

POWERHOLD

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STANDARD AND SPECIAL COLLET CHUCKS

Self-Contained And Cylinder-Actuated Designs
To Suit NC, CNC, And Other High Production Machine Tool Applications.

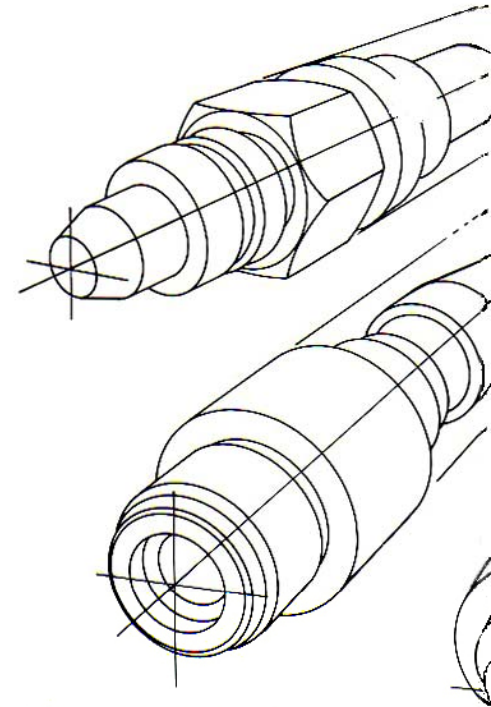
POWERHOLD STANDARD COLLET CHUCKS

Now you can increase production with deeper cuts at faster feedrates with PowerHold high-capacity standard collet chucks. Produced from top quality materials, hardened and ground on all mounting and wear surfaces, these collet chucks are direct replacements for three-jaw chucks and use standard, in-stock master collets and smooth or serrated pads in hex, square, or round configurations. And PowerHold collet pad top jaws are designed so that the standard collet pads usually used in push-type or pull-type master collets can be mounted in them (see PowerHold catalog 21-7-78). Both soft pads and over-capacity collets are available, with collet pad change over possible in less than 10 minutes.

Designed for ease of installation and the attendant reduction in downtime, the lightweight and small diameter of Pow-

erHold standard collet chucks mean reduced response time and quick-cycle, start/stop wear on motors, spindles, and braking systems. Precision balanced and safe in operation, these collet chucks can run at extremely high speeds with no lessening of holding power due to centrifugal force.

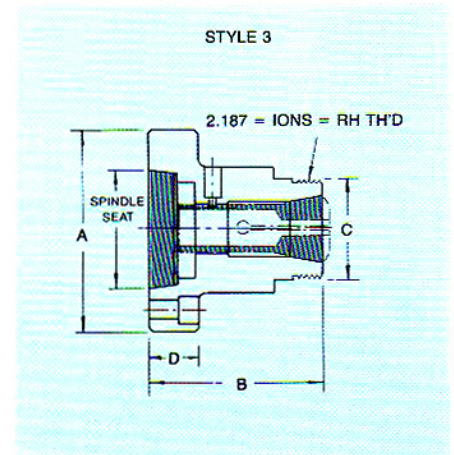
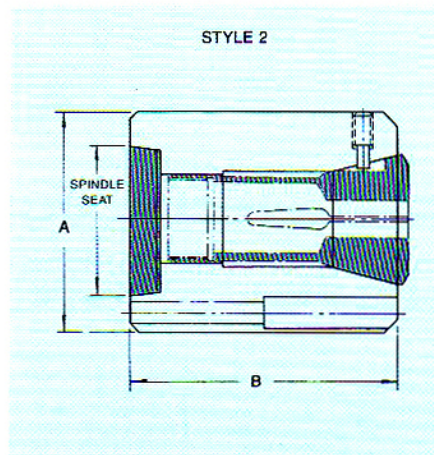
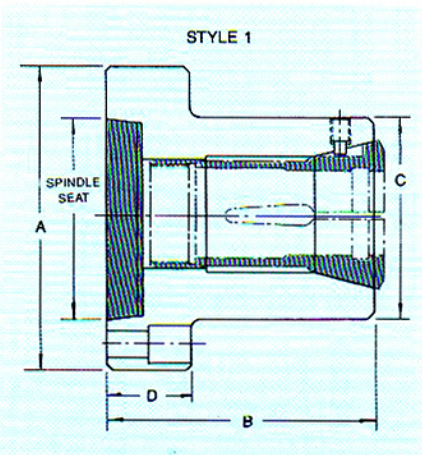
In the over 50 years since our founding, PowerHold has specialized in the development of increasingly precise and efficient workholding devices like these collet chucks. In addition to standard, off-the-shelf machine tool accessories, PowerHold has developed a reputation for custom engineering which has allowed the development of custom workholding devices for many difficult and unusual applications, such as those outlined on the back page of this catalog.



SPECIFICATIONS

PowerHold Model No.	Drawing No.	Style No.	Spindle Seat	Collet Description	A	B	C	D
5C-1.06-A5	C-11283	3 (No Th'ds)	A5	5C 1 ¹ / ₁₆ max. Solid Collet	5 ¹ / ₄	3 ³ / ₄	2 ⁹ / ₁₆	2
5CT-1.06-A5	C-11205	3	A5	5C 1 ¹ / ₁₆ max. Solid Collet	5 ¹ / ₄	3 ³ / ₄	2.187	2
5C-1.06-A6	C-11284	3 (No Th'ds)	A6	5C 1 ¹ / ₁₆ max. Solid Collet	6 ¹ / ₂	3 ³ / ₄	2 ⁵ / ₈	2
5CT-1.06-A6	C-11274	3	A6	5C 1 ¹ / ₁₆ max. Solid Collet	6 ¹ / ₂	3 ³ / ₄	2.187	2
5C-1.06-A8	C-11275	3 (No Th'ds)	A8	5C 1 ¹ / ₁₆ max. Solid Collet	8 ¹ / ₄	3 ³ / ₄	2 ⁵ / ₈	2
5CT-1.06-A8	C-11276	3	A8	5C 1 ¹ / ₁₆ max. Solid Collet	8 ¹ / ₄	3 ³ / ₄	2.187	2
3J-1.75-A5	C-11277	3 (No Th'ds)	A5	3J 1 ¹ / ₄ max. Solid Collet	5 ¹ / ₄	4	3 ³ / ₄	1 ¹ / ₈
3J-1.75-A6	C-11179	3 (No Th'ds)	A6	3J 1 ¹ / ₄ max. Solid Collet	6 ¹ / ₂	4	3 ³ / ₄	1 ¹ / ₈
3J-1.75-A8	C-11278	3 (No Th'ds)	A8	3J 1 ¹ / ₄ max. Solid Collet	8 ¹ / ₄	4	3 ³ / ₄	1 ³ / ₁₆
S15-1.5-A5	B-11188	2	A5	S15 1 ¹ / ₂ max. Collet Pads	5 ¹ / ₄	5 ⁵ / ₁₆	—	—
S15-1.5-A6	C-11055	1	A6	S15 1 ¹ / ₂ max. Collet Pads	6 ¹ / ₂	5 ⁹ / ₁₆	4	1 ¹ / ₄
S20-2.0-A6	C-11282	2	A6	S20 2.0 max. Collet Pads	6 ¹ / ₂	6 ¹ / ₂	—	—
S26-2.5-A8	C-11051	1	A8	S26 2.5 max. Collet Pads	8 ¹ / ₄	7	5 ⁵ / ₈	1 ³ / ₄
S30-3.0-A8	D-11279	1	A8	S30 3.0 max. Collet Pads	8 ¹ / ₄	7 ¹ / ₈	5 ⁵ / ₈	1 ³ / ₄
S35-3.5-A11	D-11280	1	A11	S35 3.5 max. Collet Pads	11	7 ¹ / ₈	7	2 ⁷ / ₈
SC15-4.0-A11	D-11281	1	A11	SC15 4.0 max. Collet Pads	11	8 ³ / ₁₆	7 ³ / ₄	2 ⁷ / ₈

DIMENSIONS



POWERHOLD CHUCK AND COLLET COMBINATION

One power chuck for both chucking and collet work? You bet! Now one power chuck with collet adapter can reduce set-up time and operator fatigue while actually increasing production. PowerHold power chucks are made with extra large center holes for chucking bars. They are operated by PowerHold air or hydraulic chuck actuators which also have large through holes. Therefore, a collet can be mounted in a center hole of the chuck as shown below. To convert from chucking to bar work, the top jaws are removed and the master collet is inserted into the collet bushing. For push-type chucks: Installation is completed by slipping the collet chuck body over the head of the master and bolting it to the face of the chuck. For pull-type chucks: Top jaws are removed and the collet adapter is bolted to the face of the chuck. The master collet is then inserted into the collet bushing. Radial location of the master collet is maintained by the collet key. A fifteen minute conversion back to chucking work requires only a reversal of these procedures.

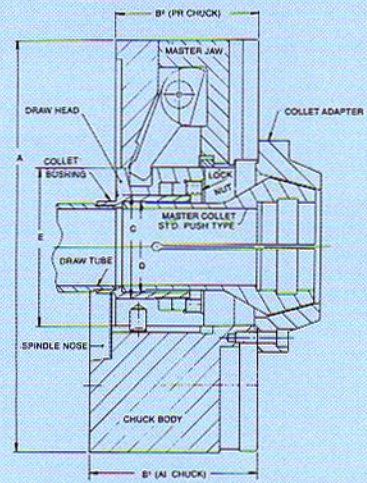
A collet chuck can be made for any standard master collet which will fit into the collet bushing. Dimensions and specifications are given below. It should be noted that bar capacity can be increased by using the chuck jaws rather than a collet to grip the bar. For example, a ten-inch chuck has a maximum collet capacity of two inches, but the jaws can grip 2½ inch bar stock.

A typical PowerHold chuck and collet combination can be used as a two jaw chuck, three jaw chuck, collet chuck and face plate for mounting special chucking fixtures. The time formerly used to change chucks can now be given over to productive work, meaning rapid payback for the chuck and collet combination.

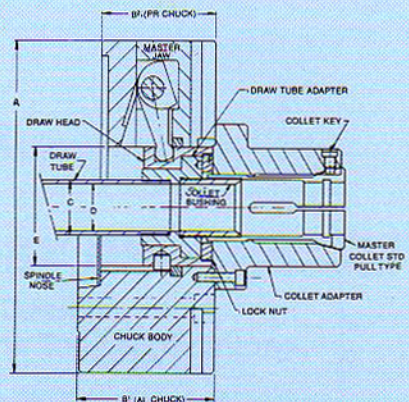
Large capacity PowerHold collet chucks can be set up for hex, round, or square stock.



DIMENSIONS (push-type chuck)

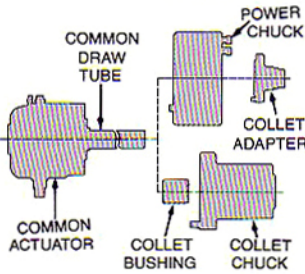


DIMENSIONS (pull-type chuck)



TWO STANDARD SYSTEMS

- Increased production and profit
- Higher RPM
- Rapid payback
- Quick changeover
- Easy installation



SPECIFICATIONS

Chuck Size	Spindle Nose (1)	Chuck Model No. (2)	Collet Capacity	Dimensions				
				A	B	C	D Max.	E
8"	* A-6	215-PR 215-A6	1"	8.47	3.03 3.74	1.79	1.50	2.9
10"	A-6 A-8	251-A6 251-A8	2"	9.84	4.29	2.62	2.38	3.88
11"	* A-6 A-8	280-PR 280-A6 280-A8	1¾"	11.00	3.86 4.61 4.61	2.57	2.19	4.0
12"	A-8 *	300-A8 350-PR	2½"	11.81	4.61	3.39	3.12	4.9
14"	A-8 A-11	350-A8 350-A11	2½"	13.8	5.71 5.71	3.56	3.28	5.3
15"	* A-11	380-PR 380-A11	3"	15.0	5.00 5.91	4.52	4.25	6.5
18"	*	450-PR	4½"	17.9	5.00	7.32	6.94	9.3

Note: (1) *Indicates this chuck has a flat seat for adapter plate.

(2) All chucks listed can be furnished with either two or three jaws. Model 270, 300, and 380 chucks can also be furnished with four jaws (two-three jaw type).

Your Workholding Solutions Company

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