

# Powerhold Auto-Offset Chucking Assembly

*Machine two centers in one chucking with Auto-Offset*



**Auto-Offset Advantage.** Often, manufacturers of pneumatic and hydraulic products often require machining an eccentric diameter within a concentric diameter. Conventionally this is accomplished by performing the concentric operations then moving the part to another machine (or a second spindle) to perform the eccentric operations. A special fixture is usually required to provide the correct radial orientation. Now, with Auto-Offset, manufacturers can machine two different centers in one chucking. Not only is this a much faster method, but it also improves part accuracy and reduces scrap. Many customers realize a return on their investment within months. Their finished products perform more efficiently because they are getting a consistent true position tolerance between concentric and eccentric surfaces.

**Offset positioning "on the fly."** Auto-Offset is a precision dovetail slide made of hardened and ground steel that mounts directly to the machine spindle nose. Your workholding device is then mounted on the Auto-Offset, enabling it to slide in one axial direction relative to your offset centerline position. A variety of workholding devices can be used, such as 3-jaw manual or power chucks, collets, and mandrels. The movement to and from the offset position can be done automatically while the work piece is rotating for non-stop production. Auto-Offset may be integrated with the machine's CNC system. The offset dimension is infinitely adjustable from 0" to the required offset amount.

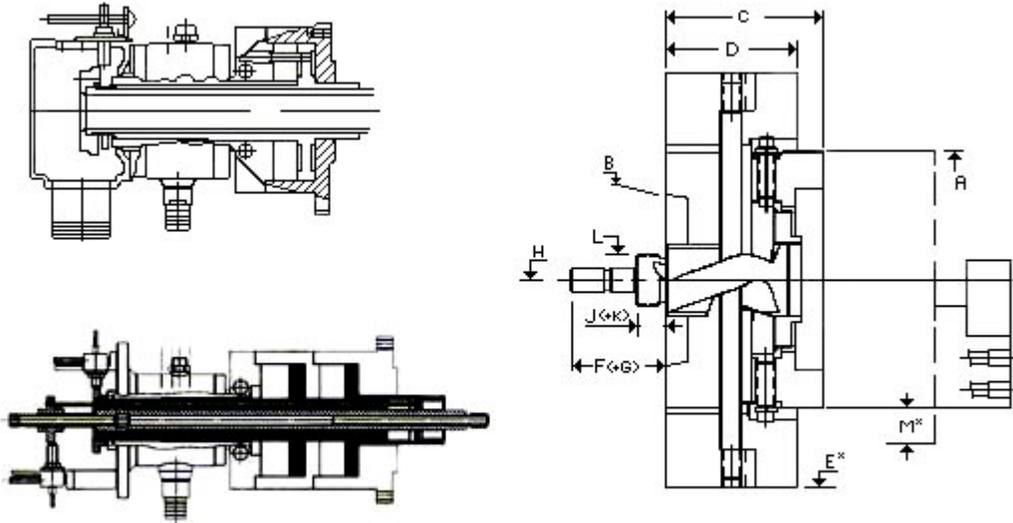
## Technical Features:

- Powered by double or single piston actuators for automatic positioning
- Counterbalanced for vibration-free rotation
- Offset positioning "On The Fly" – never stopping the spindle
- Compatible with a variety of workholding devices (jaw chucks, diaphragm chucks, etc)
- Reduced scrap
- Increased efficiency

Size	Max RPM (Central)	Max RPM (Offset)
6"	3500	3000
8"	2800	2500
10"	2500	2000
12"	2000	1500

## Powerhold AUTO-OFFSET Dimensions

- The AUTO-OFFSET is typically a custom built production tool available to suit your machining needs. Please call (800)349-1044 or e-mail [sales@powerholdinc.com](mailto:sales@powerholdinc.com), so we can design an AUTO-OFFSET for your special application.



### Dimensions (in):

Size	A	B	C	D	E	F	G	H	J	K	L	M
	Mounting Surface	Taper Mount	O.A.L	Counter-weight	Max Clearance Radius	+ G Stroke	Stroke	Thread	+K Stroke	Stroke	Thread	Max Offset
6.0"	6.3	A <sub>2</sub> 5	4.5	3.0	10.0	2.28	0.78	<sup>5</sup> / <sub>8</sub> -18	0.75	0.87	1 <sup>1</sup> / <sub>4</sub> -16	TBD
8.0"	8.5	A <sub>2</sub> 6	4.81	3.5	10.5	2.28	0.94	<sup>5</sup> / <sub>8</sub> -18	0.75	0.73	1 <sup>1</sup> / <sub>4</sub> -16	TBD
10.0"	9.8	A <sub>2</sub> 8	5.0	4.0	14.0	2.28	0.98	<sup>3</sup> / <sub>4</sub> -16	0.81	0.79	1 <sup>1</sup> / <sub>2</sub> -16	TBD
12.0"	12.0	A <sub>2</sub> 9	5.5	4.5	16.0	2.54	0.98	1.0-16	1.0	0.98	1 <sup>3</sup> / <sub>4</sub> -16	TBD

*Your Workholding Solutions Company*



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