

PO Series Precision Steel 3 Jaw & 4 Jaw Self-Centering Scroll Chucks

Forged Steel Body, High Speed

- Extremely accurate, and guaranteed to maintain this exceptional accuracy for an extended period of time.
- Chucks have a modern and compact design.
- Able to fulfill the highest demands of our customers, and are used whenever high precision machining is demanded.



■ Chuck Body

Drop forged of high grade steel, then put through precise machining operations. All bearing surfaces are carefully hardened and precisely ground.

■ Scroll Plate

Drop forged of fine quality alloy steel, and carefully case hardened. Thread flanks are ground on both sides. Each scroll is balanced.

■ Jaws

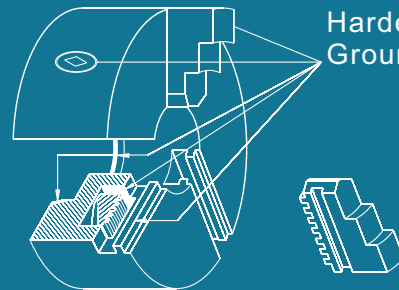
Made of fine alloy steel. Teeth and Guides hardened and fully Ground on both sides.

■ Pinions

Hardened and ground fine alloy steel.

■ Bushings

Made of fine alloy steel. Hardened and ground, then pressed into the pinion seats.



Hardened and
Ground Surfaces

■ Precision grinding of scroll plate and jaw teeth allows you to:

Eliminate the possibility of deformation as a result of heat treatment.

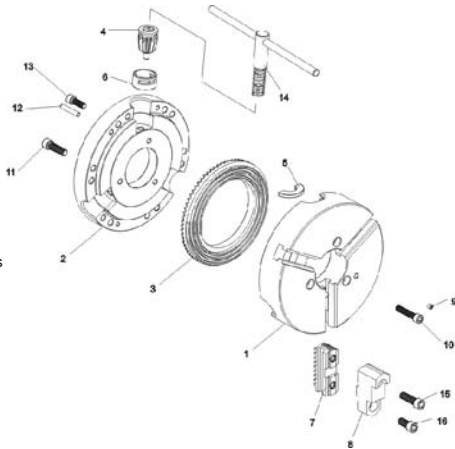
Reach uniform radial gripping force on all teeth of jaws.

Increase guarantee period for high centering accuracy.

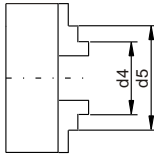
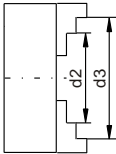
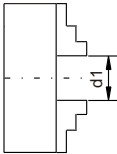


PO Series Precision Steel Body 3-Jaw & 4-Jaw Self-Centering Scroll Chucks

- 1. Chuck Body
- 2. Back Cover
- 3. Scroll Plate
- 4. Pinion
- 5. Pinion Half Ring
- 6. Pinion Sleeve
- 7. Hard Master Jaws
- 8. Hard Top Jaws
- 9. Grease Nipple
- 10. Back Cover Mounting Bolts
- 11. Chuck Mounting Bolts
- 12. Back Cover Mounting Pin
- 13. Back Cover Mounting Bolts
- 14. Chuck Wrench
- 15&16. Jaw mounting bolts



Clamping Ranges for 3 & 4 Jaw Chucks with Two-Piece Reversible Jaws & Solid Jaws



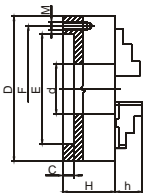
Chuck Diameter		3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Solid Jaws	d1	.08-1.06	.118-1.30	.118-1.97	.118-2.52	.157-3.54	.197-4.65	.394-5.16	-	-	-
	d2	.98-1.97	1.26-2.44	1.54-3.27	1.97-4.21	2.36-5.71	3.03-7.40	3.54-8.46	-	-	-
	d3	1.10-2.80	2.44-3.27	3.15-4.92	3.86-6.30	5.12-7.87	6.30-9.84	7.48-12.40	-	-	-
	d4	.87-1.81	.98-2.20	1.34-2.91	1.65-3.94	2.05-5.31	2.44-6.85	3.07-7.87	-	-	-
	d5	1.77-2.72	2.20-3.43	2.83-4.53	3.70-6.06	4.72-7.95	5.71-10.08	6.77-11.77	-	-	-
Two-Piece Jaws	d1	-	-	.118-1.97	.118-2.52	.157-3.54	.197-4.65	.394-5.16	.394-7.09	.787-9.25	1.18-13.19
	d2	-	-	2.05-3.78	2.44-4.76	2.83-6.14	3.39-7.76	4.06-8.90	5.00-11.57	4.33-15.75	4.72-22.44
	d3	-	-	3.74-4.92	4.53-6.30	5.24-7.87	6.30-9.84	7.48-12.40	9.06-15.75	7.48-19.69	7.87-24.80
	d4	-	-	1.34-2.99	1.65-3.81	1.97-5.12	2.28-6.50	2.56-7.17	2.84-8.98	4.72-16.14	5.51-23.23
	d5	-	-	2.95-4.65	3.46-5.75	4.13-7.48	4.92-9.25	5.71-10.43	6.50-12.95	7.87-19.09	8.27-26.18

PO Series Precision Steel Body

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

Forged Steel Body, Plain Back Chucks, Adapter Plates Required

3 & 4 Jaw Self-Centering Scroll Chucks



Principal Dimensions - Back Mounting

Chuck Dia. D	F	E	d	C	H	h	Adapter Mounting Bolts		
							Thread M	L	No. of Bolts
3-1/4"	2.6387	2.2047	0.6299	.1181	1.732	-	M8 x 1.25	0.98	3
4"	3.2677	2.7559	0.7874	.1181	1.969	-			
5"	4.2520	3.7402	1.3976	.1575	2.422	1.575	M10 x 1.5	1.18	6
6-1/4"	5.5118	4.9213	1.6535	.1575	2.756	1.693			
8"	6.9291	6.2992	2.1654	.1575	3.150	1.772	M12 x 1.75	1.57	6
10"	8.8189	7.8740	2.9921	.1969	3.543	2.087			
12-1/2"	11.2598	10.2362	4.0551	.1969	3.937	2.244	M16 x 2	1.57	6
15-3/4"	14.2519	12.9921	5.3543	.1969	4.331	2.693			
20"	18.0314	16.5354	7.4803	.1969	4.685	3.150	1"-8	5.61	6
25"	23.0709	21.4567	9.9212	.2756	5.079	3.425			
32"	14.5000	17.7170	10.5118	.7874	5.906	3.425			

3-Jaw Scroll Chuck 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 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- Forged steel body
- 3 pinion design
- eye bolts for chuck size 10" diameter and larger

Chuck Dia.	Hole Dia.	RPM max.	Model	Part No.
5"	1.3976	4800	PO3-5"A	1-105-0500
6-1/4"	1.6535	4500	PO3-6"A	1-105-0600
8"	2.1654	4000	PO3-8"A	1-105-0800
10"	2.9921	3500	PO3-10"A	1-105-1000
12-1/2"	4.0551	2800	PO3-12"A	1-105-1200
15-3/4"	5.3543	2000	PO3-16"A	1-105-1600
20"	7.480	1200	PO3-20"A	1-105-2000
25"	9.921	1000	PO3-25"A	1-105-2500
32"	10.5118	450	PO3-32"A	1-105-3200

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 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- Forged steel body
- 3 pinion design
- eye bolts for chuck sizes 10" diameter and larger

Chuck Dia.	Hole Dia.	RPM max.	Model	Part No.
3-1/4"	.6299	6000	PO3-3"	1-106-0300
4"	.7874	5200	PO3-4"	1-106-0400
5"	1.3786	4800	PO3-5"	1-106-0500
6-1/4"	1.6535	4500	PO3-6"	1-106-0600
8"	2.1654	4000	PO3-8"	1-106-0800
10"	2.9921	3500	PO3-10"	1-106-1000
12-1/2"	4.0551	2800	PO3-12"	1-106-1200
15-3/4"	5.3543	2000	PO3-16"	1-106-1600
20"	7.480	1200	PO3-20"	1-106-2000
25"	9.921	1000	PO3-25"	1-106-2500
32"	10.5118	450	PO3-32"	1-106-3200

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

- 4-Jaw Scroll Chuck with Two set of Hard Solid Jaws available.

Each chuck is provided with:

- 1 set of hard master jaws
- 1 set of hard top reversible jaws
- 1 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- Forged steel body
- 2 pinion design
- eye bolts for chuck size 10" diameter and larger

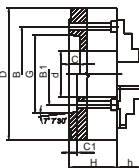
Chuck Dia.	Hole Dia.	RPM max.	Model	Part No.
5"	1.3976	4800	PO4-5"A	1-107-0500
6-1/4"	1.6535	4500	PO4-6"A	1-107-0600
8"	2.1654	4000	PO4-8"A	1-107-0800
10"	2.9921	3500	PO4-10"A	1-107-1000
12-1/2"	4.0551	2800	PO4-12"A	1-107-1200
15-3/4"	5.3543	2000	PO4-16"A	1-107-1600
20"	7.480	1200	PO4-20"A	1-107-2000
25"	9.921	1000	PO4-25"A	1-107-2500
32"	10.5118	450	PO4-32"A	1-107-3200

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

- Forged steel body.
- High speed.
- 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).



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	Screws M			
													Thread	L	Qty.	Part NO.
6-1/4"	A1-5	1.6535	4500	22	PO3-6"A/A1-5	1-115-0605	-	-	-	-	2.6772	1.693	7/16-14	2-3/8	3	BA-06-05
	A1-5	1.6535	4500	42	PO3-8"A/A1-5	1-115-0805	-	2.4374	3.2505	.563	3.0709	1.772				2-3/4
8"	A1-6	2.1653	4000	42	PO3-8"A/A1-6	1-115-0806	-	-	3.2500	4.1880	.625	-	1-2/13	3-1/8	4	BA-08-06
	A1-6	2.1653	3500	71	PO3-10"A/A1-6	1-115-1006	-	-	4.1880	.630	3.5039	2.087				2-3/4
10"	A1-8	2.9921	3500	71	PO3-10"A/A1-8	1-115-1008	-	4.3750	5.5007	.688	-	-	5/8-11	2-3/4	4	BA-10-08
	A2-6	4.0551	2800	121	PO3-12"A/A2-6	1-115-1206	5.2520	-	4.1880	.688	3.7874	2.244				4
12-1/2"	A1-8	3.1496	2800	121	PO3-12"A/A1-8	1-115-1208	-	4.3750	5.5007	.709	-	-	5/8-11	3-1/8	6	BA-12-08
	A2-8	5.3543	2000	203	PO3-16"A/A2-8	1-115-1608	6.7480	-	6.5000	7.7507	.750	4.2520				2.639
15-3/4"	A1-11	5.1181	1200	353	PO3-16"A/A1-11	1-115-1611	-	-	6.5000	7.7507	.750	-	3/4-10	4-1/2	6	BA-16-11
	A2-8	5.3543	1200	353	PO3-20"A/A2-8	1-115-2008	6.7480	-	5.5007	.709	4.6850	3.091				4-3/4
20"	A2-11	7.4803	1000	628	PO3-20"A/A2-11	1-115-2011	9.2520	-	7.7507	.787	-	-	3/4-10	5-5/16	6	BA-20-11
	A2-11	7.4803	1000	628	PO3-25"A/A2-11	1-115-2511	9.2520	-	7.7507	.750	5.0787	3.425				5-1/8
25"	A2-15	9.9213	1000	628	PO3-25"A/A2-15	1-115-2515	13.0000	-	11.251	.813	-	-	7/8-9	5-1/8	6	BA-25-15

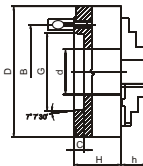
*C-C1, depth of counterbore.

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

- Forged steel body.
- High speed.



Type D1



Chuck Dia.	Taper Size	Hole Dia.(d)	RPM max.	wt. lbs.	Model	Chuck Part No .	B	G	C	H	h	Camlock Studs				
												OD	Thread	Qty.	Part No.	
6-1/4"	D1-3	1.6535	4500	20	PO3-6"D/1-3	1-125-0603	2.7795	1.2150	.5118	2.6772	1.693	9-16	M10 x 1	3	CA-D-03	
	D1-4				PO3-6"D/1-4	1-125-0604	3.2520	2.5005							5/8	CA-D-04
	D1-5				PO3-8"D/1-5	1-125-0605	4.1260	3.7505							3/4	M12 x 1
8"	D1-5	PO3-8"D/1-5	1-125-0805	4.1260	3.2505	3.0719	1.772	7/8	M16 x 1.5	4	CA-D-06					
	D1-6	PO3-8"A/D1-6	1-125-0806	5.2520	4.1880							.6299	1	M20 x 1.5	CA-D-08	
10"	D1-6	2.9921	3500	71	PO3-10"D/1-6	1-125-1006	5.2520	4.1880	3.5039	2.087	2.087	7/8	M16 x 1.5	6	CA-D-06	
	D1-8				PO3-10"A/D1-8	1-125-1008	6.7480	5.5007							.7087	1
12-1/2"	D1-6	4.0551	2800	112	PO3-12"D/1-6	1-125-1206	5.2520	4.1880	.6299	3.7874	2.244	1-3/16	M22 x 1.5	6	CA-D-06	
	D1-8				PO3-12"A/D1-8	1-125-1208	6.7480	5.5007							.7087	1
15-3/4"	D1-11	5.3543	2000	223	PO3-12"A/D1-11	1-125-1211	9.2520	7.7507	.7874	4.3976	4.3976	1-3/16	M22 x 1.5	6	CA-D-11	
	D1-8				PO3-16"A/D1-8	1-125-1608	6.7480	5.5007							.7087	1
20"	D1-11	7.5984	1200	331	PO3-16"A/D1-11	1-125-1611	9.2520	7.7507	.7874	4.6850	3.150	1-3/16	M22 x 1.5	6	CA-D-11	
	D1-8				PO3-16"A/D1-8	1-125-1608	6.7480	5.5007							.7087	1
25"	D1-8	5.3543	1000	604	PO3-20"A/D1-8	1-125-2008	6.7480	5.5007	.7087	5.0787	3.425	1-3/16	M22 x 1.5	6	CA-D-08	
	D1-11				PO3-25"A/D1-11	1-125-2511	9.2520	7.7507							.7874	1

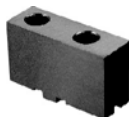
SPARE PART FOR PO Series Precision Steel Body 3-Jaw & 4-Jaw Self-Centering Scroll Chucks



■ Sold in set.



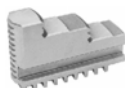
■ Sold in set.



■ Sold by piece.

Part No.	Hard Top Jaws		Hard Master Jaws		Soft Top Jaws	
	3-Jaw	4-Jaw	3-Jaw	4-Jaw	3-Jaw	4-Jaw
Chuck Dia.						
5"	TJ-PS3-125	TJ-PS4-125	MJ-PS3-125	MJ-PS4-125	STJ-PS1-125	STJ-PS1-125
6-1/4"	TJ-PS3-160	TJ-PS4-160	MJ-PS3-160	MJ-PS4-160	STJ-PS1-160	STJ-PS1-160
8"	TJ-PS3-200	TJ-PS4-200	MJ-PS3-200	MJ-PS4-200	STJ-PS1-200	STJ-PS1-200
10"	TJ-PS3-250	TJ-PS4-250	MJ-PS3-250	MJ-PS4-250	STJ-PS1-250	STJ-PS1-250
12-1/2"	TJ-PS3-315	TJ-PS4-315	MJ-PS3-315	MJ-PS4-315	STJ-PS1-315	STJ-PS1-315
15-3/4"	TJ-PS3-400	TJ-PS4-400	MJ-PS3-400	MJ-PS4-400	STJ-PS1-400	STJ-PS1-400
20"	TJ-PS3-500	TJ-PS4-500	MJ-PS3-500	MJ-PS4-500	STJ-PS1-500	STJ-PS1-500
25"	TJ-PS3-630	TJ-PS4-630	MJ-PS3-630	MJ-PS4-630	STJ-PS1-630	STJ-PS1-630
32"	TJ-PS3-800	TJ-PS4-800	MJ-PS3-800	MJ-PS4-800	STJ-PS1-800	STJ-PS1-800

■ Dimension please see page 41.



■ Sold in set.



■ Sold in set.



■ Sold in set.

Part No.	I.D. Hard Solid Jaws		O.D. Hard Solid Jaws		Soft Solid Jaws	
	3-Jaw	4-Jaw	3-Jaw	4-Jaw	3-Jaw	4-Jaw
Chuck Dia.						
3-1/4"	OJ-PS3-080	-	IJ-PS3-080	-	SJ-PS3-080	-
4"	OJ-PS3-100	OJ-PS4-125	IJ-PS3-100	IJ-PS4-100	SJ-PS3-100	SJ-PS4-100
5"	OJ-PS3-125	OJ-PS4-125	IJ-PS3-125	IJ-PS4-125	SJ-PS3-125	SJ-PS4-125
6-1/4"	OJ-PS3-160	OJ-PS4-160	IJ-PS3-160	IJ-PS4-160	SJ-PS3-160	SJ-PS4-160
8"	OJ-PS3-200	OJ-PS4-200	IJ-PS3-200	IJ-PS4-200	SJ-PS3-200	SJ-PS4-200
10"	OJ-PS3-250	OJ-PS4-250	IJ-PS3-250	IJ-PS4-250	SJ-PS3-250	SJ-PS4-250
12-1/2"	OJ-PS3-315	OJ-PS4-315	IJ-PS3-315	IJ-PS4-315	SJ-PS3-315	SJ-PS4-315
15-3/4"	OJ-PS3-400	OJ-PS4-400	IJ-PS3-400	IJ-PS4-400	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
32"	OJ-PS3-800	OJ-PS4-800	IJ-PS3-800	IJ-PS4-800	SJ-PS3-800	SJ-PS4-800

■ Dimension please see page 42.



Part No. ■ Sold by piece.

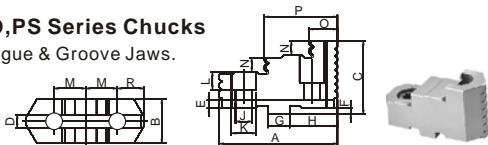
Chuck Dia.	Scroll Plate	Pinion	Wrench	Pinion Sleeve	Half Ring
3-1/4"	SC-PS-080	PI-PS-080	W-P-080	-	-
4"	SC-PS-100	PI-PS-100	W-P-125	-	-
5"	SC-PS-125	PI-PO-125	W-P-125	PS-P-125	HR-P-125
6-1/4"	SC-PS-160	PI-PO-160	W-P-200	PS-P-160	HR-P-160
8"	SC-PS-200	PI-PO-200	W-P-200	PS-P-200	HR-P-200
10"	SC-PS-250	PI-PO-250	W-P-315	PS-P-250	HR-P-250
12-3/2"	SC-PS-315	PI-PO-315	W-P-315	PS-P-315	HR-P-315
15-3/4"	SC-PS-400	PI-PO-400	W-P-400	PS-P-400	HR-P-400
20"	SC-PS-500	PI-PO-500	W-P-630	PS-P-500	HR-P-500
25"	SC-PS-630	PI-PO-630	W-P-630	PS-P-630	HR-P-630
32"	SC-PS-800	PI-PO-800	W-P-800	PS-P-800	HR-P-800

SPARE PART FOR Self-Centering Scroll Chucks

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

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

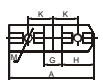
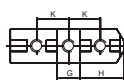
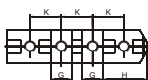
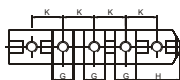
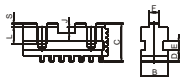
- American Standard Tongue & Groove Jaws.
- Sold in sets.



Chuck Dia.	M	H	G	J	K	D	E	F	N	C	B	OAL A	O	P	3 Jaw	4Jaw	6Jaw
															wt. of set (lbs.)		
5"	5/8	57/64		.35	.59				.315	1.516	.866	2.205	.57	1.38	0.93	1.20	1.9
6-1/4"	3/4	1-1/8	.4996			.3129			.335	1.634	.984	2.638	.71	1.63	1.20	1.60	2.40
8"	7/8	1-3/8		.43	.71				.374	1.713	1.063	3.347	.85	2.01	2.10	2.80	4.20
10"	1-1/16	1-9/16		.55	.78		1.57		.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"			.7496	.71	1.0	.5004		2.480	.532	2.539	1.654		1.06	3.01	7.30	9.75	14.60
20"	1-1/2	2-1/4		.87	1.3				.689	2.933	2.047	5.000	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 Master Jaws for 2,3,4 & 6 Jaw PA,PO,PS Series Chucks

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



■ 25" Diameter

■ 20" Diameter

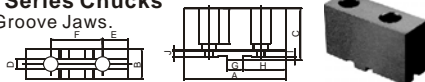
■ 12" to 16" Diameter

■ 5" to 10" Diameter

Chuck Dia.	K	H	G	F	J	S	L	D	E	B	OAL A	Thread M	2 Jaw	3 Jaw	4Jaw	6Jaw		
													wt. of set (lbs.)					
5"	5/8	57/64										5/16-8	-	0.93	1.24	1.9		
6-1/4"	3/4	1-1/8	.4996	5/16					.4724	.3150	.3150	.7874	2.1259	.80	1.20	1.60	2.40	
8"	7/8	1-3/8			.1575	.1260			.5511	.3543	.3937	.9843	3.1102	3/8-16	1.40	2.10	2.80	4.20
10"	1-1/16	1-9/16							.6299	.4331		1.1024	3.6220		2.13	3.20	4.27	6.40
12-1/2"	1-1/4	1-7/8							.6299	.5000	.4724	1.2598	4.3307	1/2-13	3.40	5.10	6.80	10.20
15-3/4"			.7496	1/2					.8661	.5906		1.4173	5.1181	5/8-11	4.90	7.30	9.74	14.60
20"	1-1/2	2-1/4			.2835	.2480			.5512			1.5748	6.5351		-	14.4	19.2	28.80
25"									1.2598	.6299		1.9685	8.2677	3/4-10	-	27.1	36.2	44.20

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

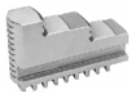
- American Standard Tongue & Groove Jaws.
- Sold by piece.



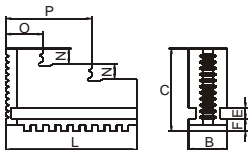
Chuck Dia.	A	3 & 4 Jaw B	2, 3 & 4 Jaw B	C	D	E	F	G	H	I	J	Bolt Size (M) 3 Jaw	wt.p/c. lbs
5"	2.520	0.866	-	1.520	.3129	0.5910	1-1/4	.500	1.000	.1260	.283	5/16-18	0.66
6-1/4"	3.071	1.000	1.575	1.634	.3129	0.8386	1-1/2	.500	1.339	.1260	.283	3/8-16	1.01
8"	3.543	1.063	1.575	1.713	.3129	0.9488	1-3/4	.500	1.575	.1260	.283	3/8-16	1.43
10"	4.173	1.280	1.850	2.028	.5000	1.0827	2-1/8	.750	1.772	.1260	.283	1/2-13	2.54
12-1/2"	4.724	1.575	2.047	2.165	.5000	1.2087	2-1/2	.750	2.087	.2480	.283	1/2-13	3.53
15-3/4"	5.512	1.654	2.047	2.539	.5000	1.3543	3	.750	2.480	.2480	.406	5/8-11	4.85
20"	5.512	1.969	-	2.933	.5000	1.3543	3	.750	2.480	.2480	.406	3/4-10	5.29
25"	6.299	2.047	-	3.288	.5000	1.3543	3	.750	2.480	.2480	.406	3/4-10	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
12-1/2"	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

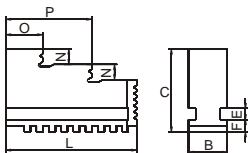


➔ **O.D. Hard Solid Jaws**
for 2,3,4 & 6 Jaw PA,PO,PS Series Scroll Chucks

- 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
12-1/2"	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

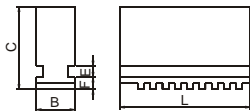


➔ **Soft Solid Jaws**
for 2,3,4 & 6 Jaw PA,PO,PS Series Scroll Chucks

- 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
12-1/2"	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 Chucks



Type A



Type C



Type D

Chuck Dia.	Taper No	D	TYPE A (A1, A2) Part No.	TYPE C Part No.	TYPE D Part No.
5"	3	4.92	--	FL-125/C3	FL-125/D3
5"	4	4.92	--	FL-125/C4	FL-125/D4
6-1/4"	3	6.30	--	FL-160/C3	FL-160/D3
6-1/4"	4	6.30	--	FL-160/C4	FL-160/D4
6-1/4"	5	6.30	FL-160/A5	FL-160/C5	FL-160/D5
8"	4	7.87	FL-200/A4	FL-200/C4	FL-200/D4
8"	5	7.87	FL-200/A5	FL-200/C5	FL-200/D5
8"	6	7.87	FL-200/A6	FL-200/C6	FL-200/D6
10"	5	9.87	FL-250/A5	FL-250/C5	FL-250/D5
10"	6	9.87	FL-250/A6	FL-250/C6	FL-250/D6
10"	8	9.87	FL-250/A8	FL-250/C8	FL-250/D8
12-1/2"	6	12.40	FL-315/A6	FL-315/C6	FL-315/D6
12-1/2"	8	12.40	FL-315/A8	FL-315/C8	FL-315/D8
12-1/2"	11	12.40	FL-315/A11	FL-315/C11	FL-315/D11
15-3/4"	6	15.83	FL-400/A6	FL-400/C6	FL-400/D6
15-3/4"	8	15.83	FL-400/A8	FL-400/C8	FL-400/D8
15-3/4"	11	15.83	FL-400/A11	FL-400/C11	FL-400/D11
20"	8	19.80	FL-500/A8	FL-500/C8	FL-500/D8
20"	11	19.80	FL-500/A11	FL-500/C11	FL-500/D11
20"	15	19.80	FL-500/A15	FL-500/C15	FL-500/D15
25"	8	24.80	FL-630/A8	FL-630/C8	FL-630/D8
25"	11	24.80	FL-630/A11	FL-630/C11	FL-630/D11
25"	15	24.80	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
		L00	3-3/4 - 6	FL-200/L00
8"	7.87	L0	4-1/2 - 6	FL-200/L0
		L1	6 - 6	FL-200/L1
		L00	3-3/4 - 6	FL-250/L00
10"	9.87	L0	4-1/2 - 6	FL-250/L0
		L1	6 - 6	FL-250/L1
		L0	4-1/2 - 6	FL-315/L0
12-1/2"	12.40	L1	6 - 6	FL-315/L1
		L2	7-3/4 - 5	FL-315/L2
		L1	6 - 6	FL-400/L1
15-3/4"	15.83	L2	7-3/4 - 5	FL-400/L2
		L3	10-3/8 - 4	FL-400/L3
		L2	7-3/4 - 5	FL-500/L2

Chuck Dia.	D	Thread d	Part No.
4"	3.94	1-10 UNS-2B	FL-100/T1
		1-1/2 - 8 UN-2B	FL-100/T2
		1-1/8 - 12W	FL-125/T3
5"	4.92	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"	6.30	1-1/2 - 8 UN-2B	FL-160/T2
		2-3/16 - 10 Hardinge	FL-160/T4
		2-1/4 - 8 UN-2B	FL-160/T5
8"	7.87	1-1/2 - 8 UN-2B	FL-200/T2
		2-1/4 - 8 UN-2B	FL-200/T5
		2-3/8 - 6 UN-2B	FL-200/T6
10"	9.87	2-3/8 - 6 UN-2B	FL-250/T6
12-1/2"	12.40	2-3/8 - 6 UN-2B	FL-315/T6

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

Adapter Plate



Type A



Type C



Type D

Chuck Dia.	Taper No	D	TYPE A (A1,A2) Part No.	TYPE C Part No.	TYPE D Part No.
5"	3	4.92	--	FLD-125/C3	FLD-125/D3
5"	4	4.92	--	FLD-125/C4	FLD-125/D4
6-1/4"	3	6.30	--	FLD-160/C3	FLD-160/D3
6-1/4"	4	6.30	--	FLD-160/C4	FLD-160/D4
6-1/4"	5	6.30	FLD-160/A5	FLD-160/C5	FLD-160/D5
8"	4	7.87	FLD-200/A4	FLD-200/C4	FLD-200/D4
8"	5	7.87	FLD-200/A5	FLD-200/C5	FLD-200/D5
8"	6	7.87	FLD-200/A6	FLD-200/C6	FLD-200/D6
10"	5	9.87	FLD-250/A5	FLD-250/C5	FLD-250/D5
10"	6	9.87	FLD-250/A6	FLD-250/C6	FLD-250/D6
10"	8	9.87	FLD-250/A8	FLD-250/C8	FLD-250/D8
12-1/2"	6	12.40	FLD-315/A6	FLD-315/C6	FLD-315/D6
12-1/2"	8	12.40	FLD-315/A8	FLD-315/C8	FLD-315/D8
12-1/2"	11	12.40	FLD-315/A11	FLD-315/C11	FLD-315/D11
15-3/4"	6	15.83	FLD-400/A6	FLD-400/C6	FLD-400/D6
15-3/4"	8	15.83	FLD-400/A8	FLD-400/C8	FLD-400/D8
15-3/4"	11	15.83	FLD-400/A11	FLD-400/C11	FLD-400/D11
20"	8	19.80	FLD-500/A8	FLD-500/C8	FLD-500/D8
20"	11	19.80	FLD-500/A11	FLD-500/C11	FLD-500/D11
20"	15	19.80	FLD-500/A15	FLD-500/C15	FLD-500/D15
25"	8	24.80	FLD-630/A8	FLD-630/C8	FLD-630/D8
25"	11	24.80	FLD-630/A11	FLD-630/C11	FLD-630/D11
25"	15	24.80	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"	15.83	L1	6 - 6	FLD-400/L1
		L2	7-3/4 - 5	FLD-400/L2
		L3	10-3/8 - 4	FLD-400/L3
20"	19.80	L2	7-3/4 - 5	FLD-500/L2

Chuck Dia.	D	Thread d	Part No.
4"	3.94	1-10 UNS-2B	FLD-100/T1
		1-1/2 - 8 UN-2B	FLD-100/T2
5"	4.92	1-1/8 - 12W	FLD-125/T3
		1-1/2 - 8 UN-2B	FLD-125/T2
		2-3/16 - 10 Hardinge	FLD-125/T4
		2-1/4 - 8 UN-2B	FLD-125/T5
		1-1/2 - 8 UN-2B	FLD-160/T2
6-1/4"	6.30	2-3/16 - 10 Hardinge	FLD-160/T4
		2-1/4 - 8 UN-2B	FLD-160/T5
		1-1/2 - 8 UN-2B	FLD-200/T2
8"	7.87	2-1/4 - 8 UN-2B	FLD-200/T5
		2-3/8 - 6 UN-2B	FLD-200/T6
		2-3/8 - 6 UN-2B	FLD-250/T6
10"	9.87	2-3/8 - 6 UN-2B	FLD-250/T6
12-1/2"	12.40	2-3/8 - 6 UN-2B	FLD-315/T6