



# STANDARD JAWS SELF CENTRING CHUCKS

## TYPE SJ

GOLD



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

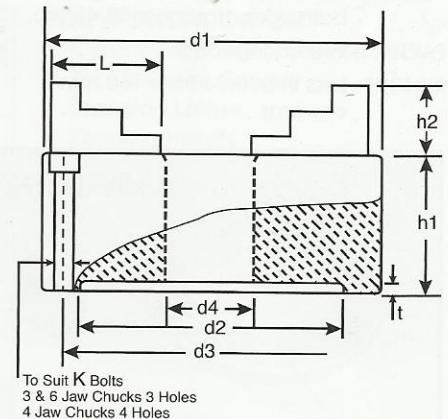
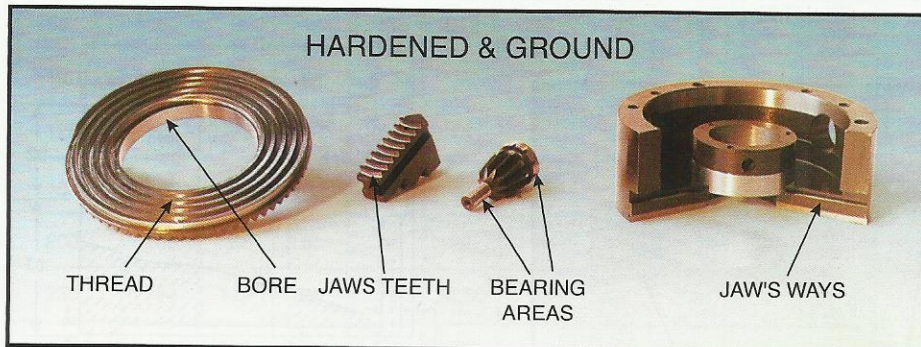
**BODY** : Jaw ways Hardened and ground.

**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 $d_1$	$d_2$ H7	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
80	56	67	$\pm 0.2$	16	44	12	3	32	M6	6	1.6	2.0	-
100	70	83	$\pm 0.25$	20	50	18	3	41	M8	8	2.5	3.0	-
125	95	108	$\pm 0.25$	33	57	21	4	48	M8	9	4.5	5.0	6.0
160	125	140	$\pm 0.3$	42	67	29	4	65	M10	10	8.0	9.0	10.0
200	160	176	$\pm 0.3$	55	75	31	4	80	M10	11	14.0	15.0	16.0
250	200	224	$\pm 0.35$	76	85	36	5	98	M12	12	27.0	28.0	30.5
315	260	286	$\pm 0.4$	107	87	36	5	118	M12	14	38.5	41.0	44.0
400	330	362	$\pm 0.4$	150	110	51	5	160	M16	17	87.0	88.0	93.0

CHUCKS WITH BACK PLATE ALSO AVAILABLE