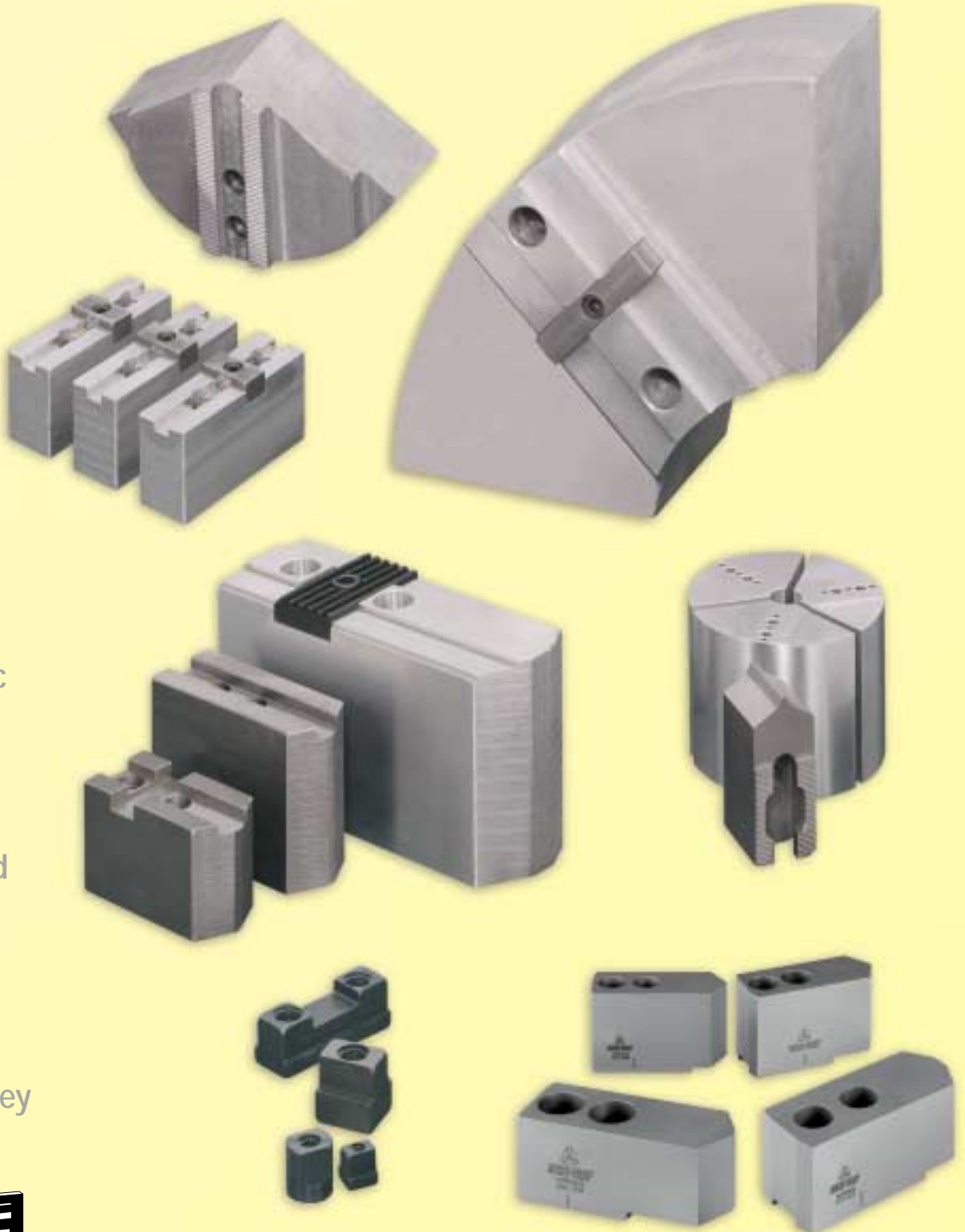


Hardinge® Chuck Jaws for All Brands of Power and Manual Chucks

Autoblok
Bergman
Bison
Buck
Bullard
Cadillac
Cushman
Ericson
Forkardt
Fuji
Gamet
Gisholt
Hardinge
Howa
Kitagawa
Logansport
Matsumoto
Micro-Centric
MMK
Nobel
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Powerhold
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ROHM
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S-P
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SMW
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Hardinge®

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Workholding/
Industrial
Products
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Hardinge corporate headquarters and manufacturing facility, Elmira, New York, USA

For over 110 years, Hardinge has designed and manufactured workholding products for the turning segment of the machine tool industry worldwide. As the Hardinge product lines broadened from manual lathes into CNC horizontal, vertical, gang tool and Swiss-type lathes, VMC milling machines, high-precision grinders, and ram and wire EDM machines, we expanded our workholding/industrial products to support these innovative machine tools.

Hardinge is unique as a workholding product manufacturer. We are so confident in the products we manufacture that we use them in the production of our own machines, tooling, accessories.

Hardinge is committed to being the single source for all of your workholding/industrial products and metal cutting needs. We know what works from actual practice. Hardinge can solve your problems, using our many years of hands-on experience.

This brochure will help you select the proper jaws for all the chucks used throughout your manufacturing facility. To place an order, call 800-843-8801 or fax 607-734-3886. Use the same toll-free number for technical questions. You may also use one of our web sites to obtain product information: www.hardinge.com or www.hardingeworkholding.com.

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People's Republic of China

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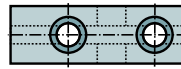
<i>Chuck</i>	<i>Style Straight/Pie</i>	<i>Type(s) of Top Jaw</i>
AUTOBLOK	C/L	Acme Serrated Key
	J/K	1/16" x 90° Serrated Bottom
	P/Q	1.5mm x 60° Serrated Bottom
BERGMAN	A/D	American Standard Tongue and Groove—Medium and Heavy Duty
BISON	A/D	American Standard Tongue and Groove—Medium Duty
BUCK	A/D	American Standard Tongue and Groove—Medium and Heavy Duty
	B/E	Square Serrated Key
	B/E	6" x 7" Manual
BULLARD	C/W	Slot-Type, 3- and 4- Jaw
CADILLAC	A/D	Tongue & Groove
CUSHMAN	A/D	American Standard Tongue and Groove—Medium and Heavy Duty
	C/L	Acme Serrated Key
ERICSON	J/K	1/16" x 90° Serrated Bottom
FORKARDT	J/K	1/16" and 3/32" x 90° Serrated Bottom
	A/D	Metric Tongue and Groove
FUJI	A/S	3mm x 60° Serrated Bottom
GAMET	J/K	1/16" x 90° Serrated Bottom
GISHOLT	B/E	Square Serrated Key
HARDINGE®	J/K	1/16" x 90° Serrated Bottom
	P/Q	1.5mm x 60° Serrated Bottom
HOWA	H/S	1.5mm x 60° Serrated Bottom
	P/Q	1.5mm x 60° Serrated Bottom
	C/L	Acme Serrated Key (12" and 15")
	J/K	1/16" x 90° Serrated Bottom
IMPORT		Many Styles Available
JAPANESE	P/Q	1.5mm x 60° Serrated Bottom
	H/S	3mm x 60° Serrated Bottom
KITAGAWA	P/Q	1.5mm x 60° Serrated Bottom
	H/S	3mm x 60° Serrated Bottom
LOGANSPOURT	A/D	American Standard Tongue and Groove—Heavy Duty
	B/E	Square Serrated Key
	C/L	Acme Serrated Key
MATSUMOTO	P/Q	1.5mm x 60° Serrated Bottom
	H/S	3mm x 60° Serrated Bottom
MICRO-CENTRIC	R/M	Precision Air Chucks
MMK	P/Q	1.5mm x 60° Serrated Bottom
	H/S	3mm x 60° Serrated Bottom
NOBEL	A/D	American Standard Tongue and Groove—Heavy Duty
NORTHFIELD	R/M	Precision Air Chucks
POWERHOLD	J/K	1/16" x 90° Serrated Bottom
PRATT BURNERD	A/D	American Standard Tongue and Groove—Medium and Heavy Duty
	C/L	Acme Serrated Key
	P/Q	1.5mm x 60° Serrated Bottom
ROHM	A/D	American Standard Tongue and Groove—Medium Duty
	J/K	1/16" x 90° Serrated Bottom
SCA	A/D	American Standard Tongue and Groove—Medium Duty
S-P	A/D	American Standard Tongue and Groove—Medium and Heavy Duty
	C/L	Acme Serrated Key
SEIKI	P/Q	1.5mm x 60° Serrated Bottom
	H/S	3mm x 60° Serrated Bottom
SMW	J/K	1/16" x 90° & 3/32" x 90° Serrated Bottom
	A/D	Metric Tongue and Groove
WARNER/SWASEY	A/D	American Standard Tongue & Groove—Medium and Heavy Duty
	H/S	Square Serrated Key
WOODWORTH	A	Dovetail—Air-Operated Diaphragm Chucks
YUASA	A/D	American Standard Tongue and Groove—Medium Duty

Style A

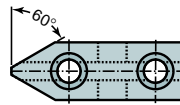
Aluminum Jaws for American Standard Tongue and Groove

See Style "D" for corresponding Pie Jaws®

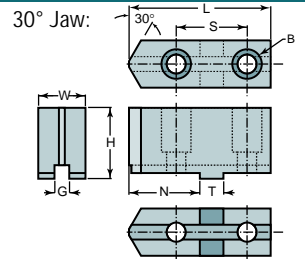
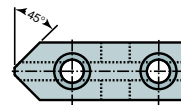
Flat Jaw:



60° Jaw:



45° Jaw:



Made with 6061 T-6 Condition Aluminum

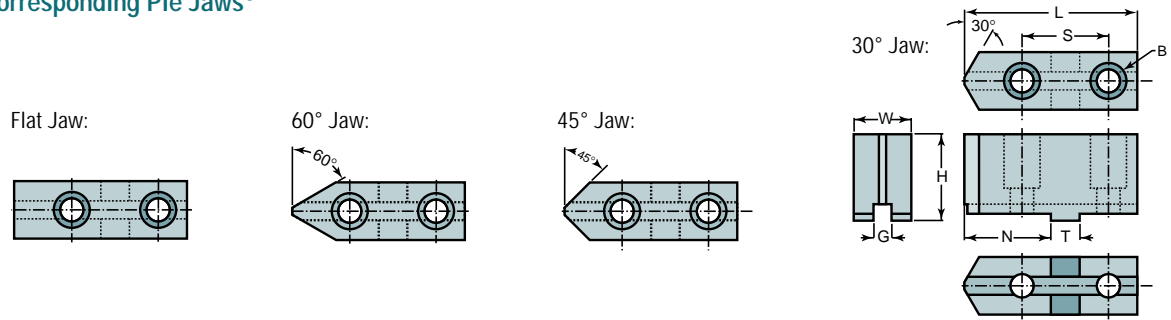
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Type Nose	Weight (lb) Set of 3
4	4MDA	SC-0000001A	5/8	1-1/4	2	.250	.437	1-3/16	1/4	7/8	SQ	.3
	5	5MDA	SC-0000002A	3/4	1-1/2	2-3/8	.312	.500	1-1/4	5/16	1-1/8	SQ
6	6MDA-1	SC-0000003A	1	1-1/2	3	.312	.500	1-1/2	3/8	1-1/2	SQ	1.3
	6HDA-1	SC-0000004A	1	1-1/2	3	.312	.500	1-1/2	7/16	1-1/2	SQ	1.3
	6MDA-4	SC-0000005A	1	1-1/2	3	.312	.500	1-1/2	3/8	1-1/2	30°	1.3
	6HDA-4	SC-0000006A	1	1-1/2	3	.312	.500	1-1/2	7/16	1-1/2	30°	1.3
	6MDA-2	SC-0000007A	1-1/2	1-1/2	3-3/8	.312	.500	1-1/2	3/8	1-7/8	45°	1.3
	6HDA-2	SC-0000008A	1-1/2	1-1/2	3-3/8	.312	.500	1-1/2	7/16	1-7/8	45°	1.8
	6MDA-6	SC-0000009A	1-1/2	2-1/2	3-3/8	.312	.500	1-1/2	3/8	1-7/8	45°	2
	6HDA-6	SC-0000010A	1-1/2	2-1/2	3-3/8	.312	.500	1-1/2	7/16	1-7/8	45°	2
	6MDA-3	SC-0000011A	1	2	3-1/8	.312	.500	1-1/2	3/8	1-1/2	45°	2
	6HDA-3	SC-0000012A	1	2	3-1/8	.312	.500	1-1/2	7/16	1-1/2	45°	2
8	6MDA-5	SC-0000013A	1	3	3-1/8	.312	.500	1-1/2	3/8	1-1/2	30°	2.5
	6HDA-5	SC-0000014A	1	3	3-1/8	.312	.500	1-1/2	7/16	1-1/2	30°	2.5
	8MDA	SC-0000015A	1-1/4	2	3-3/8	.312	.500	1-3/4	3/8	1-5/8	SQ	2
	8HDA	SC-0000016A	1-1/4	2	3-3/8	.312	.500	1-3/4	1/2	1-5/8	SQ	2
	8MDA-1	SC-0000017A	1-1/2	2	4	.312	.500	1-3/4	3/8	2-1/4	30°	3
	8HDA-1	SC-0000018A	1-1/2	2	4	.312	.500	1-3/4	1/2	2-1/4	30°	3
	8MDA-3	SC-0000019A	1-1/2	2	4	.312	.500	1-3/4	3/8	2-1/4	SQ	3
	8HDA-3	SC-0000020A	1-1/2	2	4	.312	.500	1-3/4	1/2	2-1/4	SQ	3
	8MDA-2	SC-0000021A	1-1/2	3	4	.312	.500	1-3/4	3/8	2-1/4	30°	4.7
	8HDA-2	SC-0000022A	1-1/2	3	4	.312	.500	1-3/4	1/2	2-1/4	30°	4.7
10	8MDA-4	SC-0000023A	1-1/2	3	4	.312	.500	1-3/4	3/8	2-1/4	SQ	4.7
	8HDA-4	SC-0000024A	1-1/2	3	4	.312	.500	1-3/4	1/2	2-1/4	SQ	4.7
	10MDA	SC-0000025A	1-1/2	2	4	.500	.750	2-1/8	1/2	1-3/4	SQ	2.7
	10HDA	SC-0000026A	1-1/2	2	4	.500	.750	2-1/8	5/8	1-3/4	SQ	2.7
	10MDA-1	SC-0000027A	2	2	4-1/2	.500	.750	2-1/8	1/2	2-1/4	30°	4.4
	10HDA-1	SC-0000028A	2	2	4-1/2	.500	.750	2-1/8	5/8	2-1/4	30°	4.4
	10MDA-4	SC-0000029A	2	2	4-1/2	.500	.750	2-1/8	1/2	2-1/4	SQ	4.4
	10HDA-4	SC-0000030A	2	2	4-1/2	.500	.750	2-1/8	5/8	2-1/4	SQ	4.4
	10MDA-6	SC-0000031A	2	2	6	.500	.750	2-1/8	1/2	3-7/8	60°	6.75
	10HDA-6	SC-0000032A	2	2	6	.500	.750	2-1/8	5/8	3-7/8	60°	6.75
12	10MDA-2	SC-0000033A	2	3	6	.500	.750	2-1/8	1/2	3-7/8	60°	8.5
	10HDA-2	SC-0000034A	2	3	6	.500	.750	2-1/8	5/8	3-7/8	60°	8.5
	10MDA-3	SC-0000035A	2	4	6	.500	.750	2-1/8	1/2	2-5/8	SQ	12.5
	10HDA-3	SC-0000036A	2	4	6	.500	.750	2-1/8	5/8	2-5/8	SQ	12.5
	12MDA	SC-0000037A	2	2	4-1/2	.500	.750	2-1/2	1/2	2	SQ	4.5
	12HDA	SC-0000038A	2	2	4-1/2	.500	.750	2-1/2	5/8	2	SQ	4.5
	12MDA-1	SC-0000039A	2	2-1/2	5	.500	.750	2-1/2	1/2	2-5/8	30°	6.5
	12HDA-1	SC-0000040A	2	2-1/2	5	.500	.750	2-1/2	5/8	2-5/8	30°	6.5
	12MDA-4	SC-0000041A	2	2-1/2	5	.500	.750	2-1/2	1/2	2-5/8	SQ	6.5
	12HDA-4	SC-0000042A	2	2-1/2	5	.500	.750	2-1/2	5/8	2-5/8	SQ	6.5
15	12MDA-2	SC-0000043A	2	3	6	.500	.750	2-1/2	1/2	3-3/8	60°	8.5
	12HDA-2	SC-0000044A	2	3	6	.500	.750	2-1/2	5/8	3-3/8	60°	8.5
	12MDA-3	SC-0000045A	2	4	6	.500	.750	2-1/2	1/2	2-5/8	SQ	12.5
	12HDA-3	SC-0000046A	2	4	6	.500	.750	2-1/2	5/8	2-5/8	SQ	12.5
	12MDA-5	SC-0000047A	2	5	6	.500	.750	2-1/2	1/2	3-3/8	30°	16.5
	12HDA-5	SC-0000048A	2	5	6	.500	.750	2-1/2	5/8	3-3/8	30°	16.5
	12MDA-6	SC-0000049A	2	2	6	.500	.750	2-1/2	1/2	3-3/8	30°	6.75
	12HDA-6	SC-0000050A	2	2	6	.500	.750	2-1/2	5/8	3-3/8	30°	6.75
	15MDA	SC-0000051A	2	2-1/2	5-3/16	.500	.750	3	5/8	2-1/2	SQ	5
	15HDA	SC-0000052A	2	2-1/2	5-3/16	.500	.750	3	3/4	2-1/2	SQ	5
15	15MDA-1	SC-0000053A	2-1/2	4	6	.500	.750	3	5/8	3-1/4	30°	15
	15HDA-1	SC-0000054A	2-1/2	4	6	.500	.750	3	3/4	3-1/4	30°	15
	15MDA-2	SC-0000055A	2-1/2	4	6	.500	.750	3	5/8	3-1/4	SQ	15
	15HDA-2	SC-0000056A	2-1/2	4	6	.500	.750	3	3/4	3-1/4	SQ	15

Style A

Steel Jaws for American Standard Tongue and Groove

See Style "D" for corresponding Pie Jaws®



Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

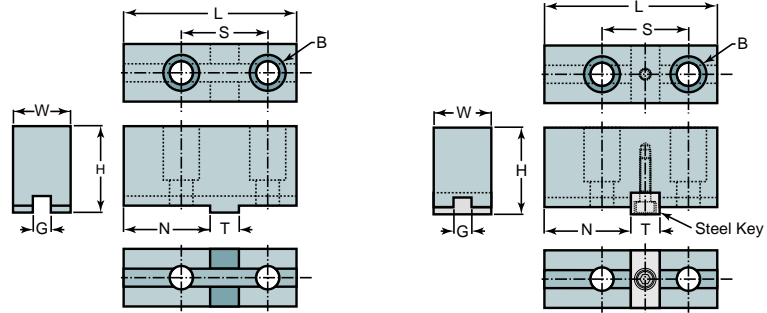
Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Type Nose	Weight (lb) Set of 3
4	4MDS	SC-0000057S	5/8	1-1/4	2	.250	.437	1-3/16	1/4	7/8	SQ	.75
5	5MDS	SC-0000058S	3/4	1-1/2	2-3/8	.312	.500	1-1/4	5/16	1-1/8	30°	1.0
6	6MDS-1	SC-0000059S	1	1-1/2	3-1/4	.312	.500	1-1/2	3/8	1-5/8	30°	3.35
	6HDS-2	SC-0000060S	1-1/2	1-1/2	3-3/8	.312	.500	1-1/2	7/16	1-7/8	45°	6.75
	6MDS-3	SC-0000061S	1	2	3-1/4	.312	.500	1-1/2	3/8	1-5/8	30°	6
	6MDS-5	SC-0000062S	1	3	3-1/4	.312	.500	1-1/2	3/8	1-5/8	30°	4.65
	6HDS-6	SC-0000063S	1-1/2	2	3	.312	.500	1-1/2	7/16	1-1/2	SQ	7
	8	8MDS-5	SC-0000064S	1-1/4	2	3-1/2	.312	.500	1-3/4	3/8	1-7/8	30°
8MDS-7		SC-0000065S	1-1/4	2	4	.312	.500	1-3/4	3/8	2-3/8	30°	12
8HDS-3		SC-0000066S	1-1/4	2	4	.312	.500	1-3/4	1/2	2-3/8	30°	12
8MDS-2		SC-0000067S	1-1/4	3	3-1/2	.312	.500	1-3/4	3/8	1-1/2	SQ	11.25
8MDS-6		SC-0000068S	1-1/4	3	3-1/2	.312	.500	1-3/4	3/8	1-7/8	30°	12
8HDS-2		SC-0000069S	1-1/4	3	3-1/2	.312	.500	1-3/4	1/2	1-5/8	30°	11.25
8MDS-8		SC-0000070S	1-1/4	3	4	.312	.500	1-3/4	3/8	2-3/8	30°	14.5
8HDS-4		SC-0000071S	1-1/4	3	4	.312	.500	1-3/4	1/2	2-3/8	30°	14.5
10	10MDS	SC-0000072S	2	2	4-1/4	.500	.750	2-1/8	1/2	2-3/16	SQ	15
	10HDS-1	SC-0000073S	2	2	4-1/4	.500	.750	2-1/8	5/8	2-3/16	SQ	15
	10MDS-1	SC-0000074S	2	2	6	.500	.750	2-1/8	1/2	3-7/8	60°	16.1
	10HDS-3	SC-0000075S	2	2	6	.500	.750	2-1/8	5/8	3-7/8	60°	20.5
	10MDS-2	SC-0000076S	2	3	4-1/4	.500	.750	2-1/8	1/2	2-3/16	SQ	22.5
	10HDS-2	SC-0000077S	2	3	4-1/4	.500	.750	2-1/8	5/8	2-3/16	SQ	20.5
	10MDS-4	SC-0000078S	2	3	6	.500	.750	2-1/8	1/2	3-7/8	60°	30.5
	10HDS-4	SC-0000079S	2	3	6	.500	.750	2-1/8	5/8	3-7/8	60°	30.5
	A-3011-S	SC-0000080S	2	2-1/2	4-1/8	.500	.750	2-1/8	5/8	2-1/8	SQ	17
	12	12MDS-1	SC-0000081S	2	2	6	.500	.750	2-1/2	1/2	3-3/8	60°
12HDS-6		SC-0000082S	2	2	6	.500	.750	2-1/2	5/8	3-3/8	30°	20
12MDS-2		SC-0000083S	2	3	6	.500	.750	2-1/2	1/2	3-3/8	60°	31.5
12HDS-2		SC-0000084S	2	3	6	.500	.750	2-1/2	5/8	3-3/8	60°	30.6
12HDS-3		SC-0000085S	2	5	6	.500	.750	2-1/2	5/8	3-3/8	30°	51
12HDS-5		SC-0000086S	2	5	4-3/4	.500	.750	2-1/2	5/8	2-1/4	SQ	36
12HDS-4		SC-0000087S	2	3	4-3/4	.500	.750	2-1/2	5/8	2-1/4	SQ	23
A-3010-S		SC-0000088S	2	2-1/2	5	.500	.750	2-1/2	5/8	2-5/8	SQ	23.25
15	15MDS-1	SC-0000089S	2	3	6	.500	.750	3	5/8	3-1/4	30°	30.5
	15HDS-1	SC-0000090S	2	3	6	.500	.750	3	3/4	3-1/4	30°	30.5
	15MDS	SC-0000091S	2	5	6	.500	.750	3	5/8	3-1/4	30°	51
	15HDS	SC-0000092S	2	5	6	.500	.750	3	3/4	3-1/4	30°	51
	A-3001-S	SC-0000093S	2	3-1/4	6-3/8	.500	.750	3	3/4	3-5/8	SQ	35
	A-3014-S	SC-0000094S	3	3	6-3/8	.500	.750	3	5/8	3-5/8	SQ	45.5
	A-3015-S	SC-0000095S	3	3	6-3/8	.500	.750	3	3/4	3-5/8	SQ	45.5

Style A

Metric Tongue and Groove Jaws—SMW KNCS Series

See Style "D" for corresponding Pie Jaws®

These jaws are made with 6061 T-6 condition aluminum. A wide selection of steel jaws is also available in this style. (Note: Steel jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Steel jaws have a built-in key

Aluminum jaws have a separate key

Made with 6061 T-6 Condition Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size (in/mm)	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
8/200	M-8MDA	SC-0000096A	1-1/2	2	4	.393	.787	1.574	8mm	2	3.6
	M-8MDA-1	SC-0000097A	1-1/2	3	4	.393	.787	1.574	8mm	2	5.4
10/250	M-10MDA	SC-0000098A	1-1/2	2	4	.472	.787	1.574	12mm	2	3.6
	M-10MDA-1	SC-0000099A	1-1/2	3	4	.472	.787	1.574	12mm	2	5.4
12/315	M-12MDA	SC-0000100A	2	2	5	.472	.787	1.574	12mm	2-3/4	6.0
	M-12MDA-1	SC-0000101A	2	3	5	.472	.787	1.574	12mm	2-3/4	9.0
15/400	M-15MDA	SC-0000102A	2	2	5	.472	1.023	2.125	12mm	2-3/4	6.0
	M-15MDA-1	SC-0000103A	2	3	5	.472	1.023	2.125	12mm	2-3/4	9.0

Steel available—dimensions "W", "H", "L" and "N" may vary

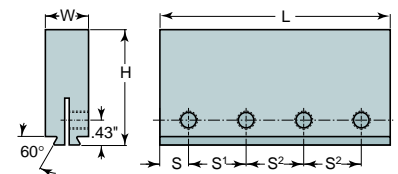
Style A

Dovetail Tongue & Groove Jaws for Woodworth Air-operated Diaphragm Chucks

Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

Model No.	Part No.	H (Height)	L (Length)	S	S ¹ (Spacing)	S ²	S ²	Weight (lb) Set of 3
12255	SC-0000112S	1.50	1.62	.43	.75	N/A	N/A	.38
12255-1	SC-0000113S	2.50	1.50	.56	1.00	N/A	N/A	.94
12255-2	SC-0000114S	3.00	3.00	.37	.75	.75	.75	1.50
12255-3	SC-0000115S	4.00	3.00	.37	.75	.75	.75	2.0
12255-4	SC-0000116S	5.00	3.00	.37	.75	.75	.75	8.25
12255-5	SC-0000117S	6.00	2.50	.50	.75	.75	N/A	2.50
12255-6	SC-0000118S	3.00	4.00	.50	1.00	1.00	1.00	2.0
12255-7	SC-0000119S	3.00	6.00	.50	1.00	1.00	1.00	3.0
12255-8	SC-0000120S	2.00	3.00	.37	.75	.75	.75	1.0
12255-9	SC-0000121S	6.00	6.00	.50	1.00	1.00	1.00	6.0
12255-10	SC-0000122S	4.00	6.00	.50	1.00	1.00	1.00	5.0
12255-11	SC-0000123S	2.00	4.00	.50	1.00	1.00	1.00	1.75
12255-12	SC-0000124S	2.00	6.00	.50	1.00	1.00	1.00	2.50
12255-13	SC-0000125S	1.50	4.00	.50	1.00	1.00	1.00	1.75



Style B

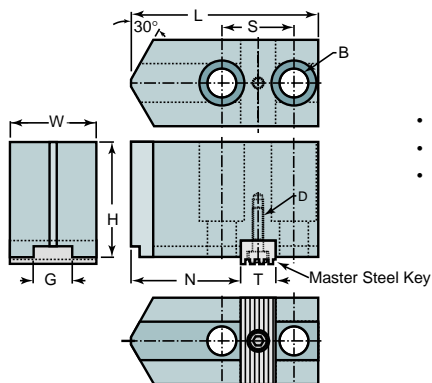
American Standard Jaws for Square Serrated Key-Type Chucks

See Style "E" for corresponding Pie Jaws®

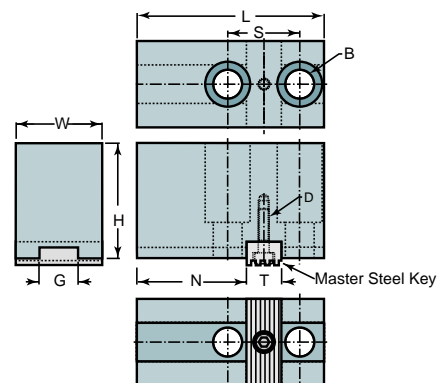
Made with 6061 T-6 Condition Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	D (Drilled Tap)	Type Nose	Weight (lb) Set of 3
6 Buck	6-A	SC-0000126A	1	1-1/2	3	.738	.377	1-11/16	5/16	1-1/2	N/A	30°	1.3
	6-A-2	SC-0000127A	1-1/2	2	4	.738	.377	1-11/16	5/16	2-3/8	N/A	30°/SQ	3
7-1/2 Buck	6-A-3	SC-0000128A	1-1/2	2	4	.866	.377	1-11/16	5/16	2-3/8	N/A	30°/SQ	3
8	8-A	SC-0000129A	1-1/2	2	4	.502	.752	1-7/16	3/8	2-3/16	1/4-20	SQ	3
	8-LP-A	SC-0000130A	1-1/2	2	3-1/4	.667	.601	1-1/4	1/2	1-29/32	10-32	30°	2.7
	8-LP-A-1	SC-0000131A	1-1/2	3	3-1/4	.667	.601	1-1/4	1/2	1-29/32	10-32	30°	4.1
10 & 12*	10-A	SC-0000132A	2	2	4-1/2	.752	.996	1-3/4	1/2	2-3/8	5/16-18	SQ	4.4
	10-A-2	SC-0000133A	2	2	6	.752	.996	1-3/4	1/2	3	5/16-18	SQ	4.4
	10-A-1	SC-0000134A	2	4	6	.752	.996	1-3/4	1/2	3	5/16-18	SQ	12.5
15-18	15-A	SC-0000135A	2-1/2	4	6	1.000	1.489	2-1/2	3/4	3-3/16	3-8/16	SQ	15
	15-A-7L	SC-0000136A	2-1/2	3	7	1.000	1.489	2-1/2	3/4	4	3-8/16	30°	16



- Key has square serrations
- Buck Chucks do not use the serrated key
- Master key not included with jaws (see page 29 for master keys)



Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	D (Drilled Tap)	Type Nose	Weight (lb) Set of 3
6 & 7-1/2 Buck	6A-6A3-S	SC-0000137S	1-1/4	1-1/2	3	.738/.866	.377	1-11/16	5/16	1-1/2	N/A	SQ	5
	6A-6A3-S-1	SC-0000138S	1-1/4	2	3	.738/.866	.377	1-11/16	5/16	1-1/2	N/A	SQ	5
	6A-6A3-S-2	SC-0000139S	1-1/4	1-1/2	3	.738/.866	.377	1-11/16	5/16	1-1/2	N/A	30°	4
	6A-6A3-S-3	SC-0000140S	1-1/4	2	3	.738/.866	.377	1-11/16	5/16	1-1/2	N/A	30°	6
8	8-S	SC-0000141S	1-1/2	2	4	.502	.752	1-7/16	3/8	2-3/16	1/4-20	SQ	9
	8-LP-S	SC-0000142S	1-1/2	2	3-1/4	.667	.601	1-1/4	1/2	1-29/32	10-32	30°	8.2
	8-LP-S-1	SC-0000143S	1-1/2	3	3-1/4	.667	.601	1-1/4	1/2	1-29/32	10-32	30°	12.4
10 & 12*	10-S-2	SC-0000144S	2	2	6	.752	.996	1-3/4	1/2	3	5/16-18	SQ	13
	10-S-1	SC-0000145S	2	4	6	.752	.996	1-3/4	1/2	3	5/16-18	SQ	38
15-18	15-S	SC-0000146S	2-1/2	4	6	1.000	1.489	2-1/2	3/4	3-3/16	3-8/16	SQ	45
	15-S-7L	SC-0000147S	2-1/2	3	7	1.000	1.489	2-1/2	3/4	4	3-8/16	30°	48

*These jaws are interchangeable on both 10- and 12-inch serrated cross key chucks

Style C

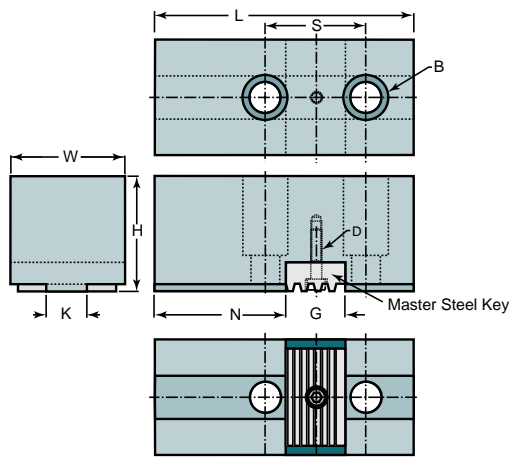
American Standard Jaws for Acme Serrated Cross Key-Type Chucks

See Style "L" for corresponding Pie Jaws®

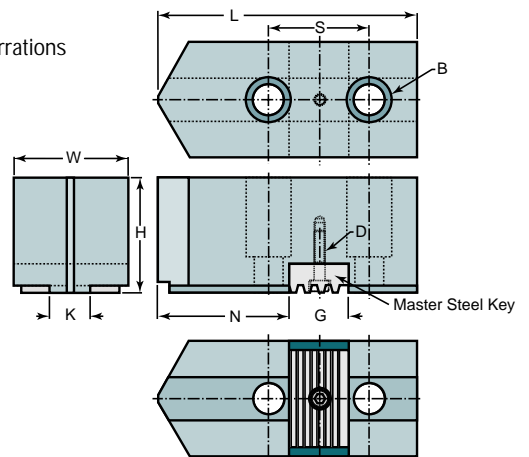
Made with 6061 T-6 Condition Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	K (Key)	G (Groove)	S (Spacing)	B (Bolt)	N (Nose)	K	Type Nose	Weight (lb) Set of 3
10	10A04-A	SC-0000148A	2	2	4-1/2	.749	1.031	1-3/4	1/2	2-9/32	5/16-18	SQ	4.5
	10A04-A-1	SC-0000149A	2	3	4-1/2	.749	1.031	1-3/4	1/2	2-9/32	5/16-18	SQ	7.5
	10A04-A-14	SC-0000150A	2	5	5	.749	1.031	1-3/4	1/2	2-23/32	5/16-18	SQ	14.5
12	12A04-A	SC-0000151A	2	2-1/2	5	.874	1.031	2	5/8	2-23/32	5/16-18	SQ	6
	12A04-A-14	SC-0000152A	2	5	5-1/2	.874	1.031	2	5/8	3-7/32	5/16-18	SQ	15.5
15-18	15A04-A-2	SC-0000153A	2	2-1/2	5	.874	1.031	2-1/2	3/4	3	3/8-16	SQ	15
	15A04-A-10	SC-0000154A	2-1/2	4	7-1/4	.998	1.531	2-1/2	3/4	4-7/32	3/8-16	30°	16
18-24	24A54-A	SC-0000155A	2-1/2	4	6	1.248	1.531	3	7/8	2-7/32	3/8-16	SQ	15



- Master key has 29° included angle serrations
- Master key not included with jaws (see page 29 for master keys)



Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	K (Key)	G (Groove)	S (Spacing)	B (Bolt)	N (Nose)	K	Type Nose	Weight (lb) Set of 3
10	10A04-S	SC-0000156S	2	2	4-1/2	.749	1.031	1-3/4	1/2	2-9/32	5/16-18	SQ	15
	10A-04-S-1	SC-0000157S	2	3	4-1/2	.749	1.031	1-3/4	1/2	2-9/32	5/16-18	SQ	23
	10A04-S-14	SC-0000158S	2	5	5	.749	1.031	1-3/4	1/2	2-23/32	5/16-18	SQ	34
12	12A04-S-1	SC-0000159S	2	3	4-1/2	.874	1.031	2	5/8	2-9/32	5/16-18	SQ	23
	12A04-S-12	SC-0000160S	2	3	5-1/2	.874	1.031	2	5/8	3-7/32	5/16-18	30°	27
	12A04-S-14	SC-0000161S	2	5	5-1/2	.874	1.031	2	5/8	3-7/32	5/16-18	SQ/30°	46
15-18	15A04-S-8	SC-0000162S	2-1/2	4	7	.998	1.531	2-1/2	3/4	3-31/32	3/8-16	30°	59.5
	15A04-S-9	SC-0000163S	2-1/2	6	7	.998	1.531	2-1/2	3/4	3-31/32	5/16-18	30°	90
18-24	21A04-S-6	SC-0000164S	3	3-1/2	5-7/8	1.248	1.531	3	7/8	2-23/32	3/8-16	SQ	52.5
	21A04-S-11	SC-0000165S	3	6	8-5/8	1.248	1.531	3	7/8	5-3/8	3/8-16	SQ	137

Note: SP chuck models K, KT and KC use style "A" jaws for American Standard Tongue and Groove Chucks

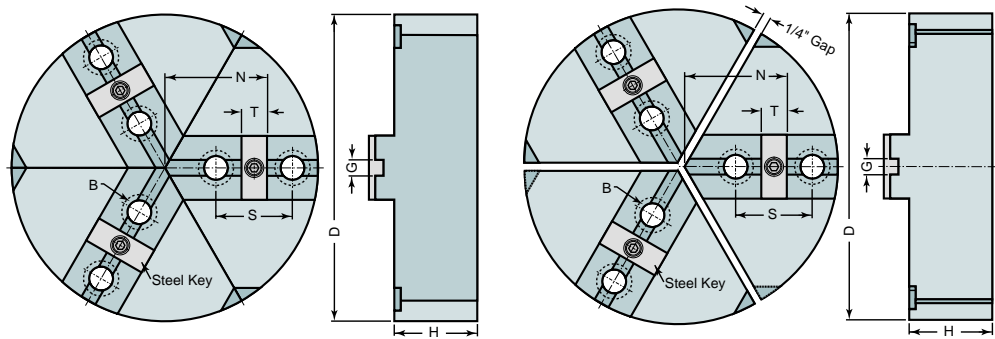
Style D

American Standard Tongue and Groove Pie Jaws®

See Style "A" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style.

(Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
5	5MDP	SC-0000166A	6	2	.312	.500	1-1/4	5/16	2	5
	6MDP	SC-0000167A	6	2	.312	.500	1-1/2	3/8	2	5
	6HDP	SC-0000168A	6	2	.312	.500	1-1/2	7/16	2	5
6	6MDP-1	SC-0000169A	6	4	.312	.500	1-1/2	3/8	2	10
	6HDP-1	SC-0000170A	6	4	.312	.500	1-1/2	7/16	2	10
	8-6MDP	SC-0000171A	8	2	.312	.500	1-1/2	3/8	2	9.5
	8-6HDP	SC-0000172A	8	2	.312	.500	1-1/2	7/16	2	9.5
	8-6MDP-1	SC-0000173A	8	4	.312	.500	1-1/2	3/8	2	18
	8-6HDP-1	SC-0000174A	8	4	.312	.500	1-1/2	7/16	2	18
8	8MDP	SC-0000175A	8	2	.312	.500	1-3/4	3/8	2-3/4	9.5
	8HDP	SC-0000176A	8	2	.312	.500	1-3/4	1/2	2-3/4	9.5
	8MDP-1	SC-0000177A	8	4	.312	.500	1-3/4	3/8	2-3/4	18
	8HDP-1	SC-0000178A	8	4	.312	.500	1-3/4	1/2	2-3/4	18
	8MDP-2	SC-0000179A	8	6	.312	.500	1-3/4	3/8	2-3/4	28
	8HDP-2	SC-0000180A	8	6	.312	.500	1-3/4	1/2	2-3/4	28
	10-8MDP	SC-0000181A	10	2	.312	.500	1-3/4	3/8	2-3/4	15
	10-8HDP	SC-0000182A	10	2	.312	.500	1-3/4	1/2	2-3/4	15
	10-8MDP-1	SC-0000183A	10	4	.312	.500	1-3/4	3/8	2-3/4	30
	10-8HDP-1	SC-0000184A	10	4	.312	.500	1-3/4	1/2	2-3/4	30
	12-8MDP	SC-0000185A	12	2-1/2	.312	.500	1-3/4	3/8	2-3/4	28
	12-8HDP	SC-0000186A	12	2-1/2	.312	.500	1-3/4	1/2	2-3/4	28
10	12-8MDP-1	SC-0000187A	12	5	.312	.500	1-3/4	3/8	2-3/4	51
	12-8HDP-1	SC-0000188A	12	5	.312	.500	1-3/4	1/2	2-3/4	51
	10MDP	SC-0000189A	10	2	.500	.750	2-1/8	1/2	3-1/2	15
	10HDP	SC-0000190A	10	2	.500	.750	2-1/8	5/8	3-1/2	15
	10MDP-1	SC-0000191A	10	4	.500	.750	2-1/8	1/2	3-1/2	30
	10HDP-1	SC-0000192A	10	4	.500	.750	2-1/8	5/8	3-1/2	30
	10MDP-2	SC-0000193A	10	6	.500	.750	2-1/8	1/2	3-1/2	45
	10HDP-2	SC-0000194A	10	6	.500	.750	2-1/8	5/8	3-1/2	45
	12-10MDP	SC-0000195A	12	2-1/2	.500	.750	2-1/8	1/4	3-1/2	28
	12-10HDP	SC-0000196A	12	2-1/2	.500	.750	2-1/8	5/8	3-1/2	28
	12-10MDP-1	SC-0000197A	12	5	.500	.750	2-1/8	1/2	3-1/2	51
	12-10HDP-1	SC-0000198A	12	5	.500	.750	2-1/8	5/8	3-1/2	51
	15-10MDP	SC-0000199A	15	3	.500	.750	2-1/8	1/2	3-1/2	51
	15-10HDP	SC-0000200A	15	3	.500	.750	2-1/8	5/8	3-1/2	51
	15-10MDP-1	SC-0000201A	15	4	.500	.750	2-1/8	1/2	3-1/2	72
	15-10HDP-1	SC-0000202A	15	4	.500	.750	2-1/8	5/8	3-1/2	72
	18-10MDP	SC-0000203A	18	3	.500	.750	2-1/8	1/2	3-1/2	85
	18-10HDP	SC-0000204A	18	3	.500	.750	2-1/8	5/8	3-1/2	85
18-10MDP-1	SC-0000205A	18	4	.500	.750	2-1/8	1/2	3-1/2	100	
18-10HDP-1	SC-0000206A	18	4	.500	.750	2-1/8	5/8	3-1/2	100	

No Gap

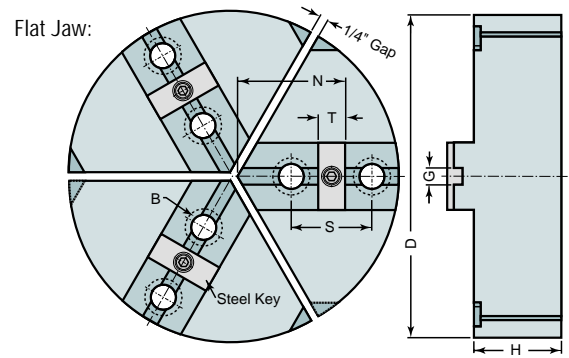
When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style D (Continued)

American Standard Tongue and Groove Pie Jaws®

See Style "A" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



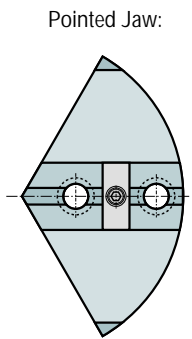
Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
12	12MDP*	SC-0000207A	12	2-1/2	.500	.750	2-1/2	1/2	4-1/4	28
	12HDP*	SC-0000208A	12	2-1/2	.500	.750	2-1/2	5/8	4-1/4	28
	12MDP-1*	SC-0000209A	12	5	.500	.750	2-1/2	1/2	4-1/4	51
	12HDP-1*	SC-0000210A	12	5	.500	.750	2-1/2	5/8	4-1/4	51
	15-12MDP*	SC-0000211A	15	3	.500	.750	2-1/2	1/2	4-1/4	51
	15-12HDP*	SC-0000212A	15	3	.500	.750	2-1/2	5/8	4-1/4	51
	15-12MDP-1*	SC-0000213A	15	4	.500	.750	2-1/2	1/2	4-1/4	72
	15-12HDP-1*	SC-0000214A	15	4	.500	.750	2-1/2	5/8	4-1/4	72
	18-12MDP*	SC-0000215A	18	3	.500	.750	2-1/2	1/2	4-1/4	85
	18-12HDP*	SC-0000216A	18	3	.500	.750	2-1/2	5/8	4-1/4	85
	18-12MDP-1*	SC-0000217A	18	4	.500	.750	2-1/2	1/2	4-1/4	100
	18-12HDP-1*	SC-0000218A	18	4	.500	.750	2-1/2	5/8	4-1/4	100
	21-12MDP-2	SC-0000219A	21	2	.500	.750	2-1/2	1/2	4-1/4	70.5
	21-12HDP-2	SC-0000220A	21	2	.500	.750	2-1/2	5/8	4-1/4	70.5
	21-12MDP	SC-0000221A	21	3	.500	.750	2-1/2	1/2	4-1/4	102
	21-12HDP	SC-0000222A	21	3	.500	.750	2-1/2	5/8	4-1/4	102
	21-12MDP-1	SC-0000223A	21	4	.500	.750	2-1/2	1/2	4-1/4	141
	21-12HDP-1	SC-0000224A	21	4	.500	.750	2-1/2	5/8	4-1/4	141
	24-12MDP-2	SC-0000225A	24	2	.500	.750	2-1/2	1/2	4-1/4	105
	24-12HDP-2	SC-0000226A	24	2	.500	.750	2-1/2	5/8	4-1/4	105
	24-12MDP	SC-0000227A	24	3	.500	.750	2-1/2	1/2	4-1/4	146
	24-12HDP	SC-0000228A	24	3	.500	.750	2-1/2	5/8	4-1/4	146
	24-12MDP-1	SC-0000229A	24	4	.500	.750	2-1/2	1/2	4-1/4	205
	24-12HDP-1	SC-0000230A	24	4	.500	.750	2-1/2	5/8	4-1/4	205
15	15MDP-2*	SC-0000231A	15	2	.500	.750	3	5/8	5-1/4	61
	15HDP-2*	SC-0000232A	15	2	.500	.750	3	3/4	5-1/4	61
	15MDP*	SC-0000233A	15	3	.500	.750	3	5/8	5-1/4	51
	15HDP*	SC-0000234A	15	3	.500	.750	3	3/4	5-1/4	51
	15MDP-1*	SC-0000235A	15	4	.500	.750	3	5/8	5-1/4	72
	15HDP-1*	SC-0000236A	15	4	.500	.750	3	3/4	5-1/4	72
	18-15MDP*	SC-0000237A	18	3	.500	.750	3	5/8	5-1/4	85
	18-15HDP*	SC-0000238A	18	3	.500	.750	3	3/4	5-1/4	85
	18-15MDP-1	SC-0000239A	18	4	.500	.750	3	5/8	5-1/4	100
	18-15HDP-1	SC-0000240A	18	4	.500	.750	3	3/4	5-1/4	100
	21-15MDP-2	SC-0000241A	21	2	.500	.750	3	5/8	5-1/4	70.5
	21-15HPD-2	SC-0000242A	21	2	.500	.750	3	3/4	5-1/4	70.5
	21-15MDP	SC-0000243A	21	3	.500	.750	3	5/8	5-1/4	102
	21-15HDP	SC-0000244A	21	3	.500	.750	3	3/4	5-1/4	102
	21-15MDP-1	SC-0000245A	21	4	.500	.750	3	5/8	5-1/4	141
	21-15HDP-1	SC-0000246A	21	4	.500	.750	3	3/4	5-1/4	141
	24-15MDP-2	SC-0000247A	24	2	.500	.750	3	5/8	5-1/4	105
	24-15HDP-2	SC-0000248A	24	2	.500	.750	3	3/4	5-1/4	105
	24-15MDP	SC-0000249A	24	3	.500	.750	3	5/8	5-1/4	146
	24-15HDP	SC-0000250A	24	3	.500	.750	3	3/4	5-1/4	146
	24-15MDP-1	SC-0000251A	24	4	.500	.750	3	5/8	5-1/4	205
	24-15HDP-1	SC-0000252A	24	4	.500	.750	3	3/4	5-1/4	205

*Pointed Jaw

When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual



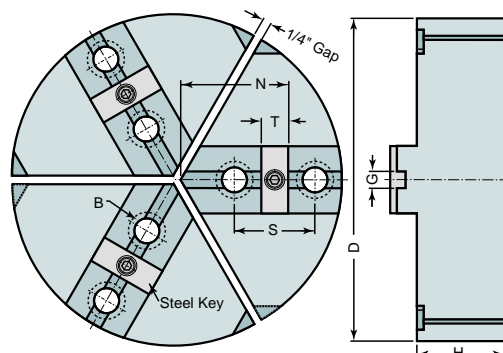
Style D (Continued)

American Standard Tongue and Groove Pie Jaws®

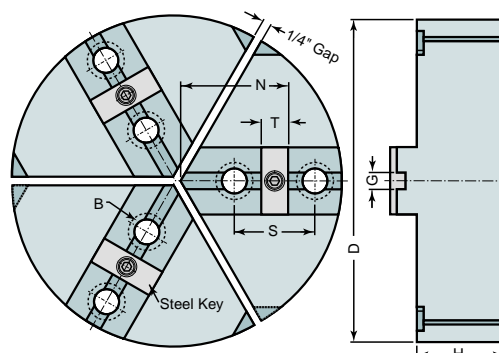
See Style "A" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.

Flat Jaw:



Pointed Jaw:

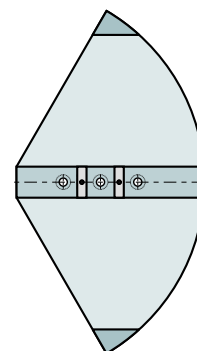


Made with A319 Cast Aluminum

SPECIFICATIONS (Inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
18	18MDP*	SC-0000253A	18	3	.500	.750	3	5/8	6-1/2	85
	18HDP*	SC-0000254A	18	3	.500	.750	3	3/4	6-1/2	85
	18MDP-1*	SC-0000255A	18	4	.500	.750	3	5/8	6-1/2	100
	18-HDP-1*	SC-0000256A	18	4	.500	.750	3	3/4	6-1/2	100
	21-18MDP-2	SC-0000257A	21	2	.500	.750	3	5/8	6-1/2	70.5
	21-18HDP-2	SC-0000258A	21	2	.500	.750	3	3/4	6-1/2	70.5
	21-18MDP	SC-0000259A	21	3	.500	.750	3	5/8	6-1/2	102
	21-18HDP	SC-0000260A	21	3	.500	.750	3	3/4	6-1/2	102
	21-18MDP-1	SC-0000261A	21	4	.500	.750	3	5/8	6-1/2	141
	21-18HDP-1	SC-0000262A	21	4	.500	.750	3	3/4	6-1/2	141
	24-18MDP-2	SC-0000263A	24	2	.500	.750	3	5/8	6-1/2	105
	24-18HDP-2	SC-0000264A	24	2	.500	.750	3	3/4	6-1/2	105
	24-18MDP	SC-0000265A	24	3	.500	.750	3	5/8	6-1/2	146
	24-18HDP	SC-0000266A	24	3	.500	.750	3	3/4	6-1/2	146
	24-18MDP-1	SC-0000267A	24	4	.500	.750	3	5/8	6-1/2	205
	24-18HDP-1	SC-0000268A	24	4	.500	.750	3	3/4	6-1/2	205
	28-18MDP	SC-0000269A	28	3	.500	.750	3	5/8	6-1/2	183
	28-18HDP	SC-0000270A	28	3	.500	.750	3	3/4	6-1/2	183
	28-18MDP-1	SC-0000271A	28	4	.500	.750	3	5/8	6-1/2	275
	28-18HDP-1	SC-0000272A	28	4	.500	.750	3	3/4	6-1/2	275
24 AND UP	32-24-18MDP-1	SC-0000273A	32	4	.500	.750	3	5/8	6-1/2	360
	32-24-18HDP-1	SC-0000274A	32	4	.500	.750	3	3/4	6-1/2	360
	36-24-18MDP-1	SC-0000275A	36	4	.500	.750	3	5/8	6-1/2	450
	36-24-18HDP-1	SC-0000276A	36	4	.500	.750	3	3/4	6-1/2	450
	24MDP-2	SC-0000277A	24	2	.500	.750	3	5/8	9-1/2	105
	24HDP-2	SC-0000278A	24	2	.500	.750	3	3/4	9-1/2	105
	24MDP	SC-0000279A	24	3	.500	.750	3	5/8	9-1/2	146
	24HDP	SC-0000280A	24	3	.500	.750	3	3/4	9-1/2	146
	24MDP-1	SC-0000281A	24	4	.500	.750	3	5/8	9-1/2	205
	24HDP-1	SC-0000282A	24	4	.500	.750	3	3/4	9-1/2	205
	28-24MDP	SC-0000283A	28	3	.500	.750	3	5/8	9-1/2	183
	28-24HDP	SC-0000284A	28	3	.500	.750	3	3/4	9-1/2	183
	28-24MDP-1	SC-0000285A	28	4	.500	.750	3	5/8	9-1/2	275
	28-24HDP-1	SC-0000286A	28	4	.500	.750	3	3/4	9-1/2	275
	32-24-18MDP-1	SC-0000287A	32	4	.500	.750	3	5/8	9-1/2	360
	32-24-18HDP-1	SC-0000288A	32	4	.500	.750	3	3/4	9-1/2	360
	36-24-18-MDP-1	SC-0000289A	36	4	.500	.750	3	5/8	9-1/2	450
	36-24-18-HDP-1	SC-0000290A	36	4	.500	.750	3	3/4	9-1/2	450
	42-24MDP-1	SC-0000291A	42	4	.500	.750	3	5/8	9-1/2	550
	42-24HDP-1	SC-0000292A	42	4	.500	.750	3	3/4	9-1/2	550

3-bolt style
for models
32-24-18MDP-1
thru **42-24HDP-1**:



*Pointed Jaw

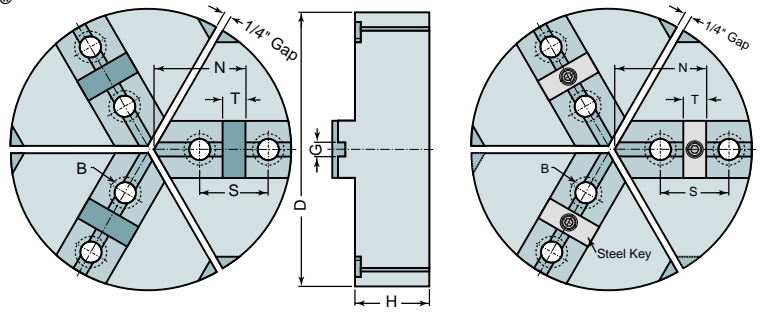
When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style D

Metric Tongue and Groove Pie Jaws®

See Style "A" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size (in/mm)	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
150/6	M-6MDP	SC-0000547A	6	2	.315	.708	1.260	8mm	2.3	5.0
	M-6MDP-1	SC-0000548A	6	4	.315	.708	1.260	8mm	2.3	10.0
200/8	M-8MDP	SC-0000549A	8	2	.393	.787	1.574	8mm	3	10.2
	M-8MDP-1	SC-0000550A	8	4	.393	.787	1.574	8mm	3	19.5
250/10	M-10MDP	SC-0000551A	10	2	.472	.787	1.574	12mm	4	15.3
	M-10MDP-1	SC-0000552A	10	4	.472	.787	1.574	12mm	4	31.5
315/12	M-12MDP	SC-0000553A	12	2-1/2	.472	.787	1.574	12mm	5	16.8
	M-12MDP-1	SC-0000554A	12	5	.472	.787	1.574	12mm	5	52.5
	AM-8MDP	SC-0000555A	8	2	.472	1.023	2.125	12mm	2.82	10.2
	AM-12MDP	SC-0000556A	12	2-1/2	.472	1.023	2.125	12mm	4.32	16.8
400/15	AM-15MDP	SC-0000557A	15	3	.472	1.023	2.125	12mm	4.67	50.25
	M-15MDP	SC-0000558A	15	3	.472	1.023	2.125	12mm	6	50.25
	M-15MDP-1	SC-0000559A	15	4	.472	1.023	2.125	12mm	6	69.0
	M-18-15MDP	SC-0000560A	18	3	.472	1.023	2.125	12mm	6	75.3
500/18	M-18-15MDP-1	SC-0000561A	18	4	.472	1.023	2.125	12mm	6	100
	M-18-24MDP	SC-0000562A	18	3	.709	1.181	2.362	16mm	4.837	75.3
	M-18-24MDP-1	SC-0000563A	18	4	.709	1.181	2.362	16mm	4.837	100

.005 radius
for models
AM-8MDP,
AM-12MDP
and
AM-15MDP:

21- and 24-inch diameters available

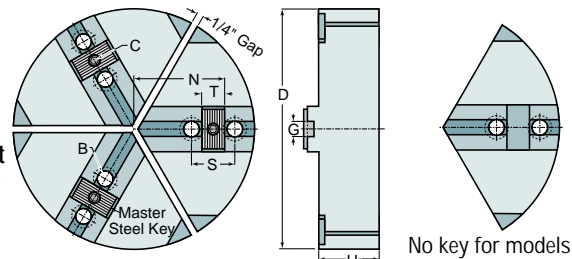
When using oversized jaws, maximum RPM's must be reduced - Consult your chuck manual

Style E

American Standard Pie Jaws® for Square Serrated Cross Key-Type Chucks

See Style "B" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size (in/mm)	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	G ¹ (Groove)	S (Spacing)	B (Bolt)	C (Cap Screw)	Weight (lb) Set of 3
6 Buck	6-AP	SC-0000598A	6	2	.738	.377	1-11/16	5/16	N/A	5
	6-AP-1	SC-0000599A	6	4	.738	.377	1-11/16	5/16	N/A	9.5
7-1/2 Buck	7-1/2AP	SC-0000600A	8	2	.866	.377	1-11/16	5/16	N/A	9.5
8	8-APH	SC-0000601A	8	4	.500	.750	1-7/16	1/2	1/4-20	18
	8-APH-1	SC-0000602A	8	2	.500	.750	1-7/16	1/2	1/4-20	9.5
	8-LP-P	SC-0000603A	8	2	.667	.601	1-1/4	1/2	10-32	9.5
	8-LP-P-1	SC-0000604A	8	4	.667	.601	1-1/4	1/2	10-32	18
10	10-APH	SC-0000605A	10	4	.750	.996	1-3/4	1/2 OR 5/8	5/16-18	30
	10-APH-1	SC-0000606A	10	2	.750	.996	1-3/4	1/2 OR 5/8	5/16-18	15
12	12-APH	SC-0000607A	12	5	.750	.996	1-3/4	1/2 OR 5/8	5/16-18	51
	12-APH-1	SC-0000608A	12	2-1/2	.750	.996	1-3/4	1/2 OR 5/8	5/16-18	28
15	15-APH	SC-0000609A	15	4	1.000	1.489	2-1/2	3/4	3/8-16	72
	15-APH-1	SC-0000610A	15	3	1.000	1.489	2-1/2	3/4	3/8-16	51
18	18-APH	SC-0000611A	18	4	1.000	1.489	2-1/2	3/4	3/8-16	100
	18-APH-1	SC-0000612A	18	3	1.000	1.489	2-1/2	3/4	3/8-16	85

Master key not included with jaws
(see page 29 for master keys)

No key for models
6-AP, 6-AP-1
and **7-1/2AP**

When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style H

Jaws with Coarse Metric Serrations (3mm)

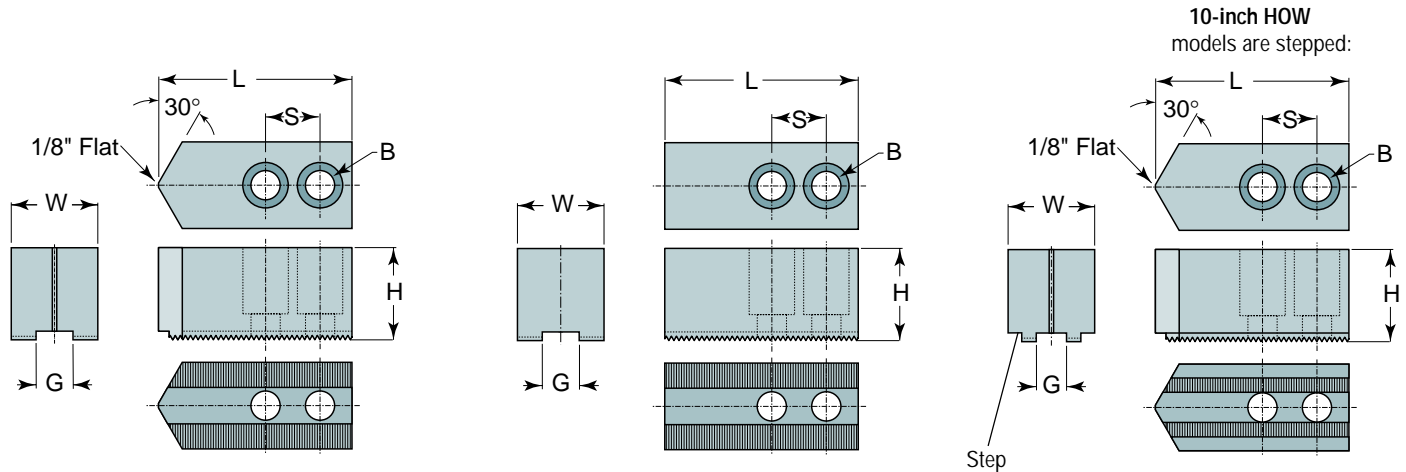
See Style "S" for corresponding Pie Jaws®

Made with 6061 T-6 Condition Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
8	HOW-8-A	SC-2000651A	1-1/2	2	4	.553	.985	12mm	3
	HOW-8-A-1	SC-2000652A	1-1/2	3	4	.553	.985	12mm	4.7
10	HOW-10-A	SC-2000653A	2	2	4-1/2	.630	1.181	12mm	4.4
	HOW-10-A-1	SC-2000654A	2	3	4-1/2	.630	1.181	12mm	5.9
12	HOW-12-A	SC-2000655A	2	2	5-1/2	.710	1.181	14mm	5
	HOW-12-A-1	SC-2000656A	2	3	5-1/2	.710	1.181	14mm	8
15	HOW-15-A	SC-2000657A	2-1/2	3	6	1.025	1.970	20mm	13.2
	MTT-15-A	SC-2000659A	2-1/2	3	6	.868	1.970	20mm	13.2
	MTT-15-A-1	SC-2000660A	2-1/2	4	6	.868	1.970	20mm	17.2
	HOW-7MA-15-A*	SC-2000661A	2	2-1/2	5	.826	1.575	16mm	6
	HOW-27M-15-A	SC-2000662A	2-1/2	3	6	1.025	1.654	20mm	13.2
21	KTT-21-A*	SC-2000663A	2-1/2	3	8-1/4	.984	2.362	20mm	17.5
	KTT-21-A-5	SC-2001768A	2-1/2	5	8-1/4	.984	2.362	20mm	29

*Flat nose



Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
8	HOW-8-S	SC-2000664S	1-1/2	2	4	.553	.985	12mm	10
	HOW-8-S-1	SC-2000665S	1-1/2	3	4	.553	.985	12mm	15
10	HOW-10-S	SC-2000666S	2	2	4-1/2	.630	1.181	12mm	13.5
	HOW-10-S-1	SC-2000667S	2	3	4-1/2	.630	1.181	12mm	21
	HOW-10-S-2	SC-2000668S	2	2	5	.630	1.181	12mm	15.5
	HOW-10-S-3	SC-2000669S	2	3	5	.630	1.181	12mm	25
12	HOW-12-S	SC-2000670S	2	2	5-1/2	.710	1.181	14mm	17
	HOW-12-S-1	SC-2000671S	2	3	5-1/2	.710	1.181	14mm	28
15	HOW-15-S	SC-2000672S	2-1/2	3	6	1.025	1.970	20mm	36
	HOW-15-S-1	SC-2000673S	2-1/2	4	6	1.025	1.970	20mm	42
	MTT-15-S	SC-2000674S	2-1/2	3	6	.868	1.970	20mm	36
	MTT-15-S-1	SC-2000675S	2-1/2	4	6	.868	1.970	20mm	42
15	HOW-7MA-15-S*	SC-2000676S	2	2-1/2	5	.826	1.575	16mm	21.5
	HOW-27M-15-S	SC-2000677S	2-1/2	3	6	1.025	1.654	20mm	36
21	KTT-21-S*	SC-2000678S	2-1/2	3	8-1/4	.984	2.362	20mm	52.6
	KTT-21-S-5	SC-2000679S	2-1/2	5	8-1/4	.984	2.362	20mm	87.7

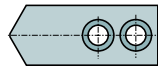
*Flat nose

Style J

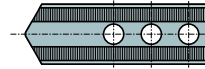
Aluminum Jaws with 90° Serrations (1/16" and 3/32" x 90°)

See Style "K" for corresponding Pie Jaws®

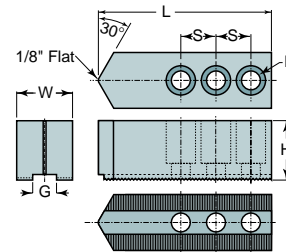
2-bolt Jaw:



3-bolt Stepped Jaw
(bottom view):



3-bolt Jaw:



= Used for Hardinge® jaw chucks

Made with 6061 T-6 Condition Aluminum

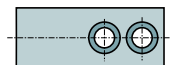
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3	
Hardinge® 4	HAR4ESHA ²	SC-1000680A	1	1-1/4	2-1/2	.434	.709	8mm	.8	
	5 or 6	PH-600-A	SC-1000681A	1	1-1/2	3-1/4	.433	.718	5/16	1
		PH-601-A	SC-1000682A	1	2	3-1/4	.433	.718	5/16	1.6
		PH-602-A	SC-1000683A	1	3	3-1/4	.433	.718	5/16	2.2
Hardinge 5	HAR5ESHA ²	SC-1000684A	1	1-1/4	2.77	.434	.709	5/16	1	
Hardinge 6	HAR6ESHA ²	SC-1000685A	1-1/4	1-1/2	3.09	.551	.787	3/8	1.5	
	SMW 6.5	SMW-6.5-A	SC-1000686A	1-1/2	1-1/2	3-1/4	.552	.875	3/8	2
		SMW-6.5-A-1	SC-1000687A	1-1/2	2	3-1/4	.552	.875	3/8	2.7
		SMW-6.5-A-2	SC-1000688A	1-1/2	3	3-1/4	.552	.875	3/8	4.1
Powerhold 6.5	PH-6.5-A	SC-1000689A	1-1/4	1-1/2	3-1/8	.551	.718	3/8	1.6	
SMW 8	SMW-8-A	SC-1000690A	1-1/2	2	4	.669	.875	1/2	3.6	
	SMW-8-A-1	SC-1000691A	1-1/2	3	4	.669	.875	1/2	5.4	
HOWA 8	HOW-12MA-8-A	SC-1000692A	1-1/2	2	4	.669	.984	1/2 or 12mm	3.6	
8-10 or 10-1/2	PH-1000-A	SC-1000693A	1-1/2	2	4	.551	.875	3/8	2.75	
	PH-1001-A	SC-1000694A	1-1/2	3	4	.551	.875	3/8	4.75	
	PH-1002-A	SC-1000695A	2	2	4	.551	.875	3/8	4.25	
	PH-1003-A	SC-1000696A	2	3	4	.551	.875	3/8	6.5	
Hardinge 8	HAR8ESHA ²	SC-1000697A	1-1/2	2	3.68	.670	.880	7/16	2.7	
Hardinge 10	HAR10ESHA ²	SC-1000698A	1-3/4	2	4.72	.828	1.187	5/8	4	
	10 HD 11 & 12	PH-1200-A	SC-1000699A	2	2	4	.787	1.187	1/2	4.25
		PH-1201-A	SC-1000700A	2	3	6	.787	1.187	1/2	7.75
		PH-1202-A	SC-1000701A	2	4	6	.787	1.187	1/2	12.25
		PH-1203-A	SC-1000702A	2	2-1/2	5	.787	1.187	1/2	6
SMW 10 & 12-1/2	PH-1204-A	SC-1000703A	2	2	6	.826	1.187	1/2	4.25	
	PH-1205-A	SC-1000704A	2	3	6	.826	1.187	1/2	7.75	
	PH-1206-A	SC-1000705A	2	4	6	.826	1.187	1/2	12.25	
14 or 15	PH-1400-A	SC-1000706A	2-1/2	4	6	.826	1.562	5/8	15	
	PH-1401-A	SC-1000707A	2-1/2	5	6	.826	1.562	5/8	20	
	PH-1500-A	SC-1000708A	2	2-1/2	6-5/8	.826	1.562	5/8	9.6	
	PH-1501-A	SC-1000709A	2	4	6-5/8	.826	1.562	5/8	14	

90° SERRATIONS X .0938 (3/32 PITCH):

SMW 16 & 20	PH-1600-A	SC-1000710A	2-1/2	3	6-1/4	1.004	1.562	3/4	13.2
	PH-1601-A	SC-1000711A	2-1/2	6	6-1/4	1.004	1.562	3/4	26.5
	PH1602-A	SC-1000712A	2-1/2	3	8	1.004	1.562	3/4	17
SMW 25 & 31.5	PH-2500-A	SC-1000713A	3-1/2	3-1/2	11	1.181	2.50	1	38
	AUTO-18-A-1 ²	SC-1000714A	2-1/2	4	10	1.102	2.70	3/4	30
Autoblok 18-24	AB-20-A ²	SC-1000715A	2-1/2	2-1/2	6.7	1.102	2.99	3/4	10
	AB-20-A-1 ²	SC-1000716A	2-1/2	4	6.7	1.102	2.99	3/4	18
	AUTO-24-IDN-A ²	SC-1000717A	3	4	11	1.102	2.75	3/4	37
	AUTO-24-IDN-A-1 ²	SC-1000718A	3	6	11	1.102	2.75	3/4	52

AUTO-24-IDN-A and
AUTO-24-IDN-A-1
models are flat:



² 2-bolt

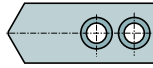
Style J

Steel Jaws with 90° Serrations (1/16" and 3/32" x 90°)

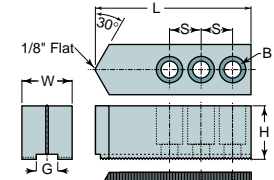
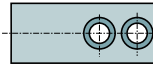
See Style "K" for corresponding Pie Jaws[®]

■ = Used for Hardinge[®] jaw chucks

2-bolt
Pointed Jaw:



2-bolt
Flat Jaw:

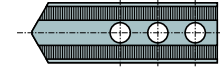


Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

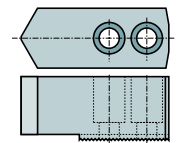
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
Hardinge [®] 4	4ESHF ^{2*}	SC-1000217S	1	1.12	2.09	.434	.709	5/16	1.5
	4EMHF ^{2*}	SC-1000218S	1	1-1/2	2.09	.434	.709	5/16	2.1
	4ESHP ²	SC-1000211S	1	1.12	2.37	.434	.709	5/16	1.44
	4EMHP ²	SC-1000220S	1	1-1/2	2.38	.434	.709	5/16	1.5
	4EH1	SC-1000219S	1	1.12	2.38	.434	.660	5/16	1.5
5 or 6	PH-600-S	SC-1000720A	1	1-1/2	3-1/4	.433	.718	5/16	3
	PH-601-S	SC-1000721A	1	2	3-1/4	.433	.718	5/16	4.5
	PH-602-S	SC-1000722A	1	3	3-1/4	.433	.718	5/16	8.2
Hardinge 5	5ESHF ^{2*}	SC-1000077S	1	1.12	2.48	.434	.709	5/16	1.5
	5EMHF ^{2*}	SC-1000078S	1	1-1/2	2.48	.434	.709	5/16	2.7
	5ESHP ²	SC-1000061S	1	1.12	2.77	.434	.709	5/16	1.92
	5EMHP ²	SC-1000081S	1	1-1/2	2.77	.434	.709	5/16	3
	5EH1	SC-1000079S	1	1.12	2.38	.434	.660	5/16	1.5
Hardinge 6	6ESHF ^{2*}	SC-1000026S	1-1/4	1-1/4	2-3/4	.551	.787	3/8	3
	6EMHF ^{2*}	SC-1000027S	1-1/4	1-3/4	2-3/4	.551	.787	3/8	4.2
	6ESHP ²	SC-1000011S	1-1/4	1-1/4	3.09	.551	.787	3/8	2.94
	6EMHP ²	SC-1000030S	1-1/4	1-3/4	3.09	.551	.787	3/8	1.3
	6EH1	SC-1000028S	1-1/4	1.34	2.81	.551	.787	3/8	2.25
SMW 6.5	SMW-6.5-S	SC-1000725S	1-1/2	1-1/2	3-1/4	.552	.875	3/8	6.2
	SMW-6.5-S-1	SC-1000726S	1-1/2	2	3-1/4	.552	.875	3/8	8.2
	SMW-6.5-S-2	SC-1000727S	1-1/2	3	3-1/4	.552	.875	3/8	12.4
Powerhold 6.5	PH-6.5-S	SC-1000728S	1-1/4	1-1/2	3-1/8	.551	.718	3/8	4.9
	PH-603-S	SC-1000729S	1	2	3-1/4	.669	.875	1/2	4.5
SMW 8	SMW-8-S	SC-1000730S	1-1/2	2	4	.669	.875	1/2	10.8
	SMW-8-S-1	SC-1000731S	1-1/2	3	4	.669	.875	1/2	16.2
Hardinge 8	8ESHF ^{2*}	SC-1000126S	1-1/2	1-1/2	3.28	.671	.880	7/16	5.25
	8EMHF ^{2*}	SC-10000127	1-1/2	2	3.28	.671	.880	7/16	7.2
	8ESHP ²	SC-1000111S	1-1/2	1-1/2	3.68	.671	.880	7/16	5.4
	8EMHP ²	SC-1000130S	1-1/2	2	3.68	.671	.880	7/16	7.5
	8EH1	SC-1000128S	1-1/2	1-3/4	2.64	.671	.810	7/16	3.75
HOWA 8	HOW-12MA-8-S	SC-1000733S	1-1/2	2	4	.669	.984	1/2or 12mm	10.8
8-10 or 10-1/2	PH-1000-S	SC-1000734S	1-1/2	2	4	.551	.875	3/8	10
	PH-1001-S	SC-1000735S	1-1/2	3	4	.551	.875	3/8	15
	PH-1002-S	SC-1000736S	2	2	4	.551	.875	3/8	13
	PH-1003-S	SC-1000737S	2	3	4	.551	.875	3/8	20
Hardinge 10	10ESHF ^{2*}	SC-1000176S	1-3/4	1-3/4	4.16	.828	1.187	M16x2	9
	10EMHF ^{2*}	SC-1000177S	1-3/4	2.60	4.16	.828	1.187	M16x2	10.8
	10ESHP ²	SC-1000161S	1-3/4	1-3/4	4.72	.828	1.187	M16x2	9.3
	10EMHP ²	SC-1000180S	1-3/4	2-1/4	4.72	.828	1.187	M16x2	12
	10EH1	SC-1000178S	1-3/4	2.02	4.32	.828	1.020	M16x2	6.45
10 HD 11 & 12	PH-1200-S	SC-1000739S	1-3/4	2	4	.787	1.187	1/2	11.8
	PH-1201-S	SC-1000740S	2	3	6	.787	1.187	1/2	30
	PH-1202-S	SC-1000741S	2	4	6	.787	1.187	1/2	40
	PH-1203-S	SC-1000742S	1-3/4	2-1/2	5-1/4	.787	1.187	1/2	19.5
SMW 10 & 12-1/2	PH-1204-S	SC-1000743S	2	2	4	.826	1.187	1/2	14
	PH-1205-S	SC-1000744S	2	3	6	.826	1.187	1/2	30
	PH-1206-S	SC-1000745S	2	4	6	.826	1.187	1/2	41
14 or 15	PH-1400-S	SC-1000746S	2-1/2	4	6	.826	1.562	5/8	50
	PH-1401-S	SC-1000747S	2-1/2	5	6	.826	1.562	5/8	60
	PH-1500-S	SC-1000748S	2	2-1/2	6-5/8	.826	1.562	5/8	29
	PH-1501-S	SC-1000749S	2	4	6-5/8	.826	1.562	5/8	42
90° SERRATIONS X .0938 (3/32 PITCH):									
SMW 16 & 20	PH-1600-S	SC-1000750S	2-1/2	3	6-1/4	1.004	1.562	3/4	39.8
	PH-1601-S	SC-1000751S	2-1/2	6	6-1/4	1.004	1.562	3/4	79.6
	PH-1602-S	SC-1000752S	2-1/2	3	8	1.004	1.562	3/4	51
SMW 25 & 31.5	PH-2500-S	SC-1000754S	3-1/2	3-1/2	11	1.181	2.50	1	114.5
Autoblok 18-24	AUTO-18-S-1 ²	SC-1000755S	2-1/2	4	10	1.102	2.70	3/4	90
	AB-20-S ²	SC-1000756S	2-1/2	2-1/2	6.7	1.102	2.99	3/4	30
	AB-20-S-1 ²	SC-1000757S	2-1/2	4	6.7	1.102	2.99	3/4	68
	AUTO-24-IDN-S ^{2*}	SC-1000758S	3	4	11	1.102	2.75	3/4	111
	AUTO-24-IDN-S-1 ^{2*}	SC-1000759S	3	6	11	1.102	2.75	3/4	156

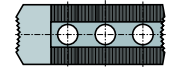
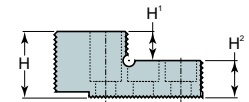
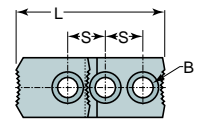
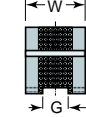
3-bolt Stepped Jaw
(bottom view):



Hardinge jaws:
Bottom cleared
for stop plate



4EH1, 5EH1, 6EH1,
8EH1 and 10EH1
models are hardened
single-step jaws:



Hard Jaw Dim.

Jaw	H ¹	H ²
4EH1	.375"	.750"
5EH1	.375"	.750"
6EH1	.500"	.845"
8EH1	.800"	.950"
10EH1	.812"	1.200"

² 2-bolt

*Flat-nose

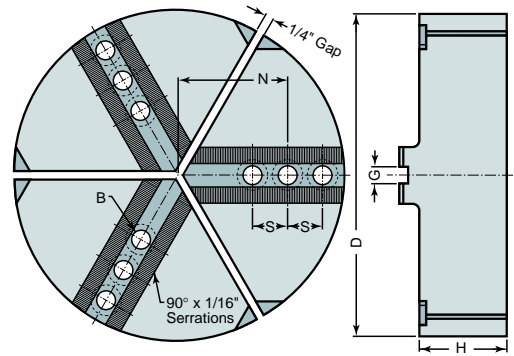
Style K

Pie Jaws[®] with 90° Serrations (1/16" and 3/32" x 90°)

See Style "J" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.

3-bolt
Pointed Jaw:



= Used for Hardinge[®] jaw chucks

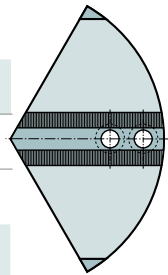
Note: ROHM-5-P and PH-601-AP models do not have a gap

Made with A319 Cast Aluminum

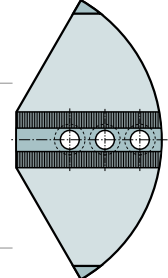
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	S (Spacing)	B (Bolt)	N	Weight (lb) Set of 3
5	ROHM-5-P ²	SC-1000760A	6	2	.393	.511	6mm	1	7.5
	HAR5ESH ²	SC-1000761A	6	2	.434	.709	5/16	1-45/64	7.5
	HAR5ESH1 ²	SC-1000762A	6	4	.434	.709	5/16	1-45/64	10
6	PH-6.5-P	SC-1000763A	6	2	.551	.718	3/8	1-5/32	7.5
	PH-600-AP ²	SC-1000764A	6	2	.435	.718	5/16	1-7/16	7.5
	PH-601-AP ²	SC-1000765A	6	4	.435	.718	5/16	1-7/16	10
	HAR6ESH ²	SC-1000766A	6.5	2	.551	.787	3/8	1-31/32	9
	HAR6ESH1 ²	SC-1000767A	6.5	4	.551	.787	3/8	1-31/32	11.5
HOWA 8	HOW-12-MA-8-P ²	SC-1000768A	8	2	.669	.984	1/2 or 12mm	2	9.5
	HOW-12MA-8-P-1 ²	SC-1000760A	8	4	.669	.984	1/2 or 12mm	2	19
8 & 10	PH-8-1077-AP	SC-1000770A	8	2	.553	.875	3/8	2-11/16	9.5
	PH-8-1078-AP	SC 1000771A	8	4	.553	.875	3/8	2-11/16	19
	HAR8ESH ²	SC-1000772A	8	2	.670	.880	7/16	2-19/64	9.5
	HAR8ESH1 ²	SC-1000773A	8	4	.670	.880	7/16	2-19/64	19
	HAR10ESH ²	SC-1000774A	10	2	.828	1.187	16mm	2-3/4	15
	HAR10ESH1 ²	SC-1000775A	10	4	.828	1.187	16mm	2-3/4	30
	PH-01077-AP	SC-1000776A	10	2	.553	.875	3/8	2-5/8	15
Powerhold 11 & 12	PH-01078-AP	SC-1000778A	10	4	.553	.875	3/8	2-5/8	30
	PH-10-1277-AP ²	SC-1000779A	10	2	.789	1.50	1/2	2-1/2	15
	PH-10-1278-AP ²	SC-1000780A	10	4	.789	1.50	1/2	2-1/2	30
	PH-01277-AP	SC-1000781A	12	2-1/2	.789	1.187	1/2	2-13/16	30
	PH-01278-AP	SC-1000782A	12	5	.789	1.187	1/2	2-13/16	52
Powerhold 14 & Up	PH-15-1277-AP	SC-1000783A	15	3	.789	1.187	1/2	2-13/16	60
	PH-01577-AP	SC-1000784A	15	3	.828	1.562	5/8	3-7/16	60
	PH-01578-AP	SC-1000785A	15	4	.828	1.562	5/8	3-7/16	72
	PH-18-1577-AP	SC-1000786A	18	3	.828	1.562	5/8	3-7/16	84
	PH-18-1578-AP	SC-1000787A	18	5	.828	1.562	5/8	3-7/16	120
SMW 10	PH-21-1577-AP*	SC-1000788A	21	3	.828	1.562	5/8	3-7/16	102
	PH-24-1577-AP*	SC-1000789A	24	3	.828	1.562	5/8	3-7/16	146
	SMW-EF100-AP ²	SC-1000790A	10	2	.828	1.187	1/2	1-7/8	15
	SMW-EF101-AP ²	SC-1000791A	10	4	.828	1.187	1/2	1-7/8	30
	SMW-EF103-AP ²	SC-1000792A	10	8	.828	1.187	1/2	1-7/8	60
12	SMW-EF120-AP	SC-1000793A	12	2-1/2	.828	1.187	1/2	2-5/16	30
	SMW-EF-121-AP	SC-1000794A	12	5	.828	1.187	1/2	2-5/16	52

2-bolt
Pointed Jaw:



3-bolt
Flat Jaw:



90 DEGREE SERRATIONS X .0938 (3/32 PITCH):

15 & Up	SMW-EF1500-AP*	SC-1000795A	15	4	1.004	1.562	3/4	3-1/8	88
	SMW-EF1800-AP*	SC-1000796A	18	4	1.004	2.362	3/4	4-11/16	97.5
	SMW-3F18-1400AP3	SC-1000797A	18	3	1.004	1.562	3/4	3-1/8	5
	SMW-EF18-1500AP	SC-1000798A	18	4	1.004	1.562	3/4	3-1/8	100
	SMW-EF 2000-AP* ²	SC-1000799A	20	4	1.004	1.562	3/4	4-11/16	120
	SMW-EF 2400-AP*	SC-1000800A	24	4	1.004	2.362	3/4	7-5/8	176
	SMW-EF 2800-AP*	SC-1000801A	28	4	1.004	1.562	3/4	7-5/8	275
	GAM 1800-AP ²	SC-1000802A	18	4	1.181	1.960	3/4	4-11/16	100

*Flat nose

²2-bolt

When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

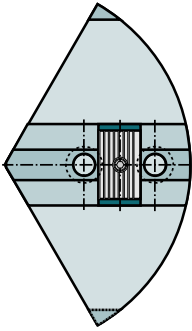
Style L

American Standard Pie Jaws® for Acme Serrated Cross Key-Type Chucks

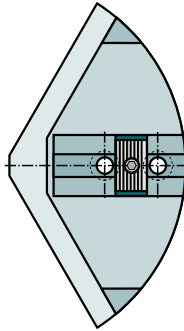
See Style "C" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.

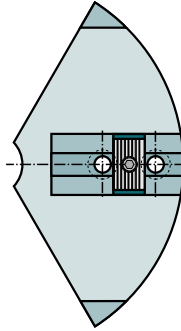
Pointed Jaw:



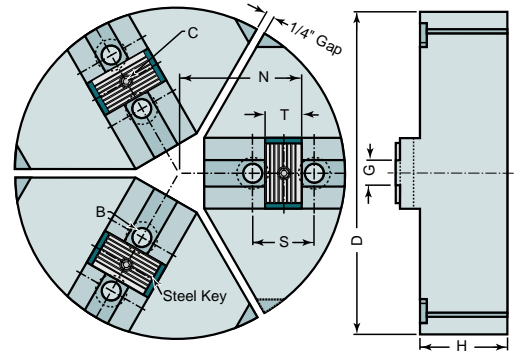
Stepped Jaw:



Jaw with Radius:



Flat Jaw:



Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	T (Tongue)	G (Groove)	S (Spacing)	B (Bolt)	N	C (Cap Screw)	D (Drilled Tap)	Weight (lb) Set of 3
8	PBA8-P-1*	SC-0000889A	8	4	.669	.601	1-1/4	1/2	2.50	10-32	1/4	19
	10SP4-P*	SC-0000890A	10	2	.625	.781	1-5/8	1/2	4	10-32	1/4	15
10	10SP4-P-1*	SC-0000891A	10	5-1/2	.625	.781	1-5/8	1/2	4	10-32	1/4	45
	10A04-P*	SC-0000892A	10	2	.749	1.031	1-3/4	1/2	3-3/4	5/16-18	1/4	15
	10A04-P-1*	SC-0000893A	10	4	.749	1.031	1-3/4	1/2	3-3/4	5/16-18	1/4	30
	12-10A04-P	SC-0000894A	12	2-1/2	.749	1.031	1-3/4	1/2	3-3/4	5/16-18	1/4	28
	12-10A04-P-1	SC-0000895A	12	5	.749	1.031	1-3/4	1/2	3-3/4	5/16-18	1/4	51
	12A04-P	SC-0000896A	12	3	.875	1.031	2	5/8	4-3/4	5/16-18	1/4	33
12	12A04-P-1	SC-0000897A	12	4	.875	1.031	2	5/8	4-3/4	5/16-18	1/4	44
	12A04-P-3	SC-0000898A	12	6	.875	1.031	2	5/8	4-3/4	5/16-18	1/4	55
	15-12A04-P-1*	SC-0000899A	15	4	.875	1.031	2	5/8	4-3/4	5/16-18	1/4	72
	18-12A04-P-1*	SC-0000900A	18	4	.875	1.031	2	5/8	4-3/4	5/16-18	1/4	100
15	15A04-P3*	SC-0000901A	15	3	.998	1.531	2-1/2	3/4	6	3/8-16	3/4	51
	15A04-P ST	SC-0000902A	15	4	.998	1.531	2-1/2	3/4	6	3/8-16	3/4	72
	15A04-P5 ST	SC-0000903A	15	5	.998	1.531	2-1/2	3/4	6	3/8-16	3/4	85
	15A04-P6 ST	SC-0000904A	15	6	.998	1.531	2-1/2	3/4	6	3/8-16	3/4	98
	15A04-P8*	SC-0000905A	15	8	.998	1.531	2-1/2	3/4	6	3/8-16	1/4	144
	15A04-P11 ST	SC-0000906A	15	4	.998	1.531	2-1/2	3/4	6-1/2	3/8-16	1/4	72
	15A04-P12 ST	SC-0000907A	15	Top Hat	.998	1.531	2-1/2	3/4	6-1/2	3/8-16	1/4	74
	1815A04P3*	SC-0000908A	18	3	.998	1.531	2-1/2	3/4	6	3/8-16	3/4	85
24	18-24A54-P*	SC-0000909A	18	4	1.248	1.531	3	7/8	6-7/8	3/8-16	1/4	110
	18A54-P ^R	SC-0000910A	18.5	4	1.248	1.532	3	7/8	7-1/8	3/8-16	1/2	91
	22A54-P ^R	SC-0000911A	22.25	4	1.248	1.532	3	7/8	8-1/2	3/8-16	2-9/32	112
	20A54-P4	SC-0000912A	20	4	1.248	1.532	3	7/8	8-1/16	3/8-16	1/4	120
	21-24A54-P1 ST	SC-0000913A	21	4	1.248	1.531	3	7/8	8	3/8-16	1/4	135
	21-24A54-P2 ST	SC-0000914A	21	5	1.248	1.531	3	7/8	8	3/8-16	1/4	150
	24A54-P ST	SC-0000915A	24	4	1.248	1.531	3	7/8	8-1/16	3/8-16	1/4	169.5
28	28A54-P	SC-0000916A	28	4	1.248	1.531	3	7/8	10-1/8	3/8-16	1/4	242
	32A54-P ST	SC-0000917A	32	4	1.248	1.531	3	7/8	10-1/8	3/8-16	1/4	288
24-36	32A54-P1 ST	SC-0000918A	32	5	1.248	1.531	3	7/8	10-1/8	3/8-16	1/4	363
	32A54-P2 ST	SC-0000919A	32	6	1.248	1.531	3	7/8	10-1/8	3/8-16	1/4	435

*Pointed

ST Stepped

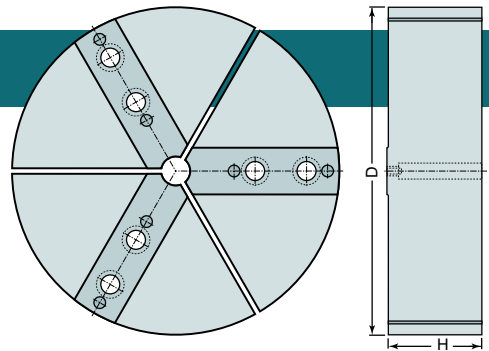
^R Has a radius

When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style M

Pie Jaws[®] for Northfield and Micro-Centric Chucks

These jaws are made with 2024 aluminum. A wide selection of C1018 steel jaws is also available in this style. (Note: Steel jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.

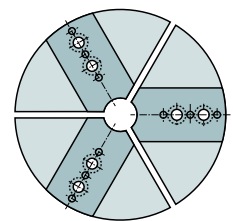


Made with 2024 Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Northfield Chucks	Micro-Centric Chucks	Part No.	H (Height)	D (Diameter)	External Chucking Range	Internal Chucking Range	Weight (lb) Set of 3
AL-3-4-2	MC-3-4-2	SC-0000982A	2.0	3.920	.750-3.750	.750-3.750	2
AL-3-4-3	MC-3-4-3	SC-0000983A	3.0	3.920	.750-3.750	.750-3.750	3
AL-3-6-2	MC-3-6-2	SC-0000984A	2.0	5.920	.750-5.750	.750-5.750	5.25
AL-3-6-3	MC-3-6-3	SC-0000985A	3.0	5.920	.750-5.750	.750-5.750	7.5
AL-3-6-4	MC-3-6-4	SC-0000986A	4.0	5.920	.750-5.750	.750-5.750	10.5
AL-3-8-2	MC-3-8-2	SC-0000987A	2.0	8.0	.750-7.750	1.00-7.750	10.5
AL-3-8-3	MC-3-8-3	SC-0000988A	3.0	8.0	.750-7.750	1.00-7.750	12.5
AL-3-8-4	MC-3-8-4	SC-0000989A	4.0	8.0	.750-7.750	1.00-7.750	19.5
AL-3-10-2*	MC-3-10-2	SC-0000990A	2.0	10.00	.750-9.750	1.00-9.750	15
AL-3-10-3*	MC-3-10-3	SC-0000991A	3.0	10.00	.750-9.750	1.00-9.750	22.5
AL-3-10-4*	MC-3-10-4	SC-0000992A	4.0	10.00	.750-9.750	1.00-9.750	30
AL-3-14-10-4*	—	SC-0000993A	4.0	14.00	.750-13.750	1.00-13.750	60
AL-3-7-2	—	SC-0000994A	2.0	7.00	.750-6.750	1.00-6.750	7.5
AL-3-7-3	—	SC-0000995A	3.0	7.00	.750-6.750	1.00-6.750	11.25
AL-3-12-2*	—	SC-0000996A	2.0	12.00	.750-11.750	1.00-11.750	22.25
AL-3-12-3*	—	SC-0000997A	3.0	12.00	.750-11.750	1.00-11.750	33.25
AL-3-12-4*	—	SC-0000998A	4.0	12.00	.750-11.750	1.00-11.750	44.25
AL-3-12-6*	—	SC-0000999A	6.0	12.00	.750-11.750	1.00-11.750	66.5

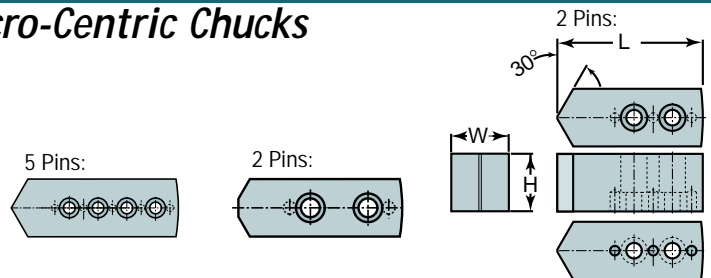
*Made with 6061 aluminum



Style R

Standard Jaws for Northfield and Micro-Centric Chucks

These jaws are made with 2024 aluminum. A wide selection of C1018 steel jaws is also available in this style. (Note: Steel jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with 2024 Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Northfield Chucks	Micro-Centric Chucks	Part No.	H (Height)	W-North (Width)	W-Micro (Width)	L-North (Length)	L-Micro (Length)	External Chucking Range	Internal Chucking Range	Weight (lb) Set of 3
AL-1-4-3/4	—	SC-0001044A	.75	.750	—	1.895	—	.130-3.750	.250-3.750	.7
AL-1-4-1.5	MC-415A ²	SC-0001045A	1.5	.750	.750	1.895	1.930	.130-3.750	.250-3.750	.5
AL-1-4-3	MC-4300A ²	SC-0001046A	3	.750	.750	1.895	1.930	.130-3.750	.250-3.750	2
AL-1-6-1	—	SC-0001047A	1	1	—	2.895	—	.130-5.750	.250-3.750	2.5
AL-1-6-1.5	—	SC-0001048A	1.5	1	—	2.895	—	.130-5.750	.250-3.750	3
AL-1-6-2	MC-6200A ⁵	SC-0001049A	2	1	1	2.895	2.955	.130-5.750	.250-5.750	5
AL-1-6-3	MC-6300A ⁵	SC-0001050A	3	1	1	2.895	2.955	.130-5.750	.250-5.750	6.5
AL-1-6-4	MC-6400A ⁵	SC-0001051A	4	1	1	2.895	2.955	.130-5.750	.250-5.750	8
AL-1-8-2	MC-8200A ²	SC-0001052A	2	2	1.5	3.687	3.750	.750-7.750	1.00-7.750	6.5
AL-1-8-3	MC-8300A ²	SC-0001053A	3	2	1.5	3.687	3.750	.750-7.750	1.00-7.750	8
AL-1-8-4	MC-8400A ²	SC-0001054A	4	2	1.5	3.687	3.750	.750-7.750	1.00-7.750	10
AL-1-10-2	MC-10200A ³	SC-0001055A	2	2	1.5	4.687	4.750	.750-9.750	1.00-9.750	6.5
AL-1-10-3	MC-10300A ³	SC-0001056A	3	2	1.5	4.687	4.750	.750-9.750	1.00-9.750	8
AL-1-10-4	MC-10400A ³	SC-0001057A	4	2	1.5	4.687	4.750	.750-9.750	1.00-9.750	10
AL-1-12-3	—	SC-0001058A	3	2	—	5.687	—	.750-11.750	1.00-11.750	11

² 2 Pins

³ 3 Pins

⁵ 5 Pins

Specify 1/4- or 5/8-inch center hole

Style N

Master Plates

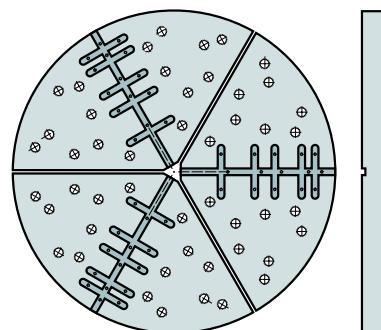
Made with A713 (Tenzaloy®) Aged to T-6 Condition

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No. (2nd no. denotes size)	Part No.	Diameter	Segment Diameter Range	Weight (lb) Set of 3
10 or 12	18-10-MP	SC-0001099	18	18 OD x 2 ID	45
	18-12-MP	SC-0001100	18	18 OD x 2 ID	45
12, 15, 18, or 24	24-12-MP	SC-0001102	24	24 OD x 12 ID*	102
	24-15-MP	SC-0001103	24	24 OD x 12 ID*	102
	24-18-MP	SC-0001104	24	24 OD x 12 ID*	102
	24-24-MP	SC-0001105	24	24 OD x 12 ID*	102
	30-15-MP	SC-0001106	30	30 OD x 18 ID*	135
15, 18, 24 or 30	30-18-MP	SC-0001107	30	30 OD x 18 ID*	135
	30-24-MP	SC-0001108	30	30 OD x 18 ID*	135
	30-30-MP	SC-0001109	30	30 OD x 18 ID*	135
	36-24-MP	SC-0001110	36	36 OD x 24 ID*	171
24, 30, or 36	36-30-MP	SC-0001111	36	36 OD x 24 ID*	171
	36-36-MP	SC-0001112	36	36 OD x 24 ID*	171
	48-36-MP	SC-0001113	48	48 OD x 24 ID*	366
36 or 48	48-48-MP	SC-0001114	48	48 OD x 24 ID*	366
	60-54-MP	SC-0001115	60	60 OD x 24 ID*	569
54 or 60	60-60-MP	SC-0001116	60	60 OD x 24 ID*	569

*Please specify make and size of chuck being used

Master Plates make machining large thin-walled parts easy!
They replace face plate fixtures and make a universal fixture out of your chuck.



All master plates available for 3- or 4-jaw chucks

Style O

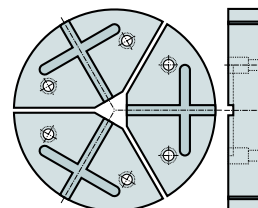
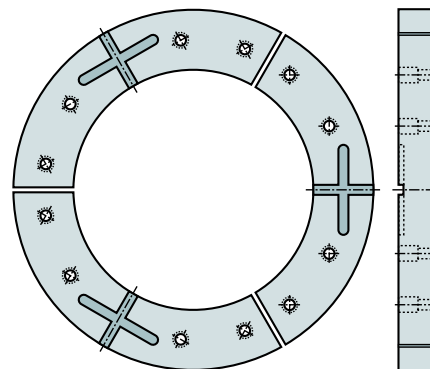
Segments for Master Plates

Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Plate Size	Model No.	Part No.	Diameter X Height	No. Jaws Per Set*	Diameter Range	Weight (lb) Set of 3
18	10-SP-2	SC-0001117	10 X 2	3	10 OD X 2 ID	15
	10-SP-4	SC-0001118	10 X 4	3	10 OD X 2 ID	30
	15-7-SP-2	SC-0001119	15 X 2	3 or 4	15 OD X 7 ID	36
	15-7-SP-4	SC-0001120	15 X 4	3 or 4	15 OD X 7 ID	72
	15-9-SP-2	SC-0001121	15 X 2	3 or 4	15 OD X 9 ID	30
	15-9-SP-4	SC-0001122	15 X 4	3 or 4	15 OD X 9 ID	60
	18-12-SP-2	SC-0001123	18 X 2	3 or 4	18 OD X 12 ID	36
	18-12-SP-4	SC-0001124	18 X 4	3 or 4	18 OD X 12 ID	72
24	22-16-SP-2	SC-0001126	22 X 2	3	22 OD X 16 ID	50
	22-16-SP-4	SC-0001127	22 X 4	3	22 OD X 16 ID	100
	24-15-SP-2	SC-0001128	24 X 2	3	24 OD X 15 ID	75
	24-15-SP-4	SC-0001129	24 X 4	3	24 OD X 15 ID	125
	24-18-SP-2	SC-0001130	24 X 2	3 or 4	24 OD X 18 ID	58
	24-18-SP-4	SC-0001131	24 X 4	3 or 4	24 OD X 18 ID	78
	26-18-SP-2	SC-0001133	26 X 2	3	26 OD X 18 ID	61
	26-18-SP-4	SC-0001134	26 X 4	3	26 OD X 18 ID	120
30	30-24-SP-2	SC-0001135	30 X 2	3 or 4	30 OD X 24 ID	63
	30-24-SP-4	SC-0001136	30 X 4	3 or 4	30 OD X 24 ID	126
36	36-30-SP-2	SC-0001137	36 X 2	3 or 4	36 OD X 30 ID	81
	36-30-SP-4	SC-0001138	36 X 4	3 or 4	36 OD X 30 ID	162
48	38-30-SP-4	SC-0001139	38 X 4	3	38 OD X 30 ID	192
	40-30-SP-2	SC-0001140	40 X 2	3	40 OD X 30 ID	142
	40-30-SP-4	SC-0001141	40 X 4	3	40 OD X 30 ID	240
	40-32-SP-4	SC-0001142	40 X 4	3	40 OD X 32 ID	200
	42-36-SP-2	SC-0001143	42 X 2	3 or 4	42 OD X 36 ID	74
	42-36-SP-4	SC-0001144	42 X 4	3 or 4	42 OD X 36 ID	140
	44-34-SP-2	SC-0001145	44 X 2	3	44 OD X 34 ID	155
	44-34-SP-4	SC-0001146	44 X 4	3	44 OD X 34 ID	294
	48-38-SP-2	SC-0001147	48 X 2	3	48 OD X 38 ID	169
	48-42-SP-2	SC-0001148	48 X 2	3 or 4	48 OD X 42 ID	86
	48-42-SP-4	SC-0001149	48 X 4	3 or 4	48 OD X 42 ID	166
	50-40-SP-2	SC-0001150	50 X 2	3 or 4	50 OD X 40 ID	188
	50-40-SP-4	SC-0001151	50 X 4	3 or 4	50 OD X 40 ID	306
	60	54-40-SP-2	SC-0001152	54 X 2	3 or 4	54 OD X 40 ID
60-50-SP-2		SC-0001153	60 X 2	3 or 4	60 OD X 50 ID	220


*4-jaw sets mount on 4-jaw master plates

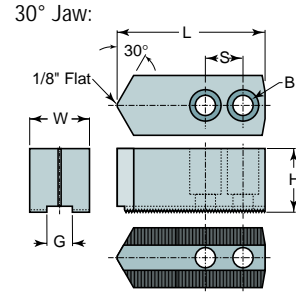
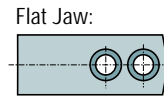


Style P

Aluminum Jaws with Fine Metric Serrations (1.5mm x 60°)

See Style "Q" for corresponding Pie Jaws®

 = Used for Hardinge® jaw chucks



Made with 6061 T-6 Condition Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
4	KTT-4-A	SC-2001154A	3/4	1	2	.314	.591	6mm	3/4
	KTT-4-A-1	SC-2001155A	3/4	2	2	.314	.591	6mm	1
	KW-4-A	SC-2001156A	1	1-1/2	2	.394	.551	8mm	3/4
	KW-4-A-1	SC-2001157A	1	3	2	.394	.551	8mm	1.2
5	KTT-5-A	SC-2001158A	1	1-1/2	2-1/2	.394	.713	8mm	1
	KTT-5-A-1	SC-2001159A	1	2	2-1/2	.394	.713	8mm	1.5
	HOW-5-A	SC-2001160A	1	1-1/2	2-1/2	.394	.748	8mm	1
	HOW-5-A-1	SC-2001161A	1	2	2-1/2	.394	.748	8mm	1.5
	SUG-5-A-STG	SC-2001162A	1	1-1/2	2-3/8	.433	.670	8mm	1.5
	HAR5MSHA	SC-2001163A	1	1-1/4	2.77	.395	.709	8mm	1.0
6	HOW-6-A	SC-2001164A	1-1/4	1-1/2	3	.433	.787	10mm	1.3
	HOW-6-A-1	SC-2001165A	1-1/4	2	3	.433	.787	10mm	1.7
	KTT-6-A	SC-2001166A	1-1/4	1-1/2	3	.474	.787	10mm	1.2
	KTT-6-A-2	SC-2001167A	1-1/4	3	3	.474	.787	10mm	3.1
	SUG-6-A-STG	SC-2001168A	1	1-1/2	3	.433	.985	8mm	2.5
	SUG-6-A-1-STG	SC-2001169A	1	2	3	.433	.985	8mm	3
	SUG-6-A-2-STG	SC-2001170A	1	3	3	.433	.985	8mm	3.5
		HAR6MSHA	SC-2001171A	1-1/4	1-1/2	3.09	.474	.787	10mm
8	KTT-8-A	SC-2001172A	1-1/2	2	4	.551	.985	12mm	3.1
	KTT-8-A-2	SC-2001174A	1-1/2	4	4	.551	.985	12mm	5
	SUG-8-A-STG	SC-2001175A	1-1/2	2	4	.551	1.181	10mm	3
	HOW-27M8-8A	SC-2001176A	1-1/2	2	4	.630	.985	12mm	3.1
	HOW-27M8-8-A-1	SC-2001177A	1-1/2	3	4	.630	.985	12mm	4
	HAR8MSHA	SC-2001178A	1-1/2	2	3.76	.551	.985	12mm	3.3
10	KTT-10-A	SC-2001179A	1-1/2	2	4-1/2	.630	1.181	12mm	3.6
	KTT-10-A-1	SC-2001180A	1-1/2	3	4-1/2	.630	1.181	12mm	5
	KTT-10-A-2	SC-2001181A	1-1/2	4	4-3/4	.630	1.181	12mm	5.3
	KTT-10-A-3	SC-2001182A	2	3	5-1/2	.630	1.181	12mm	7.5
	KTT-10-A-8	SC-2001183A	1-1/2	8	4-3/4	.630	1.181	12mm	10
	MTT-10-A	SC-2001184A	1-1/2	2	4-1/2	.630	1.260	12mm	3.5
	MTT-10-A-1	SC-2001185A	1-1/2	3	4-1/2	.630	1.260	12mm	5.2
	HOW-27M10-A	SC-2001186A	1-1/2	2	4-1/2	.710	1.181	14mm	3.6
	HOW-27M10-A-1	SC-2001187A	1-1/2	3	4-1/2	.710	1.181	14mm	5
		HAR10MSHA	SC-2001188A	1-3/4	2	4.569	.630	1.181	12mm
12	KTT-12-A-A	SC-2001189A	2	2	5-1/8	.710	1.181	14mm	6.2
	KTT-12-A-1-A	SC-2001190A	2	3	5-1/8	.710	1.181	14mm	9.3
	KTT-B212-A-A*	SC-2001191A	2	2	5-1/8	.828	1.181	16mm	6.2
	KTT-B212-A-1-A	SC-2001192A	2	3	5-1/8	.828	1.181	16mm	9.3
	KTT-12-A-B	SC-2001193A	2	2	5-1/8	.710	1.488	14mm	6.2
	KTT-12-A-B-1	SC-2001194A	2	3	5-1/8	.710	1.488	14mm	9.3
	SEIKI-12-A	SC-2001195A	1-1/2	2	4-1/4	.712	1.260	14mm	3.5
	SEIKI-12-A-1	SC-2001196A	1-1/2	3	4-1/4	.712	1.260	14mm	5.1
	SEIKI-12-A-A	SC-2001197A	2	2	4-1/4	.712	1.260	14mm	4.6
	SEIKI-12-A1-A	SC-2001198A	2	3	4-1/4	.712	1.260	14mm	4.8
	HOW-27M12-A1	SC-2001199A	2	3	5	.827	1.378	16mm	9
	SUG-12-A-STG	SC 2001200A	1-3/4	2	5-5/16	.788	1.378	12mm	7.5
14	SUG-14-A-STG	SC-2001201A	2	3	6-5/16	.827	1.772	16mm	9
15	KTT-15-A	SC-2001202A	2-1/2	3	6-1/2	.866	1.693	20mm	13.2
	KTT-15-A-1	SC-2001203A	2-1/2	4	6-1/2	.866	1.693	20mm	17.6
	KTT-B215-A	SC-2001204A	2-1/2	3	6-1/2	1.004	1.689	20mm	9.3
	KTT-B215-A-1	SC-2001205A	2-1/2	4	6-1/2	1.004	1.689	20mm	11

*Flat nose - Please specify when ordering

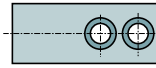
Style P

Steel Jaws with Fine Metric Serrations (1.5mm x 60°)

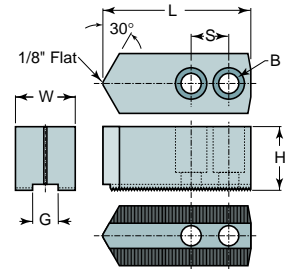
See Style "Q" for corresponding Pie Jaws®

 = Used for Hardinge® jaw chucks

Flat Jaw:



30° Jaw:



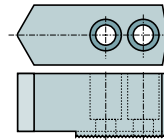
Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

SPECIFICATIONS (inches—unless specified otherwise)

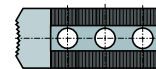
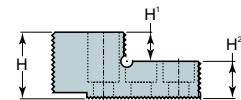
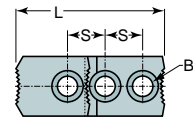
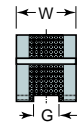
Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
4	KTT-4-S	SC-2001258S	3/4	1	2	.314	.591	6mm	1
	KTT-4-S-1	SC-2001259S	3/4	2	2	.314	.591	6mm	2
	KW-4-S	SC-2001260S	1	1-1/2	2	.394	.551	8mm	1.2
	KW-4-S-1	SC-2001261S	1	2-1/4	2	.394	.551	8mm	2.4
	4MSHF*	SC-2000225S	1	1.12	1.95	.394	.551	8mm	1.5
	4MMHF*	SC-2000226S	1	1-1/2	1.95	.394	.551	8mm	2.1
	4MSHP	SC-2000222S	1	1.12	2.22	.394	.551	8mm	1.44
	4MMHP	SC-2000227S	1	1-1/2	2.22	.394	.551	8mm	1.5
4MH1	SC-2000224S	1	1.12	2.06	.394	.551	8mm	1.5	
5	KTT-5-S	SC-2001262S	1	1-1/2	2-1/2	.394	.713	8mm	1.5
	KTT-5-S-1	SC-2001263S	1	2	2-1/2	.394	.713	8mm	1.5
	HOW-5-S	SC-2001264S	1	1-1/2	2-1/2	.393	.748	8mm	2.6
	HOW-5-S-1	SC-2001265S	1	2	2-1/2	.393	.748	8mm	3.7
	SUG-5-S-STs	SC-2001266S	1	1-1/2	2-3/8	.433	.669	8mm	7.5
	5MSHF*	SC-2000070S	1	1.12	2.40	.395	.709	8mm	1.5
	5MMHF*	SC-2000071S	1	1.49	2.48	.395	.709	8mm	2.7
	5MSHP	SC-2000066S	1	1.12	2.77	.395	.709	8mm	1.92
5MMHP	SC-2000073S	1	1-1/2	2.77	.395	.709	8mm	3	
5MH1	SC-2000072S	1	1.22	2.42	.395	.708	8mm	1.5	
6	HOW-6-S	SC-2001268S	1-1/4	1-1/2	3	.433	.787	10mm	4.2
	HOW-6-S-1	SC-2001269S	1-1/4	2	3	.433	.787	10mm	6.7
	KTT-6-S	SC-2001270S	1-1/4	1-1/2	3	.474	.787	10mm	4.2
	KTT-6-S-2	SC-2001271S	1-1/4	3	3	.474	.787	10mm	9
	SUG-6-S-STs	SC-2001272S	1	1-1/2	3	.433	.985	8mm	3.75
	SUG-6-S-1-STs	SC-2001273S	1	2	3	.433	.985	8mm	5
	SUG-6-S-2-STs	SC-2001274S	1	3	3	.433	.985	8mm	6.5
	6MSHF*	SC-2000019S	1-1/4	1-1/4	2-3/4	.473	.787	10mm	3
	6MMHF*	SC-2000020S	1-1/4	1-3/4	2-3/4	.473	.787	10mm	4.2
	6MSHP	SC-2000016S	1-1/4	1-1/4	3.09	.473	.787	10mm	2.94
6MMHP	SC-2000023S	1-1/4	1-3/4	3.09	.473	.787	10mm	1.3	
6MH1	SC-2000021S	1-1/4	1.42	2.83	.473	.787	10mm	2.25	
8	KTT-8-S*	SC-2001276S	1-1/2	2	4	.551	.985	12mm	10
	KTT-8-S-2	SC-2001278S	1-1/2	4	4	.551	.985	12mm	16
	SUG-8-S-STs	SC-2001279S	1-1/2	2	4	.551	1.181	10mm	10
	SUG-8-S-1-STs	SC-2001280S	1-1/2	3	4	.551	1.181	10mm	15
	HOW-27M8-8S	SC-2001281S	1-1/2	2	4	.630	.985	12mm	10
	HOW-27M8-8S1	SC-2001282S	1-1/2	3	4	.630	.985	12mm	16
	8MSHF*	SC-2000119S	1-1/2	1-1/2	3.36	.551	.984	12mm	5.25
	8MMHF*	SC-2000120S	1-1/2	2	3.36	.551	.984	12mm	7.2
	8MSHP	SC-2000116S	1-1/2	1-1/2	3.76	.551	.984	12mm	5.4
	8MMHP	SC-2000123S	1-1/2	2	3.76	.551	.984	12mm	7.5
8MH1	SC-2000121S	1-1/2	1-3/4	2.64	.551	.810	12mm	3.75	

*Flat nose - Please specify when ordering

Hardinge jaws:
Bottom cleared
for stop plate



4MH1, 5MH1, 6MH1, 8MH1
models are hardened
single-step jaws:



Hard Jaw Dimensions

Jaw	H ¹	H ²
4MH1	.375"	.750"
5MH1	.373"	.845"
6MH1	.500"	.927"
8MH1	.800"	.950"

Style P (Continued)

Steel Jaws with Fine Metric Serrations (1.5mm x 60°)

See Style "Q" for corresponding Pie Jaws®

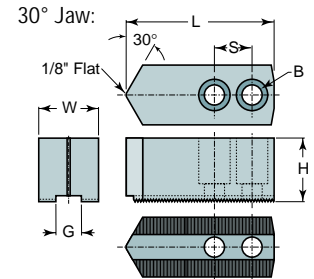
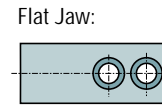
 = Used for Hardinge® jaw chucks

Made with 1018 Cold Rolled Steel (can be carburized and hardened by customer)

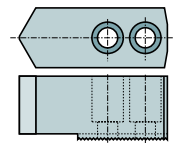
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	W (Width)	H (Height)	L (Length)	G (Groove)	S (Spacing)	B (Bolt)	Weight (lb) Set of 3
10	KTT-10-S	SC-2001284S	1-1/2	2	4-1/2	.630	1.181	12mm	11
	KTT-10-S-1	SC-2001285S	1-1/2	3	4-1/2	.630	1.181	12mm	16
	KTT-10-S-3	SC-2001286S	2	3	5-1/4	.630	1.181	12mm	21.5
	KTT-10-S-4	SC-2001287S	1-1/2	4	4-1/2	.630	1.181	12mm	25
	MTT-10-S	SC-2001288S	1-1/2	2	4-1/2	.630	1.250	12mm	11
	MTT-10-S-1	SC-2001289S	1-1/2	3	4-1/2	.630	1.250	12mm	16
	HOW-27M10-S	SC-2001290S	1-1/2	2	4-1/2	.710	1.181	14mm	11
	HOW-27M10S-1	SC-2001291S	1-1/2	3	4-1/2	.710	1.181	14mm	16
	10MSHF*	SC-2000169S	1-3/4	1-3/4	4	.631	1.187	12mm	9
	10MMHF*	SC-2000170S	1-3/4	2-1/4	4	.631	1.187	12	11.4
10MSHP	SC-2000166S	1-3/4	1-3/4	4.56	.631	1.187	12mm	9.3	
10MMHP	SC-2000173S	1-3/4	2-1/4	4.56	.631	1.187	12mm	12	
10MH1	SC-2000171S	1-3/4	2.02	4.32	.631	1.187	12mm	6.45	
12	KTT-12-S-A*	SC-2001293S	2	2	4	.710	1.181	14mm	13.5
	KTT-12-S-1-A	SC-2001294S	2	3	4	.710	1.181	14mm	21
	KTT-12-S-3-A	SC-2001295S	2	2	5-1/8	.710	1.181	14mm	18
	KTT-12-S-4-A	SC-2001296S	2	3	5-1/8	.710	1.181	14mm	29
	KTT-12-S-5-A	SC-2001297S	2	4	5-1/8	.710	1.181	14mm	34.5
	KTTB212-S-A	SC-2001298S	2	2	4	.828	1.181	16mm	13.5
	KTTB212-S-1-A	SC-2001299S	2	3	4	.828	1.181	16mm	21
	KTT-12-S-B	SC-2001300S	2	2	4	.710	1.488	14mm	13.5
	KTT-12-S-1-B	SC-2001301S	2	3	4	.710	1.488	14mm	21
	SEIKI-12-S	SC-2001302S	1-1/2	2	4-1/4	.712	1.260	14mm	9.5
	SEIKI-12-S-1	SC-2001303S	1-1/2	3	4-1/4	.712	1.260	14mm	11.5
	SEIKI-12-S-A	SC-2001304S	2	2	4-1/4	.712	1.260	14mm	12.9
	SEIKI-12-S-1-A	SC-2001305S	2	3	4-1/4	.712	1.260	14mm	21.3
	HOW-27M12-S	SC-2001306S	2	2	5	.827	1.377	16mm	28
HOW-27M12-S-1	SC-2001307S	2	3	5	.827	1.377	16mm	34	
SUG-12-S-STM	SC-2001308S	1-3/4	2	5-5/16	.788	1.378	12mm	13.5	
12MSHF*	SC-2000426S	2	1.972	4-1/2	.828	1.181	16mm	12	
12MMHF*	SC-2000427S	2	2-3/4	4-1/2	.828	1.181	16mm	17.4	
12MSHP	SC-2000416S	2	1.972	5.043	.828	1.181	16mm	13.05	
12MMHP	SC-2000423S	2	1.972	5.043	.828	1.181	16mm	18	
12MH1	SC-2000421S	2	2.180	4.927	.828	1.181	16mm	9	
14	SUG-14-S-STG	SC-2001309S	2	3	6-5/16	.827	1.772	16mm	30
15	KTT-15-S	SC-2001310S	2-1/2	3	6-1/2	.866	1.693	20mm	39.6
	KTT-15-S-1	SC-2001311S	2-1/2	4	6-1/2	.866	1.693	20mm	52.8
	KTT-B215S-SQ*	SC-2001312S	2-1/2	3	6-1/2	1.004	1.689	20mm	39.6
	KTT-B215-S-1-SQ*	SC-2001313S	2-1/2	4	6-1/2	1.004	1.689	20mm	52.8

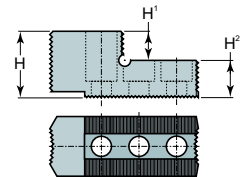
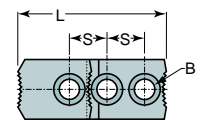
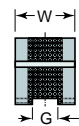
*Flat nose - Please specify when ordering



Hardinge jaws:
Bottom cleared
for stop plate



10MH1 and 12MH1
models are hardened
single-step jaws:



Hard Jaw Dimensions

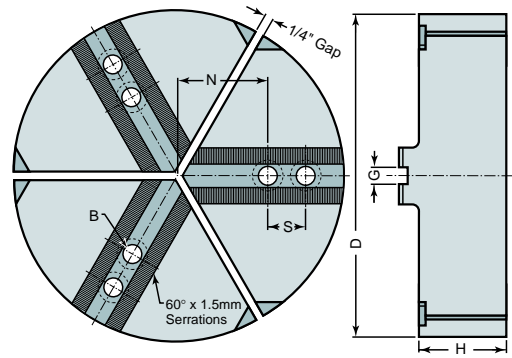
Jaw	H ¹	H ²
10MH1	.812"	1.200"
12MH1	.812"	1.378"

Style Q

Aluminum Pie Jaws[®] with Fine Metric Serrations (1.5mm x 60°)

See Style "P" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



= Used for Hardinge[®] jaw chucks

Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D	H	G	S	B	N	Weight (lb) Set of 3
			(Diameter)	(Height)	(Groove)	(Spacing)	(Bolt)	(Nose)	
4	KTT-4-P*	SC-2001370A	6	2	.314	.591	6mm	1	6
	KTT-4-P-1*	SC-2001371A	6	4	.314	.591	6mm	1	10
	KW-4-P*	SC-2001372A	6	2	.394	.551	8mm	1	6
	KW-4-P-1*	SC-2001373A	6	4	.394	.551	8mm	1	10
5	HOW-5-P*	SC-2001374A	6	2	.394	.748	8mm	1	6
	HOW-5-P-1*	SC-2001375A	6	4	.394	.748	8mm	1	10
	KTT-5-P*	SC-2001376A	6	2	.394	.713	8mm	1-1/8	6
	KTT-5-P-1*	SC-2001377A	6	4	.394	.713	8mm	1-1/8	10
	SUG-5-P-STs*	SC-2001378A	6	2	.433	.669	8mm	1-27/32	6
	HAR5MSHP	SC-2001379A	6	2	.395	.709	8mm	1-11/16	7.5
	HAR5MSHP1	SC-2001380A	6	4	.395	.709	8mm	1-11/16	10
6	KTT-6-P	SC-2001381A	6	2	.474	.787	10mm	1-21/32	6
	KTT-6-P-1	SC-2001382A	6	4	.474	.787	10mm	1-21/32	10
	KTT-8-6-P	SC-2001383A	8	2	.474	.787	10mm	1-21/32	9.5
	KTT-8-6-P-1	SC-2001384A	8	4	.474	.787	10mm	1-21/32	19
	KTT-10-6-P	SC-2001385A	10	2	.474	.787	10mm	1-21/32	15
	SUG-6-P-STs*	SC-2001386A	6	2	.433	.985	8mm	1-3/8	6
	SUG-6-P-1-STs*	SC-2001387A	6	4	.433	.985	8mm	1-3/8	12
	HAR6MSHP	SC-2001388A	6.5	2	.474	.787	10mm	1-15/16	9
	HAR6MSHP1	SC-2001389A	6.5	4	.474	.787	10mm	1-15/16	11.5
	KTT-8-P	SC-2001390A	8	2	.553	.985	12mm	2	9.5
8	KTT-8-P-1	SC-2001391A	8	4	.553	.985	12mm	2	19
	KTT-10-8-P	SC-2001392A	10	2	.553	.985	12mm	2	15
	KTT-10-8-P-1	SC-2001393A	10	4	.553	.985	12mm	2	30
	KTT-12-8-P	SC-2001394A	12	2-1/2	.553	.985	12mm	2	28
	HOW-27M8-8P	SC-2001395A	8	2	.630	.985	12mm	2	9.5
	HOW-27M8-8P-1	SC-2001396A	8	4	.630	.985	12mm	2	19
	SUG-8-P-STs	SC-2001397A	8	2	.553	1.181	10mm	1-27/32	10
	SUG-8-P-1-STs	SC-2001398A	8	4	.553	1.181	10mm	1-27/32	20
	HARMSHP	SC-2001399A	8	2	.551	.985	12mm	2-17/64	9.5
	HAR8MSP1	SC-2001400A	8	4	.551	.985	12mm	2-17/94	19
	MTT-10-P	SC-2001401A	10	2	.630	1.250	12mm	2-7/8	15
	MTT-10-P-1	SC-2001402A	10	4	.630	1.250	12mm	2-7/8	30
	KTT-10-P	SC-2001403A	10	2	.630	1.181	12mm	2-1/2	15
	KTT-10-P-1	SC-2001404A	10	4	.630	1.181	12mm	2-1/2	30
10	KTT-12-10-P	SC-2001405A	12	2-1/2	.630	1.181	12mm	2-1/2	28
	KTT-12-10-P-1	SC-2001406A	12	5	.630	1.181	12mm	2-1/2	51
	KTT-15-10-P	SC-2001407A	15	3	.630	1.181	12mm	2-1/2	51
	KTT-15-10-P-1	SC-2001408A	15	4	.630	1.181	12mm	2-1/2	72
	KTT-18-10-P	SC-2001409A	18	3	.630	1.181	12mm	2-1/2	85
	KTT-18-10-P-1	SC-2001410A	18	4	.630	1.181	12mm	2-1/2	110
	HOW-27M10-P	SC-2001411A	10	2	.710	1.181	14mm	3	15
	HOW-27M10-P-1	SC-2001412A	10	4	.710	1.181	14mm	3	30
	HAR10MSHP	SC-2001413A	10	2	.630	1.181	12mm	2-3/4	15
	HAR10MSHP1	SC-2001414A	10	4	.630	1.181	12mm	2-3/4	30

*No gap between jaws

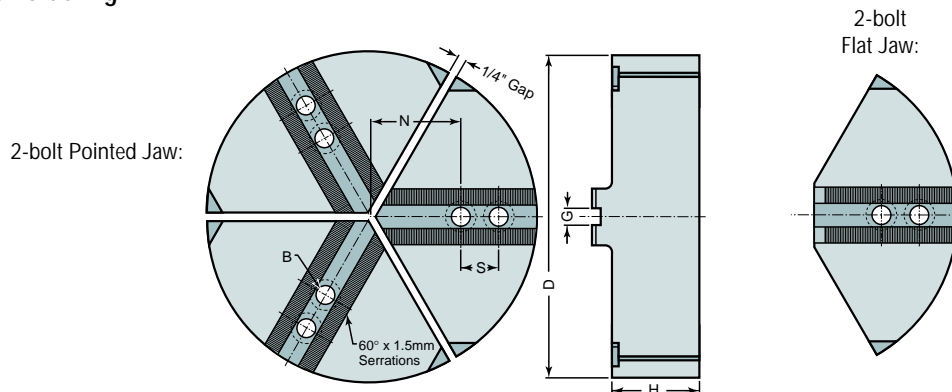
When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style Q (Continued)

Aluminum Pie Jaws[®] with Fine Metric Serrations (1.5mm x 60°)

See Style "P" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with A319 Cast Aluminum

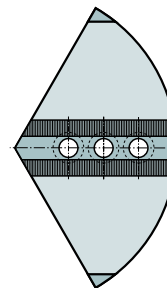
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
12	KTT-12-P-A ³	SC-2001415A	12	2-1/2	.710	1.181	14mm	2-5/16	28
	KTT-12-P-1-A ³	SC-2001416A	12	5	.710	1.181	14mm	2-5/16	51
	KTT-15-12-P-A ³	SC-2001417A	15	3	.710	1.181	14mm	2-5/16	51
	KTT-15-12-P-1	SC-2001418A	15	4	.710	1.181	14mm	3-3/4	72
	KTT-18-12-P-A ³	SC-2001419A	18	3	.710	1.181	14mm	2-3/16	71
	KTT-18-12-P-1 ³	SC-2001420A	18	4	.710	1.181	14mm	2-3/16	96
	KTT-21-12-P-2 ^{3*}	SC-2001421A	21	2	.710	1.181	14mm	2-3/16	70.5
	KTT-21-12-P-3 ^{3*}	SC-2001422A	21	3	.710	1.181	14mm	2-3/16	102
	KTT-21-12-P-1 ^{3*}	SC-2001423A	21	4	.710	1.181	14mm	2-3/16	141
	KTT-B212-P-A ³	SC-2001424A	12	2-1/2	.828	1.181	16mm	2-11/16	28
	KTTB212-P-1-A ³	SC-2001425A	12	5	.828	1.181	16mm	2-11/16	51
	KTT-12-P-B	SC-2001426A	12	2-1/2	.710	1.488	14mm	2-3/8	28
	KTT-12-P-1-B	SC-2001427A	12	5	.710	1.488	14mm	2-3/8	51
	HOW-27M12-P	SC-2001428A	12	2-1/2	.827	1.377	16mm	2-3/4	28
HOW-27M12-P-1	SC-2001429A	12	5	.827	1.377	16mm	2-3/4	51	
SEIKI-12-P	SC-2001430A	12	2-1/2	.710	1.260	14mm	3-1/8	28	
SUG-12-P-STM	SC-2001431A	12	2-1/2	.788	1.377	12mm	3-7/16	28	
SUG-12-P-1-STM	SC-2001432A	12	5	.788	1.377	12mm	3-7/16	51	
14	SUG-14-P-STG	SC-2001433A	14	3	.827	1.771	16mm	4-3/16	46
	KTT-15-P-2	SC-2001434A	15	2	.866	1.693	20mm	4-5/16	32
15 & 18	KTT-15-P	SC-2001435A	15	3	.866	1.693	20mm	4-5/16	52
	DTT-15-P-1	SC-2001436A	15	4	.866	1.693	20mm	4-5/16	72
	KTT-18-15-P	SC-2001437A	18	3	.866	1.693	20mm	4-5/16	85
	KTT-18-15-P-1	SC-2001438A	18	4	.866	1.693	20mm	4-5/16	100
	KTT-21-15-P-2*	SC-2001439A	21	2	.866	1.693	20mm	4-5/16	70.5
	KTT-21-15-P*	SC-2001440A	21	3	.866	1.693	20mm	4-5/16	102
	KTT-21-15-P-1*	SC-2001441A	21	4	.866	1.693	20mm	4-5/16	141
	KTT-24-15-P-2*	SC-2001442A	24	2	.866	1.693	20mm	4-5/16	105
	KTT-24-15-P*	SC-2001443A	24	3	.866	1.693	20mm	4-5/16	146
	KTT-24-15-P-1*	SC-2001444A	24	4	.866	1.693	20mm	4-5/16	205
KTT-B215-P	SC-2001445A	15	3	1.004	1.689	20mm	4-5/16	52	
KTT-B215-P-1	SC-2001446A	15	4	1.004	1.689	20mm	4-5/16	72	
KTT-15-P-2.36	SC-2001447A	15	3	.886	2.360	20mm	3-3/16	52	
KTT-15-P-12.36	SC-2001448A	15	4	.886	2.360	20mm	3-3/16	72	

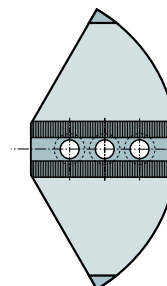
³ 3-bolt

*Flat nose

3-bolt
Pointed Jaw:



3-bolt
Flat Jaw:



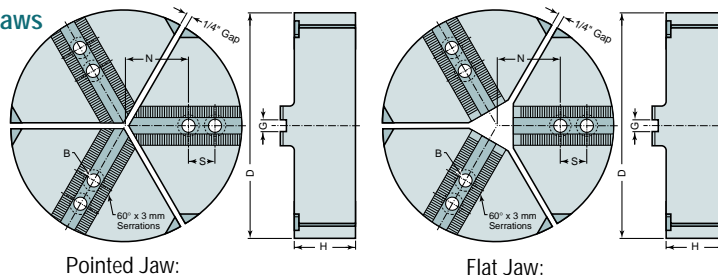
When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style S

Aluminum Pie Jaws[®] with Coarse Metric Serrations (3mm x 60°)

See Style "H" for corresponding straight aluminum or steel jaws

These jaws are made with A319 cast aluminum. A wide selection of steel and cast iron jaws is also available in this style. (Note: Steel and cast iron jaw weights are approximately 3 times that of the aluminum weights listed below). Please specify material when ordering.



Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

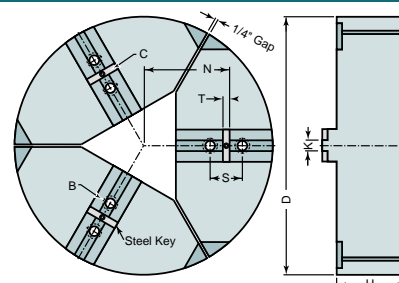
Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	G (Groove)	S (Spacing)	B (Bolt)	N (Nose)	Weight (lb) Set of 3
8	HOW-8-P	SC-2001607A	8	2	.533	.985	12mm	2	10
	HOW-8-P-1	SC-2001608A	8	4	.553	.985	12mm	2	20
10	HOW-10-P	SC-2001609A	10	2	.630	1.181	12 or 14mm	3	15
	HOW-10-P-1	SC-2001610A	10	4	.630	1.181	12 or 14mm	3	30
12	HOW-12-P	SC-2001611A	12	2-1/2	.708	1.181	14mm	3-5/8	28
	HOW-12-P-1	SC-2001612A	12	5	.708	1.181	14mm	3-5/8	51
	HOW-15-12-P*	SC-2001613A	15	3	.708	1.181	14mm	3-5/8	51
	HOW-18-12-P	SC-2001614A	18	3	.708	1.181	14mm	3-5/8	85
15	HOW-15-P	SC-2001615A	15	3	1.025	1.970	20mm	2-3/4	51
	HOW-27M-15-P	SC-2001616A	15	3	1.025	1.653	20mm	4-5/16	51
	HOW-7MA-15-P	SC-2001617A	15	3	.826	1.575	16mm	4-1/8	51
	HOW-7MA-15-P-1	SC-2001618A	15	4	.826	1.575	16mm	4-1/8	72
	MTT-15-P	SC-2001619A	15	3	.868	1.960	20mm	4-1/8	51
	MTT-15-P-1	SC-2001620A	15	4	.868	1.960	20mm	4-1/8	72
18	KTT-18-P	SC-2001621A	18	3	.985	2.362	20mm	4-1/8	85
	KTT-18-P-1	SC-2001622A	18	4	.985	2.362	20mm	4-1/8	100
	MTT-18-15-P	SC-2001623A	18	3	.868	1.960	20mm	4-1/8	85
	MTT-18-15-P-1	SC-2001624A	18	4	.868	1.960	20mm	4-1/8	100
21	KTT-21-P-2	SC-2001625A	21	2	.984	2.362	20mm	4-3/4	70.5
	KTT-21-P*	SC-2001626A	21	3	.984	2.362	20mm	4-3/4	102
	KTT-21-P-1*	SC-2001627A	21	4	.984	2.362	20mm	4-3/4	141
	KTT-24-21-P-2*	SC-2001628A	24	2	.984	2.362	20mm	4-3/4	105
	KTT-24-21-P*	SC-2001629A	24	3	.984	2.362	20mm	4-3/4	146
	KTT-24-21-P-1*	SC-2001630A	24	4	.984	2.362	20mm	4-3/4	205
	KTT-28-21-P*	SC-2001631A	28	3	.984	2.362	20mm	4-3/4	183
	KTT-28-21-P-1*	SC-2001632A	28	4	.984	2.362	20mm	4-3/4	275
24	KTT-24-P-2*	SC-2001633A	24	2	.984	2.362	20mm	7-1/2	105
	KTT-24-P*	SC-2001634A	24	3	.984	2.362	20mm	7-1/2	146
	KTT-24-P-1*	SC-2001635A	24	4	.984	2.362	20mm	7-1/2	225
	KTT-28-24-P*	SC-2001636A	28	3	.984	2.362	20mm	7-1/2	183
	KTT-28-24-P-1*	SC-2001637A	28	4	.984	2.362	20mm	7-1/2	275

*Flat nose

Style W

Bullard Style Aluminum Jaws—Slot-Type

See Style "C" for corresponding straight aluminum or steel jaws



3-JAW CHUCKS

Made with A319 Cast Aluminum

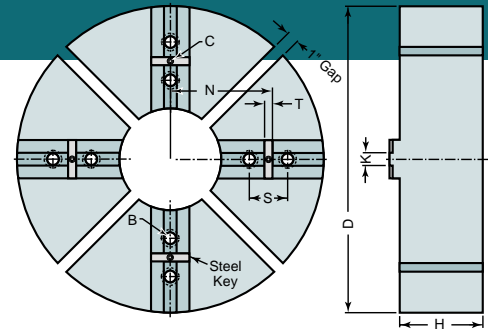
SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	K	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	C (Cap Screw)	Weight (lb) Set of 3	Radius
24-56	24-Bullard	SC-0001700A	24	4	1.000	.625	3	7/8	8	5/16-18	159	—
	30-Bullard	SC-0001701A	30	4	1.000	.625	3	7/8	9	5/16-18	255	—
	36-Bullard	SC-0001702A	36	4	1.000	.625	3	7/8	12	5/16-18	318	8
	56-Bullard	SC-0001704A	56	4	1.000	.625	3	7/8	23	5/16-18	634	—

When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

Style W – Continued

Bullard Style Aluminum Jaws—Slot-Type



4-JAW CHUCKS

Made with A319 Cast Aluminum

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	D (Diameter)	H (Height)	K	T (Tongue)	S (Spacing)	B (Bolt)	N (Nose)	C (Cap Screw)	Weight (lb) Set of 4	Radius
20-40	20-Bullard-4J	SC-0001705A	20	4	1.000*	.625	4	3/4**	7-5/16	5/16-18	92	4
	28-Bullard-4J	SC-0001706A	28	4	1.000*	.625	4	3/4**	10-5/16	5/16-18	182	6
	38-Bullard-4J	SC-0001707A	38	4	1.000*	.625	4-3/4	3/4**	14-13/16	5/16-18	312	10

*K dimension available as 1.060 When using oversized jaws, maximum RPM must be reduced - Consult your chuck manual

**7/8 screw size available

Hardinge® Quick-Change Sure-Grip® Jaws

See brochure 2357 for corresponding Hardinge Quick-Change Sure-Grip Chucks



QUICK-CHANGE TOP JAW

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size (in)	Chuck Model No.	Spindle Nose	Top Jaw Model No.	Top Jaw Part No.	Length	Width	Height	Serrations	ϕ	Thread	Weight (lb) Set of 3
6	CM2-306C-5Q	A2-5	6MQP2	SC-2000747S	3.15	1.25	1.46	1.5mm x 60°	1.22	M10 x 1.5	3.36
	HM-306-Q	A2-5	6MQP1	SC-2000741S	3.03	1.25	1.46	1.5mm x 60°	1.22	M10 x 1.5	3.36
	HM-306-6Q	A2-6	6MQP3	SC-2000746S	3.05	1.25	1.46	1.5mm x 60°	1.22	M10 x 1.5	3.36
	HM-306-6LQ	A2-6	6MQP3	SC-2000746S	3.05	1.25	1.46	1.5mm x 60°	1.22	M10 x 1.5	3.36
8	HM-308-5Q	A2-5	8MQP1	SC-2000721S	3.76	1.50	1.63	1.5mm x 60°	1.68	M10 x 1.5	5.52
	CM2-308C-6Q	A2-6	8MQP2	SC-2000727S	4.19	1.50	1.63	1.5mm x 60°	1.68	M10 x 1.5	5.52
	CM2-308B-6Q	A2-6	8MQP1	SC-2000721S	3.76	1.50	1.63	1.5mm x 60°	1.68	M10 x 1.5	5.52
	HM-308-Q	A2-6	8MQP1	SC-2000721S	3.76	1.50	1.63	1.5mm x 60°	1.68	M10 x 1.5	5.52
10	HM-310-6Q	A2-6	10MQP1	SC-2000701S	4.58	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48
	CM2-310B-8Q	A2-8	10MQP1	SC-2000701S	4.58	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48
	CM2-310C-8Q	A2-8	10MQP2	SC-2000706S	4.87	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48*
	HM-310-8Q	A2-8	10MQP1	SC-2000701S	4.58	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48
	HVM-310-8Q	A2-8	10MQP1	SC-2000701S	4.58	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48
	HVM-310-11Q	A2-11	10MQP1	SC-2000701S	4.58	1.75	1.72	1.5mm x 60°	2.05	M12 x 1.75	9.48
12	CM2-312C-8Q	A2-8	12MQP1	SC-2000761S	5.42	2.00	1.96	1.5mm x 60°	2.55	M16 x 2	13.5
	HM-312C-8Q	A2-8	12MQP1	SC-2000761S	5.42	2.00	1.96	1.5mm x 60°	2.55	M16 x 2	13.5
	HVM-312C-8Q	A2-8	12MQP1	SC-2000761S	5.42	2.00	1.96	1.5mm x 60°	2.55	M16 x 2	13.5
	HVM-312C-11Q	A2-11	12MQP1	SC-2000761S	5.42	2.00	1.96	1.5mm x 60°	2.55	M16 x 2	13.5

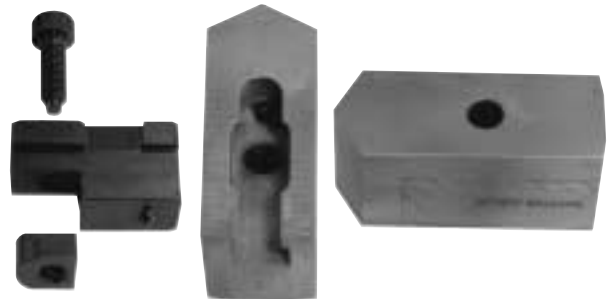
Quick-Change Conversion Kits

for 6", 8", 10" and 12" Hardinge Sure-Grip Power Jaw Chucks

See brochure 2357 for corresponding Sure-Grip Chucks

KIT CONFIGURATIONS

Chuck Size (in)	Sure-Grip Chuck Model No.	Spindle Nose	Top Jaw Model No.	Conversion Kit Assembly No.
6	CM2-306C-5	A2-5	6MQP2	SC-2000747QC
	HM-306	A2-5	6MQP1	SC-2000741QC
	HM-306-6	A2-6	6MQP3	SC-2000746QC
	HM-306-6L	A2-6	6MQP3	SC-2000746QC
8	HM-308-5	A2-5	8MQP1	SC-2000721QC
	CM2-308B-6	A2-6	8MQP1	SC-2000721QC
	CM2-308C-6	A2-6	8MQP2	SC-2000727QC
	HM-308	A2-6	8MQP1	SC-2000721QC
10	HM-310-6	A2-6	10MQP1	SC-2000701QC
	CM2-310B-8	A2-8	10MQP1	SC-2000701QC
	CM2-310C-8	A2-8	10MQP2	SC-2000706QC
	HM-310-8	A2-8	10MQP1	SC-2000701QC
	HVM-310-8	A2-8	10MQP1	SC-2000701QC
	HVM-310-11	A2-11	10MQP1	SC-2000701QC



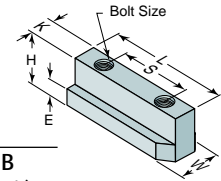
Chuck Size (in)	Sure-Grip Chuck Model No.	Spindle Nose	Top Jaw Model No.	Conversion Kit Assembly No.
12	HCM-312C-8	A2-8	12MQP1	SC-2000761QC
	HM-312C-8	A2-8	12MQP1	SC-2000761QC
	HVM312C-8	A2-8	12MQP1	SC-2000761QC
	HVM-312C-11	A2-11	12MQP1	SC-2000761QC

Accessories

Jaw Nuts

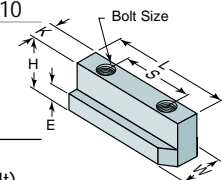
■ = Used for Hardinge® jaw chucks

TO FIT CHUCKS WITH 1.5mm x 60° SERRATIONS



SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	L (Length)	H (Height)	W (Width)	K	E	S (Spacing)	B (Bolt)
4" HARDINGE	A2-4	SC-0000223	1.136	.705	.553	.393	.219	.551"	M8-1.25
5" HARDINGE - Both Required	A2-5	SC-0000065	.620	.705	.553	.393	.219	N/A	M8-1.25
5" HARDINGE - Both Required	A2-5	SC-0000067	.595	.705	.553	.393	.219	N/A	M8-1.25
5" KITAGAWA	JN-135-A	SC-0001708	1-3/16	.612	.550	.394	.215	.708	5/16-18
6" HARDINGE	A2-5	SC-0000015	1.570	.719	.646	.470	.250	.787	M10-1.5
6" HARDINGE	A2-6	SC-0000500	1.507	.719	.646	.470	.250	.787	M10-1.5
6" MATSUMOTO	JN-6B-M	SC-0001709	1-7/16	.885	.689	.430	.295	.969	8mm
	JN-6B-A	SC-0001710				11mm			5/16-18
6" KITAGAWA	JN-6K-M	SC-0001711	1-7/16	.728	.689	.471	.295	.786	10mm
HOWA HO15M-6	JN-6K-A	SC-0001712				12mm			3/8-16
HOWA HO7MA-6	JN-6H-A	SC-0001713	1-7/16	.551	.669	.471	.295	.787	5/16-18
8" HARDINGE - Both Required	A2-5 & A2-6	SC-0000115	.650	.976	.750	.548	.313	N/A	M12-1.75
8" HARDINGE - Both Required	A2-5 & A2-6	SC-0000131	.700	.796	.750	.548	.313	N/A	M12-1.75
8" KITAGAWA B-8	JN-149-M	SC-0001714	1-7/8	.970	.807	.549	.340	1.000	12mm
8" MATSUMOTO	JN-149-A	SC-0001715				14mm			1/2-13
HOWA HO7MA-8									
HOWA HO15-8									
8" KITAGAWA B-208	JN-208-M	SC-0001716	1-7/8	.810	.807	.549	.340	1.000	12mm
	JN-208-A	SC-0001717				14mm			1/2-13
10" HARDINGE	A2-6, A2-8, A2-11	SC-0000165	2.227	.976	.923	.631	.390	1.187	M12-1.75
10" HOWA	JN-81-M	SC-0001718	2	1.000	.910	.628	.374	.984	12mm
HOWA HO7MA-10/HO27M-8	JN-81-A	SC-0001719				16mm			1/2-13
10" KITAGAWA B-10	JN-82-M	SC-0001720	2	1.000	.910	.628	.340	1.181	12mm
11" MATSUMOTO	JN-82-A	SC-0001721				16mm			1/2-13
HOWA HO1MA-10 B-10									
10" KITAGAWA B-210	JN-210-M	SC-0001722	2	.850	.885	.628	.340	1.181	12mm
	JN-210-A	SC-0001723				16mm			1/2-13
10" HOWA HOLLOW	JN-95-M	SC-0001724	2-1/2	1.141	1.000	.825	.413	1.578	20mm
HOWA HO7MA-15	JN-95-A	SC-0001725				21mm			3/4-10
12" HARDINGE	A2-8 & A2-11	SC-0000412	2.470	1.047	1.170	.825	.443	1.181	M16-2
HO27M-12	JN-157-A	SC-0001726	2-1/2	1.141	1.000	.825	.413	1.578	5/8-11
12" KITAGAWA B-12	JN-108-M	SC-0001727	2-1/4	1.250	1.040	.708	.530	1.181	14mm
12" MATSUMOTO	JN-108-A	SC-0001728				18mm			9/16-12
10" HOWA HO1MA-12									
HO7MA-12/HO27M-10									
12" KITAGAWA B-212	JN-112-M	SC-0001729	2-3/16	1.095	1.160	.826	.455	1.181	16mm
	JN-112-A	SC-0001730				21mm			5/8-11
10-12" HOWA	JN-113-M	SC-0001731	2	.875	.875	.630	.335	1.181	12mm
SOLID	JN-113-A	SC-0001732				16mm			1/2-13
10-12" NIKKO HOLLOW	JN-125-A	SC-0001733	2-3/16	1.320	1.040	.787	.531	1.375	1/2-13
15" KITAGAWA B-15	JN-155-M	SC-0001734	3-1/4	1.750	1.320	.864	.625	1.690	20mm
	JN-155-A	SC-0001735				22mm			3/4-10
15" KITAGAWA B-215	JN-115-M	SC-0001736	3-5/32	1.545	1.375	.998	.742	1.693	20mm
	JN-115-A	SC-0001737				25.5mm			3/4-10



TO FIT CHUCKS WITH 3mm x 60° SERRATIONS

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model No.	Part No.	L (Length)	H (Height)	W (Width)	K	E	S (Spacing)	B (Bolt)
12" HOWA	JN-143-M	SC-0001738	2-1/16	1.250	1.040	.708	.530	1.181	14mm
HO7-MA-12	JN-143-A	SC-0001739				18mm			9/16-12
18-20" HOWA	JN-183-M	SC-0001740	3-1/4	1.575	1.339	1.022	.669	1.968	20mm
HOWA HO27M-18	JN-183-A	SC-0001741				26mm			3/4-10
18" KITAGAWA	JN-203-A	SC-0001742	3-1/4	1.375	1.375	.984	.500	1.907	3/4-10
21" KITAGAWA	JN-213-A	SC-0001743	3-3/4	1.375	1.375	.984	.500	3.362	3/4-10
24" KITAGAWA	JN-223-A	SC-0001744	4-3/4	1.375	1.375	.984	.500	3.362	3/4-10
15-18" MATSUMATO	JN-153-A	SC-0001745	3-5/32	1.500	1.330	.864	.750	1.960	3/4-10
12" PRATT BURNERD	JN-26512	SC-0001746	2-1/2	1.060	1.220	.825	.438	1.250	5/8-11

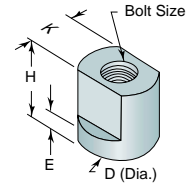
Accessories

Jaw Nuts and I-Beam Assemblies

TO FIT SMW CHUCKS

SPECIFICATIONS (inches—unless specified otherwise)

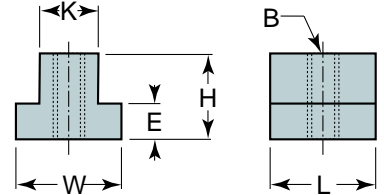
Chuck Size	Model No.	Part No.	H (Height)	D (Diameter)	K	E	B (Bolt)	Weight (lb)
12	JK224	SC-0001747	1.168	1.10	.825	.425	1/2-13	.3
16-20	JK225	SC-0001748	1.340	1.34	1.002	.575	3/4-10	.5



TO FIT CHUCKS WITH 1/16" x 90° SERRATIONS

SPECIFICATIONS (inches—unless specified otherwise)

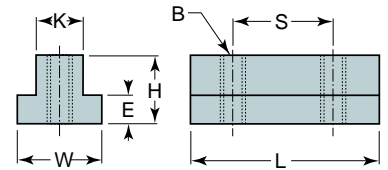
Chuck Size	Model No.	Part No.	L (Length)	H (Height)	W (Width)	K	E	B (Bolt)	Weight (lb)
6	JK232	SC-0001749	5/8	.581	.530	.432	.252	5-16-18	.1
8	JK233	SC-0001750	3/4	.606	.750	.550	.252	3/8-16	.1
10	JK235	SC-0001751	1	.850	1.000	.786	.325	1/2-13	.2
14	JK236	SC-0001752	1-1/8	1.000	1.000	.826	.430	5/8-11	.2



TO FIT CHUCKS WITH ACME SERRATED MASTER KEYS

SPECIFICATIONS (inches—unless specified otherwise)

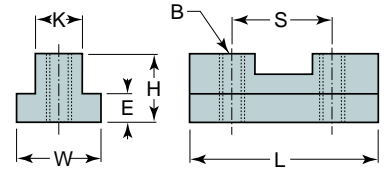
Chuck Size	Model Number	Part Number	L (Length)	H (Height)	W (Width)	K	E	S (Spacing)	B (Bolt)	Weight (lb)
10	CL213	SC-0001753	2-1/2	5/8	15/16	.678	.381	1-3/4	1/2-13	.5
12	CL215	SC-0001754	3	3/4	1-1/16	.802	.440	2	5/8-11	.5
15-18	CL217	SC-0001755	3-1/2	.7/8	1-1/4	.933	.550	2-1/2	3/4-10	.8
21-24	CL219	SC-0001756	4-1/4	1-3/16	1-9/16	1.159	.684	3	7/8-9	1.3



TO FIT CHUCKS WITH SQUARE SERRATED MASTER KEYS

SPECIFICATIONS (inches—unless specified otherwise)

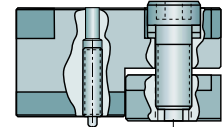
Chuck Size	Model Number	Part Number	L (Length)	H (Height)	W (Width)	K	E	S (Spacing)	B (Bolt)	Weight (lb)
8	JN-SP-8	SC-0001757	2-1/8	.996	.875	.498	.875	1-7/16	3/8-16	.4
8	BE203	SC-0001758	2-7/16	1	1	.750	.375	1-3/4	1/2-13	.5
10-12	BE204	SC-0001759	2-1/2	1	1	.750	.375	1-3/4	5/8-11	.5
15-18	BE207	SC-0001760	3-1/4	1-1/4	1-1/4	1.000	.437	2-1/2	3/4-10	1.2



I-BEAM ASSEMBLIES

for Hardinge Quick-Change Chuck Jaws

Chuck Size	Part Number	Chuck Size	Part Number
6" (A2-5)	SC-0000740 QC	10"	SC-0000700 QC
6.65" (A2-6)	SC-0000745 QC	10.5"	SC-0000700 QC
8"	SC-0000720 QC	12"	SC-0000760 QC

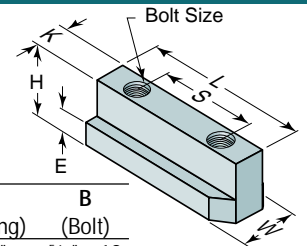


Jaw Nuts for Hardinge 1/16" x 90° Jaws

TO FIT CHUCKS WITH 1/16" x 90° SERRATIONS

SPECIFICATIONS (inches—unless specified otherwise)

Chuck Size	Model Number	Part Number	L (Length)	H (Height)	W (Width)	K	E	S (Spacing)	B (Bolt)
4" HARDINGE – Soft Jaw	A2-4	SC-0000098	1.245	.65	.553	.432	.219	.660"	5/16" x 18
4" HARDINGE – Hard Jaw	A2-4	SC-0000099	1.249	.65	.553	.432	.219	.709"	5/16" x 18
5" HARDINGE – Soft Jaw	A2-5	SC-0000098	1.245	.65	.553	.432	.219	.660"	5/16" x 18
5" HARDINGE – Hard Jaw	A2-5	SC-0000099	1.249	.65	.553	.432	.219	.709"	5/16" x 18
6" HARDINGE – Soft Jaw	A2-5	SC-0000048	1.430	.695	.600	.548	.250	.709"	3/8" x 16
6" HARDINGE – Hard Jaw	A2-5	SC-0000049	1.508	.695	.600	.548	.250	.787"	3/8" x 16
8" HARDINGE – Soft & Hard Jaw: Both Required	A2-6	SC-0000112	.725	.769	.830	.667	.313	N/A	7/16" x 14
8" HARDINGE – Soft & Hard Jaw: Both Required	A2-6	SC-0000101	.620	.769	.830	.667	.313	N/A	7/16" x 14
10" HARDINGE – Soft Jaw: Both Required	A2-6, A2-8, A2-11	SC-0000162	1.134	.953	1.110	.825	.406	N/A	M16-2
10" HARDINGE – Soft Jaw: Both Required	A2-6, A2-8, A2-11	SC-0000151	1.257	.953	1.110	.825	.406	N/A	M16-2
10" HARDINGE – Hard Jaw	A2-6, A2-8, A2-11	SC-0000193	2.196	.953	1.110	.825	.405	1.020	M16-2



Master Keys — Square and Acme Serrated

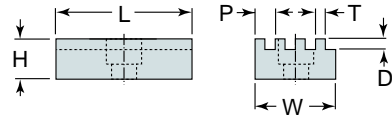
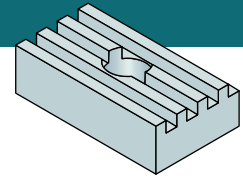
SQUARE SERRATED

Material: 4140 • Heat Treat R_c 40-45 • Finish: Black Oxide

SPECIFICATIONS (inches—unless specified otherwise)

Model No.	Part No.	W (Width)	H (Height)	L (Length)	D	T	P	Weight (lb)
A-8SK*	SC-0001761	.744	3/8	1-5/16	.101	.098	.200	.25
A-12SK*	SC-0001762	.995	1/2	1-11/16	.130	.124	.250	.25
A-18SK*	SC-0001763	1.487	1/2	2-1/4	.130	.124	.250	.50
A-21SK*	SC-0001764	1.487	1/2	2-1/2	.130	.124	.250	.52

*Screws included with Master Keys



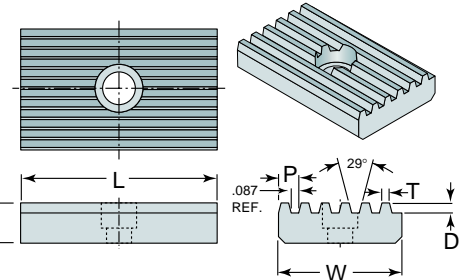
ACME SERRATED

Material: 4140 • Heat Treat R_c 40-45 • Finish: Black Oxide

SPECIFICATIONS (inches—unless specified otherwise)

Model No.	Part No.	W (Width)	H (Height)	L (Length)	D	T	P	Weight (lb)
A-12AK*	SC-0001765	1.030/1.029	1/2	1-11/16	.130	.093/.091	.250	.20
A-15AK*	SC-0001766	1.530/1.529	1/2	2-7/16	.130	.093/.091	.250	.45
A-21AK*	SC-0001767	1.530/1.529	1/2	2-7/8	.130	.093/.091	.250	.50

*Screws included with Master Keys



What do you do when you need a new chuck?

Buy a Hardinge® Sure-Grip® 3-Jaw Power Quick-Change Jaw Chuck.

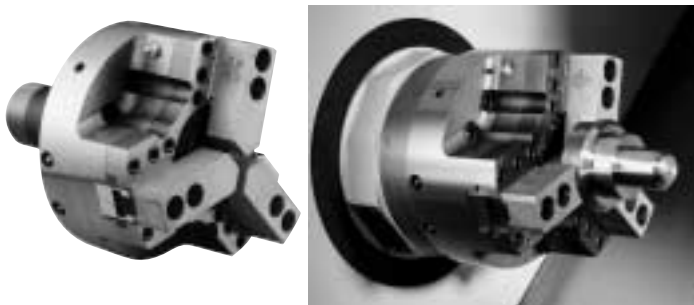
The Hardinge® Sure-Grip series of 3-jaw power chucks are lever-operated, counter-centrifugal and dynamically balanced. This enables you to continually operate your CNC lathe at higher spindle speeds and feed rates with less concern for loss of jaw force normally associated with other manufacturer's chucks. Hardinge chucks are directly mounted to ANSI A2-4, A2-5, A2-6 and A2-8 spindles, eliminating the need to adjust the chuck to the centerline of the spindle. Chucks are offered in 4", 5", 6", 8", 10" and 12" sizes with the largest thru-holes in the industry, reducing bar stock restrictions.

All Hardinge chucks are designed using the latest in design software. FEA Analysis is done during the design process to accurately depict structural deflections, stress levels, thermal response and vibration response of the assembled components.

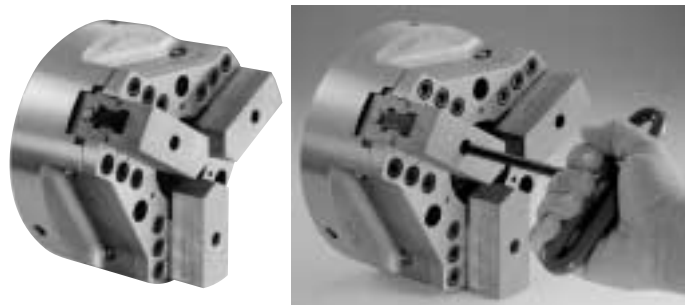
The Hardinge Quick-Change Sure-Grip power chucks have the same features as the standard Sure-Grip chucks plus the ability to quickly change the jaws during setup. Each top jaw changes with the simple turn of a single locking bolt in less than one minute (much faster than conventional jaws). No special tools are required, just a standard hex wrench.

For detailed information, specifications and part numbers, request Brochure #2357.

Sure-Grip 3-Jaw Power Chuck



Sure-Grip Quick-Change 3-Jaw Power Chuck



Want to do higher precision machining?

Convert Your Jaw Chuck-Style Lathe into a Collet Lathe.

Hardinge HCAC™ Collet Adaptation Chucks help move you up to a higher precision, higher production shop. Setup time takes a pleasant drop allowing more time to make products. Collet Adaptation Chucks convert a chuck-style spindle into a collet-style spindle. Collets run truer than jaw chucks, allowing you to eliminate many secondary operations. You can choose a draw-style collet adaptation chuck to provide the best TIR possible, or the stationary-collet style for its ability to hold lengths, even when the chucking diameter varies.

Plain nose adapters are used with standard draw-collets or style “S” master collets. When step chucks and closers, spindle mounted expanding collets, fixture plates and other spindle mounted tooling need to be used, the spindle-to-spindle collet adaptation chuck is required.

Collet Adaptation Chucks are also available to convert a draw-collet spindle system into a push-collet system. The B42 can be adapted for an A2-8 spindle nose and the B65 for an A2-6 spindle nose.

If your shop already has a set of draw collets but needs precise length control, use the Dead-Length® Collet Adaptation Chucks for draw collets. This design holds the draw collet stationary while a sleeve closes the collet.

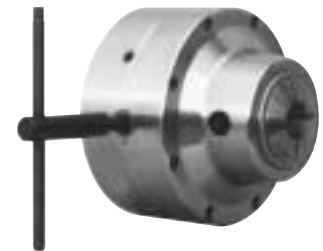
To get more information about Hardinge HCAC Collet Adaptation Chucks, give us a call or fax at the numbers shown on the back page of this brochure. Ask for Brochure #2352.



5C Draw Collet Adaptation Chuck



16C Draw Collet Adaptation Chuck with A2-5 or A2-6 Spindle Nose



Manual Scroll-Style Collet Adaptation Chuck



S26 Master Draw Collet Adaptation Chuck



B42 Stationary Collet Adaptation Chuck



Dead-Length® Draw Collet Adaptation Chuck



Hardinge HCAC Collet Adaptation Chucks Brochure # 2352

Additional Hardinge® Products



Hardinge Workholding/Industrial Products:
Brochure #2353



The Hardinge Advantage:
Brochure #23277



Hardinge HCAC™ Collet Adaptation Chucks:
Brochure #2352



Swiss-Type Collets & Guide Bushings:
Brochure #2283



Collets for Automatics:
Brochure #2287



Hardinge Sure-Grip® Expanding Collet Systems:
Brochure #2270



HQC® Quick-Change Collet Systems:
Brochure #2339



Precision Tool Holding Systems & Mill Tooling:
Brochure #2350



Toolholder Collets, Toolholder Bushings & Round Shank Holders:
Brochure #2351



CNC Rotary & Indexing Tables:
Brochure #2356



Hardinge Spindle Tooling for Manual & CNC Lathes:
Brochure #2348



Sure-Grip® 3-Jaw Power Chucks for All Brands of Lathes:
Brochure #2357



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of Machine Tools and
Workholding/ Industrial Products



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Part No. HAA-0009500-2358
January 2001

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