

# *Quick Change Collet Chucks*





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## Commitment to Service

MicroCentric Quick Change Collet Chucks are available from stock and can be adapted to any machine configuration. MicroCentric is not only committed to building the world's finest workholding products, but we also strive to provide our customers with unmatched service and support.



Made in U.S.A

## Quick Change Collet Chuck Models

All components of MicroCentric Collet Chucks are made from alloy steel hardened and precision ground for highest accuracy and long term performance. Their modular design makes it possible to adapt MicroCentric chucks to all machine spindle and draw tube configurations.

### NX Series - *Low Profile Dead Length Design*



The CB-NX series is a dead length design with a reduced diameter nose for maximum tool clearance. The collet is coupled directly to the chuck body and remains fixed as the tapered seat moves forward when the chuck is actuated. The collet remains fixed in the Z axis during clamping and therefore does not create a pull back effect on the bar stock or workpiece.

### ND Series - *Dead Length Design*



The ND series models are used for collet sizes 120mm and larger. The collet is coupled directly to the chuck body and remains fixed as the tapered seat moves forward when the chuck is actuated. The collet remains fixed in the Z axis during clamping and therefore does not create a pull back effect on the bar stock or workpiece.

### NB Series - *Pull Back Design*



In the NB series chuck, the collet is coupled directly to the draw tube connector. When the draw tube is actuated, the collet is drawn into the tapered seat of the chuck body, efficiently translating draw tube force into maximum clamping force.

### NDR Series - *Pull to Close Dead Length Design*



The CB-NDR is a patented *Dead Length* design for use with servo stop bar loaders. Unlike conventional dead length collet chucks, the NDR is actuated as the draw tube is drawn toward the machine spindle to prevent the bar from being pushed off the servo stop.

### NK Series - *Combination Design for Bar & Chucking Work*



NK series chucks are a pull back design with the added flexibility of being able to mount end stops inside the chuck body for easy conversion from bar to chucking applications. The collet is coupled directly to the draw tube connector. As the draw tube is actuated the collet is drawn into the tapered seat efficiently translating draw tube force into maximum clamping force.



### NRB Series - *Self Contained Pull Back* Design for Stationary Applications



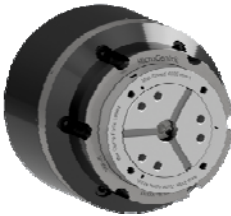
The NRB series is a hydraulically actuated self-contained *Pull Back* design for non-rotating applications. The collet is coupled to the built-in piston and is drawn into the tapered seat when the chuck is actuated. Part stops can be mounted inside the chuck body.

### AG Series - *Compensating Pull Back* Design



The CB-AG series collet chuck is a pull back design with a floating collet seat for machining shafts between centers. Centers or other part locators are mounted in the ID of the chuck. The floating collet seat can also be locked out to clamp parts on-center. Compact OD and short length provides greater rigidity compared to other compensating chuck designs.

### WSF Series - *Retractable* Design



Shafts can be machined complete between centers with MicroCentric's retractable collet chuck. A face driver mounted in the ID of the chuck drives the shaft as it is supported by the tailstock to turn the end of the shaft. When the chuck is actuated the collet moves forward to clamp the turned diameter enabling the OD of the shaft to be machined completed while the end of the shaft is securely clamped.

## CB-NX Collet Chucks - Dead Length Design

The CB-NX series is a low profile dead length design with a reduced diameter nose for maximum tool clearance. The collet is coupled directly to the chuck body and remains fixed as the tapered seat moves forward when the chuck is actuated. The collet remains fixed in the Z axis during clamping and therefore does not create a pull back effect on the bar stock or workpiece.



### CB-NX Features

- Low Profile Dead Length design
- Reduced diameter nose and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up tapered collet seat within .0002" (0.005mm)
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life
- Stop plates, stop housings, and ejectors can be mounted inside the chuck body for chucking applications

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB42-NX/A5	A2-5	42BZI	1.625"/42mm
CB42-NX/140	140mm	42BZI	1.625"/42mm
CB42-NX/A6	A2-6	42BZI	1.625"/42mm
CB52-NX/A5	A2-5	52BZI	2.000"/52mm
CB52-NX/140	140mm	52BZI	2.000"/52mm
CB52-NX/A6	A2-6	52BZI	2.000"/52mm
CB65-NX/A5	A2-5	65BZI	2.625"/66mm
CB65-NX/140	140mm	65BZI	2.625"/66mm
CB65-NX/A6	A2-6	65BZI	2.625"/66mm
CB65-NX/A8	A2-8	65BZI	2.625"/66mm
CB65-NX/A8-OS	A2-8	65BZI	2.625"/66mm
CB80-NX/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NX/A8	A2-8	80BZI	3.250"/82.5mm
CB80-NX/A11	A2-11	80BZI	3.250"/82.5mm
CB100-NX/A6	A2-6	100BZI	4.000"/100mm
CB100-NX/A8	A2-8	100BZI	4.000"/100mm
CB100-NX/A11	A2-11	100BZI	4.000"/100mm

\*CB-NX chucks with spindle adapters other than those listed above are quoted on request.

### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

### Optional Accessories

- Quick Change Collets (p.43)
- Stop plates (p. 55)
- Stop housings (p. 56)
- Ejector assemblies (p.57)
- Changing Fixtures (p. 54)

## CB42-NX Collet Chuck

### Specifications

Collet Model	42BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	1.625" / 42mm
Collet Capacity - Min Clamping Diameter	.156" / 4mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	7,868 lbs / 35 kN
Max Clamping Force	17,985 lbs / 80 kN
Maximum Speed	7,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB42-NX/A5</b>	1	A2-5	4.643" 117.93mm	- -	- -	M60x2	20.32 lbs 9.22 kg
<b>CB42-NX/140</b>	2	140mm	4.246" 107.85mm	.703" 17.86mm	5.950" 151.13mm	M60x2	19.30 lbs 8.75 kg
<b>CB42-NXA6</b>	2	A2-6	4.543" 115.39mm	1.000" 25.4mm	6.480" 164.59mm	M60x2 M75x2 (2 pc)	20.33 lbs 9.22 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

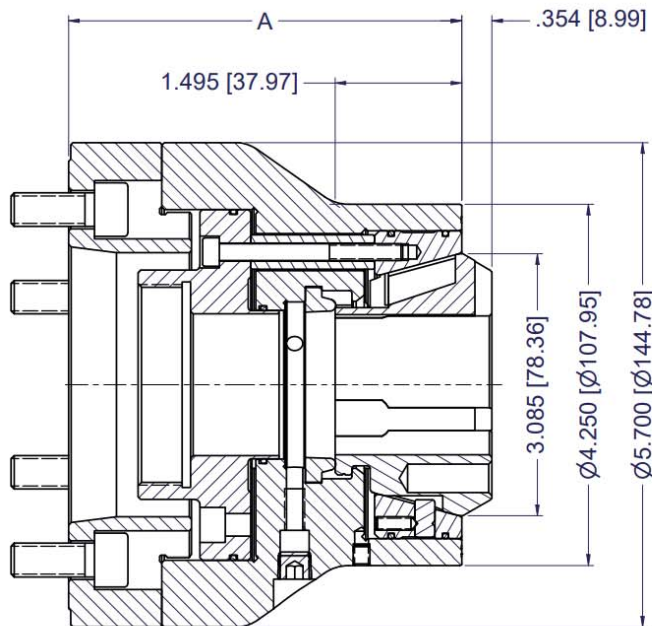


Figure 1

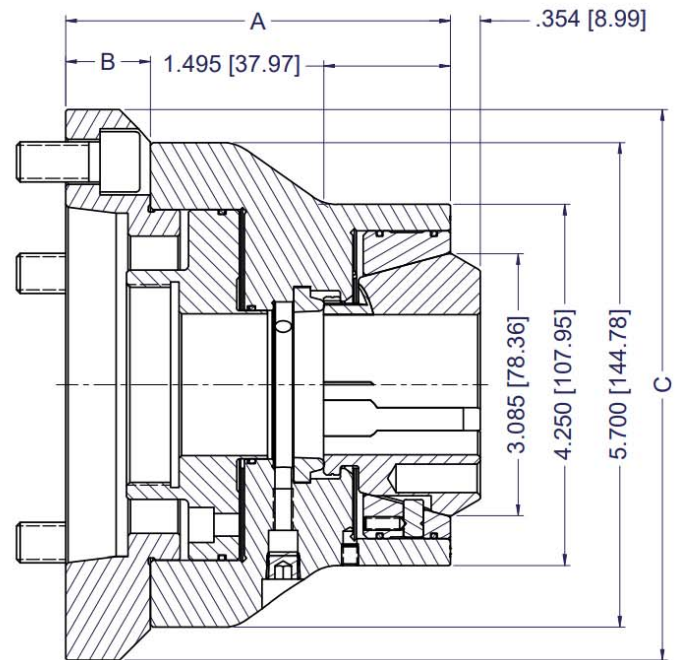


Figure 2

## CB52-NX Collet Chuck

### Specifications

Collet Model	52BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	2.000" / 52mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	8,992 lbs / 40 kN
Max Clamping Force	21,132 lbs / 94 kN
Maximum Speed	7,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB52-NX/A5</b>	1	A2-5	4.840" 122.94 mm	- -	- -	M60x2	20.25 lbs 9.19 kg
<b>CB52-NX/140</b>	2	140mm	4.443" 112.85 mm	.703" 17.86mm	5.950" 151.13mm	M60x2	19.21 lbs 8.71 kg
<b>CB52-NX/A6</b>	2	A2-6	4.740" 120.40 mm	1.000" 25.4mm	6.480" 164.59mm	M60x2 M75x2 (2 pcs)	20.22 lbs 9.17 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

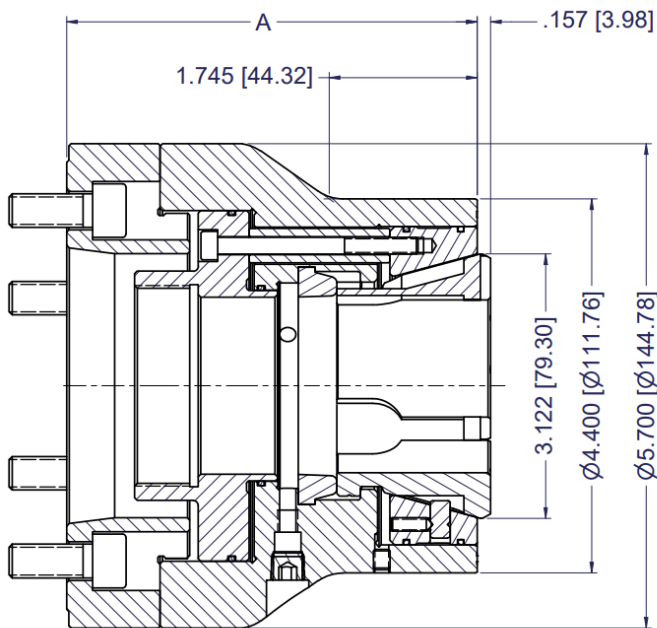


Figure 1

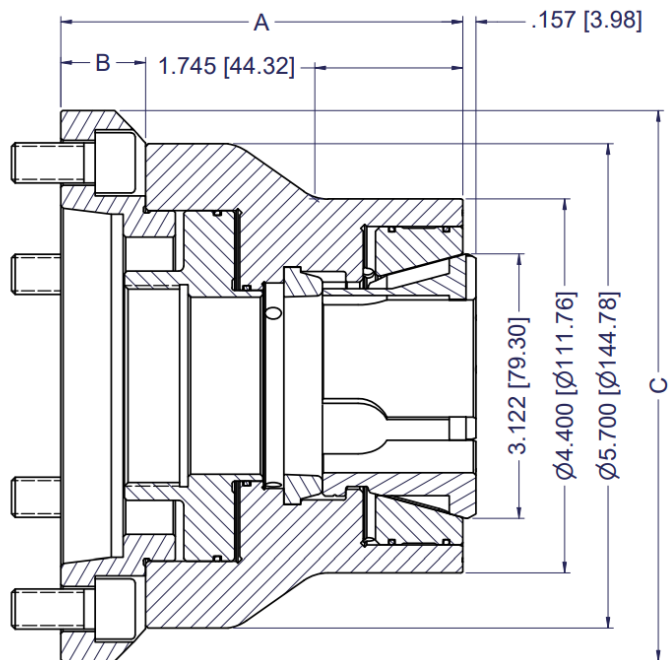


Figure 2

## CB65-NX Collet Chuck

### Specifications

Collet Model	65BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB65-NX/A5</b>	1	A2-5	4.780" 121.41mm	-	-	M60x2	25.9 lbs 11.8 kg
<b>CB65-NX/140</b>	1	140mm	4.583" 116.41mm	-	-	M60x2	25.0 lbs 11.3 kg
<b>CB65-NX/A6</b>	1	A2-6	5.330" 135.38mm	-	-	M80x2	27.7 lbs 12.6 kg
<b>CB65-NX/A8</b>	2	A2-8	5.605" 142.37mm	1.625" 41.28mm	8.250" 209.55mm	M80x2	34.2 lbs 15.5 kg
<b>CB65-NX/A8-OS</b>	2	A2-8	5.605" 142.37mm	1.625" 41.28mm	9.250" 234.95mm	M80x2 M100x2 (2 pcs)	39.05 lbs 17.71 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

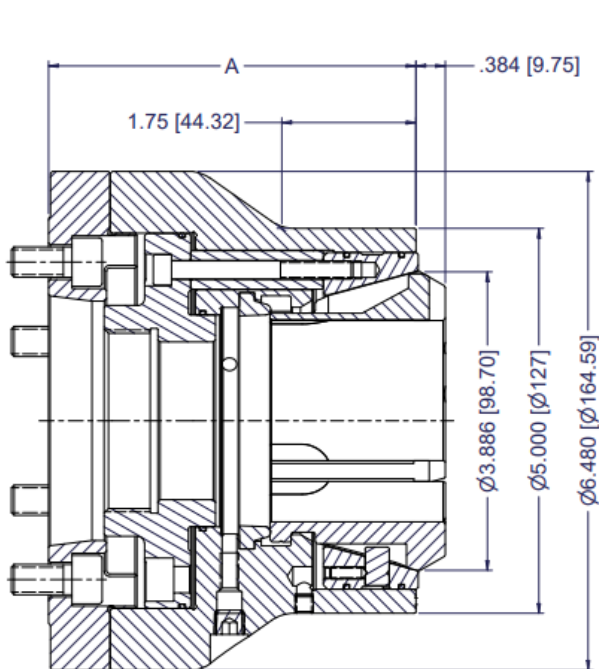


Figure 1

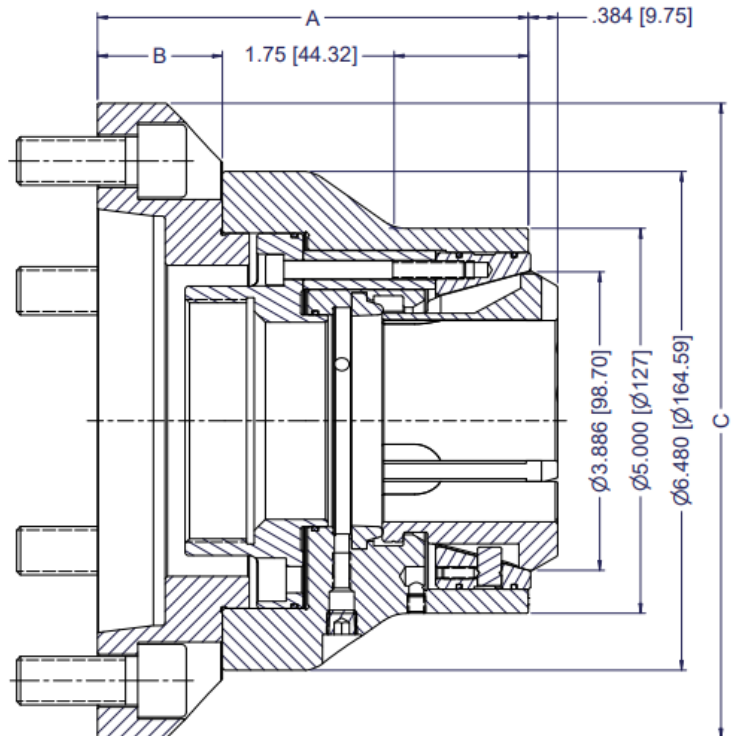


Figure 2



## CB80-NX Collet Chuck

### Specifications

Collet Model	80BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	3.250" / 82.5mm
Collet Capacity - Min Clamping Diameter	.500" / 12mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	11,240 lbs / 50 kN
Max Clamping Force	25,853 lbs / 115 kN
Maximum Speed	5,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB80-NX/A6</b>	1	A2-6	4.960" 125.98 mm	- -	- -	M90x2	35.64 lbs 16.16 kg
<b>CB80-NX/A8</b>	2	A2-8	5.210" 132.33 mm	1.105" 28.07 mm	8.250" 209.55mm	M100x2	37.65 lbs 17.07 kg
<b>CB80-NX/A11</b>	2	A2-11	6.105" 155.07 mm	2.000" 50.80 mm	10.950" 278.13 mm	M100x2 115x2 (2 pcs)	59.54 lbs 27.00 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

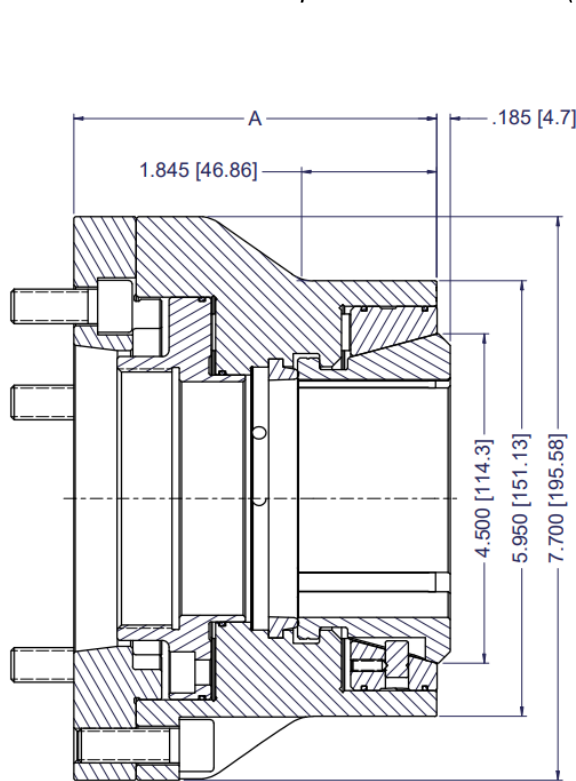


Figure 1

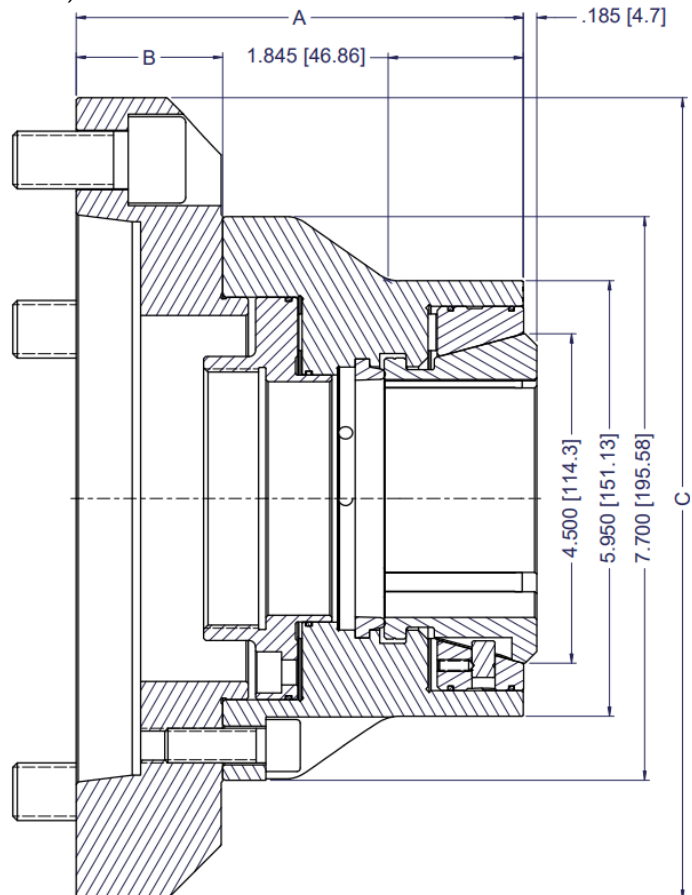


Figure 2

## CB100-NX Collet Chuck

### Specifications

Collet Model	100BZI
Accuracy - Max Radial Runout*	.001" / 0.025mm
Collet Capacity - Max Clamping Diameter	4.000" / 100mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	14,612 lbs / 65 kN
Max Clamping Force	33,721 lbs / 150 kN
Maximum Speed	5,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB100-NX/A6</b>	1	A2-6	6.500"	-	-	M90x2	71.92 lbs
			165.10 mm	-	-		32.62 kg
<b>CB100-NX/A8</b>	1	A2-8	6.600"	-	-	M115x2	66.82 lbs
			167.64 mm	-	-		30.31 kg
<b>CB100-NX/A11</b>	2	A2-11	7.440"	2.000"	10.950"	M115x2	82.73 lbs
			188.98 mm	50.80 mm	278.13 mm		37.53 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

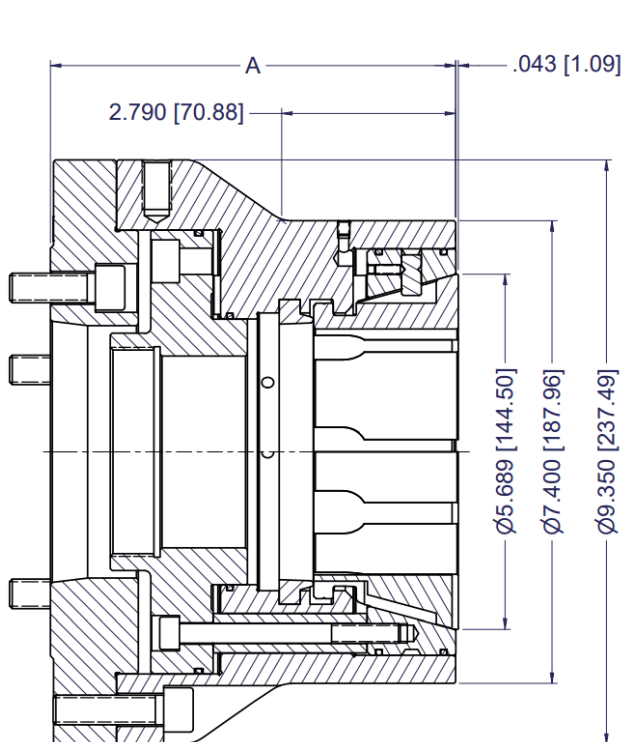


Figure 1

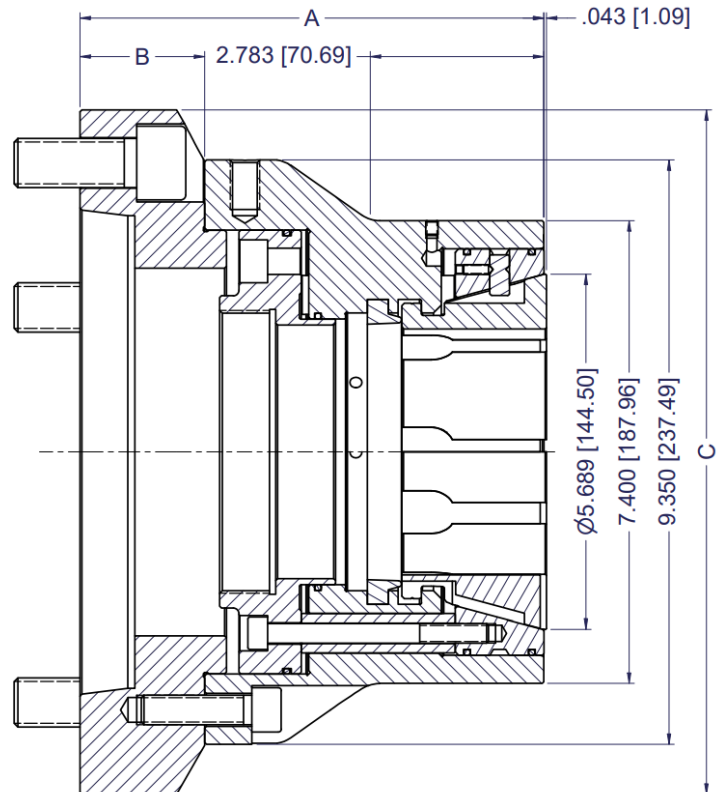


Figure 2

## CB-ND Collet Chucks - Dead Length Design

The ND series models are used for collet sizes 120mm and larger. The collet is coupled directly to the chuck body and remains fixed as the tapered seat moves forward when the chuck is actuated. Since the collet remains fixed in the Z axis during clamping it does not create a pull back effect on the bar stock or workpiece.



### CB-ND Features

- *Dead Length* design
- Radial adjusting screws to true-up the chuck assembly within .0002" (0.005mm)
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life
- Stop plates and stop housings can be mounted inside the chuck body for chucking applications requiring end stops or part ejectors

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB120-ND/A6	A2-6	120BZI	4.720"/120mm
CB120-ND/A8	A2-8	120BZI	4.720"/120mm
CB120-ND/A11	A2-11	120BZI	4.720"/120mm
CB120-ND/A15	A2-15	120BZI	4.720"/120mm
CB140-ND/A8	A2-10	140BZI	5.510"/140mm
CB140-ND/A11	A2-11	140BZI	5.510"/140mm
CB140-ND/A15	A2-15	140BZI	5.510"/140mm
CB160-ND/A8	A2-8	160BZI	6.300"/160mm
CB160-ND/A11	A2-11	160BZI	6.300"/160mm
CB160-ND/A15	A2-15	160BZI	6.300"/160mm

*\*CB-ND chucks with spindle adapters other than those listed above are quoted on request.*

### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required.  
Machine spindle drawing including draw tube dimensions and position must be submitted with order

### Optional Accessories

- Quick Change Collets (p.43)
- Stop plates (p. 55)
- Stop housings (p. 56)
- Ejector assemblies (p.57)
- Changing Fixtures (p. 54)



## CB120-ND Collet Chuck

### Specifications

Collet Model	120BZ1
Accuracy - Max Radial Runout*	.002" / 0.05mm
Collet Capacity - Max Clamping Diameter	4.725" / 120mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	15,736 lbs / 70 kN
Max Clamping Force	35,969 lbs / 160 kN
Maximum Speed	4,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB120-ND/A6</b>	1	A2-6	6.385" 162.18 mm	-	-	M90x2	136.93 lbs 62.10 kg
<b>CB120-ND/A8</b>	1	A2-8	6.385" 162.18 mm	-	-	M115x2	128.39 lbs 58.23 kg
<b>CB120-ND/A11</b>	1	A2-11	6.735" 171.07 mm	-	-	M150x2	125.55 lbs 56.94 kg
<b>CB120-ND/A15</b>	2	A2-15	7.885" 200.28 mm	2.650" 67.31 mm	14.950" 379.73 mm	M150x2	171.68 lbs 77.86 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

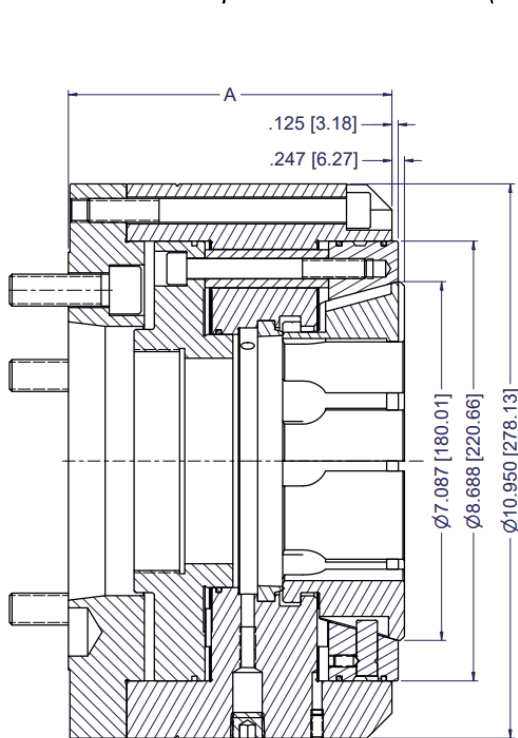


Figure 1

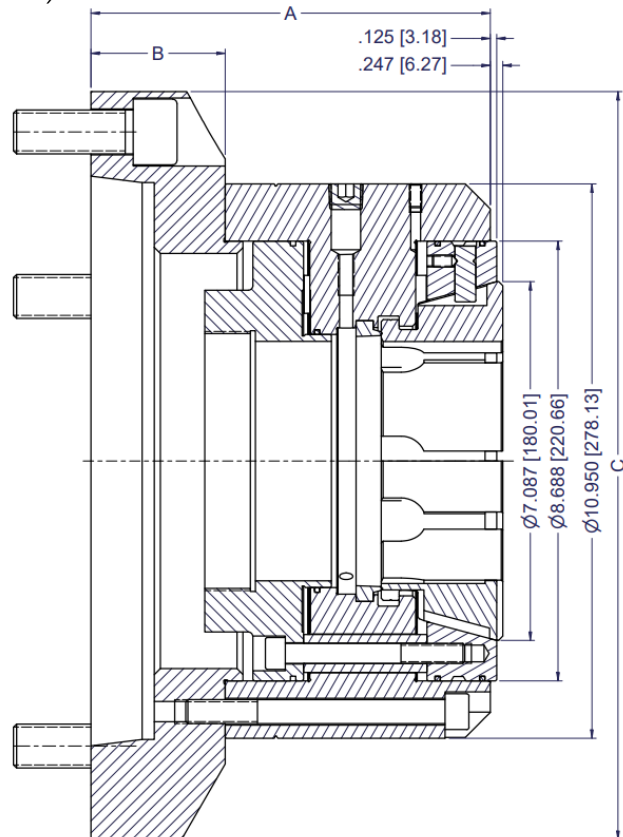


Figure 2

## CB140-ND Collet Chuck

### Specifications

Collet Model	140BZI
Accuracy - Max Radial Runout*	.002" / 0.05mm
Collet Capacity - Max Clamping Diameter	5.591" / 142mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	16,860 lbs / 75 kN
Max Clamping Force	38,218 lbs / 170 kN
Maximum Speed	3,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB140-ND/A8</b>	1	A2-8	6.648" 168.86 mm	-	-	M115x2	159.43 lbs 72.30 kg
<b>CB140-ND/A11</b>	1	A2-11	7.138" 181.31 mm	-	-	M150x2	157.53 lbs 71.44 kg
<b>CB140-ND/A15</b>	2	A2-15	7.898" 200.61 mm	2.750" 69.85 mm	14.950" 379.73 mm	M150x2	190.45 lbs 86.37 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

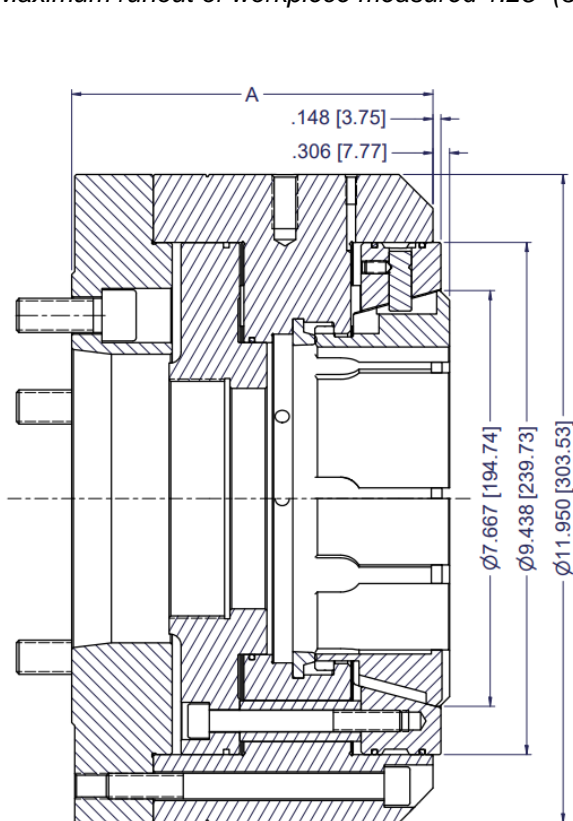


Figure 1

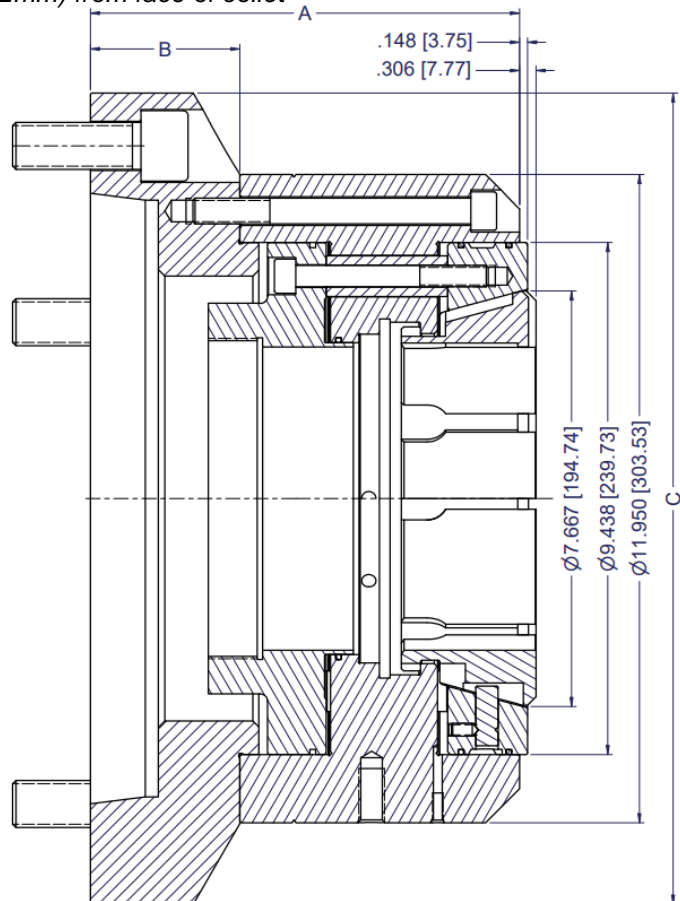


Figure 2

## CB160-ND Collet Chuck

### Specifications

Collet Model	160BZI
Accuracy - Max Radial Runout*	.002" / 0.05mm
Collet Capacity - Max Clamping Diameter	6.300" / 160mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	16,860 lbs / 75 kN
Max Clamping Force	38,218 lbs / 170 kN
Maximum Speed	3,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB160-ND/A8</b>	1	A2-8	7.115" 180.72 mm	-	-	M115x2	197.97 lbs 89.78 kg
<b>CB160-ND/A11</b>	1	A2-11	7.365" 187.07 mm	-	-	M150x2	197.65 lbs 89.64 kg
<b>CB160-ND/A15</b>	2	A2-15	8.115" 206.12 mm	2.750" 69.85 mm	14.950" 379.73 mm	M150x2	211.27 lbs 95.81 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

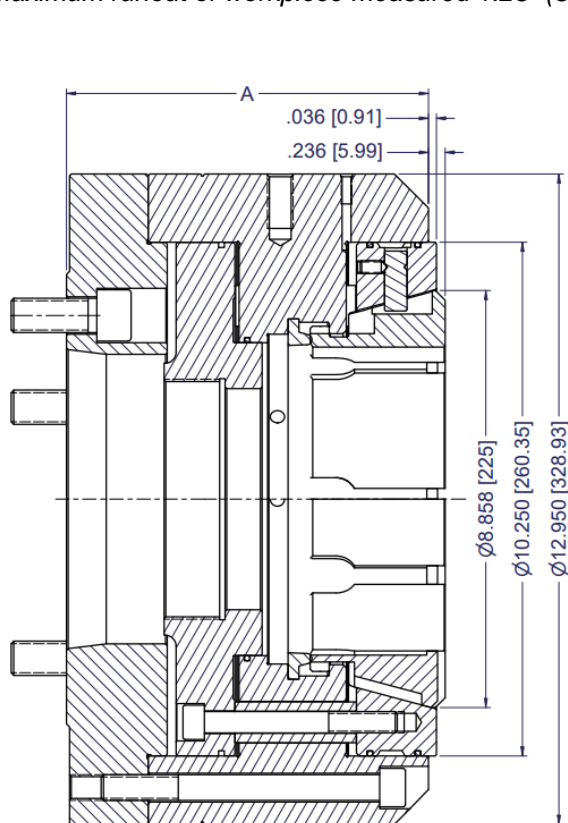


Figure 1

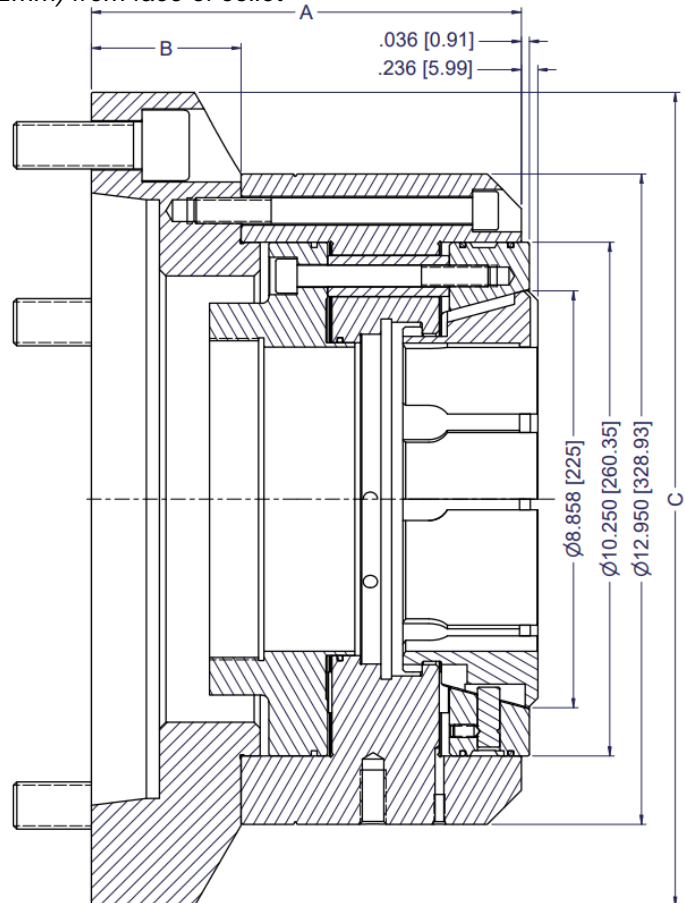


Figure 2

## CB-NB Collet Chucks - Pull Back Design

In the CB-NB series collet chucks, the collet is coupled directly to the draw tube connector. When the draw tube is actuated, the collet is drawn into the tapered seat of the chuck body, efficiently translating draw tube force into maximum clamping force.



### CB-NB Features

- *Pull Back* design maximizes the efficiency of the clamping system by concentrating all forces in the direction of the spindle for highest accuracy and greatest overall rigidity
- Low profile OD and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up the chuck assembly within .0002" (0.005mm)
- Lubricated for life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB42-NB/A5	A2-5	42BZI	1.625"/42mm
CB42-NB/140	140mm	42BZI	1.625"/42mm
CB42-NB/A6	A2-6	42BZI	1.625"/42mm
CB52-NB/A5	A2-5	52BZI	2.000"/52mm
CB52-NB/140	140mm	52BZI	2.000"/52mm
CB52-NB/A6	A2-6	52BZI	2.000"/52mm
CB65-NB/A5	A2-5	65BZI	2.625/66mm
CB65-NB/140	140mm	65BZI	2.625/66mm
CB65-NB/A6	A2-6	65BZI	2.625/66mm
CB65-NB/A8	A2-8	65BZI	2.625/66mm
CB65-NB/A8-OS	A2-8	65BZI	2.625/66mm
CB80-NB/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NB/A8	A2-8	80BZI	3.250"/82.5mm
CB80-NB/A11	A2-11	80BZI	3.250"/82.5mm
CB100-NB/A6	A2-6	100BZI	4.000"/100mm
CB100-NB/A8	A2-8	100BZI	4.000"/100mm
CB100-NB/A11	A2-11	100BZI	4.000"/100mm
CB120-NB/A8	A2-8	120BZI	4.720"/120mm
CB120-NB/A11	A2-11	120BZI	4.720"/120mm
CB120-NB/A15	A2-12	120BZI	4.720"/120mm
CB140-NB/A8	A2-8	140BZI	5.510"/140mm
CB140-NB/A11	A2-11	140BZI	5.510"/140mm
CB140-NB/A15	A2-15	140BZI	5.510"/140mm

\*CB-NB chucks with spindle adapters other than those listed above are quoted on request.

### Standard Equipment

- Spindle adapter plate
- Threaded actuator as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

### Optional Accessories

- Quick Change Collets (p.43)
- Changing Fixtures (p. 54)

## CB42-NB Collet Chuck

### Specifications

Collet Model	42BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	1.625" / 42mm
Collet Capacity - Min Clamping Diameter	.156" / 4mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	7,868 lbs / 35 kN
Max Clamping Force	17,985 lbs / 80 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB42-NB/A5</b>	1	A2-5	4.45" 113 mm	- -	- -	M60x2	19.43 lbs 8.81 kg
<b>CB42-NB/140</b>	2	140mm	4.05" 102.9mm	.703" 17.86mm	5.950" 151.13mm	M60x2	18.40 lbs 8.34 kg
<b>CB42-NB/A6</b>	2	A2-6	4.35" 115.39mm	1.000" 25.4mm	6.480" 164.59mm	M75x2	20.33 lbs 9.22 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

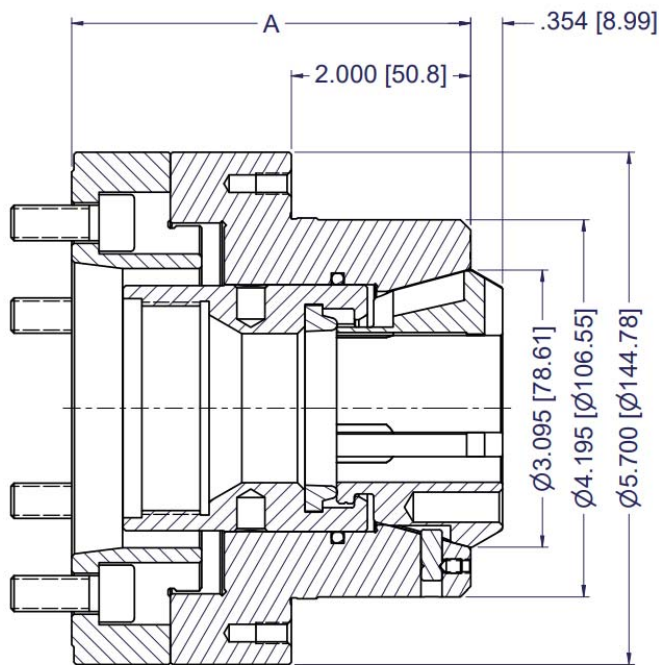


Figure 1

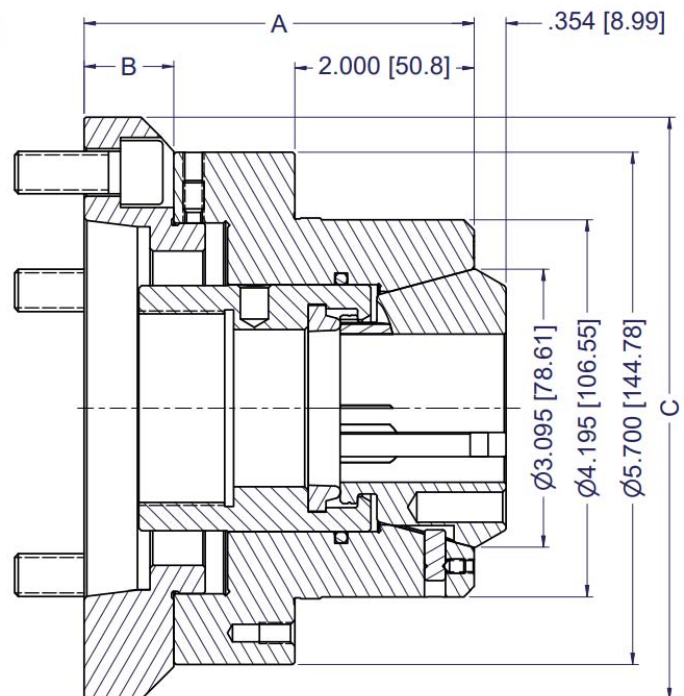


Figure 2



## CB52-NB Collet Chuck

### Specifications

Collet Model	52BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	2.000" / 52mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	8,992 lbs / 40 kN
Max Clamping Force	21,132 lbs / 94 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB52-NB/A5</b>	1	A2-5	4.45" 113 mm	- -	- -	M68x2	18.62 lbs 8.44 kg
<b>CB52-NB/140</b>	2	140mm	4.05" 102.9mm	.703" 17.86mm	5.950" 151.13mm	M68x2	17.58 lbs 7.97 kg
<b>CB52-NB/A6</b>	2	A2-6	4.35" 115.39mm	1.000" 25.4mm	6.480" 164.59mm	M75x2	18.80 lbs 8.53 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

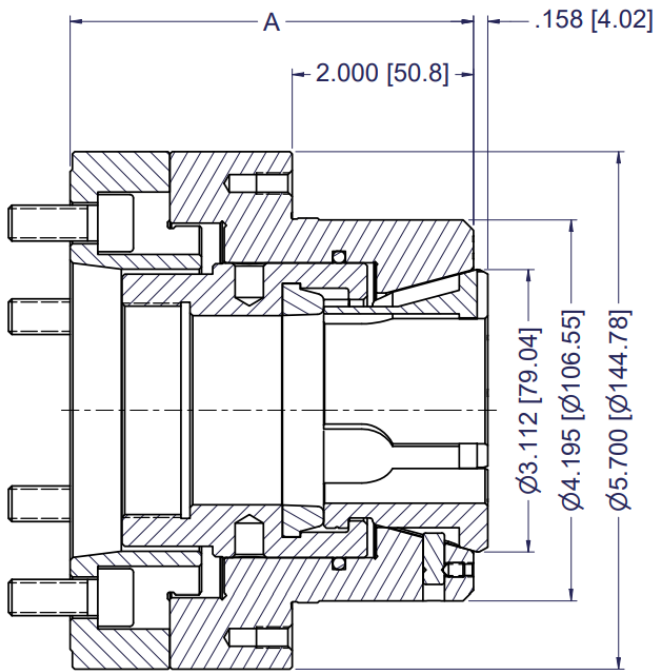


Figure 1

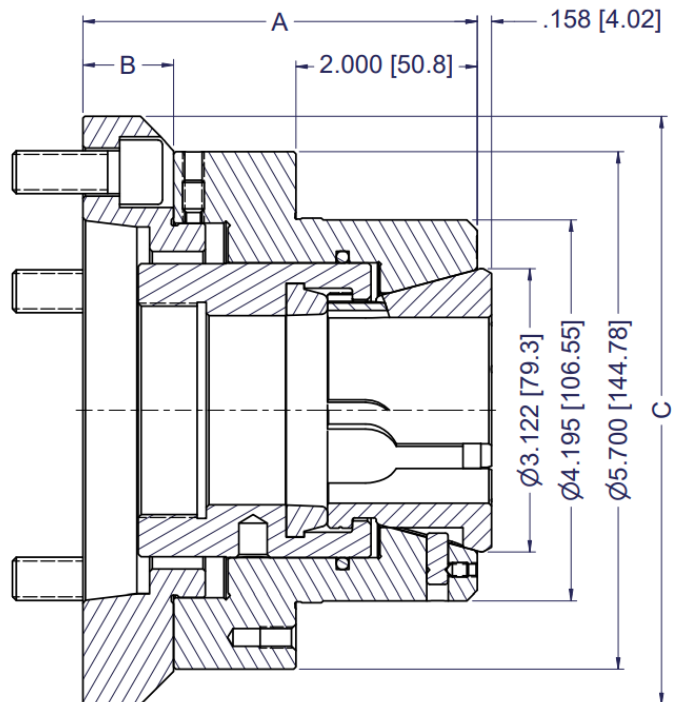


Figure 2

## CB65-NB Collet Chuck

### Specifications

Collet Model	65BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB65-NB/A5</b>	1	A2-5	4.300" 109.22mm	-	-	M70x2	25.83 lbs 11.71 kg
<b>CB65-NB/140</b>	1	140mm	4.103" 104.22mm	-	-	M70x2	24.91 lbs 11.30 kg
<b>CB65-NB/A6</b>	1	A2-6	4.850" 123.19mm	-	-	M85x2	27.58 lbs 12.51 kg
<b>CB65-NB/A8</b>	2	A2-8	5.125" 130.18mm	1.625" 41.28mm	8.250" 209.55mm	M85x2	34.06 lbs 15.45 kg
<b>CB65-NB/A8-OS</b>	2	A2-8	5.125" 130.18mm	1.625" 41.28mm	9.250" 234.95mm	M100x2	39.44 lbs 17.89 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

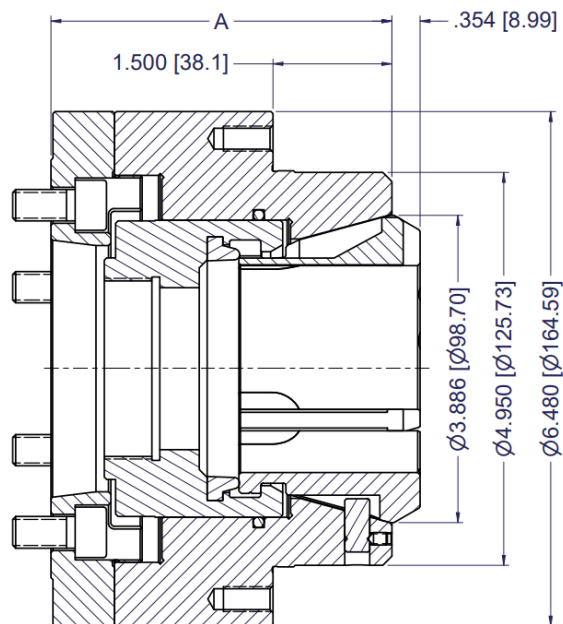


Figure 1

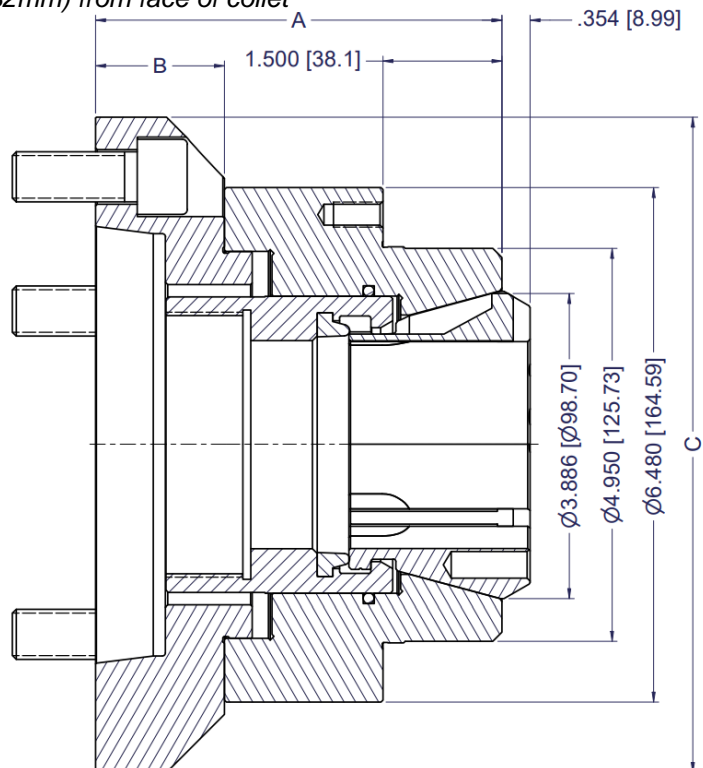


Figure 2

## CB80-NB Collet Chuck

### Specifications

Collet Model	80BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	3.250" / 82.5mm
Collet Capacity - Min Clamping Diameter	.500" / 12mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	11,240 lbs / 50 kN
Max Clamping Force	25,853 lbs / 115 kN
Maximum Speed	5,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB80-NB/A6</b>	1	A2-6	4.960" 125.98 mm	- -	- -	M85x2	39.11 lbs 17.74 kg
<b>CB80-NB/A8</b>	2	A2-8	5.210" 132.33 mm	1.105" 28.07 mm	8.250" 209.55mm	M105x2	40.79 lbs 18.50 kg
<b>CB80-NB/A11</b>	2	A2-11	6.105" 155.07 mm	2.000" 50.80 mm	10.950" 278.13 mm	M115x2	63.92 lbs 28.99 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

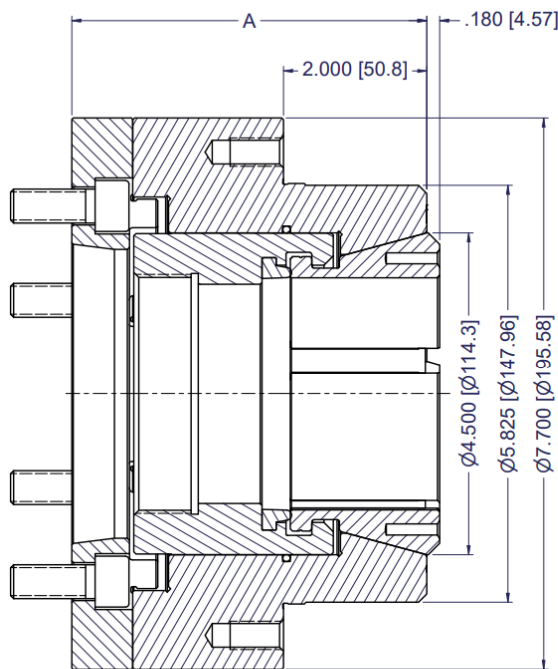


Figure 1

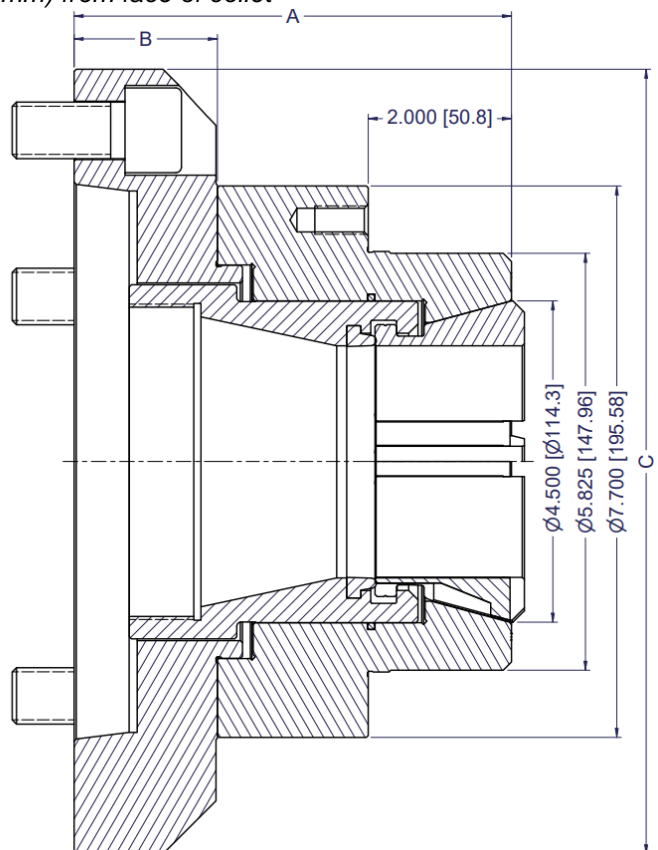


Figure 2



## CB100-NB Collet Chuck

### Specifications

Collet Model	100BZI
Accuracy - Max Radial Runout*	.0006" / 0.015mm
Collet Capacity - Max Clamping Diameter	4.000" / 100mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	14,612 lbs / 65 kN
Max Clamping Force	33,721 lbs / 150 kN
Maximum Speed	5,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB100-NB/A6</b>	1	A2-6	4.710" 119.63mm	- -	- -	M85x2	57.67 lbs 26.15 kg
<b>CB100-NB/A8</b>	1	A2-8	4.810" 122.17mm	- -	- -	M115x2	56.48 lbs 25.61 kg
<b>CB100-NB/A11</b>	2	A2-11	5.650" 143.51 mm	2.000" 50.80 mm	10.950" 278.13 mm	M115x2	73.68 lbs 33.41 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

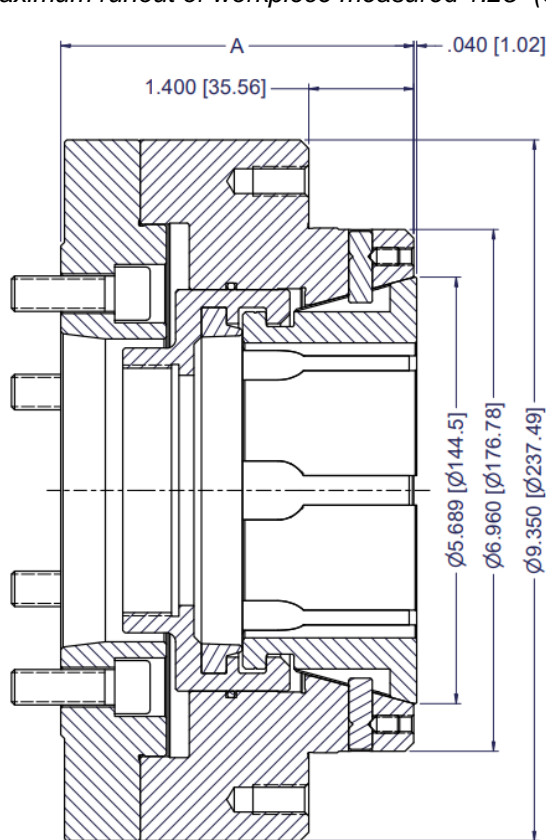


Figure 1

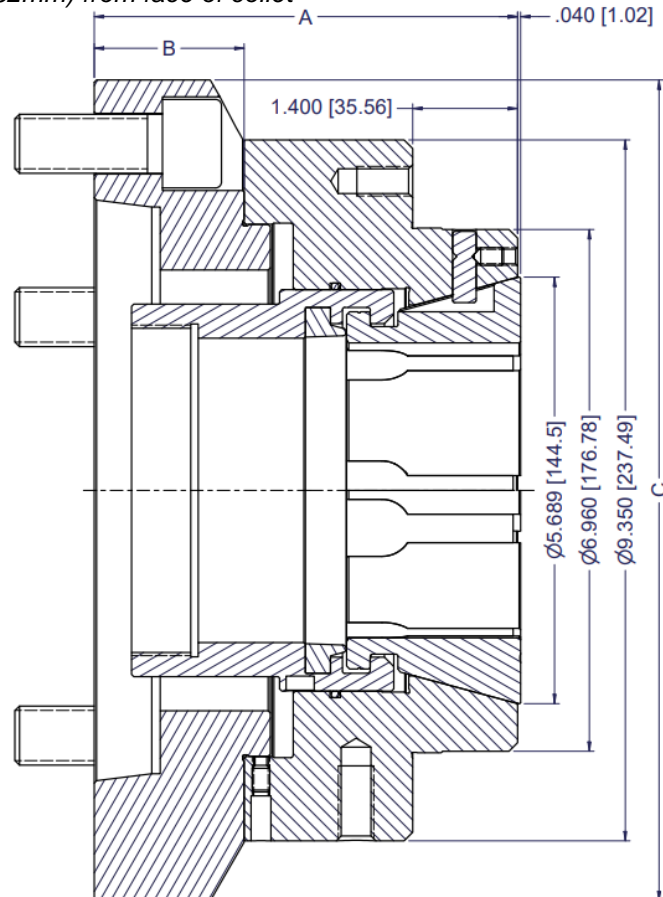


Figure 2

## CB120-NB Collet Chuck

### Specifications

Collet Model	120BZI
Accuracy - Max Radial Runout*	.001" / 0.025mm
Collet Capacity - Max Clamping Diameter	4.725" / 120mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	15,736 lbs / 70 kN
Max Clamping Force	35,969 lbs / 160 kN
Maximum Speed	4,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB120-NB/A8</b>	1	A2-8	5.150"	-	-	M115x2	88.28 lbs
			130.81 mm	-	-		40.04 kg
<b>CB120-NB/A11</b>	1	A2-11	5.500"	-	-	M150x2	87.66 lbs
			139.70 mm	-	-		39.76 kg
<b>CB120-NB/A15</b>	2	A2-15	6.650"	2.650"	14.950"	M150x2	134.73 lbs
			168.91 mm	67.31 mm	379.73 mm		61.10 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

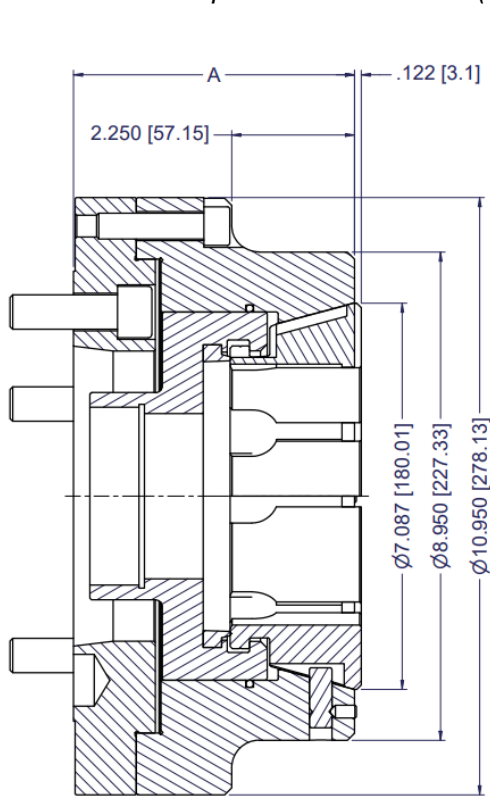


Figure 1

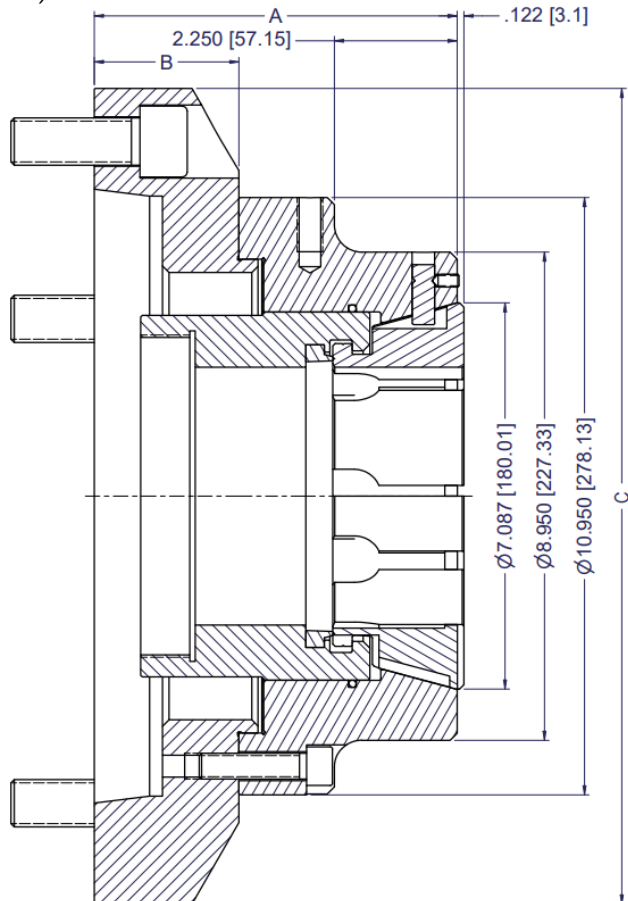


Figure 2

## CB140-NB Collet Chuck

### Specifications

Collet Model	140BZI
Accuracy - Max Radial Runout*	.001" / 0.025mm
Collet Capacity - Max Clamping Diameter	5.591" / 142mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	16,860 lbs / 75 kN
Max Clamping Force	38,218 lbs / 170 kN
Maximum Speed	3,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB140-NB/A8</b>	1	A2-8	5.605" 142.37 mm	- -	- -	M115x2	113.28 lbs 51.37 kg
<b>CB140-NB/A11</b>	1	A2-11	6.095" 104.01 mm	- -	- -	M150x2	119.41 lbs 54.15 kg
<b>CB140-NB/A15</b>	2	A2-15	6.855" 174.12 mm	2.650" 67.31 mm	14.950" 379.73 mm	M150x2	157.98 lbs 71.65 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

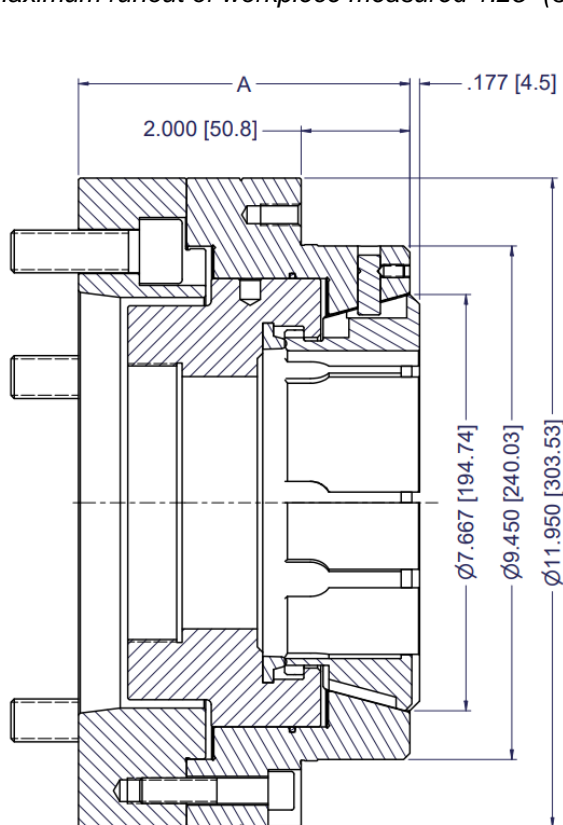


Figure 1

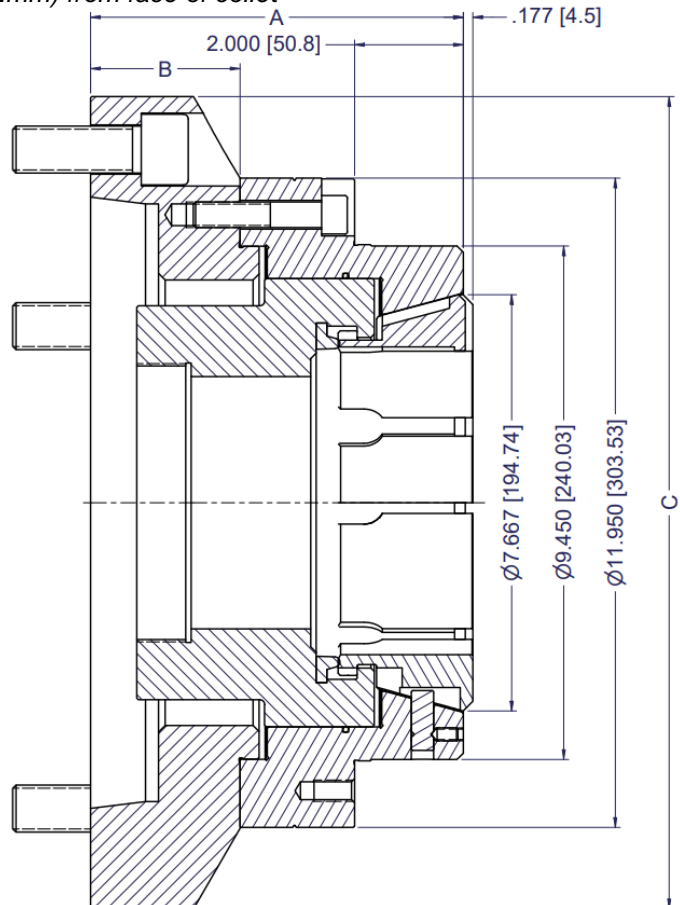


Figure 2

## CB-NDR Collet Chucks - Pull to Close Dead Length Design for Servo Stop Bar Loaders

The CB-NDR is a patented *Dead Length* design for use with servo stop bar loaders. Unlike conventional dead length collet chucks, the NDR is actuated as the draw tube is drawn toward the machine spindle to prevent the bar from being pushed off the servo stop.



### CB-NDR Features

- *Pull to Close Dead Length* design produces no pull back and will not push the bar off the servo stop
- Radial adjusting screws to true-up the chuck assembly within .0002" (0.005mm)
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB65-NDR/A5	A2-5	65BZI	2.625/66mm
CB65-NDR/140	140mm	65BZI	2.625/66mm
CB65-NDR/A6	A2-6	65BZI	2.625/66mm
CB65-NDR/A8	A2-8	65BZI	2.625/66mm
CB65-NDR/A8-OS	A2-8	65BZI	2.625/66mm
CB80-NDR/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NDR/A8	A2-8	80BZI	3.250"/82.5mm

\*CB-NDR chucks with spindle adapters other than those listed above are quoted on request.

### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required.  
Machine spindle drawing including draw tube dimensions and position must be submitted with order

### Optional Accessories

- Quick Change Collets (p.43)
- Stop plates (p. 55)
- Stop housings (p. 56)
- Ejector assemblies (p.57)
- Changing Fixtures (p. 54)

## CB65-NDR Collet Chuck

### Specifications

Collet Model	65BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.480" / 12.2mm
Max Draw Tube Force	8,990 lbs / 40 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB65-NDR/A5</b>	1	A2-5	6.175" 156.85 mm	-	-	M60x2	44.73 lbs 20.29 kg
<b>CB65-NDR/140</b>	1	140mm	5.985" 152.02 mm	-	-	M75x2	42.16 lbs 19.12 kg
<b>CB65-NDR/A6</b>	1	A2-6	6.725" 170.82 mm	-	-	M75x2	45.22 lbs 20.51 kg
<b>CB65-NDR/A8</b>	2	A2-8	7.000" 177.80 mm	1.625" 41.28mm	8.250" 209.55mm	M85x2	52.56 lbs 23.84 kg
<b>CB65-NDR/A8-OS</b>	2	A2-8	7.000" 177.80 mm	1.625" 41.28mm	8.250" 209.55mm	M90x2	52.12 lbs 23.64 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

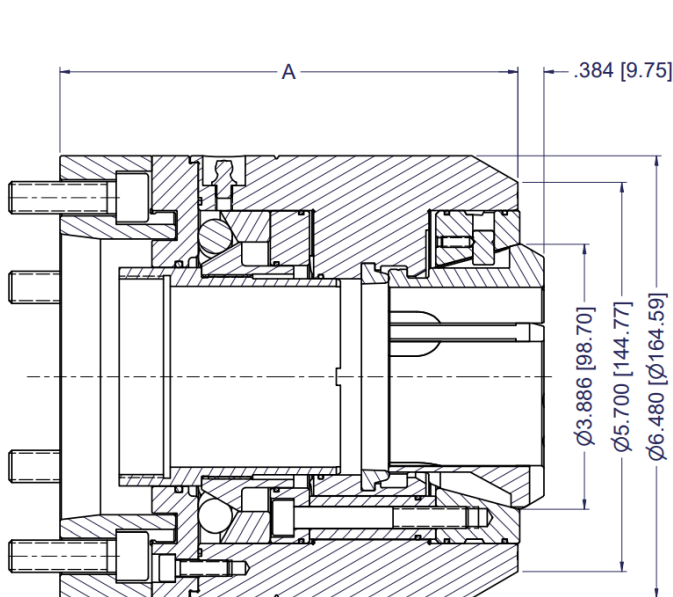


Figure 1

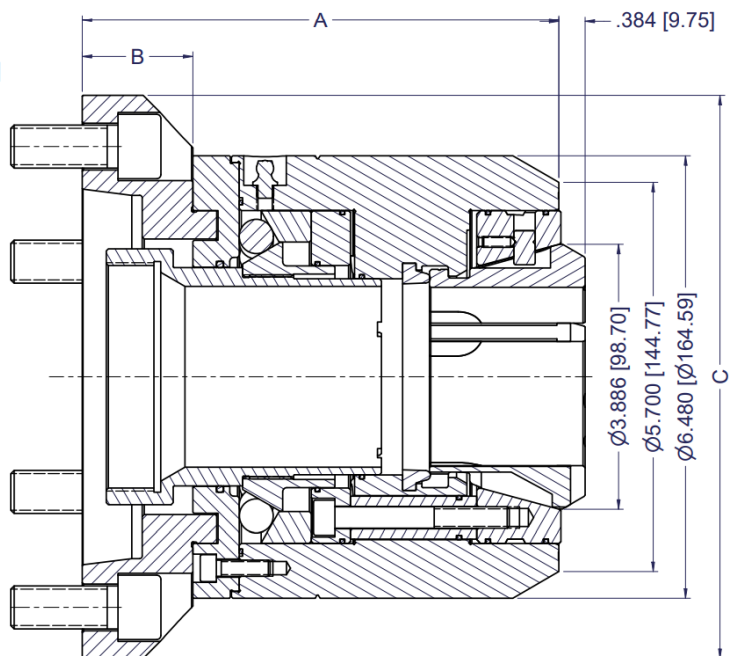


Figure 2



## CB80-NDR Collet Chuck

### Specifications

Collet Model	80BZI
Accuracy - Max Radial Runout*	.0008" / 0.020mm
Collet Capacity - Max Clamping Diameter	3.250" / 82.5mm
Collet Capacity - Min Clamping Diameter	.500" / 12mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.480" / 12.2mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	25,853 lbs / 115 kN
Maximum Speed	5,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB80-NDR/A6</b>	1	A2-6	6.245" 158.62 mm	- -	- -	M80x2	61.67 lbs 27.97 kg
<b>CB80-NDR/A8</b>	2	A2-8	6.500" 165.10 mm	1.105" 28.07 mm	8.250" 209.55mm	M90x2	62.83 lbs 28.49 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

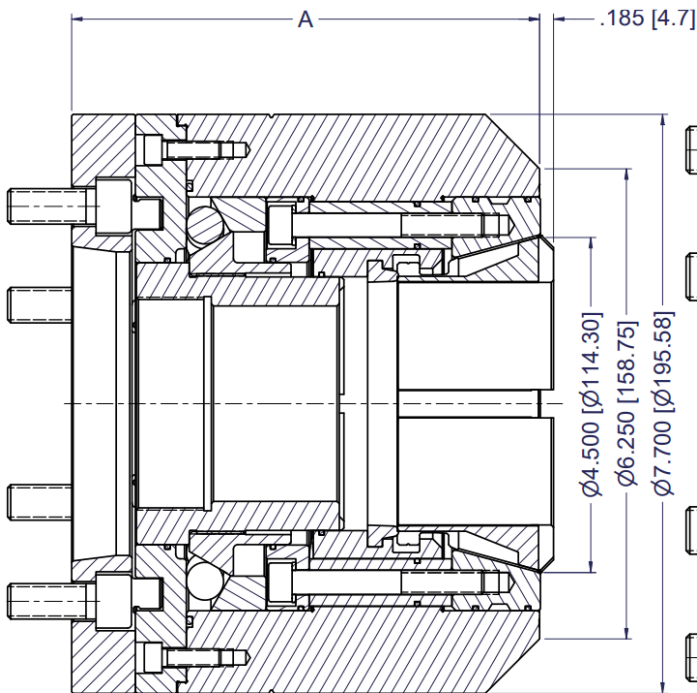


Figure 1

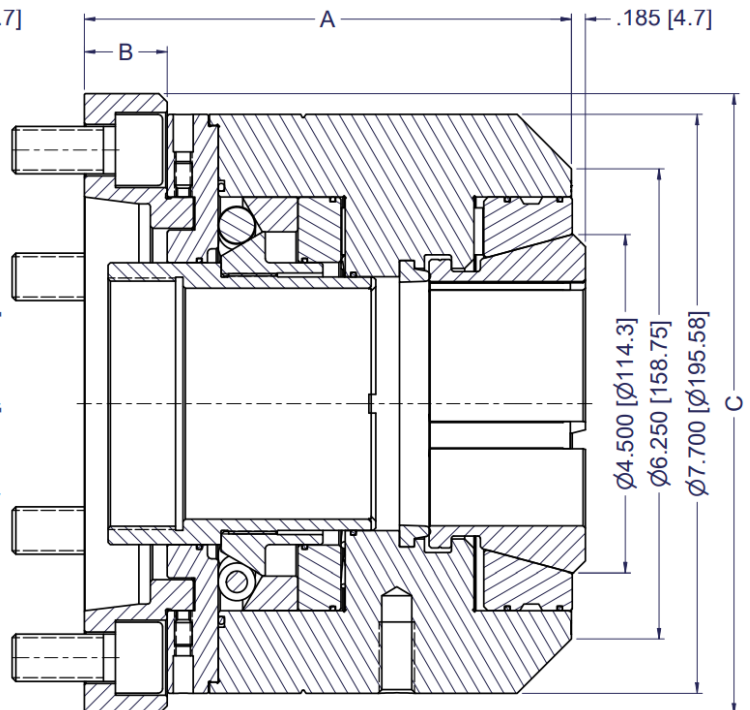


Figure 2

## CB-NK Collet Chucks - Combination Design

NK series chucks are a pull back design with the added flexibility of being able to mount end stops inside the chuck body for easy conversion from bar to chucking applications. The collet is coupled directly to the draw tube connector. As the draw tube is actuated the collet is drawn into the tapered seat efficiently translating draw tube force into maximum clamping force.



### CB-NK Features

- *Pull Back* design maximizes the efficiency of the clamping system by concentrating all forces in the direction of the spindle for highest accuracy and greatest overall rigidity
- Low profile OD and short overall length provides increased tool clearance and maximum utilization of the machine's Z axis
- Radial adjusting screws to true-up the chuck assembly with in .0002" (0.005mm)
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life
- Removable stop plates and stop housings can be mounted inside the chuck body for chucking applications requiring end stops or part ejectors

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB42-NK/A5	A2-5	42BZI	1.625"/42mm
CB42-NK/140	140mm	42BZI	1.625"/42mm
CB42-NK/A6	A2-6	42BZI	1.625"/42mm
CB65-NK/A5	A2-5	65BZI	2.625/66mm
CB65-NK/140	140mm	65BZI	2.625/66mm
CB65-NK/A6	A2-6	65BZI	2.625/66mm
CB65-NK/A8	A2-8	65BZI	2.625/66mm
CB80-NK/A6	A2-6	80BZI	3.250"/82.5mm
CB80-NK/A8	A2-8	80BZI	3.250"/82.5mm
CB100-NK/A6	A2-6	100BZI	4.000"/100mm
CB100-NK/A8	A2-8	100BZI	4.000"/100mm
CB100-NK/A11	A2-11	100BZI	4.000"/100mm

*\*CB-NK chucks with spindle adapters other than those listed above are quoted on request.*

### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required.  
Machine spindle drawing including draw tube dimensions and position must be submitted with order

### Optional Accessories

- Quick Change Collets (p.43)
- Stop plates (p. 55)
- Stop housings (p. 56)
- Ejector assemblies (p.57)
- Changing Fixtures (p. 54)

## CB42-NK Collet Chuck

### Specifications

Collet Model	42BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	1.625" / 42mm
Collet Capacity - Min Clamping Diameter	.156" / 4mm
Through Capacity	1.420" / 36mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	7,868 lbs / 35 kN
Max Clamping Force	17,985 lbs / 80 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB42-NK/A5</b>	1	A2-5	5.100" 129.54 mm	- -	- -	M60x2	28.84 lbs 13.08 kg
<b>CB42-NK/140</b>	2	140mm	4.703" 119.46 mm	.703" 17.86mm	5.950" 151.13mm	M60x2	27.80 lbs 12.61 kg
<b>CB42-NK/A6</b>	2	A2-6	5.000" 127.00 mm	1.000" 25.4mm	6.480" 164.59mm	M75x2	28.88 lbs 13.10 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

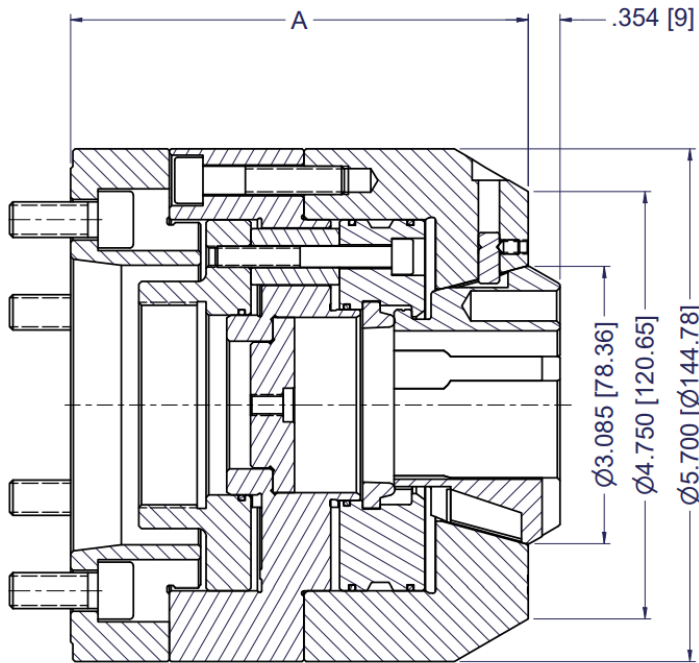


Figure 1

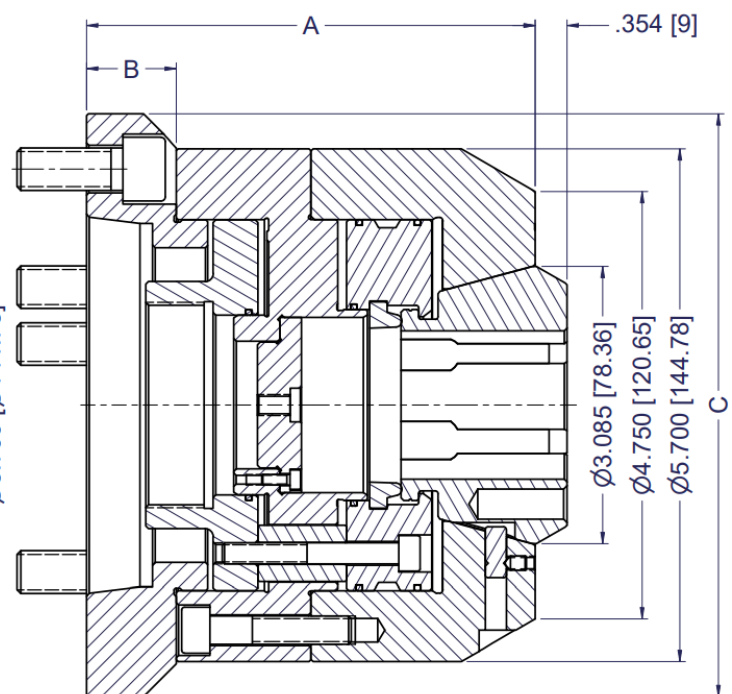


Figure 2



# CB65-NK Collet Chuck

## Specifications

Collet Model	65BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Through Capacity	2.245" / 57mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	6,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB65-NK/A5</b>	1	A2-5	5.375" 136.53 mm	-	-	M72x2	36.90 lbs 16.73 kg
<b>CB65-NK/140</b>	1	140mm	5.178" 131.52 mm	-	-	M72x2	35.99 lbs 16.32 kg
<b>CB65-NK/A6</b>	1	A2-6	5.925" 150.50 mm	-	-	M85x2	40.05 lbs 18.16 kg
<b>CB65-NK/A8</b>	2	A2-8	6.200" 157.48 mm	1.625" 41.28mm	8.250" 209.55mm	M85x2	46.53 lbs 21.10 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

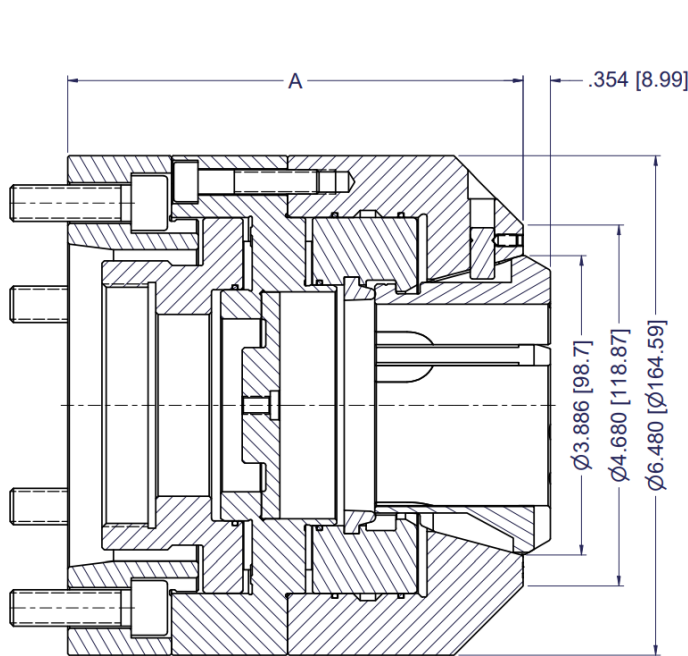


Figure 1

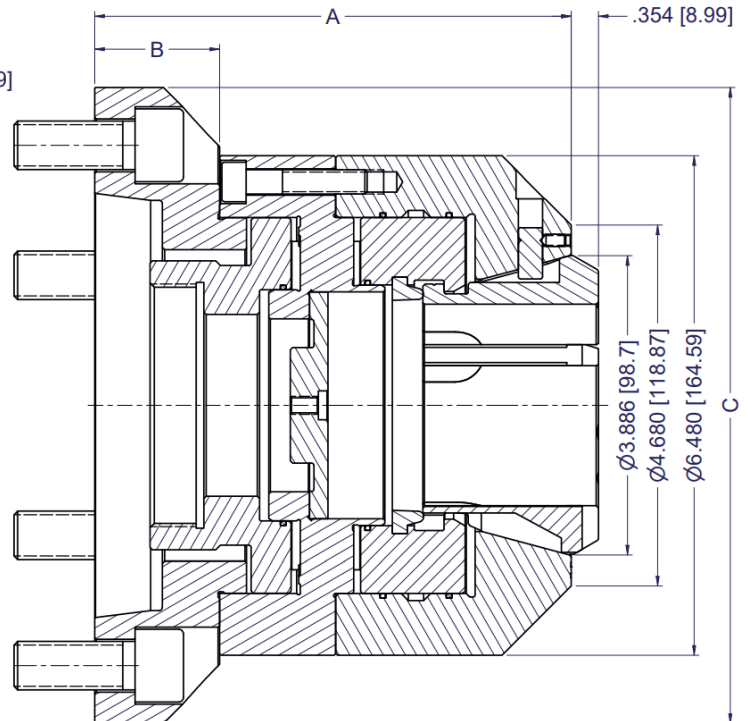


Figure 2

## CB80-NK Collet Chuck

### Specifications

Collet Model	80BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	3.250" / 82.5mm
Collet Capacity - Min Clamping Diameter	.500" / 12mm
Through Capacity	2.700" / 68mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	11,240 lbs / 50 kN
Max Clamping Force	25,853 lbs / 115 kN
Maximum Speed	5,500 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB80-NK/A6</b>	1	A2-6	5.425" 137.80 mm	- -	- -	M90x2	53.49 lbs 24.26 kg
<b>CB80-NK/A8</b>	2	A2-8	5.680" 144.27 mm	1.105" 28.07 mm	8.250" 209.55mm	M90x2	55.50 lbs 25.17 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

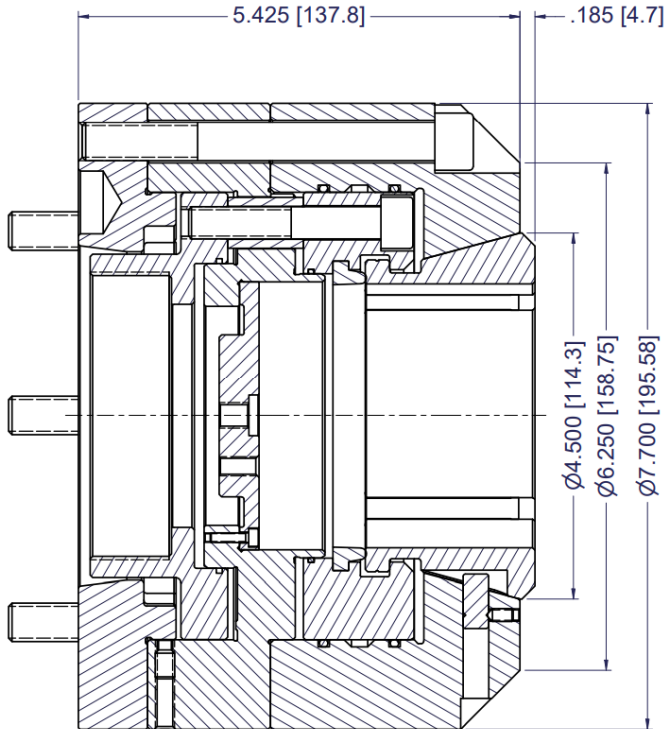


Figure 1

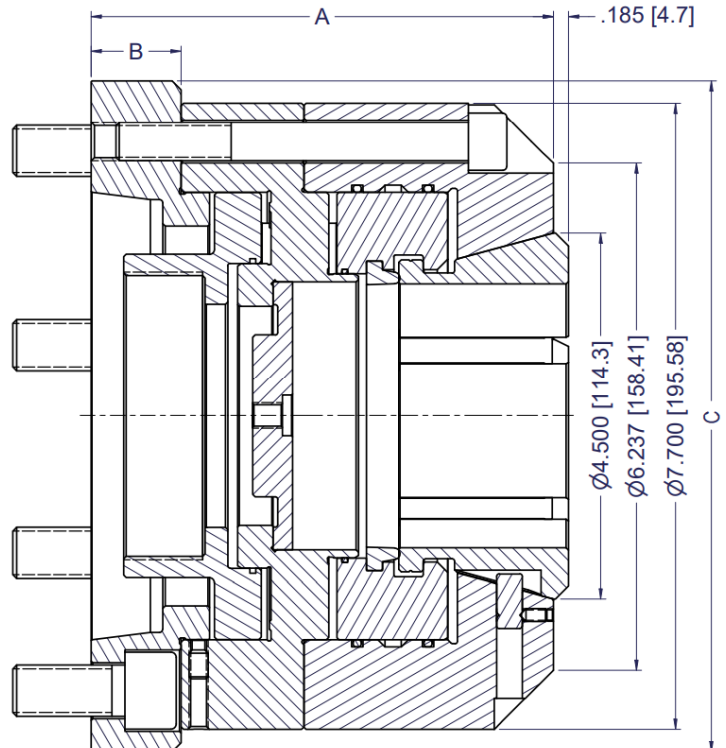


Figure 2

## CB100-NK Collet Chuck

### Specifications

Collet Model	100BZI
Accuracy - Max Radial Runout*	.0006" / 0.015mm
Collet Capacity - Max Clamping Diameter	4.000" / 100mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Through Capacity	3.370" / 93mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	.315" / 8mm
Max Draw Tube Force	14,612 lbs / 65 kN
Max Clamping Force	33,721 lbs / 150 kN
Maximum Speed	5,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB100-NK/A6</b>	1	A2-6	6.790"	-	-	M90x2	93.19 lbs
			172.47 mm	-	-		42.26 kg
<b>CB100-NK/A8</b>	1	A2-8	6.890"	-	-	M115x2	92.87 lbs
			175.01 mm	-	-		42.12 kg
<b>CB100-NK/A11</b>	2	A2-11	7.730"	2.000"	10.950"	M130x2	108.78 lbs
			196.34 mm	50.80 mm	278.13 mm		49.33 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet

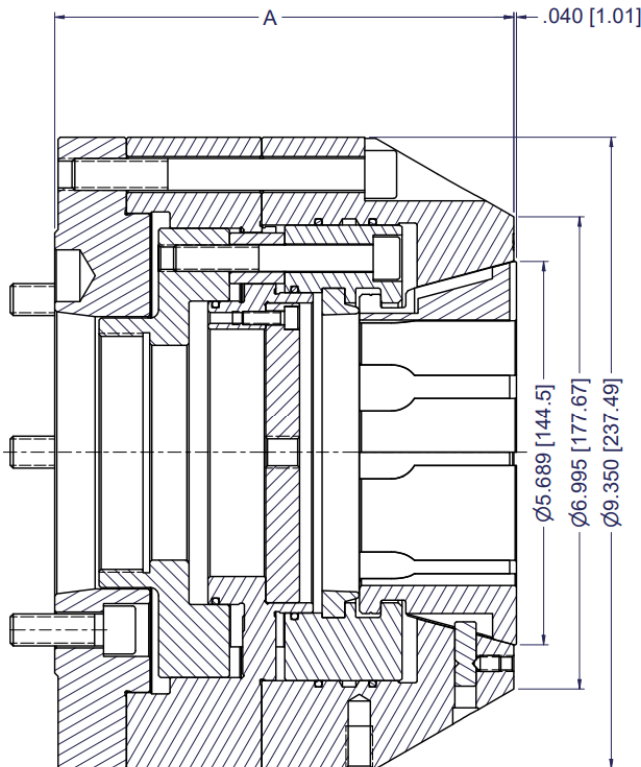


Figure 1

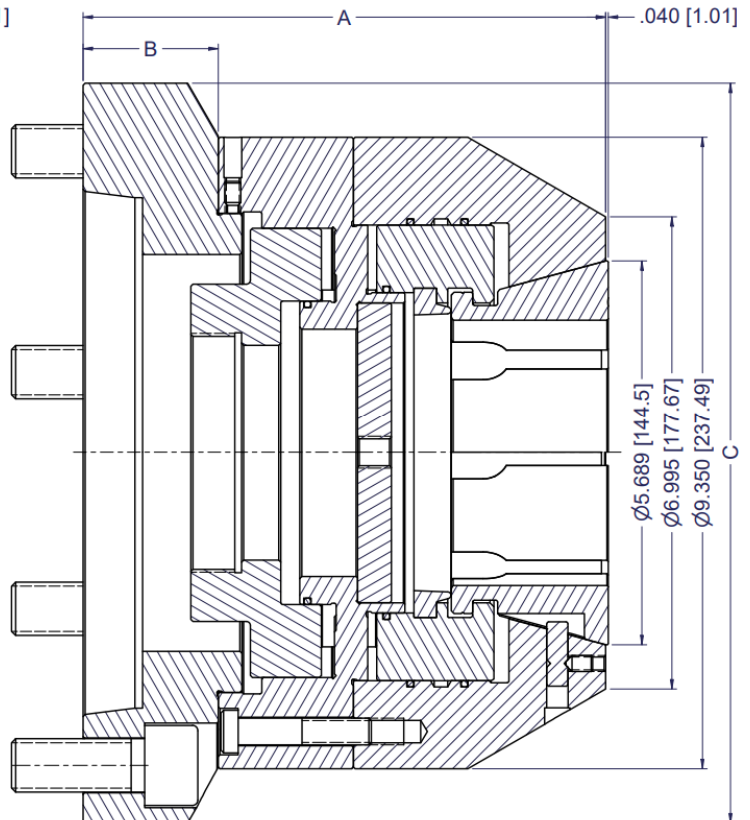


Figure 2

## CB-NRB Collet Chucks - Stationary Design

The NRB series is a hydraulically actuated self-contained *Pull Back* design for non-rotating applications. The collet is coupled to the built-in piston and is drawn into the tapered seat when the chuck is actuated. Part stops can be mounted inside the chuck body.



### CB-NRB Features

- Self-contained design with built-in cylinder can be hydraulic or pneumatically actuated
- *Pull Back* design maximizes the efficiency of the clamping system by concentrating the chucking force in the direction of the machine table, in addition to drawing the workpiece against the part stop
- Lubricated-for-life design requires minimal maintenance
- All components hardened and precision ground for highest accuracy and long life

Chuck Model	Collet Model	Collet Capacity
CB42-NRB	42BZI	1.625"/42mm
CB65-NRB	65BZI	2.625"/66mm
CB80-NRB	80BZI	3.250"/82.5mm
CB100-NRB	100BZI	4.000"/100mm
CB120-NRB	120BZI	4.720"/120mm

*\*Non-rotating dead length designs are quoted on request.*

### Optional Accessories

- Quick Change Collets (p.43)
- Changing Fixtures (p. 54)

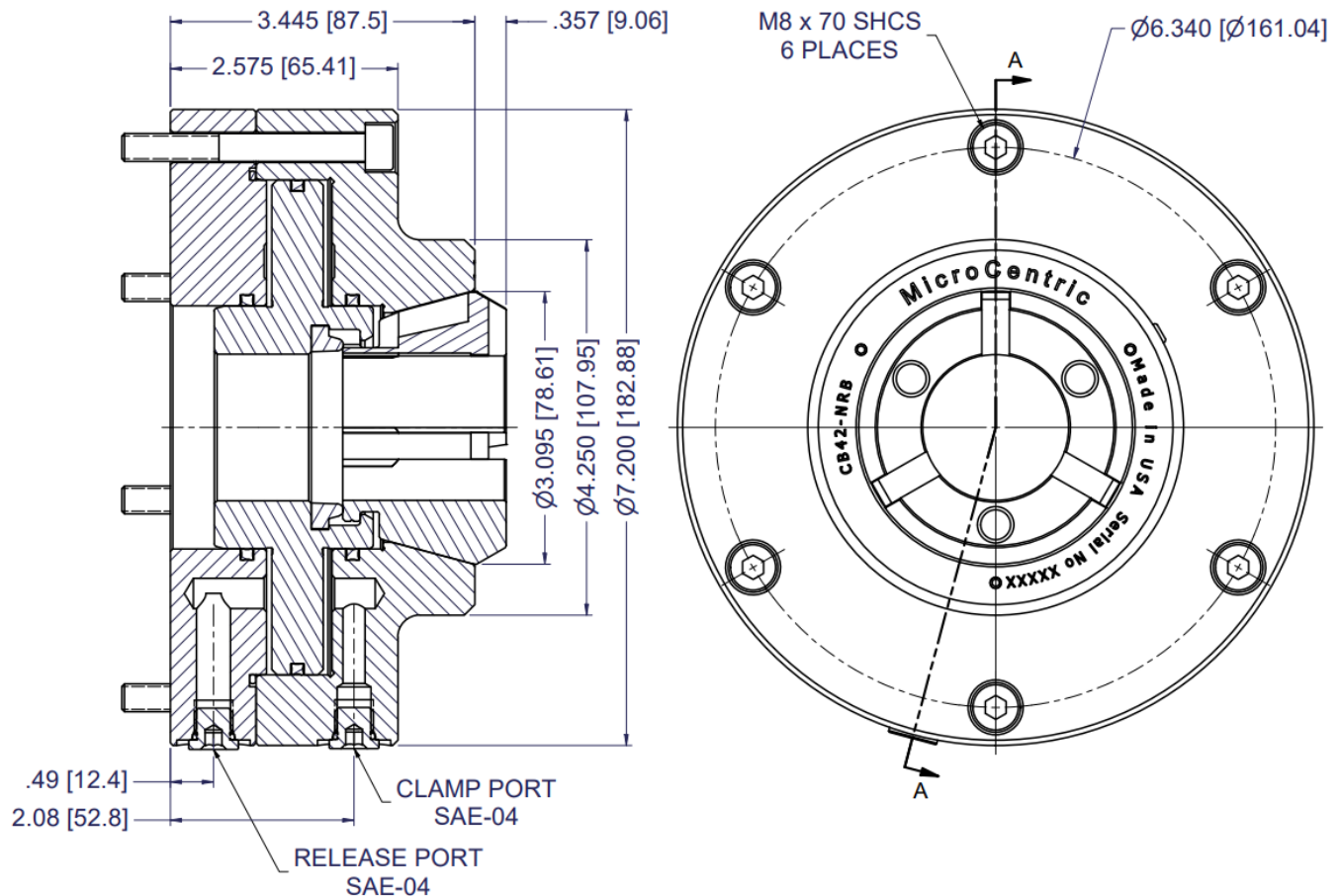


## CB42-NRB Collet Chuck

### Specifications

Collet Model	42BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	1.625" / 42mm
Collet Capacity - Min Clamping Diameter	.156" / 4mm
Collet Clamp Range	+/- .020" / 0.5mm
Max Clamping Force	17,985 lbs / 80 kN
Max Hydraulic Pressure	420 psi / 2.9 Mpa
Weight	29.02 lbs / 13.16 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet



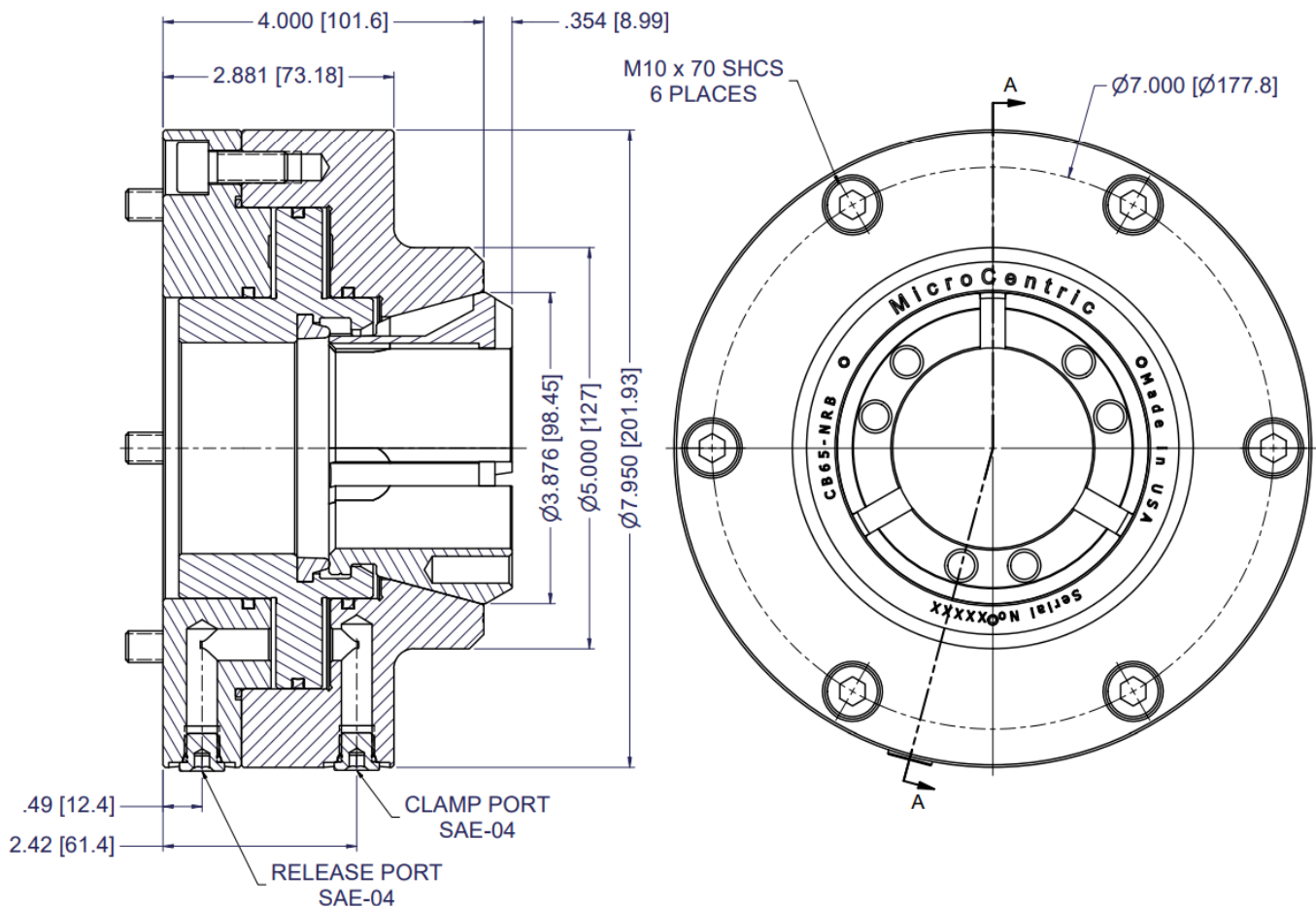


## CB65-NRB Collet Chuck

### Specifications

Collet Model	65BZI
Accuracy - Max Radial Runout*	.0004" / 0.010mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Max Clamping Force	23,605 lbs / 105 kN
Max Hydraulic Pressure	580 psi / 4.0 Mpa
Weight	38.44 lbs / 17.44 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet





## Specifications

*\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet*



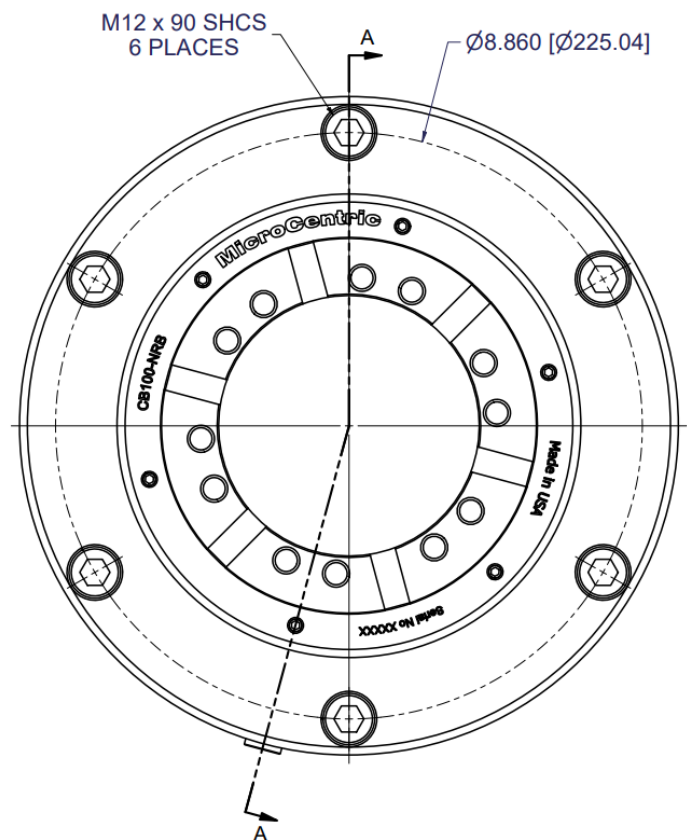
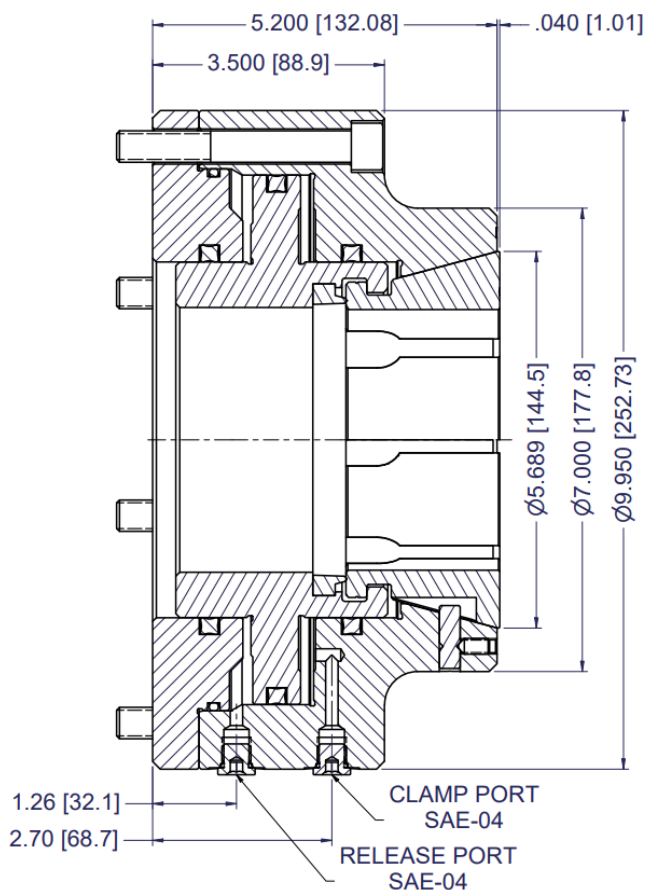


## CB100-NRB Collet Chuck

### Specifications

Collet Model	100BZI
Accuracy - Max Radial Runout*	.0006" / 0.015mm
Collet Capacity - Max Clamping Diameter	4.000" / 100mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Max Clamping Force	33,721 lbs / 150 kN
Max Hydraulic Pressure	530 psi / 3.7 Mpa
Weight	68.55 lbs / 31.09 kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet





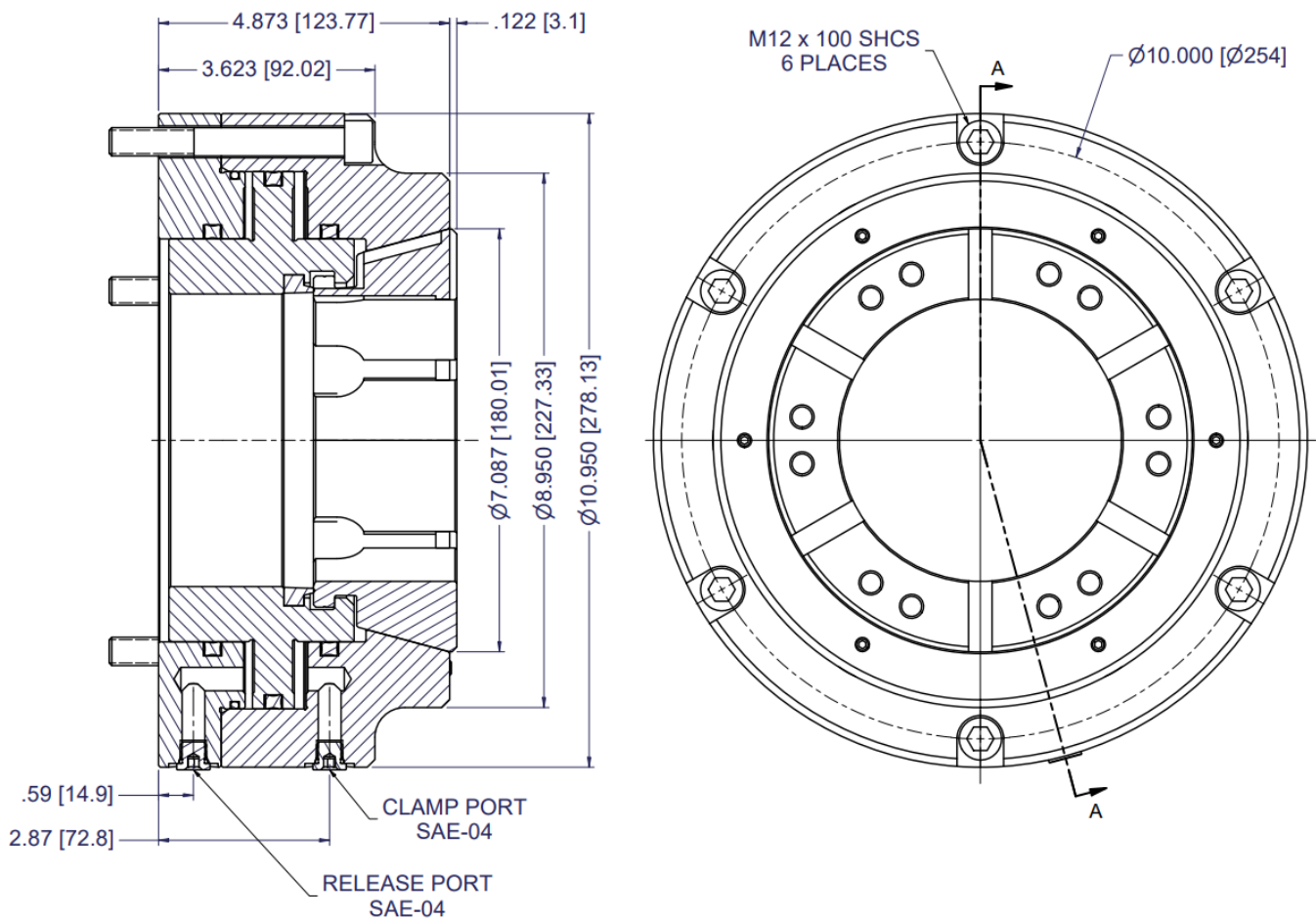


## CB120-NRB Collet Chuck

### Specifications

Collet Model	120BZ1
Accuracy - Max Radial Runout*	.001" / 0.025mm
Collet Capacity - Max Clamping Diameter	4.725" / 120mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Max Clamping Force	35,969 lbs / 160 kN
Max Hydraulic Pressure	550 psi / 3.8 Mpa
Weight	85.26 lbs / 38.67kg

\*Maximum runout of workpiece measured 1.25" (32mm) from face of collet



## CB-AG Collet Chucks - Compensating Design

The CB-AG series collet chuck is a pull back design with a floating collet seat for machining shafts between centers. Centers or other part locators are mounted in the ID of the chuck. The floating collet seat can also be locked out to clamp parts on-center. Compact OD and short length compared to other compensating chuck designs provides greater rigidity.



### CB-AG Features

- 1.5mm (.060") total compensation
- Mounting in ID of chuck body for mounting locating centers
- Radial adjusting screws to true-up locating center within .0002" (0.005mm)
- Lubricated-for-life design requires minimal maintenance
- Compact design for greater rigidity
- Collet seat can be locked out for clamping parts on-center
- All components hardened and precision ground for highest accuracy and long life

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
CB65-AG/A5	A2-5	65BZI	2.625/66mm
CB65-AG/140	140mm	65BZI	2.625/66mm
CB65-AG/A6	A2-6	65BZI	2.625/66mm
CB65-AG/A8	A2-8	65BZI	2.625/66mm

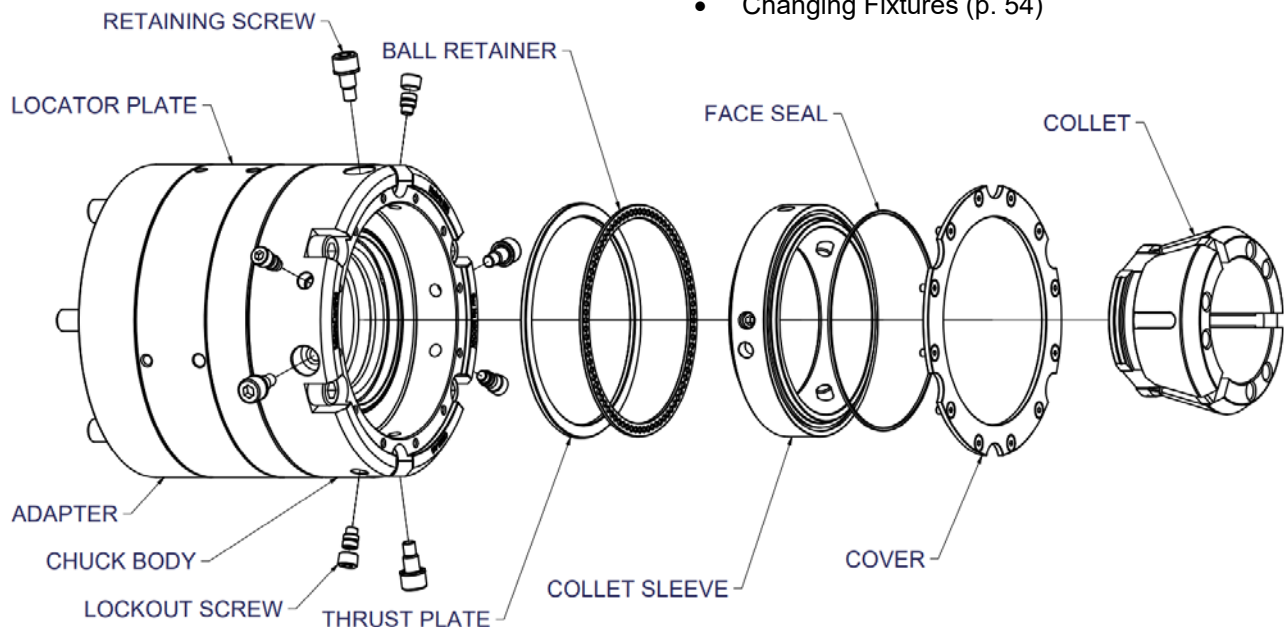
\*CB-AG chucks with spindle adapters other than those listed above are quoted on request.

### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required

### Optional Accessories

- Quick Change Collets (p. 43)
- Locating Centers (quoted on request)
- Changing Fixtures (p. 54)



## CB65-AG Collet Chuck

### Specifications

Collet Model	65BZI
Total Compensation	.060" / 1.50mm
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	.160" / 4mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	4,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Max. Draw Tube Thread	Chuck Weight
<b>CB65-AG/A5</b>	1	A2-5	5.375" 136.53 mm	- -	- -	M65x2	38.71 lbs 17.56 kg
<b>CB65-AG/140</b>	1	140mm	5.178" 131.52 mm	- -	- -	M65x2	37.59 lbs 17.05 kg
<b>CB65-AG/A6</b>	1	A2-6	5.925" 150.50 mm	- -	- -	M85x2	41.86 lbs 18.98 kg
<b>CB65-AG/A8</b>	2	A2-8	6.200" 157.48 mm	1.625" 41.28mm	8.250" 209.55mm	M85x2	48.34 lbs 21.92 kg
<b>CB65-NX/A8-OS</b>	2	A2-8	6.200" 157.48 mm	1.625" 41.28mm	9.250" 234.95mm	M100x2	53.19 lbs 24.12 kg

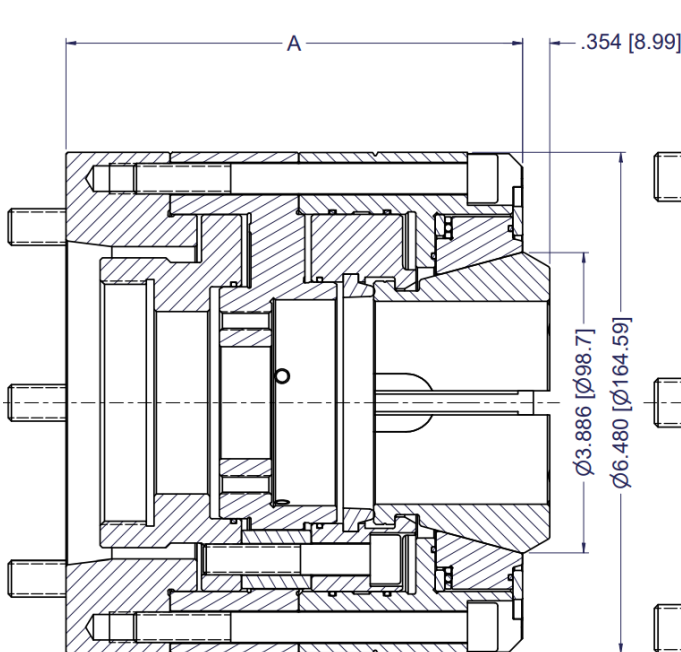


Figure 1

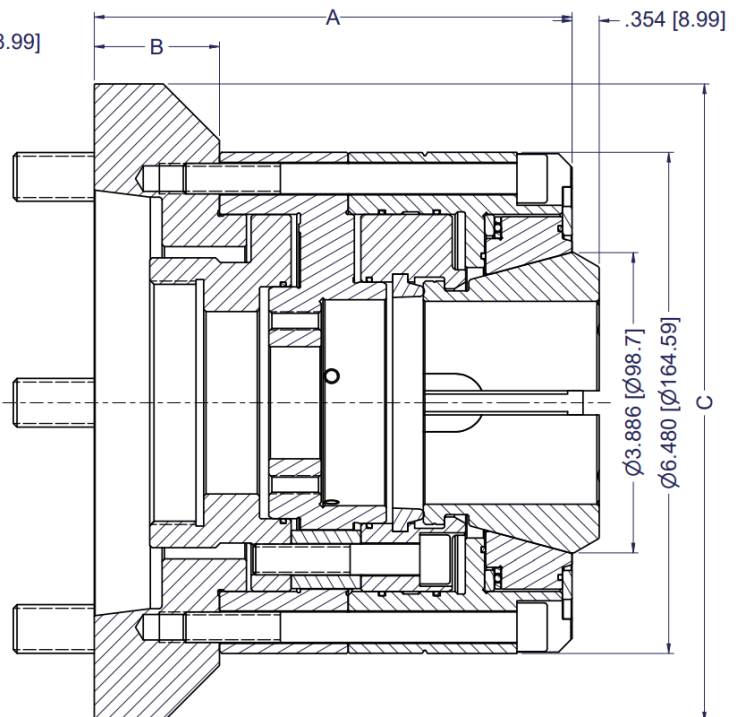


Figure 2

## WSF Collet Chucks - Retractable Design

Shafts can be machined complete between centers with MicroCentric's retractable collet chuck. A face driver mounted in the ID of the chuck drives the shaft as it is supported by the tailstock to turn the end of the shaft. When the chuck is actuated the collet moves forward to clamp the turned diameter enabling the OD of the shaft to be machined completed while the end of the shaft is securely clamped.



### WSF Features

- Mounting for face driver in ID of chuck assembly
- Radial adjusting screws to true-up chuck assembly within .0002" (0.005mm)
- All components hardened and precision ground for highest accuracy and long life

Chuck Model	Spindle Nose	Collet Model	Collet Capacity
WSF-65/A6	A2-6	65BZI	2.625/66mm
WSF-65/A8	A2-8	65BZI	2.625/66mm
WSF-65/A11	A2-11	65BZI	2.625/66mm
WSF-80/A8	A2-8	80BZI	3.250"/82.5mm
WSF-80/A11	A2-11	80BZI	3.250"/82.5mm
WSF-100/A11	A2-11	100BZI	4.000"/100mm

*\*WSF chucks with spindle adapters other than those listed above are quoted on request.*

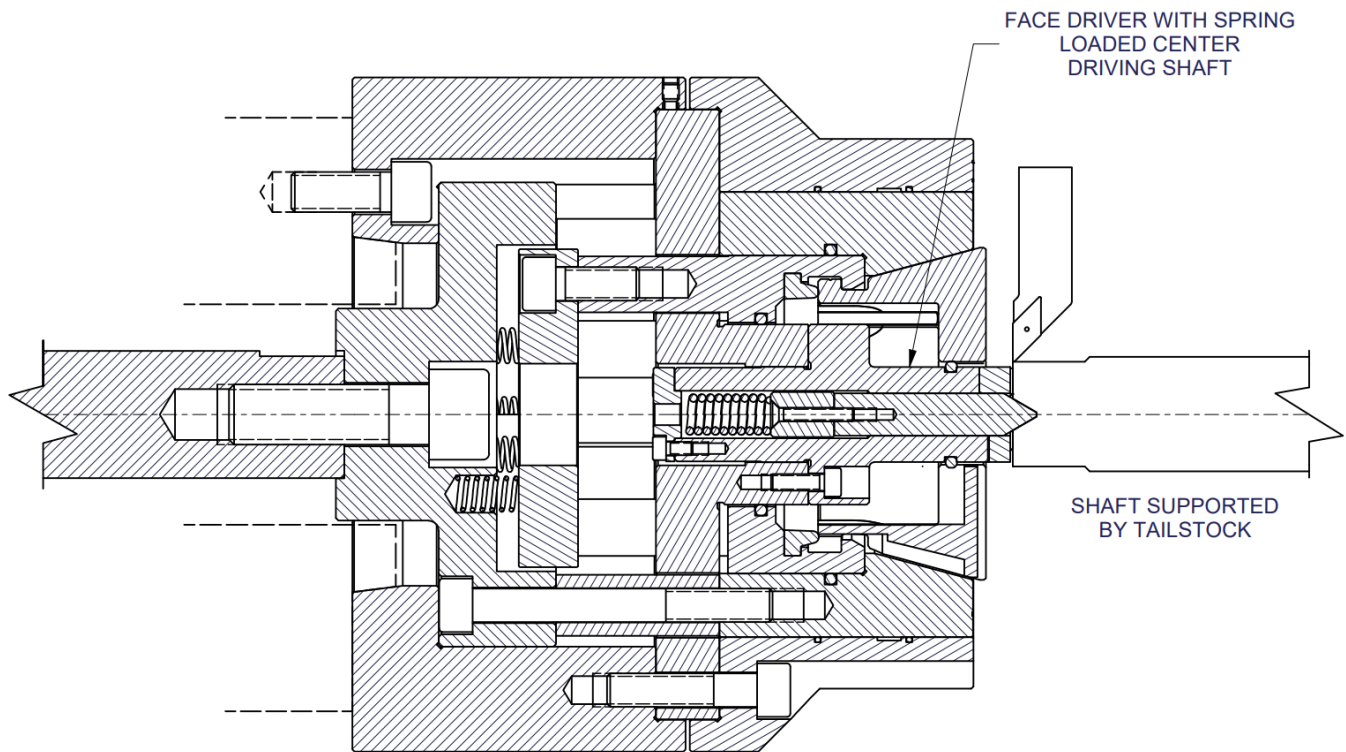
### Standard Equipment

- Spindle adapter plate
- Threaded draw tube connector as required. Machine spindle drawing including draw tube dimensions and position must be submitted with order

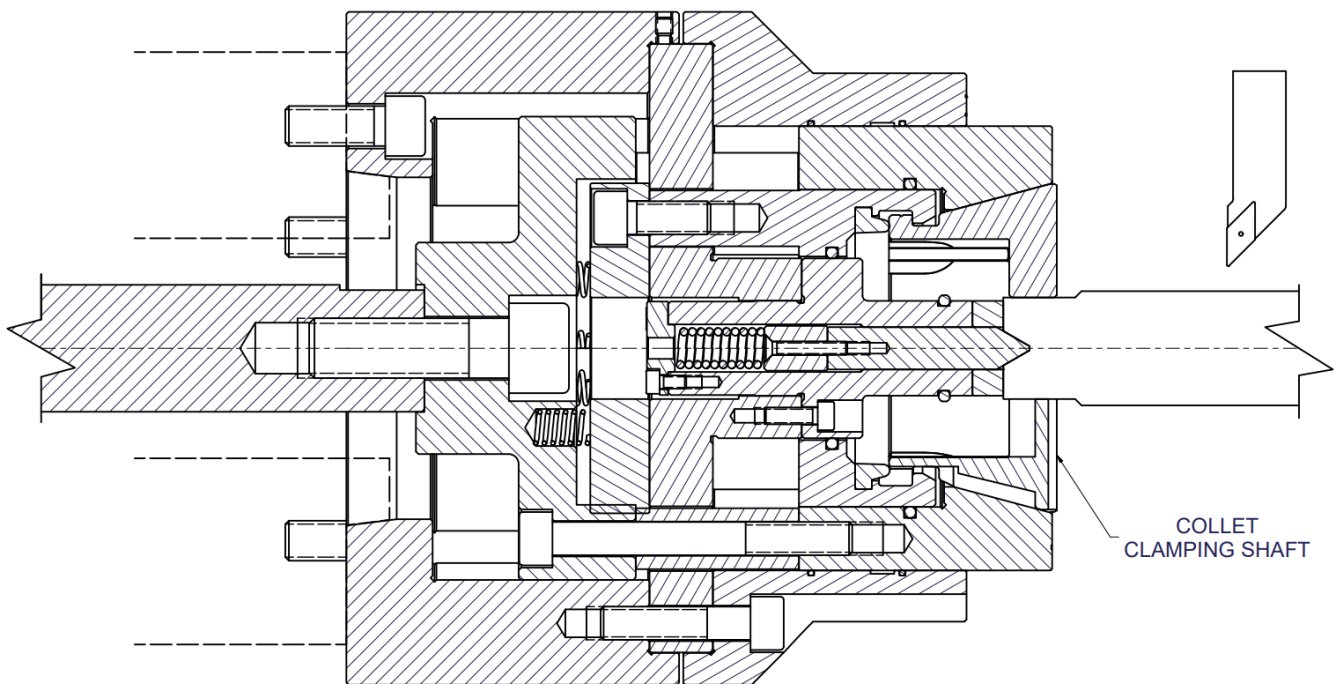
### Optional Accessories

- Quick Change Collets (p. 43)
- Changing Fixtures (p. 54)
- Face drivers (quoted on request)
- Long stroke hydraulic cylinder package (quoted on request)

## *WSF Collet Chuck Retracted*



## *WSF Collet Chuck Clamping Shaft*





## WSF-65 Collet Chuck

### Specifications

Collet Model	65BZI
Collet Capacity - Max Clamping Diameter	2.625" / 66mm
Collet Capacity - Min Clamping Diameter	.187" / 5mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	1.080" / 27.43mm
Max Draw Tube Force	10,116 lbs / 45 kN
Max Clamping Force	23,605 lbs / 105 kN
Maximum Speed	4,000 rpm

Chuck Model	Fig.	Spindle Nose	A	B	C	Chuck Weight
WSF-65/A5	1	A2-5	7.335"	-	-	79.30 lbs
			186.31 mm	-	-	35.96 kg
WSF-65/A6	1	A2-6	7.335"	-	-	78.47 lbs
			186.31 mm	-	-	35.59 kg
WSF-65/A8	2	A2-8	7.635"	1.650"	9.250"	82.20 lbs
			193.93 mm	41.91 mm	234.95 mm	37.28 kg
WSF-65/A11	2	A2-1	7.400"	2.405"	10.950"	95.60 lbs
			187.96 mm	61.09 mm	278.13 mm	43.36 kg

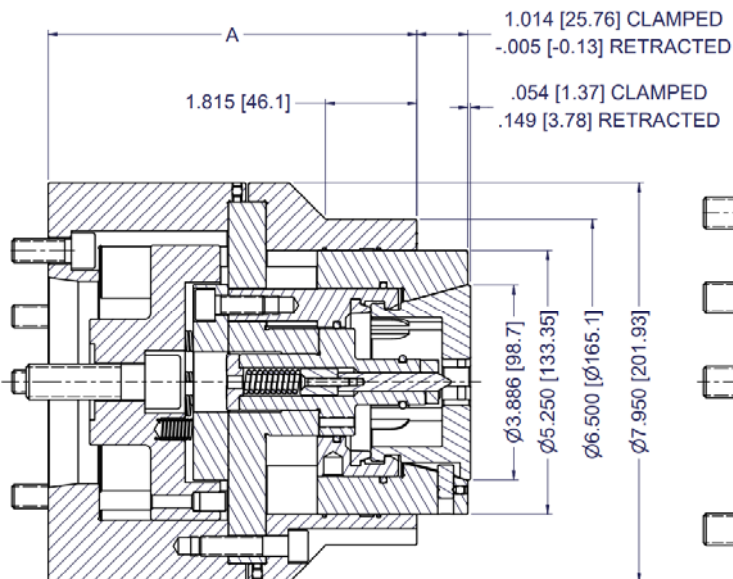


Figure 1

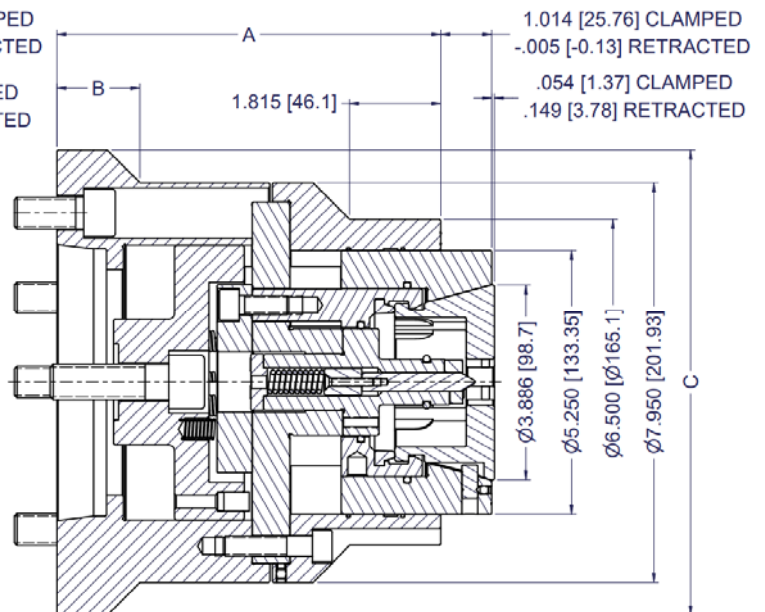


Figure 2



## WSF-80 Collet Chuck

### Specifications

Collet Model	80BZI
Collet Capacity - Max Clamping Diameter	3.250" / 82.5mm
Collet Capacity - Min Clamping Diameter	.500" / 12mm
Collet Clamp Range	+/- .020" / 0.5mm
Chuck Stroke - Linear	1.341" / 34.06mm
Max Draw Tube Force	11,240 lbs / 50 kN
Max Clamping Force	25,853 lbs / 115 kN
Maximum Speed	4,500 rpm

Chuck Model	Fig.	Spindle Nose	A	Chuck Weight
<b>WSF-80/A6</b>	1	A2-6	8.950" 227.33mm	102.91 lbs 46.67 kg
<b>WSF-80/A8</b>	1	A2-8	9.250" 234.95mm	104.09 lbs 47.21 kg
<b>WSF-80/A11</b>	2	A2-11	10.908" 277.05mm	115.59 lbs 52.42 kg

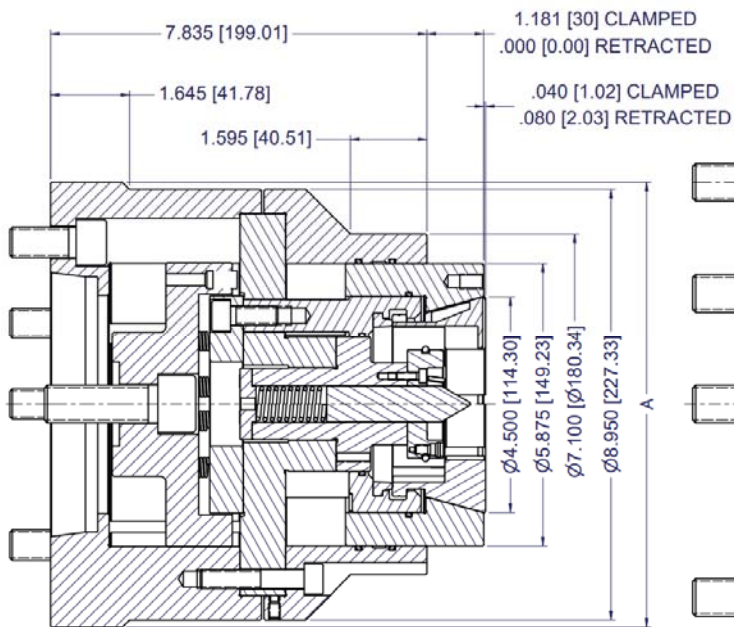


Figure 1

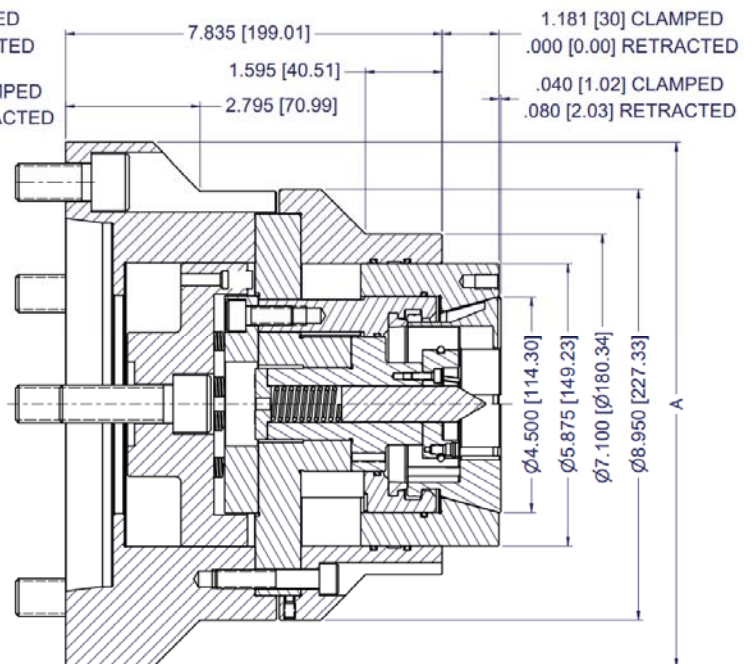


Figure 2

## WSF-100 Collet Chuck

### Specifications

Collet Model	100BZI
Collet Capacity - Max Clamping Diameter	4.000" / 100mm
Collet Capacity - Min Clamping Diameter	1.00" / 25mm
Collet Clamp Range	+/- .040" / 1mm
Chuck Stroke - Linear	1.750" / 44.45mm
Max Draw Tube Force	14,612 lbs / 65 kN
Max Clamping Force	33,721 lbs / 150 kN
Maximum Speed	3,000 rpm

Chuck Model	Fig.	Spindle Nose	A	Chuck Weight
<b>WSF-100/A8</b>	1	A2-8	9.065" 230.25mm	165.84 lbs 75.21 kg
<b>WSF-100/A11</b>	2	A2-11	10.065" 255.65mm	174.96 lbs 79.35 kg

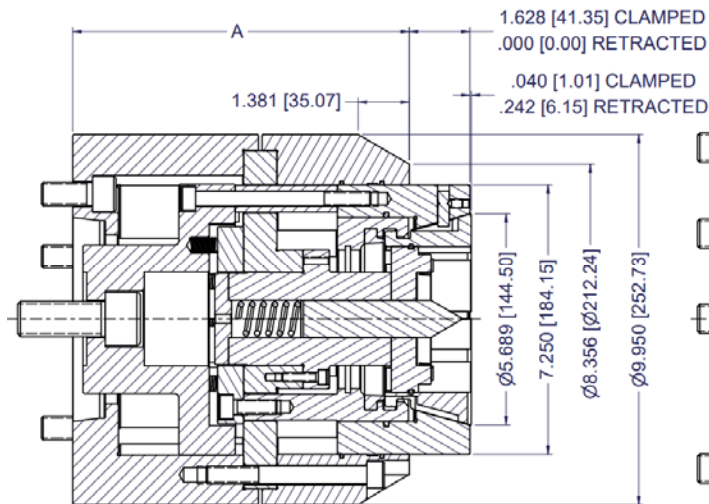


Figure 1

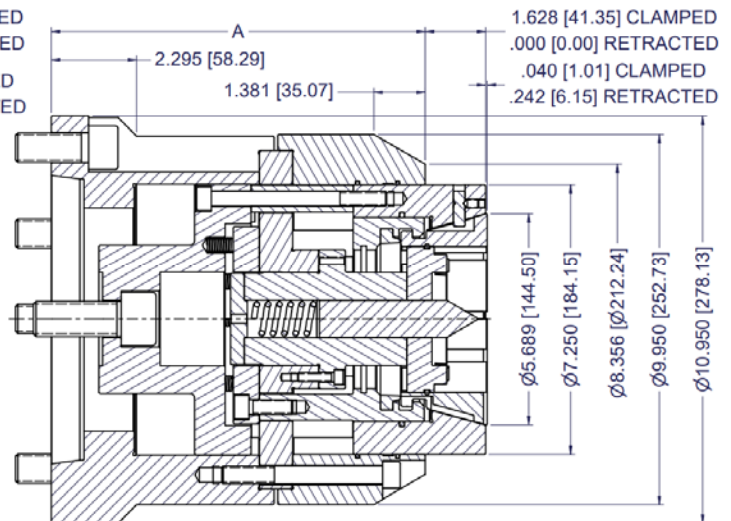


Figure 2

# MicroCentric Quick Change Collets

## One Piece Vulcanized Design

MicroCentric Quick Change Collets are hardened and precision ground segments held together by vulcanized rubber. The vulcanized design produces a seal that prevents chips and sludge from accumulating inside the collet chuck. MicroCentric's vulcanizing technology produces a permanent bond between rubber and metal.

## Collet Configurations



### Standard Collet

Recommended for bar and most chucking application



### Reduced Nose

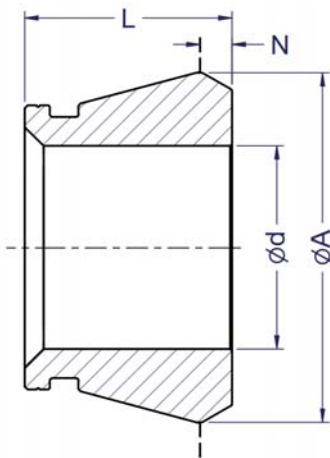
Recommended for chucking applications, when the clamping length is under .500" (12.7mm)



### Machinable Collet

Can be machined to special bore diameters or other special configurations

## Collet Models & Capacities



Model	No. of Segments	$\phi d$ max	$\phi A$	L	N	Range
SK42BZI	3	1.625"	3.085"	1.850"	0.354"	+/- .020
		42mm	78.4mm	47mm	9mm	+/- 0.5mm
SK42BZI/G	3	1.625"	3.085"	1.550"	.055"	+/- .020
		42mm	78.4mm	39.4mm	1.4mm	+/- 0.5mm
SK52BZI	3	2.000"	3.122"	1.811"	0.157"	+/- .020
		52mm	79.3mm	46mm	4mm	+/- 0.5mm
SK65BZI	3	2.625"	3.886"	2.284"	0.354"	+/- .020"
		66mm	98.7mm	58mm	9mm	+/- 0.5mm
SK65BZI/G	3	2.625"	3.886"	1.984"	.055"	+/- .020"
		66mm	98.7mm	50.4mm	1.4mm	+/- 0.5mm
SK80BZI	4	3.250"	4.500"	2.085"	0.181"	+/- .020"
		82.5mm	114.3mm	53mm	4.6mm	+/- 0.5mm
SK100BZI	6	4.000"	5.689"	2.323"	0.039"	+/- .040"
		101.5mm	144.5mm	59mm	1mm	+/- 1.0mm
SK120BZI	6	4.725"	7.087"	2.402"	0.118"	+/- .040"
		120mm	180mm	61mm	3mm	+/- 1.0mm
SK140BZI	6	5.551"	7.700"	2.480"	0/177"	+/- .040"
		140mm	195.6mm	63mm	4.5mm	+/- 1.0mm
SK160BZI	6	6.300"	8.858"	2.480"	0.197"	+/- .040"
		160mm	225mm	63mm	5mm	+/- 1.0mm

## 1.625" (42mm) Capacity Collets

### SK42BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (Serrated)*	.312 - 1.625"
	RSM (Smooth)*	.187 - 1.625"
● <b>Hex</b>	HEX (Smooth)*	.187 - 1.406"
		5 - 36mm
■ <b>Square</b>	SQR (Smooth)	.250 - 1.125"
		6 - 28mm

\* available from stock in 1/32" and 1mm increments

### SK42BZI/G Reduced Nose Collets



Configuration		Range
● <b>Round</b>	RSM (Smooth)	.187 - 1.625"
		5 - 42mm
● <b>Hex</b>	HEX (Smooth)	.187 - 1.406"
		5 - 36mm
■ <b>Square</b>	SQR (Smooth)	.250 - 1.125"
		6 - 29mm

### SK42BZI/HSW Machinable Collets & AR42 Loading Rings

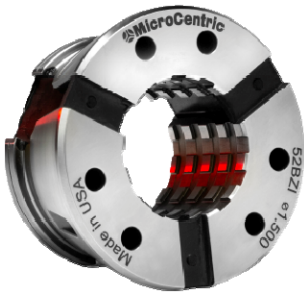


Item	Description	Bore Size
<b>SW42BZI</b>	Machinable Collet	.312" (8mm)
<b>AR42</b>	Loading Ring	

The SK42BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. The AR42 loading ring is used to preload the collet during machining.

## 2.000" (52mm) Capacity Collets

### SK52BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (Serrated)*	.375 - 2.000"
		9 - 52mm
	RSM (Smooth)*	.187 - 2.000"
● <b>Hex</b>		5 - 52mm
	HEX (Smooth)*	.250 - 1.750"
■ <b>Square</b>		6 - 45mm
	SQR (Smooth)	.250 - 1.437"
		6 - 36mm

\* available from stock in 1/16" and 1mm increments

### SK52BZI/HSW Machinable Collets & AR52 Loading Rings



Item	Description	Bore Size
<b>SK52BZI/HSW</b>	Machinable Collet	.312" (8mm)
<b>AR52</b>	Loading Ring	

The SK52BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. The AR52 loading ring is used to preload the collet during machining.

## 2.625" (65mm) Capacity Collets

### SK65BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (Serrated)*	.375 - 2.562"
	RSM (Smooth)*	.187 - 2.625"
● <b>Hex</b>	HEX (Smooth)*	.250 - 2.250"
	SQR (Smooth)	.250 - 1.812"
■ <b>Square</b>	SQR (Smooth)	.250 - 1.812"
		6 - 46mm

\* available from stock in 1/32" and 1mm increments

### SK65BZI/G Reduced Nose Collets



Configuration		Range
● <b>Round</b>	RSM (Smooth)	.187 - 2.625"
		5 - 66mm
● <b>Hex</b>	HEX (Smooth)	.250 - 2.250"
		6 - 57mm
■ <b>Square</b>	SQR (Smooth)	.250 - 1.812"
		6 - 46mm



## SK65BZI/HSW Machinable Collets & AR65 Loading Rings



Item	Description	Bore Size
<b>SK65BZI/HSW</b>	Machinable Collet	.312" (8mm)
<b>AR65</b>	Loading Ring	

The SK65BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. The AR65 loading ring is used to preload the collet during machining.

## SK65BZI S-Pad Master Collets



Collet Pad	Master Collet	Range
<b>S-16</b>	SK65BZI/G/S16	.125" - 1.650" 3.2 - 41.3mm
<b>S-20</b>	SK65BZI/S20	.125" - 2.000" 3.2 - 50.8mm
<b>S-22</b>	SK65BZI/S22	.125" - 2.250" 3.2 - 57.1mm

Master Collets are made from hardened alloy steel, and are precision ground to close tolerances to ensure accuracy and long term performance. Master collets are supplied with clamp screws.

## 3.250" (82.5mm) Capacity Collets

### SK80BZI Quick Change Collets



Configurations		Range
● Round	RSR (serrated)*	.750 - 3.250"
		19 - 82.5mm
	RSM (smooth)*	.500 - 3.250"
		12 - 82.5mm
⬡ Hex	HEX (smooth)*	.500 - 2.750"
		12 - 71mm
■ Square	SQR (smooth)	.500 - 2.250"
		12 - 58mm

\* available from stock in 1/16" and 1mm increments

### SK80BZI/HSW Machinable Collets & AR80 Loading



Item	Description	Bore Size
<b>SK80BZI/HSW</b>	Machinable Collet	.750" (19mm)
<b>AR80</b>	Loading Ring	

The SK80BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

### SK80BZI S-Pad Master Collets



Collet Pad	Master Collet	Range
<b>S-26</b>	SK80BZI/S26	.125" - 2.650"
		3.2 - 66.7mm
<b>S-30</b>	SK80BZI/S30	.125" - 3.000"
		3.2 - 76.2mm

Master Collets are made from hardened alloy steel, and are precision ground to close tolerances to ensure accuracy and long term performance. Master collets are supplied with clamp screws.

## 4.000" (100mm) Capacity Collets

### SK100BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (serrated)	1.000 - 4.000"
		25 - 101.5mm
	RSM (smooth)	1.000 - 4.000"
		25 - 101.5mm
● <b>Hex</b>	HEX (smooth)	1.250 - 3.375"
		31 - 86mm
■ <b>Square</b>	SQR (smooth)	1.250 - 2.750"
		31 - 70mm

### SK100BZI/HSW Machinable Collets & AR100 Loading Rings



Item	Description	Bore Size
<b>SK100BZI/HSW</b>	Machinable Collet	1.000" (25.4mm)
<b>AR100</b>	Loading Ring	

The SK80BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

### SK100/65BZI & SK100/42BZI Master Collets



Item	Description	Range
<b>SK100/42BZI</b>	Master Collet	.187 - 1.625"
		5 - 42mm
<b>SK100/65BZI</b>	Master Collet	.187 - 2.625"
		5 - 66mm

The SK100BZI/65BZI and SK100/42BZI master collets contain an additional coupling in the ID of the master collet to allow for the use of SK65BZI and SK42BZI collets in collet chucks designed for SK100BZI Collets.

## 4.725" (120mm) Capacity Collets

### SK120BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (serrated)	1.000 - 4.725"
		25 - 120mm
	RSM (smooth)	1.000 - 4.725"
● <b>Hex</b>		25 - 120mm
	HEX (smooth)	1.250 - 4.062"
		31 - 103mm
■ <b>Square</b>	SQR (smooth)	1.250 - 3.343"
		31 - 85mm

### SK120BZI/HSW Machinable Collets & AR120 Loading Rings



Item	Description	Bore Size
<b>SK120BZI/HSW</b>	Machinable Collet	1.500" (38.1mm)
<b>AR120</b>	Loading Ring	

The SK120BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

## 5.510" (140mm) Capacity Collets

### SK140BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (serrated)	1.000 - 5.510"
		25 - 140mm
	RSM (smooth)	1.000 - 5.510"
● <b>Hex</b>	HEX (smooth)	1.250 - 4.750"
		31 - 121mm
■ <b>Square</b>	SQR (smooth)	1.250 - 3.906"
		31 - 99mm

### SK140BZI/HSW Machinable Collets & AR140 Loading Rings



Item	Description	Bore Size
<b>SK140BZI/HSW</b>	Machinable Collet	1.500" (38.1mm)
<b>AR140</b>	Loading Ring	

The SK140BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.

## 6.300" (160mm) Capacity Collets

### SK160BZI Quick Change Collets



Configuration		Range
● <b>Round</b>	RSR (serrated)	1.000 - 6.300"
		25 - 160mm
	RSM (smooth)	1.000 - 6.300"
● <b>Hex</b>	HEX (smooth)	1.250 - 5.375"
		31 - 136mm
	SQR (smooth)	1.250 - 4.500"
■ <b>Square</b>	SQR (smooth)	31 - 114mm

### SK160BZI/HSW Machinable Collets & AR160 Loading Rings

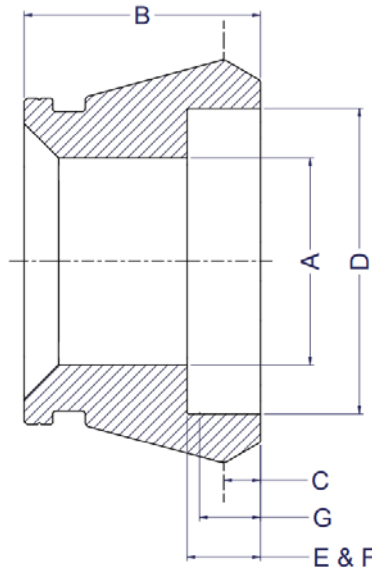


Item	Description	Bore Size
<b>SK160BZI/HSW</b>	Machinable Collet	1.500" (38.1mm)
<b>AR160</b>	Loading Ring	

The SK160BZI/HSW collet is case hardened to Rc 38-42 and can be bored out directly in the collet chuck to the diameter or configuration required. A plug or loading ring is used to preload the collet during machining.



## Maximum Collet Counter Bores



Model	Through Capacity	Overall Length	Collet Protrusion Length	For Maximum Turning Diameter		For Maximum Clamping Depth		Minimum Turning Depth*	Minimum Clamping Depth of Workpiece
				Maximum Turning Dia.	Maximum Turning Depth at Max. Dia.	Maximum Turning Dia. at Max Depth	Maximum Turning Depth		
	A	B	C	D	E	D	E	F	G
SK42BZI	1.625"	1.850"	0.354"	2.441"	0.669"	45.0mm	27.0mm	0.610"	0.472"
	42.0mm	47.0mm	9.0mm	62.0mm	17.0mm	45.0mm	27.0mm	15.5mm	12.0mm
SK42BZIG	1.625"	1.551"	0.055"	2.441"	0.370"	1.772"	0.764"	0.311"	0.173"
	42.0mm	39.4mm	1.4mm	62.0mm	9.4mm	45.0mm	19.4mm	7.9mm	4.4mm
SK52BZI	2.000"	1.811"	0.157"	2.441"	0.551"	2.110"	0.709"	0.413"	0.276"
	52.0mm	46.0mm	4.0mm	62.0mm	14.0mm	53.6mm	18.0mm	10.5mm	7.0mm
SK65BZI	2.625"	2.283"	0.354"	3.071"	0.748"	2.665"	1.339"	0.610"	0.472"
	66.7mm	58.0mm	9.0mm	78.0mm	19.0mm	67.7mm	34.0mm	15.5mm	12.0mm
SK65BZIG	2.625"	1.984"	0.055"	3.071"	0.449"	2.665"	1.039"	0.311"	0.173"
	66.7mm	50.4mm	1.4mm	78.0mm	11.4mm	67.7mm	26.4mm	7.9mm	4.4mm
SK80BZI	3.250"	2.087"	0.181"	3.583"	0.575"	3.287"	1.205"	0.437"	0.299"
	82.5mm	53.0mm	4.6mm	91.0mm	14.6mm	83.5mm	30.6mm	11.1mm	7.6mm
SK100BZI	4.000"	2.323"	0.039"	4.606"	0.827"	4.114"	1.260"	0.394"	0.157"
	101.5mm	59.0mm	1.0mm	117.0mm	21.0mm	104.5mm	32.0mm	10.0mm	4.0mm
SK120BZI	4.724"	2.402"	0.118"	5.984"	0.709"	5.551"	1.398"	0.374"	0.236"
	120.0mm	61.0mm	3.0mm	152.0mm	18.0mm	141.0mm	35.5mm	9.5mm	6.0mm
SK140BZI	5.510"	2.480"	0.177"	6.693"	0.728"	5.669"	1.437"	0.492"	0.335"
	140.0mm	63.0mm	4.5mm	170.0mm	18.5mm	144.0mm	36.5mm	12.5mm	8.5mm
SK160BZI	6.300"	2.480"	0.197"	8.268"	0.472"	7.362"	1.260"	0.472"	0.315"
	160.0mm	63.0mm	5.0mm	210.0mm	12.0mm	187.0mm	32.0mm	12.0mm	8.0mm

\*Minimum turning depth values apply to pull back style chucks only. For dead length chucks, minimum turning depth is equal to minimum clamping depth of workpiece.

## Collet Changing Fixtures

A changing fixture is used to install and remove MicroCentric collets from the chuck. Pins in the pivoting jaws of the changing fixture are inserted into the holes on the face of the collet. When the changing fixture is actuated, the rear of the collet collapses and allows the collet to be coupled or uncoupled from the chuck.

### Changing Fixture Configurations



#### *CG Pistol Grip Fixture*

The CG fixture is manually actuated and is available for 42, 52, 65, and 80mm size collets.



#### *CP Pneumatic Fixture*

The CP fixture is a self-contained pneumatic design available for all collets sizes up to 140mm.



#### *CH Hydraulic Fixture*

The CH fixture is a self-contained design actuated by the EN162 hydraulic pump. CH fixtures are available for 120, 140, and 160mm size collets.

### Changing Fixture Models

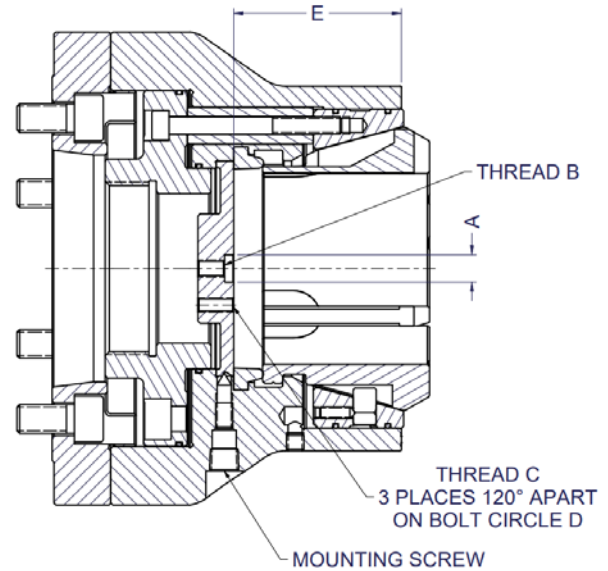
Changing Fixture	Type	Collet Model
<b>CP42</b>	Pneumatic	SK42BZI
<b>CG42</b>	Pistol Grip	SK42BZI
<b>CG52</b>	Pistol Grip	SK52BZI
<b>CP65</b>	Pneumatic	SK65BZI
<b>CG65</b>	Pistol Grip	SK65BZI
<b>CP80</b>	Pneumatic	SK80BZI
<b>CG80</b>	Pistol Grip	SK80BZI
<b>CP100</b>	Pneumatic	SK100BZI
<b>CH120</b>	Hydraulic	SK120BZI
<b>CP120</b>	Pneumatic	SK120BZI
<b>CH140</b>	Hydraulic	SK140BZI
<b>CP140</b>	Pneumatic	SK140BZI
<b>CH160</b>	Hydraulic	SK160BZI
<b>EN162</b>	Hydraulic Pump*	

\* The EN162 Hydraulic Pump is an air driven unit used to actuate the CH series changing fixtures

## Collet Chuck Accessories

### Stop Plates

Stop plates are available for NX, ND, and NK chucks. Part stops are mounted to the front face of the stop plate to end stop workpieces inside the chuck.

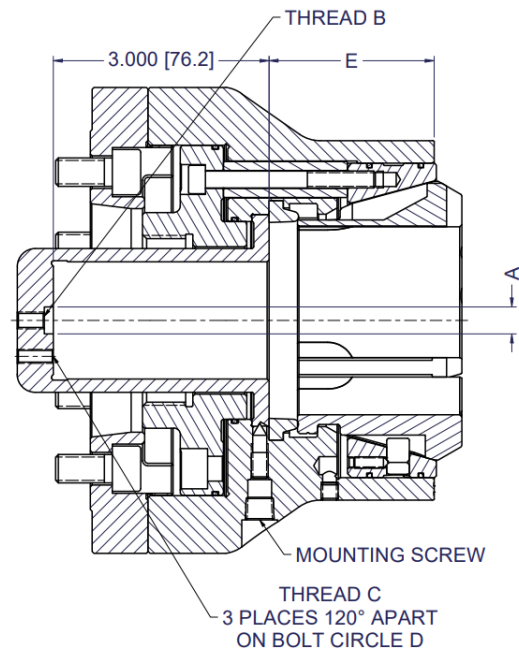


Model	Chuck	A	B	C	D	E
<b>SP-42/D</b>	CB42-NX/ND/NS	0.375"	M6	M5	1.000"	1.849"
		9.5mm			25.4mm	46.96mm
<b>SP-42/K</b>	CB42-NK	0.375"	M6	M5	1.000"	2.606"
		9.5mm			25.4mm	66.19mm
<b>SP-52/D</b>	CB52-NX	0.375"	M6	M5	1.000"	2.109"
		9.5mm			25.4mm	53.57mm
<b>SP-65/D</b>	CB65-NX/ND/NS	0.375"	M6	M5	1.000"	2.296"
		9.5mm			25.4mm	58.32mm
<b>SP-65/K</b>	CB65-NK	0.375"	M6	M5	1.000"	3.165"
		9.5mm			25.4mm	80.39mm
<b>SP-80/D</b>	CB80-NX/ND	.500"	M8	M6	1.250"	2.296"
		12.7mm			31.75mm	58.32mm
<b>SP-80/K</b>	CB80-NK	.500"	M8	M6	1.250"	3.205"
		12.7mm			31.75mm	81.41mm
<b>SP-100/D</b>	CB100-NX/ND	0.600"	M10	M8	1.500"	2.830"
		15.2mm			38.1mm	71.88mm
<b>SP-100/K</b>	CB100-NK	0.600"	M10	M8	1.500"	3.170"
		15.2mm			38.1mm	80.52mm
<b>SP-120/D</b>	CB120-ND	0.600"	M10	M8	2.500"	2.650"
		15.2mm			63.5mm	67.31mm
<b>SP-140/D</b>	CB140-ND	0.600"	M10	M8	2.500"	2.578"
		15.2mm			63.5mm	65.48mm
<b>SP-160/D</b>	CB160-ND	0.600"	M10	M8	2.500"	2.715"
		15.2mm			63.5mm	68.96mm

Stop plates are made from alloy steel hardened and precision ground, and include a set of mounting screws.

## Stop Housings

Stop housings are available for NX, ND, and NK chucks. Part stops are mounted to the inner face of the stop housing to end stop workpieces deep inside the chuck. Stop housings deeper than 3.00" (76mm), and stop housings with ejectors or special locators are quoted on request.

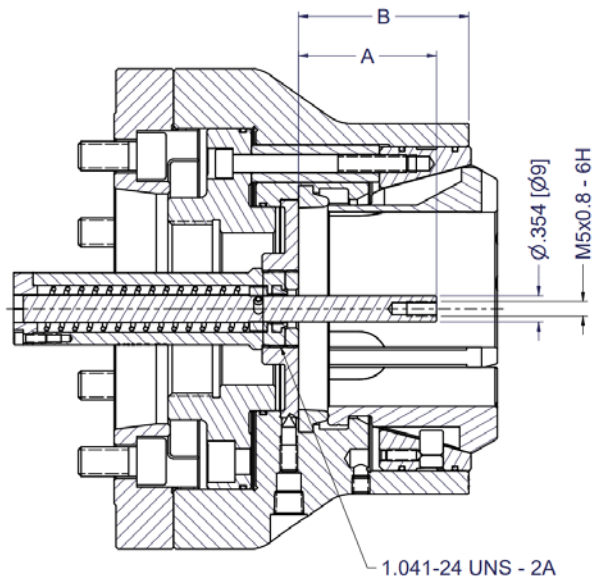


Model	Chuck	A	B	C	D	E
<b>SH-42/D</b>	CB42-NX/ND/NS	0.375" 9.5mm	M6	M5	1.000" 25.4mm	1.849" 46.96mm
<b>SH-42/K</b>	CB42-NK	0.375" 9.5mm	M6	M5	1.000" 25.4mm	2.606" 66.19mm
<b>SH-52/D</b>	CB52-NX	0.375" 9.5mm	M6	M5	1.000" 25.4mm	2.109" 53.57mm
<b>SH-65/D</b>	CB65-NX/ND/NS	0.375" 9.5mm	M6	M5	1.000" 25.4mm	2.296" 58.32mm
<b>SH-65/K</b>	CB65-NK	0.375" 9.5mm	M6	M5	1.000" 25.4mm	3.165" 80.39mm
<b>SH-80/D</b>	CB80-NX/ND	.500" 12.7mm	M8	M6	1.250" 31.75mm	2.296" 58.32mm
<b>SH-80/K</b>	CB80-NK	.500" 12.7mm	M8	M6	1.250" 31.75mm	3.205" 81.41mm
<b>SH-100/D</b>	CB100-NX/ND	0.600" 15.2mm	M10	M8	1.500" 38.1mm	2.830" 71.88mm
<b>SH-100/K</b>	CB100-NK	0.600" 15.2mm	M10	M8	1.500" 38.1mm	3.170" 80.52mm
<b>SH-120/D</b>	CB120-ND	0.600" 15.2mm	M10	M8	2.500" 63.5mm	2.650" 67.31mm
<b>SH-140/D</b>	CB140-ND	0.600" 15.2mm	M10	M8	2.500" 63.5mm	2.578" 65.48mm
<b>SH-160/D</b>	CB160-ND	0.600" 15.2mm	M10	M8	2.500" 63.5mm	2.715" 68.96mm

Stop housings are made from alloy steel hardened and precision ground, and include a set of mounting screws.

## Ejector Assemblies

Spring cartridge ejector assemblies are available for NX, ND, and NK chucks. Ejectors with larger stroke and mounted deeper into the ID of the chuck are quoted on request.



Model	Chuck Model	A	B
AW42-20/D	CB42-NX/ND/NS	2.00" / 50.8mm	1.849" / 46.96mm
AW42-30/D	CB42-NX/ND/NS	3.00" / 76.2mm	1.849" / 46.96mm
AW42-20/K	CB42-NK	2.00" / 50.8mm	2.606" / 66.19mm
AW42-30/K	CB42-NK	3.00" / 76.2mm	2.606" / 66.19mm
AW52-20/D	CB52-NX	2.00" / 50.8mm	2.109" / 53.57mm
AW52-30/D	CB52-NX	3.00" / 76.2mm	2.109" / 53.57mm
AW65-20/D	CB65-NX/ND/NS	2.00" / 50.8mm	2.296" / 58.32mm
AW65-30/D	CB65-NX/ND/NS	3.00" / 76.2mm	2.296" / 58.32mm
AW65-20/K	CB65-NK	2.00" / 50.8mm	3.165" / 80.39mm
AW65-30/K	CB65-NK	3.00" / 76.2mm	3.165" / 80.39mm
AW80-20/D	CB80-NX/ND	2.00" / 50.8mm	2.296" / 58.32mm
AW80-30/D	CB80-NX/ND	3.00" / 76.2mm	2.296" / 58.32mm
AW80-20/K	CB80-NK	2.00" / 50.8mm	3.205" / 81.41mm
AW80-30/K	CB80-NK	3.00" / 76.2mm	3.205" / 81.41mm
AW100-20/D	CB100-NX/ND	2.00" / 50.8mm	2.830" / 71.88mm
AW100-30/D	CB100-NX/ND	3.00" / 76.2mm	2.830" / 71.88mm
AW100-20/K	CB100-NK	2.00" / 50.8mm	3.170" / 80.52mm
AW100-30/K	CB100-NK	3.00" / 76.2mm	3.170" / 80.52mm
AW120-20/D	CB120-ND	2.00" / 50.8mm	2.650" / 67.31mm
AW120-30/D	CB120-ND	3.00" / 76.2mm	2.650" / 67.31mm
AW140-20/D	CB140-ND	2.00" / 50.8mm	2.578" / 65.48mm
AW140-30/D	CB140-ND	3.00" / 76.2mm	2.578" / 65.48mm
AW160-20/D	CB160-ND	2.00" / 50.8mm	2.715" / 68.96mm
AW160-30/D	CB160-ND	3.00" / 76.2mm	2.715" / 68.96mm

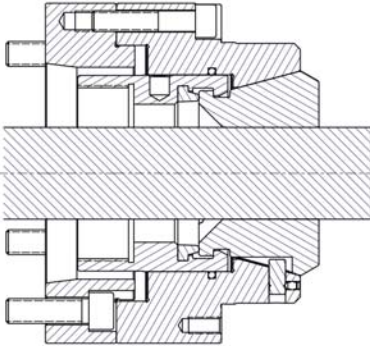
Ejector assemblies are made from alloy steel hardened and precision ground alloy steel, and include an ejector mounting plate and a set of mounting screws.



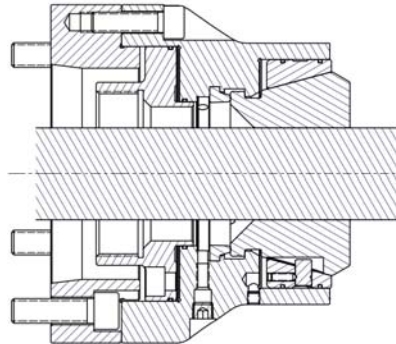
## Quick Change Collet Chuck Applications

### Bar Work Applications:

*Pull Back Chuck*

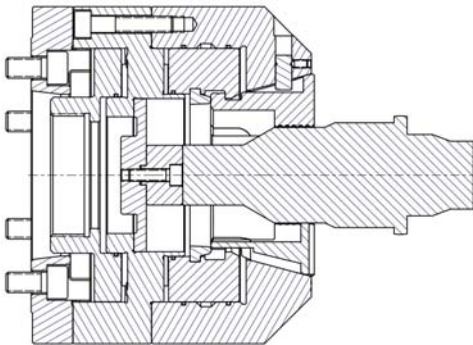


*Dead Length Chuck*

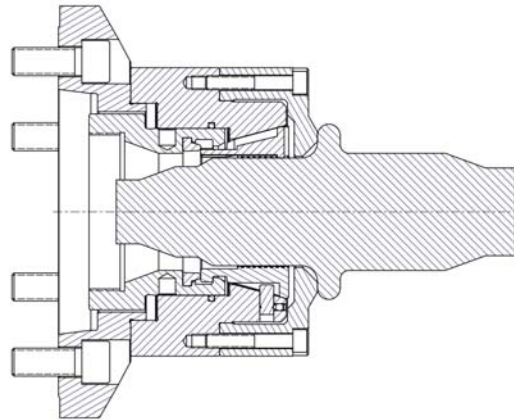


### Chucking Work Applications:

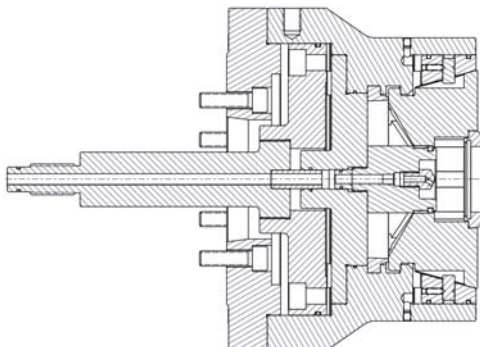
*Pull Back Chuck with internal part stop*



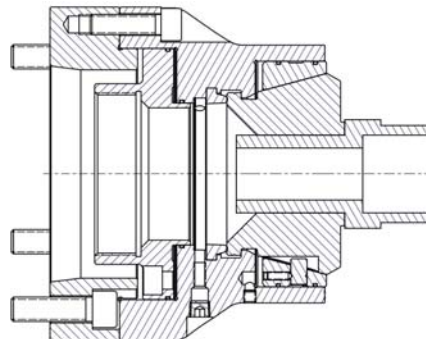
*Pull Back Chuck with external part stop*



*Dead Length Chuck with locating face inside collet to stop workpiece, with coolant through*

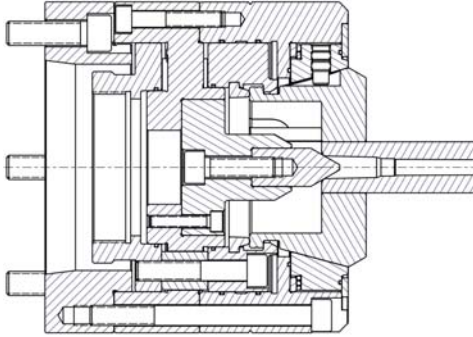


*Dead Length Chuck with face of collet used to end stop workpiece*

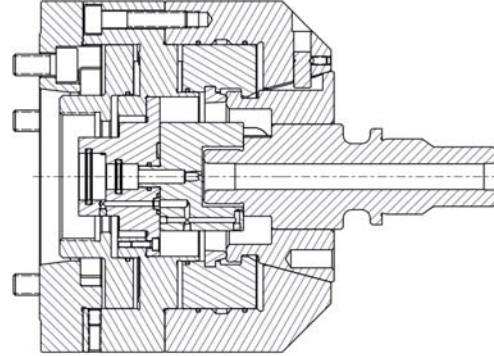




*Compensating Chuck with floating collet seat and center mounted in ID of chuck to locate workpiece*

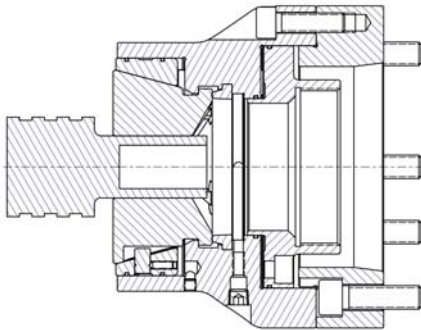


*Pull Back Chuck with internal part stop, air sensing, and coolant flush through spindle*

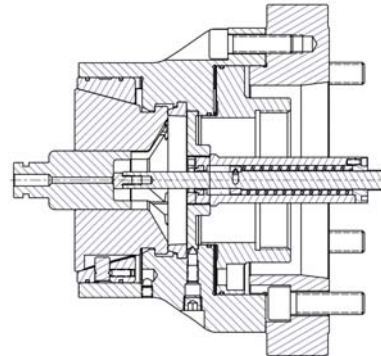


## Sub Spindle Applications:

*Low Profile Dead Length Chuck clamping workpiece picked off by sub spindle*

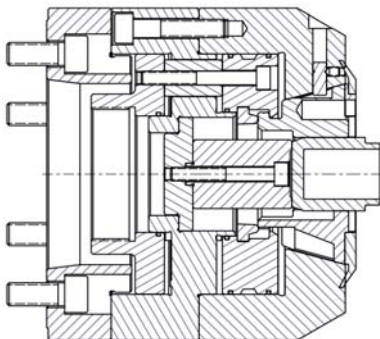


*Low Profile Dead Length Chuck with spring ejector mounted in chuck body*



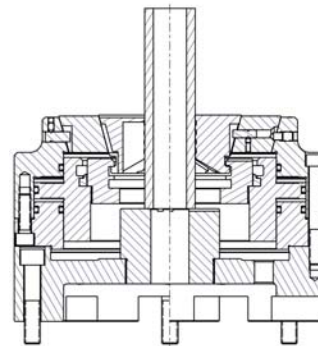
## ID Grinding Application:

*Pull Back Chuck with special lip seal collet that keeps ID of chuck free of grinding swarf*



## Drilling Application:

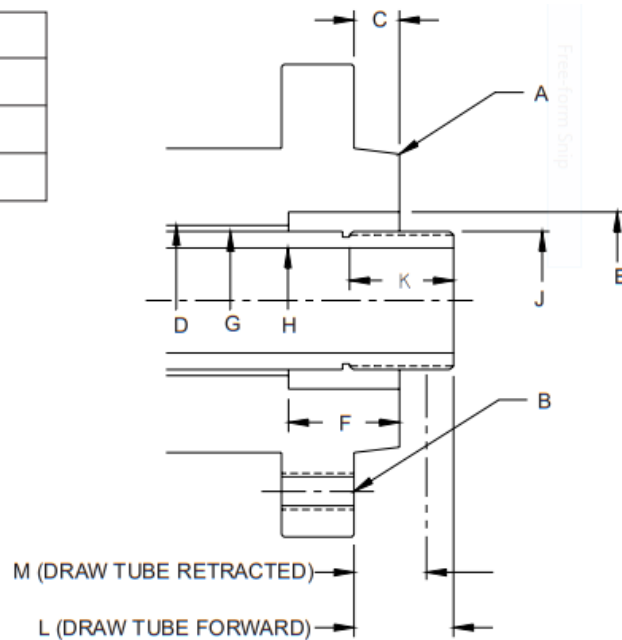
*Self Contained - Non Rotating Chuck with internal part stop mounted to machine table*



## Spindle & Draw Tube Data Sheet

Company	
Chuck Model	
Date	
Ref. No.	

Contact us at **1-800-573-1139** if you have any questions about completing this data sheet.



Machine Make		
Machine Model		
Machine Serial No.		
A* taper size		
B mounting thread		
C length of pilot		
D through hole diameter		
E ID counterbore or taper (if any)		
F depth of counterbore (if any)		
G OD of draw tube		
H ID of draw tube		
J thread data	thread diameter	
	thread pitch	
	<input type="radio"/> right hand	<input type="radio"/> left hand
	<input type="radio"/> OD thread	<input type="radio"/> ID thread
K length of thread		
L** forward position		
M retracted position		

\* For machines with a straight spindle pilot a detail drawing of the spindle must be submitted

\*\* Positive (+) indicates draw tube is in front of the spindle face (as shown)

Negative (-) indicates draw tube is behind the spindle face





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