L00	1-241-0601	3-3/4" - 6	2-3/4	.5512	2.1260	4.0551	1.693
	L0				PS3-6"/A/L0	1-241-0602	4-1/2" - 6	3-1/4	.5906	2.5197	4.4488	
8"	L00	2.1654	2500	42	PS3-8"/A/L00	1-241-0801	3-3/4" - 6	2-3/4	.5512	2.1260	4.3701	1.772
	L0				PS3-8"/A/L0	1-241-0802	4-1/2" - 6	3-1/4	.5906	2.5197	4.7638	
	L1				PS3-8"/A/L1	1-241-0803	6" - 6	4-1/8	.6299	2.9921	5.2362	
10"	L0	2.9921	2000	64	PS3-10"/A/L0	1-241-1002	4-1/2" - 6	3-1/4	.5906	2.5197	5.0394	2.087
	L1				PS3-10"/A/L1	1-241-1003	6" - 6	4-1/8	.6299	2.9921	5.5118	
	L2				PS3-10"/A/L2	1-241-1004	7-3/4" - 5	5-1/4	.8661	3.5039	6.0236	
12-1/2"	L0	4.0551	1500	134	PS3-12"/A/L0	1-241-1202	4-1/2" - 6	3-1/4	.5906	2.5197	5.3937	2.244
	L1				PS3-12"/A/L1	1-241-1203	6" - 6	4-1/8	.6299	2.9921	5.8661	
	L2				PS3-12"/A/L2	1-241-1204	7-3/4" - 5	5-1/4	.8661	3.5039	6.3780	
15-3/4"	L1	4.0551	1000	251	PS3-16"/A/L1	1-241-1203	6" - 6	4-1/8	.6299	2.9921	6.1811	2.639
	L2				PS3-16"/A/L2	1-241-1204	7-3/4" - 5	5-1/4	.8661	3.5039	6.6929	

➔ **3-Jaw ,Type D1, Direct Mount Self-Centering Scroll Chucks With Two Piece Hard Reversible Jaws**

- Semi-steel body.



Type D1



Chuck Dia.	Taper Size	Hole Dia.(d)	Max.Hole Enlargement	RPM max.	wt. lbs.	Model	Chuck Part No .	B	G	C	H	h	Camlock Studs		
													Dia.	Thread	Qty.
5"	D1-4	1.2598	1.2598	3200	11	PS3-5"A/D1-4	1-221-0504	3.2520	2.5005	.5118	2.7559	1.575	5/8	M10x1	3
6-1/4"	D1-3	1.6535	1.9685	3000	20	PS3-6"A/D1-3	1-221-0603	2.7795	2.1250	.5118	3.2087	1.693	9/16		
	D1-4					PS3-6"A/D1-4	1-221-0604	3.2520	2.5005				5/8		
8"	D1-3	2.0275	2.0275	2500	42	PS3-8"A/D1-3	1-221-0803	2.7795	2.1250	.5118	3.5827	1.772	9/16	M12x1	6
	D1-4					PS3-8"A/D1-4	1-221-0804	3.2520	2.5005				5/8		
	D1-5					PS3-8"A/D1-5	1-221-0805	4.1260	3.2505				3/4		
	D1-6					PS3-8"A/D1-6	1-221-0806	5.2520	4.1880				7/8	M16x1.5	
	D1-5					PS3-10"A/D1-5	1-221-1005	4.1260	3.2505				.5629	3/4	M12x1
10"	D1-6	2.9921	3.7402	2000	71	PS3-10"A/D1-6	1-221-1006	5.2520	4.1880	.6299	4.0748	2.087	7/8	M16x1.5	
	D1-8					PS3-10"A/D1-8	1-221-1008	6.7480	5.5007	.7087	1	M20x1.5			
	D1-6					PS3-12"A/D1-6	1-221-1206	5.2520	4.1880	.6299	4.6338	7/8	M16x1.5		
12-1/2"	D1-8	4.0551	4.5276	1500	112	PS3-12"A/D1-8	1-221-1208	6.7480	5.5007	.7087	4.6338	2.244	1	M20x1.5	
	D1-11					PS3-12"A/D1-11	1-221-1211	9.2520	7.7507	.7874	5.5118	1-3/16	M22x1.5		
	D1-6					PS3-16"A/D1-6	1-221-1606	5.2520	4.1880	.6299	7/8	M16x1.5			
15-3/4"	D1-8	5.3543	5.3543	1000	223	PS3-16"A/D1-8	1-221-1608	6.7480	5.5007	.7087	5.0591	2.639	1	M20x1.5	
	D1-11					PS3-16"A/D1-11	1-221-1611	9.2520	7.7507	.7874	1-3/16	M22x1.5			
	D1-8					PS3-20"A/D1-8	1-221-2008	6.7480	5.5007	.7087	5.6693	3.5039	1	M20x1.5	
20"	D1-11	7.5905	7.5984	700	331	PS3-20"A/D1-11	1-221-2011	9.2520	7.7507	.7874	1-3/16	M22x1.5			
	D1-11					PS3-25"AD1-11	1-221-2511	9.2520	7.7507	.7874	6.4961	3.4646	1-3/16	M22x1.5	

■ **2-Jaw Scroll Chucks with Soft Top Reversible Jaws Semi-Steel Body, Plain back**

Each chuck is provided with:

- 1 set of hard master jaws
- 1 set of soft top reversible jaws
- 1 set of mounting bolts
- 1 chuck wrench
- 2 hex keys
- 2 eye bolts with 16" chucks
- 2 pinion design



Chuck Dia.	Hole Dia.	Max.Hole Enlargements	RPM max.	Model	Part No.
6-1/4"	1.6535	1.9252	3000	PS2-6"S	1-205-0600
8"	2.1654	2.8189	2500	PS2-8"S	1-205-0800
10"	2.9921	3.5827	2000	PS2-10"S	1-205-1000
12-1/2"	4.0551	4.4882	1500	PS2-12"S	1-205-1200
15-3/4"	5.3543	5.7480	1000	PS2-16"S	1-205-1600

Dimension for 2-jaw scroll chuck please see page 23.

SPARE PART FOR PS Series Universal

2-Jaw,3-Jaw & 4-Jaw Self-Centering Scroll Chucks

Chuck Dia.	Scroll plate	Pinion	Wrench	Pinion Screw
3-1/4"	SC-PS-80	PI-PS-80	W-P-80	PH-P-80
4"	SC-PS-100	PI-PS-100	W-P-100	PH-P-100
5"	SC-PS-125	PI-PS-125	W-P-125	PH-P-125
6-1/4"	SC-PS-160	PI-PS-160	W-P-160	PH-P-160
8"	SC-PS-200	PI-PS-200	W-P-200	PH-P-200
10"	SC-PS-250	PI-PS-250	W-P-250	PH-P-250
12-3/2"	SC-PS-315	PI-PS-315	W-P-315	PH-P-315
15-3/4"	SC-PS-400	PI-PS-400	W-P-400	PH-P-400
20"	SC-PS-500	PI-PS-500	W-P-500	PH-P-500
25"	SC-PS-630	PI-PS-630	W-P-630	PH-P-630



■ Scroll Plate



■ Pinion



■ Wrench



■ Pinion Screw

SPARE PART FOR PS Series Universal 2-Jaw, 3-Jaw & 4-Jaw Self-Centering Scroll Chucks



Chuck	Hard Top Jaws			Soft Top Jaws			Hard Master Jaws		
	2-Jaw	3-Jaw	4-Jaw	2-Jaw	3-Jaw	4-Jaw	2-Jaw	3-Jaw	4-Jaw
5"	-	TJ-PS3-125	TJ-PS4-125	-	STJ-PS3-125	STJ-PS4-125	-	MJ-PS3-125	MJ-PS4-125
6-1/4"	TJ-PS2-160	TJ-PS3-160	TJ-PS4-160	STJ-PS2-160	STJ-PS3-160	STJ-PS4-160	MJ-PS2-160	MJ-PS3-160	MJ-PS4-160
8"	TJ-PS2-200	TJ-PS3-200	TJ-PS4-200	STJ-PS2-200	STJ-PS3-200	STJ-PS4-200	MJ-PS2-200	MJ-PS3-200	MJ-PS4-200
10"	TJ-PS2-250	TJ-PS3-250	TJ-PS4-250	STJ-PS2-250	STJ-PS3-250	STJ-PS4-250	MJ-PS2-250	MJ-PS3-250	MJ-PS4-250
12-1/2"	TJ-PS2-315	TJ-PS3-315	TJ-PS4-315	STJ-PS2-315	STJ-PS3-315	STJ-PS4-315	MJ-PS2-315	MJ-PS3-315	MJ-PS4-315
15-3/4"	TJ-PS2-400	TJ-PS3-400	TJ-PS4-400	STJ-PS2-400	STJ-PS3-400	STJ-PS4-400	MJ-PS2-400	MJ-PS3-400	MJ-PS4-400
20"	-	TJ-PS3-500	TJ-PS4-500	-	STJ-PS3-500	STJ-PS4-500	-	MJ-PS3-500	MJ-PS4-500
25"	-	TJ-PS3-630	TJ-PS4-630	-	STJ-PS3-630	STJ-PS4-630	-	MJ-PS3-630	MJ-PS4-630

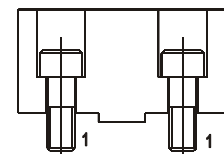
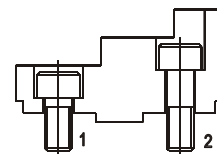


Chuck Dia.	I.D. Hard Solid Jaws			O.D. Hard Solid Jaws			Soft Solid Jaws		
	2-Jaw	3-Jaw	4-Jaw	2-Jaw	3-Jaw	4-Jaw	2-Jaw	3-Jaw	4-Jaw
3-1/4"	-	OJ-PS3-80	-	-	IJ-PS3-80	-	-	SJ-PS3-80	-
4"	-	OJ-PS3-100	-	-	IJ-PS3-100	-	-	SJ-PS3-100	-
5"	-	OJ-PS3-125	OJ-PS4-125	-	IJ-PS3-125	IJ-PS4-125	-	SJ-PS3-125	SJ-PS4-125
6-1/4"	OJ-PS2-160	OJ-PS3-160	OJ-PS4-160	IJ-PS2-160	IJ-PS3-160	IJ-PS4-160	SJ-PS2-160	SJ-PS3-160	SJ-PS4-160
8"	OJ-PS2-200	OJ-PS3-200	OJ-PS4-200	IJ-PS2-200	IJ-PS3-200	IJ-PS4-200	SJ-PS2-200	SJ-PS3-200	SJ-PS4-200
10"	OJ-PS2-250	OJ-PS3-250	OJ-PS4-250	IJ-PS2-250	IJ-PS3-250	IJ-PS4-250	SJ-PS2-250	SJ-PS3-250	SJ-PS4-250
12-1/2"	OJ-PS2-315	OJ-PS3-315	OJ-PS4-315	IJ-PS2-315	IJ-PS3-315	IJ-PS4-315	SJ-PS2-315	SJ-PS3-315	SJ-PS4-315
15-3/4"	OJ-PS2-400	OJ-PS3-400	OJ-PS4-400	IJ-PS2-400	IJ-PS3-400	IJ-PS4-400	SJ-PS2-400	SJ-PS3-400	SJ-PS4-400
20"	-	OJ-PS3-500	OJ-PS4-500	-	IJ-PS3-500	IJ-PS4-500	-	SJ-PS3-500	SJ-PS4-500
25"	-	OJ-PS3-630	OJ-PS4-630	-	IJ-PS3-630	IJ-PS4-630	-	SJ-PS3-630	SJ-PS4-630

➔ Mounting Bolts for Hard & Soft Top Jaws

■ Sold by piece.

Chuck Dia.	Thread	Screw No.1		Screw No.2	
		Short Screw		Long Screw	
		L	Part No.	L	Part No.
5"	M8		MT-J1-5	1.00	MT-J2-5
6"	M10	.79	MT-J1-6	1.18	MT-J2-6
8"			MT-J1-6		MT-J2-6
10" & 12"	M12	1.00	MT-J1-10	1.57	MT-J2-10
16"	M16	1.00	MT-J1-16	1.57	MT-J2-16
20"	M20	1.57	MT-J1-20	2.95	MT-J2-20
25"			MT-J1-20	3.15	MT-J2-25



➔ Camlock Studs

■ Sold by piece.



Taper Size	Camlock Studs			No. of Studs
	Dia.	Thread	Part No.	
D1-3	9/16"	M10 x 1	CA-D-03	3
D1-4	5/8"		CA-D-04	
D1-5	3/4"	M12 x 1	CA-D-05	6
D1-6	7/8"	M16 x 1.5	CA-D-06	
D1-8	1"	M20 x 1.5	CA-D-08	
D1-11	1-3/16"	M22 x 1.5	CA-D-11	
D1-15	1-3/8"	M24 x 1.5	CA-D-15	

➔ Type C, DIN Studs

■ Sold by piece.



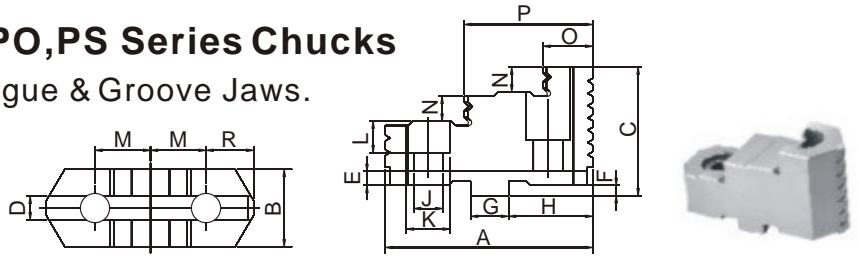
Taper Size	Stud Dia. inch	Stud Dia. mm	Thread mm	No. of Studs	Part No.
C-4	.7677	19.5	M10 - 39	3	LO-D-04
C-5	.7677	19.5	M10 - 43	4	LO-D-05
C-6	.8465	21.5	M12 - 50		LO-D-06
C-8	1.063	27.0	M16 - 60	6	LO-D-08
C-11	1.339	34.0	M20 - 75		LO-D-11

SPARE PART FOR Self-Centering Scroll Chucks

2-jaw, 3-Jaw, 4-jaw & 6-Jaw Self-Centering Scroll Chucks

Hard Top Jaws for 2,3,4 & 6 Jaw PA,PO,PS Series Chucks

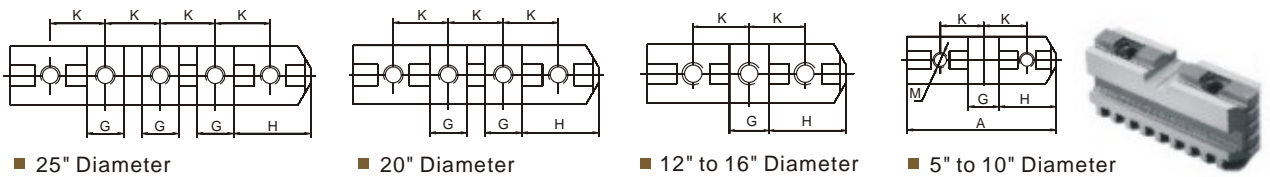
- American Standard Tongue & Groove Jaws.
- Sold in sets.



Chuck Dia.	M	H	G	J	K	D	E	F	N	C	B	OAL A	O	P	wt. of set (lbs.)		
															3 Jaw	4Jaw	6Jaw
5"	5/8	57/64	.4996	.35	.59	.3129	1.57	.1260	.315	1.516	.866	2.205	.57	1.38	0.93	1.20	1.9
6-1/4"	3/4	1-1/8		.43	.71				.335	1.634	.984	2.638	.71	1.63	1.20	1.60	2.40
8"	7/8	1-3/8		.374	1.713				1.063	3.347	.85	2.01	2.10	2.80	4.20		
10"	1-1/16	1-9/16	.7496	.55	.78	.5004		.2480	.472	2.023	1.280	3.740	.96	2.32	3.20	4.27	6.40
12-1/2"	1-1/4	1-7/8		.512	2.165				1.457	4.331	1.04	2.68	5.10	6.80	10.20		
15-3/4"	1-1/2	2-1/4		.71	1.0				.532	2.539	1.654	5.000	1.06	3.01	7.30	9.75	14.60
20"			.87	1.3	.689	2.933	1.654	1.97	3.46	14.4	19.2		28.80				
25"			.827	3.228	2.047	2.01	3.50	27.1	36.2	44.20							

Hard Top Jaws for 2,3,4 & 6 Jaw PA,PO,PS Series Chucks

- American Standard Tongue & Groove Jaws.
- Sold in sets.

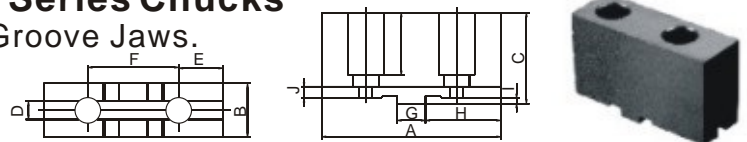


25" Diameter 20" Diameter 12" to 16" Diameter 5" to 10" Diameter

Chuck Dia.	K	H	G	F	J	S	L	D	E	B	OAL A	Thread M	wt. of set (lbs.)					
													2 Jaw	3 Jaw	4Jaw	6Jaw		
5"	5/8	57/64	.4996	5/16	.1575	.1260	.4724	.3150	.3150	.7874	2.1259	M8	-	0.93	1.24	1.9		
6-1/4"	3/4	1-1/8					.5511	.3150	.3150	.7874	2.5590	M10	.80	1.20	1.60	2.40		
8"	7/8	1-3/8					.5511	.3543	.3937	.9843	3.1102		1.40	2.10	2.80	4.20		
10"	1-1/16	1-9/16	.7496	1/2			.2835	.2480	.6299	.4331	.4724	1.1024	3.6220	M12	2.13	3.20	4.27	6.40
12-1/2"	1-1/4	1-7/8							.6299	.5000	1.2598	4.3307	3.40		5.10	6.80	10.20	
15-3/4"	1-1/2	2-1/4							.8661	.5906	1.5748	6.5351	1.4173	5.1181	M16	4.90	7.30	9.74
20"			1.2598	.6299	.5512	1.5748			6.5351	-			14.4	19.2		28.80		
25"			1.9685	8.2677	M20	-			27.1	36.2			44.20					

Soft Top Jaws for 2,3,4 & 6 Jaw PA,PO,PS Series Chucks

- American Standard Tongue & Groove Jaws.
- Sold in sets.



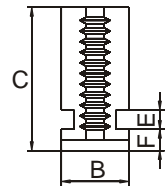
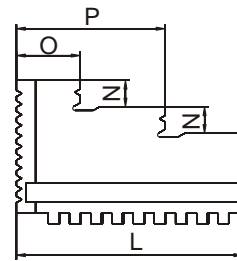
Chuck Dia.	A	3 & 4 Jaw B	2, 3 & 4 Jaw B	C	D	E	F	G	H	I	J	Bolt Size (M) 3 Jaw	wt. p/c. lbs
5"	2.520	0.866	-	1.520	.3129	0.5910	1-1/4	.500	1.000	.1260	.283	M8	.66
6-1/4"	3.071	1.000	1.575	1.634	.3129	0.8386	1-1/2	.500	1.339	.1260	.283	M10	1.01
8"	3.543	1.063	1.575	1.713	.3129	0.9488	1-3/4	.500	1.575	.1260	.283	M10	1.43
10"	4.173	1.280	1.850	2.028	.5000	1.0827	2-1/8	.750	1.772	.1260	.283	M12	2.54
12-3/2"	4.724	1.457	2.047	2.165	.5000	1.2087	2-1/2	.750	2.087	.2480	.283	M12	3.53
15-3/4"	5.512	1.654	2.047	2.539	.5000	1.3543	3	.750	2.480	.2480	.406	M16	4.85
20"	5.512	1.654	-	2.933	.5000	1.3543	3	.750	2.480	.2480	.406	M20	5.29
25"	6.299	2.047	-	3.288	.5000	1.3543	3	.750	2.480	.2480	.406	M20	9.26

➔ **I.D. Hard Solid Jaws**
 for 2,3,4 & 6 Jaw PA,PO,PS Series Scroll Chucks

■ Sold in sets.



Chuck Dia.	C	L	B	F	E	N	P	O	wt./pc. Lbs.
3-1/4"	1.1024	1.2598	.4331	.2362	.2362	.2362	0.827	.374	.10
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.19
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.313	.512	.40
6-1/4"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	.80
8"	2.1260	3.3459	.9843	.3543	.3937	.4724	2.244	.906	1.07
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	1.73
12-3/2"	2.9528	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	2.90
15-3/4"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	5.20
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	7.33
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	13.00

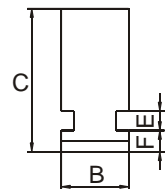
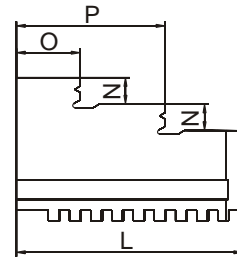


➔ **O.D. Hard Solid Jaws**
 for 2,3,4 & 6 Jaw PA,PO,PS Series Scroll Chucks

■ Sold in sets.



Chuck Dia.	C	L	B	F	E	N	P	O	wt./pc. Lbs.
3-1/4"	1.1024	1.2598	.4331	.2362	.2362	.2362	0.827	.374	.10
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.19
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.313	.512	.40
6-1/4"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	.80
8"	2.1260	3.3459	.9843	.3543	.3937	.4724	2.244	.906	1.07
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	1.73
12-3/2"	2.9528	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	2.90
15-3/4"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	5.20
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	7.33
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	13.00

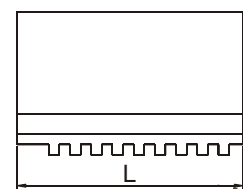
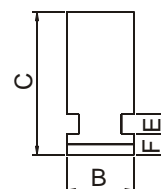


➔ **Soft Solid Jaws**
 for 2,3,4 & 6 Jaw PA,PO,PS Series Scroll Chucks

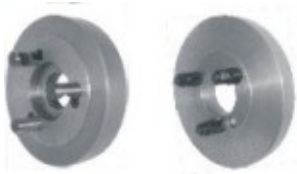
■ Sold in sets.



Chuck Dia.	C	L	B	F	E	N	P	O	wt./pc. Lbs.
3-1/4"	1.1024	1.2598	.4331	.2362	.2362	.2362	0.827	.374	.13
4"	1.2598	1.6535	.5906	.2362	.2362	.2756	1.063	.433	.29
5"	1.5748	2.0079	.7874	.3150	.3150	.3150	1.313	.512	.57
6-1/4"	2.0866	2.7559	.7874	.3150	.3150	.3937	1.772	.748	1.10
8"	2.1260	3.3459	.9843	.3543	.3937	.4724	2.244	.906	1.77
10"	2.4803	4.1339	1.1024	.4331	.4724	.5512	2.736	1.102	3.00
12-3/2"	2.9528	4.9213	1.2598	.5000	.4724	.7087	3.268	1.358	4.20
15-3/4"	3.6220	5.7087	1.4173	.5906	.5512	.8661	3.898	1.417	5.33
20"	3.9370	7.0866	1.5748	.6299	.5512	1.0236	4.705	1.969	11.00
25"	4.3307	8.8583	1.9685	.6299	.5512	1.1024	5.866	2.598	19.00



FL Series Cast-iron Adapter Semi-Machined for PO & PS Series Chuck



Type A



Type C



Type D

Chuck Dia.	Taper No	TYPE A(A1,A2) Part No .	TYPE C Part No .	TYPE D Part No .
5"	3	--	FL-125/C3	FL-125/D3
5"	4	--	FL-125/C4	FL-125/D4
6-1/4"	3	--	FL-160/C3	FL-160/D3
6-1/4"	4	--	FL-160/C4	FL-160/D4
6-1/4"	5	FL-160/A5	FL-160/C5	FL-160/D5
8"	4	FL-200/A4	FL-200/C4	FL-200/D4
8"	5	FL-200/A5	FL-200/C5	FL-200/D5
8"	6	FL-200/A6	FL-200/C6	FL-200/D6
10"	5	FL-250/A5	FL-250/C5	FL-250/D5
10"	6	FL-250/A6	FL-250/C6	FL-250/D6
10"	8	FL-250/A8	FL-250/C8	FL-250/D8
12-1/2"	6	FL-315/A6	FL-315/C6	FL-315/D6
12-1/2"	8	FL-315/A8	FL-315/C8	FL-315/D8
12-1/2"	11	FL-315/A11	FL-315/C11	FL-315/D11
15-3/4"	6	FL-400/A6	FL-400/C6	FL-400/D6
15-3/4"	8	FL-400/A8	FL-400/C8	FL-400/D8
15-3/4"	11	FL-400/A11	FL-400/C11	FL-400/D11
20"	8	FL-500/A8	FL-500/C8	FL-500/D8
20"	11	FL-500/A11	FL-500/C11	FL-500/D11
20"	15	FL-500/A15	FL-500/C15	FL-500/D15
25"	8	FL-630/A8	FL-630/C8	FL-630/D8
25"	11	FL-630/A11	FL-630/C11	FL-630/D11
25"	15	FL-630/A15	FL-630/C15	FL-630/D15



Type L



Threaded

Chuck Dia.	D	Taper Size	Thread T - UNS3	Part No.
6-1/4"	6.30	L00	3-3/4 - 6	FL-160/L00
		L0	4-1/2 - 6	FL-160/L0
8"	7.87	L00	3-3/4 - 6	FL-200/L00
		L0	4-1/2 - 6	FL-200/L0
		L1	6 - 6	FL-200/L1
10"	9.87	L00	3-3/4 - 6	FL-250/L00
		L0	4-1/2 - 6	FL-250/L0
		L1	6 - 6	FL-250/L1
12-1/2"	12.40	L0	4-1/2 - 6	FL-315/L0
		L1	6 - 6	FL-315/L1
		L2	7-3/4 - 5	FL-315/L2
15-3/4"	11.75	L1	6 - 6	FL-400/L1
		L2	7-3/4 - 5	FL-400/L2
		L3	10-3/8 - 4	FL-400/L3
20"	16.02	L2	7-3/4 - 5	FL-500/L2

Chuck Dia.	Thread d	Part No.
4"	1-10 UNS-2B	FL-100/T1
	1-1/2 - 8 UN-2B	FL-100/T2
5"	1-1/8 - 12W	FL-125/T3
	1-1/2 - 8 UN-2B	FL-125/T2
	2-3/16 - 10 Hardinge	FL-125/T4
	2-1/4 - 8 UN-2B	FL-125/T5
6-1/4"	1-1/2 - 8 UN-2B	FL-160/T2
	2-3/16 - 10 Hardinge	FL-160/T4
8"	2-1/4 - 8 UN-2B	FL-160/T5
	1-1/2 - 8 UN-2B	FL-200/T2
	2-1/4 - 8 UN-2B	FL-200/T5
10"	2-3/8 - 6 UN-2B	FL-200/T6
	2-3/8 - 6 UN-2B	FL-250/T6
12-1/2"	2-3/8 - 6 UN-2B	FL-315/T6

FLD Series Cast-iron Adapter Fully-Machined for PO & PS Series Chuck



Type A



Type C



Type D

Chuck Dia.	TaperNo	TYPE A(A1,A2) Part No .	TYPE C Part No .	TYPE D Part No .
5"	3	--	FLD-125/C3	FLD-125/D3
5"	4	--	FLD-125/C4	FLD-125/D4
6-1/4"	3	--	FLD-160/C3	FLD-160/D3
6-1/4"	4	--	FLD-160/C4	FLD-160/D4
6-1/4"	5	FLD-160/A5	FLD-160/C5	FLD-160/D5
8"	4	FLD-200/A4	FLD-200/C4	FLD-200/D4
8"	5	FLD-200/A5	FLD-200/C5	FLD-200/D5
8"	6	FLD-200/A6	FLD-200/C6	FLD-200/D6
10"	5	FLD-250/A5	FLD-250/C5	FLD-250/D5
10"	6	FLD-250/A6	FLD-250/C6	FLD-250/D6
10"	8	FLD-250/A8	FLD-250/C8	FLD-250/D8
12-1/2"	6	FLD-315/A6	FLD-315/C6	FLD-315/D6
12-1/2"	8	FLD-315/A8	FLD-315/C8	FLD-315/D8
12-1/2"	11	FLD-315/A11	FLD-315/C11	FLD-315/D11
15-3/4"	6	FLD-400/A6	FLD-400/C6	FLD-400/D6
15-3/4"	8	FLD-400/A8	FLD-400/C8	FLD-400/D8
15-3/4"	11	FLD-400/A11	FLD-400/C11	FLD-400/D11
20"	8	FLD-500/A8	FLD-500/C8	FLD-500/D8
20"	11	FLD-500/A11	FLD-500/C11	FLD-500/D11
20"	15	FLD-500/A15	FLD-500/C15	FLD-500/D15
25"	8	FLD-630/A8	FLD-630/C8	FLD-630/D8
25"	11	FLD-630/A11	FLD-630/C11	FLD-630/D11
25"	15	FLD-630/A15	FLD-630/C15	FLD-630/D15



Type L



Threaded

Chuck Dia.	D	Taper Size	Thread T - UNS3	Part No.
6-1/4"	6.30	L00	3-3/4 - 6	FLD-160/L00
		L0	4-1/2 - 6	FLD-160/L0
8"	7.87	L00	3-3/4 - 6	FLD-200/L00
		L0	4-1/2 - 6	FLD-200/L0
		L1	6 - 6	FLD-200/L1
10"	9.87	L00	3-3/4 - 6	FLD-250/L00
		L0	4-1/2 - 6	FLD-250/L0
		L1	6 - 6	FLD-250/L1
12-1/2"	12.40	L0	4-1/2 - 6	FLD-315/L0
		L1	6 - 6	FLD-315/L1
		L2	7-3/4 - 5	FLD-315/L2
15-3/4"	11.75	L1	6 - 6	FLD-400/L1
		L2	7-3/4 - 5	FLD-400/L2
		L3	10-3/8 - 4	FLD-400/L3
20"	16.02	L2	7-3/4 - 5	FLD-500/L2

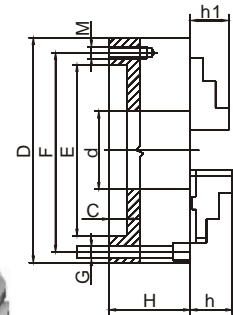
Chuck Dia.	Thread d	Part No.
4"	1-10 UNS-2B	FLD-100/T1
	1-1/2 - 8UN-2B	FLD-100/T2
5"	1-1/8 - 12W	FLD-125/T3
	1-1/2 - 8UN-2B	FLD-125/T2
	2-3/16 - 10 Hardinge	FLD-125/T4
	2-1/4 - 8UN-2B	FLD-125/T5
6-1/4"	1-1/2 - 8UN-2B	FLD-160/T2
	2-3/16 - 10 Hardinge	FLD-160/T4
8"	2-1/4 - 8UN-2B	FLD-160/T5
	1-1/2 - 8UN-2B	FLD-200/T2
	2-1/4 - 8UN-2B	FLD-200/T5
	2-3/8 - 6UN-2B	FLD-200/T6
	2-3/8 - 6UN-2B	FLD-250/T6
12-1/2"	2-3/8 - 6UN-2B	FLD-315/T6

Front Mounting Self-Centering

3 & 4 Jaw Scroll chuck

Plain Back, Forged Steel & Semi-Steel Body

- 3 & 4 Jaw Scroll Chucks with semi-steel and forged steel body are designed for use with all rotary tables and other devices where back mounting chucks cannot be used. They 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.
- Base plates are designed for use with FUERDA 3 & 4 Jaw, Front Mounting, Self-centering Lathe chuck.



Principal Dimensions

Chuck Dia.(D)	F	E(H7)	d	C	H		h	h1	Screws			
					PS	PO			Thread (G)		Qty.	Thread (M)
3-1/4"	2.6378	2.2047	0.6299	0.1181	1.732	1.732	-	0.512	1/4-20x1.97	3	M6	3
4"	3.2677	2.7559	0.7874	0.1181	1.969	1.969	-	0.669	5/16-18x2.17	3	M8	3
5"	4.2520	3.7402	1.2598	0.1575	2.205	2.422	1.575	0.787	5/16-18x2.17	3	M8	3
6-1/4"	5.5118	4.9213	1.6535	0.1575	2.559	2.756	1.693	1.260	3/8-16x2.76	3	M10	3
8"	6.9291	6.2992	2.1654	0.1575	2.953	3.150	1.772	1.142	3/8-16x3.15	3	M10	3
10"	8.8189	7.8740	2.9921	0.1969	3.347	3.543	2.087	1.339	1/2-13x3.54	3	M12	3
12-1/2"	11.2598	10.2362	4.0551	0.1969	3.701	3.937	2.244	1.693	5/8-11x3.94	3	M16	3
15-3/4"	14.2519	12.9921	5.3543	0.1969	4.134	4.331	2.639	2.165	5/8-11x4.53	3	M16	3

3-Jaw Front Mounting Scroll Chucks Plain Back, Semi-Steel Body

Chuck Dia.	2-Piece Reversible Jaws		Hard Solid Jaws	
	Model	Part No.	Model	Part No.
3-1/4"	-	-	PS3-3"(F)	1-202-0301
4"	-	-	PS3-4"(F)	1-202-0401
5"	PS3-5"A(F)	1-201-0501	PS3-5"(F)	1-202-0501
6-1/4"	PS3-6"A(F)	1-201-0601	PS3-6"(F)	1-202-0601
8"	PS3-8"A(F)	1-201-0801	PS3-8"(F)	1-202-0801
10"	PS3-10"A(F)	1-201-1001	PS3-10"(F)	1-202-1001
12-1/2"	PS3-12"A(F)	1-201-1201	PS3-12"(F)	1-202-1201
15-3/4"	PS3-16"A(F)	1-201-1601	PS3-16"(F)	1-202-1601

3-Jaw Front Mounting Scroll Chucks Plain Back, Steel Body

Chuck Dia.	2-Piece Reversible Jaws		Hard Solid Jaws	
	Model	Part No.	Model	Part No.
3-1/4"	-	-	PO3-3"(F)	1-106-0301
4"	-	-	PO3-4"(F)	1-106-0401
5"	PO3-5"A(F)	1-105-0501	PO3-5"(F)	1-106-0501
6-1/4"	PO3-6"A(F)	1-105-0601	PO3-6"(F)	1-106-0601
8"	PO3-8"A(F)	1-105-0801	PO3-8"(F)	1-106-0801
10"	PO3-10"A(F)	1-105-1001	PO3-10"(F)	1-106-1001
12-1/2"	PO3-12"A(F)	1-105-1201	PO3-12"(F)	1-106-1201
15-3/4"	PO3-16"A(F)	1-105-1601	PO3-16"(F)	1-106-1601

4-Jaw Front Mounting Scroll Chucks Plain Back, Semi-Steel Body

Chuck Dia.	2-Piece Reversible Jaws		Hard Solid Jaws	
	Model	Part No.	Model	Part No.
3-1/4"	-	-	-	-
4"	-	-	PS4-4"(F)	1-204-0401
5"	PS4-5"A(F)	1-203-0501	PS4-5"(F)	1-204-0501
6-1/4"	PS4-6"A(F)	1-203-0601	PS4-6"(F)	1-204-0601
8"	PS4-8"A(F)	1-203-0801	PS4-8"(F)	1-204-0801
10"	PS4-10"A(F)	1-203-1001	PS4-10"(F)	1-204-1001
12-1/2"	PS4-12"A(F)	1-203-1201	PS4-12"(F)	1-204-1201
15-3/4"	PS4-16"A(F)	1-203-1601	PS4-16"(F)	1-204-1601

4-Jaw Front Mounting Scroll Chucks Plain Back, Steel Body

Chuck Dia.	2-Piece Reversible Jaws		Hard Solid Jaws	
	Model	Part No.	Model	Part No.
3-1/4"	-	-	-	-
4"	-	-	PO4-4"(F)	1-108-0401
5"	PO4-5"A(F)	1-107-0501	PO4-5"(F)	1-108-0501
6-1/4"	PO4-6"A(F)	1-107-0601	PO4-6"(F)	1-108-0601
8"	PO4-8"A(F)	1-107-0801	PO4-8"(F)	1-108-0801
10"	PO4-10"A(F)	1-107-1001	PO4-10"(F)	1-108-1001
12-1/2"	PO4-12"A(F)	1-107-1201	PO4-12"(F)	1-108-1201
15-3/4"	PO4-16"A(F)	1-107-1601	PO4-16"(F)	1-108-1601