

Setrite® Self Centring Scroll Chucks

3 Jaw and 6 Jaw Versions

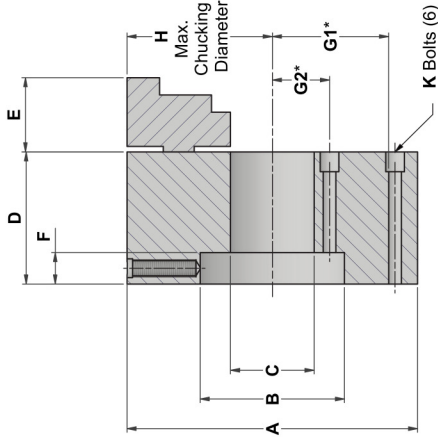
- Precision manufactured for adapter mounting
- 12µm TIR repeatability on duplicate parts
- Steel body on sizes 160mm to 380mm
- Semi-steel body on the 125mm chucks
- 4 adjusting screws - 125mm to 310mm
- 8 adjusting screws - 380mm
- Sizes 125mm to 380mm
- Nitride hardened scroll
- Hardened pinion
- Two-piece American standard tongue and groove jaws on chuck sizes 160mm to 380mm
- 125mm chucks equipped with one set of hard inside jaws and one set of hard outside jaws
- One pinion - up to 310mm
- 3 pinions - 380mm
- Durability - double the contact surface of the master jaw & body versus our competitor's chucks
- Twelve month warranty

Eccentric adjustment of chuck on mounting plate to obtain required TIR on the workpiece may result in unacceptable vibration at these speeds.

Reduce rpm's accordingly.

Jaws must be fully engaged in the chuck body.

3 Jaw



Chuck Size	Model Number	Approx. Weight (kilos)	Maximum rpm
5"/125mm	9219-01351	6	5000
6"/160mm	9219-01360	12	4900
8"/210mm	9219-01370	21	4200
10"/250mm	9219-01380	32	3300
12"/310mm	9219-01390	51	2300
15"/380mm	9219-01400	66	2000

6 Jaw

Chuck Size	Model Number	Approx. Weight (kilos)	Maximum rpm
5"/125mm	9219-01356	7	2600
6"/160mm	9219-01365	12	2500
8"/210mm	9219-01375	22	2200
10"/250mm	9219-01385	35	1900
12"/310mm	9219-01395	53	1500
15"/380mm	9219-01405	93	1300

Dimensional Data Setrite® Adapter Mounting Self-Centring Chucks

Chuck Size											Gripping Capacity	
(A)	B*	C	D	E	F	G1	G1	H	K	Min	Max	
125	60.32	33	72		16.7	112.8		127	1/4	2	100	
160	79.37	46	73	41	17.4	135.7		185	1/4	5	127	
210	120.65	57	82.5	44.5	19	190.5		235	3/8	5	165	
250	161.92	76	92	54	20.6		111.1	279	7/16	5	203	
310	200.81	103	101.6	58.7	20.6		133.3	355	1/2	19	254	
380	299.24	116	130	79.4	28.6		171.4	432	5/8	38	330	

PBI offers a full range of Mounting Plates type "D", "A", "L" and threaded plates for the Setrite® Chucks.

Mounting plates are precision machined to suit the spindle nose of your machine. For maximum accuracy of Setrite® mounting plates, mount plate on machine spindle nose, place a dial indicator on the chuck side face of the adapter close to the mounting holes, rotate the adapter and if the total indicator reading (TIR) exceeds 12µm take a light truing cut across the face of the mounting plate.

For standard spindle dimensions, see page 28.