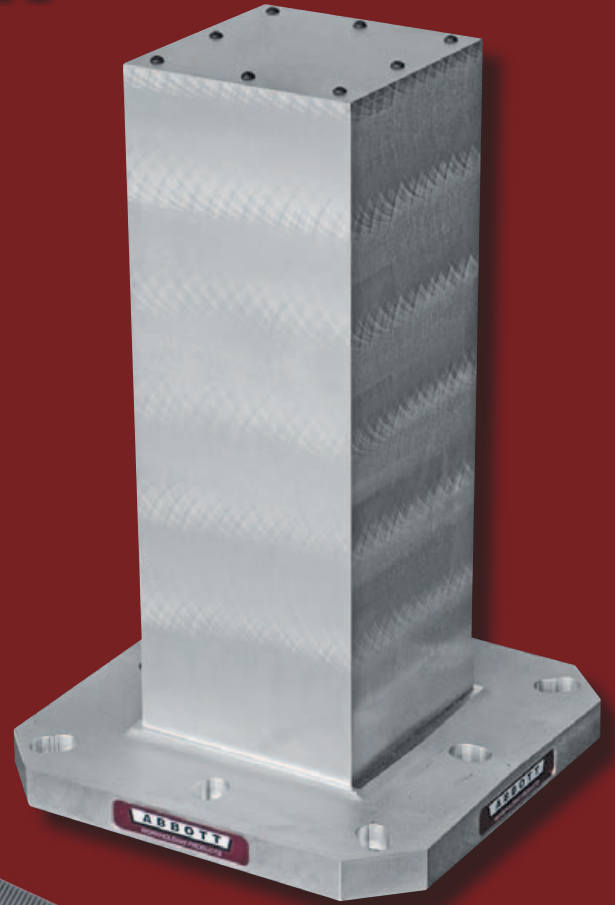
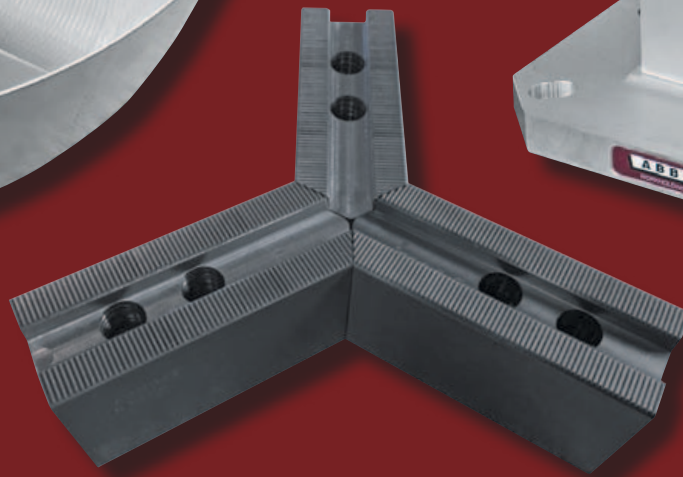
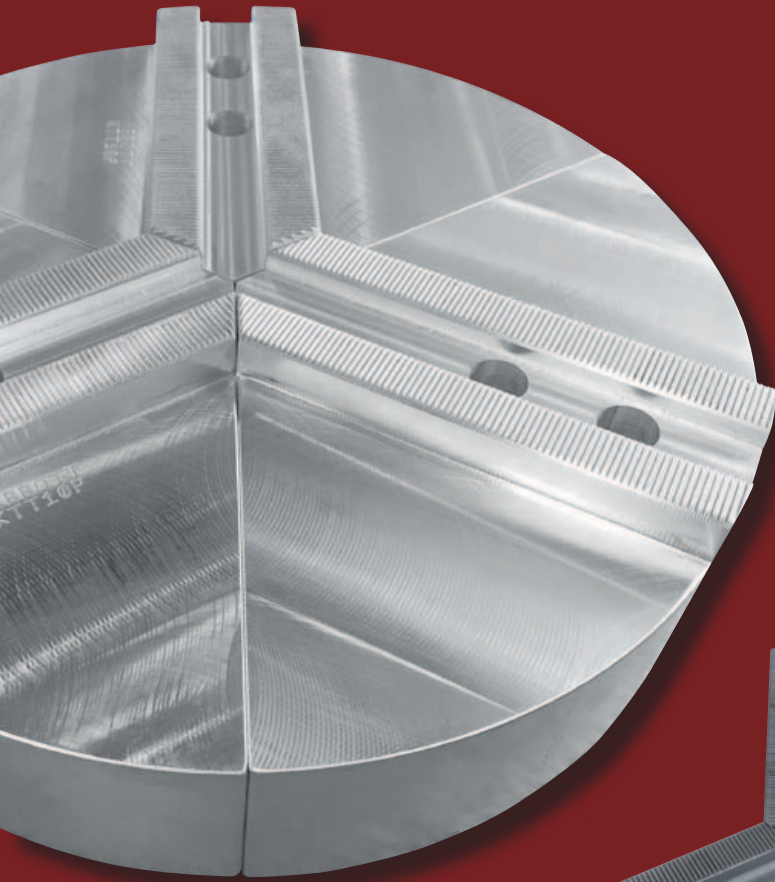


# ABBOTT

## WORKHOLDING PRODUCTS

### METRIC CATALOG



**SOFT JAWS**

**PIE JAWS®**

**MASTER PLATES**

**TOOLING COLUMNS**

785.776.8555 • 800.528.6459 • Fax 785.587.0004

[www.abbottworkholding.com](http://www.abbottworkholding.com)



Made in U.S.A.  
Since 1954

## Company History

### *Proud of the Past, Prepared for the Future*

**I**n 1954, Abbott Engineering and Manufacturing Co. began producing soft jaws and specialized tooling on a sub-contract basis in Phoenix, AZ. The business initially consisted of one employee operating out of a rented Quonset hut, but quickly matured into a dynamic, profitable corporation.

In 1955, Abbott built the nation's first Pie Jaw® brand chuck jaw. This new type of jaw eliminated the problems inherent in rectangular jaws. Drawing on their experience and expertise, Abbott began testing their concept thoroughly. The prototype set consisted of three aluminum circular segmented jaws that were machined out of an aluminum billet. Shortly after that, the first order was placed for the new, innovative product.

Spurred on by cost-cutting techniques, an expanding product line and rapidly increasing acceptance of its Pie Jaw® innovation, Abbott emerged into national prominence in the early 1960s. By 1968 the company

name had changed to Abbott Aluminum Chuck Jaws, a division of How-Mil Enterprises, Inc. With the advent of CNC machines, the product line was further expanded to include tooling columns, tooling blocks, master plates and segments, angle plates and parallels.

In early 1990, Carl Reed joined Abbott Aluminum Chuck Jaws as President and Chief Executive Officer. Since then, many changes have taken place within Abbott, resulting in dramatic improvements in the quality, availability and affordability of an expanded line of products. However, the biggest change occurred in August 1993.

After 40 years of operating a business in Phoenix, Arizona, Abbott Aluminum elected to move its entire operation to Manhattan, Kansas. In concert with the relocation, Abbott further expanded its line of workholding products to include an extensive inventory of steel and aluminum straight jaws, cast iron and steel Pie Jaws® and a very comprehensive inventory of aluminum tooling columns, sub-plates and associated fixturing.

As a direct result of the increased manufacturing capabilities, Abbott changed its name to Abbott Workholding Products, which more accurately described the multiple product lines being manufactured in the 37,000 square foot Kansas facility.

Abbott is the originator of and industry leader in aluminum chuck jaws and other lightweight products. We use certified (99.8%) pure aluminum in our hammers to avoid material contaminations when utilized on exotic high-temperature metals. Abbott Pie Jaw® brand chuck jaws are made of 6061 T-6 or 319 cast





aluminum. All tooling columns (CNC tombstones) are made of 713 (Tenzaloy™) aged to T-6 condition.

As significant as any other single technological advancement in precision toolmaking, our revolutionary Pie Jaw® brand chuck jaws technology has benefited manufacturers in a host of industries by enabling them to drastically increase their productivity, quality and profits while reducing production costs. Pie Jaws® can be used in place of rectangular jaws in more than 75% of all machine tool applications. In most cases, manufacturers quickly realize the many inherent benefits they offer.

1. Concentricities and close tolerances are easily and consistently maintained.  
Production quality standards are significantly improved.
2. Gripping and holding of material is positive and effective without distorting thin-walled materials.
3. Machine and tool life are drastically extended due to more effective application of coolants.
4. Substantially lighter-weight jaws enhance operation utilization and shop efficiency.

Today, Abbott manufactures more than 4,000 aluminum, steel and cast iron straight and Pie Jaw® brand chuck jaws, as well as master plates, segments, tooling columns, sub plates, and a variety of accessories. The significant weight and cost advantages of aluminum tooling columns and fixtures have necessitated the emergence of the product line for Abbott with over 120 different sizes and configurations currently in production. Skilled technicians allow Abbott to service requests for special orders that require precise customer specifications. Currently, Abbott's products are achieving greater industry acceptance than ever before. We have established customers all across North America as well as internationally. With more than \$4 million in inventory, Abbott can provide fast, reliable, overnight delivery to most U.S. and international cities.

It is the dawn of a new era at Abbott Workholding Products. We are extremely proud of our

past accomplishments and industry heritage. We will continue to provide the guaranteed quality products and personalized service that have helped us earn our enviable reputation as the industry leader for over 60 years.

Although we view our yesterdays as stepping stones to tomorrow, Abbott is preparing for the future today by adding technologically advanced equipment and expanding our production facilities. What's more, we intend to create new products and opportunities that capitalize on our extensive Workholding experience, expertise and manufacturing capabilities.

However, while achieving our new milestones, one thing will never change—Abbott's unwavering commitment to develop more effective ways to increase your productivity and profitability.

Pie Jaw® is a registered trademark of Abbott Aluminum Inc.  
Tenzaloy™ is a registered trademark of Federated Metals Div., American Smelting and Refining Co.

**LIGHTWEIGHT chuck jaws**

IMPROVED QUALITY AND increased speed in lathe operations are moneysaving reasons for the use of aluminum chuck jaws developed by Abbott Engineering & Manufacturing Co., P. O. Box 10301, Phoenix, Ariz.

The Abbott chuck jaws, machined from Alcoa aluminum bar stock, minimize the possibility of scratching or marking parts being lathed. In addition, the company has found that they have as much as five times the grip of comparable steel chucks.

Because of aluminum's light weight, wear on spindle bearings is cut down, in turn permitting fast spindle speeds and feeds. Other advantages of the aluminum chucks include ease in handling and quick "set-up" time.

Abbott's line of chuck jaws and chuck pot fixtures covers practically any need in secondary machine operations.

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## Chuck Reference

Chuck	Jaw Interface Type	Style(s) Soft / Pie
ATS	1/16" x 90° Serrated 3/32" x 90° Serrated	J/K J/K
ATLAS	Am. Std. Tongue & Groove	A/D
AUTO-STRONG	1.5mm x 60° Serrated 3mm x 60° Serrated Am. Std. Tongue & Groove	P/Q H/S A/D
BISON/ BERGMAN	Am. Std. Tongue & Groove	A/D
BTC	1.5mm x 60° Serrated	P/Q
BUCK	Am. Std. Tongue & Groove Square Serrated Key	A/D B/E
BULLARD	Bullard Style	C/W
CADILLAC	Am. Std. Tongue & Groove	A/D
CUSHMAN	Am. Std. Tongue & Groove Acme Serrated Key	A/D C/L
ERICSON	1/16" x 90° Serrated	J/K
FORKARDT	1/16" x 90° Serrated 3/32" x 90° Serrated Metric Tongue & Groove	J/K J/K A/D
FUJI	3mm x 60° Serrated	H/S
GAMET	1/16" x 90° Serrated	J/K
GISHOLT	Square Serrated Key	B/E
HARDINGE	1.5mm x 60° Serrated 1/16" x 90° Serrated	P/Q J/K
HOWA	1.5mm x 60° Serrated 3mm x 60° Serrated 1/16" x 90° Serrated Acme Serrated Key	P/Q H/S J/K C/L
HURON	Am. Std. Tongue & Groove	A/D
KITAGAWA	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S
LMC	1.5mm x 60° Serrated 3mm x 60° Serrated Am. Std. Tongue & Groove Acme Serrated Key Square Serrated Key	P/Q H/S A/D C/L B/E
MATSUMOTO	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S

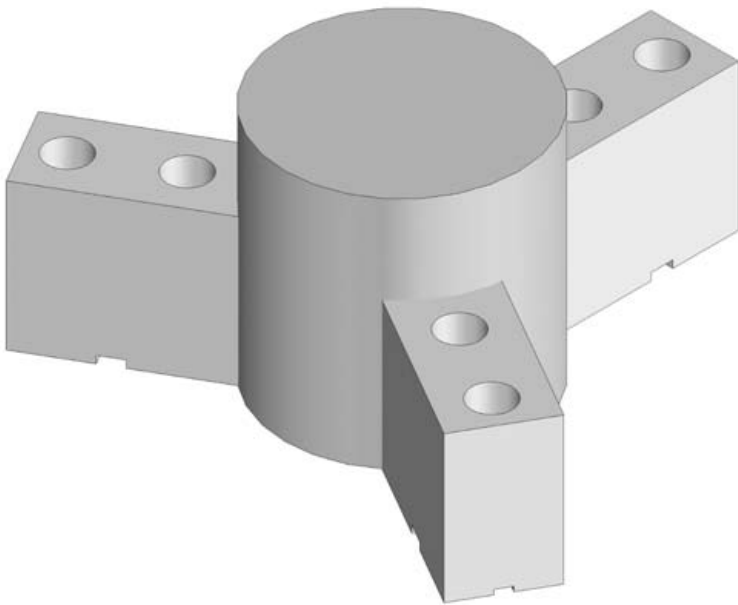
Chuck	Jaw Interface Type	Style(s) Soft / Pie
MICROCENTRIC	Pin Locator	R/M
MMK	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S
NIKKO	1.5 mm x 60° Serrated	P/Q
NOBEL	Am. Std. Tongue & Groove	A/D
NORTHFIELD	Pin Locator	R/M
POWERHOLD	1/16" x 90° Serrated	J/K
PRATT BURNERD	1.5mm x 60° Serrated Am. Std. Tongue & Groove Acme Serrated Key	P/Q A/D C/L
ROHM	1/16" x 90° Serrated 3/32" x 90° Serrated Am. Std. Tongue & Groove Metric Tongue & Groove	J/K J/K A/D A/D
SAMCHULLY	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S
SCA	Am. Std. Tongue & Groove	A/D
SEOAM	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S
S-P	Am. Std. Tongue & Groove Square Serrated Key	A/D B/E
SCHUNK	1.5mm x 60° Serrated 3mm x 60° Serrated 1/16" x 90° Serrated 3/32" x 90° Serrated Metric Tongue & Groove	P/Q H/S J/K J/K A/D
SEIKI	1.5mm x 60° Serrated 3mm x 60° Serrated	P/Q H/S
SKINNER	Am. Std. Tongue & Groove	A/D
SMW AUTOBLOK	1.5mm x 60° Serrated 1/16" x 90° Serrated 3/32" x 90° Serrated Am. Std. Tongue & Groove Metric Tongue & Groove	P/Q J/K J/K A/D A/D
WARNER/ SWASEY	Am. Std. Tongue & Groove Square Serrated Key	A/D B/E
YUASA	Am. Std. Tongue & Groove	A/D

## Pie Jaw® Advantages

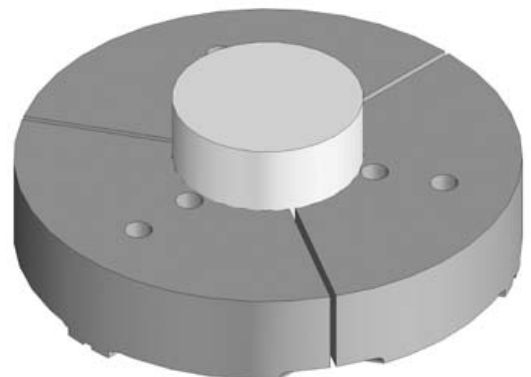
Abbott Workholding Products invented the lightweight aluminum Pie Jaw®.

*The Abbott Pie Jaw® offers you the ability to make more accurate parts faster than you ever have before.*

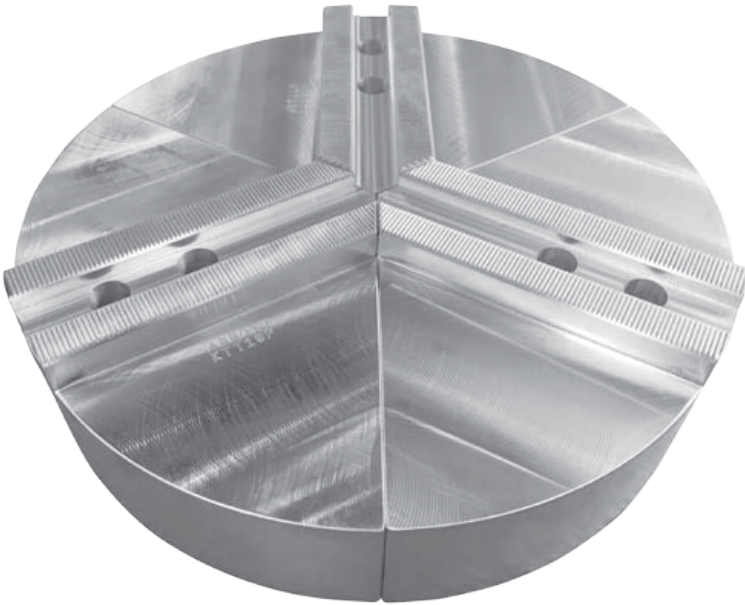
**T**he Abbott Pie Jaw® maintains 360 degrees of contact, so parts cannot deform, giving you a greater degree of accuracy. Our Pie Jaws® are designed to grip the part more effectively without distorting thin walled or odd-shaped parts.



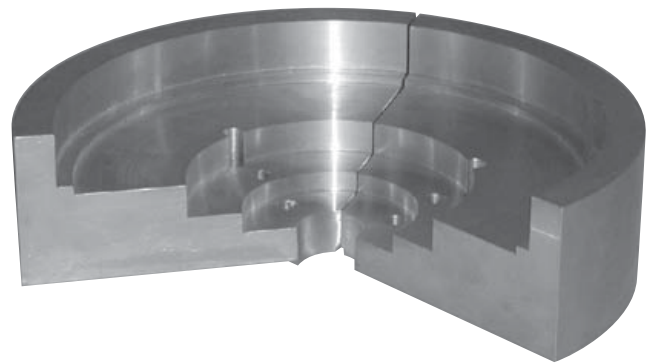
Standard soft jaws keep only three points of contact around the part. Constant chuck pressure could damage the part and at high rotations the part could deform between the contact points. Additionally, traditional soft jaws cannot be utilized on thin walled or odd-shaped parts without modification .





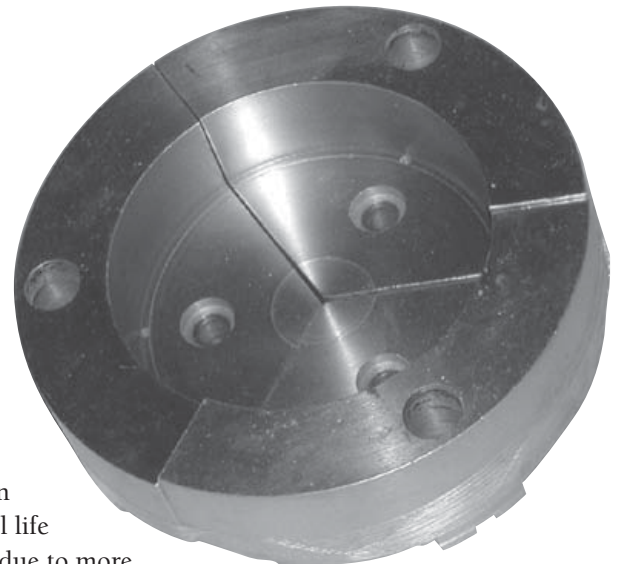


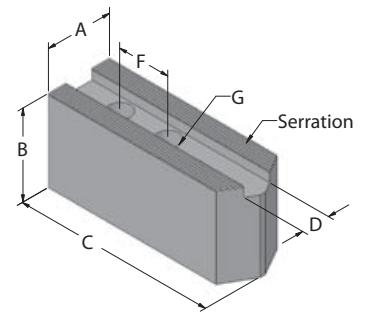
Most of our Pie Jaws® are made from aerospace aluminum alloys. The light weight of the aluminum Pie Jaws® enables you to rotate your chuck faster than before, so you can turn parts faster with less wear and tear on your machine. Substantially lighter weight jaws enhance operation utilization and shop efficiency.



Concentricities and close tolerances are easily and consistently maintained. In addition, machine and tool life are significantly extended due to more effective application of coolants.

In fact, Pie Jaws® can be used in over three-quarters of all your turning operations.





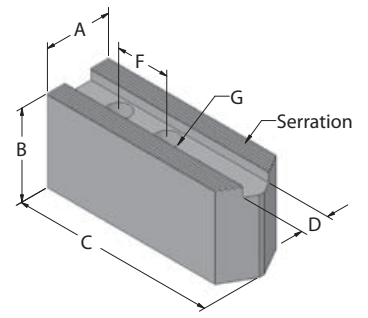
## 1.5mm X 60° Serrated Soft Jaws — Style P

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE	
100	KTT4A	KTT4S	25.4	25.4	50.8	8.0	15.0	M6	
	KW4A	KW4S	25.4	38.1	50.8	10.0	14.0	M8	
	KW4A1	KW4S1	25.4	76.2	50.8	10.0	14.0	M8	
125	KTT5A	KTT5S	25.4	38.1	63.5	10.0	18.0	M8	
	KTT5A1	KTT5S1	25.4	76.2	63.5	10.0	18.0	M8	
	HOW5A	HOW5S	25.4	38.1	63.5	10.0	19.0	M8	
	HOW5A1	HOW5S1	25.4	76.2	63.5	10.0	19.0	M8	
	SUG5ASTS	SUG5SSTS	25.4	38.1	63.5	11.0	17.0	M8	
165	HOW6A	HOW6S	31.8	38.1	76.2	11.0	20.0	M10	
	HOW6A1	HOW6S1	31.8	76.2	76.2	11.0	20.0	M10	
	SUG6ASTS	SUG6SSTS	31.8	38.1	76.2	11.0	25.0	M8	
	SUG6A1STS	SUG6S1STS	31.8	50.8	76.2	11.0	25.0	M8	
	SUG6A2STS	SUG6S2STS	31.8	76.2	76.2	11.0	25.0	M8	
	KTT6A	KTT6S	31.8	38.1	76.2	12.0	20.0	M10	
	KTT6ASQ	KTT6SSQ	31.8	38.1	76.2	12.0	20.0	M10	
	KTT6A1	KTT6S1	31.8	50.8	76.2	12.0	20.0	M10	
	KTT6A1SQ	KTT6S1SQ	31.8	50.8	76.2	12.0	20.0	M10	
	KTT6A2	KTT6S2	31.8	76.2	76.2	12.0	20.0	M10	
	KTT6A2SQ	KTT6S2SQ	31.8	76.2	76.2	12.0	20.0	M10	
	KTT6A4	KTT6S4	31.8	101.6	76.2	12.0	20.0	M10	
	210	KTT8A	KTT8S	38.1	50.8	101.6	14.0	25.0	M12
KTT8ASQ		KTT8SSQ	38.1	50.8	101.6	14.0	25.0	M12	
KTT8A1		KTT8S1	38.1	76.2	101.6	14.0	25.0	M12	
KTT8A1SQ		KTT8S1SQ	38.1	76.2	101.6	14.0	25.0	M12	
KTT8A2		KTT8S2	38.1	101.6	101.6	14.0	25.0	M12	
KTT8A2SQ		KTT8S2SQ	38.1	101.6	101.6	14.0	25.0	M12	
KTT8A6		KTT8S6	38.1	152.4	101.6	14.0	25.0	M12	
SUG8ASTS		SUG8SSTS	38.1	50.8	101.6	14.0	30.0	M10	
SUG8A1STS		SUG8S1STS	38.1	76.2	101.6	14.0	30.0	M10	
HOW27M88A		HOW27M88S	38.1	50.8	101.6	16.0	25.0	M12	
HOW27M88A1		HOW27M88S1	38.1	76.2	101.6	16.0	25.0	M12	
250		KTT10A	KTT10S	38.1	50.8	114.3	16.0	30.0	M12
		KTT10ASQ	KTT10SSQ	38.1	50.8	114.3	16.0	30.0	M12
	KTT10A1	KTT10S1	38.1	76.2	114.3	16.0	30.0	M12	
	KTT10A1SQ	KTT10S1SQ	38.1	76.2	114.3	16.0	30.0	M12	
	KTT10A3	KTT10S3	50.8	76.2	139.7	16.0	30.0	M12	
	KTT10A4	KTT10S4	38.1	101.6	114.3	16.0	30.0	M12	
	KTT10A4SQ	KTT10S4SQ	38.1	101.6	114.3	16.0	30.0	M12	
	KTT10A6	KTT10S6	38.1	152.4	114.3	16.0	30.0	M12	
	MTT10A	MTT10S	38.1	50.8	114.3	16.0	32.0	M12	
	MTT10A1	MTT10S1	38.1	76.2	114.3	16.0	32.0	M12	
	HOW27M10A	HOW27M10S	38.1	50.8	114.3	18.0	30.0	M14	
	HOW27M10A1	HOW27M10S1	38.1	76.2	114.3	18.0	30.0	M14	





## 1.5mm X 60° Serrated Soft Jaws — Style P

– continued

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE
315	KTT12A	KTT12S	50.8	50.8	139.7	18.0	30.0	M14
	KTT12ASQ	KTT12SSQ	50.8	50.8	139.7	18.0	30.0	M14
	KTT12A1	KTT12S1	50.8	76.2	139.7	18.0	30.0	M14
	KTT12A1SQ	KTT12S1SQ	50.8	76.2	139.7	18.0	30.0	M14
	KTT12A4	KTT12S4	50.8	101.6	139.7	18.0	30.0	M14
	KTT12A4SQ	KTT12S4SQ	50.8	101.6	139.7	18.0	30.0	M14
	KTT12A6	KTT12S6	50.8	152.4	139.7	18.0	30.0	M14
	SEIK112A	SEIK112S	38.1	50.8	108.0	18.0	32.0	M14
	SEIK112A1	SEIK112S1	38.1	76.2	108.0	18.0	32.0	M14
	SUG12ASTM	SUG12SSTM	50.8	50.8	139.7	20.0	35.0	M12
	KTTB212A	KTTB212S	50.8	50.8	139.7	21.0	30.0	M16
	KTTB212ASQ	KTTB212SSQ	50.8	50.8	139.7	21.0	30.0	M16
	KTTB212A1	KTTB212S1	50.8	76.2	139.7	21.0	30.0	M16
	KTTB212A1SQ	KTTB212S1SQ	50.8	76.2	139.7	21.0	30.0	M16
	KTTB212A4	KTTB212S4	50.8	101.6	139.7	21.0	30.0	M16
	KTTB212A4SQ	KTTB212S4SQ	50.8	101.6	139.7	21.0	30.0	M16
	KTTB212A6	KTTB212S6	50.8	152.4	139.7	21.0	30.0	M16
	HOW27M12A	HOW27M12S	50.8	50.8	139.7	21.0	35.0	M16
HOW27M12A1	HOW27M12S1	50.8	76.2	139.7	21.0	35.0	M16	
356	SUG14ASTG	SUG14SSTG	50.8	76.2	160.3	21.0	45.0	M16
381-457	KTT15A	KTT15S	63.5	76.2	165.1	22.0	43.0	M20
	KTT15ASQ	KTT15SSQ	63.5	76.2	165.1	22.0	43.0	M20
	KTT15A1	KTT15S1	63.5	101.6	165.1	22.0	43.0	M20
	KTT15A1SQ	KTT15S1SQ	63.5	101.6	165.1	22.0	43.0	M20
	KTT15A6	KTT15S6	63.5	152.4	165.1	22.0	43.0	M20
	KTT18A	KTT18S	63.5	76.2	190.5	22.0	43.0	M20
	KTT18A1	KTT18S1	63.5	101.6	190.5	22.0	43.0	M20
	KTTB215A	KTTB215S	63.5	76.2	165.1	25.5	43.0	M20
	KTTB215ASQ	KTTB215SSQ	63.5	76.2	165.1	25.5	43.0	M20
	KTTB215A1	KTTB215S1	63.5	101.6	165.1	25.5	43.0	M20
	KTTB215A1SQ	KTTB215S1SQ	63.5	101.6	165.1	25.5	43.0	M20
	KTTB215A6	KTTB215S6	63.5	152.4	165.1	25.5	43.0	M20
	KTTB218A	KTTB218S	63.5	76.2	190.5	25.5	43.0	M20
	KTTB218A1	KTTB218S1	63.5	101.6	190.5	25.5	43.0	M20

## 1.5mm X 60° Serrated Pie Jaws® — Style Q

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

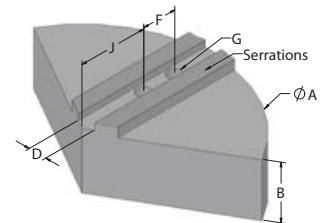
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT
100	KTT4P	152.4	50.8	8.0	15.0	M6	25.4	2.6
	KTT4P1	152.4	101.6	8.0	15.0	M6	25.4	4.9
	KW4P	152.4	50.8	10.0	14.0	M8	25.4	2.6
	KW4P1	152.4	101.6	10.0	14.0	M8	25.4	4.9
125	KTT5P	152.4	50.8	10.0	18.0	M8	28.6	2.6
	KTT5P1	152.4	101.6	10.0	18.0	M8	28.6	4.9
	HOW5P	152.4	50.8	10.0	19.0	M8	25.4	2.6
	HOW5P1	152.4	101.6	10.0	19.0	M8	25.4	4.9
	SUG5PSTS	152.4	50.8	11.0	17.0	M8	46.8	2.6
165	SUG6PSTS	152.4	50.8	11.0	25.0	M8	34.9	2.6
	SUG6P1STS	152.4	101.6	11.0	25.0	M8	34.9	4.9
	KTT6P	152.4	50.8	12.0	20.0	M10	42.1	2.6
	KTT6P3	152.4	76.2	12.0	20.0	M10	42.1	3.7
	KTT6P1	152.4	101.6	12.0	20.0	M10	42.1	4.9
	KTT86P	203.2	50.8	12.0	20.0	M10	42.1	4.6
	KTT86P1	203.2	101.6	12.0	20.0	M10	42.1	9.0
	KTT106P	254.0	50.8	12.0	20.0	M10	42.1	7.4

## 1.5mm X 60° Serrated Pie Jaws® — Style Q

— continued

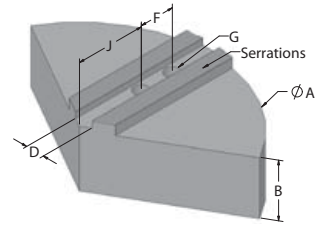
Made with 319 cast aluminum, cast iron, 1018 steel or A36 steel

Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum



Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT	
210	KTT8P	203.2	50.4	14.0	25.0	M12	58.7	4.6	
	KTT8P3	203.2	76.2	14.0	25.0	M12	58.7	6.7	
	KTT8P1	203.2	101.6	14.0	25.0	M12	58.7	9.0	
	KTT8P6	203.2	152.4	14.0	25.0	M12	58.7	13.4	
	KTT108P	254.0	50.4	14.0	25.0	M12	58.7	7.4	
	KTT108P1	254.0	101.6	14.0	25.0	M12	58.7	14.3	
	KTT128P	304.8	50.4	14.0	25.0	M12	58.7	10.6	
	KTT128P1	304.8	101.6	14.0	25.0	M12	58.7	20.6	
	SUG8PST5	203.2	50.4	14.0	30.0	M10	46.8	4.6	
	SUG8P1ST5	203.2	101.6	14.0	30.0	M10	46.8	9.0	
	HOW27M88P	203.2	50.4	16.0	25.0	M12	50.8	4.6	
	HOW27M88P1	203.2	101.6	16.0	25.0	M12	50.8	9.0	
	AUTOBHM8P	203.2	50.4	17.0	23.0	M12	63.5	4.6	
	AUTOBHM8P1	203.2	101.6	17.0	23.0	M12	63.5	9.0	
	250	KTT10P	254.0	50.8	16.0	30.0	M12	73.0	7.4
		KTT10P3	254.0	76.2	16.0	30.0	M12	73.0	10.9
KTT10P1		254.0	101.6	16.0	30.0	M12	73.0	14.3	
KTT10P6		254.0	152.4	16.0	30.0	M12	73.0	21.3	
KTT1210P		304.8	50.8	16.0	30.0	M12	73.0	10.6	
KTT1210P1		304.8	101.6	16.0	30.0	M12	73.0	20.6	
KTT1510P		381.0	76.2	16.0	30.0	M12	73.0	24.4	
KTT1510P1		381.0	101.6	16.0	30.0	M12	73.0	32.2	
KTT1810P		457.2	76.2	16.0	30.0	M12	73.0	35.3	
KTT1810P1		457.2	101.6	16.0	30.0	M12	73.0	46.6	
MTT10P		254.0	50.8	16.0	32.0	M12	73.0	7.4	
MTT10P1		254.0	101.6	16.0	32.0	M12	73.0	14.3	
HOW27M10P		254.0	50.8	18.0	30.0	M14	76.2	7.4	
HOW27M10P1		254.0	101.6	18.0	30.0	M14	76.2	14.3	
315	KTT12P	304.8	50.8	18.0	30.0	M14	88.9	10.6	
	KTT12P3	304.8	76.2	18.0	30.0	M14	88.9	15.5	
	KTT12P1	304.8	101.6	18.0	30.0	M14	88.9	20.6	
	KTT12P6	304.8	152.4	18.0	30.0	M14	88.9	30.5	
	KTT1512P	381.1	76.2	18.0	30.0	M14	88.9	24.4	
	KTT1512P1	381.1	101.6	18.0	30.0	M14	88.9	32.2	
	KTT1812P	457.2	76.2	18.0	30.0	M14	88.9	35.3	
	KTT1812P1	457.2	101.6	18.0	30.0	M14	88.9	46.6	
	KTT2112P2	533.4	50.8	18.0	30.0	M14	88.9	32.5	
	KTT2112P	533.4	76.2	18.0	30.0	M14	88.9	47.7	
	KTT2112P1	533.4	101.6	18.0	30.0	M14	88.9	63.3	
	SEIK12P	304.8	50.8	18.0	32.0	M14	79.4	10.6	
	SUG12PSTM	304.8	50.8	20.0	35.0	M12	87.3	10.6	
	SUG12P1STM	304.8	101.6	20.0	35.0	M12	87.3	20.6	
	KTTB212P	304.8	50.8	21.0	30.0	M16	88.9	10.6	
	KTTB212P3	304.8	76.2	21.0	30.0	M16	88.9	15.5	
	KTTB212P1	304.8	101.6	21.0	30.0	M16	88.9	20.6	
	KTTB212P6	304.8	152.4	21.0	30.0	M16	88.9	30.5	
	KTT15B212P	381.1	76.2	21.0	30.0	M16	88.9	24.4	
	KTT15B212P1	381.1	101.6	21.0	30.0	M16	88.9	32.2	
	KTT18B212P	457.2	76.2	21.0	30.0	M16	88.9	35.3	
	KTT18B212P1	457.2	101.6	21.0	30.0	M16	88.9	46.6	
	KTT21B212P2	533.4	50.8	21.0	30.0	M16	88.9	32.5	
	KTT21B212P	533.4	76.2	21.0	30.0	M16	88.9	47.6	
	KTT21B212P1	533.4	101.6	21.0	30.0	M16	88.9	63.1	
	HOW27M12P	304.8	50.8	21.0	35.0	M16	69.9	10.6	
	HOW27M12P1	304.8	101.6	21.0	35.0	M16	69.9	20.6	

## 1.5mm X 60° Serrated Pie Jaws® — Style Q

– continued

Made with 319 cast aluminum, cast iron, 1018 steel or A36 steel

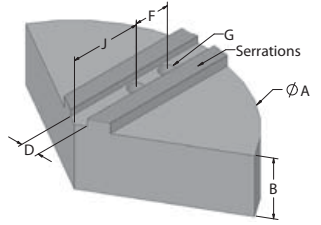
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

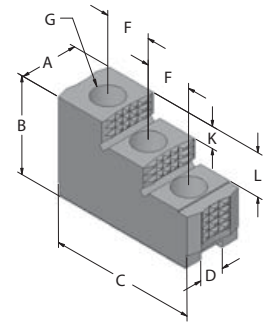
Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT
355	SUG14PSTG	381.0	76.2	21.0	45.0	M16	106.4	24.4
381	KTT15P	381.0	76.2	22.0	43.0	M20	109.5	24.4
	KTT15P1	381.0	101.6	22.0	43.0	M20	109.5	32.2
	KTT15P6	381.0	152.4	22.0	43.0	M20	109.5	47.7
	KTT15P8	381.0	203.2	22.0	43.0	M20	109.5	62.7
	KTT1815P	457.2	76.2	22.0	43.0	M20	109.5	35.3
	KTT1815P1	457.2	101.6	22.0	43.0	M20	109.5	46.6
	KTT2115P	533.4	76.2	22.0	43.0	M20	109.5	47.7
	KTT2115P1	533.4	101.6	22.0	43.0	M20	109.5	63.3
	KTT2415P	609.6	76.2	22.0	43.0	M20	109.5	62.7
	KTT2415P1	609.6	101.6	22.0	43.0	M20	109.5	82.9
	KTTB215P	381.0	76.2	25.5	43.0	M20	109.5	24.4
	KTTB215P1	381.0	101.6	25.5	43.0	M20	109.5	32.2
	KTTB215P6	381.0	152.4	25.5	43.0	M20	109.5	47.7
	KTTB215P8	381.0	203.2	25.5	43.0	M20	109.5	62.7
	KTT18B215P	457.2	76.2	25.5	43.0	M20	109.5	35.3
	KTT18B215P1	457.2	101.6	25.5	43.0	M20	109.5	46.6
	KTT21B215P	533.4	76.2	25.5	43.0	M20	109.5	47.7
	KTT21B215P1	533.4	101.6	25.5	43.0	M20	109.5	63.3
	KTT24B215P	609.6	76.2	25.5	43.0	M20	109.5	62.7
	KTT24B215P1	609.6	101.6	25.5	43.0	M20	109.5	82.9
450	KTT18P	457.2	76.2	22.0	43.0	M20	127.0	35.3
	KTT18P1	457.2	101.6	22.0	43.0	M20	127.0	46.6
	KTT2118P	533.4	76.2	22.0	43.0	M20	127.0	47.7
	KTT2118P1	533.4	101.6	22.0	43.0	M20	127.0	63.3
	KTT2418P	609.6	76.2	22.0	43.0	M20	127.0	62.7
	KTT2418P1	609.6	101.6	22.0	43.0	M20	127.0	82.9
	KTTB218P	457.2	76.2	25.5	43.0	M20	139.7	35.3
	KTTB218P1	457.2	101.6	25.5	43.0	M20	139.7	46.6
	KTT21B218P	533.4	76.2	25.5	43.0	M20	139.7	47.7
	KTT21B218P1	533.4	101.6	25.5	43.0	M20	139.7	63.3
KTT24B218P	609.6	76.2	25.5	43.0	M20	139.7	62.7	
KTT24B218P1	609.6	101.6	25.5	43.0	M20	139.7	82.9	

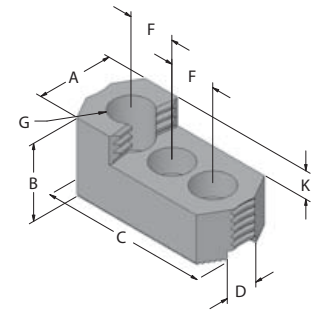


## 1.5mm X 60° Serrated Hard Jaws

Made with 1018 case hardened steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE	K STEP 1	L STEP 2
165	KTT6HJDS	28.7	43.9	72.4	12.0	20.0	M10	10.7	21.8
210	KTT8HJDS	38.1	56.6	80.5	14.0	25.0	M12	16.0	31.8
250	KTT10HJDS	38.1	69.3	101.3	16.0	30.0	M12	19.1	31.8
315	KTT12HJDS	50.8	63.0	105.7	18.0	30.0	M14	17.3	34.5
	KTTB212HJDS	50.8	69.9	104.9	21.0	30.0	M16	19.1	19.1
381	KTT15HJDS	63.5	75.7	149.4	22.0	43.0	M20	19.1	39.1
	KTTB215HJDS	63.5	75.7	149.4	25.5	43.0	M20	19.1	39.1

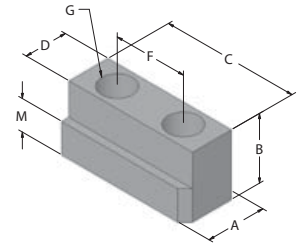


### 1.5mm X 60° Serrated Single Step Hard Jaws

Made with 1018 case hardened steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE	K STEP 1
165	KTT6HJSS	28.7	38.1	72.4	12.0	20.0	M10	12.2
210	KTT8HJSS	38.1	50.3	80.3	14.0	25.0	M12	19.1
250	KTT10HJSS	38.1	50.3	101.3	16.0	30.0	M12	19.3
315	KTT12HJSS	50.8	50.3	105.7	18.0	30.0	M14	21.1
381	KTT15HJSS	63.5	63.0	149.4	22.0	43.0	M20	23.6
	KTTB215HJSS	63.5	63.0	149.4	25.5	43.0	M20	23.6

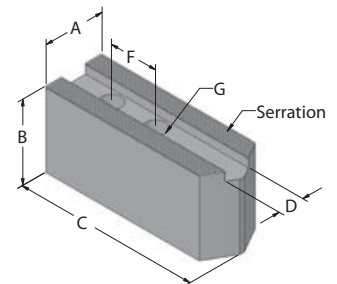


### 1.5mm X 60° Serrated Jaw Nuts

Made with 4140 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	F HOLE SPACING	G BOLT SIZE	M FLANGE
165	KTT6JN	17.5	22.1	36.6	12.0	20.0	M10	7.5
	KTTB206JN	17.5	18.3	36.6	12.0	20.0	M10	7.5
210	KTT8JN	20.3	25.4	47.5	14.0	25.0	M12	8.5
	KTTB208JN	20.6	20.6	46.5	14.0	25.0	M12	8.5
	HOW27M88JN	24.9	25.4	50.8	16.0	25.0	M12	9.5
250	KTT10JN	22.1	25.4	52.1	16.0	30.0	M12	8.5
	KTTB210JN	22.6	21.6	51.1	16.0	30.0	M12	8.5
315	KTT12JN	26.4	33.0	57.2	18.0	30.0	M14	13.5
	KTTB212JN	29.5	27.7	55.6	21.0	30.0	M16	11.4
381	KTT15JN	33.5	45.5	80.0	22.0	43.0	M20	16.5



### 3mm X 60° Serrated Soft Jaws — Style H

Made with 6061 T-6 condition aluminum or 1018 steel

Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE
210	HOW8A	HOW8S	38.1	50.8	101.6	14.0	25.0	M12
	HOW8A1	HOW8S1	38.1	76.2	101.6	14.0	25.0	M12
250	HOW10A	HOW10S	38.1	50.8	114.3	16.0	30.0	M12
	HOW10A1	HOW10S1	38.1	76.2	114.3	16.0	30.0	M12
	HOW10A4	HOW10S4	38.1	101.6	114.3	16.0	30.0	M12
315	HOW12A	HOW12S	50.8	50.8	139.7	18.0	30.0	M14
	HOW12A1	HOW12S1	50.8	76.2	139.7	18.0	30.0	M14
381	HOW7MA15A	HOW7MA15S	50.8	63.5	127.0	21.0	40.0	M16
	MTT15A	MTT15S	63.5	76.2	165.1	22.0	50.0	M20
	MTT15A1	MTT15S1	63.5	101.6	165.1	22.0	50.0	M20
	HOW27M15A	HOW27M15S	63.5	76.2	165.1	26.0	42.0	M20
	HOW15A	HOW15S	63.5	76.2	165.1	26.0	50.0	M20
	HOW15A1	HOW15S1	63.5	101.6	165.1	26.0	50.0	M20
457	MTT18A	MTT18S	63.5	76.2	209.6	22.0	50.0	M20
	MTT18A1	MTT18S1	63.5	101.6	209.6	22.0	50.0	M20
533-609	KTT21A	KTT21S	63.5	76.2	209.6	25.0	60.0	M20
	KTT21A1	KTT21S1	63.5	101.6	209.6	25.0	60.0	M20
	KTT21A5	KTT21S5	63.5	127.0	209.6	25.0	60.0	M20



### 3mm X 60° Serrated Pie Jaws® — Style S

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

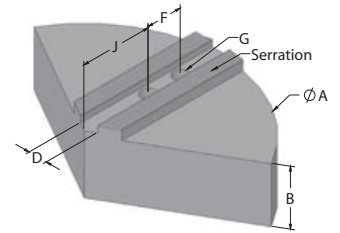
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

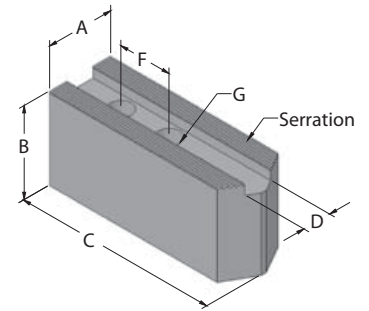
Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT
8	HOW8P	8	2	0.551	0.984	M12	2	10.2
	HOW8P1	8	4	0.551	0.984	M12	2	19.8
10	HOW10P	10	2	0.630	1.181	M12	3	16.2
	HOW10P1	10	4	0.630	1.181	M12	3	31.5
12	HOW12P	12	2	0.709	1.181	M14	3 5/8	23.4
	HOW12P1	12	4	0.709	1.181	M14	3 5/8	45.3
	HOW1512P	15	3	0.709	1.181	M14	3 5/8	53.7
	HOW1812P	18	3	0.709	1.181	M14	3 5/8	77.7
15	HOW7MA15P	15	3	0.827	1.575	M16	4 1/8	53.7
	MTT15P	15	3	0.866	1.969	M20	4 1/8	53.7
	MTT15P1	15	4	0.866	1.969	M20	4 1/8	70.8
	MTT15P6	15	6	0.866	1.969	M20	4 1/8	105.0
	MTT1815P	18	3	0.866	1.969	M20	4 1/8	77.7
	MTT1815P1	18	4	0.866	1.969	M20	4 1/8	102.6
	MTT2115P	21	3	0.866	1.969	M20	4 1/8	105.0
	MTT2115P1	21	4	0.866	1.969	M20	4 1/8	139.2
	HOW27M15P	15	3	1.024	1.654	M20	4 5/16	53.7
	HOW15P	15	3	1.024	1.969	M20	2 3/4	53.7
	HOW15P1	15	4	1.024	1.969	M20	2 3/4	70.8
18	MTT18P	18	3	0.866	1.969	M20	5 3/8	77.7
	MTT18P1	18	4	0.866	1.969	M20	5 3/8	102.6
	MTT2118P	21	3	0.866	1.969	M20	5 3/8	105.0
	MTT2118P1	21	4	0.866	1.969	M20	5 3/8	139.2
	MTT2418P	24	3	0.866	1.969	M20	5 3/8	138.0
	MTT2418P1	24	4	0.866	1.969	M20	5 3/8	182.4
21	KTT1821P	18	3	0.984	2.362	M20	5 3/4	77.7
	KTT1821P1	18	4	0.984	2.362	M20	5 3/4	102.6
	KTT21P2	21	2	0.984	2.362	M20	5 3/4	71.4
	KTT21P	21	3	0.984	2.362	M20	5 3/4	105.0
	KTT21P1	21	4	0.984	2.362	M20	5 3/4	139.2
	KTT2421P	24	3	0.984	2.362	M20	5 3/4	138.0
	KTT2421P1	24	4	0.984	2.362	M20	5 3/4	182.4
	KTT2821P	28	3	0.984	2.362	M20	5 3/4	186.0
	KTT2821P1	28	4	0.984	2.362	M20	5 3/4	249.6
24	KTT24P2	24	2	0.984	2.362	M20	7 1/2	93.0
	KTT24P	24	3	0.984	2.362	M20	7 1/2	138.0
	KTT24P1	24	4	0.984	2.362	M20	7 1/2	182.4
	KTT2824P	28	3	0.984	2.362	M20	7 1/2	186.0
	KTT2824P1	28	4	0.984	2.362	M20	7 1/2	249.6



## 1/16" X 90° Serrated Soft Jaws — Style J

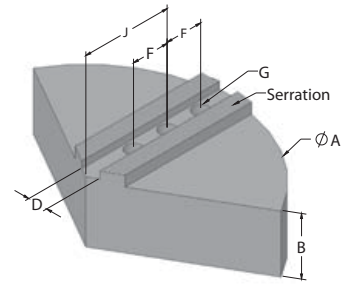
Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE
125	HAR5ESHA	HAR5ESHS	25.4	31.8	63.5	11.0	18.0	5/16"
165	PH6A	PH6S	31.8	38.1	76.2	11.0	18.3	5/16"
	PH6A1	PH6S1	31.8	50.8	76.2	11.0	18.3	5/16"
	PH6A2	PH6S2	31.8	76.2	76.2	11.0	18.3	5/16"
	HAR6ESHA	HAR6ESHS	31.8	38.1	78.5	14.0	20.0	3/8"
	HAR6ESHA1	HAR6ESHS1	31.8	50.8	78.5	14.0	20.0	3/8"
	HAR6ESHA2	HAR6ESHS2	31.8	76.2	78.5	14.0	20.0	3/8"
	PH6.5A	PH6.5S	31.8	38.1	76.2	14.0	18.3	3/8"
	SMW6.5A	SMW6.5S	31.8	38.1	76.2	14.0	16.5	M10
	SMW6.5A1	SMW6.5S1	31.8	50.8	76.2	14.0	16.5	M10
	SMW6.5A2	SMW6.5S2	31.8	76.2	76.2	14.0	16.5	M10
210	ATS8A	ATS8S	38.1	50.8	101.6	17.0	22.2	1/2"
	ATS8A1	ATS8S1	38.1	76.2	101.6	17.0	22.2	1/2"
	HAR8ESHA	HAR8ESHS	38.1	50.8	93.5	17.0	22.4	7/16"
	SMW8A	SMW8S	38.1	50.8	101.6	17.0	23.0	M12
	SMW8A1	SMW8S1	38.1	76.2	101.6	17.0	23.0	M12
	HOW12MA8A	HOW12MA8S	38.1	50.8	101.6	17.0	25.0	M12
250	PH10A	PH10S	38.1	50.8	114.3	14.0	22.2	3/8"
	PH10A1	PH10S1	38.1	76.2	114.3	14.0	22.2	3/8"
	SMW10A	SMW10S	38.1	50.8	114.3	21.0	30.0	M16
	SMW10A1	SMW10S1	38.1	76.2	114.3	21.0	30.0	M16
	ATS10A	ATS10S	38.1	50.8	114.3	21.0	30.1	1/2"
	ATS10A1	ATS10S1	38.1	76.2	114.3	21.0	30.1	1/2"
	HAR10ESHA	HAR10ESHS	38.1	50.8	114.3	21.0	30.1	5/8"
315	PH12A	PH12S	50.8	50.8	139.7	20.0	30.1	1/2"
	PH12A1	PH12S1	50.8	76.2	139.7	20.0	30.1	1/2"
	PH12A2	PH12S2	50.8	101.6	139.7	20.0	30.1	1/2"
	SMW12A	SMW12S	50.8	50.8	139.7	21.0	30.0	M16
	SMW12A1	SMW12S1	50.8	76.2	139.7	21.0	30.0	M16
	SMW12A2	SMW12S2	50.8	101.6	139.7	21.0	30.0	M16
	ATS12A	ATS12S	50.8	50.8	139.7	21.0	30.1	1/2"
	ATS12A1	ATS12S1	50.8	50.8	139.7	21.0	30.1	1/2"
	381	PH15A	PH15S	63.5	76.2	21.0	21.0	39.7
PH15A1		PH15S1	63.5	101.6	21.0	21.0	39.7	5/8"
PH15A5		PH15S5	63.5	127.0	21.0	21.0	39.7	5/8"

## 1/16" X 90° Serrated Pie Jaws® — Style K

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel  
 Add CI prefix to aluminum part # for cast iron jaws  
 Add ST prefix to aluminum part # for steel jaws  
 Cast iron version weight is approximately 2.6 times that of aluminum  
 Steel version weight is approximately 2.8 times that of aluminum



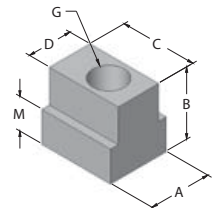
Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT	
125	HAR5ESH	152.4	50.8	11.0	18.0	5/16"	43.3	2.6	
165	PH6P	152.4	50.8	11.0	18.3	5/16"	36.5	2.6	
	PH6P1	152.4	101.6	11.0	18.3	5/16"	36.5	4.9	
	HAR6ESH	152.4	50.8	14.0	20.0	3/8"	36.5	2.6	
	HAR6ESH1	152.4	101.6	14.0	20.0	3/8"	36.5	4.9	
	PH6.5P	152.4	50.8	14.0	18.3	3/8"	46.7	2.6	
	PH6.5P1	152.4	101.6	14.0	18.3	3/8"	46.7	4.9	
	SMW6.5P	152.4	50.8	14.0	17.4	M10	50.8	2.6	
	SMW6.5P1	152.4	101.6	14.0	17.4	M10	50.8	4.9	
	210	ATS8P	203.2	50.8	17.0	22.2	1/2"	63.5	4.6
ATS8P1		203.2	101.6	17.0	22.2	1/2"	63.5	9.0	
HAR8ESH		203.2	50.8	17.0	22.4	7/16"	58.3	4.6	
HAR8ESH1		203.2	101.6	17.0	22.4	7/16"	58.3	9.0	
SMW8P		203.2	50.8	17.0	23.0	M12	63.5	4.6	
SMW8P1		203.2	101.6	17.0	23.0	M12	63.5	9.0	
HOW12MA8P		203.2	50.8	17.0	25.0	M12	50.8	4.6	
HOW12MA8P1		203.2	101.6	17.0	25.0	M12	50.8	9.0	
250		PH810P	203.2	50.8	14.0	22.2	3/8"	68.3	4.6
	PH810P1	203.2	101.6	14.0	22.2	3/8"	68.3	9.0	
	PH10P	254.0	50.8	14.0	22.2	3/8"	88.9	7.4	
	PH10P1	254.0	101.6	14.0	22.2	3/8"	88.9	14.3	
	SMW10P	254.0	50.8	21.0	30.0	M16	76.2	7.4	
	SMW10P1	254.0	101.6	21.0	30.0	M16	76.2	14.3	
	SMW1210P	304.8	50.8	21.0	30.0	M16	76.2	10.6	
	SMW1510P	381.0	76.2	21.0	30.0	M16	76.2	24.4	
	SMW1810P	457.2	76.2	21.0	30.0	M16	76.2	35.3	
	ATS10P	254.0	50.8	21.0	30.1	1/2"	96.8	7.4	
	ATS10P1	254.0	101.6	21.0	30.1	1/2"	96.8	14.3	
	HAR10ESH	254.0	50.8	21.0	30.1	5/8"	69.9	7.4	
	HAR10ESH1	254.0	101.6	21.0	30.1	5/8"	69.9	14.3	
	315	PH1012P	254.0	50.8	20.0	30.1	1/2"	55.6	7.4
		PH1012P1	254.0	101.6	20.0	30.1	1/2"	55.6	14.3
PH12P		304.8	50.8	20.0	30.1	1/2"	101.6	10.6	
PH12P1		304.8	101.6	20.0	30.1	1/2"	101.6	20.6	
PH1512P		381.0	76.2	20.0	30.1	1/2"	101.6	24.4	
SMW12P		304.8	50.8	21.0	30.0	M16	101.6	10.6	
SMW12P1		304.8	101.6	21.0	30.0	M16	101.6	20.6	
ATS12P		304.8	50.8	21.0	30.1	1/2"	96.8	10.6	
ATS12P1		304.8	101.6	21.0	30.1	1/2"	96.8	20.6	
381		PH15P	381.0	76.2	21.0	39.7	5/8"	127.0	24.4
	PH15P1	381.0	101.6	21.0	39.7	5/8"	127.0	32.2	
	PH1815P	457.2	76.2	21.0	39.7	5/8"	127.0	35.3	
	PH1815P1	457.2	101.6	21.0	39.7	5/8"	127.0	46.6	
	PH2115P	533.4	76.2	21.0	39.7	5/8"	127.0	47.7	
	PH2415P	609.6	76.2	21.0	39.7	5/8"	127.0	62.7	

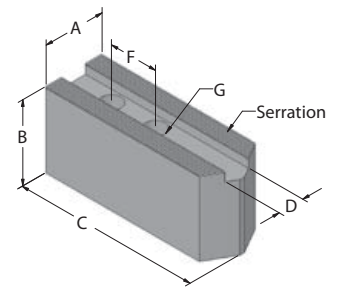
## Jaw Nuts For 1/16" X 90° Serrated Chucks

Made with 4140 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available



CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	G BOLT SIZE	M FLANGE
250	PH10JN	19.1	15.5	19.1	14.0	3/8"	6.4
315	PH12JN	25.4	21.6	25.4	20.0	1/2"	8.3
381	PH15JN	25.4	25.4	28.7	21.0	5/8"	10.9



### 3/32" X 90° Serrated Soft Jaws — Style J

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	F HOLE SPACING	G BOLT SIZE
400	SMW16A	SMW16S	63.5	76.2	165.1	25.5	38.0	M20
	SMW16A1	SMW16S1	63.5	101.6	165.1	25.5	38.0	M20
	ATS16A	ATS16S	63.5	76.2	165.1	25.5	39.7	3/4"
	ATS16A1	ATS16S1	63.5	101.6	165.1	25.5	39.7	3/4"
450	AUTO18A1	AUTO18S1	63.5	101.6	254.0	28.0	68.6	M20
500	SMW20A	SMW20S	63.5	76.2	209.6	25.5	38.0	M20
	SMW20A1	SMW20S1	63.5	101.6	209.6	25.5	38.0	M20
	ATS20A	ATS20S	63.5	76.2	209.6	25.5	39.7	3/4"
	ATS20A1	ATS20S1	63.5	101.6	209.6	25.5	39.7	3/4"
	AB20A	AB20S	63.5	63.5	170.2	28.0	75.9	M20
630	SMW25A	SMW25S	76.2	101.6	279.4	25.5	38.0	M20
	ATS25A	ATS25S	76.2	101.6	279.4	30.0	63.5	1"

### 3/32" X 90° Serrated Pie Jaws® — Style K

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

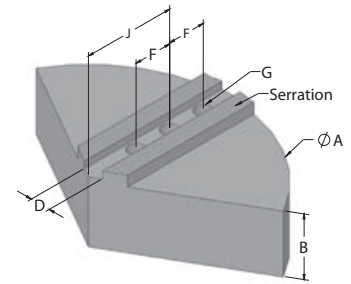
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



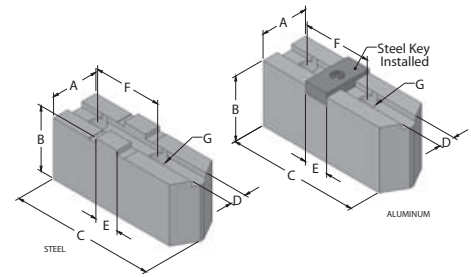
CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT
400	SMW1516P	381.0	76.2	25.5	38.0	M20	123.8	24.4
	SMW1516P1	381.0	101.6	25.5	38.0	M20	123.8	32.2
	SMW1816P	457.2	76.2	25.5	38.0	M20	123.8	35.3
	SMW1816P1	457.2	101.6	25.5	38.0	M20	123.8	46.6
	ATS1516P	381.0	76.2	25.5	39.7	3/4"	115.9	24.4
	ATS1516P1	381.0	101.6	25.5	39.7	3/4"	115.9	32.2
	ATS1816P	457.2	76.2	25.5	39.7	3/4"	115.9	35.3
	ATS1816P1	457.2	101.6	25.5	39.7	3/4"	115.9	46.6
500	SMW1820P	457.2	76.2	25.5	38.0	M20	165.1	35.3
	SMW1820P1	457.2	101.6	25.5	38.0	M20	165.1	46.6
	SMW2120P	533.4	76.2	25.5	38.0	M20	165.1	47.7
	SMW2120P1	533.4	101.6	25.5	38.0	M20	165.1	63.3
	ATS1820P	457.2	76.2	25.5	39.7	3/4"	169.9	35.3
	ATS1820P1	457.2	101.6	25.5	39.7	3/4"	169.9	46.6
	ATS2120P	533.4	76.2	25.5	39.7	3/4"	169.9	47.7
	ATS2120P1	533.4	101.6	25.5	39.7	3/4"	169.9	63.3
630	SMW2425P	609.6	76.2	25.5	38.0	M20	200.0	62.7
	SMW2425P1	609.6	101.6	25.5	38.0	M20	200.0	82.9
	SMW2825P	711.2	76.2	25.5	38.0	M20	200.0	84.5
	SMW2825P1	711.2	101.6	25.5	38.0	M20	200.0	113.5
	ATS2425P	609.6	76.2	30.0	63.5	1"	206.4	62.7
	ATS2425P1	609.6	101.6	30.0	63.5	1"	206.4	82.9
	ATS2825P	711.2	76.2	30.0	63.5	1"	206.4	84.5
	ATS2825P1	711.2	101.6	30.0	63.5	1"	206.4	113.5



## American Standard Tongue & Groove Soft Jaws — Style A

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available



CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE
165	TG6MDA	TG6MDS	31.8	38.1	76.2	7.9	12.7	38.1	3/8"
	TG6MDASQ	TG6MDS5Q	31.8	38.1	76.2	7.9	12.7	38.1	3/8"
	TG6MDA1	TG6MDS1	31.8	50.8	76.2	7.9	12.7	38.1	3/8"
	TG6MDA2	TG6MDS2	31.8	76.2	76.2	7.9	12.7	38.1	3/8"
	TG6MDA2SQ	TG6MDS2SQ	31.8	76.2	76.2	7.9	12.7	38.1	3/8"
	TG6HDA	TG6HDS	31.8	38.1	76.2	7.9	12.7	38.1	7/16"
	TG6HDASQ	TG6HDS5Q	31.8	38.1	76.2	7.9	12.7	38.1	7/16"
	TG6HDA1	TG6HDS1	31.8	50.8	76.2	7.9	12.7	38.1	7/16"
	TG6HDA2	TG6HDS2	31.8	76.2	76.2	7.9	12.7	38.1	7/16"
	TG6HDA2SQ	TG6HDS2SQ	31.8	76.2	76.2	7.9	12.7	38.1	7/16"
210	TG8MDA	TG8MDS	38.1	50.8	101.6	7.9	12.7	44.5	3/8"
	TG8MDASQ	TG8MDS5Q	38.1	50.8	101.6	7.9	12.7	44.5	3/8"
	TG8MDA1	TG8MDS1	38.1	76.2	101.6	7.9	12.7	44.5	3/8"
	TG8MDA2	TG8MDS2	38.1	101.6	101.6	7.9	12.7	44.5	3/8"
	TG8MDA2SQ	TG8MDS2SQ	38.1	101.6	101.6	7.9	12.7	44.5	3/8"
	TG8HDA	TG8HDS	38.1	50.8	101.6	7.9	12.7	44.5	1/2" [M12]
	TG8HDASQ	TG8HDS5Q	38.1	50.8	101.6	7.9	12.7	44.5	1/2" [M12]
	TG8HDA1	TG8HDS1	38.1	76.2	101.6	7.9	12.7	44.5	1/2" [M12]
	TG8HDA2	TG8HDS2	38.1	101.6	101.6	7.9	12.7	44.5	1/2" [M12]
	TG8HDA2SQ	TG8HDS2SQ	38.1	101.6	101.6	7.9	12.7	44.5	1/2" [M12]
250	TG10MDA	TG10MDS	38.1	50.8	114.3	12.7	19.1	54.0	1/2" [M12]
	TG10MDASQ	TG10MDS5Q	38.1	50.8	114.3	12.7	19.1	54.0	1/2" [M12]
	TG10MDA1	TG10MDS1	38.1	76.2	114.3	12.7	19.1	54.0	1/2" [M12]
	TG10MDA2	TG10MDS2	38.1	101.6	114.3	12.7	19.1	54.0	1/2" [M12]
	TG10MDA2SQ	TG10MDS2SQ	38.1	101.6	114.3	12.7	19.1	54.0	1/2" [M12]
	TG10HDA	TG10HDS	38.1	50.8	114.3	12.7	19.1	54.0	5/8" [M16]
	TG10HDASQ	TG10HDS5Q	38.1	50.8	114.3	12.7	19.1	54.0	5/8" [M16]
	TG10HDA1	TG10HDS1	38.1	76.2	114.3	12.7	19.1	54.0	5/8" [M16]
	TG10HDA2	TG10HDS2	38.1	101.6	114.3	12.7	19.1	54.0	5/8" [M16]
	TG10HDA2SQ	TG10HDS2SQ	38.1	101.6	114.3	12.7	19.1	54.0	5/8" [M16]
315	TG12MDA	TG12MDS	50.8	50.8	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12MDASQ	TG12MDS5Q	50.8	50.8	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12MDA1	TG12MDS1	50.8	76.2	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12MDA2	TG12MDS2	50.8	101.6	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12MDA2SQ	TG12MDS2SQ	50.8	101.6	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12MDA5	TG12MDS5	50.8	127.0	139.7	12.7	19.1	63.5	1/2" [M12]
	TG12HDA	TG12HDS	50.8	50.8	139.7	12.7	19.1	63.5	5/8" [M16]
	TG12HDASQ	TG12HDS5Q	50.8	50.8	139.7	12.7	19.1	63.5	5/8" [M16]
	TG12HDA1	TG12HDS1	50.8	76.2	139.7	12.7	19.1	63.5	5/8" [M16]
	TG12HDA2	TG12HDS2	50.8	101.6	139.7	12.7	19.1	63.5	5/8" [M16]
	TG12HDA2SQ	TG12HDS2SQ	50.8	101.6	139.7	12.7	19.1	63.5	5/8" [M16]
	TG12HDA5	TG12HDS5	50.8	127.0	139.7	12.7	19.1	63.5	5/8" [M16]
	381-457	TG15MDA	TG15MDS	63.5	76.2	165.1	12.7	19.1	76.2
TG15MDASQ		TG15MDS5Q	63.5	76.2	165.1	12.7	19.1	76.2	5/8" [M16]
TG15MDA1		TG15MDS1	63.5	101.6	165.1	12.7	19.1	76.2	5/8" [M16]
TG15MDA1SQ		TG15MDS1SQ	63.5	101.6	165.1	12.7	19.1	76.2	5/8" [M16]
TG15MDA5		TG15MDS5	63.5	127.0	165.1	12.7	19.1	76.2	5/8" [M16]
TG15HDA		TG15HDS	63.5	76.2	165.1	12.7	19.1	76.2	3/4"
TG15HDASQ		TG15HDS5Q	63.5	76.2	165.1	12.7	19.1	76.2	3/4"
TG15HDA1		TG15HDS1	63.5	101.6	165.1	12.7	19.1	76.2	3/4"
TG15HDA1SQ		TG15HDS1SQ	63.5	101.6	165.1	12.7	19.1	76.2	3/4"
TG15HDA5		TG15HDS5	63.5	127.0	165.1	12.7	19.1	76.2	3/4"
TG15HDA-M20		TG15HDS-M20	63.5	76.2	165.1	12.7	19.1	76.2	M20
TG15HDASQ-M20		TG15HDS5Q-M20	63.5	76.2	165.1	12.7	1.0	76.2	M20
TG15HDA1-M20		TG15HDS1-M20	63.5	101.6	165.1	12.7	19.1	76.2	M20
TG15HDA1SQ-M20		TG15HDS1SQ-M20	63.5	101.6	165.1	12.7	19.1	76.2	M20
TG15HDA5-M20		TG15HDS5-M20	63.5	127.0	165.1	12.7	19.1	76.2	M20
533-610	TG21MDA	TG21MDS	63.5	76.2	209.5	12.7	19.1	76.2	5/8" [M16]
	TG21MDA1	TG21MDS1	63.5	101.6	209.5	12.7	19.1	76.2	5/8" [M16]
	TG21MDA5	TG21MDS5	63.5	127.0	209.5	12.7	19.1	76.2	5/8" [M16]
	TG21HDA	TG21HDS	63.5	76.2	209.5	12.7	19.1	76.2	3/4"
	TG21HDA1	TG21HDS1	63.5	101.6	209.5	12.7	19.1	76.2	3/4"
	TG21HDA5	TG21HDS5	63.5	127.0	209.5	12.7	19.1	76.2	3/4"
	TG21HDA-M20	TG21HDS-M20	63.5	76.2	209.5	12.7	19.1	76.2	M20
	TG21HDA1-M20	TG21HDS1-M20	63.5	101.6	209.5	12.7	19.1	76.2	M20
	TG21HDA5-M20	TG21HDS5-M20	63.5	127.0	209.5	12.7	19.1	76.2	M20

## American Standard Tongue & Groove Pie Jaws® — Style D

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

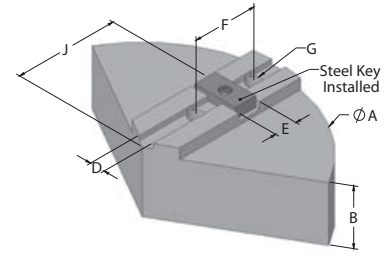
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT	
125	TG5MDP	152.4	50.8	7.9	12.7	31.8	5/16"	38.1	2.6	
165	TG6MDP	152.4	50.8	7.9	12.7	38.1	3/8"	50.8	2.6	
	TG6MDP1	152.4	101.6	7.9	12.7	38.1	3/8"	50.8	4.9	
	TG86MDP	203.2	50.8	7.9	12.7	38.1	3/8"	50.8	4.6	
	TG86MDP1	203.2	101.6	7.9	12.7	38.1	3/8"	50.8	9.0	
	TG6HDP	152.4	50.8	7.9	12.7	38.1	7/16"	50.8	2.6	
	TG6HDP1	152.4	101.6	7.9	12.7	38.1	7/16"	50.8	4.9	
	TG86HDP	203.2	50.8	7.9	12.7	38.1	7/16"	50.8	4.6	
	TG86HDP1	203.2	101.6	7.9	12.7	38.1	7/16"	50.8	9.0	
	210	TG8MDP	203.2	50.8	7.9	12.7	44.5	3/8"	69.9	4.6
		TG8MDP1	203.2	101.6	7.9	12.7	44.5	3/8"	69.9	9.0
TG8MDP6		203.2	152.4	7.9	12.7	44.5	3/8"	69.9	13.4	
TG108MDP		254.0	50.8	7.9	12.7	44.5	3/8"	69.9	7.4	
TG108MDP1		254.0	101.6	7.9	12.7	44.5	3/8"	69.9	14.3	
TG128MDP		304.8	50.8	7.9	12.7	44.5	3/8"	69.9	10.6	
TG128MDP1		304.8	101.6	7.9	12.7	44.5	3/8"	69.9	20.6	
TG8HDP		203.2	50.8	7.9	12.7	44.5	1/2" [M12]	69.9	4.6	
TG8HDP1		203.2	101.6	7.9	12.7	44.5	1/2" [M12]	69.9	9.0	
TG8HDP6		203.2	152.4	7.9	12.7	44.5	1/2" [M12]	69.9	13.4	
TG108HDP		254.0	50.8	7.9	12.7	44.5	1/2" [M12]	69.9	7.4	
TG108HDP1		254.0	101.6	7.9	12.7	44.5	1/2" [M12]	69.9	14.3	
TG128HDP		304.8	50.8	7.9	12.7	44.5	1/2" [M12]	69.9	10.6	
TG128HDP1		304.8	101.6	7.9	12.7	44.5	1/2" [M12]	69.9	20.6	
250		TG10MDP	254.0	50.8	12.7	19.1	54.0	1/2" [M12]	88.9	7.4
		TG10MDP1	254.0	101.6	12.7	19.1	54.0	1/2" [M12]	88.9	14.3
	TG10MDP6	254.0	152.4	12.7	19.1	54.0	1/2" [M12]	88.9	21.3	
	TG1210MDP	304.8	50.8	12.7	19.1	54.0	1/2" [M12]	88.9	10.6	
	TG1210MDP1	304.8	101.6	12.7	19.1	54.0	1/2" [M12]	88.9	20.6	
	TG1510MDP	381.0	76.2	12.7	19.1	54.0	1/2" [M12]	88.9	24.4	
	TG1510MDP1	381.0	101.6	12.7	19.1	54.0	1/2" [M12]	88.9	32.2	
	TG1810MDP	457.2	76.2	12.7	19.1	54.0	1/2" [M12]	88.9	35.3	
	TG1810MDP1	457.2	101.6	12.7	19.1	54.0	1/2" [M12]	88.9	46.6	
	TG10HDP	254.0	50.8	12.7	19.1	54.0	5/8" [M16]	88.9	7.4	
	TG10HDP1	254.0	101.6	12.7	19.1	54.0	5/8" [M16]	88.9	14.3	
	TG10HDP6	254.0	152.4	12.7	19.1	54.0	5/8" [M16]	88.9	21.3	
	TG1210HDP	304.8	50.8	12.7	19.1	54.0	5/8" [M16]	88.9	10.6	
	TG1210HDP1	304.8	101.6	12.7	19.1	54.0	5/8" [M16]	88.9	20.6	
	TG1510HDP	381.0	76.2	12.7	19.1	54.0	5/8" [M16]	88.9	24.4	
	TG1510HDP1	381.0	101.6	12.7	19.1	54.0	5/8" [M16]	88.9	32.2	
	TG1810HDP	457.2	76.2	12.7	19.1	54.0	5/8" [M16]	88.9	35.3	
	TG1810HDP1	457.2	101.6	12.7	19.1	54.0	5/8" [M16]	88.9	46.6	
315	TG12MDP	304.8	50.8	12.7	19.1	63.5	1/2" [M12]	108.0	10.6	
	TG12MDP1	304.8	101.6	12.7	19.1	63.5	1/2" [M12]	108.0	20.6	
	TG12MDP6	304.8	152.4	12.7	19.1	63.5	1/2" [M12]	108.0	30.5	
	TG1512MDP	381.0	76.2	12.7	19.1	63.5	1/2" [M12]	108.0	24.4	
	TG1512MDP1	381.0	101.6	12.7	19.1	63.5	1/2" [M12]	108.0	32.2	
	TG1812MDP	457.2	76.2	12.7	19.1	63.5	1/2" [M12]	108.0	35.3	
	TG1812MDP1	457.2	101.6	12.7	19.1	63.5	1/2" [M12]	108.0	46.6	
	TG2112MDP2	533.4	50.8	12.7	19.1	63.5	1/2" [M12]	108.0	32.5	
	TG2112MDP	533.4	76.2	12.7	19.1	63.5	1/2" [M12]	108.0	47.7	
	TG2112MDP1	533.4	101.6	12.7	19.1	63.5	1/2" [M12]	108.0	63.3	
	TG12HDP	304.8	50.8	12.7	19.1	63.5	5/8" [M16]	108.0	10.6	
	TG12HDP1	304.8	101.6	12.7	19.1	63.5	5/8" [M16]	108.0	20.6	
	TG12HDP6	304.8	152.4	12.7	19.1	63.5	5/8" [M16]	108.0	30.5	
	TG1512HDP	381.0	76.2	12.7	19.1	63.5	5/8" [M16]	108.0	24.4	
	TG1512HDP1	381.0	101.6	12.7	19.1	63.5	5/8" [M16]	108.0	32.2	
	TG1812HDP	457.2	76.2	12.7	19.1	63.5	5/8" [M16]	108.0	35.3	
	TG1812HDP1	457.2	101.6	12.7	19.1	63.5	5/8" [M16]	108.0	46.6	
	TG2112HDP2	533.4	50.8	12.7	19.1	63.5	5/8" [M16]	108.0	32.5	
	TG2112HDP	533.4	76.2	12.7	19.1	63.5	5/8" [M16]	108.0	47.7	
	TG2112HDP1	533.4	101.6	12.7	19.1	63.5	5/8" [M16]	108.0	63.3	

## American Standard Tongue & Groove Pie Jaws® — Style D

– continued

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

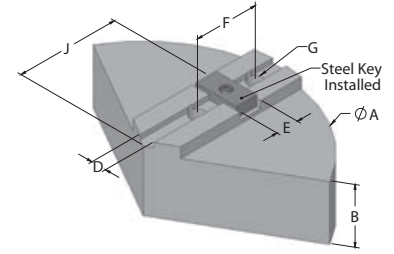
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

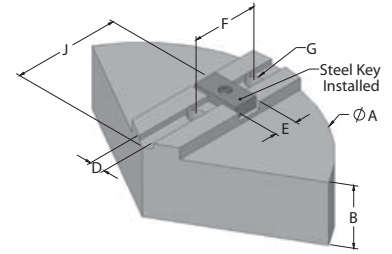


CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT	
381	TG15MDP	381.0	76.2	12.7	19.1	76.2	5/8" [M16]	133.4	24.4	
	TG15MDP1	381.0	101.6	12.7	19.1	76.2	5/8" [M16]	133.4	32.2	
	TG15MDP6	381.0	152.4	12.7	19.1	76.2	5/8" [M16]	133.4	47.7	
	TG1815MDP	457.2	76.2	12.7	19.1	76.2	5/8" [M16]	133.4	35.3	
	TG1815MDP1	457.2	101.6	12.7	19.1	76.2	5/8" [M16]	133.4	46.6	
	TG2115MDP	533.4	76.2	12.7	19.1	76.2	5/8" [M16]	133.4	47.7	
	TG2115MDP1	533.4	101.6	12.7	19.1	76.2	5/8" [M16]	133.4	63.3	
	TG2415MDP	609.6	76.2	12.7	19.1	76.2	5/8" [M16]	133.4	62.7	
	TG2415MDP1	609.6	101.6	12.7	19.1	76.2	5/8" [M16]	133.4	82.9	
	TG15HDP	381.0	76.2	12.7	19.1	76.2	3/4"	133.4	24.4	
	TG15HDP1	381.0	101.6	12.7	19.1	76.2	3/4"	133.4	32.2	
	TG15HDP6	381.0	152.4	12.7	19.1	76.2	3/4"	133.4	47.7	
	TG1815HDP	457.2	76.2	12.7	19.1	76.2	3/4"	133.4	35.3	
	TG1815HDP1	457.2	101.6	12.7	19.1	76.2	3/4"	133.4	46.6	
	TG2115HDP	533.4	76.2	12.7	19.1	76.2	3/4"	133.4	47.7	
	TG2115HDP1	533.4	101.6	12.7	19.1	76.2	3/4"	133.4	63.3	
	TG2415HDP	609.6	76.2	12.7	19.1	76.2	3/4"	133.4	62.7	
	TG2415HDP1	609.6	101.6	12.7	19.1	76.2	3/4"	133.4	82.9	
	TG15HDP-M20	381.0	76.2	12.7	19.1	76.2	M20	133.4	24.4	
	TG15HDP1-M20	381.0	101.6	12.7	19.1	76.2	M20	133.4	32.2	
	TG15HDP6-M20	381.0	152.4	12.7	19.1	76.2	M20	133.4	47.7	
	TG1815HDP-M20	457.2	76.2	12.7	19.1	76.2	M20	133.4	35.3	
	TG1815HDP1-M20	457.2	101.6	12.7	19.1	76.2	M20	133.4	46.6	
	TG2115HDP-M20	533.4	76.2	12.7	19.1	76.2	M20	133.4	47.7	
	TG2115HDP1-M20	533.4	101.6	12.7	19.1	76.2	M20	133.4	63.3	
	TG2415HDP-M20	609.6	76.2	12.7	19.1	76.2	M20	133.4	62.7	
	TG2415HDP1-M20	609.6	101.6	12.7	19.1	76.2	M20	133.4	82.9	
	450	TG18MDP	457.2	76.2	12.7	19.1	76.2	5/8" [M16]	165.1	35.3
		TG18MDP1	457.2	101.6	12.7	19.1	76.2	5/8" [M16]	165.1	46.6
		TG18MDP8	457.2	203.2	12.7	19.1	76.2	5/8" [M16]	165.1	92.3
TG2118MDP		533.4	76.2	12.7	19.1	76.2	5/8" [M16]	165.1	47.7	
TG2118MDP1		533.4	101.6	12.7	19.1	76.2	5/8" [M16]	165.1	63.3	
TG2418MDP		609.6	76.2	12.7	19.1	76.2	5/8" [M16]	165.1	62.7	
TG2418MDP1		609.6	101.6	12.7	19.1	76.2	5/8" [M16]	165.1	82.9	
TG2818MDP		711.2	76.2	12.7	19.1	76.2	5/8" [M16]	165.1	84.5	
TG2818MDP1		711.2	101.6	12.7	19.1	76.2	5/8" [M16]	165.1	113.5	
TG3018MDP1		762.0	101.6	12.7	19.1	76.2	5/8" [M16]	165.1	130.2	
TG18HDP		457.2	76.2	12.7	19.1	76.2	3/4"	165.1	35.3	
TG18HDP1		457.2	101.6	12.7	19.1	76.2	3/4"	165.1	46.6	
TG18HDP8		457.2	203.2	12.7	19.1	76.2	3/4"	165.1	92.3	
TG2118HDP		533.4	76.2	12.7	19.1	76.2	3/4"	165.1	47.7	
TG2118HDP1		533.4	101.6	12.7	19.1	76.2	3/4"	165.1	63.3	
TG2418HDP		609.6	76.2	12.7	19.1	76.2	3/4"	165.1	62.7	
TG2418HDP1		609.6	101.6	12.7	19.1	76.2	3/4"	165.1	82.9	
TG2818HDP		711.2	76.2	12.7	19.1	76.2	3/4"	165.1	84.5	
TG2818HDP1		711.2	101.6	12.7	19.1	76.2	3/4"	165.1	113.5	
TG3018HDP1		762.0	101.6	12.7	19.1	76.2	3/4"	165.1	130.2	
TG18HDP-M20		457.2	76.2	12.7	19.1	76.2	M20	165.1	35.3	
TG18HDP1-M20		457.2	101.6	12.7	19.1	76.2	M20	165.1	46.6	
TG18HDP8-M20		457.2	203.2	12.7	19.1	76.2	M20	165.1	92.3	
TG2118HDP-M20		533.4	76.2	12.7	19.1	76.2	M20	165.1	47.7	
TG2118HDP1-M20		533.4	101.6	12.7	19.1	76.2	M20	165.1	63.3	
TG2418HDP-M20		609.6	76.2	12.7	19.1	76.2	M20	165.1	62.7	
TG2418HDP1-M20		609.6	101.6	12.7	19.1	76.2	M20	165.1	82.9	
TG2818HDP-M20		711.2	76.2	12.7	19.1	76.2	M20	165.1	84.5	
TG2818HDP1-M20		711.2	101.6	12.7	19.1	76.2	M20	165.1	113.5	
TG3018HDP1-M20		762.0	101.6	12.7	19.1	76.2	M20	165.1	130.2	

## American Standard Tongue & Groove Pie Jaws® — Style D

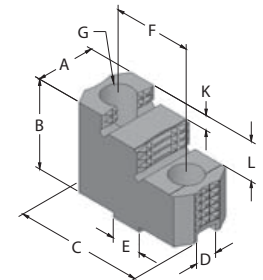
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Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel  
 Add CI prefix to aluminum part # for cast iron jaws  
 Add ST prefix to aluminum part # for steel jaws  
 Cast iron version weight is approximately 2.6 times that of aluminum  
 Steel version weight is approximately 2.8 times that of aluminum



Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT
533	TG21MDP	533.4	76.2	12.7	19.1	76.2	5/8" [M16]	196.9	47.6
	TG21MDP1	533.4	101.6	12.7	19.1	76.2	5/8" [M16]	196.9	63.3
	TG2421MDP	609.6	76.2	12.7	19.1	76.2	5/8" [M16]	196.9	62.7
	TG2421MDP1	609.6	101.6	12.7	19.1	76.2	5/8" [M16]	196.9	82.9
	TG2821MDP	711.2	76.2	12.7	19.1	76.2	5/8" [M16]	196.9	84.5
	TG2821MDP1	711.2	101.6	12.7	19.1	76.2	5/8" [M16]	196.9	113.5
	TG21HDP	533.4	76.2	12.7	19.1	76.2	3/4"	196.9	47.6
	TG21HDP1	533.4	101.6	12.7	19.1	76.2	3/4"	196.9	63.3
	TG2421HDP	609.6	76.2	12.7	19.1	76.2	3/4"	196.9	62.7
	TG2421HDP1	609.6	101.6	12.7	19.1	76.2	3/4"	196.9	82.9
	TG2821HDP	711.2	76.2	12.7	19.1	76.2	3/4"	196.9	84.5
	TG2821HDP1	711.2	101.6	12.7	19.1	76.2	3/4"	196.9	113.5
	TG21HDP-M20	533.4	76.2	12.7	19.1	76.2	M20	196.9	47.6
	TG21HDP1-M20	533.4	101.6	12.7	19.1	76.2	M20	196.9	63.3
	TG2421HDP-M20	609.6	76.2	12.7	19.1	76.2	M20	196.9	62.7
	TG2421HDP1-M20	609.6	101.6	12.7	19.1	76.2	M20	196.9	82.9
	TG2821HDP-M20	711.2	76.2	12.7	19.1	76.2	M20	196.9	84.5
	TG2821HDP1-M20	711.2	101.6	12.7	19.1	76.2	M20	196.9	113.5
610+	TG24MDP2	609.6	50.8	12.7	19.1	76.2	5/8" [M16]	241.3	42.3
	TG24MDP	609.6	76.2	12.7	19.1	76.2	5/8" [M16]	241.3	62.7
	TG24MDP1	609.6	101.6	12.7	19.1	76.2	5/8" [M16]	241.3	82.9
	TG2824MDP	711.2	76.2	12.7	19.1	76.2	5/8" [M16]	241.3	84.5
	TG2824MDP1	711.2	101.6	12.7	19.1	76.2	5/8" [M16]	241.3	113.5
	TG322418MDP1	812.8	101.6	12.7	19.1	76.2	5/8" [M16]	241.3	147.5
	TG362418MDP1	914.4	101.6	12.7	19.1	76.2	5/8" [M16]	241.3	187.5
	TG422418MDP1	1066.8	101.6	12.7	19.1	76.2	5/8" [M16]	241.3	255.4
	TG24HDP2	609.6	50.8	12.7	19.1	76.2	3/4"	241.3	43.2
	TG24HDP	609.6	76.2	12.7	19.1	76.2	3/4"	241.3	62.7
	TG24HDP1	609.6	101.6	12.7	19.1	76.2	3/4"	241.3	82.9
	TG2824HDP	711.2	76.2	12.7	19.1	76.2	3/4"	241.3	84.5
	TG2824HDP1	711.2	101.6	12.7	19.1	76.2	3/4"	241.3	113.5
	TG322418HDP1	812.8	101.6	12.7	19.1	76.2	3/4"	241.3	147.5
	TG362418HDP1	914.4	101.6	12.7	19.1	76.2	3/4"	241.3	187.5
	TG422418HDP1	1066.8	101.6	12.7	19.1	76.2	3/4"	241.3	255.4
	TG24HDP2-M20	609.6	50.8	12.7	19.1	76.2	M20	241.3	43.2
	TG24HDP-M20	609.6	76.2	12.7	19.1	76.2	M20	241.3	62.7
	TG24HDP1-M20	609.6	101.6	12.7	19.1	76.2	M20	241.3	82.9
	TG2824HDP-M20	711.2	76.2	12.7	19.1	76.2	M20	241.3	84.5
	TG2824HDP1-M20	711.2	101.6	12.7	19.1	76.2	M20	241.3	113.5
	TG322418HDP1M20	812.8	101.6	12.7	19.1	76.2	M20	241.3	147.5
	TG362418HDP1M20	914.4	101.6	12.7	19.1	76.2	M20	241.3	187.5
	TG422418HDP1M20	1066.8	101.6	12.7	19.1	76.2	M20	241.3	255.4



## American Standard Tongue & Groove Hard Jaws

Made with 1018 case hardened steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

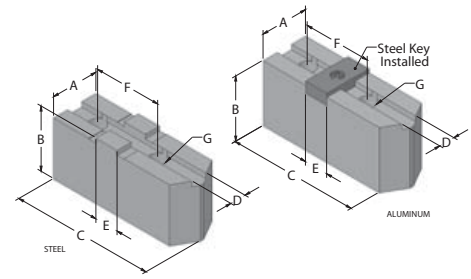
CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE	J DIM	K STEP 1	L STEP 2
210	TG8MDHJDS	31.8	50.8	90.2	7.9	12.7	44.5	3/8"	49.2	15.2	26.4
250	TG10MDHJDS	44.5	63.5	95.8	12.7	19.1	54.0	1/2"	55.6	17.3	35.1
	TG10HDHJDS	44.5	63.5	95.8	12.7	19.1	54.0	5/8"	55.6	17.3	35.1
315	TG12MDHJDS	44.5	63.5	114.3	12.7	19.1	63.5	1/2"	61.9	17.3	35.1
	TG12HDHJDS	44.5	63.5	114.3	12.7	19.1	63.5	5/8"	61.9	17.3	35.1
381	TG15MDHJDS	63.5	88.9	140.0	12.7	19.1	76.2	5/8"	79.3	22.4	44.5
	TG15HDHJDS	63.5	88.9	140.0	12.7	19.1	76.2	3/4"	79.3	22.4	44.5



## Metric Tongue & Groove Soft Jaws — Style A

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

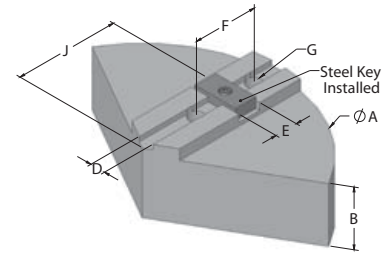


CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE
165	MTG6MDA	MTG6MDS	31.8	38.1	76.2	8.0	18.0	32.0	M8
	MTG6MDA1	MTG6MDS1	31.5	50.8	76.2	8.0	18.0	32.0	M8
210	MTG8MDA	MTG8MDS	38.1	50.8	101.6	10.0	20.0	40.0	M8
	MTG8MDA1	MTG8MDS1	38.1	76.2	101.6	10.0	20.0	40.0	M8
	MTG8MDA2	MTG8MDS2	38.1	101.6	101.6	10.0	20.0	40.0	M8
250	MTG10MDA	MTG10MDS	38.1	50.8	114.3	12.0	20.0	40.0	M12
	MTG10MDA1	MTG10MDS1	38.1	76.2	114.3	12.0	20.0	40.0	M12
	MTG10MDA2	MTG10MDS2	38.1	101.6	114.3	12.0	20.0	40.0	M12
315	MTG12MDA	MTG12MDS	50.8	50.8	139.7	12.0	20.0	40.0	M12
	MTG12MDA1	MTG12MDS1	50.8	76.2	139.7	12.0	20.0	40.0	M12
	MTG12MDA2	MTG12MDS2	50.8	101.6	139.7	12.0	20.0	40.0	M12
406	MTG16MDA	MTG16MDS	63.5	76.2	165.1	12.0	26.0	54.0	M12
	MTG16MDA1	MTG16MDS1	63.5	101.6	165.1	12.0	26.0	54.0	M12
508	MTG20MDA	MTG20MDS	63.5	76.2	209.6	18.0	30.0	60.0	M16
	MTG20MDA1	MTG20MDS1	63.5	101.6	209.6	18.0	30.0	60.0	M16

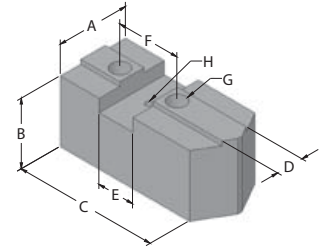
## Metric Tongue & Groove Pie Jaws® — Style D

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel  
Add CI prefix to aluminum part # for cast iron jaws  
Add ST prefix to aluminum part # for steel jaws  
Cast iron version weight is approximately 2.6 times that of aluminum  
Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	E TONGUE	F HOLE SPACING	G BOLT SIZE	J DIM	WEIGHT	
165	MTG6MDP	152.4	50.8	8.0	18.0	32.0	M8	58.7	2.6	
	MTG6MDP1	152.4	101.6	8.0	18.0	32.0	M8	58.7	4.9	
	MTG86MDP	203.2	50.8	8.0	18.0	32.0	M8	58.7	4.6	
210	MTG8MDP	203.2	50.8	10.0	20.0	40.0	M8	76.2	4.6	
	MTG8MDP1	203.2	101.6	10.0	20.0	40.0	M8	76.2	9.0	
	MTG108MDP	254.0	50.8	10.0	20.0	40.0	M8	76.2	7.4	
250	MTG10MDP	254.0	50.8	12.0	20.0	40.0	M12	101.6	7.4	
	MTG10MDP1	254.0	101.6	12.0	20.0	40.0	M12	101.6	14.3	
315	MTG12MDP	304.8	50.8	12.0	20.0	40.0	M12	127.0	10.6	
	MTG12MDP1	304.8	101.6	12.0	20.0	40.0	M12	127.0	20.6	
406	MTG1516MDP	304.8	76.2	12.0	26.0	54.0	M12	152.4	24.4	
	MTG1516MDP1	304.8	101.6	12.0	26.0	54.0	M12	152.4	32.2	
	MTG1816MDP	457.2	76.2	12.0	26.0	54.0	M12	152.4	35.3	
	MTG1816MDP1	457.2	101.6	12.0	26.0	54.0	M12	152.4	46.6	
508	MTG1816MDP6	457.2	152.4	12.0	26.0	54.0	M12	152.4	70.2	
	MTG1820MDP	457.2	76.2	18.0	30.0	60.0	M16	123.0	35.3	
	MTG1820MDP1	457.2	101.6	18.0	30.0	60.0	M16	123.0	46.6	
	MTG2120MDP	533.4	76.2	18.0	30.0	60.0	M16	123.0	47.7	
	MTG2120MDP1	533.4	101.6	18.0	30.0	60.0	M16	123.0	63.1	
	MTG2420MDP	609.6	76.2	18.0	30.0	60.0	M16	123.0	62.7	
	MTG2420MDP1	609.6	101.6	18.0	30.0	60.0	M16	123.0	82.7	
	635	MTG2125MDP	533.4	76.2	18.0	30.0	60.0	M16	190.5	47.7
		MTG2125MDP1	533.4	101.6	18.0	30.0	60.0	M16	190.5	63.1
		MTG2425MDP	609.6	76.2	18.0	30.0	60.0	M16	190.5	62.7
MTG2425MDP1		609.6	101.6	18.0	30.0	60.0	M16	190.5	82.7	



## Acme Serrated Key Soft Jaws — Style C

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE
210	8LPA	8LPS	38.1	50.8	82.6	16.9	15.3	31.8	1/2"	10-32
	8LPA1	8LPS1	38.1	76.2	82.6	16.9	15.3	31.8	1/2"	10-32
250	10A04A	10A04S	50.8	50.8	114.3	19.1	26.2	44.5	1/2"	5/16"-18
	10A04A1	10A04S1	50.8	76.2	114.3	19.1	26.2	44.5	1/2"	5/16"-18
	10A04A2	10A04S2	50.8	101.6	114.3	19.1	26.2	44.5	1/2"	5/16"-18
315	12A04A	12A04S	50.8	50.8	139.7	22.2	26.2	50.8	5/8"	5/16"-18
	12A04A1	12A04S1	50.8	76.2	139.7	22.2	26.2	50.8	5/8"	5/16"-18
	12A04A2	12A04S2	50.8	101.6	139.7	22.2	26.2	50.8	5/8"	5/16"-18
381-450	15A04A	15A04S	63.5	76.2	165.1	25.4	38.9	63.5	3/4"	3/8"-16
	15A04A1	15A04S1	63.5	101.6	165.1	25.4	38.9	63.5	3/4"	3/8"-16
530-610	21A04A	21A04S	76.2	76.2	209.6	31.8	38.9	76.2	7/8"	3/8"-16
	21A04A1	21A04S1	76.2	101.6	209.6	31.8	38.9	76.2	7/8"	3/8"-16

## Acme Serrated Key Pie Jaws® — Style L

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

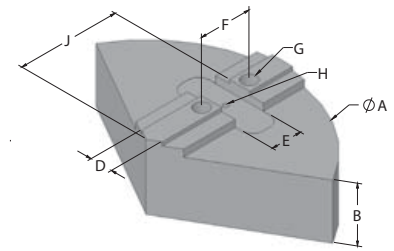
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

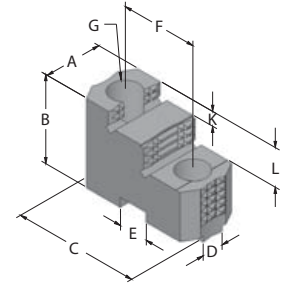
Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D TONGUE	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE	J DIM	WEIGHT
210	8LPP	203.2	50.8	16.9	15.3	31.8	1/2"	10-32	81.0	4.6
	8LPP1	203.2	101.6	16.9	15.3	31.8	1/2"	10-32	81.0	9.0
250	10A04P	254.0	50.8	19.1	26.2	44.5	1/2"	5/16"-18	95.3	7.4
	10A04P1	254.0	101.6	19.1	26.2	44.5	1/2"	5/16"-18	95.3	14.3
	1210A04P	304.8	50.8	19.1	26.2	44.5	1/2"	5/16"-18	95.3	10.6
	1210A04P1	304.8	101.6	19.1	26.2	44.5	1/2"	5/16"-18	95.3	20.6
315	12A04P	304.8	50.8	22.2	26.2	50.8	5/8"	5/16"-18	120.7	10.6
	12A04P1	304.8	101.6	22.2	26.2	50.8	5/8"	5/16"-18	120.7	20.6
	1512A04P	381.0	76.2	22.2	26.2	50.8	5/8"	5/16"-18	120.7	24.4
	1512A04P1	381.0	101.6	22.2	26.2	50.8	5/8"	5/16"-18	120.7	32.2
381-450	15A04P	381.0	76.2	25.4	38.9	63.5	3/4"	3/8"-16	152.4	224.4
	15A04P1	381.0	101.6	25.4	38.9	63.5	3/4"	3/8"-16	152.4	32.2
	15A04P6	381.0	152.4	25.4	38.9	63.5	3/4"	3/8"-16	152.4	47.7
	1815A04P	457.2	76.2	25.4	38.9	63.5	3/4"	3/8"-16	152.4	35.3
	1815A04P1	457.2	101.6	25.4	38.9	63.5	3/4"	3/8"-16	152.4	46.6
530-610	1824A54P1	457.2	101.6	31.8	38.9	76.2	7/8"	3/8"-16	174.6	46.6
	2124A54P1	533.4	101.6	31.8	38.9	76.2	7/8"	3/8"-16	203.2	60.7
	24A54P1	609.6	101.6	31.8	38.9	76.2	7/8"	3/8"-16	204.8	82.9
711+	28A54P1	711.2	101.6	31.8	38.9	76.2	7/8"	3/8"-16	257.2	113.5
	32A54P1	812.8	101.6	31.8	38.9	76.2	7/8"	3/8"-16	257.2	147.5
	42A54P1	1066.8	101.6	31.8	38.9	76.2	7/8"	3/8"-16	257.2	255.4

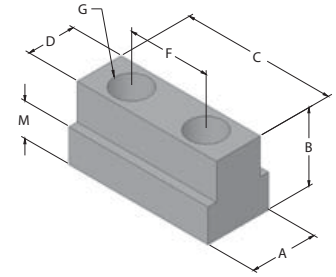


## Acme Serrated Key Hard Jaws

Made with 1018 case hardened steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE	J DIM	K STEP 1	L STEP 2
250	10A04HJDS	44.5	63.5	105.4	19.1	26.2	44.5	1/2"	5/16"-18	63.8	15.7	31.8
315	12A04HJDS	44.5	63.5	132.3	22.2	26.2	50.8	5/8"	5/16"-18	85.1	13.0	28.7
381	15A04HJDS	63.5	88.9	153.2	25.4	38.9	63.5	3/4"	3/8"-16	89.3	20.6	40.6

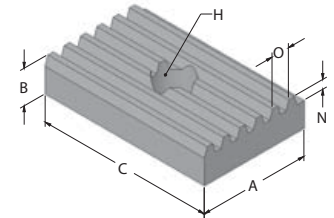


## Jaw Nuts For Acme Serrated Key Chucks

Made with 4140 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	F HOLE SPACING	G BOLT SIZE	M FLANGE
250	10A04JN	23.9	16.3	63.5	17.2	44.5	1/2"	9.7
315	12A04JN	26.9	19.3	76.2	20.4	50.8	5/8"	11.2
381	15A04JN	31.8	23.6	88.9	23.7	63.5	3/4"	14.0

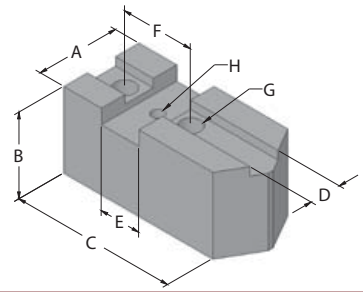


## Acme Serrated Key Master Keys

Made with 4140 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	H BOLT SIZE	N DEPTH	O PITCH
250-315	12A04MK	26.2	12.7	42.9	5/16"	3.3	6.4
381-450	15A04MK	38.9	12.7	62.0	3/8"	3.3	6.4
530-610	21A04MK	38.9	12.7	73.2	3/8"	3.3	6.4



## Square Serrated Key Soft Jaws — Style B

Made with 6061 T-6 condition aluminum or 1018 steel  
Add SQ suffix to part # for square nosed version

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE
65	6A	6S	31.8	38.1	76.2	18.7	9.6	42.9	5/16"	N/A
	6A1	6S1	31.8	50.8	76.2	18.7	9.6	42.9	5/16"	N/A
190	7.5A	7.5S	38.1	50.8	101.6	22.0	9.6	42.9	5/16"	N/A
	7.5A1	7.5S1	38.1	76.2	101.6	22.0	9.6	42.9	5/16"	N/A
210	8A	8S	38.1	50.8	101.6	12.7	18.9	36.5	3/8"	1/4"-20
	8A1	8S1	38.1	76.2	101.6	12.7	18.9	36.5	3/8"	1/4"-20
250-315	12A	12S	50.8	50.8	139.7	19.1	25.2	44.5	1/2"	5/16"-18
	12A1	12S1	50.8	76.2	139.7	19.1	25.2	44.5	1/2"	5/16"-18
	12A-5-8	12S-5-8	50.8	50.8	139.7	19.1	25.2	44.5	5/8"	5/16"-18
	12A1-5-8	12S1-5-8	50.8	76.2	139.7	19.1	25.2	44.5	5/8"	5/16"-18
381	15A	15S	63.5	76.2	165.1	25.4	37.8	63.5	3/4"	3/8"-16
	15A1	15S1	63.5	101.6	165.1	25.4	37.8	63.5	3/4"	3/8"-16

## Square Serrated Key Pie Jaws® — Style E

Made with 6061 T-6 condition aluminum, 319 cast aluminum, cast iron, 1018 steel or A36 steel

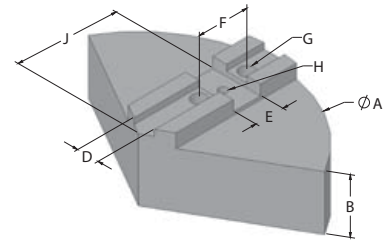
Add CI prefix to aluminum part # for cast iron jaws

Add ST prefix to aluminum part # for steel jaws

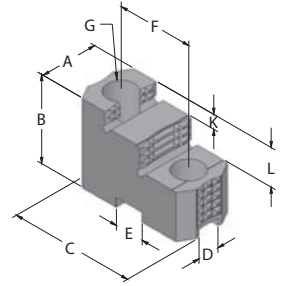
Cast iron version weight is approximately 2.6 times that of aluminum

Steel version weight is approximately 2.8 times that of aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available



CHUCK	ALUMINUM PART#	A DIAMETER	B HEIGHT	D SLOT	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE	J DIM	WEIGHT
165	6P	152.4	50.8	18.7	9.6	42.9	5/16"	N/A	46.0	2.6
	6P1	152.4	101.6	18.7	9.6	42.9	5/16"	N/A	46.0	4.9
190	7.5P	203.2	50.8	22.0	9.6	42.9	5/16"	N/A	46.0	4.6
210	8P	203.2	50.8	12.7	18.9	36.5	3/8"	1/4"-20	76.2	4.6
	8P1	203.2	101.6	12.7	18.9	36.5	3/8"	1/4"-20	76.2	9.0
250	10P	254.0	50.8	19.1	25.2	44.5	1/2"	5/16"-18	95.3	7.4
	10P1	254.0	101.6	19.1	25.2	44.5	1/2"	5/16"-18	95.3	14.3
	10P6	254.0	152.4	19.1	25.2	44.5	1/2"	5/16"-18	95.3	21.3
315	12P	304.8	50.8	19.1	25.2	44.5	1/2"	5/16"-18	117.5	10.6
	12P1	304.8	101.6	19.1	25.2	44.5	1/2"	5/16"-18	117.5	20.6
	12P-5-8	304.8	50.8	19.1	25.2	44.5	5/8"	5/16"-18	117.5	10.6
	12P1-5-8	304.8	101.6	19.1	25.2	44.5	5/8"	5/16"-18	117.5	20.6
381	15P	381.0	76.2	25.4	37.8	63.5	3/4"	3/8"-16	146.1	24.4
	15P1	381.0	101.6	25.4	37.8	63.5	3/4"	3/8"-16	146.1	32.3
450	18P	457.2	76.2	25.4	37.8	63.5	3/4"	3/8"-16	181.0	35.3
	18P1	457.2	101.6	25.4	37.8	63.5	3/4"	3/8"-16	181.0	16.6

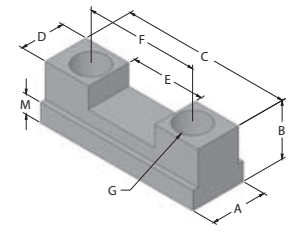


### Square Serrated Key Hard Jaws

Made with 1018 case hardened steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D SLOT	E SLOT	F HOLE SPACING	G BOLT SIZE	H TAPPED HOLE	J DIM	K STEP 1	L STEP 2
250-315	12HJDS	44.5	63.5	96.0	19.1	25.2	44.5	1/2"	5/16"-18	54.8	16.0	31.8
	12HJDS-5-8	44.5	63.5	96.0	19.1	25.2	44.5	5/8"	5/16"-18	54.8	16.0	31.8
381	15HJDS	57.2	76.2	120.7	25.4	37.8	63.5	3/4"	3/8"-16	76.5	19.1	38.1



### Jaw Nuts For Square Serrated Key Chucks

Made with 4140 steel

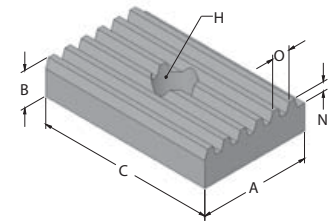
Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	D TONGUE	E SLOT	F HOLE SPACING	G BOLT SIZE	M FLANGE
250-315	12JN	25.4	25.4	62.0	19.1	25.3	44.5	1/2"	9.5
	12JN-5-8	25.4	25.4	63.5	19.1	25.3	44.5	5/8"	9.5
381	15JN	31.8	31.8	95.3	25.4	37.8	63.5	3/4"	11.1

### Square Serrated Key Master Keys

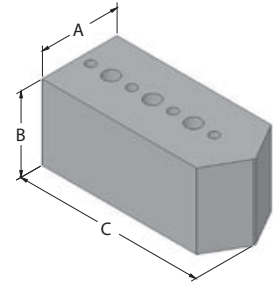
Made with 4140 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available



CHUCK	PART#	A WIDTH	B HEIGHT	C LENGTH	H BOLT SIZE	N DEPTH	O PITCH
250-315	12MK	25.2	12.7	42.9	5/16"	3.3	6.4
381-450	15MK	37.8	12.7	57.2	3/8"	3.3	6.4
530-610	21MK	37.8	12.7	63.5	3/8"	3.3	6.4



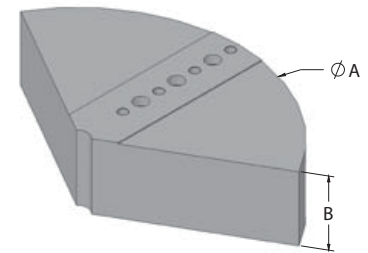


## Pin Locator Soft Jaws — Style R

Made with 6061-T6 aluminum or 1018 steel

Dimensions in millimeters unless otherwise noted • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A WIDTH	B HEIGHT	C LENGTH	# PINS	# HOLES	HOLE SPACING
101.6	AL141.5	ST141.5	19.1	38.1	48.13	3	2	.500
	AL143	ST143	19.1	76.2	48.13	3	2	.500
	MC4150A	MC4150S	19.1	38.1	49.02	3	2	.500
152.4	AL161.5	ST161.5	25.4	38.1	73.53	5	4	.500
	AL162	ST162	25.4	50.8	73.53	5	4	.500
	AL163	ST163	25.4	76.2	73.53	5	4	.500
	MC6200A	MC6200S	25.4	50.8	75.06	3	4	.500
203.2	AL182	ST182	50.8	50.8	93.65	3	2	1.100
	AL183	ST183	50.8	76.2	93.65	3	2	1.100
	AL184	ST184	50.8	101.6	93.65	3	2	1.100
	MC8200A	MC8200S	38.1	50.8	98.22	3	2	1.250
254	AL1102	ST1102	50.8	50.8	119.05	4	3	1.100
	AL1103	ST1103	50.8	76.2	119.05	4	3	1.100
	AL1104	ST1104	50.8	101.6	119.05	4	3	1.100
	MC10200A	MC10200S	38.1	50.8	124.43	3	3	1.250
304.8	AL1123	ST1123	50.8	76.2	144.48	2	2	2.000

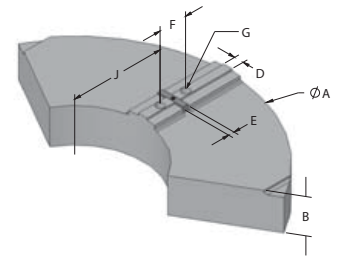


## Pin Locator Pie Jaws® — Style M

Made with 6061 T-6 aluminum or 1018 steel

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK	ALUMINUM PART#	STEEL PART#	A DIAMETER	B HEIGHT	# PINS	# HOLES	HOLE SPACING	ALUMINUM WEIGHT	STEEL WEIGHT
101.6	AL342	ST342	99.6	50.8	2	2	2.000	0.9	2.7
	AL343	ST343	99.6	76.2	2	2	2.000	1.4	4.1
	MC342	STMC342	99.6	50.8	2	2	2.000	0.9	2.7
152.4	AL362	ST362	150.4	0.0	2	2	2.000	0.0	0.0
	AL363	ST363	150.4	0.0	2	2	2.000	0.0	0.0
	AL364	ST364	150.4	101.6	2	2	2.000	4.8	12.8
	MC362	STMC362	50.8	76.2	2	2	2.000	2.4	6.5
177.8	AL372	ST372	175.8	50.6	2	2	2.000	3.4	9.0
	AL373	ST373	175.8	76.2	2	2	2.000	5.1	13.3
203.2	AL382	ST382	201.2	50.8	2	2	2.000	4.8	11.8
	AL383	ST383	201.2	76.2	2	2	2.000	5.7	17.7
	AL384	ST384	201.2	101.6	2	2	2.000	8.8	23.7
	MC382	STMC382	201.2	50.8	2	2	2.000	4.8	11.8
254	AL3102	ST3102	252.0	50.8	2	2	2.000	6.8	18.6
	AL3103	ST3103	252.0	76.2	2	2	2.000	10.2	28.0
	AL3104	ST3104	252.0	101.6	2	2	2.000	13.6	37.4
	MC3102	STMC3102	252.0	50.8	2	2	2.000	6.8	18.6
304.8	AL3122	ST3122	302.8	50.8	2	2	2.000	10.1	25.4
	AL3123	ST3123	302.8	76.2	2	2	2.000	15.1	38.1
	AL3124	ST3124	302.8	101.6	2	2	2.000	20.1	50.8



## Bullard Style Pie Jaws® — Style W

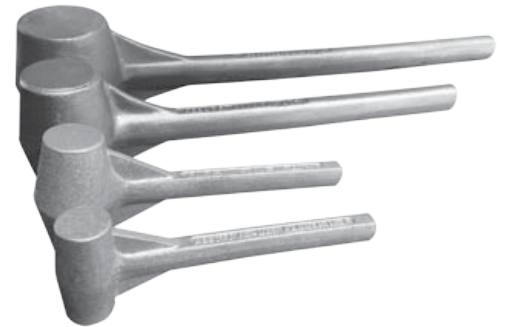
Made with 319 cast aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK	PART #	A DIAMETER	B HEIGHT	D TONGUE	E SLOT	F HOLE SPACING	G BOLT SIZE	J DIM	GAP	WEIGHT
610	24BULLARD	609.6	101.6	25.4	15.9	76.2	7/8"	203.2	6.4	72.3
762	30BULLARD	762.0	101.6	25.4	15.9	76.2	7/8"	228.6	6.4	115.9
914	36BULLARD	914.4	101.6	25.4	15.9	76.2	7/8"	304.8	6.4	144.5
1016	40BULLARD	1016.0	101.6	25.4	15.9	76.2	7/8"	304.8	6.4	188.2
1219	48BULLARD	1219.2	101.6	25.4	15.9	76.2	7/8"	406.4	6.4	240.0

## Aluminum Hammers

Abbott aluminum hammers are the perfect alternative to lead, brass and plastic tipped hammers. Single piece cast construction gives maximum solidity and guarantees safety because head cannot separate from handle. The hammers are non-sparking, non-marring and have excellent vibration dampening characteristics that allow the handle to absorb impact forces instead of your hand. Abbott #1 & #2 hammers are made from certified pure A100 aluminum, which makes them non-contaminating when working with exotic high temperature metals. Abbott #5, & #10 hammers are made from 356-T6 aluminum alloy, making them the perfect choice for heavy work where a more durable and forceful hammer is preferred, without sacrificing non-sparking and non-marring characteristics.



### Aluminum Hammers

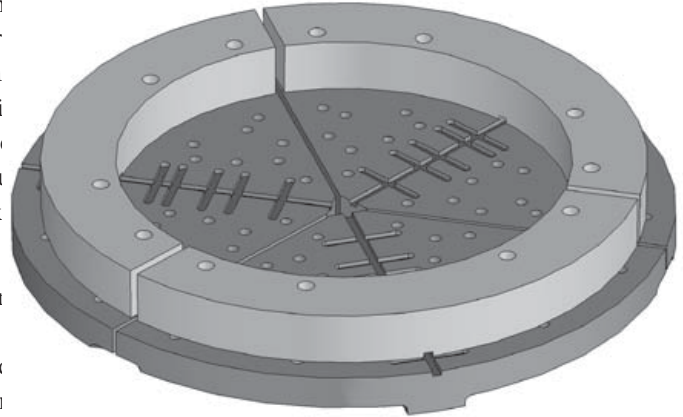
Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

PART #	ALLOY	FACE SIZE	LENGTH	WEIGHT
1HAMMER	A100	41.3mm DIA	304.8	0.8
2HAMMER	A100	50.8mm DIA	330.2	1.5
5HAMMER	356-T6	76.2mm DIA	558.8	4.1
10HAMMER	356-T6	101.6mm DIA	736.6	7.4

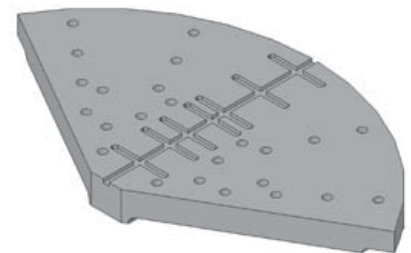
# Master Plates

Abbott's master plate and segment system is a great choice for turn diameter work pieces. The system consists of an aluminum master similar to a thin Pie Jaw®, which is pre-drilled and keyed to accom Abbott's standard, off-the-shelf segment rings. Plates are available i diameters from 15 to 60 inches and can be mounted on 8-60 inch chucks, effectively increasing the holding capability of smaller chu master plate can be custom machined to fit any model chuck, mak permanent universal fixture on any machine.

When using this system, the transition from one job to the next si requires bolting on a new size or configuration of segments before with the next production run. For repeat jobs, machine operators c nate job specific tooling, allowing them to setup in minutes by usi machined segments from a previous run. Segments are available in specific ID/OD ranges, allowing machining time to be spent on making production parts instead of boring out excess jaw material. The master plate and segment system maximizes flexibility between machines because segments can be used to run jobs on any machine that has been fitted with a master plate, regardless of machine or chuck type. In addition to reduced setup and tool preparation time the system enables material and shipping cost savings as well.



- Universal quick change system for any chuck
- Reduce setup and changeover times by up to 80%
- Ideal for machining larger diameter thin walled parts
- Eliminate out of round conditions and concentricity problems
- Effectively double the holding capacity of any chuck without eliminating the ability to hold small parts

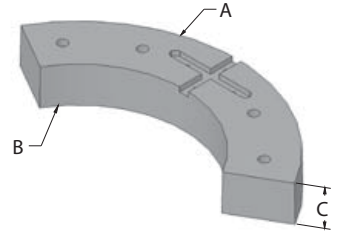


## Master Plates — Style N

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK RANGE	BASE PART#	DIAMETER	SEGMENT DIAMETER RANGE	WEIGHT
200+	15MP	381.0	0 I.D. UP TO 406.4 O.D.	16.4
250+	18MP	457.2	0 I.D. UP TO 558.8 O.D.	22.8
315+	21MP	533.4	0 I.D. UP TO 558.8 O.D.	30.7
315+	24MP	609.6	0 I.D. UP TO 660.4 O.D.	40.0
381+	30MP	762.0	0 I.D. UP TO 812.8 O.D.	63.0
450+	36MP	914.4	0 I.D. UP TO 1016.0 O.D.	90.4
610+	48MP	1219.2	0 I.D. UP TO 1371.6 O.D.	159.0
762+	60MP	1524.0	0 I.D. UP TO 1524.0 O.D.	248.7



## Segments For Master Plates — Style O

Made with 6061 T-6 condition aluminum or 319 cast aluminum

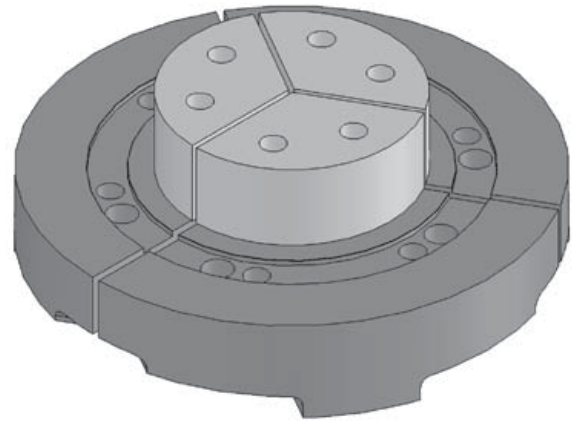
Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

PLATE SIZE	ALUMINUM PART#	A OUTSIDE DIAMETER	B INSIDE DIAMETER	C HEIGHT	WEIGHT	
381+	10SP2	254.0	N/A	50.8	7.0	
	10SP4	254.0	N/A	101.6	13.9	
	10SP6	254.0	N/A	152.4	21.4	
	10SP8	254.0	N/A	203.2	28.9	
	111SP2.5	279.4	25.4	63.5	10.5	
	121SP2.5	304.8	25.4	63.5	12.7	
	131SP2.5	330.2	25.4	63.5	14.9	
	144SP3	355.6	101.6	76.2	19.2	
	145SP3	355.6	127.0	76.2	18.3	
	157SP2	381.0	177.8	50.8	12.5	
	157SP4	381.0	177.8	101.6	25.2	
	157SP6	381.0	177.8	152.4	38.3	
	159SP2	381.0	228.6	50.8	10.2	
	159SP4	381.0	228.6	101.6	20.7	
	161SP4	406.4	25.4	101.6	36.7	
167SP3	406.4	177.8	76.2	22.2		
457+	1812SP2	457.2	304.8	50.8	12.4	
	1812SP4	457.2	304.8	101.6	25.4	
	1812SP6	457.2	304.8	152.4	38.5	
	199SP3	482.6	228.6	76.2	29.7	
	2112SP2	533.4	304.8	50.8	21.0	
	2112SP4	533.4	304.8	101.6	42.3	
	2210SP2	558.8	254.0	50.8	27.2	
	2210SP3	558.8	254.0	76.2	41.0	
533+	2216SP2	558.8	406.4	50.8	16.1	
	2216SP4	558.8	406.4	101.6	32.5	
610+	2415SP2	609.6	381.0	50.8	25.0	
	2415SP4	609.6	381.0	101.6	50.2	
	2418SP2	609.6	457.2	50.8	17.9	
	2418SP4	609.6	457.2	101.6	36.0	
	2418SP6	609.6	457.2	152.4	54.5	
	2618SP2	660.4	457.2	50.8	25.1	
	2618SP4	660.4	457.2	101.6	50.5	
	2618SP6	660.4	457.2	152.4	76.4	
	3015SP4	762.0	381.0	101.6	97.1	
	762+	3024SP2	762.0	609.6	50.8	23.0
3024SP4		762.0	609.6	101.6	46.6	
3024SP6		762.0	609.6	152.4	70.8	
3226SP4		812.8	660.4	101.6	50.2	
914+	3628SP4	914.4	711.2	101.6	73.9	
	3628SP6	914.4	711.2	152.4	112.0	
	3630SP2	914.4	762.0	50.8	28.4	
	3630SP4	914.4	762.0	101.6	57.3	
	3830SP4	965.2	762.0	101.6	78.7	
	4030SP2	1016.0	762.0	50.8	50.3	
	4030SP4	1016.0	762.0	101.6	101.2	
	1219+	4032SP4	1016.0	812.8	101.6	83.3
4232SP4		1066.8	812.8	101.6	107.0	
4236SP2		1066.8	914.4	50.8	33.5	
4236SP4		1066.8	914.4	101.6	67.9	
4434SP2		1117.6	863.6	50.8	56.0	
4434SP4		1117.6	863.6	101.6	112.9	
4838SP2		1219.2	965.2	50.8	61.9	
4842SP2		1219.2	1066.8	50.8	38.9	
4842SP4		1219.2	1066.8	101.6	88.5	
5040SP2		1270.0	1016.0	50.8	64.8	
5040SP4		1270.0	1016.0	101.6	130.5	
5440SP2		1371.6	1016.0	50.8	94.8	
1524		6050SP2	1524.0	1270.0	50.8	79.4

# Precision Master Plates

When it comes to turning/holding smaller diameter parts Abbott's precision master plate and segment system is an ideal choice for high changeover and short running jobs. Due to the system's high repeatability, it is an excellent alternative to more expensive quick change chucks. The system consists of an aluminum master plate, similar to a thin Pie Jaw®, which is bored and bushed to accommodate Abbott's standard, off-the-shelf pinned segments. Plates are available in 8, 10 and 12 inch diameters and can be mounted on 4-12 inch diameter chucks. The master plate can be custom machined to fit any model chuck, making it a permanent universal fixture on any machine.

When using this system, the transition from one job to the next simply requires bolting on a new size or configuration of segments before continuing with the next production run. For repeat jobs, machine operators can designate job specific tooling, allowing them to setup in minutes by using pre-machined segments from a previous run. The master plate and segment system maximizes flexibility between machines because segments can be used to run jobs on any machine that has been fitted with a master plate, regardless of machine or chuck type.



- Universal quick change system for any chuck
- Reduce setup and changeover times by up to 80%
- Eliminate out of round conditions and concentricity problems
- Repeatability < 0.001" TIR

## Precision Master Plates — Style N

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

CHUCK RANGE	BASE PART#	DIAMETER	SEGMENT DIAMETER RANGE	WEIGHT
102+	8MMP-P	203.2	0MM I.D. UP TO 202.2MM O.D.	4.5
127+	10MMP-P	254.0	0MM I.D. UP TO 253.0MM O.D.	7.0
152+	12MMP-P	304.8	0MM I.D. UP TO 303.8MM O.D.	10.3

## Segments For Precision Master Plates — Style O

Made with 6061 T-6 condition aluminum

Dimensions in millimeters unless otherwise noted • Weights in kgs. • Custom configurations available

PLATE SIZE	ALUMINUM PART#	A OUTSIDE DIAMETER	B INSIDE DIAMETER	C HEIGHT	WEIGHT
203-305	6SP2M-P	151.4	N/A	50.8	2.3
	6SP3M-P	151.4	N/A	76.2	3.4
	6SP4M-P	151.4	N/A	101.6	4.5
	8SP2M-P	202.2	N/A	50.8	4.0
	8SP3M-P	202.2	N/A	76.2	6.3
	8SP4M-P	202.2	N/A	101.6	8.2
254-305	10SP2M-P	253.0	N/A	50.8	6.5
	10SP3M-P	253.0	N/A	76.2	10.0
	10SP4M-P	253.0	N/A	101.6	12.9
	12SP2M-P	303.8	N/A	50.8	9.5
	12SP3M-P	303.8	N/A	76.2	14.5
	12SP4M-P	303.8	N/A	101.6	19.1

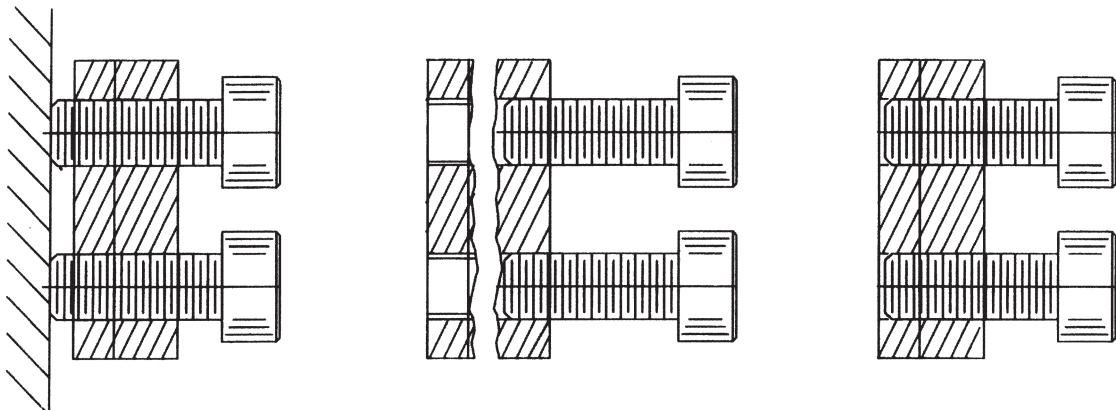


## Mounting Top Jaws

Safe and effective use of top jaws requires strict adherence to established safety guidelines. Consult the machine and chuck manufacturer's operating manual for safe use and limitations. In preparation, wipe the mounting face of each master jaw, and each top jaw, clean off all dirt and chips. Inspect each top jaw before mounting to verify a good material condition.

Now carefully mate the top jaw to the master jaw, making sure of a proper fit between all components. Insert jaw mounting bolts and tighten them evenly and firmly. Use

only high quality fasteners. CAUTION: IT IS CRITICAL THAT THE BOLTS BE OF PROPER LENGTH FOR THE PARTICULAR TOP JAWS BEING USED - see illustration below. Bolts that are TOO LONG will extend through the jaw nut, bottom out, and give the appearance of being properly torqued while not actually securing the top jaw in place. Bolts that are TOO SHORT will have insufficient thread engagement in the jaw nut, and could result in the jaw nut fracturing. Ensure that the master jaw still moves without binding.



**Incorrect**  
**Bolts too long**

**Incorrect**  
**Bolts too short**

**Correct**  
**Full engagement**

## Boring Soft Jaws

The accuracy and concentricity of the soft top jaws is established by precisely boring, or turning, the jaws while mounted on the chuck, in the gripping position. Always carry out this operation with the chuck jaws under pressure, in the same direction as they will be used. For external applications, load the chuck by gripping on a plug and bore the jaws to the dimension of the workpiece. For internal

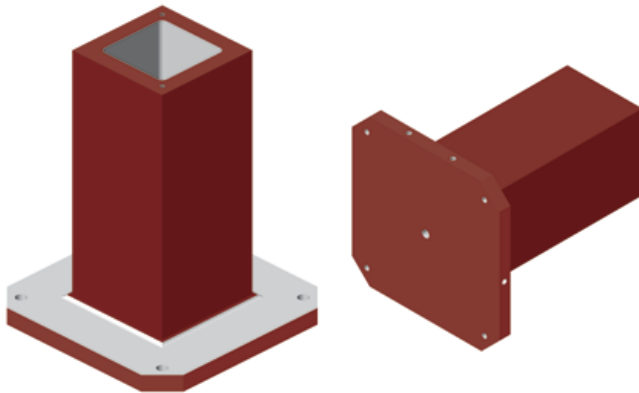
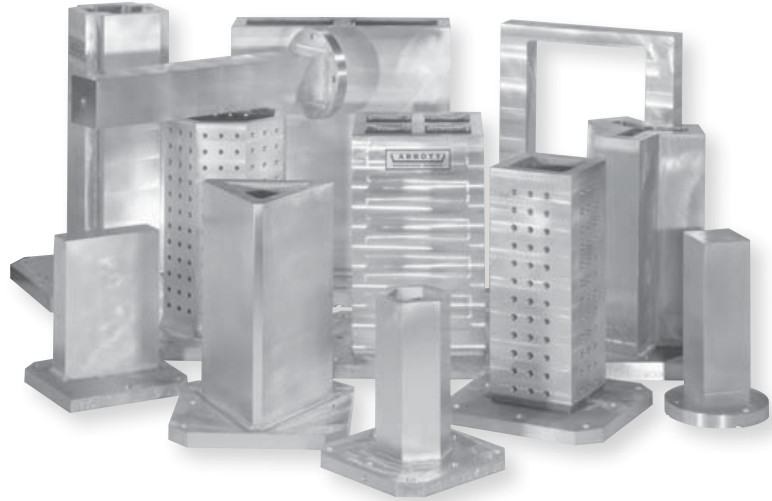
work, load the chuck by opening against a ring or band and turn the gripping surface to the dimension of the workpiece. The pre-loading operation can also be quickly and effectively done with a boring ring. Effective contact between the gripping surface of the jaws and the workpiece may be confirmed by inserting pieces of tissue paper, and then applying chuck pressure.

Always ensure that you have a balanced combination of chuck, jaws, and workpiece. Special care should be given when using oversized jaws. Consult your chuck manual to help determine the maximum safe operating speed for your application. Use of a grip-force analyzer is also recommended.

# Tooling Columns

## Tenzaloy™ Tooling Columns

Abbott tooling columns, made of Tenzaloy™ naturally aged to T-6 condition, provide a practical, inexpensive and lightweight means of holding work accurately in a vertical or horizontal plane for CNC machining operations. They can be mounted directly on a machine table/pallet or used in conjunction with a rotary table. Standard Abbott tooling columns are available in multiple configurations built to any height, width and thickness dimensions required for your application. In addition, base sizes can be customized to fit any machine pallet.



■ Unmachined Surface  
■ Machined Surface on BS Configuration

### Standard tooling column configuration

**BS (base & sides)**—overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock

- Columns are designed to be machined to listed nominal dimensions
- As cast areas have additional stock
- Larger & smaller size bases available upon request

### Tooling Columns:

- Strong, Rigid & Lightweight
- Vibration Dampening
- Corrosion Resistant
- Excellent Machinability
- Custom Sizes and Configurations Available

### Turn Key Solutions:

- In House Design Engineering
- Custom Fixturing

## 713 (Tenzaloy™)

### General Advantages and Characteristics

#### High Strength

Tenzaloy™ is a high-strength aluminum casting alloy that has tensile yield and elongation properties equivalent to the common heat treated alloys such as 195T6, 355T6 and 319T6. The impact strength of Tenzaloy™ is greater than any of these alloys, and in several instances the elongation is higher.

Tenzaloy™ attains its strength by a natural aging process that gradually takes place at room temperature. The typical properties are reached after 10-14 days, and when testing for specification purposes, a 21-day period is used. Some slight further aging and strengthening takes place up to six months, at which time the alloy is stable and no further change of any kind takes place. Test bars held for six years at room temperature have shown that the properties remain constant.

#### Elimination of Heat Treatment

Because Tenzaloy™ is self-aging, no heat treatment is required. The first and most obvious advantage gained is the saving of the cost of the treatment and the extra freight often involved if the heat treating is being done outside the foundry. The process of heat treatment is far from a fool-proof operation, and is subject to many errors and failures (both man and machine).

The solution heat treatment is carried out at as high a temperature as possible for maximum efficiency. This temperature is just below the melting point, and a common cause of difficulty is overheating due to faulty temperature control or hot spots in the furnace. This overheating often results in warped, cracked and, occasionally, melted castings, which are then a complete loss.

The quenching operation which follows solution heat treatment can cause substantial problems with regard to warpage and cracking. When distortion occurs, the castings must be straightened—a troublesome operation which must be performed within a short time after quenching, while the castings are soft.

#### Stress-free, Full-strength Castings

If Tenzaloy™ is given a simple heat treatment of six hours at 468° C. and allowed to air cool (not quenched) it will age normally and result in a stress-free, full-strength casting. This is not possible with any heat treated alloy.

All castings of any alloy will contain internal stresses as a result of the casting process. The solution heat treatment cycle of the heat treated alloys will eliminate these cast stresses, but the quenching operation introduced much greater ones. Conventional T6 aging treatments do not relieve these stresses. Aging treatments which do relieve these quenching stresses (such as T71) result in inferior properties. The cast stresses can be relieved by a simple, one-step aging treatment (T5) but here again inferior properties result.

Thus, through the use of Tenzaloy™, it is possible to obtain castings that have their full strength and yet are stress-free. This is important for uses where close dimensional and straightness tolerances must be maintained, especially where the castings are extensively machined.

#### Dimensional Stability

Tenzaloy™ is dimensionally stable and does not grow or increase in size as do the heat treatable alloys. Actually, fully aged Tenzaloy™ shows a very slight decrease in length of less than 0.025mm per 25.4mm. In contrast to this, heat treated alloys can increase in size as much as 0.10% to 0.15% (0.025mm to 0.038mm per 25.4mm).

#### Machinability

The machinability of Tenzaloy™ is exceptionally good—equal to the very best of aluminum alloys, such as the aluminum-magnesium types. The machinability is greater than the common aluminum-copper or aluminum-silicon heat-treatable alloys. Often it will be found that several machining steps can be eliminated because Tenzaloy™ attains a fine finish with fewer cuts. Also, Tenzaloy™ may be machined at the highest possible speeds. As can be seen from the mechanical property tables and aging curves, immediately after casting, the alloy is relatively soft and ductile. If machined at this point the castings will give the impression of being gummy. Even though many machining operations are performed soon after casting, best results will be obtained if the castings are allowed to age about five days. Although the typical properties are not reached until ten to fourteen days, sufficient hardening will have taken place in five days to materially improve machinability.

Tenzaloy™ is readily polished to a high luster with a silvery-white color. The time when the ability to be polished will be best will vary somewhat with the preferences of the polisher. One who prefers a soft metal, easily smeared, will like to polish soon after casting. One who prefers a hard metal easily cut, will prefer a casting that has aged and hardened.

#### Anodizing

Tenzaloy™ can be readily anodized by standard procedures and will produce a white color superior to alloys containing copper and/or silicon. The anodized coating may be dyed any available color. It should be emphasized that the surfaces of sand castings in any alloy are prone toward porosity of many kinds, and that if coloring is being considered, the surfaces must contain a minimum of porosity for satisfactory dye application.

#### Brazing

Because of its high melting range of 607-652° C., Tenzaloy™ is one of the few casting alloys which can be brazed at temperatures of 552-607° C. Conventional techniques may be used, such as oven, torch or flux-bath dip methods. Tenzaloy™ can be brazed to itself, to extruded aluminum sections, or to other forms of the proper alloys.

#### Corrosion Resistance

Tenzaloy™ has excellent corrosion resistance, equivalent to the aluminum-silicon alloys. Tenzaloy™ compares favorably with other high strength alloys in that the alloy is not susceptible to acceleration of corrosion by stress (below 80% of the yield strength) nor to stress corrosion cracking. The alloy exhibited a negligible loss of mechanical properties after immersion in aerated 3% water solution of sodium chloride for ninety days, and the small surface attack that was present was found to be uniform without pitting. This uniformity of resistance is not encountered with the aluminum-silicon alloys commonly considered to be corrosion resistant.

## General Applications

Since Tenzaloy™ has mechanical properties equivalent to the common heat-treated alloys, it may be substituted in applications where a heat-treated alloy is presently being used. Tenzaloy™ is used in any high strength application where load carrying capacity and impact strength is desired. This may be almost any type of casting of this nature, including frames, brackets, levers, bases, housing, heavy duty fan blades, etc. The high machinability and fine finishes obtainable have been sufficient reason alone for the use of Tenzaloy™ in many instances.

Tenzaloy™ has often been used for the production of large, high strength castings where heat-treated alloys could not be used because of the lack of sufficiently large heat treating facilities.

The dimensional stability, ease of machining, and the ability to make stress-free castings is of great value in applications where strength and close tolerances are essential, such as instrument frames, housings and components.

The ability to be brazed has resulted in the widespread use of Tenzaloy™ (cast by all methods) for such things as radar wave guide, plumbing and gasoline pump fittings.

The ease of polishing and brilliant surface obtainable make it ideal for castings requiring this type of finish.

Tenzaloy™ has been successfully used in applications involving pressure tightness. In such applications, as with all aluminum alloys, particular attention must be given to gating and risering to insure proper feeding of the casting.

Tenzaloy™ has replaced malleable iron in many applications, often with no changes in design. In other instances, the change has been made with but minor changes in design to compensate for the lower modulus of elasticity of aluminum as compared to iron base alloys. Many small brackets, levers, and particularly anything that must be carried, lifted, or shipped long distances, can be advantageously converted to Tenzaloy™ alloy.

Tenzaloy™ is most easily welded by the insert gas shielded arc process using 43S or similar filler rod. By this means, excellent welds may be obtained between Tenzaloy™ components and between Tenzaloy™ and most other aluminum shapes, cast or wrought. High strength welds can be obtained with the use of Tenzaloy™ filler, but greater skill is necessary.

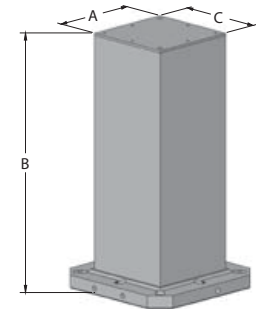
# Universal Mount Tooling Columns

Abbott's pre-machined universal mount columns are available as a stock option to our standard made to order fixtures. Machined bases include both center and edge locating details as well as a selection of slotted mounting bolt holes, allowing them to be used on virtually any machine tool with corresponding pallet size. In addition to the universal base machining, the faces are machined per "BS" specifications and a top plate is provided when applicable. An adaptor washer kit is provided for use with 1/2-13 or M12 mounting bolts.

*UM—Overall height machined, base machined with universal mounting details and faces machined with .015" additional stock.  
As cast areas have additional stock.*

*Made with 713 Tenzaloy™ aluminum alloy*

*Dimensions in mm unless otherwise noted • Finished weight in kgs.*

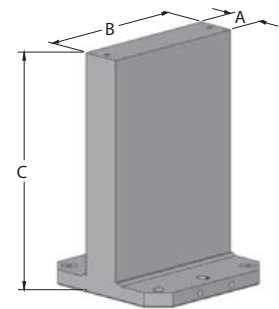


PART NUMBER	A	B	C	BASE SIZE	WEIGHT
N824-400UM	203.2	609.6	203.2	400mm x 38mm	58
N1024-400UM	254.0	609.6	254.0	400mm x 38mm	70
N1028-400UM	254.0	711.2	254.0	400mm x 38mm	81
N1028-500UM	254.0	711.2	254.0	500mm x 38mm	90
N1228-500UM	304.8	711.2	304.8	500mm x 38mm	103
N1232-500UM	304.8	812.8	304.8	500mm x 38mm	117
NR1638-630UM	406.4	965.2	406.4	630mm x 38mm	254

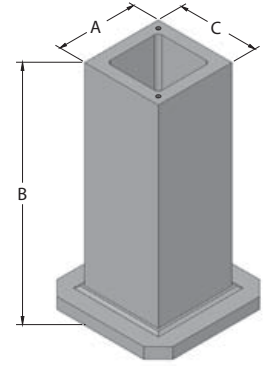
*UM—Overall height machined, base machined with universal mounting details and faces machined with .015" additional stock.  
As cast areas have additional stock.*

*Made with 713 Tenzaloy™ aluminum alloy*

*Dimensions in mm unless otherwise noted • Finished weight in kgs.*



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
D41624-400UM	101.6	400.0	609.6	400mm x 38mm	82
D62028-500UM	152.4	500.0	711.2	500mm x 38mm	172
D82028-500UM	203.2	500.0	711.2	500mm x 38mm	125
D82032-500UM	203.2	500.0	812.8	500mm x 38mm	140
D82538-630UM	203.2	630.0	965.2	630mm x 38mm	250



## Square Tooling Columns

*BS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.*

*Alternative heights and base sizes available.*

*Custom configurations quoted per request.*

*Made with 713 Tenzaloy™ aluminum alloy*

*Dimensions in millimeters unless otherwise noted • Weights in kgs.*

PART NUMBER	A	B	C	BASE SIZE	WEIGHT
N426-400BS	101.6	660.4	101.6	400mm x 38mm	36
N522-400BS	127.0	558.8	127.0	400mm x 38mm	30
N626-400BS	152.4	660.4	152.4	400mm x 38mm	36
N824-400BS	203.2	609.6	203.2	400mm x 38mm	58
N828-400BS	203.2	711.2	203.2	400mm x 38mm	66
N828-500BS	203.2	711.2	203.2	500mm x 38mm	75
N832-500BS	203.2	812.8	203.2	500mm x 38mm	82
N1024-400BS	254.0	609.6	254.0	400mm x 38mm	71
N1028-400BS	254.0	711.2	254.0	400mm x 38mm	81
N1028-500BS	254.0	711.2	254.0	500mm x 38mm	90
N1032-500BS	254.0	812.8	254.0	500mm x 38mm	100
N1036-500BS	254.0	914.4	254.0	500mm x 38mm	109
N1224-400BS	304.8	609.6	304.8	400mm x 38mm	78
N1228-400BS	304.8	711.2	304.8	400mm x 38mm	96
N1228-500BS	304.8	711.2	304.8	500mm x 38mm	105
N1232-500BS	304.8	812.8	304.8	500mm x 38mm	117
N1232-630BS	304.8	812.8	304.8	630mm x 38mm	133
N1236-630BS	304.8	914.4	304.8	630mm x 38mm	144
NR1430-630BS	355.6	762.0	355.6	630mm x 44mm	190
NR1436-630BS	355.6	914.4	355.6	630mm x 44mm	220
NR1628-500BS	406.4	711.2	406.4	500mm x 38mm	181
NR1628-630BS	406.4	711.2	406.4	630mm x 38mm	197
NR1638-630BS	406.4	965.2	406.4	630mm x 38mm	255
NR1834-630BS	457.2	863.6	457.2	630mm x 38mm	259
NR1838-630BS	457.2	965.2	457.2	630mm x 38mm	286
NR2238-630BS	558.8	965.2	558.8	630mm x 50mm	441
NR2438-800BS	609.6	965.2	609.6	800mm x 50mm	516
NR2450-800BS	609.6	1270.0	609.6	800mm x 50mm	658
NR2946BS	731.5	1168.4	731.5	1000mm x 800mm x 57mm	826
NR2946-1000BS	731.5	1168.4	731.5	1000mm x 57mm	854
NR3253-1000BS	812.8	1346.2	812.8	1000mm x 50mm	1146
NR3753-1000BS	939.8	1346.2	939.8	1000mm x 63mm	1028



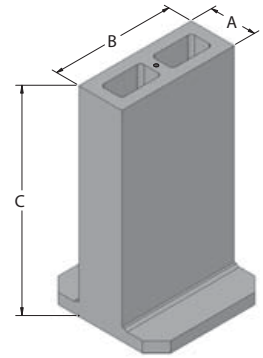
## Two-Sided Tooling Columns

BS (Base & Sides)—Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.

Alternative heights and base sizes available. Custom configurations quoted per request.

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs.



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
D31620-400BS	76.2	400.0	495.3	400mm x 38mm	57
D4820-400BS	101.6	203.2	495.3	400mm x 38mm	44
D41218-400BS	101.6	304.8	457.2	400mm x 38mm	54
D41624-400BS	101.6	400.0	609.6	400mm x 38mm	83
D41624-500BS	101.6	406.4	609.6	500mm x 50mm	101
D61220-400BS	152.4	304.8	508.0	400mm x 38mm	79
D61628-400BS	152.4	400.0	711.2	400mm x 38mm	90
D62028-500BS	152.4	500.0	711.2	500mm x 38mm	172
D62530-630BS	152.4	630.0	762.0	630mm x 50mm	250
D63638-630BS	152.4	914.4	965.2	630mm x 50mm	419
D63753-1000BS	152.4	939.8	1346.2	1000mm x 50mm	665
D81624-400BS	203.2	400.0	609.6	400mm x 38mm	90
D81626-500BS	203.2	406.4	660.4	500mm x 63mm	121
D82028-500BS	203.2	500.0	711.2	500mm x 38mm	126
D82032-500BS	203.2	500.0	812.8	500mm x 38mm	141
D82538-630BS	203.2	630.0	965.2	630mm x 38mm	251
D83440BS	203.2	863.6	1016.0	800mm x 630mm x 50mm	317
D102536-630BS	254.0	630.0	914.4	630mm x 50mm	259
D102542-630BS	254.0	630.0	1066.8	630mm x 50mm	296
D103046-800BS	254.0	762.0	1168.4	800mm x 50mm	399
D121521-500BS	304.8	381.0	533.4	500mm x 38mm	105
D144949BS	355.6	1250.0	1250.0	1000mm x 800mm x 76mm	880
D163940BS	406.4	1000.0	1016.0	1000mm x 800mm x 50mm	630

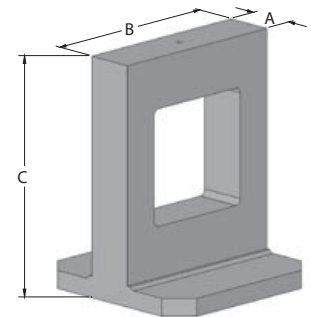
## Window Tooling Columns

BS (Base & Sides)—Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.

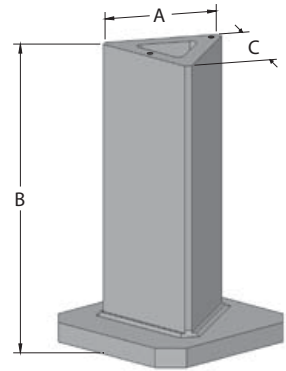
Alternative heights and base sizes available. Custom configurations quoted per request.

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs.



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
W31628-400BS	76.2	400.0	711.2	400mm x 38mm	49
W41620-400BS	101.6	400.0	508.0	400mm x 38mm	54
W42029-500BS	101.6	500.0	736.6	500mm x 38mm	73
W42537-630BS	101.6	630.0	939.8	630mm x 50mm	141
W43434-630BS	101.6	863.6	863.6	630mm x 50mm	143



## Triangle Tooling Columns

*BS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.*

*Alternative heights and base sizes available.*

*Custom configurations quoted per request.*

*Made with 713 Tenzaloy™ aluminum alloy*

*Dimensions in millimeters unless otherwise noted • Weights in kgs.*

PART NUMBER	A	B	C	BASE SIZE	WEIGHT
T6287-400BS	152.4	711.2	180.3	400mm x 50mm	72
T6287-500BS	152.4	711.2	180.3	500mm x 50mm	84
T8288-400BS	213.4	711.2	205.7	400mm x 50mm	68
T10269-500BS	254.0	660.0	234.0	500mm X 44mm	75
T122611-500BS	300.0	660.4	276.9	500mm x 44mm	85
T123011-500BS	300.0	762.0	276.9	500mm x 44mm	95
T142813-630BS	368.3	711.2	335.3	630mm x 44mm	124
T143813-630BS	368.3	965.2	335.3	630mm x 44mm	152

## Hexagon Tooling Columns

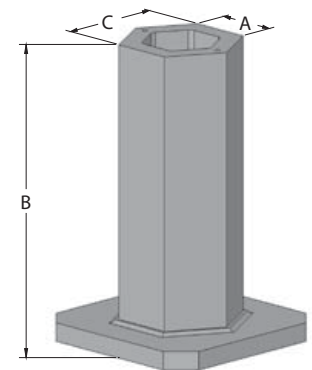
*SBS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.*

*Alternative heights and base sizes available.*

*Custom configurations quoted per request.*

*Made with 713 Tenzaloy™ aluminum alloy*

*Dimensions in millimeters unless otherwise noted • Weights in kgs.*



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
H4187-400BS	101.6	457.2	177.8	400mm x 38mm	34
H5249-400BS	127.0	609.6	221.0	400mm x 38mm	57
H82814-500BS	203.2	711.2	353.1	500mm x 38mm	96
H92816-630BS	228.6	711.2	396.2	630mm x 44mm	141
H93616-630BS	228.6	914.4	396.2	630mm x 44mm	169
H165028-800BS	406.4	1270.0	706.1	800mm x 50mm	622
H165028BS	406.4	1270.0	706.1	1000mm x 800mm x 50mm	654

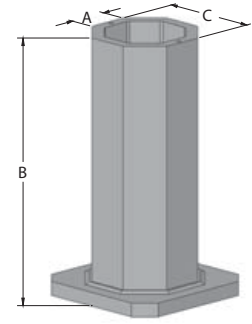
## Octagon Tooling Columns

BS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.

Alternative heights and base sizes available. Custom configurations quoted per request.

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs.



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
O42811-400BS	116.8	711.2	279.4	400mm x 38mm	68
O42811-500BS	116.8	711.2	279.4	500mm x 38mm	77
O52812-500BS	127.0	711.2	307.3	500mm x 38mm	91
O62816-500BS	165.1	711.2	398.8	500mm x 38mm	110
O63616-630BS	165.1	914.4	398.8	630mm x 38mm	158

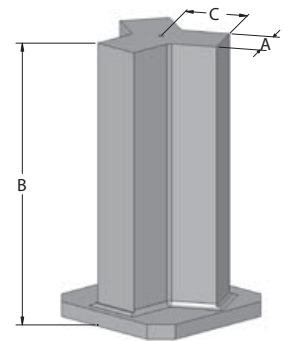
## Y-Shaped Tooling Columns

BS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.

Alternative heights and base sizes available. Custom configurations quoted per request.

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs.



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
Y3286-500BS	78.7	711.2	152	500mm x 38mm	90
Y5286-400BS	127.0	711.2	160	400mm x 38mm	119
Y5286-500BS	127.0	711.2	160	500mm x 38mm	129
Y6288-500BS	152.4	711.2	198	500mm x 50mm	136
Y6348-630BS	152.4	863.6	198	630mm x 50mm	180
Y84010BS	203.2	1016.0	254	1000mm x 800mm x 50mm	345

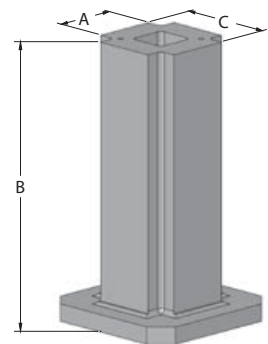
## X-Shaped Tooling Columns

BS (Base & Sides)–Overall height machined, base machined with pallet specific mounting details and faces machined with .015" additional stock. As cast areas have additional stock.

Alternative heights and base sizes available. Custom configurations quoted per request.

Made with 713 Tenzaloy™ aluminum alloy

Dimensions in millimeters unless otherwise noted • Weights in kgs.



PART NUMBER	A	B	C	BASE SIZE	WEIGHT
X42812-500BS	101.6	711.2	304.8	500mm x 38mm	118
X4248-400BS	114.3	609.6	203.2	400mm x 38mm	71
X62812-500BS	152.4	711.2	304.8	500mm x 50mm	112
X62812-630BS	152.4	711.2	304.8	630mm x 50mm	133
X63412-500BS	152.4	863.6	304.8	500mm x 50mm	130
X63812-630BS	152.4	965.2	304.8	630mm x 50mm	163
X62810-400BS	165.1	711.2	254.0	400mm x 44mm	108
X62810-500BS	165.1	711.2	254.0	500mm x 44mm	119
X83414-630BS	203.2	863.6	355.6	630mm x 50mm	205
X83814-630BS	203.2	965.2	355.6	630mm x 50mm	224

## Warranty

**A**BBOTT warrants that its goods will conform to the description and specifications as set forth in the latest ABBOTT product catalog or in purchase orders received and accepted by ABBOTT.

ABBOTT further warrants that the goods shall be free from defects in material and workmanship. Minor surface porosity is not to be considered a defect for purposes of this warranty.

This warranty is expressly made in lieu of any and all other warranties, expressed or implied, including the warranties of merchantability and fitness. There are no other warranties which extend beyond the description in this agreement.

### Limitations of Remedies

The exclusive remedy in the event that any of the goods do not conform to the description of ABBOTT's standard warranty shall be replacement or repair of the goods at the option of ABBOTT.

Except as otherwise agreed upon herein, ABBOTT shall not be liable for special or consequential damages, such as, but not limited to, damage or loss of other property or equipment,

loss of profits or revenue, loss of use of power system, cost of capital, cost of purchased or replacement parts or claims of third persons or parties.

The remedies set forth herein are exclusive and the liability of ABBOTT with respect to goods sold or ancillary claims arising from the use of any goods manufactured by ABBOTT, whether such remedies are based on contract, tort, strict liability or other warranty theories, shall not, except as expressly provided for herein, exceed the price of the goods or the part or portion of the goods on which such liability or claim is based.

All goods claimed to be non-conforming must be shipped to MANUFACTURER's Manhattan, Kansas plant at MANUFACTURER's expense. Such goods will be repaired or replaced within a reasonable time. ABBOTT's acceptance of any goods so shipped shall not be deemed an admission that the goods are non-conforming, and if ABBOTT finds that any goods returned are not defective, such goods will be re-shipped to purchaser and purchaser will be charged all shipping charges incurred by ABBOTT.

### Return Policy

#### Standard Chuck Jaws

All standard chuck jaws may be returned to Abbott within 6 months of invoice/shipping date.

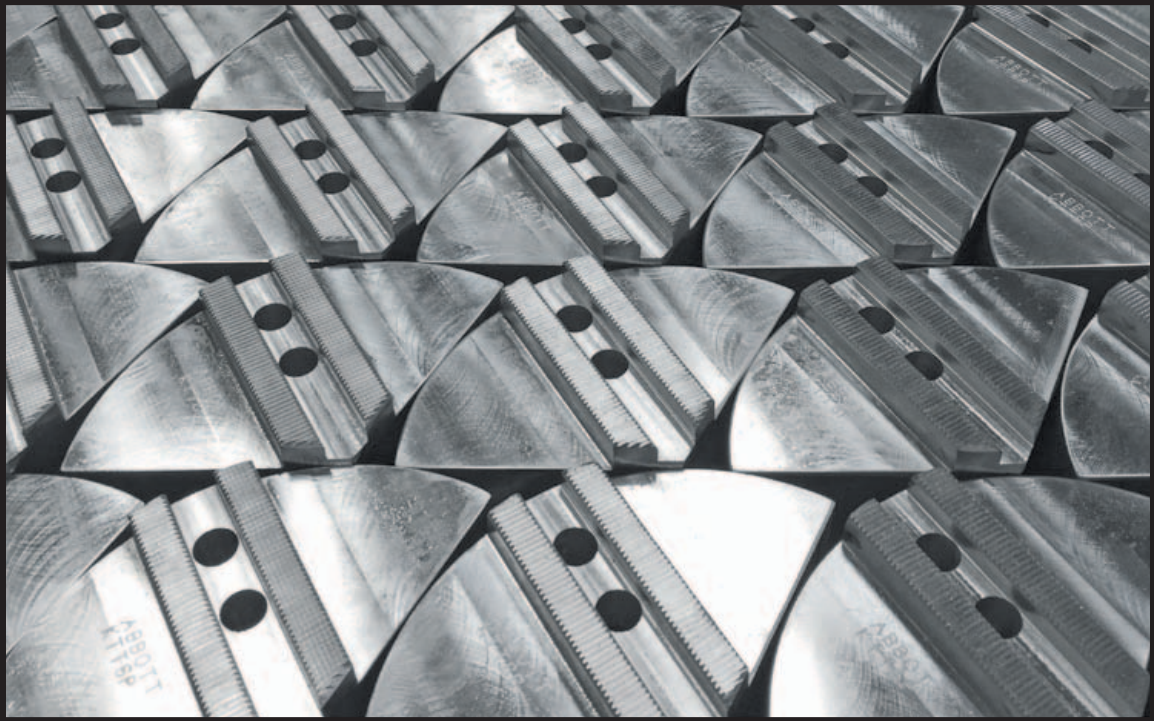
After 6 months from invoice date, goods may not be returned unless special circumstances exist and return is approved by Abbott.

All returned goods must be assigned an RMA number by Abbott prior to being returned. All returned goods must be inspected by Abbott and accepted into inventory prior to credit being applied.

All returned goods are subject to a 15% restocking fee unless Abbott is at fault due to inaccurate order processing or incorrect manufacturing.

#### Made to order chuck jaws, master plates and fixtures

All made to order products, including special chuck jaws, master plates and fixtures, may not be returned unless special circumstances exist and return is approved by Abbott.



# **ABBOTT**

**WORKHOLDING PRODUCTS**

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Since 1954