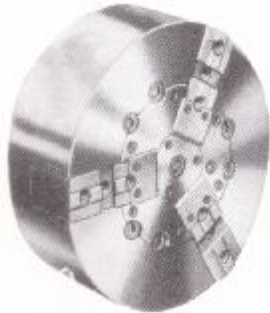




# Large 3-Jaw Self-Centering Non Thru-Hole Power Chucks Wedge Type

Made in U.S.A.



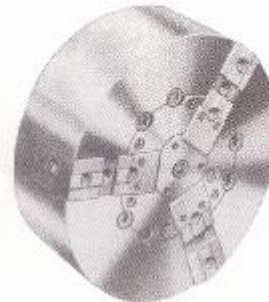
Non-Adjustable Jaws

Recommended for general manufacturing service where adjustability of individual jaws is not required. Particularly suited for repetitive operations, especially heavy workpieces. When fitted with soft blank jaws machined to desired shapes, provides a simple and economical method of workholding, eliminating costly special devices. Balanced to eliminate vibration and chatter at high RPM.

Am. Std Tongue & Groove, Acme, 3mm x 60 or Square Serrated Master Jaws

For draw tube type change number from 20-620 to 20-623

Size	Part Number	Est Weight (lbs)
21	KC-620-21-A11	560
21	KC-620-21-A15	560
24	KC-620-24-A11	700
24	KC-620-24-A15	700
28	KC-620-28-A11	1100
28	KC-620-28-A15	1100
32	KC-620-32-A15	1450
32	KC-620-32-A20	1450
36	KC-620-36-A15	1800
36	KC-620-36-A20	1800



Adjustable Jaws

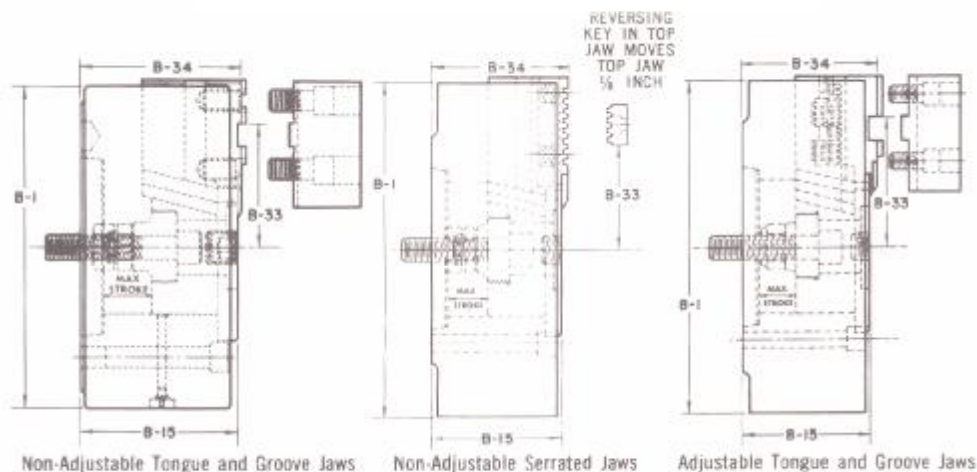
Self-centering power chucks with jaws providing independent jaw action are simple and quick to adjust. This series of chucks is designed for accurate, expeditious holding of irregularly shaped workpieces. Initial accuracy maintained on repetitive chucking operations.

Am. Std Tongue & Groove, Acme, or Square Serrated Master Jaws

For draw tube type change number from 20-670 to 20-673

Size	Part Number	Est Weight (lbs)
21	KC-640-21-A11	360
21	KC-640-21-A15	560
24	KC-640-24-A11	560
24	KC-640-24-A15	700
28	KC-640-28-A11	700
28	KC-640-28-A15	1100
32	KC-640-32-A15	1250
32	KC-640-32-A20	1450
36	KC-640-36-A15	1800
36	KC-640-36-A20	1800

# POWER CHUCK DIMENSIONS



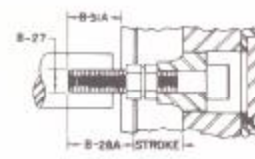
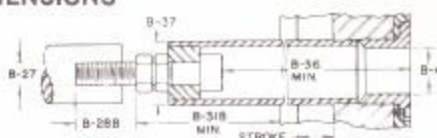
Chuck Size	B-1	B-15	Wedge Stroke	Each Jaw Moves	B-34 Non-Adj T&G	B-34 Adj T&G	B-34 Non-Adj Serr.	B-33 Non-adjustable T & G Jaws		B-33 Adjustable T & G Jaws		B-33 Non-adjustable Serrated Jaws	
								Min Closed	Max Open	Min Closed	Max Open	Min Closed	Max Open
6	6-1/2	3-1/4	1	1/4	3-25/64	3-25/64	-	2-1/4	2-1/2	-	-	-	-
8	8-1/4	4-1/4	1-1/4	5/16	4-11/32	4-11/32	-	2-3/4	3-1/16	2-3/4	3-7/16	-	-
10	10	4-13/16	1-1/2	3/8	4-15/16	4-15/16	5	3-7/16	3-13/16	3-7/16	4-5/16	2-11/32	3-23/32
12 A6	12	4-3/4	1-1/2	3/8	4-15/16	4-57/64	5	4-1/8	4-1/2	3-15/16	5-3/16	2-31/32	4-11/32
12 A8	12	4-13/16	1-1/2	3/8	4-57/64	4-15/16	5-1/16	4-1/8	4-1/2	4-1/2	5-1/16	2-31/32	4-19/32
15	15	5-1/2	1-1/2	3/8	4-15/16	5-5/8	5-13/16	5-1/4	5-5/8	5-1/4	6-5/8	3-27/32	5-15/32
15 A8***	15	5-13/16	1-1/2	3/8	5-5/8	5-5/8	6-1/8	5-1/4	5-5/8	5-1/4	6-5/8	3-27/32	5-15/32
18	18	5-1/2	1-1/2	3/8	5-5/8	5-13/16	6	5-1/4*	7-1/8**	5-1/4*	8-5/8**	3-27/32	6-29/32
21	21	5-11/16	2	3/8	5-13/16	6-1/8	6-13/16	6-3/4*	8-5/8**	6-3/4*	10-1/4**	5-15/16	8-7/32
24	24	6-9/16	2	3/8	6-45/64	6	6-7/8	6-3/4*	10-1/8**	6-3/4*	11-3/4**	5-15/16	9-23/32
28	28	6-9/16	2	3/8	6-45/64	6-13/16	6-7/8	7-1/4	12-7/8	7-1/4	13-3/4	5-61/64	11-19/32
30	30	6-9/16	2	3/8	6-45/64	6-13/16	6-7/8	6-47/64	13-1/8	6-3/4	14-3/4	5-61/64	12-19/32
32	32	6-9/16	2	3/8	6-45/64	6-7/8	6-7/8	7-47/64	14-1/8	6-3/4	14-7/8	5-61/64	15-19/32
36	36	6-9/16	2	3/8	6-45/64	6-7/8	6-7/8	6-47/64	16-1/8	6-3/4	18-3/4	5-61/64	15-27/32

\*Measured from inner keyway    \*\*Measured from outer keyway    \*\*\*2-3 Jaw only

## DRAW SCREW AND DRAW TUBE DIMENSIONS



Standard Draw Tube and Pilot-Bar Bushing



Draw Screw Ass'y

Chuck Size	B-4		B-27	B-28A	B-28B	B-31A	Stroke	B31-B	B-36	B-37
	Standard	Max Bore								
6	5/8	3/4	5/8-18	1-11/16	1-11/16	1-3/8	1	6-1/4	7-1/16	1-3/8
8	1-1/16	1-1/4	5/8-18	1-7/16	1-11/16	7/8	1-1/4	6	7-3/4	1-3/4
10	1-1/16	1-1/2	3/4-16	1-5/8	1-5/8	1-5/32	1-1/2	10-5/8	12-5/16	Δ
12 A6	1-1/16	1-1/2	3/4-16	1-5/8	1-5/8	1-5/64	1-1/2	10-5/8	12-5/16	2-3/8
12 A8	1-1/2	1-3/4	1-14	2-13/16	2-13/16	2-3/8	1-1/2	10-3/4	11-7/8	2-3/8
15	1-15/16	2-15/16	1-14	2-3/4	2-3/4	2-5/16	1-1/2	11-11/16	13-7/16	2-3/4
15 A8*	1-15/16	2-15/16	1-14	2-9/16	2-3/4	2-1/16	1-1/2	11-7/16	13-7/16	2-3/4
18	2-1/2	2-3/4	1-14	2-3/4	2-3/4	2-1/8	1-1/2	13-1/4	15-1/4	3-3/4
21	2-1/2	3-1/2	1-14	2-13/16	2-13/16	1-3/4	1-3/4	17-1/2	20-3/8	4
24-36	2-1/2	3-1/2	1-14	2-13/16	2-13/16	1-3/4	1-3/4	17-1/2	20-3/8	4

Special sizes available upon request    Δ A6 – 2-5/16", A8 – 2-3/8"    \*2-3 Jaw only    \*\*With wedge forward