

Power Chuck Selection Guide

When selecting a new power chuck, it is important that you are aware of all specifications and requirements of your machine.

Please complete the worksheet below and fax to 231-947-4953 or call us at 800-228-BUCK

CHUCK OUTSIDE DIAMETER SELECTION

Inch	5	6.25	8	10	12.5	15.75	24	32
MM	125	160	200	250	315	400	610	800
*Chuck outside diameter should be selected in reference to the min-max workpiece diameter (inside or outside) **See chuck clamping ranges on pages 18 to 25								

CHUCK TYPE SELECTION

Type of Chuck	# Jaws	Plain Back	A Mount	Other Mount	Page #
Open Center					18,19,24
Closed Center					20,21,24
Air Clamping					22
Stationary					23
2/3 Jaw Combination					25
Other					Contact sales office

*Select the proper type of chuck in reference to the chuck application, machining requirements and workpiece dimensions.

LATHE SPINDLE NOSE SELECTION

*To determine proper spindle type and size (A and D) refer to page 10

CHUCK WORKING PARAMETER SELECTION

Min. Chuck Hole Diameter	inch		
Workpiece Diameter min-max	inch		
Workpiece Length min-max	inch		
Weight of Workpiece min-max	lbs		
Maximum Draw Bar Pull Force	Lbf/kN		
Maximum Gripping Force	Lbf/kN		
Maximum Machining Speed	rpm		

THREADED NUT AND DRAW TUBE SELECTION

The overall length of the draw tube can be calculated after determining the distance between the face of the cylinder back plate and the face of the lathe spindle nose.

It is important to know the thread of your existing draw tube or draw bar. Compare to the threading of the chuck you are selecting to be sure they match. If not, special draw nuts are offered.