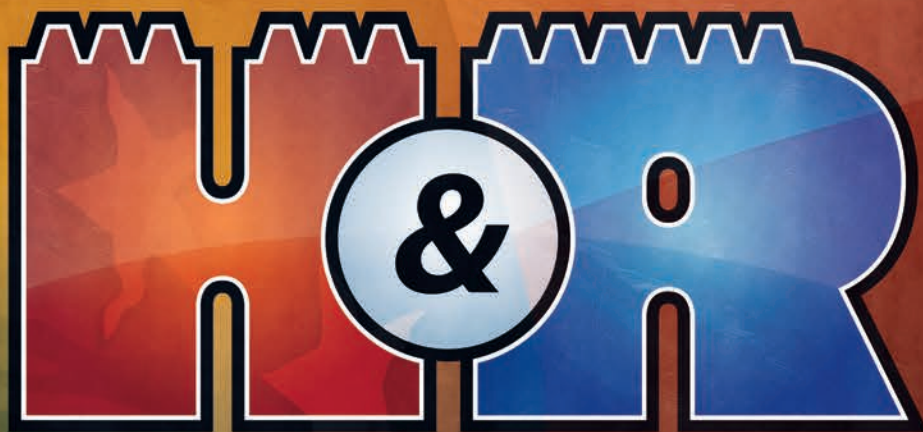
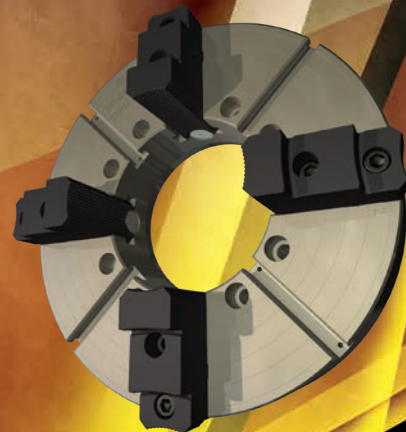
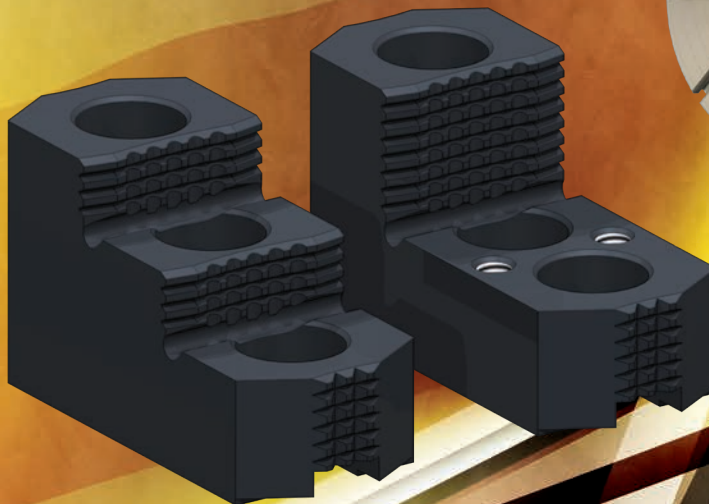
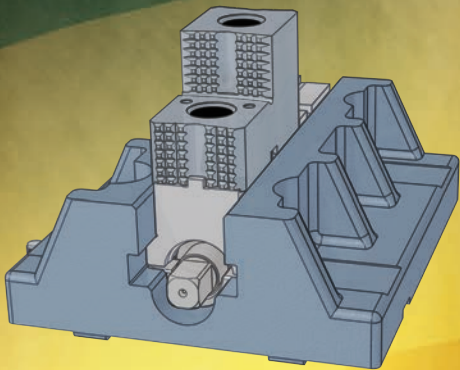




Mfg. and Supply, Inc.

The Workholding Authority

www.hrmfg.com



Greetings and welcome to the H&R product catalog. We have been in business since 1980 and our passion lies in the design and manufacture of full service tooling and workholding for all standard and special chucks, as well as turnkey engineering of custom fixtures. Please take a few moments to read this memo and the "Technical Specification for Jaws."

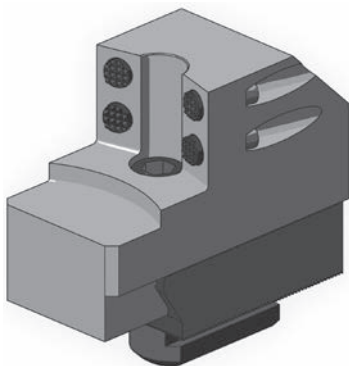
For Important H&R Warranty Information and Policies, please visit www.hrmfg.com/faq.htm



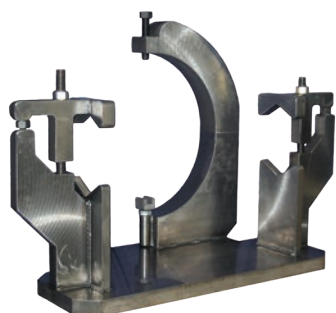
Hard and Soft Jaws: Pages 4-19



The Gladiator Chuck: Page 26



The Eliminator: Page 27



Custom Fixtures: Page 45

Standard Workholding Products

H&R inventories a full line of standard products of hard jaws, soft jaws, and accessories. In hard jaws, H&R stocks single step, two step, and extended hard jaws. A rigorous quality control program is in place and all hard jaws are certified before they are inventoried. In soft jaws, H&R stocks standards, offset and offset pointed jaws. In jaw nuts, H&R stocks American and Metric threaded jaw nuts.

If you need assistance in ordering or cross-over of numbers, please call us at 1-800-749-0629 and the H&R team will be happy to help you solve your problem and place a correct order. H&R reserves the right to change technical specification and/or pricing at any time without notification. Visit our website for additional assistance, as well as a product cross reference.

Turnkey Design and Development

Our Engineering Department has an innovative approach to the design of special jaws (both hard and soft jaws) and other custom holding devices to fit your special requirements. H&R supports tooling for multi-tasking or just in time. H&R will also design, manufacture, and stock other parts for chucks and numerous other pieces of equipment for the machine tool industry. (See page 44 for details)

We're here to help you!

H&R is in the best position to help any business looking for standard and custom workholding fixtures or special tooling. With our attentive development process, unique skills, and experienced personnel, the result is that the customer gets exactly the right tool to fit their needs. Call 1-800-749-0629 to request more information or visit our website at www.hrmfg.com.

Return Policy

H&R's Return Policy and Restocking Charges are based upon the problem the customer is having within a 60 day period of time. Standard products, not used or abused, can be accepted very readily at the standard 15% restocking charge. Special tooling made to customer specification are non-returnable. If the problem is a manufacturing defect, H&R will fix-it to your satisfaction.

Thank you for your interest in H&R Mfg. and Supply, Inc.
We look forward to serving you!

Sincerely,



Derek L. Hivnor, President



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(B) Heavy Duty Soft Jaws	5	<i>Bergman, Bison, Buck, Cushman, Huron, Rohm, Forkhardt, Pratt Burnerd America, SCA, S.P., W&S, Nobel & Yuasa</i>
(C) Full Wrap Jaws	6	<i>Bergman, Bison, Buck, Cushman, Huron, Rohm, Forkhardt, Pratt Burnerd America, SCA, S.P., W&S, Nobel & Yuasa</i>
(D) Hard Jaws	7	<i>Bergman, Bison, Buck, Cushman, Huron, Rohm, Forkhardt, Pratt Burnerd America, SCA, S.P., W&S, Nobel & Yuasa</i>
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All Jaws, Master Keys, Jaw Nuts	8	<i>Buck, Cushman, Gisholt, S.P., Howa & Pratt Burnerd America</i>
Square Serrated Keyed		
All Jaws, Master Keys, Jaw Nuts	9	<i>Cushman, Logansport, Autoblok, Huron, Buck, S.P., W&S & Pratt Burnerd America</i>
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(A) Soft Jaws	11	<i>Kitagawa, Matsumoto, Howa & Seike, Samchully, Strong</i>
(B) Double Step Hard Jaws, Single Step Hard Jaws, Autoblok Chuck Series	12	<i>Kitagawa, Matsumoto, Howa & Seike, Samchully, Strong</i>
(C) Full Wrap Jaws, Jaw Nuts	13	<i>Kitagawa, Nikko, Matsumoto, Howa & Seike, Samchully, Strong</i>
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(B) Hard Jaws, "T" Nuts, Full Wrap	17	<i>Cushman, Gamet, Erickson, Power Hold, Rohm, Autoblok, Forkhardt, SMW & Pratt Burnerd America</i>

	Page Numbers	Chucks
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Multi-Tasking Tooling		

TECHNICAL SPECIFICATIONS FOR JAWS



**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

Jaw Terminology:

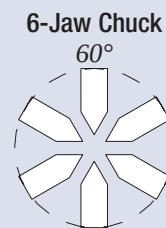
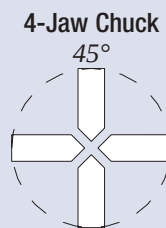
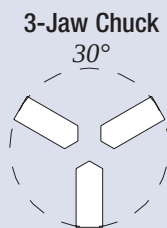
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|--|---|--|
| (1) SH = standard height | (4) H = heavy duty tongue and groove jaw | (7) CI = cast iron jaw |
| (2) EH = extended height | (5) O = offset jaw | (8) AL = aluminum jaw |
| (3) M = medium duty tongue and groove jaw | (6) P = pointed jaw | (9) 2.0 Or any Other Number following the base part number denotes height (B Dimension). |
-
- | | | |
|--|--|--|
| Soft Jaws - Mild Steel or Aluminum | Milling Machine Arbors - 4140 Heat Treat | "VEE" Block - Cast Iron |
| Hard Jaws - Mild Steel Carburized | Outboard Supports - Cast Malleable | Boring Mill - Cast Steel and Carburized Steel |
| Keys - 4140 HT | Full Wrap Jaws
Aluminum
Cast Iron
Custom Made Mild Steel | Tail Stock - Cast Iron |
| Operating Screws - 4140 HT | | Face Plate - Mild Steel |
| Thrust Bearings - Mild Steel Carburized | | Right Angle Drive - Cast Mild Steel |
| Chuck Adapters - Mild Steel | | |

NOTE: All Critical Dimensions are shown in a Blue shaded area in this catalog.

Part Number: H&R's part number describes the **Technical Specifications** of the jaws, Mounting Base and associated accessories. The base number is used for all Serrated Parts.

Examples:	Soft Jaw HR-108-2.5	Hard Jaw HR-108-RJ	Full-Wrap Jaw HR-108-2-AL	Jaw Nut JN-108-A
------------------	-------------------------------	------------------------------	-------------------------------------	----------------------------

Pointing A Jaw: There are 3 different ways to point a jaw:



NOTE: Point by adding a "P" to part number. Be specific on the degree of point. Standard is 30°.

Example: HR-108-2.5-P

Offset Jaws: H&R has accepted and promoted the philosophy that the offset jaw provides more **Dollar-Value** to the ultimate customer by providing more boring options, with a longer jaw that approximated the full range of the chuck face. These jaws come both square and pointed. **Example:** HR-108-2.5-O HR-108-2.5-OP

Hard Jaws: H&R standard hard jaws are made from mild steel and carburized at 56 to 60 RC with a depth of .030 to .040. **MACHINING OF HARD JAWS IS NOT RECOMMENDED.** Once .030 is removed from a jaw, the remaining material will be soft.

"CAUTION" Never Weld on a Hard Jaw

Jaw Nut Engagement: It is important that all bolts are engaged to their fullest length in both Jaw Nuts and T-Nuts.

Warranty: H&R Mfg. and Supply, Inc. will warranty their products for workmanship to meet or exceed specifications listed in this catalog. This warranty is expressly made in lieu of all other warranties, expressed or implied.

OEM steel specifications verse actual material (inch standards verse metric standards)

H&R makes every attempt to match specifications from the OEM. However, standard steel specifications and availability may dictate the height or weight over OEM. In most cases, these minor deviations will not cause any technical problems in applications.

H&R will strive to give our customers the best value for their dollar by using standard available U.S.A. material.

Caution: Jaws made or revised to design specifications different than those listed in this catalog may result in reduced capabilities of the chuck. The Chuck operating manual should be reviewed in these applications.

H&R reserves the right to make changes in design specifications and price without prior notification. Those in place at day of shipment will apply.

For: Bergman, Bison, Buck, Cushman, Huron,
Rohm, Forkhardt, Pratt Burnerd America,
SCA, S.P., W&S, Nobel & Yuasa

*Mild Steel Standard
Aluminum Available*

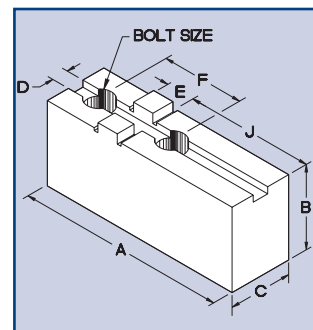
“P” - means Pointed Jaw
“O” - means Tongue is Offset (see “J” dimension)
“***” - means 1/8" Tongue Height
“***” - means 3/16" Tongue Height

Medium Duty Soft Jaws

Chuck Size	Standard Height									Extra Height	
	Part No.	A	B	C	D	E	F	Bolt	J	Part No.	B
5" - 6" **	HR-5MSH	2-3/16	1-3/8	3/4	.313	.500	1.250	5/16	CENTER	HR-5MEH	3-3/8
	HR-6MSH	2-13/16	1-3/8	1	.313	.500	1.50	3/8	CENTER	HR-6MEH	3-3/8
	HR-447	2-5/8	1-5/8	1-1/4	.313	.500	1.50	3/8	1-1/8	HR-471	3-3/8
	HR-6MSH-O	3-1/4	1-3/8	1	.313	.500	1.50	3/8	1-13/16	HR-6MEH-O	3-3/8
	HR-6MSH-OP	3-1/4	1-3/8	1	.313	.500	1.50	3/8	1-13/16	HR-6MEH-OP	3-3/8
	HR-459-P	3-3/16	1-5/8	1-1/4	.313	.500	1.50	3/8	1-11/16	HR-483-P	3-3/8
8" **	HR-8MSH	3-5/16	1-7/8	1-1/4	.313	.500	1.75	3/8	CENTER	HR-8MEH	3-3/8
	HR-450	3-1/2	1-5/8	1-1/4	.313	.500	1.75	3/8	1-5/8	HR-474	3-3/8
	HR-8MSH-O	3-3/4	1-7/8	1-1/4	.313	.500	1.75	3/8	2-3/16	HR-8MEH-O	3-3/8
	HR-8MSH-OP	3-3/4	1-7/8	1-1/4	.313	.500	1.75	3/8	2-3/16	HR-8MEH-OP	3-3/8
	HR-462-P	3-15/16	1-5/8	1-1/4	.313	.500	1.75	3/8	2-1/4	HR-486-P	3-3/8
8" W&S	M-1603-B\2307B1	3-1/2	2-1/8	1-1/4	.313	.500	1.75	1/2	1-13/16	M-1603-L\2307B2	2-7/8
10" **	HR-10MSH	3-15/16	1-7/8	1-1/2	.500	.750	2.12	1/2	CENTER	HR-10MEH	3-3/8
	HR-452	4-1/4	1-7/8	1-1/2	.500	.750	2.12	1/2	1-15/16	HR-476	3-3/8
	HR-10MSH-O	4-5/8	1-7/8	1-1/2	.500	.750	2.12	1/2	2-5/8	HR-10MEH-O	3-3/8
	HR-10MSH-OP	4-5/8	1-7/8	1-1/2	.500	.750	2.12	1/2	2-5/8	HR-10MEH-OP	3-3/8
	HR-464-P	4-13/16	1-7/8	1-1/2	.500	.750	2.12	1/2	2-11/16	HR-488-P	3-3/8
10" W&S	M-1605-B\2309B1	4-1/4	2-3/8	1-3/4	.500	.750	2.12	5/8	2-1/8	M-1605-L\2309B2	3-3/8
12" **	HR-12MSH	4-1/2	2-1/8	1-3/4	.500	.750	2.50	1/2	CENTER	HR-12MEH	3-7/8
	HR-454	4-7/8	2-3/8	1-3/4	.500	.750	2.50	1/2	2-5/16	HR-478	3-7/8
	HR-12MSH-O	5-3/8	2-1/8	1-3/4	.500	.750	2.50	1/2	3-1/8	HR-12MEH-O	3-7/8
	HR-12MSH-OP	5-3/8	2-1/8	1-3/4	.500	.750	2.50	1/2	3-1/8	HR-12MEH-OP	3-7/8
	HR-466-P	5-3/4	2-3/8	1-3/4	.500	.750	2.50	1/2	3-3/8	HR-490-P	3-7/8
12" W&S	M-1607-B\2311B1	4-7/8	2-3/8	1-3/4	.500	.750	2.50	5/8	2-1/2	M-1607-L\2311B2	3-7/8
15" ***	HR-15MSH	5-3/16	2-5/16	1-3/4	.500	.750	3.00	5/8	CENTER	HR-15MEH	3-13/16
	HR-456	5-5/8	2-5/16	2	.500	.750	3.00	5/8	2-3/4	HR-480	3-13/16
	HR-15MSH-O	6-1/4	2-5/16	1-3/4	.500	.750	3.00	5/8	3-5/8	HR-15MEH-O	3-13/16
	HR-15MSH-OP	6-1/4	2-5/16	1-3/4	.500	.750	3.00	5/8	3-5/8	HR-15MEH-OP	3-13/16
	HR-468-P	7-1/4	2-5/16	2	.500	.750	3.00	5/8	4-1/2	HR-495-P	3-13/16
15" W&S	M-1609-B	5-3/4	3-1/4	2	.500	.750	3.00	3/4	3	M-1609-L	4-3/4
18" - 21" ***	HR-18MSH	5-3/16	2-13/16	2-1/4	.500	.750	3.00	3/4	CENTER	HR-18MEH	4-13/16
	HR-457	5-5/8	2-5/16	2	.500	.750	3.00	3/4	2-3/4	HR-481	3-13/16
	HR-18MSH-O	6-3/8	2-13/16	2-1/4	.500	.750	3.00	3/4	3-3/4	HR-18MEH-O	4-13/16
	HR-18MSH-OP	6-3/8	2-13/16	2-1/4	.500	.750	3.00	3/4	3-3/4	HR-18MEH-OP	4-13/16
	HR-519-P	7-1/4	3-5/16	2-1/2	.500	.750	3.00	3/4	4-1/2	HR-520-P	4-13/16
18" W&S	M-1611-B	6	3-1/4	2-1/2	.500	.750	3.00	3/4	3	M-1611-L	4-3/4
24" - 36" ***	HR-458	5-5/8	3-5/16	2-1/2	.500	.750	3.00	3/4	2-3/4	HR-482	4-13/16

SMW-KNCS & FORKHARDT TYPE “WAK”

Chuck Size	“WAK” Soft Jaws								
	Part No.	A	B	C	D	E	F	J	Bolt
5 1/2"	HR-WAK 140	2-3/4	1-3/8	3/4	.315	.706	1.250	1	M8
	HR-WAKB-140	2-1/2	1-3/8	1-1/2	.315	.706	1.250	1	M8
6 1/4"	HR-WAK 160/175	3-3/8	1-3/8	3/4	.315	.706	1.250	1	M8
	HR-WAKB 160/175	2-1/2	1-3/8	1-1/2	.315	.706	1.250	1	M8
8"	HR-WAK 200	4-1/8	1-5/8	7/8	.395	.787	1.575	2	M8
	HR-WAKB 200	2-3/4	1-3/8	1-1/2	.395	.787	1.575	1-1/16	M8
10"	HR-WAK 250/315	5	1-7/8	1-1/4	.472	.787	1.575	2-3/4	M12
	HR-WAKB 250	3-1/2	1-7/8	2-1/4	.472	.787	1.575	1-3/4	M12
	HR-WAKEH 250/315	5	3-3/8	1-1/4	.472	.787	1.575	2-3/4	M12
12"	HR-WAKB 315	3-1/2	1-7/8	3	.472	.787	1.575	1-3/4	M12
	HR-WAK 400	5-3/4	1-7/8	1-1/4	.472	1.022	2.125	2-3/4	M12
16"	HR-WAKB 400	4	2-3/8	3	.472	1.022	2.125	1-3/4	M12
	HR-WAK 500/630	7	2-7/8	1-3/4	.708	1.180	2.362	3	M16
24"	HR-WAKB 500/630	6	2-7/8	4	.708	1.180	2.362	3	M16

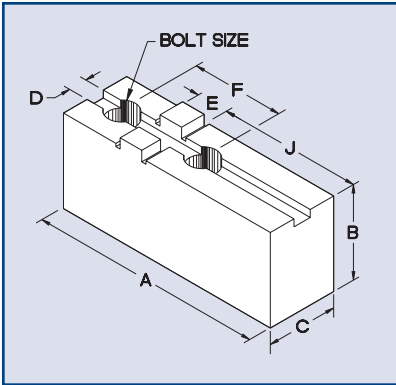


AMERICAN STANDARD TONGUE & GROOVE



**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

For: Bergman, Bison, Buck, Cushman, Huron, Rohm, Forkhardt, Pratt Burnerd America, SCA, SP, W&S, Nobel & Yuasa



**Mild Steel Standard
Aluminum Available**

“P” - means Pointed Jaw
“O” - means Tongue is Offset (see “J” dimension)
“**” - means 1/8" Tongue Height
“***” - means 3/16" Tongue Height

Heavy Duty Soft Jaws											
Chuck Size	Standard Height									Extra Height	
	Part No.	A	B	C	D	E	F	Bolt	J	Part No.	B
6" **	HR-6HSH	2-13/16	1-3/8	1-1/2	.313	.500	1.50	7/16	CENTER	HR-6HEH	3-3/8
	HR-448	2-5/8	1-5/8	1-1/4	.313	.500	1.50	7/16	1-1/8	HR-472	3-3/8
	HR-6HSH-O	3-1/4	1-3/8	1-1/2	.313	.500	1.50	7/16	1-13/16	HR-6HEH-O	3-3/8
	HR-6HSH-OP	3-1/4	1-3/8	1-1/2	.313	.500	1.50	7/16	1-13/16	HR-6HEH-OP	3-3/8
	HR-460-P	3-3/16	1-5/8	1-1/4	.313	.500	1.50	7/16	1-11/16	HR-484-P	3-3/8
8" **	HR-8HSH	3-5/16	1-7/8	1-1/2	.313	.500	1.75	1/2	CENTER	HR-8HEH	3-3/8
	HR-451	3-1/2	1-7/8	1-1/2	.313	.500	1.75	1/2	1-5/8	HR-475	3-3/8
	HR-8HSH-O	3-3/4	1-7/8	1-1/2	.313	.500	1.75	1/2	2-3/16	HR-8HEH-O	3-3/8
	HR-8HSH-OP	3-3/4	1-7/8	1-1/2	.313	.500	1.75	1/2	2-3/16	HR-8HEH-OP	3-3/8
	HR-463-P	3-15/16	1-7/8	1-1/2	.313	.500	1.75	1/2	2-1/4	HR-487-P	3-3/8
10" **	HR-10HSH	3-15/16	1-7/8	1-3/4	.500	.750	2.12	5/8	CENTER	HR-10HEH	3-7/8
	HR-453	4-1/2	2-3/8	1-3/4	.500	.750	2.12	5/8	1-15/16	HR-477	3-7/8
	HR-10HSH-O	4-5/8	1-7/8	1-3/4	.500	.750	2.12	5/8	2-5/8	HR-10HEH-O	3-7/8
	HR-10HSH-OP	4-5/8	1-7/8	1-3/4	.500	.750	2.12	5/8	2-5/8	HR-10HEH-OP	3-7/8
	HR-465-P	4-13/16	2-3/8	1-3/4	.500	.750	2.12	5/8	2-11/16	HR-489-P	3-7/8
12" **	HR-12HSH	4-1/2	2-1/8	2	.500	.750	2.50	5/8	CENTER	HR-12HEH	4-13/16
	HR-455	4-7/8	2-3/8	2	.500	.750	2.50	5/8	2-5/16	HR-479	3-7/8
	HR-12HSH-O	5-3/8	2-1/8	2	.500	.750	2.50	5/8	3-1/8	HR-12HEH-O	4-13/16
	HR-12HSH-OP	5-3/8	2-1/8	2	.500	.750	2.50	5/8	3-1/8	HR-12HEH-OP	4-13/16
	HR-467-P	5-3/4	2-3/8	2	.500	.750	2.50	5/8	3-3/8	HR-491-P	3-7/8
15" - 36" ***	HR-15HSH	5-3/16	2-5/16	2-1/2	.500	.750	3	3/4	CENTER	HR-15HEH	4-13/16
	HR-457	5-5/8	2-5/16	2	.500	.750	3	3/4	2-3/4	HR-481	3-13/16
	HR-15HSH-O	6-1/4	2-5/16	2-1/2	.500	.750	3	3/4	3-5/8	HR-15HEH-O	4-13/16
	HR-15HSH-OP	6-1/4	2-5/16	2-1/2	.500	.750	3	3/4	3-5/8	HR-15HEH-OP	4-13/16
	HR-469-P	7-1/4	2-5/16	2	.500	.750	3	3/4	4-1/2	HR-496-P	3-13/16
18" - 36" ***	HR-18HSH	5-3/16	2-13/16	3	.500	.750	3	3/4	CENTER	HR-18HEH	4-13/16
	HR-458	5-5/8	3-5/16	2-1/2	.500	.750	3	3/4	2-3/4	HR-482	4-13/16
	HR-18HSH-O	6-3/8	2-13/16	3	.500	.750	3	3/4	3-3/4	HR-18HEH-O	4-13/16
	HR-18HSH-OP	6-3/8	2-13/16	3	.500	.750	3	3/4	3-3/4	HR-18HEH-OP	4-13/16
	HR-519-P	7-1/4	3-5/16	2-1/2	.500	.750	3	3/4	4-1/2	HR-520-P	4-13/16
24" - 36" *** NOBEL	HR-28HSH	6-3/8	2-13/16	3	.500	.750	3	7/8	3-3/4	HR-28HEH	4-13/16
	HR-28HSH-O	7-1/2	2-13/16	3	.500	.750	3	7/8	4-1/2	HR-28HEH-O	4-13/16
	HR-28HSH-OP	7-1/2	2-13/16	3	.500	.750	3	7/8	4-1/2	HR-28HEH-OP	4-13/16

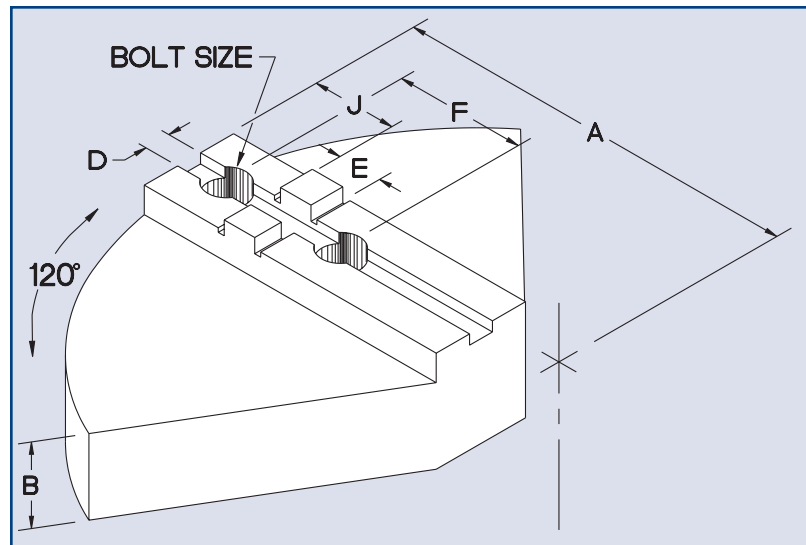
For: Bergman, Bison, Buck, Cushman, Huron, Rohm,
Forkhardt, Pratt Burnerd America, SCA, S.P., W&S,
Nobel & Yuasa

ADD TO PART NUMBER

“AL” - for Aluminum

“CI” - for Cast Iron

“ST” - for Steel



“**” - means 1/8" Tongue Height
“***” - means 3/16" Tongue Height

Chuck Size	Full Wrap Jaws							
	Part No.	A	B	D	E	F	J	Bolt
6" ** Medium	HR-6MSH-2-	3	2	.313	.500	1.500	center	3/8
	HR-6MEH-4-	3	4	.313	.500	1.500	center	3/8
6" ** Heavy	HR-6HSH-2-	3	2	.313	.500	1.500	center	7/16
	HR-6HEH-4-	3	4	.313	.500	1.500	center	7/16
8" ** Medium	HR-8MSH-2-	4	2	.313	.500	1.750	center	3/8
	HR-8MEH-4-	4	4	.313	.500	1.750	center	3/8
8" ** Heavy	HR-8HSH-2-	4	2	.313	.500	1.750	center	1/2
	HR-8HEH-4-	4	4	.313	.500	1.750	center	1/2
10" ** Medium	HR-10MSH-2-	5	2	.500	.750	2.125	1-1/2	1/2
	HR-10MEH-4-	5	4	.500	.750	2.125	1-1/2	1/2
10" ** Heavy	HR-10HSH-2-	5	2	.500	.750	2.125	1-1/2	5/8
	HR-10HEH-4-	5	4	.500	.750	2.125	1-1/2	5/8
12" ** Medium	HR-12MSH-2-	6	2	.500	.750	2.500	2	1/2
	HR-12MEH-4-	6	4	.500	.750	2.500	2	1/2
12" ** Heavy	HR-12HSH-2-	6	2	.500	.750	2.500	2	5/8
	HR-12HEH-4-	6	4	.500	.750	2.500	2	5/8
15" *** Medium	HR-15MSH-2-	7-1/2	2	.500	.750	3.000	2-1/4	5/8
	HR-15MEH-4-	7-1/2	4	.500	.750	3.000	2-1/4	5/8
15" *** Heavy	HR-15HSH-2-	7-1/2	2	.500	.750	3.000	2-1/4	3/4
	HR-15HEH-4-	7-1/2	4	.500	.750	3.000	2-1/4	3/4
18" *** Medium	HR-18MSH-3-	9	3	.500	.750	3.000	3-1/4	3/4
	HR-18MEH-4-	9	4	.500	.750	3.000	3-1/4	3/4
18" *** Heavy	HR-18HSH-3-	9	3	.500	.750	3.000	3-1/4	3/4
	HR-18HEH-4-	9	4	.500	.750	3.000	3-1/4	3/4
21" *** Medium	HR-21MSH-3-	10-1/2	3	.500	.750	3.000	4-1/2	3/4
	HR-21MEH-4-	10-1/2	4	.500	.750	3.000	4-1/2	3/4
24" - 28" *** Heavy	HR-28HSH-3-	12	3	.500	.750	3.000	5-1/4	7/8
	HR-28HEH-4-	12	4	.500	.750	3.000	5-1/4	7/8

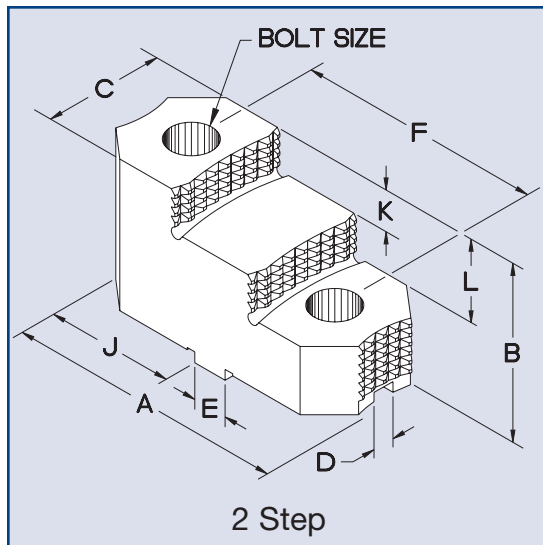
Oversize Full Wraps are available on Standard Bases.
Consult your Chuck Specifications for reduced RPM's.

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Nobel & Yuasa



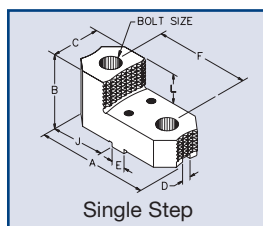
**SPECIAL HARD JAWS
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MADE TO ORDER
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Horizontal Serrations Only

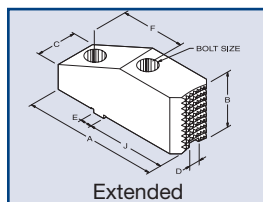
Chuck Size	Medium Duty 2 Step Rev Hard Jaws										
	Part No.	A	B	C	D	E	F	J	K	L	Bolt
6"	HR-6 MTGRJ	2.788	1.969	1-1/2	.313	.500	1.500	1.125	.530	1.060	3/8
	HR-8 MTGRJ	3.286	1.969	1-1/2	.313	.500	1.750	1.375	.530	1.060	3/8
8"	HR-8 STGRJ	3.270	1.625	1	.313	.500	1.750	1.375	.375	.750	3/8
	HR-10 MTGRJ	3.920	2.469	1-3/4	.500	.750	2.125	1.563	.650	1.300	1/2
10"	HR-10 STGRJ	3.750	1.875	1-1/4	.500	.750	2.125	1.563	.500	1.000	1/2
	HR-12 MTGRJ	4.550	2.469	1-3/4	.500	.750	2.500	1.875	.650	1.300	1/2
12"	HR-12 STGRJ	4.375	2.250	1-1/4	.500	.750	2.500	1.875	.625	1.250	1/2
	HR-15 MTGRJ	5.350	3.469	2-1/2	.500	.750	3.000	2.250	.950	1.900	5/8
15" & up	HR-15 STGRJ	5.260	2.750	1-1/2	.500	.750	3.000	2.250	.735	1.469	5/8

Chuck Size	Heavy Duty 2 Step Rev Hard Jaws										
	Part No.	A	B	C	D	E	F	J	K	L	Bolt
8"	HR-8 HTGRJ	3.286	1.969	1-1/2	.313	.500	1.750	1.375	.530	.910	1/2
10"	HR-10 HTGRJ	3.920	2.469	1-3/4	.500	.750	2.125	1.563	.650	1.300	5/8
12"	HR-12 HTGRJ	4.550	2.469	1-3/4	.500	.750	2.500	1.875	.650	1.300	5/8
15" - 24"	HR-15 HTGRJ	5.350	3.469	2-1/2	.500	.750	3.000	2.250	.950	1.900	3/4
15" - 24"	HR-18 STGRJ	5.260	3.469	1-3/4	.500	.750	3.000	2.250	.950	1.900	3/4
24" - 36"	HR-24 HTGRJ	6.942	3.969	3	.500	.750	3.000	3.750	1	2	3/4
24" - 36"	HR-28 HTGRJ	6.942	3.969	3	.500	.750	3.000	3.750	1	2	7/8

Chuck Size	“WAK” 2 Step Rev Hard Jaws										
	Part No.	A	B	C	D	E	F	J	K	L	Bolt
8"	HR-WAK-200-RJ	2.75	1.565	1	.394	.787	1.575	1.004	.395	.790	8MM
10"	HR-WAK-250/315-RJ	3.79	2.250	1.750	.472	.787	1.575	1.813	.550	1.100	12MM
16"	HR-WAK-400-RJ	4.23	2.500	2	.472	1.022	2.125	1.587	.687	1.375	12MM
24"	HR-WAK-500/630-RJ	4.76	3.000	2	.708	1.180	2.362	1.780	.687	1.375	16MM

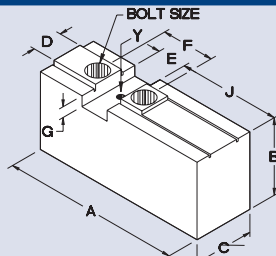


Chuck Size	Heavy Duty Single Step Hard Jaws									
	Part No.	A	B	C	D	E	F	J	L	Bolt
12"	HR-12-HTGRJ-SS	4.550	2.469	2.000	.500	.750	2.50	1.875	1.262	5/8
15" - 24"	HR-15-HTGRJ-SS	5.350	3.469	2.500	.500	.750	3.00	2.250	1.900	3/4
24" - 36"	HR-24-HTGRJ-SS	6.960	3.750	3.000	.500	.750	3.00	3.750	2.000	3/4
24" - 36"	HR-28-HTGRJ-SS	6.960	3.750	3.000	.500	.750	3.00	3.750	2.000	7/8
24"	HR-WAK-500/630-RJ-SS	4.76	3.000	2.000	.708	1.180	2.362	1.780	1.375	16MM



Chuck Size	Heavy Duty Extended Stroke Hard Jaws								
	Part No.	A	B	C	D	E	F	J	Bolt
15" - 24"	HR-15-HTGRJ-EX	6.820	3.469	2-1/2	.500	.750	3.00	3.750	3/4
24" - 36"	HR-28-HTGRJ-EX	6.820	3.469	2-1/2	.500	.750	3.00	3.750	7/8

Extended Stroke means: J=3.860 or 1.50 inch per Jaw Extended.



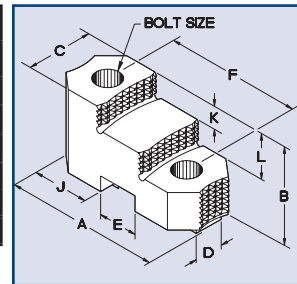
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For: Buck, Cushman, Gisholt, S.P.,
Howa & Pratt Burnerd America

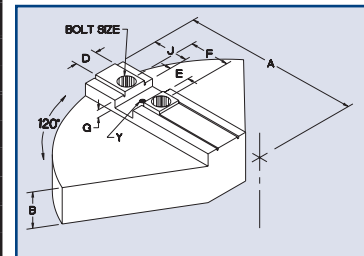
“*” - means GROOVE NOT TONGUE
“**” - means 590 SERIES CHUCK

Chuck Size	Soft Jaws											Extra Height	
	Part No.	A	B	C	D	E	F	G	J	Y	Bolt	Part No.	B
8" *	HR-8-LSH	3-3/4	2	1-1/2	.670	.601	1.250	.375	2-1/8	10-24	1/2		
	P.B.7749-22038	3-3/4	2	1-1/2	.670	.601	1.250	.375	2-1/8	10-24	1/2		
10" ** Howa H07MC-12	HR-10ACSH	4-1/8	2-5/16	1-3/4	.750	1.031	1.750	.375	2-1/8	5/16-18	1/2	HR-10ACEH	3-5/16
	HR-10ACSH-5.5	5-1/2	2-5/16	1-3/4	.750	1.031	1.750	.375	3-1/2	5/16-18	1/2	HR-10ACEH-5.5	3-5/16
12" ** Howa H07MC-15	HR-12ACSH	5-1/8	2-5/16	1-3/4	.875	1.031	2.000	.375	2-7/8	5/16-18	5/8	HR-12ACEH	3-5/16
	HR-12ACSH-5.5	5-1/2	2-5/16	1-3/4	.875	1.031	2.000	.375	3-1/4	5/16-18	5/8	HR-12ACEH-5.5	3-5/16
15" - 18" **	HR-15ACSH	6	3-5/16	2-1/2	1	1.531	2.500	.375	2-5/8	3/8-16	3/4	HR-15ACEH	4-13/16
	HR-15ACSH-7.5	7-1/2	3-5/16	2-1/2	1	1.531	2.500	.375	4-1/4	3/8-16	3/4	HR-15ACEH-7.5	4-13/16
	05-225934	5	2-13/16	2	1	1.531	2.500	.375	2	3/8-16	3/4		
21" & Over	HR-21ACSH	6	3-5/16	3	1.250	1.531	3.000	.375	2-5/8	3/8-16	7/8	HR-21ACEH	4-13/16
	HR-21ACSH-8.0	8	3-5/16	3	1.250	1.531	3.000	.375	4-5/8	3/8-16	7/8	HR-21ACEH-8.0	4-13/16
32" Matsumoto	HR-30M-2.5	7-7/8	2-5/16	2-1/2	.984	1.456	2.562	.413	2-13/16	M10X1.5	22M		
	HR-30M-3.5	7-7/8	3-5/16	2-1/2	.984	1.456	2.562	.413	2-13/16	M10X1.5	22M		
	HR-30M-5.0	7-7/8	4-13/16	2-1/2	.984	1.456	2.562	.413	2 13/16	M10X1.5	22M		

Chuck Size	Reversible Hard Jaws										
	Part No.	A	B	C	D	E	F	J	K	L	Bolt
8"	HR-8-LSH-RJ	3-1/2	1.969	1-1/2	.670	.601	1.250	1.755	.530	1.060	1/2
10"	HR-10-ASRJ	4-1/4	2.469	1-3/4	.750	1.031	1.750	1.705	.600	1.200	1/2
12"	HR-12-ASRJ	4-7/8	2.469	1-3/4	.875	1.031	2.000	2.032	.550	1.100	5/8
15" - 18"	HR-15/18-ASRJ	5-1/2	3.469	2-1/2	1.000	1.531	2.500	2.375	.950	1.900	3/4
	HR-15/18-ASRJ-SS	6	3.500	2-1/2	1.000	1.531	2.500	2.375	1.900	1.900	3/4
21" and over	HR-21/24-ASRJ	6-1/2	3.469	3	1.250	1.531	3.000	2.965	.950	1.900	7/8



Chuck Size	Full Wrap Jaws								
	Part No.	A	B	D	E	F	J	Y	Bolt
8"	HR-8LSH-2-	4	2	.670	.601	1.250	1-3/8	10-24	1/2
	HR-8LEH-4-	4	4	.670	.601	1.250	1-3/8	10-24	1/2
10"	HR-10ACSH-2-	5	2	.750	1.031	1.750	1-1/2	5/16-18	1/2
	HR-10ACEH-4-	5	4	.750	1.031	1.750	1-1/2	5/16-18	1/2
12"	HR-12ACSH-2-	6	2	.875	1.031	2.000	1-3/4	5/16-18	5/8
	HR-12ACEH-4-	6	4	.875	1.031	2.000	1-3/4	5/16-18	5/8
15"	HR-15ACSH-2-	7-1/2	2	1.000	1.531	2.500	2	3/8-16	3/4
	HR-15ACEH-4-	7-1/2	4	1.000	1.531	2.500	2	3/8-16	3/4
18"	HR-18ACSH-3-	9	3	1.000	1.531	2.500	2-1/2	3/8-16	3/4
	HR-18ACEH-4-	9	4	1.000	1.531	2.500	2-1/2	3/8-16	3/4
21"	HR-21ACSH-3-	10-1/2	3	1.250	1.531	3.000	3	3/8-16	7/8
	HR-21ACEH-4-	10-1/2	4	1.250	1.531	3.000	3	3/8-16	7/8
24"	HR-24ACSH-3-	12	3	1.250	1.531	3.000	3-1/2	3/8-16	7/8
	HR-24ACEH-4-	12	4	1.250	1.531	3.000	3-1/2	3/8-16	7/8



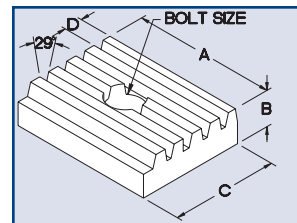
ADD TO PART NUMBER

“AL” - for Aluminum

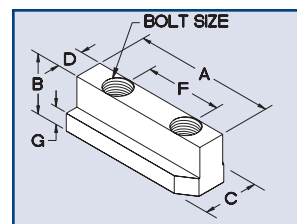
“CI” - for Cast Iron

“ST” - for Steel

Chuck Size	Master Keys					
	Part No.	A	B	C	D	Bolt
8"	8-LAK	1-1/2	.383	.600	.156	#10
10" - 12" (25-10912)	12-AK	1-11/16	.500	1.030	.250	5/16
10" - 12"	12-AKSP	2	.500	1.187	.250	3/8
15" - 18" (25-10907)	15-AK	2-7/16	.500	1.530	.250	3/8
15" - 18"	15-AKSP	2	.500	1.530	.250	3/8
21" - 24" (25-11199)	21-AK	2-7/8	.500	1.530	.250	3/8



Chuck Size	Jaw Nuts							
	Part No.	A	B	C	D	G	F	Bolt
8"	JN-8L	2	1.000	1.030	.668	.440	1-1/4	1/2-13
	JN-8LSH	2	1.000	.937	.670	.437	1-1/4	1/2-13
10" (25-010918)	JN-C10	2-1/2	.640	.940	.678	.381	1-3/4	1/2-13
12" (25-010911)	JN-C12	3	.745	1.060	.802	.440	2	5/8-11
15" - 18" (25-010916)	JN-C15/18	3-1/2	.931	1.250	.933	.550	2-1/2	3/4-10
21" - 24" (25-011200)	JN-C21	4-3/4	1.186	1.555	1.159	.684	3	7/8-9

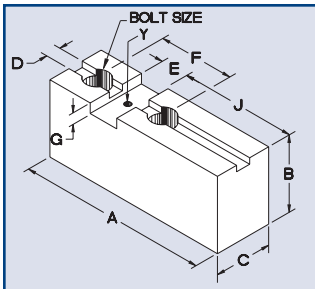


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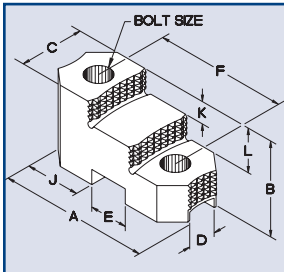


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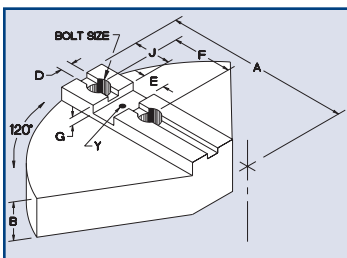
For: Cushman, Logansport, Autoblok, Howa, Buck, S.P., W&S & Pratt Burnerd America



Chuck Size	Soft Jaws											Extra Height	
	Part No.	A	B	C	D	E	F	G	J	Bolt	Y	Part No.	B
6" Manual "Buck"	HR-T-10050	2-3/4	2	1	.74	.37	1.680	.200	1-3/16	5/16	N/A		
7 1/2" Manual "Buck"	HR-T-10105	3-3/16	2	1-1/4	.86	.37	1.680	.200	1-3/8	5/16	N/A		
8"	HR-8-SQSH	3	2	1-1/4	.500	.745	1.437	.275	1-1/4	3/8	1/4-20		
10" - 12"	HR-12-SQSH	4-3/8	2-1/2	1-3/4	.750	.994	1.750	.375	2	1/2	5/16-18	HR-12-SQEH	3-1/2
	HR-12-SQSH-0	5	2-1/2	1-3/4	.750	.994	1.750	.375	3	1/2	5/16-18	HR-12-SQEH-0	3-1/2
10" - 12"	HR-12-SQSHS	4-3/8	2-1/2	1-3/4	.750	.994	1.750	.375	2	5/8	5/16-18	HR-12-SQEH	3-1/2
	HR-12-SQSHS-0	5	2-1/2	1-3/4	.750	.994	1.750	.375	3	5/8	5/16-18	HR-12-SQEH-0	3-1/2
15" - 18" **	HR-15-SQSH	5	3	2-1/4	1.000	1.488	2.500	.375	1-3/4	3/4	3/8-16	HR-15-SQEH	5
	HR-15-SQSH-0	6-1/4	3	2-1/4	1.000	1.488	2.500	.375	3-1/2	3/4	3/8-16	HR-15-SQEH-0	5
21" & Over	HR-21-SQSH	6	3	2-1/4	1.000	1.488	3.000	.375	2-3/4	3/4	3/8-16	HR-21-SQEH	5

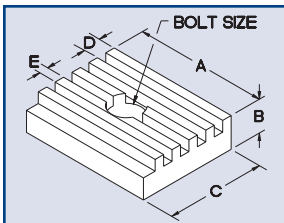


Chuck Size	Reversible Hard Jaws										
	Part No.	A	B	C	D	E	F	J	K	L	Bolt
12"	HR-12-SQRJ	4-7/8	2.469	1-3/4	.750	.994	1.750	2.437	.650	1.300	1/2
12" A	HR-12A-SQRJ	4-7/8	2.469	1-3/4	.750	.994	1.750	2.437	.650	1.300	5/8
15" - 18"	HR-15/18-SQRJ	5-1/2	3.469	2-1/2	1.000	1.488	2.500	2.535	.950	1.900	3/4
21"	HR-21-SQRJ	5-1/2	3.469	2-1/2	1.000	1.488	3.000	1-5/8	.950	1.900	3/4
21" A	HR-21A-SQRJ	5-1/2	3.469	2-1/2	1.000	1.488	3.000	1-5/8	.950	1.900	7/8

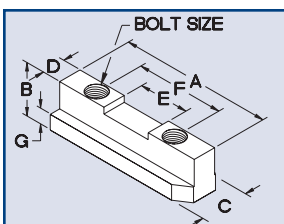


ADD TO PART NUMBER
 "AL" - for Aluminum
 "CI" - for Cast Iron
 "ST" - for Steel

Chuck Size	Full Wrap Jaws								
	Part No.	A	B	D	E	F	J	Y	Bolt
8"	HR-8-SQSH-2-	4	2	.500	.745	1.437	1-1/4	1/4-20	3/8
	HR-8-SQEH-4-	4	4	.500	.745	1.437	1-1/4	1/4-20	3/8
10"	HR-10-SQSH-2-	5	2	.750	.994	1.750	1-1/4	5/16-18	1/2
	HR-10-SQEH-4-	5	4	.750	.994	1.750	1-1/4	5/16-18	1/2
12"	HR-12-SQSH-2-	6	2	.750	.994	1.750	1-1/2	5/16-18	1/2
	HR-12-SQEH-4-	6	4	.750	.994	1.750	1-1/2	5/16-18	1/2
15"	HR-15-SQSH-2-	7-1/2	2	1.000	1.488	2.500	1-3/4	3/8-16	3/4
	HR-15-SQEH-4-	7-1/2	4	1.000	1.488	2.500	1-3/4	3/8-16	3/4
18"	HR-18-SQSH-3-	9	3	1.000	1.488	2.500	2	3/8-16	3/4
	HR-18-SQEH-4-	9	4	1.000	1.488	2.500	2	3/8-16	3/4
21"	HR-21-SQSH-3-	10-1/2	3	1.000	1.488	3.000	2-1/2	3/8-16	3/4
	HR-21-SQEH-4-	10-1/2	4	1.000	1.488	3.000	2-1/2	3/8-16	3/4



Chuck Size	Master Keys						
	Part No.	A	B	C	D	E	Bolt
8" SP	8-CC-310-A	1.446	.440	.745	.156	.076	1/4
8"	8-SQK	1-5/16	3/8	.745	.200	.098	1/4
12"	12-SQK	1-11/16	1/2	.993	.250	.124	5/16
15"	15-SQK	2	1/2	1.487	.250	.124	3/8
18"	18-SQK	2-1/4	1/2	1.487	.250	.124	3/8
21"	21-SQK	2-1/2	1/2	1.487	.250	.124	3/8
	21-SQ-SP	2-1/2	1/2	1.530	.250	.120	3/8



Chuck Size	Jaw Nuts								
	Part No.	A	B	C	D	E	F	G	Bolt
8" WC	JN-WC8	2-1/8	.996	.993	.748	7/8	1-7/16	3/8	1/2-13
8"	JN-SP-8	2-1/8	.996	.875	.498	7/8	1-7/16	3/8	3/8-16
10" - 12"	JN-SP-10/12	2-7/16	1	1.000	.748	1-1/16	1-3/4	3/8	1/2-13
12" CC	JN-SP-12CC	2-1/2	1	1.000	.748	1-1/16	1-3/4	3/8	5/8-11
15" - 18"	JN-SP-15/18	3-3/4	1-1/4	1.250	1.000	1-9/16	2-1/2	7/16	3/4-10
21" - 24"	JN-SP-21/24	4-1/2	1-1/4	1.250	1.000	1-9/16	3	7/16	3/4-10

Square Ends

H&R Part No.	Head Length			Handle Dia-Length
HR-1/4SQ	3-1/2	7	~	1/2 - 7
HR-5/16SQ	4	8	~	1/2 - 7
HR-3/8SQ	4	8	~	1/2 - 7
HR-400SQ	4	8	~	1/2 - 10
HR-7/16SQ	4	8	~	1/2 - 12
HR-1/2SQ	5	7-1/2	10	3/4 - 18
HR-9/16SQ	5	7-1/2	10	3/4 - 18
HR-5/8SQ	5	7-1/2	10	3/4 - 18
HR-11/16SQ	5	7-1/2	10	3/4 - 18
HR-3/4SQ	5	7-1/2	10	1 - 24
HR-7/8SQ	5	7-1/2	10	1 - 24
HR-1SQ	5	7-1/2	10	1 - 24

Metric Square Ends

H&R Part No.	Head Length	Handle Dia-Length
HR-14MMSQ	7-1/2	3/4 - 18
HR-15MMSQ	9	3/4 - 18
HR-16MMSQ	10	3/4 - 18
HR-17MMSQ	6, 7-1/2, 10	3/4 - 18
HR-19MMSQ	6, 11-1/2	3/4 - 18
HR-22MMSQ	6, 12-1/2	1 - 24

Double Ends Square

H&R Part No.	Head Length	Handle Dia-Length
HR-1/2DES	6	3/4 - 18
HR-9/16DES	6	3/4 - 18
HR-5/8DES	6	3/4 - 18
HR-11/16DES	6	3/4 - 18
HR-3/4DES	6	1 - 24
HR-7/8DES	6	1 - 24
HR-1DES	6-1/2	1 - 24

Hex End

H&R Part No.	Head Length		Handle Dia-Length
HR-1/2HEX	5	10	3/4 - 18
HR-9/16HEX	5	10	3/4 - 18
HR-5/8HEX	5	10	3/4 - 18
HR-11/16HEX	5	10	3/4 - 18
HR-3/4HEX	5	10	3/4 - 18
HR-7/8HEX	5	10	1 - 24
HR-1HEX	5	10	1 - 24

Internal Square

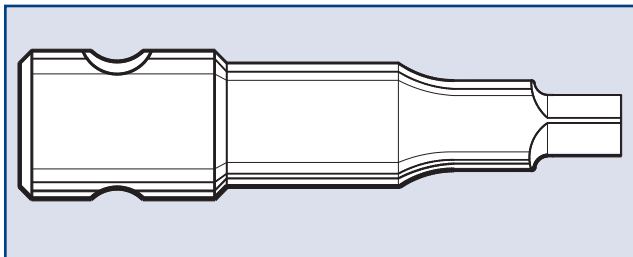
H&R Part No.	Head Length	Handle Dia-Length
HR-3/4INTSQ	6	3/4 - 18
HR-7/8INTSQ	6	1 - 24
HR-1INTSQ	6	1 - 24

O.S.H.A. Safety Springs Available on Request

SPECIAL CHUCK WRENCHES made to Order

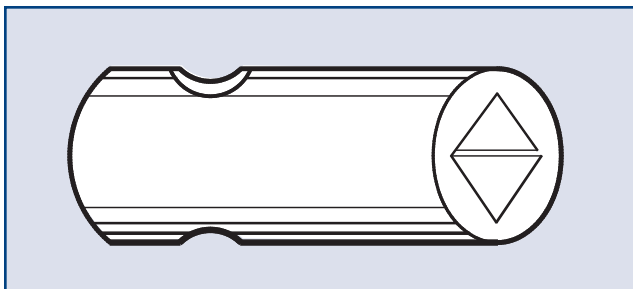
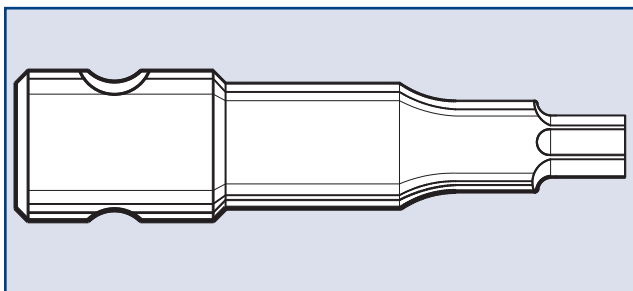
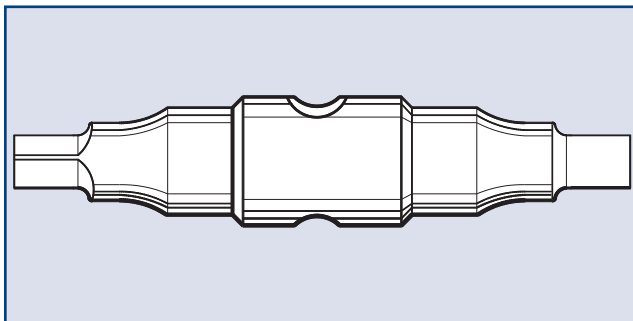
All Chuck Wrenches Made of 4140 Heat Treat Material

Other Sizes Available on Request



WARRANTY IS VOID if handle extension, (Cheater Pipe) is used or has been used with wrenches and/or any modification made to wrench.

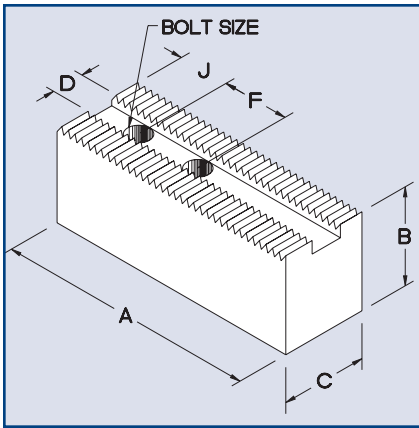
Handle lengths are designed for MAXIMUM twisting load.



1.5MM (0.0591) @ 60° SERRATED



**ALL PRODUCTS
PROUDLY MADE
IN THE USA**



For: Kitagawa, Matsumoto, Howa & Seike, Samchully, Strong

*3 holes are available –
Call for pricing*

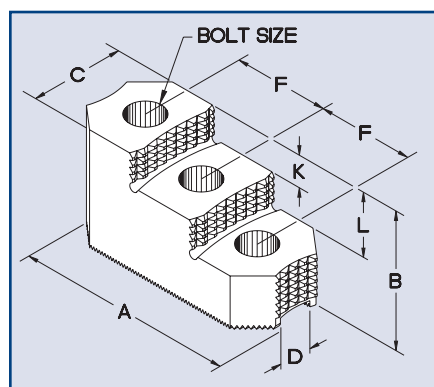
*Mild Steel Standard
Aluminum Available*

Chuck Size	Soft Jaws								Extra Length/Pointed			
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
4" Kitagawa	HR-4K-1.0-P	2	1	1	.316	.375	.600	5MM				
	HR-138-1.0-P	2-5/16	1	1	.395	.313	.750	8MM				
5" Howa Solid	HR-138-1.5-P	2-5/16	1-1/2	1	.395	.313	.750	8MM				
	5" Kitagawa	HR-135-1.5-P	2-5/16	1-1/2	1	.395	.313	.708	8MM			
6" Nikko 6" Matsumoto	HR-6B-1.5-P	3-1/8	1-1/2	1	.433	.438	.969	8MM				
	HR-6B-2.0-P	3-1/8	2	1	.433	.438	.969	8MM				
	HR-6B-3.0-P	3-1/8	3	1	.433	.438	.969	8MM				
6" Kitagawa 6" Howa-HO27M6	HR-6K-1.5-P	3-1/8	1-1/2	1-1/4	.472	.438	.787	10MM				
	HR-6K-2.0-P	3-1/8	2	1-1/4	.472	.438	.787	10MM				
	HR-6K-3.0-P	3-1/8	3	1-1/4	.472	.438	.787	10MM				
Howa HO12MB (3 HLS)	HR-146-2.5-P	3-1/2	2-1/2	1-1/2	.827	.500	.984	12MM				
8" Kitagawa B-08 B-208 Kitagawa 8" Matsumoto 8" Howa Hollow	HR-149-1.5	3-1/2	1-1/2	1-1/2	.551	.781	.984	12MM	HR-149-1.5-0	4-1/4	HR-149-1.5-OP	4-1/4
	HR-149-2.0	3-1/2	2	1-1/2	.551	.781	.984	12MM	HR-149-2.0-0	4 1/4	HR-149-2.0-OP	4 1/4
	HR-149-2.5	3-1/2	2-1/2	1-1/2	.551	.781	.984	12MM	HR-149-2.5-0	4-1/4	HR-149-2.5-OP	4-1/4
	HR-149-3.5	3-1/2	3-1/2	1-1/2	.551	.781	.984	12MM	HR-149-3.5-0	4-1/4	HR-149-3.5-OP	4-1/4
	HR-149-5.0	3-1/2	5	1-1/2	.551	.781	.984	12MM	HR-149-5.0-0	4-1/4	HR-149-5.0-OP	4-1/4
8" Howa HO7MA-8	HR-80-1.5	4	1-1/2	1-1/2	.551	.945	1.181	10MM				
	HR-80-2.5	4	2-1/2	1-1/2	.551	.945	1.181	10MM				
10" Howa Solid HO27-M8 HO7MA-10	HR-81-1.5	4	1-1/2	1-1/2	.630	.650	.984	12MM	HR-81-1.5-0	5	HR-81-1.5-OP	5
	HR-81-2.5	4	2-1/2	1-1/2	.630	.650	.984	12MM	HR-81-2.5-0	5	HR-81-2.5-OP	5
	HR-81-3.5	4	3-1/2	1-1/2	.630	.650	.984	12MM	HR-81-3.5-0	5	HR-81-3.5-OP	5
B-10 Kitagawa B-210 Kitagawa 11" Matsumoto Hollow	HR-82-2.0	4	2	1-3/4	.630	.650	1.181	12MM	HR-82-2.0-0	5	HR-82-2.0-OP	5
	HR-82-2.5	4	2-1/2	1-3/4	.630	.650	1.181	12MM	HR-82-2.5-0	5	HR-82-2.5-OP	5
	HR-82-3.5	4	3-1/2	1-3/4	.630	.650	1.181	12MM	HR-82-3.5-0	5	HR-82-3.5-OP	5
	HR-82-5.0	4	5	1-3/4	.630	.650	1.181	12MM	HR-82-5.0-0	5	HR-82-5.0-OP	5
10" Seike	HR-85-2.0	4	2	1-1/2	.630	.650	1.266	12MM	HR-85-2.0-0	5	HR-85-2.0-OP	5
	HR-85-4.0	4	4	1-1/2	.630	.650	1.266	12MM	HR-85-4.0-0	5	HR-85-4.0-OP	5
10" Howa HO12MA-10	HR-87-1.75	4	1-3/4	1-3/4	.827	.625	1.181	16MM	HR-87-1.75-0	5	HR-87-1.75-OP	5
10" Howa Hollow <i>See HR-157 for 3MM</i>	HR-95-2.5	4-13/16	2-1/2	1-3/4	.827	1.181	1.578	20MM				
	HR-95-3.5	4-13/16	3-1/2	1-3/4	.827	1.181	1.578	20MM				
	HR-95-5.0	4-13/16	5	1-3/4	.827	1.181	1.578	20MM				
B-12 Kitagawa 12" Matsumoto 12" Howa-HO27MA12 Howa HO27-M10	HR-108-2.0	5-1/4	2	2	.710	1.188	1.181	14MM	HR-108-2.0-0	6-1/4	HR-108-2.0-OP	6-1/4
	HR-108-2.5	5-1/4	2 1/2	2	.710	1.188	1.181	14MM	HR-108-2.5-0	6-1/4	HR-108-2.5-OP	6-1/4
	HR-108-3.5	5-1/4	3 1/2	2	.710	1.188	1.181	14MM	HR-108-3.5-0	6-1/4	HR-108-3.5-OP	6-1/4
	HR-108-5.0	5-1/4	5	2	.710	1.188	1.181	14MM	HR-108-5.0-0	6-1/4	HR-108-5.0-OP	6-1/4
B-212 Kitagawa	HR-112-2.0	5-1/4	2	2	.827	1.188	1.181	16MM	HR-112-2.0-0	6-1/4	HR-112-2.0-OP	6-1/4
	HR-112-2.5	5-1/4	2-1/2	2	.827	1.188	1.181	16MM	HR-112-2.5-0	6-1/4	HR-112-2.5-OP	6-1/4
	HR-112-3.5	5-1/4	3-1/2	2	.827	1.188	1.181	16MM	HR-112-3.5-0	6-1/4	HR-112-3.5-OP	6-1/4
	HR-112-5.0	5-1/4	5	2	.827	1.188	1.181	16MM	HR-112-5.0-0	6-1/4	HR-112-5.0-OP	6-1/4
12" Howa-HO27M12	HR-147-2.5	5	2-1/2	2	.827	1.190	1.375	16MM	HR-147-2.5-0	6	HR-147-2.5-OP	6
	HR-147-3.5	5	3-1/2	2	.827	1.190	1.375	16MM	HR-147-3.5-0	6	HR-147-3.5-OP	6
New 12" Howa	HR-150-2.5	5-5/16	2-1/2	2-1/2	1.022	1.190	1.969	22MM	HR-150-2.5-0	6-5/16	HR-150-2.5-OP	6-5/16
	HR-150-3.5	5-5/16	3-1/2	2-1/2	1.022	1.190	1.969	22MM	HR-150-3.5-0	6-5/16	HR-150-3.5-OP	6-5/16
B-15 Kitagawa B-18 (New)	HR-155-2.5	6-1/2	2-1/2	2-1/2	.866	1.400	1.690	20MM	HR-155-2.5-0	7-1/2	HR-155-2.5-OP	7-1/2
	HR-155-3.5	6-1/2	3-1/2	2-1/2	.866	1.400	1.690	20MM	HR-155-3.5-0	7-1/2	HR-155-3.5-OP	7-1/2
	HR-155-5.0	6-1/2	5	2-1/2	.866	1.400	1.690	20MM	HR-155-5.0-0	7-1/2	HR-155-5.0-OP	7-1/2
B-215 Kitagawa BB-218	HR-115-2.5	6-1/2	2-1/2	2-1/2	1.000	1.400	1.690	20MM	HR-115-2.5-0	7-1/2	HR-115-2.5-OP	7-1/2
	HR-115-3.5	6-1/2	3-1/2	2-1/2	1.000	1.400	1.690	20MM	HR-115-3.5-0	7-1/2	HR-115-3.5-OP	7-1/2
	HR-115-5.0	6-1/2	5	2-1/2	1.000	1.400	1.690	20MM	HR-115-5.0-0	7-1/2	HR-115-5.0-OP	7-1/2

For: Kitagawa, Matsumoto, Howa & Seike, Samchully, Strong

Double Step Reversible Hard Jaws

Chuck Size	Kitagawa	Matsumoto								
	Part No.	Part No.	A	B	C	D	F	K	L	Bolt
6"	HR-6K-RJ		3	1.969	1-1/4	.472	.787	.500	1.000	10MM
6"		HR-6B-RJ	3	1.969	1-1/4	.433	.969	.500	1.000	8MM
8"	HR-149-RJ	HR-149-RJ	3-1/2	1.969	1-1/2	.551	.984	.575	1.030	12MM
	HR-81-RJ	HR-81-RJ	4-1/4	2.500	1-3/4	.630	.984	.650	1.300	12MM
10"	HR-82-RJ	HR-82-RJ	4-1/4	2.469	1-3/4	.630	1.181	.650	1.300	12MM
11"		HR-82-RJ	4-1/4	2.469	1-3/4	.630	1.181	.650	1.300	12MM
12" (B-12)	HR-108-RJ	HR-108-RJ	4-7/8	2.469	2	.710	1.181	.650	1.300	14MM
12" (B-212)	HR-112-RJ		4-7/8	2.469	2	.827	1.181	.650	1.300	16MM
12" Howa HO27M12		HR-147-RJ	4-7/8	2.500	1-3/4	.827	1.375	.650	1.300	16MM
15" (B-15)	HR-155-RJ		5 1/2	3.469	2-1/2	.866	1.690	.950	1.900	20MM
15" (B-215)	HR-115-RJ		5-1/2	3.469	2-1/2	1.004	1.690	.950	1.900	20MM



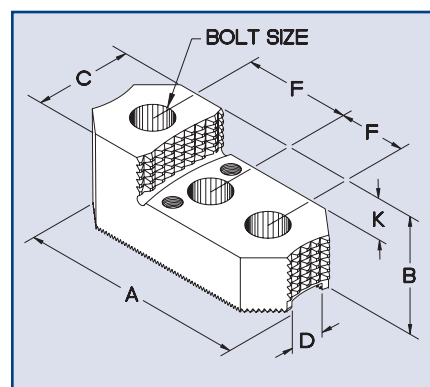
SPECIAL HARD JAWS

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QUICK CHANGE
JAW SYSTEMS

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Single Step Reversible Hard Jaws

Chuck Size	Kitagawa	Matsumoto							
	Part No.	Part No.	A	B	C	D	F	K	Bolt
6"		HR-6B-RJ-SS	3	1.969	1-1/4	.433	.969	1.000	8MM
6"	HR-6K-RJ-SS		3	1.969	1-1/4	.472	.787	1.000	10MM
8"	HR-149-RJ-SS	HR-149-RJ-SS	3-1/2	1.969	1-1/2	.551	.984	1.030	12MM
10"	HR-82-RJ-SS	HR-82-RJ-SS	4-1/4	2.469	1-3/4	.630	1.181	1.250	12MM
11"		HR-82-RJ-SS	4-1/4	2.469	1-3/4	.630	1.181	1.250	12MM
12" (B-12)	HR-108-RJ-SS	HR-108-RJ-SS	4-7/8	2.469	2	.710	1.181	1.300	14MM
12" (B-212)	HR-112-RJ-SS		4-7/8	2.469	2	.827	1.181	1.300	16MM
15" (B-15)	HR-155-RJ-SS		5-1/2	3.469	2-1/2	.866	1.690	1.900	20MM
15" (B-215)	HR-115-RJ-SS		5-1/2	3.469	2-1/2	1.004	1.690	1.900	20MM

Autoblok Chuck Series ALM-BHM-BBM

Chuck Size	Soft Jaws								Extra Length/Pointed			
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
165 AND/ALM/BHM 165/175(6.5) Autoblok 175 BBM	AB-M175-1.5	2-3/4	1-1/2	1-1/4	.472	.63	.787	10MM	AB-M175-1.5-0	3-1/2	AB-M175-1.5-OP	3-1/2
	AB-M175-2.0	2-3/4	2	1-1/4	.472	.63	.787	10MM	AB-M175-2.0-0	3-1/2	AB-M175-2.0-OP	3-1/2
	AB-M175-3.0	2-3/4	3	1-1/4	.472	.63	.787	10MM	AB-M175-3.0-0	3-1/2	AB-M175-3.0-OP	3-1/2
210 ANM/ALM 210(8.3) Autoblok Bhm/rcm/bbm	AB-M210-1.5	3-1/2	1-1/2	1-1/2	.669	.79	.906	12MM	AB-M210-1.5-0	4-1/4	AB-M210-1.5-OP	4-1/4
	AB-M210-2.0	3-1/2	2	1-1/2	.669	.79	.906	12MM	AB-M210-2.0-0	4-1/4	AB-M210-2.0-OP	4-1/4
	AB-M210-3.5	3-1/2	3-1/2	1-1/2	.669	.79	.906	12MM	AB-M210-3.5-0	4-1/4	AB-M210-3.5-OP	4-1/4
305 RCM 315(12.5) Autoblok 315 ANM/BHM/GHM	AB-M315-2.5	5	2-1/2	2	.827	.87	1.180	16MM	AB-M315-2.5-0	6	AB-M315-2.5-OP	6
	AB-M315-3.5	5	3-1/2	2	.827	.87	1.180	16MM	AB-M315-3.5-0	6	AB-M315-3.5-OP	6
	AB-M315-5.0	5	5	2	.827	.87	1.180	16MM	AB-M315-5.0-0	6	AB-M315-5.0-OP	6
400(16) Autoblok 400ANM	AB-M400-2.5	5-1/2	2-1/2	2-1/2	1.003	1.062	1.496	20MM	AB-M400-2.5-0	6-1/2	AB-M400-2.5-OP	6-1/2
	AB-M400-3.5	5-1/2	3-1/2	2-1/2	1.003	1.062	1.496	20MM	AB-M400-3.5-0	6-1/2	AB-M400-3.5-OP	6-1/2
	AB-M400-5.0	5-1/2	5	2-1/2	1.003	1.062	1.496	20MM	AB-M400-5.0-0	6-1/2	AB-M400-5.0-OP	6-1/2

1.5MM (0.0591) @ 60° SERRATED

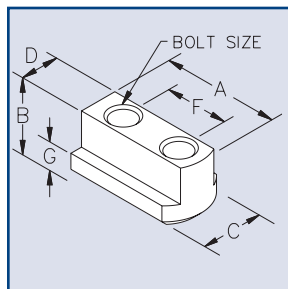
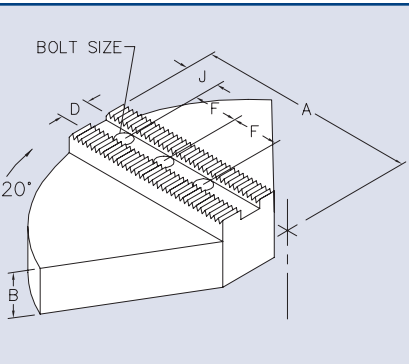


**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

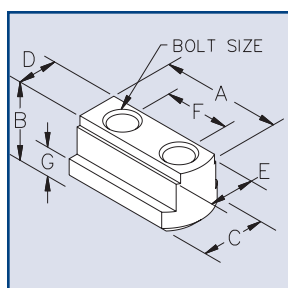
For: Kitagawa, Nikko,
Matsumoto, Howa & Seike,
SamChuly & Strong

ADD TO PART NUMBER

“AL” - for Aluminum
“CI” - for Cast Iron
“ST” - for Steel



Double Step Jaw Nut



Chuck Size	Full Wrap Jaws							
	Part No.	A	B	D	J	F	Holes	Bolt
6"	HR-6B-2-	3	2	.433	.750	.969	2	8MM
	HR-6B-4-	3	4	.433	.750	.969	2	8MM
	HR-6K-2-	3	2	.475	.750	.787	2	10MM
	HR-6K-4-	3	4	.475	.750	.787	2	10MM
8"	HR-149-2-	4	2	.551	.781	.984	2	12MM
	HR-149-4-	4	4	.551	.781	.984	2	12MM
10"	HR-82-2-	5	2	.630	.750	1.181	2	12MM
	HR-82-4-	5	4	.630	.750	1.181	2	12MM
12"	HR-108-2-	6	2	.710	1.000	1.181	2	14MM
	HR-108-4-	6	4	.710	1.000	1.181	2	14MM
	HR-112-2-	6	2	.827	1.000	1.181	2	16MM
	HR-112-4-	6	4	.827	1.000	1.181	2	16MM
15"	HR-155-2-	7-1/2	2	.866	1.400	1.690	2	20MM
	HR-155-4-	7-1/2	4	.866	1.400	1.690	2	20MM
	HR-115-2-	7-1/2	2	1.004	1.400	1.690	2	20MM
	HR-115-4-	7-1/2	4	1.004	1.400	1.690	2	20MM

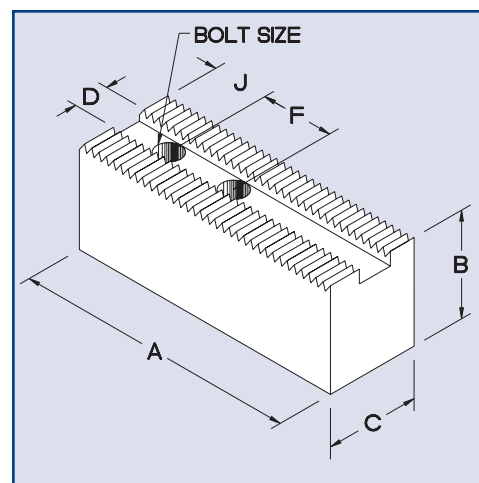
Chuck Size	Jaw Nuts							
	Part No.	A	B	C	D	F	G	Bolt
5" Kitagawa	JN-135-A	1-3/16	.612	.550	.394	.708	.215	5/16-18
6" Matsumoto	JN-6B-M	1-7/16	.885	.689	.430	.969	.295	8MM
	JN-6B-A							5/16-18
B-6" Kitagawa Howa-HO15M-6	JN-6K-M	1-7/16	.885	.689	.471	.786	.295	10MM
	JN-6K-A							3/8-16
6" Kitagawa B-206	JN-206-M	1-7/16	.728	.690	.472	.787	.295	10MM
8" Kitagawa 8" Matsumoto Howa HO7MA-8 Howa HO15-8	JN-149-M	1-7/8	.970	.807	.549	.984	.340	12MM
	JN-149-A							1/2-13
8" Kitagawa B-208	JN-208-M	1-7/8	.810	.807	.549	.984	.340	12MM
	JN-208-A							1/2-13
10" Howa HO7MA-10/HO27M-8	JN-81-M	2	1.000	.910	.628	.984	.374	12MM
	JN-81-A							1/2-13
10" Kitagawa B-10 11" Matsumoto Howa HO1MA-10 B-10	JN-82-M	2	1.000	.910	.628	1.181	.340	12MM
	JN-82-A							1/2-13
10" Kitagawa B-210	JN-210-M	2	.850	.885	.628	1.181	.340	12MM
	JN-210-A							1/2-13
10" Howa Hollow HO7MA-15	JN-95-M	2-1/2	1.141	1.000	.825	1.578	.413	20MM
	JN-95-A							3/4-10
HO27M-12	JN-147-A	2-1/2	1.141	1.000	.825	1.378	.413	5/8-11
12" Kitagawa B-12 12" Matsumoto 10" Howa HO1MA-12 HO7MA-12	JN-108-M	2-1/4	1.250	1.040	.708	1.181	.530	14MM
	JN-108-A							9/16-12
12" Kitagawa B-212	JN-112-M	2-3/16	1.095	1.160	.826	1.181	.455	16MM
	JN-112-A							5/8-11
15" Kitagawa B-15	JN-155-M	3-1/4	1.750	1.320	.864	1.690	.625	20MM
	JN-155-A							3/4-10
15" Kitagawa B-215	JN-115-M	3-5/32	1.545	1.375	.998	1.693	.742	20MM
	JN-115-A							3/4-10

Chuck Size	Double Step Jaw Nuts								
	Part No.	A	B	C	D	E	F	G	Bolt
B-12 to B-212	JN-220-A	2.188	1.120	1.159	.708	.826	1.181	.454	9/16-12
	JN-220-M								14MM
B-15	JN-B15-A	3.150	1.772	1.315	.866	.944	1.693	.630	3/4-10
	JN-B15-M								20MM

For: Kitagawa, Matsumoto, Howa, Pratt Burnerd America & Seike

“P” - means Pointed Jaw
“O” - means Offset Jaw
“OP” - means Offset Pointed Jaw

*3 holes are available –
Call for pricing*



Chuck Size	Soft Jaws								Extra Length/Pointed			
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
8"	HR-83-2.5	4	2-1/2	1-1/2	.551	1	1	12MM				
	HR-83-3.5	4	3-1/2	1-1/2	.551	1	1	12MM				
10" - 12" Howa Solid	HR-113-1.5	4	1-1/2	1-1/2	.630	.650	1.181	12MM	HR-113-1.5-O	5	HR-113-1.5-OP	5
	HR-113-2.5	4	2-1/2	1-1/2	.630	.650	1.181	12MM	HR-113-2.5-O	5	HR-113-2.5-OP	5
	HR-113-3.5	4	3-1/2	1-1/2	.630	.650	1.181	12MM	HR-113-3.5-O	5	HR-113-3.5-OP	5
10" - 12"	HR-123-2.5	4-3/4	2-1/2	1-1/2	.591	1.250	1.181	12MM	HR-123-2.5-O	5-1/2	HR-123-2.5-OP	5-1/2
	HR-123-3.5	4-3/4	3-1/2	1-1/2	.591	1.250	1.181	12MM	HR-123-3.5-O	5-1/2	HR-123-3.5-OP	5-1/2
12" - 14" Howa Solid	HR-143-2.5	5-1/4	2-1/2	2	.710	1.188	1.181	14MM	HR-143-2.5-O	6-1/4	HR-143-2.5-OP	6-1/4
	HR-143-3.5	5-1/4	3-1/2	2	.710	1.188	1.181	14MM	HR-143-3.5-O	6-1/4	HR-143-3.5-OP	6-1/4
	HR-143-5.0	5-1/4	5	2	.710	1.188	1.181	14MM	HR-143-5.0-O	6-1/4	HR-143-5.0-OP	6-1/4
15" - 18" Matsumoto	HR-153-2.5	6	2-1/2	2-1/2	.866	1.250	1.968	20MM	HR-153-2.5-O	7	HR-153-2.5-OP	7
	HR-153-3.5	6	3-1/2	2-1/2	.866	1.250	1.968	20MM	HR-153-3.5-O	7	HR-153-3.5-OP	7
	HR-153-5.0	6	5	2-1/2	.866	1.250	1.968	20MM	HR-153-5.0-O	7	HR-153-5.0-OP	7
15" Howa H07MA-15	HR-157-2.5	5-1/4	2-1/2	2	.827	1.188	1.578	16MM	HR-157-2.5-O	6-1/4	HR-157-2.5-OP	6-1/4
	HR-157-3.5	5-1/4	3-1/2	2	.827	1.188	1.578	16MM	HR-157-3.5-O	6-1/4	HR-157-3.5-OP	6-1/4
	HR-157-5.0	5-1/4	5	2	.827	1.188	1.578	16MM	HR-157-5.0-O	6-1/4	HR-157-5.0-OP	6-1/4
18" - 20" Howa H01MA-15	HR-183-2.5	6-1/4	2-1/2	2-1/2	1.022	1.500	1.968	20MM	HR-183-2.5-O	7-1/2	HR-183-2.5-OP	7-1/2
	HR-183-3.5	6-1/4	3-1/2	2-1/2	1.022	1.500	1.968	20MM	HR-183-3.5-O	7-1/2	HR-183-3.5-OP	7-1/2
	HR-183-5.0	6-1/4	5	2-1/2	1.022	1.500	1.968	20MM	HR-183-5.0-O	7-1/2	HR-183-5.0-OP	7-1/2
18" Kitagawa	HR-203-2.5	7	2-1/2	2-1/2	.984	1.550	1.907	20MM	HR-203-2.5-O	8	HR-203-2.5-OP	8
	HR-203-3.5	7	3-1/2	2-1/2	.984	1.550	1.907	20MM	HR-203-3.5-O	8	HR-203-3.5-OP	8
	HR-203-5.0	7	5	2-1/2	.984	1.550	1.907	20MM	HR-203-5.0-O	8	HR-203-5.0-OP	8
21" Kitagawa	HR-213-2.5	7	2-1/2	2-1/2	.984	1.550	2.362	20MM	HR-213-2.5-O	8-1/2	HR-213-2.5-OP	8-1/2
	HR-213-3.5	7	3-1/2	2-1/2	.984	1.550	2.362	20MM	HR-213-3.5-O	8-1/2	HR-213-3.5-OP	8-1/2
	HR-213-5.0	7	5	2-1/2	.984	1.550	2.362	20MM	HR-213-5.0-O	8-1/2	HR-213-5.0-OP	8-1/2
24" Kitagawa	HR-223-2.5	8-1/2	2-1/2	2-1/2	.984	1.550	3.150	20MM	HR-223-2.5-O	10	HR-223-2.5-OP	10
	HR-223-3.5	8-1/2	3-1/2	2-1/2	.984	1.550	3.150	20MM	HR-223-3.5-O	10	HR-223-3.5-OP	10
	HR-223-5.0	8-1/2	5	2-1/2	.984	1.550	3.150	20MM	HR-223-5.0-O	10	HR-223-5.0-OP	10



For: Kitagawa, Matsumoto, Howa, Pratt Burnerd America & Seike

SPECIAL HARD JAWS

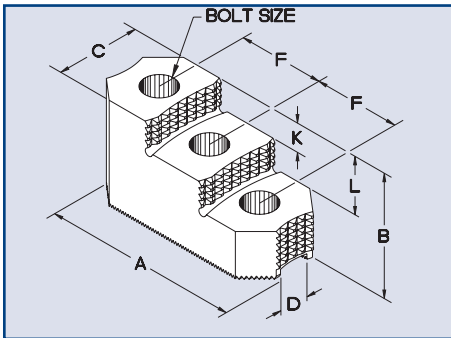
MADE TO ORDER

SEE PAGE 44 OR CALL FOR MORE INFORMATION

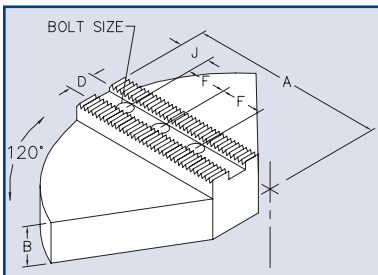
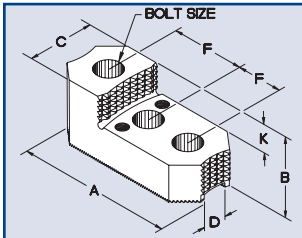
QUICK CHANGE JAW SYSTEMS

MADE TO ORDER

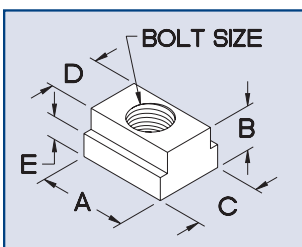
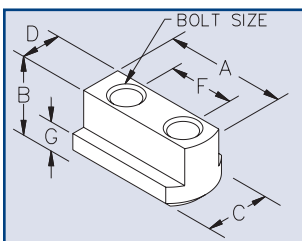
CALL FOR MORE INFORMATION



*JN-203-A Jaw Nut required.



ADD TO PART NUMBER
 "AL" - for Aluminum
 "CI" - for Cast Iron
 "ST" - for Steel



Kitagawa Reversible Hard Jaws

Chuck Size	Part No.	A	B	C	D	F	K	L	Bolt
10"	HR-113-RJ	4-1/4	2.469	1-3/4	.630	1.181	.650	1.300	12MM
12"	HR-143-RJ	4-7/8	2.469	1-3/4	.710	1.181	.650	1.300	14MM
18"	HR-203-RJ *	6-1/2	3.469	2-1/2	.984	1.907	.950	1.900	20MM
21" - 24"	HR-213-RJ	7-3/8	3.469	2-1/2	.984	2.362	.950	1.900	20MM

Matsumoto Reversible Hard Jaws

Chuck Size	Part No.	A	B	C	D	F	K	L	Bolt
15" - 18"	HR-153-RJ	6-1/2	3.469	2-1/2	.866	1.969	.950	1.900	20MM
HOWA	HR-183-RJ	6-1/2	3.469	2-1/2	1.022	1.969	.950	1.900	20MM

Single Step Hard Jaws

Chuck Size	Part No.	A	B	C	D	F	K	Bolt
18"	HR-203-RJ-SS *	6-1/2	3.469	2-1/2	.984	1.907	1.900	20MM
15" - 18"	HR-153-RJ-SS	6-1/2	3.469	2-1/2	.866	1.964	1.900	20MM
21" - 24"	HR-213-RJ-SS	7-3/8	3.469	2-1/2	.984	2.362	1.900	20MM

Full Wrap Jaws

Chuck Size	Part No.	A	B	D	J	F	Holes	Bolt
15"	HR-153-2-	7-1/2	2	.866	1.187	1.969	2	20MM
	HR-153-4-	7-1/2	4	.866	1.187	1.969	2	20MM
	HR-157-2-	7-1/2	2	.827	1.187	1.578	2	16MM
	HR-157-4-	7-1/2	4	.827	1.187	1.578	2	16MM
18"	HR-203-3-	9	3	.984	1.500	1.907	2	20MM
	HR-203-4-	9	4	.984	1.500	1.907	2	20MM
21"	HR-213-3-	10-1/2	3	.984	1.500	2.362	2	20MM
	HR-213-4-	10-1/2	4	.984	1.500	2.362	2	20MM
24"	HR-223-3-	12	3	.984	2.000	3.150	2	20MM
	HR-223-4-	12	4	.984	2.000	3.150	2	20MM

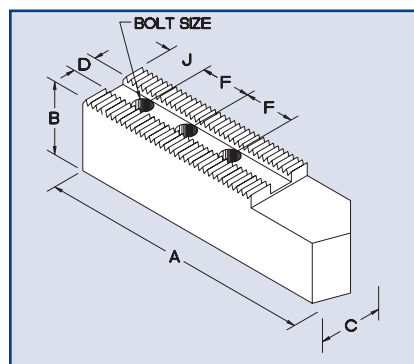
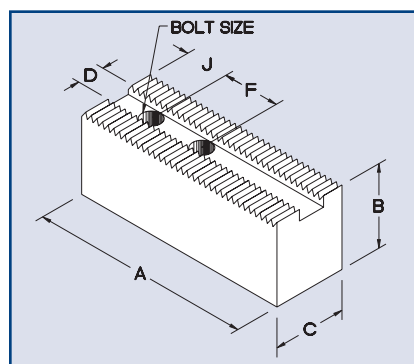
Jaw Nuts

Chuck Size	Part No.	A	B	C	D	G	F	Bolt
10" to 12" Howa Solid	JN-113-M	2	.875	.875	.630	.335	1.181	12MM
	JN-113-A							1/2-13
12" Howa HO7-MA-12	JN-108-M	2-1/16	1.250	1.040	.708	.530	1.181	14MM
	JN-108-A							9/16-12
18" - 20" Howa Howa HO27M-18	JN-183-M	3-1/4	1.575	1.339	1.022	.669	1.968	20MM
	JN-183-A							3/4-10
18" Kitagawa	JN-203-A	3-1/4	1.500	1.476	.984	.500	1.907	3/4-10
21" Kitagawa	JN-213-A	3-3/4	1.500	1.476	.984	.500	2.362	3/4-10
24" Kitagawa	JN-223-A	4-3/4	1.500	1.476	.984	.500	3.150	3/4-10
15" - 18" Matsumoto	JN-153-M	3-5/32	1.500	1.330	.864	.750	1.960	20MM
	JN-153-A	3-5/32	1.500	1.330	.864	.750	1.960	3/4-10
12" Pratt Burnerd	JN-26512	2-1/2	1.060	1.220	.825	.438	1.250	5/8-11
"T" Nuts								
21" - 24" Kitagawa	HR-TN-213A	1-1/2	1.770	1.476	.984	.746		3/4-10
"T" Nut	HR-TN-213M	1-1/2	1.770	1.476	.984	.746		20MM

For: Cushman, Gamet, Erickson, Power Hold, Rohm, Autoblok, Forkhardt, SMW & Pratt Burnerd America

Chuck Size	Soft Jaws								Extra Length/Pointed			
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
5" - 6"	*HR-6-JSH	3-1/8	1-1/2	1-1/4	.433	.437	.718	5/16	*ASTERISK MEANS 2 HOLES ONLY			
	*HR-6-JEH	3-1/8	3	1-1/4	.433	.437	.718	5/16				
	*HR-WB-11-90	3-1/2	2-1/2	1-1/2	.669	.600	.866	1/2				
	*HR-WB-11-70	2-3/4	2-1/2	1-1/2	.669	.600	.866	1/2				
8" - 10"	HR-10-JSH	4-1/4	2	1-1/2	.551	.562	.875	3/8	HR-10-JSH-0	5	HR-10-JSH-OP	5
	HR-10-JEH	4-1/4	3-1/2	1-1/2	.551	.562	.875	3/8	HR-10-JEH-0	5	HR-10-JEH-OP	5
10"HD	HR-11-JSH	4-5/8	2	1-3/4	.788	.625	1.187	1/2	HR-11-JSH-0	5-1/4	HR-11-JSH-OP	5-1/4
	HR-11-JEH	4-5/8	3-1/2	1-3/4	.788	.625	1.187	1/2	HR-11-JEH-0	5-1/4	HR-11-JEH-OP-OP	5-1/4
	HR-11-JEH-4	4-5/8	4	1-3/4	.788	.625	1.187	1/2	HR-11-JEH-4-0	5-1/4	HR-11-JEH-4-OP	5-1/4
	*HR-WB-12	4-3/4	3	2	.827	1.187	1.125	5/8	HR-WB-12-0	5-3/4	HR-WB-12-OP	5-3/4
11" - 12"	HR-12-JSH	5-1/4	2-1/2	1-3/4	.788	.625	1.187	1/2	HR-12-JSH-0	6-1/4	HR-12-JSH-OP	6-1/4
	HR-12-JEH	5-1/4	3-1/2	1-3/4	.788	.625	1.187	1/2	HR-12-JEH-0	6-1/4	HR-12-JEH-OP	6-1/4
	HR-12-JEH-4	5-1/4	4	1-3/4	.788	.625	1.187	1/2	HR-12-JEH-4-0	6-1/4	HR-12-JEH-4-OP	6-1/4
	*HR-WB-13	5-1/2	3-1/2	2-1/4	1.004	1.187	1.375	20MM	HR-WB-13-0	6-1/4	HR-WB-13-OP	6-1/4
14" - 15"	HR-15-JSH	6-5/8	2-1/2	1-3/4	.826	.750	1.562	5/8	HR-15-JSH-0	7-1/2	HR-15-JSH-OP	7-1/2
	HR-15-JEH	6-5/8	3-1/2	1-3/4	.826	.750	1.562	5/8	HR-15-JEH-0	7-1/2	HR-15-JEH-OP	7-1/2
	HR-15-JEH-4	6-5/8	4	1-3/4	.826	.750	1.562	5/8	HR-15-JEH-4-0	7-1/2	HR-15-JEH-4-OP	7-1/2
	HR-15-JEH-5	6-5/8	5	1-3/4	.826	.750	1.562	5/8	HR-15-JEH-5-0	7-1/2	HR-15-JEH-5-OP	7-1/2
	HR-18-JSH	6-5/8	2-1/2	2	.826	.750	1.562	5/8	HR-18-JSH-0	7-1/2	HR-18-JSH-OP	7-1/2
18"	HR-18-JEH	6-5/8	3-1/2	2	.826	.750	1.562	5/8	HR-18-JEH-0	7-1/2	HR-18-JEH-OP	7-1/2
	HR-18-JEH-5	6-5/8	5	2	.826	.750	1.562	5/8	HR-18-JEH-5-0	7-1/2	HR-18-JEH-5-OP	7-1/2
	HR-18-HD	8	3	2-1/2	1.181	.750	1.970	20MM				
18"HD Gamet	HR-18-HD-EH	8	5	2-1/2	1.181	.750	1.970	20MM				

Chuck Size	Pratt Burnerd							
	Part No.	A	B	C	D	J	F	Bolt
6½"	2740-17512	2-1/2	1-1/2	1	.472	.312	.718	5/16
	2860-17512	2-3/4	1-1/2	1-1/4	.472	.500	.830	1/2
8"	2740-21512	3	1-3/4	1-1/4	.670	.312	.875	5/16
	2860-21512	3-3/16	2	1-1/2	.669	.500	1.000	1/2
10"	2740-26512	3-1/2	2	1-1/2	.827	.500	1.000	1/2
	2860-26512	4	2-1/4	1-3/4	.827	.750	1.250	5/8
12½"	2740-32512	4-1/2	2-1/4	1-1/2	.827	.500	1.187	1/2
	2860-32512	4-1/2	2-1/2	2	.827	.625	1.250	5/8
14"	2740-32512	4-1/2	2-1/4	1-1/2	.827	.500	1.187	1/2
16"	2860-40512	6	3	2	1.004	.750	1.750	3/4
SMW 2 Holes								
6½"	11-6.5-2	3-1/2	2	1-1/2	.551	.437	.984	3/8
8"	11-8-2.0	3-1/2	2	1-1/2	.669	.500	1.130	1/2
	11-8-3.5	3-1/2	3-1/2	1-1/2	.669	.500	1.130	1/2
10" - 12½"L	11-12.5-2.5	4-3/4	2-1/2	2	.827	1.125	1.187	1/2
	11-12.5-3.5	4-3/4	3-1/2	2	.827	1.125	1.187	1/2
	11-12.5-5.0	4-3/4	5	2	.827	1.125	1.187	1/2
SMW 3 Holes								
5"	12-5-1.5-P	2-1/2	1-1/2	1	.433	.437	.600	5/16
6½"	12-6.5-1.5-P	3-1/4	1-1/2	1-1/2	.552	.437	.875	3/8
	12-6.5-2.5-P	3-1/4	2-1/2	1-1/2	.552	.437	.875	3/8
8"	12-8-2.0-P	4-1/4	2	1-1/2	.669	.500	.875	1/2
	12-8-3.5-P	4-1/4	3-1/2	1-1/2	.669	.500	.875	1/2
10" - 12½"L	12-12.5-2.5-P	5-1/4	2-1/2	2	.827	.625	1.187	1/2
	12-12.5-3.5-P	5-1/4	3-1/2	2	.827	.625	1.187	1/2
	12-12.5-5.0-P	5-1/4	5	2	.827	.625	1.187	1/2



Autoblok Chuck Series HDB-BHD-RCD-BBD

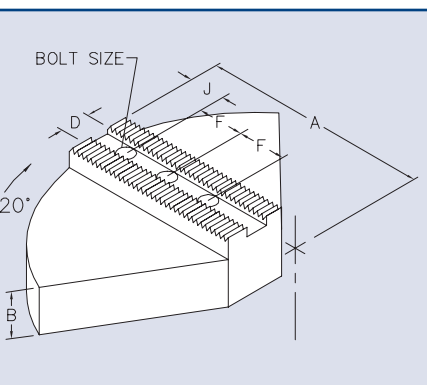
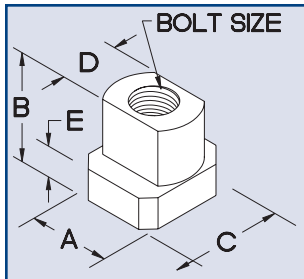
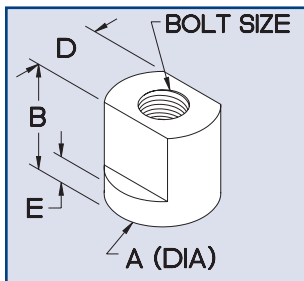
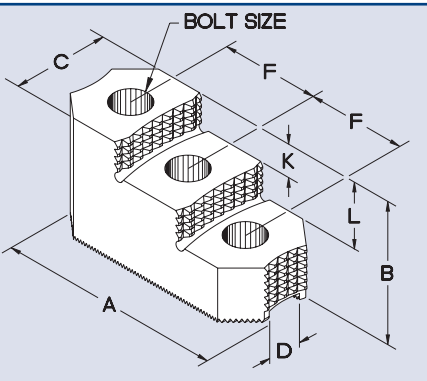
Chuck Size	Soft Jaws								Extra Length/Pointed			
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
125 AND/ALD Autoblok 130BHD & 140BBD	AB-D140-1.5-P	2-3/8	1-1/2	1-1/4	.472	.595	.63	8MM				
	AB-D140-2.0-P	2-3/8	2	1-1/4	.472	.595	.63	8MM				
	AB-D210-1.5	3-1/2	1-1/2	1-1/2	.669	.787	.906	12MM	AB-D210-1.5-0	4-1/4	AB-D210-1.5-OP	4-1/4
210(8) Autoblok	AB-D210-2.0	3-1/2	2	1-1/2	.669	.787	.906	12MM	AB-D210-2.0-0	4-1/4	AB-D210-2.0-OP	4-1/4
AND/ALD/BHD/BBD/RCD	AB-D210-3.5	3-1/2	3-1/2	1-1/2	.669	.787	.906	12MM	AB-D210-3.5-0	4-1/4	AB-D210-3.5-OP	4-1/4
200 CLD & 315 BBD	AB-D250-2.5	4	2-1/2	2	.827	.787	1.181	16MM	AB-D250-2.5-0	5	AB-D250-2.5-OP	5
	AB-D250-3.5	4	3-1/2	2	.827	.787	1.181	16MM	AB-D250-3.5-0	5	AB-D250-3.5-OP	5
200/315(12) Autoblok 250 All Models	AB-D250-5.0	4	5	2	.827	.787	1.181	16MM	AB-D250-5.0-0	5	AB-D250-5.0-OP	5
300 HDB 300/315(12) Autoblok 315 AND/BHD/BCD/BBD	AB-D315-2.5	5	2-1/2	2	.827	.870	1.181	16MM	AB-D315-2.5-0	6	AB-D315-2.5-OP	6
	AB-D315-3.5	5	3-1/2	2	.827	.870	1.181	16MM	AB-D315-3.5-0	6	AB-D315-3.5-OP	6
	AB-D315-5.0	5	5	2	.827	.870	1.181	16MM	AB-D315-5.0-0	6	AB-D315-5.0-OP	6

1/16" @ 90° SERRATED



**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

For: Cushman, Gamet, Erickson, Power Hold, Rohm, Autoblok, Forkhardt, SMW & Pratt Burnerd America



**ADD TO PART
NUMBER**
 "AL" - for Aluminum
 "CI" - for Cast Iron
 "ST" - for Steel

Reversible Hard Jaws									
Chuck Size	SMW								
	Part No.	A	B	C	D	F	K	L	Bolt
6½"	HR-11-6.5-RJ	3	2	1-1/4	.551	.865	3/8	3/4	3/8
8"	HR-11-8-RJ	3-1/2	1.969	1-1/2	.669	.945	.530	1.060	1/2
10" - 12"L	HR-11-12.5-RJ	4-7/8	2.469	1-3/4	.827	1.181	.650	1.300	1/2
Chuck Size	Pratt Burnerd								
	6½"	HR-16-6.5-RJ	3	2	1-1/4	.510	.719	3/8	3/4
	8"	HR-16-8-RJ	3-9/16	2	1-1/2	.669	.875	3/8	3/4
	10"	HR-16-10-RJ	4-1/4	2-1/2	1-1/2	.827	.980	1/2	1
Chuck Size	Others								
	5" - 6"	HR-6-JSH-RJ	3	2	1-1/4	.433	.719	1/2	1
	8" - 10"	HR-10-JSH-RJ	3-1/2	2	1-1/2	.551	.875	1/2	1
	11" - 12"	HR-12-JSH-RJ	4-1/4	2.469	1-3/4	.788	1.181	.650	1.300
	14" - 15"	HR-15-JSH-RJ	4-7/8	2.469	1-3/4	.827	1.562	.650	1.300
	18"	HR-18-HD-RJ	6-1/2	3.469	2-1/2	1.181	1.970	.950	1.900

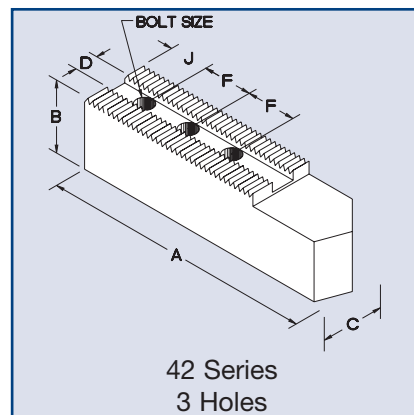
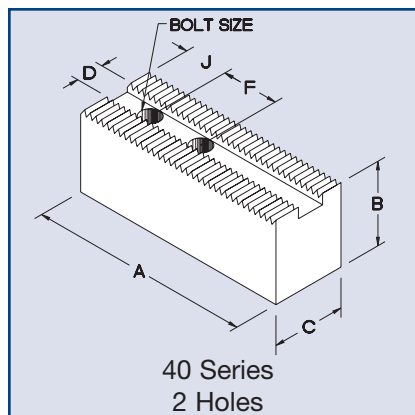
Chuck Size	SMW "T" Nuts					
	Part No.	A	B	D	E	Bolt
5" SP-125	HR-TN-SMW-125	.630	.850	.433	.300	5/16-18
6½" SP-160	HR-TN-SMW-160	.790	1.040	.551	.370	3/8-16
8" SP-200	HR-TN-SMW-200	.910	1.080	.669	.370	1/2-13
10" - 12½" SP-250	HR-TN-BB-250/315	1.100	1.180	.826	.430	1/2-13
12½"	HR-TN-15	1.100	1.180	.826	.430	5/8-11

Chuck Size	Forkhardt "T" Nuts						
	Part No.	A	B	C	D	E	Bolt
FN-315	HR-TN-FN-315	.934	1.065	1.125	.830	.433	5/8-11
FN-230	HR-TN-FN-230	.551	.669	.669	.472	.276	M8
FN-293	HR-TN-FN-293	.590	.728	.708	.551	.314	M10
FN-231	HR-TN-FN-231	.748	.905	.866	.699	.354	M12
FN-232	HR-TN-FN-232	.925	1.063	1.122	.708	.433	M16
FN-233	HR-TN-FN-233	1.082	1.141	1.417	1.003	.433	M20
FN-187	HR-TN-FN-187	1.375	1.614	1.653	1.181	.590	M24

Chuck Size	Full Wrap Jaws							
	Part No.	A	B	D	F	J	Holes	Bolt
6"	HR-6JSH-2-	3	2	.433	.718	3/4	2	5/16
	HR-6JEH-4-	3	4	.433	.718	3/4	2	5/16
8"	HR-10JSH-2-	4	2	.551	.875	3/4	2	3/8
	HR-10JEH-4-	4	4	.551	.875	3/4	2	3/8
10" HD	HR-11JSH-2-	5	2	.788	1.187	3/4	2	1/2
	HR-11JEH-4-	5	4	.788	1.187	3/4	2	1/2
12"	HR-12JSH-2-	6	2	.788	1.187	1	2	1/2
	HR-12JEH-4-	6	4	.788	1.187	1	2	1/2
15"	HR-15JSH-2-	7-1/2	2	.826	1.563	1-3/16	2	5/8
	HR-15JEH-4-	7-1/2	4	.826	1.563	1-3/16	2	5/8
18" HD	HR-18HD-3-	9	3	1.181	1.970	1	2	.800
	HR-18HD-4-	9	4	1.181	1.970	1	2	.800
11" HD	HR-WB-12-2-	6	2	.827	1.125	1-1/4	2	5/8
	HR-WB-12-4-	6	4	.827	1.125	1-1/4	2	5/8
15"	HR-WB-13-2-	7-1/2	2	1.004	1.375	1-1/4	2	.800
	HR-WB-13-4-	7-1/2	4	1.004	1.375	1-1/4	2	.800
6½" SMW	HR-12-6.5-2-	3	2	.551	.875	3/4	2	3/8
	HR-12-6.5-4-	3	4	.551	.875	3/4	2	3/8
8" SMW	HR-12-8-2-	4	2	.669	.875	3/4	2	1/2
	HR-12-8-4-	4	4	.669	.875	3/4	2	1/2
10" SMW	HR-11-12.5-2-	5	2	.827	1.187	3/4	2	1/2
	HR-11-12.5-4-	5	4	.827	1.187	3/4	2	1/2
12½" SMW	HR-12-12.5-2-	6	2	.827	1.187	1	2	1/2
	HR-12-12.5-4-	6	4	.827	1.187	1	2	1/2

For: SMW, Rohm, Forkhardt, "BIG BORE" Chucks & Autoblok

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QUICK CHANGE JAW SYSTEMS
MADE TO ORDER
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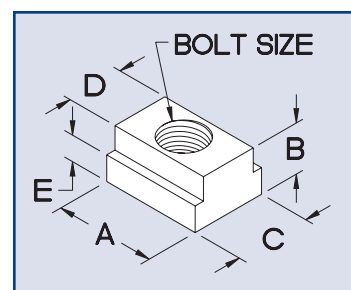
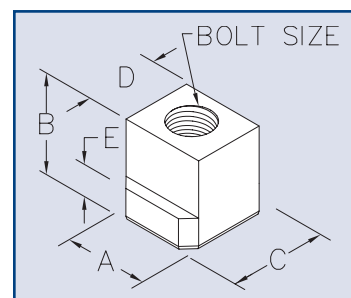


Chuck Size	Soft Jaws								Extra Length/Pointed			
	SMW											
	Part No.	A	B	C	D	J	F	Bolt	Part No.	A	Part No.	A
16" - 20" 400 Series 500 Series	HR-40-16	6-1/4	3	2-1/2	1.004	1-7/16	1.562	3/4				
	HR-40-16-5	6-1/4	5	2-1/2	1.004	1-7/16	1.562	3/4				
	HR-40-16-6	6-1/4	6	2-1/2	1.004	1-7/16	1.562	3/4				
	HR-42-16	8	3	2-1/2	1.004	1-3/8	1.562	3/4	HR-42-16-0	9	HR-42-16-0P	9
	HR-42-16-5	8	5	2-1/2	1.004	1-3/8	1.562	3/4	HR-42-16-5-0	9	HR-42-16-5-0P	9
	HR-42-16-6	8	6	2-1/2	1.004	1-3/8	1.562	3/4	HR-42-16-6-0	9	HR-42-16-6-0P	9
25" - 31½" 630 Series 800 Series	HR-40-25	8-1/4	3-1/2	3-1/2	1.181	1-1/4	2.500	1.0				
	HR-40-25-5	8-1/4	5	3-1/2	1.181	1-1/4	2.500	1.0				
	HR-40-25-6	8-1/4	6	3-1/2	1.181	1-1/4	2.500	1.0				
	HR-42-25	11	3-1/2	3-1/2	1.181	1-1/2	2.500	1.0	HR-42-25-0	12	HR-42-25-0P	12
	HR-42-25-5	11	5	3-1/2	1.181	1-1/2	2.500	1.0	HR-42-25-5-0	12	HR-42-25-5-0P	12
	HR-42-25-6	11	6	3-1/2	1.181	1-1/2	2.500	1.0	HR-42-25-6-0	12	HR-42-25-6-0P	12
35" - 40" 850 Series 1000 Series	HR-40-35	10	3-1/2	3-1/2	1.181	2-3/4	2.750	1.0				
	HR-40-35-5	10	5	3-1/2	1.181	2-3/4	2.750	1.0				
	HR-42-35	12	3-1/2	3-1/2	1.181	2-3/4	2.750	1.0	HR-42-35-0	14	HR-42-35-0P	14
	HR-42-35-5	12	5	3-1/2	1.181	2-3/4	2.750	1.0	HR-42-35-5-0	14	HR-42-35-5-0P	14
Forkhardt												
16" - 20"	HR-WB-23	6	3-1/2	2-1/2	1.004	1.181	1.375	3/4	HR-WB-23-0	8	HR-WB-23-0P	8
	HR-WB-23-5	6	5	2-1/2	1.004	1.181	1.375	3/4	HR-WB-23-5-0	8	HR-WB-23-5-0P	8
25" - 31½"	HR-250	10	3-1/2	2-1/2	1.004	.787	1.771	3/4	HR-250-0	12	HR-250-0P	12
	HR-250-5	10	5	2-1/2	1.004	.787	1.771	3/4	HR-250-5-0	12	HR-250-5-0P	12
18"HD Gamet	HR-350	12	3-1/2	2-1/2	1.004	.787	2.375	3/4	HR-350-0	14	HR-350-0P	14
	HR-350-5	12	5	2-1/2	1.004	.787	2.375	3/4	HR-350-5-0	14	HR-350-5-0P	14
Autoblok												
20" - 32"	HR-20-32	6-3/4	3	3	1.102	1.500	1.625	3/4	HR-20-32-0	9	HR-20-32-0P	9
	HR-20-32-5	6-3/4	5	3	1.102	1.500	1.625	3/4	HR-20-32-5-0	9	HR-20-32-5-0P	9

Chuck Size	Forkhardt "T" Nuts						
	Part No.	A	B	C	D	E	Bolt
Forkhardt FN-233	HR-TN-FN-233	1.082	1.141	1.417	1.003	.433	M20
Forkhardt FN-187	HR-TN-FN-187	1.378	1.614	1.653	1.181	.590	M24
Forkhardt 400/630	HR-TN-FN-400/630	1.090	1.145	1.412	1.003	.440	3/4-10

Chuck Size	Autoblok, Schunk, & SMW "T" Nuts						
	Part No.	A	B	C	D	E	Bolt
16" - 20"	HR-TN-BB-400/500	1.417	1.358	1.417	1.003	.571	3/4-10
25" - 31½"	HR-TN-BB-630/800	1.750	1.752	1.750	1.180	.728	1-8

Chuck Size	Square "T" Nuts						
	Part No.	A	B	C	D	E	Bolt
Autoblok 20" - 32"	HR-AB-20-32-M	1.26	1.50	1.50	1.101	.540	20MM

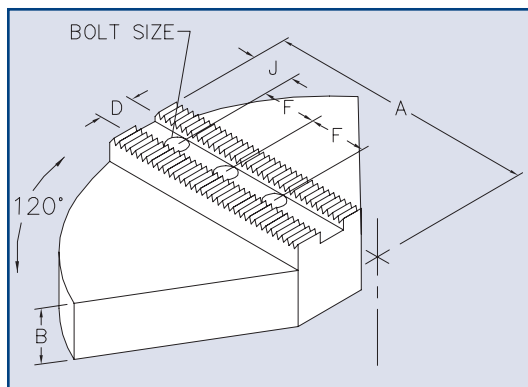


3/32" @ 90° SERRATED



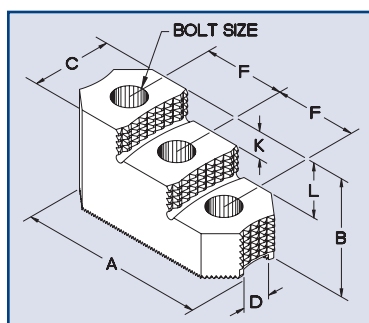
**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

For: SMW, Rohm, Forkhardt, "BIG BORE" Chucks & Autoblok

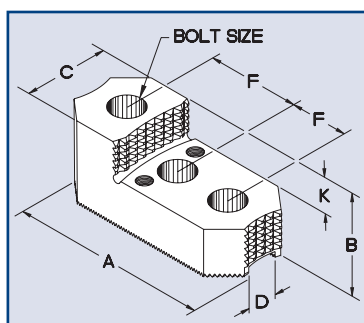


**ADD TO PART
NUMBER**
"AL" - for Aluminum
"CI" - for Cast Iron
"ST" - for Steel

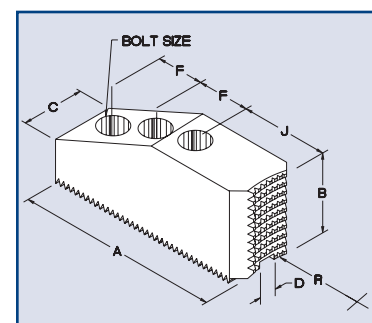
Chuck Size	Full Wrap Jaws							
	Part No.	A	B	D	F	J	Holes	Bolt
15"	HR-40-16-2-	7-1/2	2	1.004	1.562	1-1/2	2	3/4
	HR-40-16-4-	7-1/2	4	1.004	1.562	1-1/2	2	3/4
21"	HR-42-16-3-	10-1/2	3	1.004	1.562	1-1/2	3	3/4
	HR-42-16-4-	10-1/2	4	1.004	1.562	1-1/2	3	3/4
24"	HR-42-25-3-	12	3	1.181	2.500	2	3	1
	HR-42-25-4-	12	4	1.181	2.500	2	3	1



2 Step



Single Step



Extended

Chuck Size	2 Step & Single Step Hard Jaws								
	Part No.	A	B	C	D	F	K	L	Bolt
16" - 20"	HR-BB-500-RJ	5-1/2	3.469	2-1/2	1.004	1.625	.950	1.900	3/4
	HR-BB-500-RJ-SS	5-1/2	3.469	2-1/2	1.004	1.625	1.900	NA	3/4
25" - 31 1/2"	HR-BB-630-RJ	8-1/4	3.969	3-1/2	1.181	2.375	1.000	2	1
	HR-BB-630-RJ-SS	8-1/4	3.969	3-1/2	1.181	2.375	2.000	NA	1

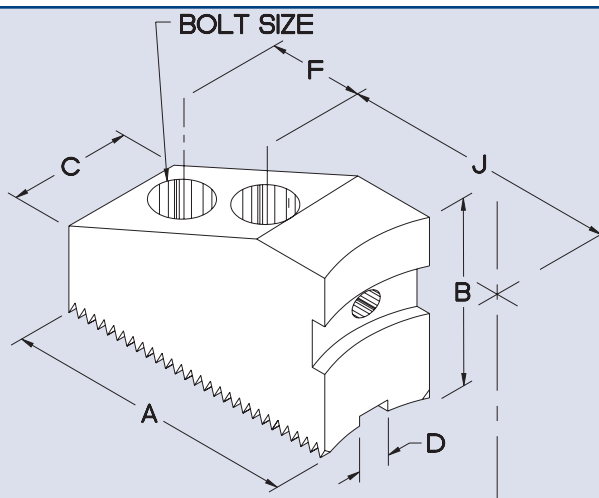
BB=SMW Chucks • LVE=Forkhardt Chucks

Chuck Size	Extended Hard Jaws								
	Part No.	A	B	C	D	F	J	R	Bolt
16"	HR-BB-400	6-1/4	2-1/2	2-1/2	1.004	1.500	1.936	1.750	3/4
20"	HR-BB-500	8-1/2	3	2-1/2	1.004	1.625	3.561	1.750	3/4
25"	HR-BB-630	9	3	2-1/2	1.181	2.375	2.604	3.500	1
	HR-LVE-630	9	3	2-1/2	1.004	2.375	2.604	3.500	20MM
31 1/2"	HR-BB-800	11	3-1/2	3-1/2	1.181	2.500	4.300	5.000	1
	HR-LVE-800	11	3-1/2	2-1/2	1.004	2.500	4.300	5.000	20MM
35" - 40"	HR-BB-850/1000	12-3/4	3-1/2	3-1/2	1.181	2.500	6.500	5.000	1
	HR-LVE-850/1000	12-3/4	3-1/2	3-1/2	1.004	2.500	6.500	5.000	20MM

Specify
Collet No. Size

"A"

With
Part Number
#3
#4
#5
#6



**ALL 3
SPLIT**

1.5MM Serrations

Chuck Size	Part No.	"A"				B	C	D	F	J	Bolt
		#3	#4	#5	#6						
6" KITAGAWA	HR-6K-MC-	2-1/4	2			2	1-1/4	.475	.787	1.810	10MM
8" KITAGAWA 8" MATSUMOTO	HR-149-MC-	3-1/2	3-1/8	2-5/8		2-1/2	1-1/2	.551	.984	2.250	1/2
8" NIKKO	HR-80-MC-	3-1/2	3-1/8			2	1-1/2	.551	1.181	2.250	10MM
10" HOWA SOLID	HR-81-MC-	4-1/2	4-1/8	3-13/16	3-1/2	2-1/2	1-1/2	.630	.984	3.000	1/2
10" KITAGAWA 11" MATSUMOTO	HR-82-MC-	4-1/2	4-1/8	3-13/16	3-1/2	2-1/2	1-3/4	.630	1.181	3.000	1/2
10" SEIKE	HR-85-MC-	4-1/2	4-1/8	3-13/16	3-1/2	2	1-1/2	.630	1.266	3.000	1/2
12" KITAGAWA	HR-108-MC-		5-1/8	4-3/4	4-7/16	2-1/2	2	.710	1.181	3.610	9/16
12" MATSUMOTO	HR-112-MC-		5-1/8	4-3/4	4-7/16	2-1/2	2	.827	1.181	3.610	5/8
10" - 12" NIKKO	HR-125-MC-		4-1/2	4	3-3/4	2-1/2	1-3/4	.788	1.375	3.000	1/2
12" HOWA	HR-150-MC-			4-3/4	4-1/4	4-1/4	2-1/2	1.022	1.968	3.250	3/4
15" KITAGAWA	HR-155-MC-			6.000	5-11/16	4-7/8	2-1/2	.866	1.690	4.300	3/4
	HR-115-MC-			6.000	5-11/16	4-7/8	2-1/2	1.004	1.690	4.300	3/4

3MM Serrations

Chuck Size	Part No.	"A"				B	C	D	F	J	Bolt
		#3	#4	#5	#6						
10" - 12" HOWA	HR-113-MC-	4-1/2	4-1/8	3.81	3-1/2	2-1/2	1-1/2	.630	1.181	3	1/2
12" HOWA SOLID	HR-143-MC-		4-1/2	4	3-3/4	2-1/2	2	.710	1.181	3	14MM
15" - 18" MATSUMOTO	HR-153-MC-				4-7/8	3-1/2	2-1/2	.866	1.690	3-1/2	20MM

1/16" Serrations

Chuck Size	Part No.	"A"				B	C	D	F	J	Bolt
		#3	#4	#5	#6						
8"	HR-10J-MC-	4-1/8	3-7/8	3-1/2		2	1-1/2	.551	.875	3	3/8
10" HD	HR-11J-MC-	4-3/8	4-1/8	3-3/4		2-1/2	1-3/4	.788	1.187	3-1/2	1/2
11" - 12"	HR-12J-MC-		4-3/4	4-1/4	3-7/8	3	1-3/4	.788	1.187	3-1/4	1/2
14" - 15"	HR-15J-MC-				4-5/8	3	1-3/4	.827	1.562	3-1/2	5/8
12"	HR-WB12-MC-			4-1/8	3-3/4	3	2	.827	1.125	3-1/4	5/8
15"	HR-WB13-MC-				4-5/8	3-1/2	1	1.004	1.375	3-1/2	20MM
6½" SMW	HR-11-6.5-MC-	2-3/4				2	1-1/2	.551	.984	1-13/16	3/8
8" SMW	HR-11-8-MC-	3-1/2	3-1/8			2-1/2	1-1/2	.669	1.130	2-1/4	1/2
10" - 12½" SMW	HR-11-12.5-MC-		5-3/8	5	4-5/8	2-1/2	2	.827	1.187	4	1/2

COLLET PADS



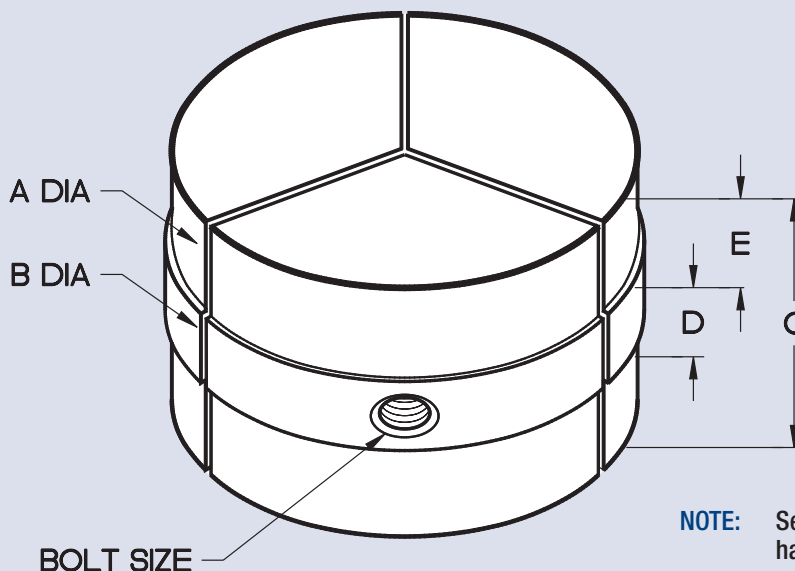
ALL PRODUCTS
PROUDLY MADE
IN THE USA

Collet Pads are
available in:

Emergency Soft

Hard Smooth
and

Hard Serrated
Round
Square
Hex



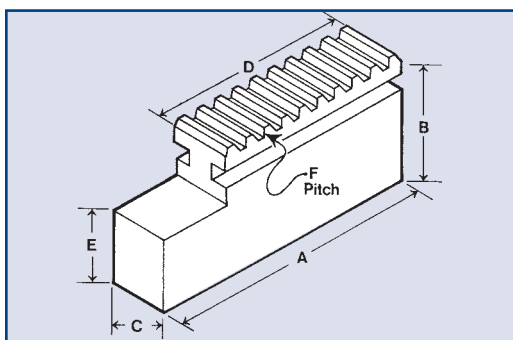
Now available
for all
Chucks
with
H&R
Master Collet
Top Jaws

NOTE: See individual jaw pages for
hard master collet jaws

Technical Specifications for Collet Pads

Collets									
Part No.	A	B	C	D	E	Bolt	Max Round	Max Hex	Max Square
#3 COLLET	1.875	1.960	1.375	.434	.594	5/16-24	1.500	1.312	1.062
#4 COLLET	2.375	2.460	1.750	.625	.565	5/16-24	2.000	1.750	1.375
#5 COLLET	3.000	3.085	1.875	.625	.625	3/8-24	2.500	2.187	1.750
#6 COLLET	3.500	3.585	2.250	.625	.812	3/8-24	3.000	2.625	2.125

KNCS MONOBLOCK SOFT JAWS



For: Autoblok, Forkhardt, Rohm, SMW Systems and Schunk

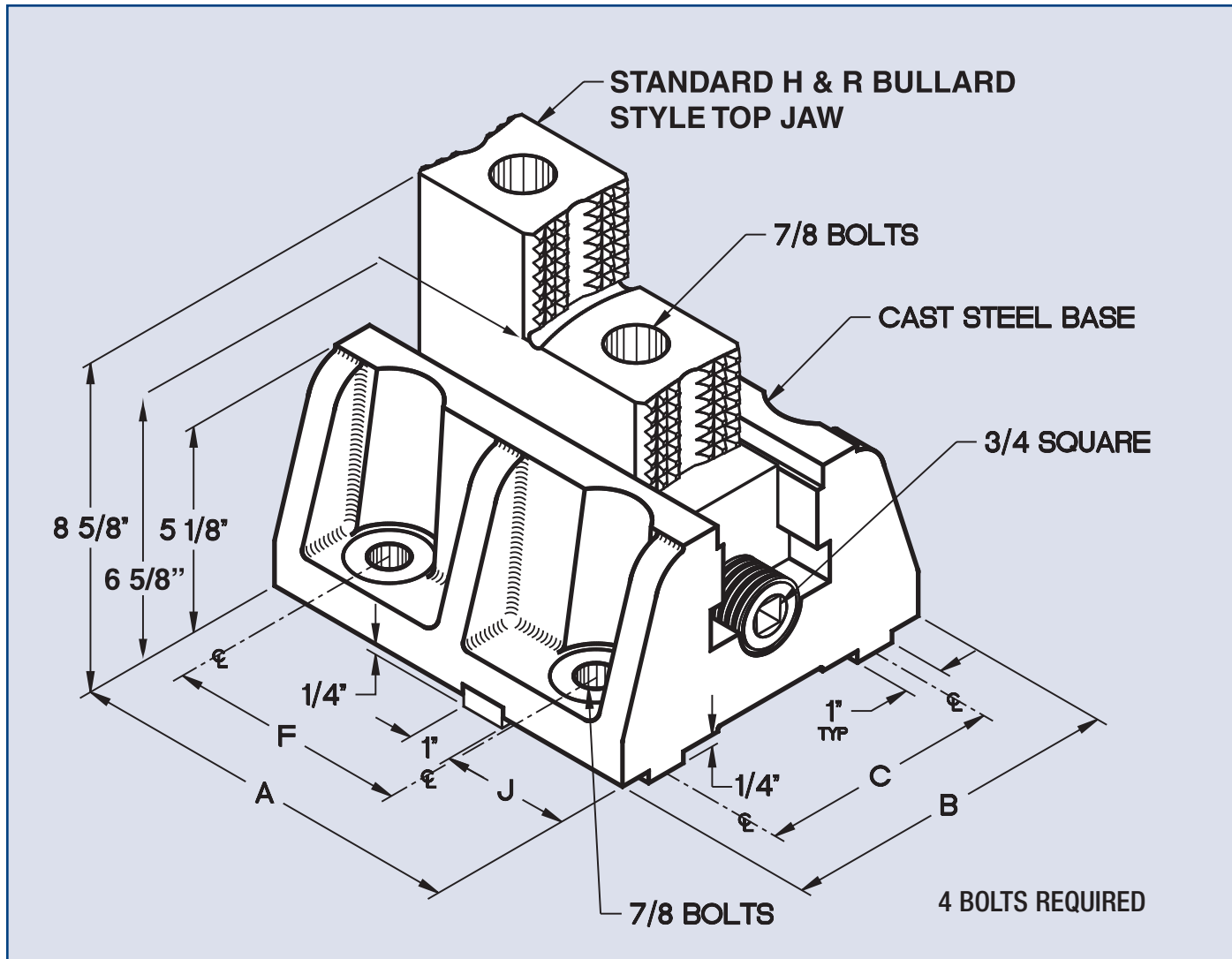
Other Series Soft & Hard Jaws Available

Call With Specifications & Pricing

Specify Brand of Chuck

UVB Series								
Chuck Size	Part No.		A	B	C	D	E	F Pitch
250	UVB-250	MM	97	89	26	76	52.5	5.498
		INCH	3.78	3.50	1.023	3	2.07	
315	UVB-315	MM	118	101.6	32	92	55	5.498
		INCH	4.63	4.00	1.258	3.6	2.17	
400	UVB-400	MM	145	101.6	32	114	55	5.498
		INCH	5.75	4.00	1.258	4.5	2.17	
500	UVB-500	MM	175	124	45	175	124	7.000
		INCH	6.89	4.88	1.77	6.89	4.88	
630	UVB-630	MM	230	124	45	230	124	7.000
		INCH	9.06	4.88	1.77	9.06	4.88	

Replaceable Standard Top Jaws (Soft Jaws available) – 12,000 lbs. workload capacity per jaw



Metric Sizes Available on request

Two positions Hardened & Ground Master Jaw
Hardened thrust bearing & operating screw for extended wear

Part No.	A	B	C	F	J	Top Jaw Positions
HR-BM-8-6-TJ	8	8-5/8	6	4	3-1/2	1
HR-BM-8-7-TJ	8	8-5/8	7	4	3-1/2	1
HR-BM-10-6-TJ	10	8-5/8	6	6	3	2
HR-BM-10-7-TJ	10	8-5/8	7	6	3	2
HR-BM-12-6-TJ	12	10	6	7	3-1/2	2
HR-BM-12-7-TJ	12	10	7	7	3-1/2	2
HR-BM-14-6-TJ	14	12	6	9	3-1/2	4
HR-BM-14-7-TJ	14	12	7	9	3-1/2	4
HR-BM-8-4.9-TJ**	8	6-3/4	4.921	6	1-7/8	3
Part No.	A	B	C	F	J	Top Jaw Positions
HR-BM-8-4.9-TJ**	8	6-3/4	4.921	6	1-7/8	3

Replacement parts available in stock

Special bottom available upon request

T.J. = Std 4" Bullard Hard Jaw

Additional top tooling see page 24

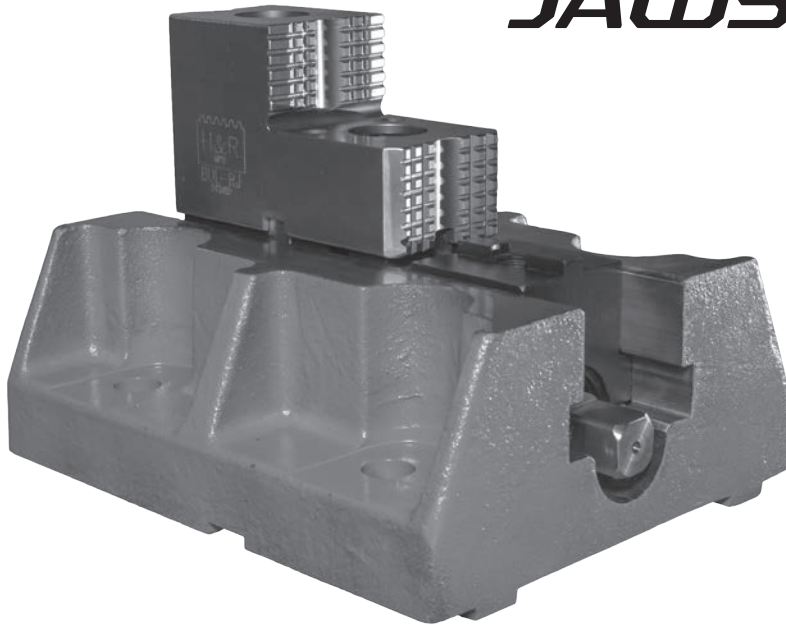
**HR-BM-8-4.9-TJ comes standard with 15-HTGRJ-SS – 8,000 lbs. workload capacity

**BM-8-4.9-Mounting Pkg. Other Jaws See Pages 5 & 7

**Key @ .750, Tongue @ .866, 20mm Bolt - 4 Required
 For Toshiba Vertical Lathes (picture above does not apply)

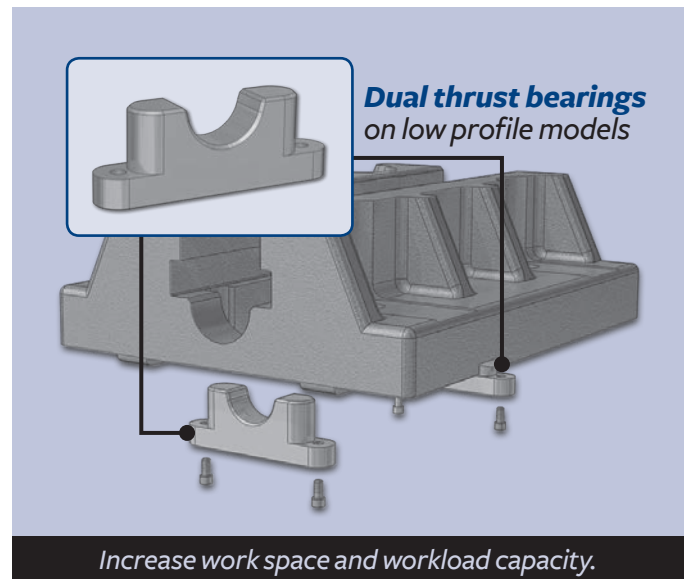
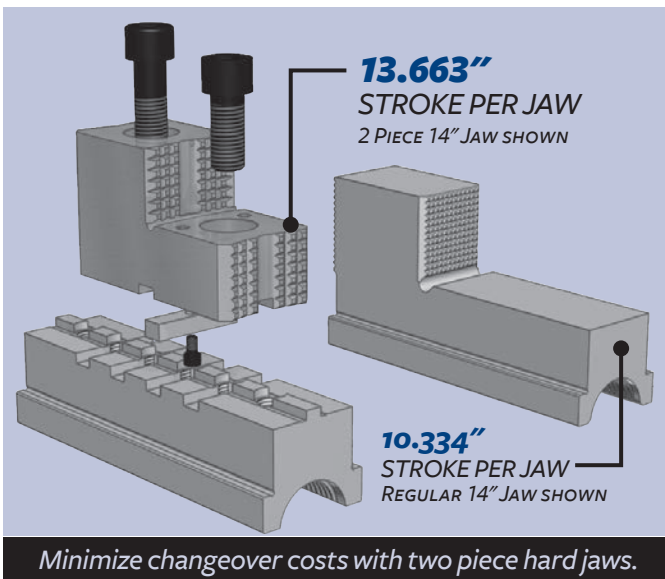


Low Profile **BORING MILL JAWS**



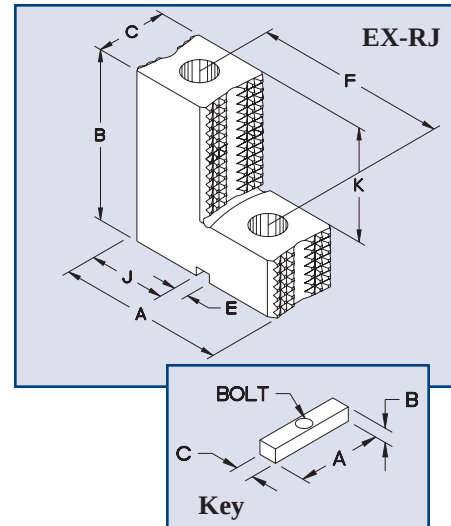
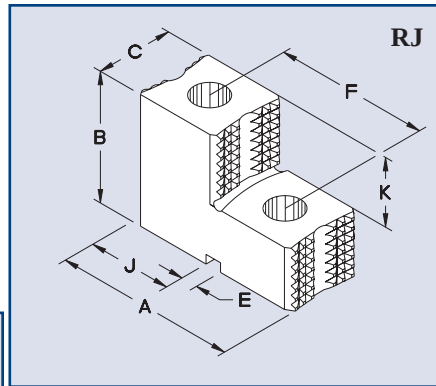
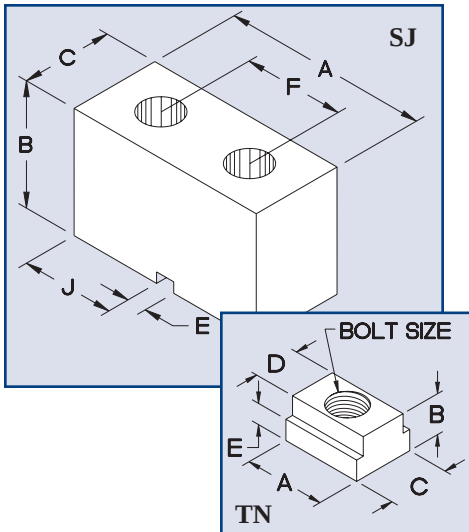
**25,000 lbs. workload
capacity per jaw.**

Reduce scrapped parts and
minimize machine downtime!



Metric Sizes Available on request

Part No.	A	B	C	F	Height Top Jaw	Height Top Casting	Bolt Size
BM-LP-12-6-SHJ	12	10	6	7	7.31	4.44	7/8
BM-LP-12-7-SHJ	12	10	7	7	7.31	4.44	7/8
BM-LP-12-6-TJ	12	10	6	7	8.56	4.44	7/8
BM-LP-12-7-TJ	12	10	7	7	8.56	4.44	7/8
BM-LP-14-6-SHJ	14	12	6	9	7.48	4.44	7/8
BM-LP-14-7-SHJ	14	12	7	9	7.48	4.44	7/8
BM-LP-14-6-TJ	14	12	6	9	8.56	4.44	7/8
BM-LP-14-7-TJ	14	12	7	9	8.56	4.44	7/8

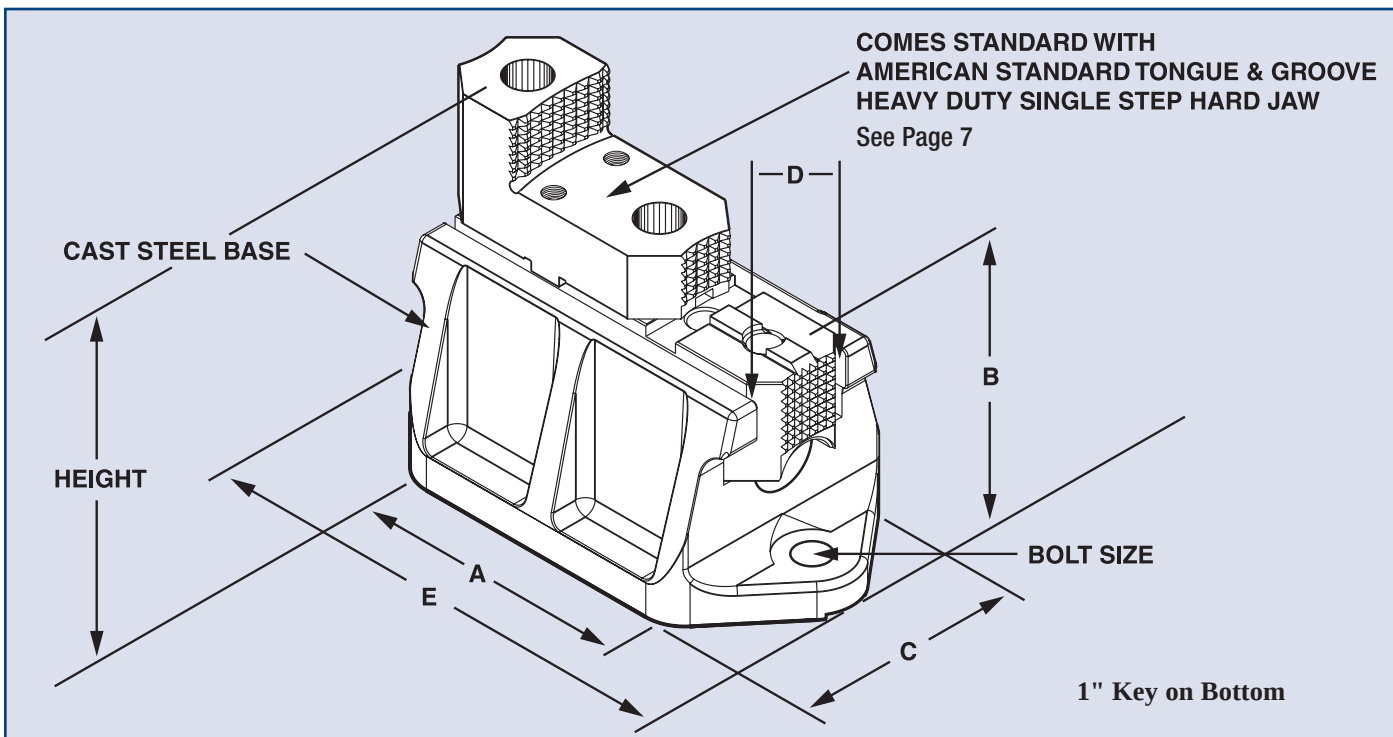


Bullard Jaws									
Part No.	A	B	C	D	E	F	J	K	Bolt
HR-BUL-SJ	6-5/8	4	3	~	5/8	3-1/4	CENTER	~	7/8
HR-BUL-RJ	6-5/8	4	3	~	5/8	3-1/4	3	2	7/8
HR-BUL-RJ-FS*	6-5/8	4	3	~	5/8	3-1/4	3	2	7/8
HR-BUL-EX-RJ	6-5/8	6	3	~	5/8	3-1/4	3	4	7/8
HR-BUL-KEY	2-5/8	1/2	5/8	~	~	~	~	~	5/16
HR-BUL-TN	1-3/4	1	1-1/2	.975	.520	~	~	~	7/8-9

*FS stands for Fine Serrated Teeth

STEEL FACE PLATE JAWS

Two positions Hardened & Ground Master Jaw



Part No.	Top Jaw	A	B	C	D	E	Bolt Size	Height
FPJ-6-TJ	12-HTGRJ-SS	6.00	4.50	5.50	2.00	8.50	5/8	7.00
FPJ-8-TJ	15-HTGRJ-SS	8.00	4.50	5.50	2.250	10.50	3/4	7.92

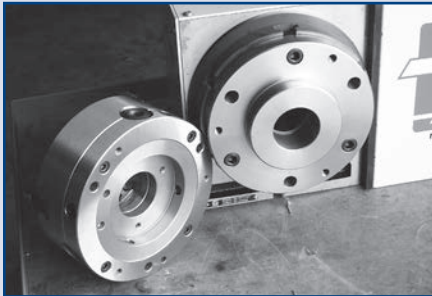
H&R ROTARY ADAPTER PACKAGE



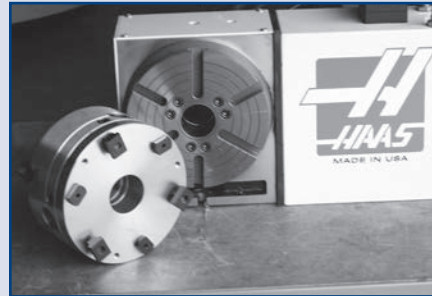
**ALL PRODUCTS
PROUDLY MADE
IN THE USA**

Rotary adapter packages for all major manufacturers including: Samchully, Haas, Nikon, Kitagawa, Tsudakoma, Troyke, AND MANY MORE. Contact sales for ordering information.

Available Sizes: 6" • 8" • 10" • 12" • 15"



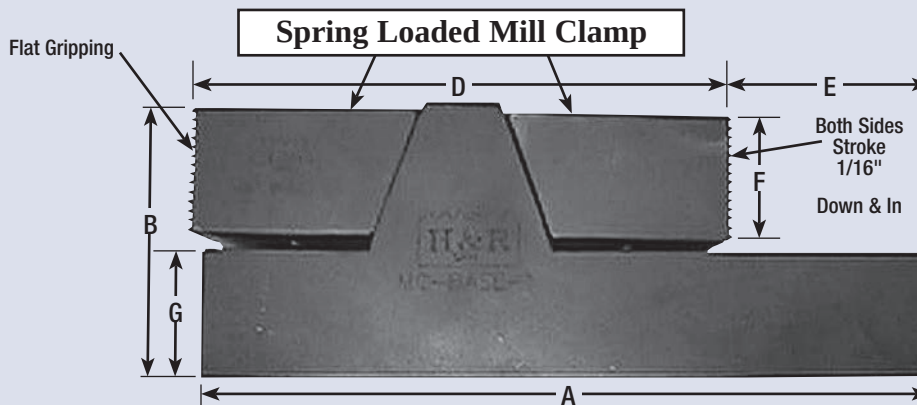
Mounted
Adaptor
Easily
Centered & Indicated



Sine Key
For Easy Alignment

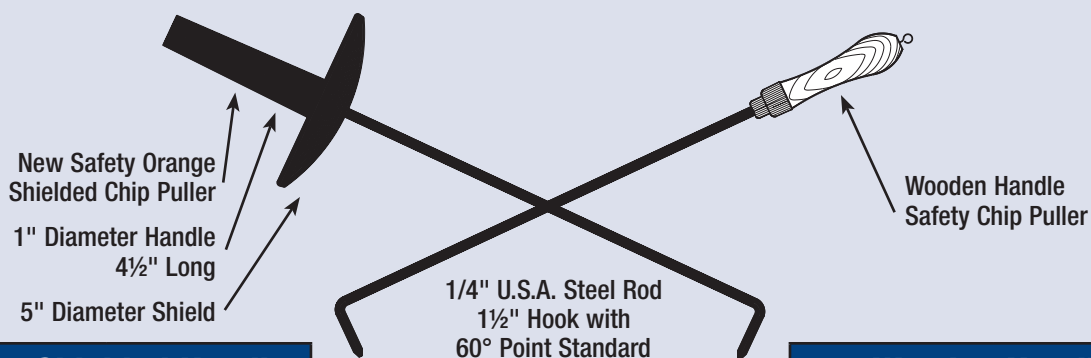
Bolts &
T-Nuts
For Holding

MACHINING CENTER CLAMP



H&R Part No.	A	B	Width	D	E	F	G	Bolt Size
MC-CLAMP-.500	5.500	2.125	1.250	3.838	1.740	1.000	0.750	1/2"
MC-CLAMP-.750	8.000	2.750	2.000	5.675	2.375	1.250	1.250	3/4"
MC-CLAMP-1.00	10.000	3.750	2.500	7.259	2.859	1.750	1.750	1"

CHIP HOOK-R



Safety Shielded Handle

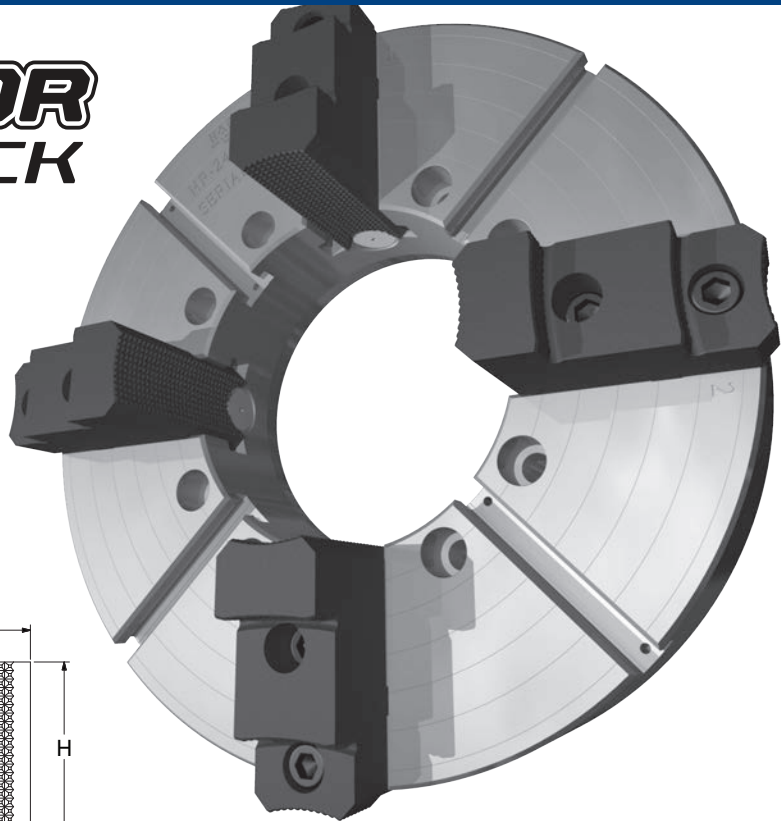
H&R Part No.	H&R Length
HR-SC-18	18"
HR-SC-24	24"
HR-SC-30	30"

WARNING:
NOT TO BE USED AROUND
MOVING PARTS

Wooden Handle

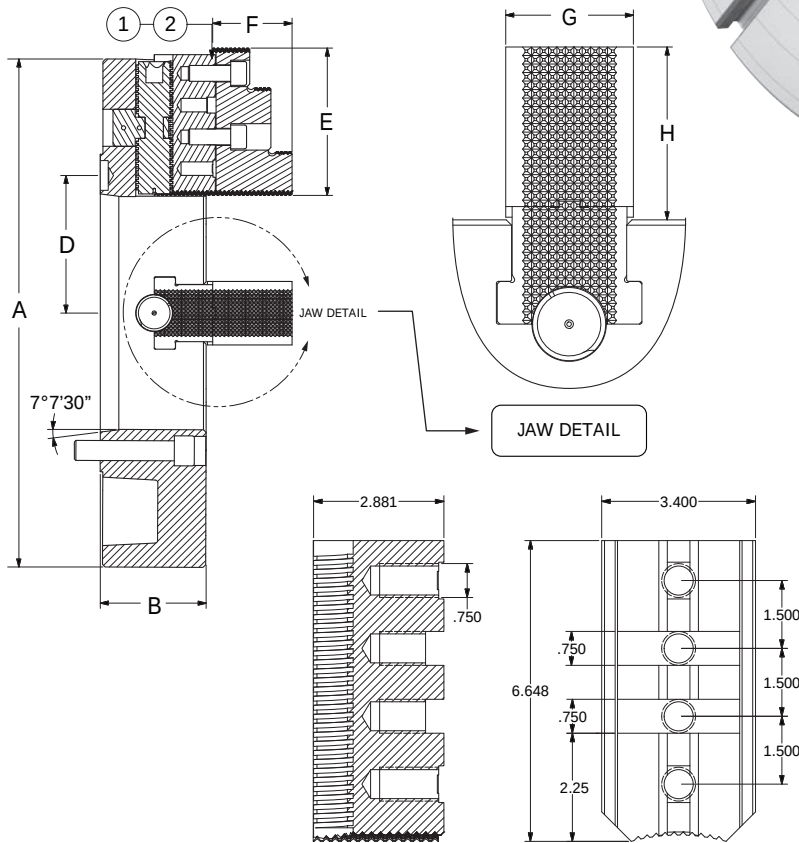
H&R Part No.	H&R Length
HR-WD-18	18"
HR-WD-24	24"
HR-WD-30	30"

THE GLADIATOR CHUCK



All Gladiator Chucks are crafted using 8640 through-hardened material and feature the largest oil country thru-holes available in the industry.

Every Gladiator Chuck is standard equipped with our widest extra heavy duty hard jaws so you can handle a variety of jobs as soon as it's on the spindle.



Notes

① Two Position Master Jaw on 24" Gladiator

② Three Position Master Jaw on 32" Gladiator

Part No.	Mount Type	A - Chuck Diameter	B Thickness	Inner Diameter	Gripping DIA		Clamping Force		MAX RPM	Weight	Top Jaw Bolts
					Minimum External	Minimum Internal	Wrench Torque	Force of Each Jaw			
HR-32-16-A20	A-20	32"	5"	16"	7.57"	11.69"	400 ft lbs (542 N•m)	6250 lbf (2834 kgf) 25,000 lbf TOTAL (11,336 kgf TOTAL)	650	689	7/8" - 9
HR-24-15-A20	A-20	25"	5"	15"	7.67"	11.69"			1000	491	7/8" - 9
HR-24-11-A15	A-15	24"	5"	11"	4.67"	7.67"			1000	453	3/4" - 10

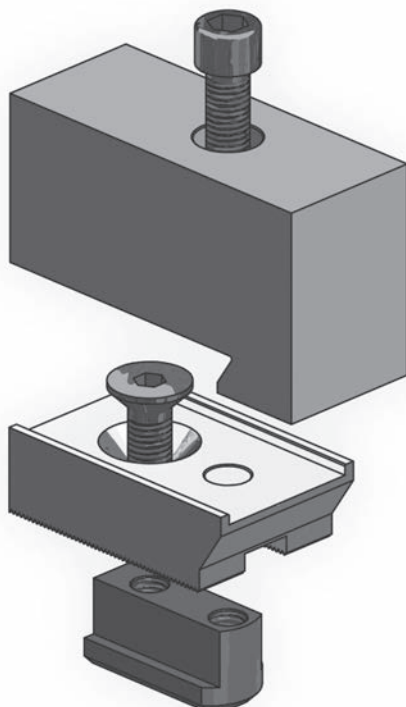
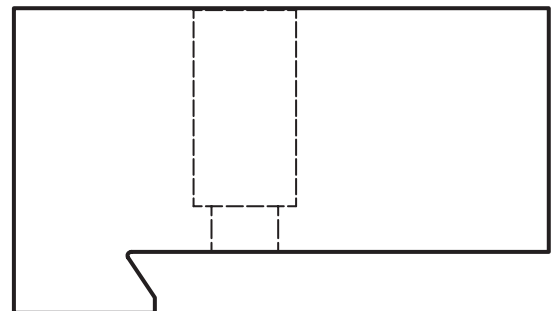
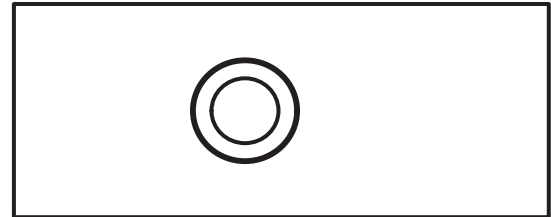
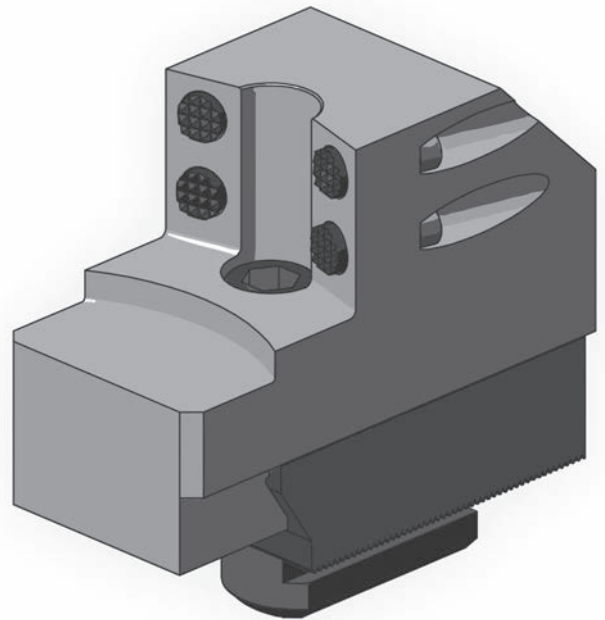


THE ELIMINATOR

H&R's Eliminator chuck jaws are customized for your product line or application and eliminates the need for repeatedly machining soft jaws, as well as reduce man hours spent on tooling, set up, and machine downtime.

Soft Jaw Part Numbers

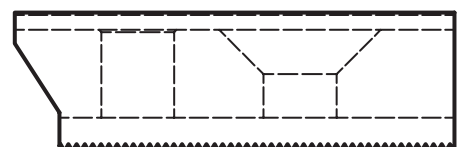
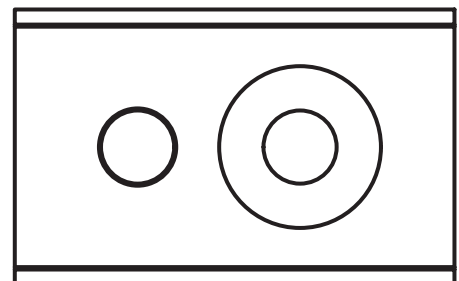
Jaw Height	
2"	5"
HR-EL-6K-2.0	HR-EL-6K-5.0
HR-EL-149-2.0	HR-EL-149-5.0
HR-EL-82-2.0	HR-EL-82-5.0
HR-EL-108-2.0	HR-EL-108-5.0
HR-EL-112-2.0	HR-EL-112-5.0
HR-EL-155-2.0	HR-EL-155-5.0
HR-EL-115-2.0	HR-EL-115-5.0



Master Jaw Part Numbers

1.5mm Serrated
HR-EL-6K-MJ
HR-EL-149-MJ
HR-EL-82-MJ
HR-EL-108-MJ
HR-EL-112-MJ
HR-EL-155-MJ
HR-EL-115-MJ

All Eliminator master jaws are shipped with bolts & jaw nuts



One bolt changes insert grip diameter in seconds without moving the master. Companies already using the H&R Quick Change Hard Inserts have documented drastic savings in a 3 to 6 month payback period. A set of Quick Change Inserts, custom sized to your specifications, will virtually eliminate the non-essential need for machining soft jaws over and over again, as well as reduce the man hours spent on tooling, set-up, and costly non-productive machine downtime due to set-up, (**More parts completed**

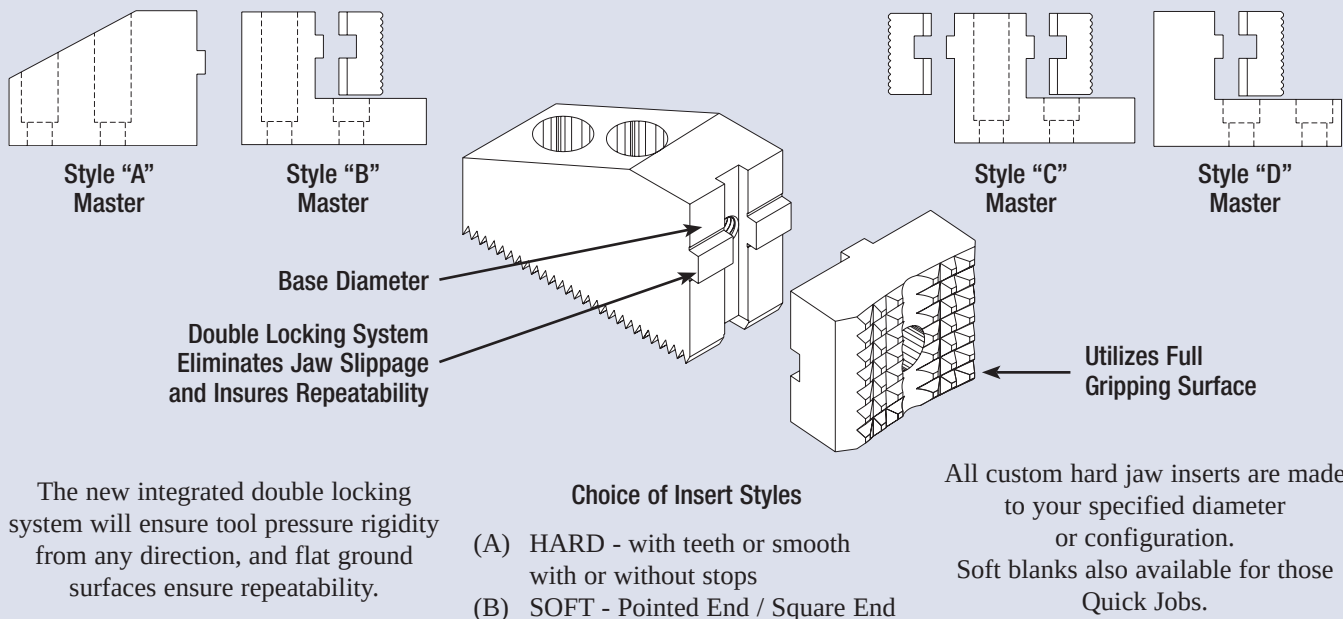
per hour.) When the occasional or frequent need arises for special jaw size, standard H&R soft inserts are available to fit the same rigid double lock master, with the same quick one bolt change. Please call us to prepare a cost estimate for equipping your machines with Quick Change Jaw Inserts to your specifications. Compare this cost to **what your present total system would cost you over the next several years, and you will see the savings you could enjoy with this new system.**

Quick Change Jaw Inserts normally pay for themselves in 3 to 6 months.

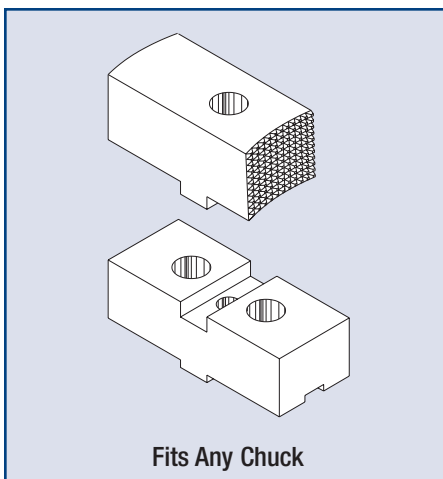
LOCATE MASTER TOP JAWS ONCE

Master top jaws remain in one location for a specific range of diameters (*based upon customer specifications and our unique design.*) The inserts are designed to make up the specific different OD sizes requested.

H&R O.D. FLAT SYSTEM

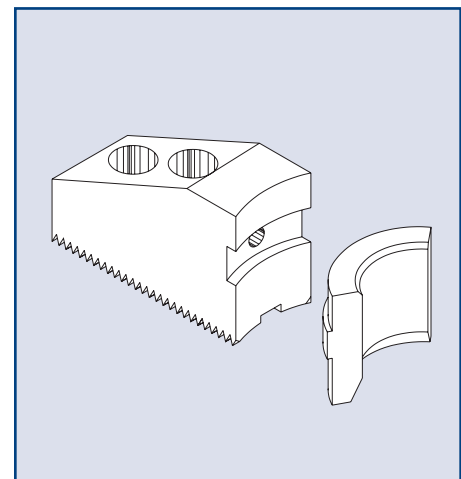


H&R I.D. - O. D. FLAT SYSTEM



This unique design allows a quick change system with interchangeable soft or hard inserts for **O.D.** and **I.D.**, even on the same jaw. Within certain size ranges, **ONE** insert can have **two sizes one on each end of the same insert reducing your cost even further.** The flat ground connection between the master and the inserts insures repeatability and stability.

Call for more information.

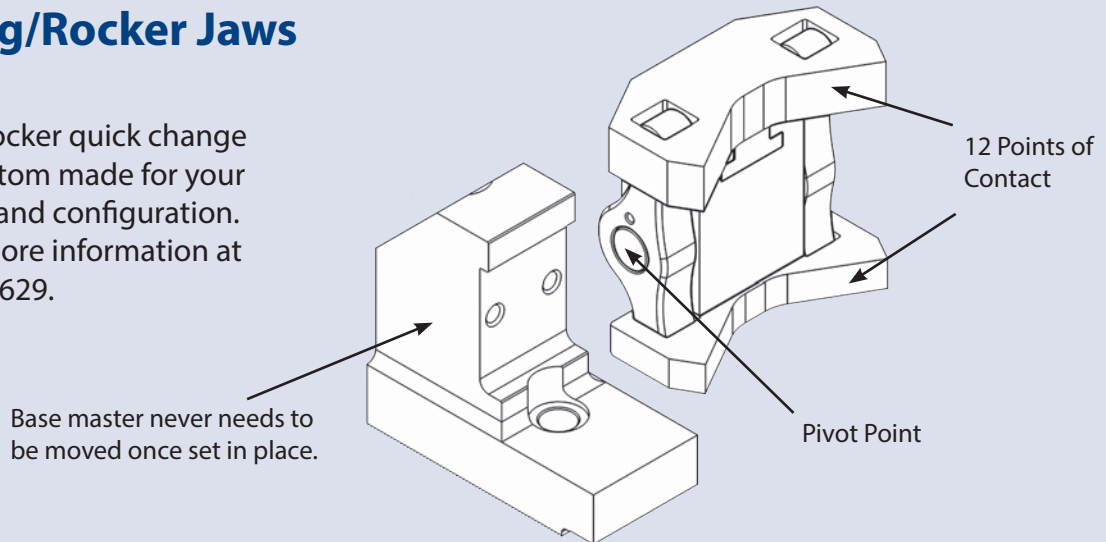


H&R COLLET QUICK CHANGE SYSTEM



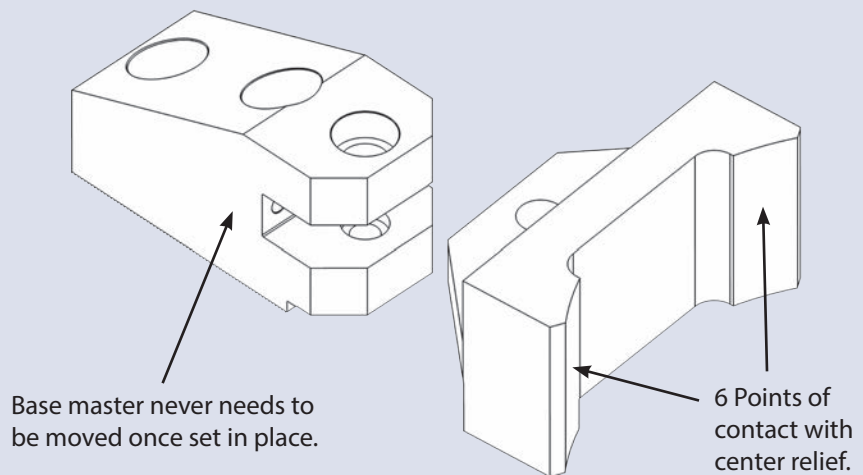
Coupling/Rocker Jaws

Coupling/Rocker quick change jaws are custom made for your application and configuration. Call us for more information at 1-800-749-0629.



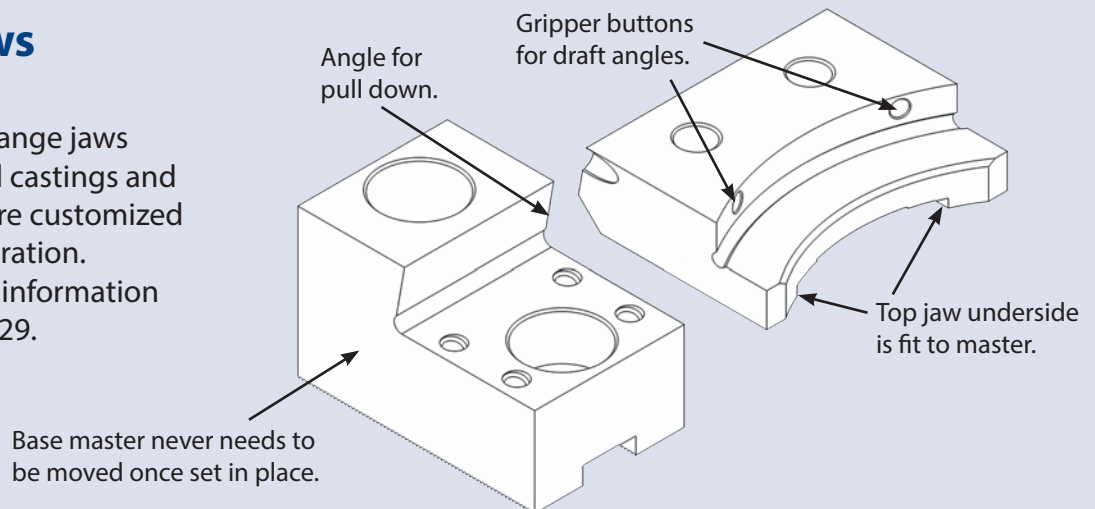
Swivel Jaws

Swivel quick change jaws are well suited to holding pipe couplings and are customized for your configuration. Call us for more information at 1-800-749-0629.

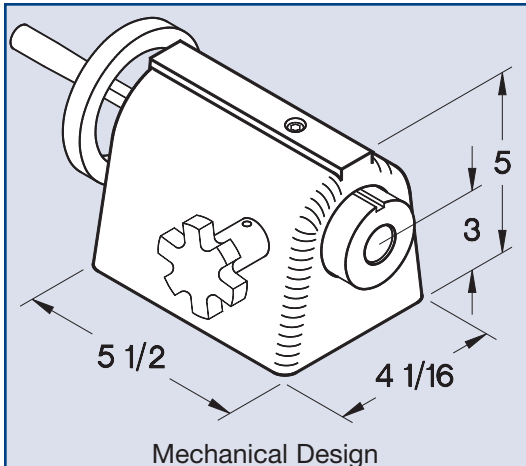


Flange Jaws

Flange quick change jaws are used to hold castings and forgings. Jaws are customized for your configuration. Call us for more information at 1-800-749-0629.

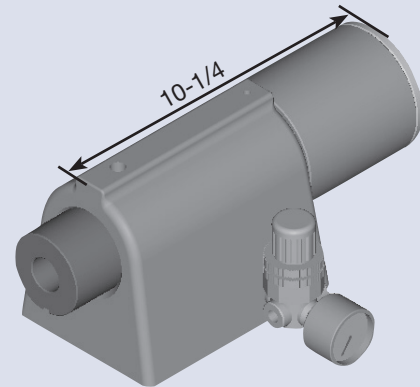


Quick change set-up for machining on your 4 axis machine or indexing head or dividing head

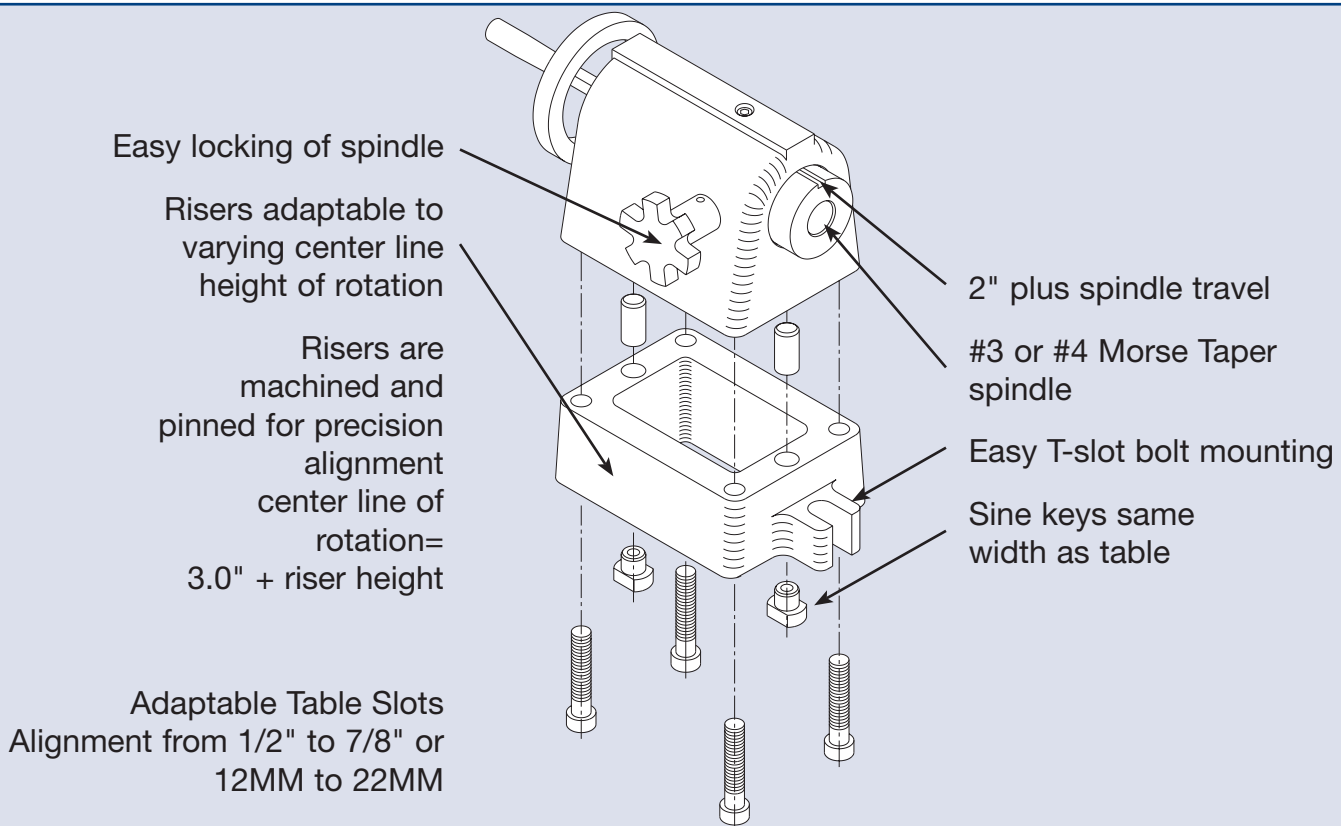
**NOTE:**

Depending upon size of base, base will be larger than top.

**Easily
Indicated for
Squareness**



Pneumatic Design
Same Dimension as Mechanical Drawing



NOTE: for the ease of installation, align sine-keys to mill table before the assembly of the total unit.

PNEUMATIC UNIVERSAL AIR DRIVEN TAILSTOCK

- ◆ 2 1/4" stroke or spindle travel
- ◆ 80 psi working pressure
- ◆ 500 lbs working thrust load
- ◆ #3 or #4 Morse taper spindle
- ◆ Riser height from 3/4" to 6"
- ◆ Easily indicated for squareness
- ◆ Self-Centering and Self-Alignment

**MANUAL
H&R Part No.**

HR-TS-#3
HR-TS-#4

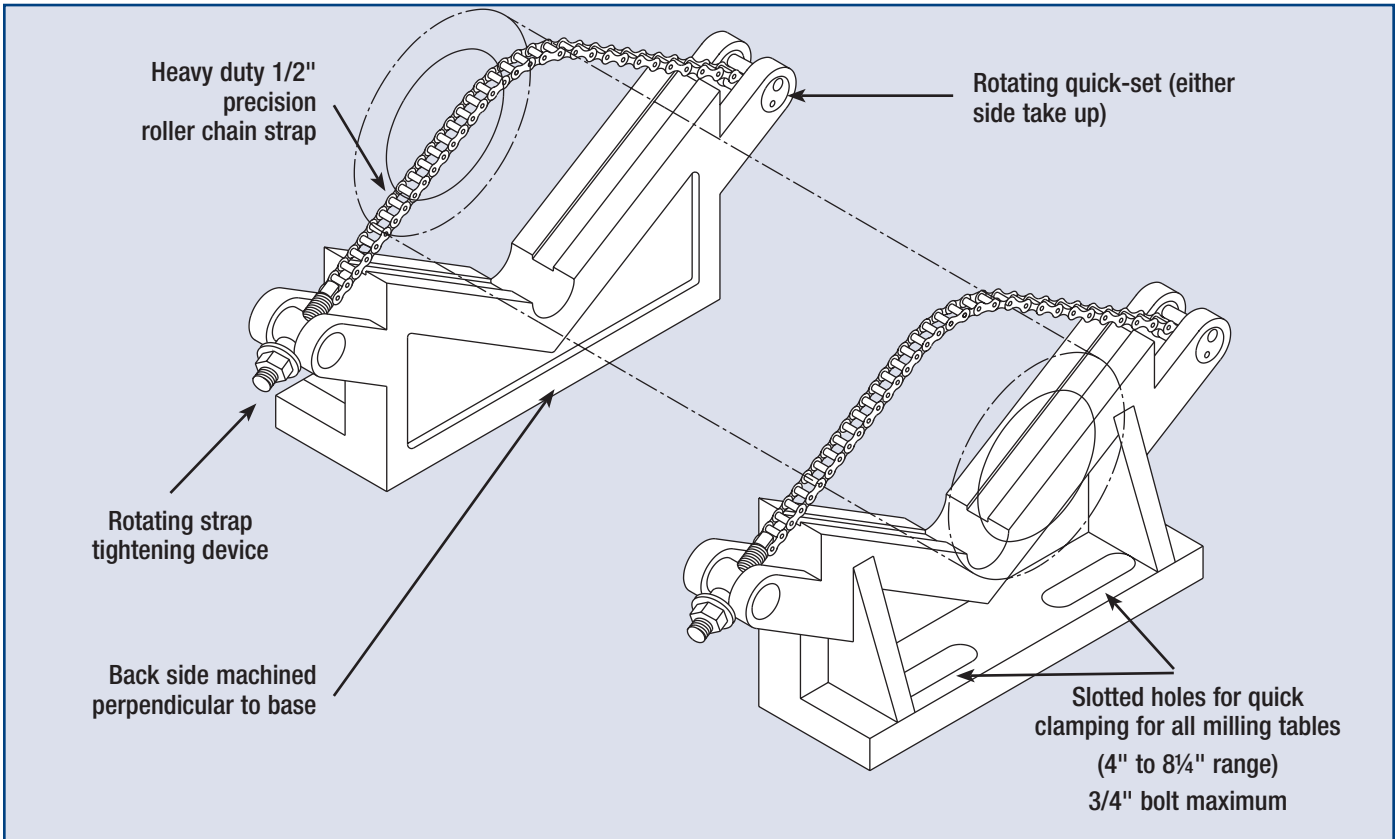
**PNEUMATIC
H&R Part No.**

HR-AIR-TS-#3
HR-AIR-TS-#4

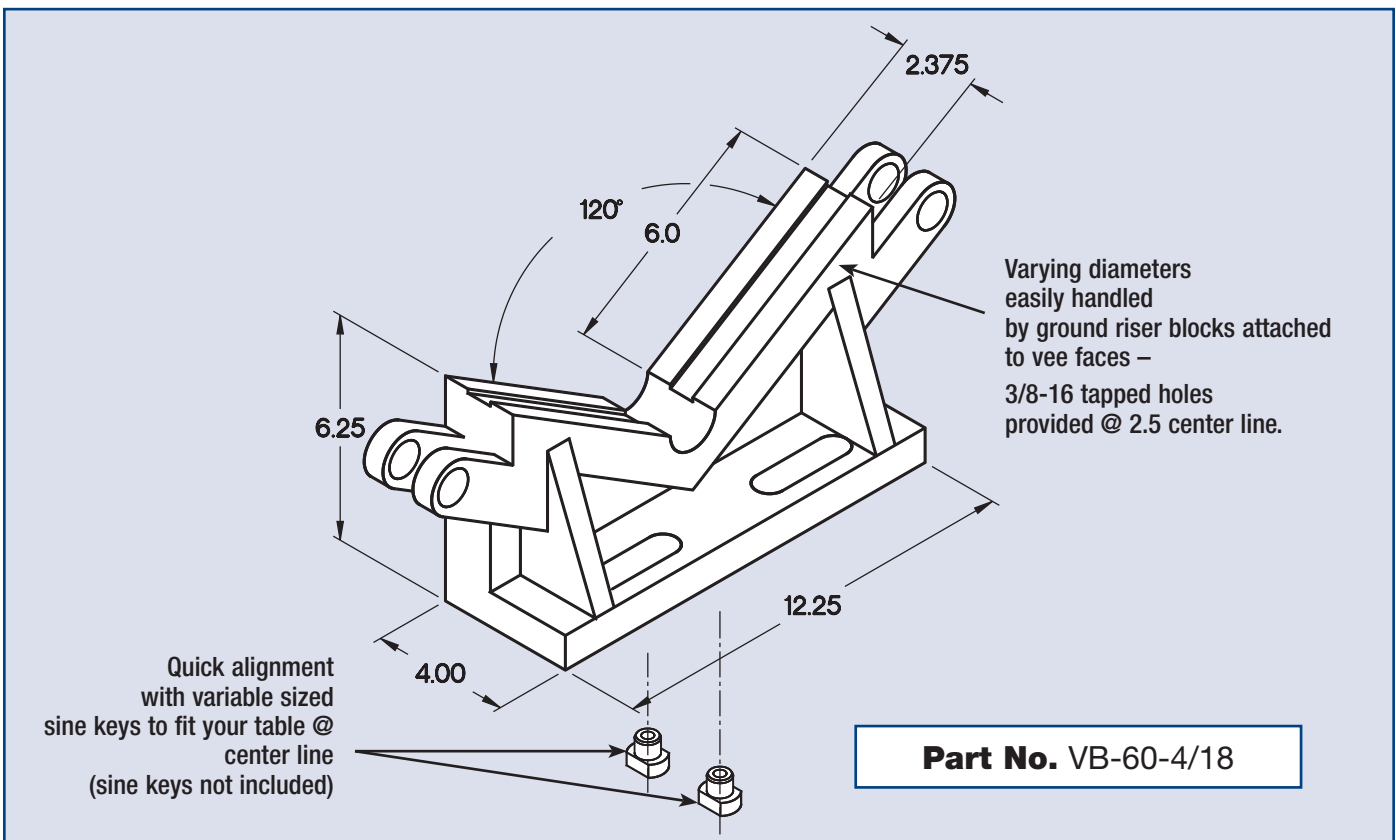
EXTRA HEAVY CAST IRON construction for strength and durability



4" to 18" diameter capacity

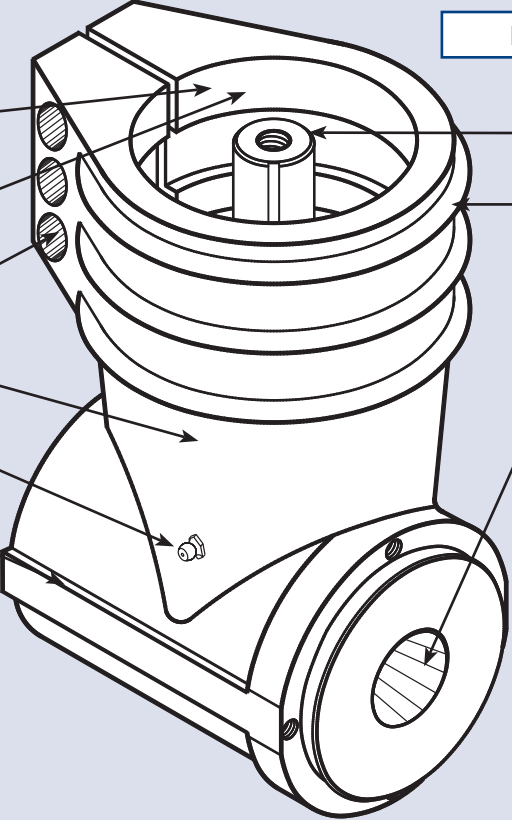


Heavy duty cast iron to reduce vibration



Sold in set of **TWO** one **RIGHT** & one **LEFT**

Buy the best right angle drive



NOTE: Special draw bar required.

RT-STD for 3 3/8" quill
R-8 to R-8 Taper

RT-STD-30 for 3 3/8" quill #30
National Standard Taper to R-8

Spreader Bolt

ALL CAST STEEL BODY

Packed in
molybdenum grease

Alignment flat
both sides

1800 RPM input maximum
1350 RPM output

Ribbed support for strength

Special hardened and ground spiral
bevel gears 1.33 to 1 gear reduction
ratio

R-8 Spindles are quality inspected in
testing before shipment .001 T.I.R.
Max.

TAPERED ROLLER BEARINGS
Both ends for better tolerance and
higher quality performance

Approximate Weight
20 Pounds

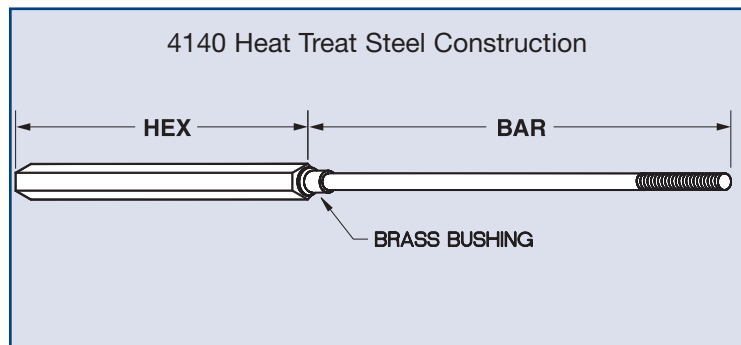
H&R Part No.
RT-STD

H&R Part No.
RT-STD-30

AVAILABLE IN STOCK

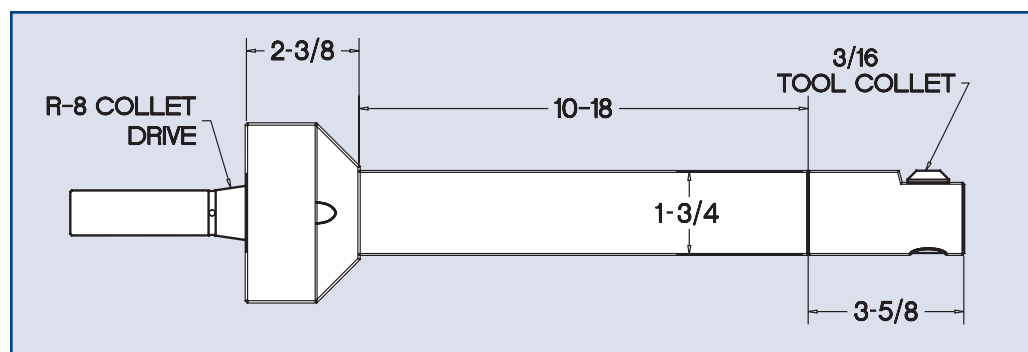
Extended Draw Bar with 7/16-20 Threaded End

Part No.	Hex Length	Bar Length	Machine Specifications
HR-DB-1	2"	18"	Bridgeport Stephead
HR-DB-2	5"	18"	Bridgeport Stephead
HR-DB-3	8"	18"	Bridgeport RAA
HR-DB-4	8"	19"	Lagun Varispeed Alliant
HR-DB-5	11"	18"	Index Varispeed Index RAA Lagun RAA



Light Duty Extension

Mounts with 3 @ 1/4" bolts
to H&R
right angle drive only



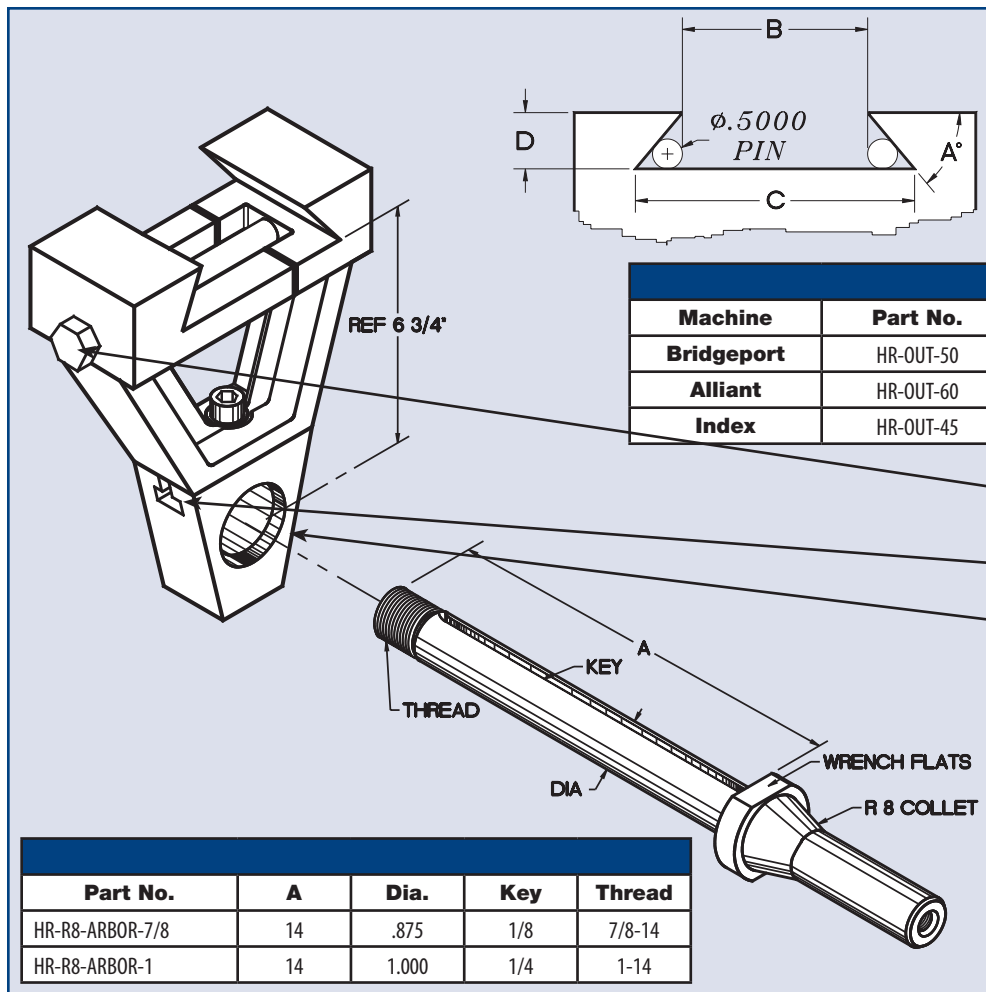
RIGHT ANGLE DRIVE ACCESSORIES



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R-8 Machine Arbor

**HEAVY
CAST IRON**



Machine	Part No.	A	B	C	D
Bridgeport	HR-OUT-50	50°	3.730	5.200	1.140
Alliant	HR-OUT-60	60°	3.937	5.250	1.230
Index	HR-OUT-45	45°	5.672	7.830	1.000

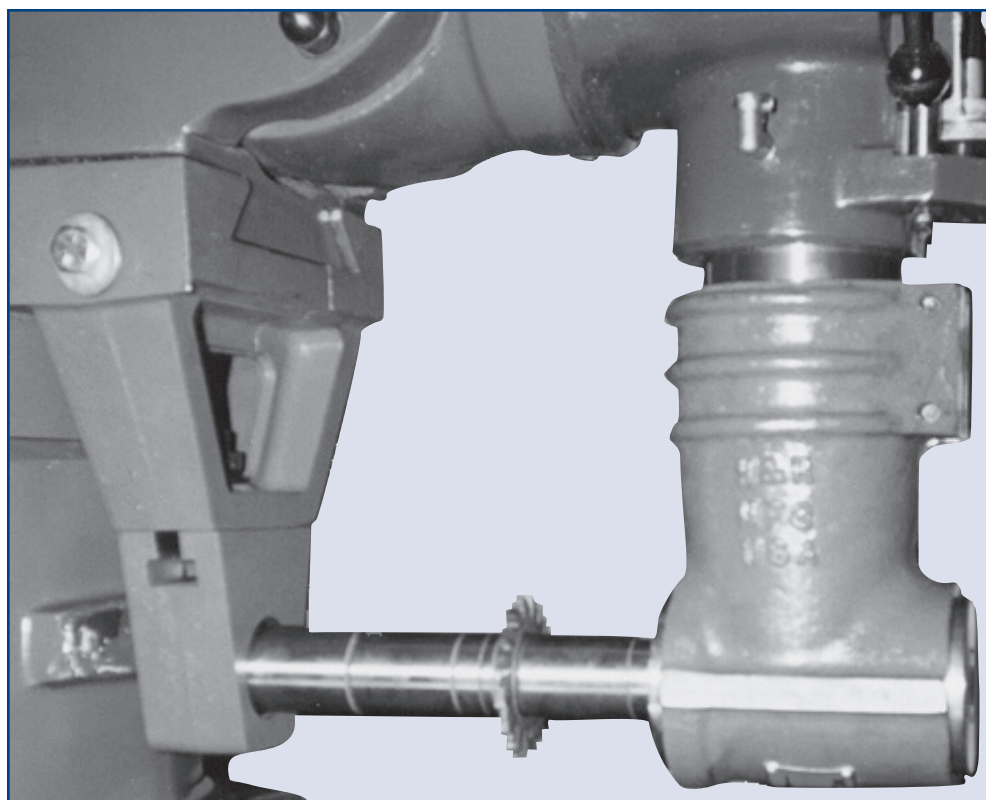
Single bolt clamp

"T" Slot for centering
and alignment

Chip guard

Arbor Assembly
Comes With

- 1) 1.625 running bushing
- 2) A series of 1/4", 1/2", 1" and 2" spacers
- 3) Nut



**Convert Your
Vertical Mill**

to a

Horizontal Mill

with a

Right Angle Drive

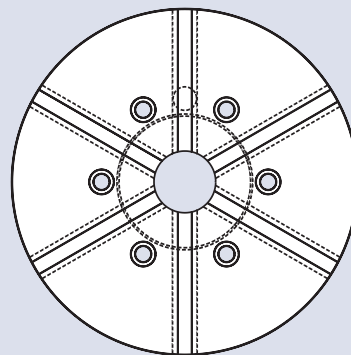
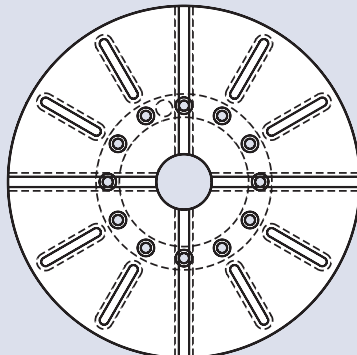
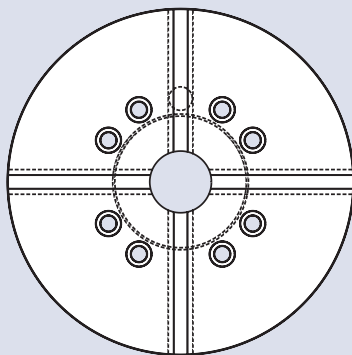
and

Arbor Support

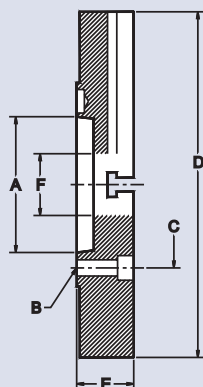
Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with or without hardware.

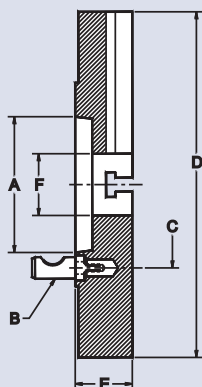
Made From Mild Steel (No Casting)



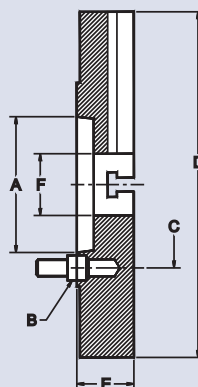
Your Choice of Any Slot Design



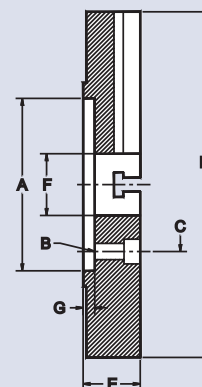
Type
"A"
A-Mount



Type
"B"
D-Mount



Type
"C"
Din-Mount



Type
"D"
Flat-Mount

H&R Part No.	Type	A	B	C	Diameter			E	F	G	H	I	J	K	Radial Slot	Bolt Size
					D1	D2	D3									
HR-A6-*	A	4.187	1/2"SHCS	5-1/4	12"	14"	~	2"	2"	N/A	9/16"	1"	1/2"	3/8"	AVAILABLE AT CUSTOMER REQUEST	1/2/13
HR-D6-*	B	4.187	0.875	5-1/4	12"	14"	~	2"	2"	N/A	9/16"	1"	1/2"	3/8"		1/2/13
HR-DIN-6-*	C	4.187	21.5MM	5-1/4	12"	14"	~	2"	2"	N/A	9/16"	1"	1/2"	3/8"		1/2/13
HR-FLAT BACK-*	D	CUSTOMER MUST SUPPLY INFORMATION							2"		9/16"	1"	1/2"	3/8"		1/2/13
HR-A8-*	A	5.5	5/8"SHCS	6-3/4	14"	16"	18"	2-1/4	2"	N/A	9/16"	1"	1/2"	3/8"		1/2/13
HR-D8-*	B	5.5	1	6-3/4	14"	16"	18"	2-1/4	2"	N/A	9/16"	1"	1/2"	3/8"		1/2/13
HR-DIN-8-*	C	5.5	27MM	6-3/4	14"	16"	18"	2-1/4	2"	N/A	9/16"	1"	1/2"	3/8"		1/2/13
HR-FLAT BACK-*	D	CUSTOMER MUST SUPPLY INFORMATION							2"		9/16"	1"	1/2"	3/8"		1/2/13
HR-A11-*	A	7.75	3/4" SHCS	9-1/4	16"	18"	20"	2-3/4	2"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-D11-*	B	7.75	1.187	9-1/4	16"	18"	20"	2-3/4	2"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-DIN-11-*	C	7.75	34MM	9-1/4	16"	18"	20"	2-3/4	2"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-FLAT BACK-*	D	CUSTOMER MUST SUPPLY INFORMATION							3"		3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-A15-*	A	11.25	7/8" SHCS	13	20"	24"	28"	3-1/4	3"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-D15-*	B	11.25	1.375	13	20"	24"	28"	3-1/4	3"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-DIN-15-*	C	11.25	41MM	13	20"	24"	28"	3-1/4	3"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-FLAT BACK-*	D	CUSTOMER MUST SUPPLY INFORMATION							3"		3/4"	1-1/4	3/4"	31/64"		5/8/11
HR-A20-*	A	16.25	1" SHCS	18-1/4	28"	30"	36"	3-1/2	3"	N/A	3/4"	1-1/4	3/4"	31/64"		5/8/11

*After above Part Number put (D1, D2, D3) per your requirement.

"A" TYPE CONVERSION ADAPTERS

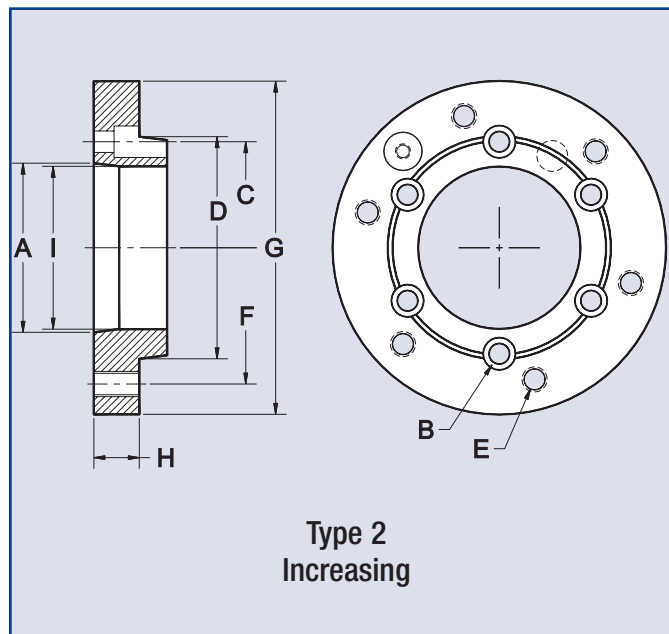
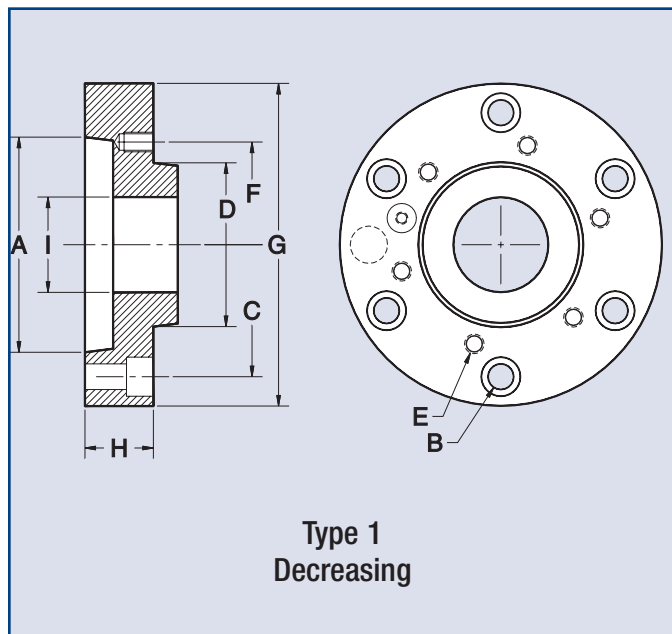


**ALL PRODUCTS
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Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with UNC or Metric Mounting Bolt

Made From Mild Steel (No Casting)



H&R Part No.	Spindle Machine						Chuck							
	Type	Mount	A	Bolt B (in.)	Bolt B (MM)	Dia. C	Mount	D	Tap E (in.)	Tap E (MM)	Dia. F	Dia. G	Offset H	Hole I
HR-A5-A6	2	5	3.25	7/16"	10MM	4.125	6	4.187	1/2X13	12X1.75	5.25	6.5	1	2.5
HR-A5-A8	2	5	3.25	7/16"	10MM	4.125	8	5.5	5/8X11	16X2	6.75	8.25	1.125	3
HR-A6-A5	1	6	4.187	1/2"	12MM	5.25	5	3.25	7/16X14	10X1.5	4.125	6.5	1.5	1.7
HR-A6-A8	2	6	4.187	1/2"	12MM	5.25	8	5.5	5/8X11	16X2	6.75	8.25	1.125	3.25
HR-A6-A11	2	6	4.187	1/2"	12MM	5.25	11	7.75	3/4X10	20X2.5	9.25	11	1.375	4
HR-A8-A6	1	8	5.5	5/8"	16MM	6.75	6	4.187	1/2X13	12X1.75	5.25	8.25	1.75	2.5
HR-A8-A11	2	8	5.5	5/8"	18MM	6.75	11	7.75	3/4X10	20X2.5	9.25	11	1.375	5.25
HR-A8-A15	2	8	5.5	5/8"	16MM	6.75	15	11.25	7/8X9	22X2.5	13	15	1.625	5.25
HR-A11-A6	1	11	7.75	3/4"	20MM	9.25	6	4.187	1/2X13	12X1.75	5.25	11	1.75	2.5
HR-A11-A8	1	11	7.75	3/4"	20MM	9.25	8	5.5	5/8X11	16X2	6.75	11	1.875	3.25
HR-A11-A15	2	11	7.75	3/4"	20MM	9.25	15	11.25	7/8X9	22X2.5	13	15	1.625	7.5
HR-A11-A20	2	11	7.75	3/4"	20MM	9.25	20	16.25	1X8	24X3	18.25	20.5	1.875	7.5
HR-A15-A8	1	15	11.25	7/8"	22MM	13	8	5.5	5/8X11	16X2	6.75	15	2	3.25
HR-A15-A11	1	15	11.25	7/8"	22MM	13	11	7.5	3/4X10	20X2.5	9.25	15	2.25	5.25
HR-A15-A20	2	15	11.25	7/8"	22MM	13	20	16.25	1X8	24X3	18.25	20.5	1.875	11
HR-A20-A11	1	20	16.25	1"	24MM	18.25	11	7.75	3/4X10	20X2.5	9.25	20.5	2.125	5.25
HR-A20-A15	1	20	16.25	1"	24MM	18.25	15	11.25	7/8X9	22X2.5	13	20.5	2.5	8.25

SPECIFY METRIC OR INCH REQUIREMENTS WHEN ORDERING

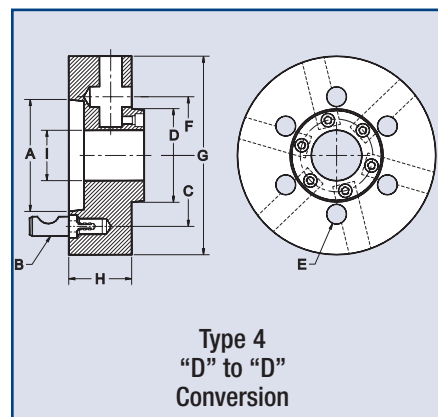
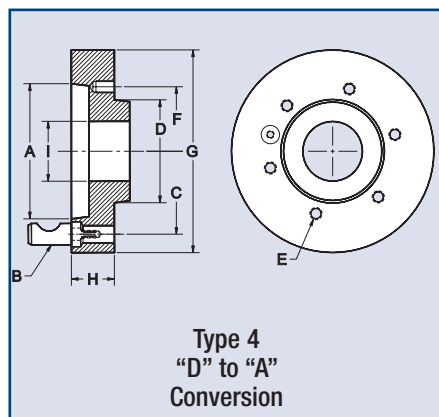
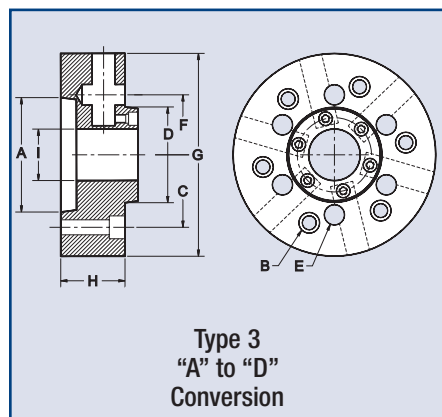
Note:

- ◆ Spindle and Chuck mountings are outer bolt circle type A2.
- ◆ "B" bolts are total of 6 equally spaced 60 DEG. Apart on a bolt circle of "C".
- ◆ "E" tapped holes are a total of 12 equally spaced 30 DEG. Apart on a bolt circle of "F".
- ◆ Drive button included.

Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with or without hardware

Made From Mild Steel (No Casting)



H&R Part No.	Type	Spindle Mount			Chuck Mount			Offset G	I.D. H	I
		A	B	C	D	E	O.D. F			
HR-A5-D5	3	3.25	7/16"	4-1/8	3.25	0.781	4-1/8	5-3/4	1-1/2	1-3/4
HR-A5-D6	3	3.25	7/16"	4-1/8	4.187	0.906	5-1/4	7-1/8	1-3/4	2-1/4
HR-D5-A5	4	3.25	0.75	4-1/8	3.25	7/16"-14"	4-1/8	5-3/4	1-1/2	2-5/8
HR-D5-D6	5	3.25	0.75	4-1/8	4.187	0.906	5-1/4	7-1/8	1-3/4	1-3/4
HR-A6-D6	3	4.187	1/2"	5-1/4	4.187	0.906	5-1/4	7-1/8	1-3/4	2-1/4
HR-A6-D8	3	4.187	1/2"	5-1/4	5.5	1.031	6-3/4	8-7/8	2	3-3/8
HR-D6-A6	4	4.187	0.875	5-1/4	4.187	1/2"-13"	5-1/4	7-1/8	1-5/8	3-4/9
HR-D6-A8	4	4.187	0.875	5-1/4	5.5	5/8"-11"	6-3/4	8-1/4	1-3/4	3-4/9
HR-D6-D8	5	4.187	0.875	5-1/4	5.5	1.031	6-3/4	8-7/8	2	2-1/4
HR-A8-D6	3	5.5	5/8"	6-3/4	4.187	0.906	5-1/4	8-1/4	1-3/4	2-1/4
HR-A8-D8	3	5.5	5/8"	6-3/4	5.5	1.031	6-3/4	8-7/8	2	3-3/8
HR-A8-D11	3	5.5	5/8"	6-3/4	7.75	1.218	9-1/4	11-3/4	2-3/8	5-3/8
HR-D8-A6	4	5.5	1	6-3/4	4.187	1/2"-13"	5-1/4	8-7/8	1-3/4	3-4/9
HR-D8-A8	4	5.5	1	6-3/4	5.5	5/8"-11"	6-3/4	8-7/8	1-3/4	4-5/8
HR-D8-A11	4	5.5	1	6-3/4	7.75	3/4"-10"	9-1/4	11	2	4-5/8
HR-D8-A15	4	5.5	1	6-3/4	11.25	7/8"-9"	13	15	2-1/4	4-5/8
HR-D8-D6	5	5.5	1	6-3/4	4.187	0.906	5-1/4	8-7/8	2	2-1/4
HR-D8-D11	5	5.5	1	6-3/4	7.75	1.218	9-1/4	11-3/4	2-3/8	3-3/8
HR-A11-D8	3	7.75	3/4"	9-1/4	5.5	1.031	6-3/4	11	3-1/2	3-3/8
HR-A11-D11	3	7.75	3/4"	9-1/4	7.75	1.218	9-1/4	11-3/4	2-3/8	5-3/8
HR-A11-D15	3	7.75	3/4"	9-1/4	11.25	1.406	13	15-7/8	2-3/4	7-37/64
HR-D11-A8	4	7.75	1.187	9-1/4	5.5	5/8"-11"	6-3/4	11-3/4	2-1/4	4-5/8
HR-D11-A11	4	7.75	1.187	9-1/4	7.75	3/4"-10"	9-1/4	11-3/4	2-1/4	6-3/4
HR-D11-A15	4	7.75	1.187	9-1/4	11.25	7/8"-9"	13	15	2-1/2	6-3/4
HR-D11-A20	4	7.75	1.187	9-1/4	16.25	1"-8"	18-1/4	20-1/4	2-3/4	6-3/4
HR-D11-D8	5	7.75	1.187	9-1/4	5.5	0.906	6-3/4	11-3/4	2-1/4	3-3/8
HR-D11-D15	5	7.75	1.187	9-1/4	11.25	1.406	13	15-7/8	2-3/4	5-3/8
HR-A15-D8	3	11.25	7/8"	13	5.5	1.031	6-3/4	15	3-7/8	3-3/8
HR-A15-D11	3	11.25	7/8"	13	7.75	1.218	9-1/4	15	4	5-3/8
HR-A15-D15	3	11.25	7/8"	13	11.25	1.406	13	15-7/8	2-3/4	8-3/8
HR-D15-A11	4	11.25	1.375	13	7.75	3/4"-10"	9-1/4	15-7/8	2-1/2	6-3/4
HR-D15-A15	4	11.25	1.375	13	11.25	7/8"-9"	13	15-7/8	2-1/2	10-1/8
HR-D15-A20	4	11.25	1.375	13	16.25	1"-8"	18-1/4	20-1/4	2-3/4	10-1/8
HR-D15-D11	5	11.25	1.375	13	7.75	1.218	9-1/4	15 7/8	2-3/4	5 3/8
HR-D15-D20	5	11.25	1.375	13	16.25	1.656	18 1/4	21 1/2	3	8 3/8

"L" TYPE CONVERSION ADAPTERS

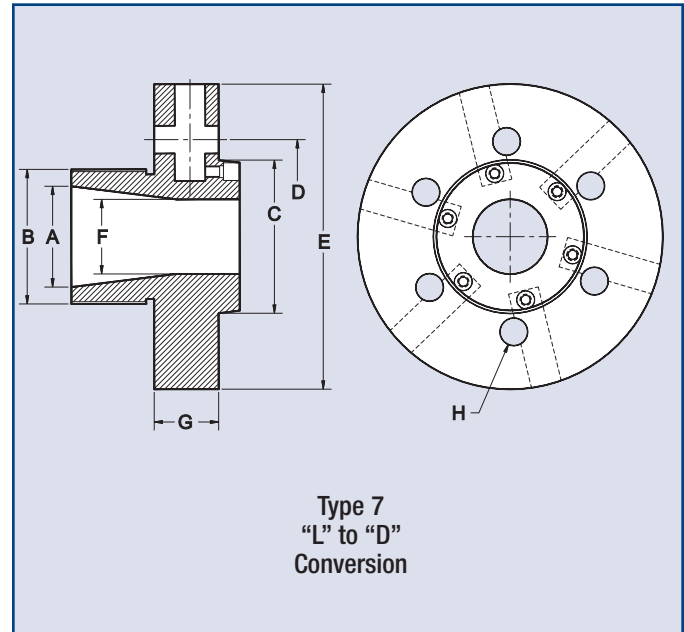
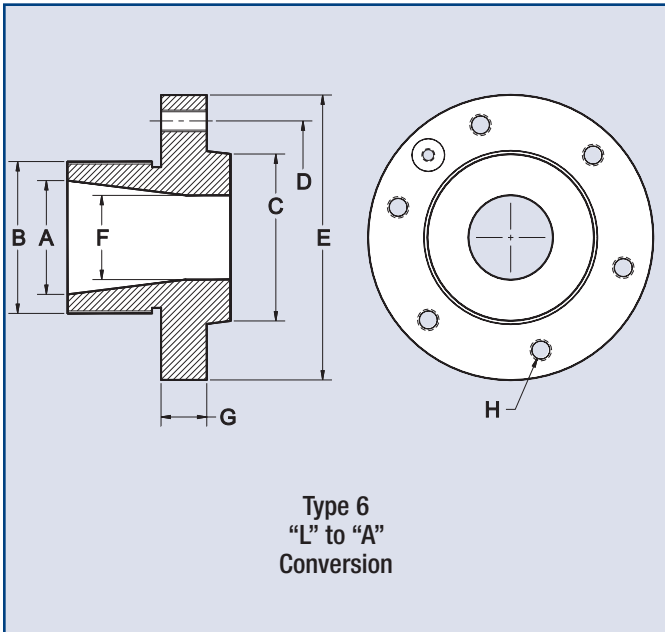


**ALL PRODUCTS
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IN THE USA**

Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with or without hardware

Made From Mild Steel (No Casting)

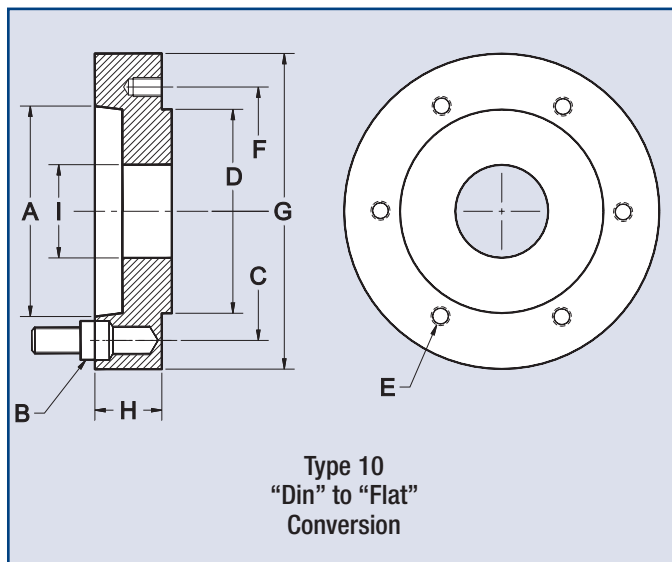
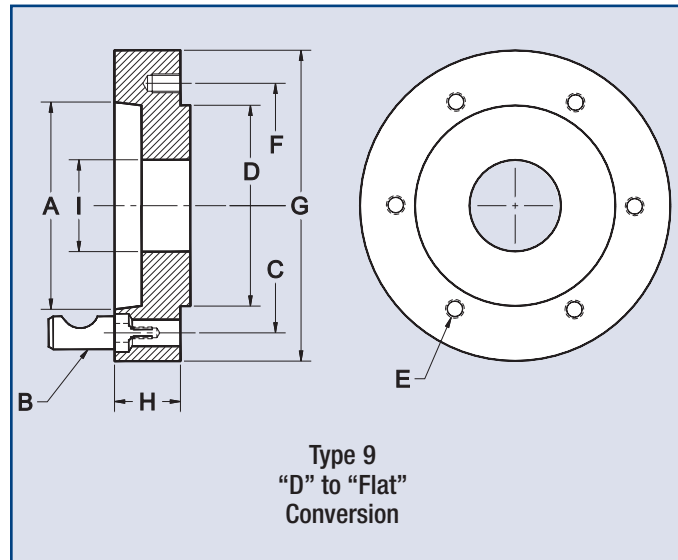
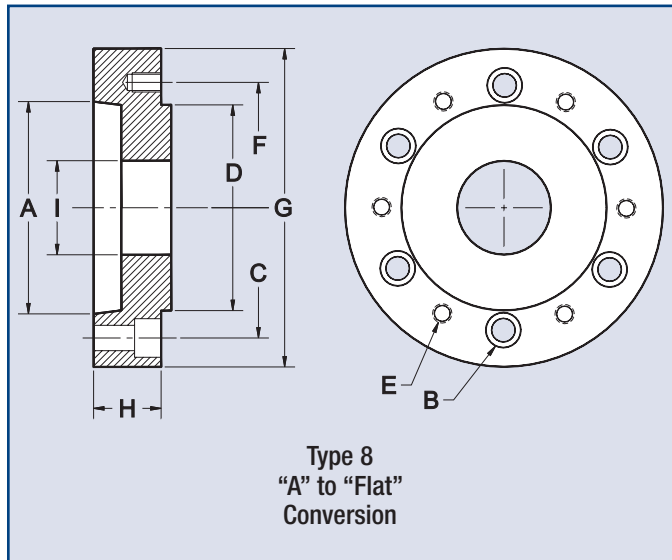


H&R Part No.	Type	A	B	C	D	E	F	G	H
HR-L00-A6	6	2.75	3.745	4.187	5-1/4	6-1/2	2	1-1/4	1/2"-13"
HR-L00-D6	7	2.75	3.745	4.187	5-1/4	7-1/8	2	1-3/4	0.906
HR-L00-A8	6	2.75	3.745	5.5	6-3/4	8-1/4	2	1-1/2	5/8"-11"
HR-L00-D8	7	2.75	3.745	5.5	6-3/4	8-7/8	2	2	1.031
HR-L0-A8	6	3.25	4.495	5.5	6-3/4	8-1/4	2-1/2	1-1/2	5/8"-11"
HR-L0-D8	7	3.25	4.495	5.5	6-3/4	8-7/8	2-1/2	2	1.031
HR-L0-A11	6	3.25	4.495	7.75	9-1/4	11	2-1/2	1-3/4	3/4"-10"
HR-L0-D11	7	3.25	4.495	7.75	9-1/4	11-3/4	2-1/2	2-3/8	1.218
HR-L1-A8	6	4.125	5.995	5.5	6-3/4	8-1/4	3-5/8	1-1/2	5/8"-11"
HR-L1-D8	7	4.125	5.995	5.5	6-3/4	8-7/8	3-5/8	2	1.031
HR-L1-A11	6	4.125	5.995	7.75	9-1/4	11	3-5/8	1-3/4	3/4"-10"
HR-L1-D11	7	4.125	5.995	7.75	9-1/4	11-3/4	3-5/8	2-3/8	1.218
HR-L1-A15	6	4.125	5.995	11.25	13	15	3-5/8	2	7/8"-9"
HR-L1-D15	7	4.125	5.995	11.25	13	15-7/8	3-5/8	2-3/4	1.406
HR-L2-A8	6	5.25	7.745	5.5	6-3/4	8-1/4	4-1/2	1-1/2	5/8"-11"
HR-L2-D8	7	5.25	7.745	5.5	6-3/4	8-7/8	4-1/2	2	1.031
HR-L2-A11	6	5.25	7.745	7.75	9-1/4	11	4-1/2	1-3/4	3/4"-10"
HR-L2-D11	7	5.25	7.745	7.75	9-1/4	11-3/4	4-1/2	2-3/8	1.218
HR-L2-A15	6	5.25	7.745	11.25	13	15	4-1/2	2	7/8"-9"
HR-L2-D15	7	5.25	7.745	11.25	13	15-7/8	4-1/2	2-3/4	1.406
HR-L3-A11	6	6.5	10.37	7.75	9-1/4	11	5-1/2	1-3/4	3/4"-10"
HR-L3-D11	7	6.5	10.37	7.75	9-1/4	11-3/4	5-1/2	2-3/8	1.218
HR-L3-A15	6	6.5	10.37	11.25	13	15	5-1/2	2	7/8"-9"
HR-L3-D15	7	6.5	10.37	11.25	13	15-7/8	5-1/2	2-3/4	1.406
HR-L3-A20	6	6.5	10.37	16.25	18-1/4	20-1/2	5-1/2	2-1/2	1"-8"
HR-L3-D20	7	6.5	10.37	16.25	18-1/4	21-1/2	5-1/2	3-1/4	1.656

Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with or without hardware

Made From Mild Steel (No Casting)


Customer Supplied Information

"D" Diameter of Chuck Mount _____

"E" Thread size of Mounting Holes _____

"F" Bolt circle of Mounting Holes _____

"G" Outside Diameter _____

"I" Inside Diameter _____

"H" Depth of Chuck Mount _____

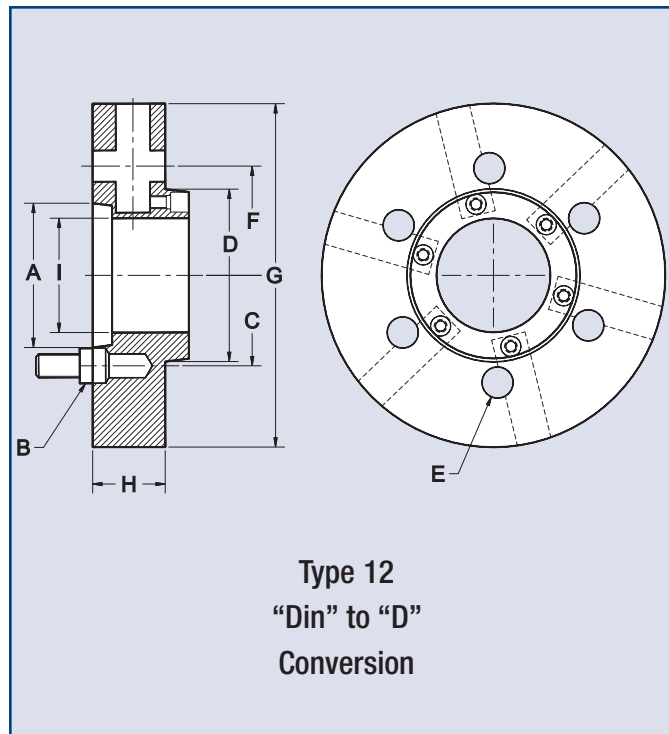
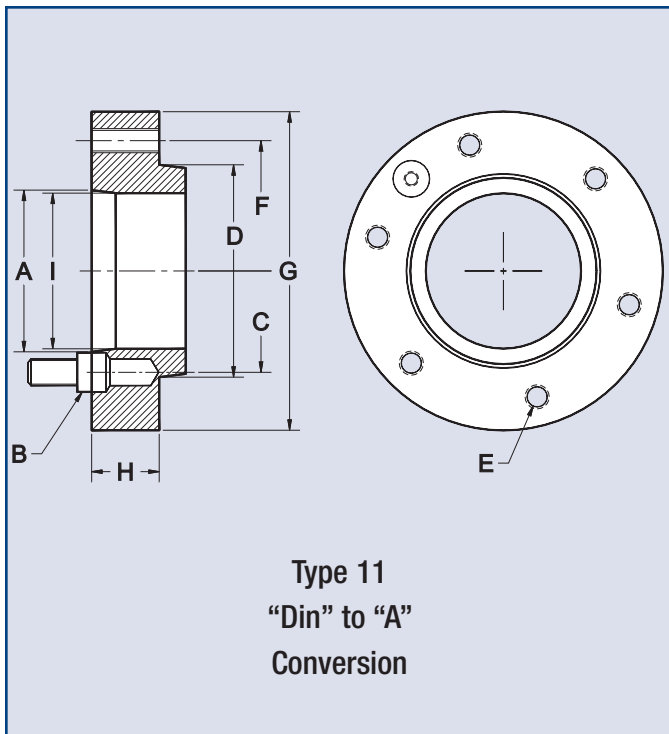
H&R Part No.	Type	A	B	C	D	E	F	G	Minimum H	I	J
HR-A5 TO FLAT	8	3.25	7/16" SHCS	4-1/8	CUSTOMER TO SUPPLY INFORMATION				1"		
HR-D5 TO FLAT	9	3.25	.750 STUD	4-1/8					1-1/2		
HR-DIN 5 TO FLAT	10	3.25	19.5/M-10	4-1/8					1-1/2		
HR-A6 TO FLAT	8	4.187	1/2" SHCS	5-1/4					1-1/8		
HR-D6 TO FLAT	9	4.187	.875 STUD	5-1/4					1-5/8		
HR-DIN 6 TO FLAT	10	4.187	21.5/M-12	5-1/4					1-5/8		
HR-A8 TO FLAT	8	5.5	5/8" SHCS	6-3/4					1-1/4		
HR-D8 TO FLAT	9	5.5	1" STUD	6-3/4					1-3/4		
HR-DIN 8 TO FLAT	10	5.5	27/M-16	6-3/4					1-3/4		
HR-A11 TO FLAT	8	7.75	3/4" SHCS	9-1/4					1-1/2		
HR-D11 TO FLAT	9	7.75	1.187 STUD	9-1/4					2-1/4		
HR-DIN 11 TO FLAT	10	7.75	34/M-20	9-1/4					2-1/4		
HR-A15 TO FLAT	8	11.25	7/8" SHCS	13"					1-3/4		



Features:

- ◆ Dimensions are per U.S.A. Standards.
- ◆ Available with or without hardware

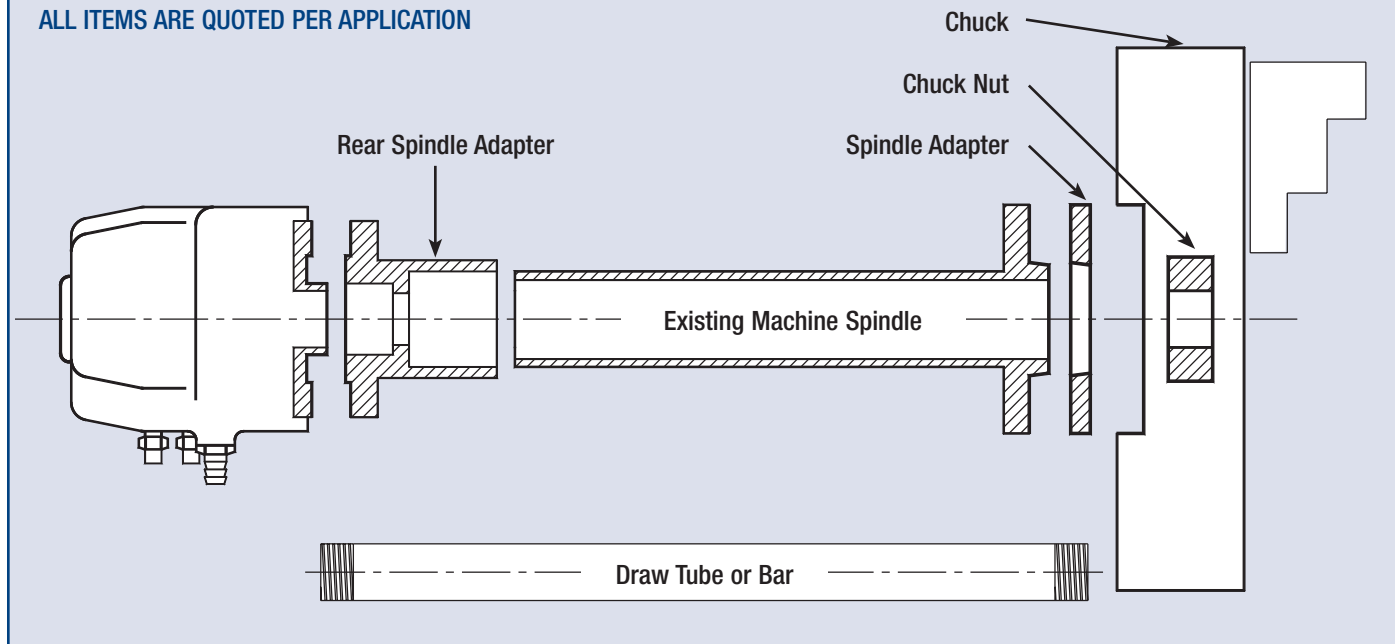
Made From Mild Steel (No Casting)



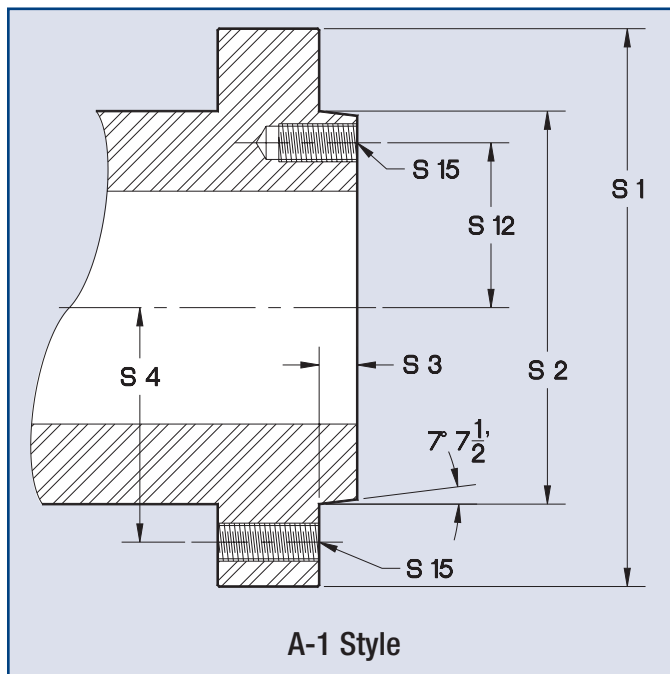
H&R Part No.	Type	Spindle Mount				Chuck Mount					
		A	B1	B2	C	D	E	F	G	H	I
HR-DIN-5 TO A5	11	3.25	19.5MM	M-10	4-1/8	3.25	7/16-14	4-1/8	5-3/8	1-1/2	2-1/2
HR-DIN-5 TO A6 2-1/2	11	3.25	19.5MM	M-10	4-1/8	4.187	1/2-13		5-1/4	6-1/4	1-1/2
HR-DIN-6 TO A6 3-1/4	11	4.187	21.5MM	M-12	5-1/4	4.187	1/2/13		5-1/4	6-3/4	1-3/4
HR-DIN-6 TO D6 2-1/4	12	4.187	21.5MM	M-12	5-1/4	4.187	0.906		5-1/4	7-1/8	1-3/4
HR-DIN-6 TO A8	11	4.187	21.5MM	M-12	5-1/4	5.5	5/8/11	6-3/4	8-1/4	1-3/4	3-1/4
HR-DIN-6 TO D8	12	4.187	21.5MM	M-12	5-1/4	5.5	1.031	6-3/4	8-7/8	2	3-3/8
HR-DIN-8 TO A8	11	5.5	27MM	M-16	6-3/4	5.5	5/8/11	6-3/4	8-3/4	2	5-3/8
HR-DIN-8 TO D8	12	5.5	27MM	M-16	6-3/4	5.5	1.031	6-3/4	8-7/8	2	3 3/8
HR-DIN-8 TO A11	11	5.5	27MM	M-16	6-3/4	7.75	3/4/10	9-1/4	11	2	5-3/8
HR-DIN-8 TO D11	12	5.5	27MM	M-16	6-3/4	7.75	1.218	9-1/4	11	2-3/8	5-3/8
HR-DIN-11 TO A8	11	7.75	34MM	M-20	9-1/4	5.5	5/8/11	6-3/4	11-1/2	2-3/8	5-3/8
HR-DIN-11 TO D8	12	7.75	34MM	M-20	9-1/4	5.5	1.031	6-3/4	11-1/2	2-3/8	3-3/8
HR-DIN-11 TO A11	11	7.75	34MM	M-20	9-1/4	7.75	3/4/10	9-1/4	11-1/2	2-3/8	7-1/2
HR-DIN-11 TO D11	12	7.75	34MM	M-20	9-1/4	7.75	1.218	9-1/4	11-3/4	2-3/8	5-3/8
HR-DIN-11 TO A15	11	7.75	34MM	M-20	9-1/4	11.25	7/8/09	13	15	2-3/8	7-1/2
HR-DIN-11 TO D15	12	7.75	34 MM	M-20	9-1/4	11.25	1.406	13	15-7/8	2-3/4	7-1/2

Complete Engineered Packages or Individual Items to Customer Specifications

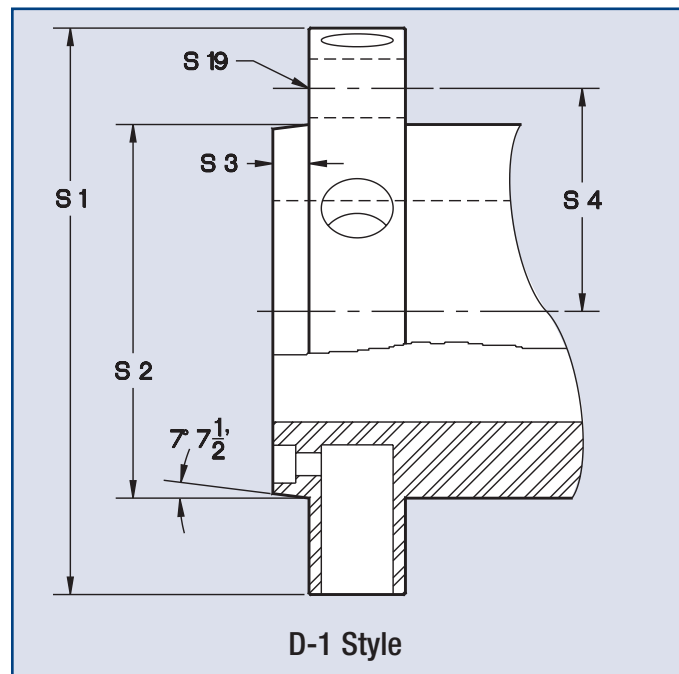
ALL ITEMS ARE QUOTED PER APPLICATION



MOUNTING STANDARDS (ASME)



A-1 Style



D-1 Style

American Standard Type A-1

DIM	A-5	A-6	A-8	A-11	A-15	A-20
S 1	5.250	6.500	8.250	11.000	15.000	20.500
S 2	3.250	4.188	5.500	7.750	11.250	16.250
S 3	.562	.625	.688	.750	.812	.875
S 4	2.063	2.625	3.375	4.625	6.500	9.125
S 12	1.219	1.625	2.188	3.250	4.875	7.250
S 15	7/16-14	1/2-13	5/8-11	3/4-10	7/8-9	1-8

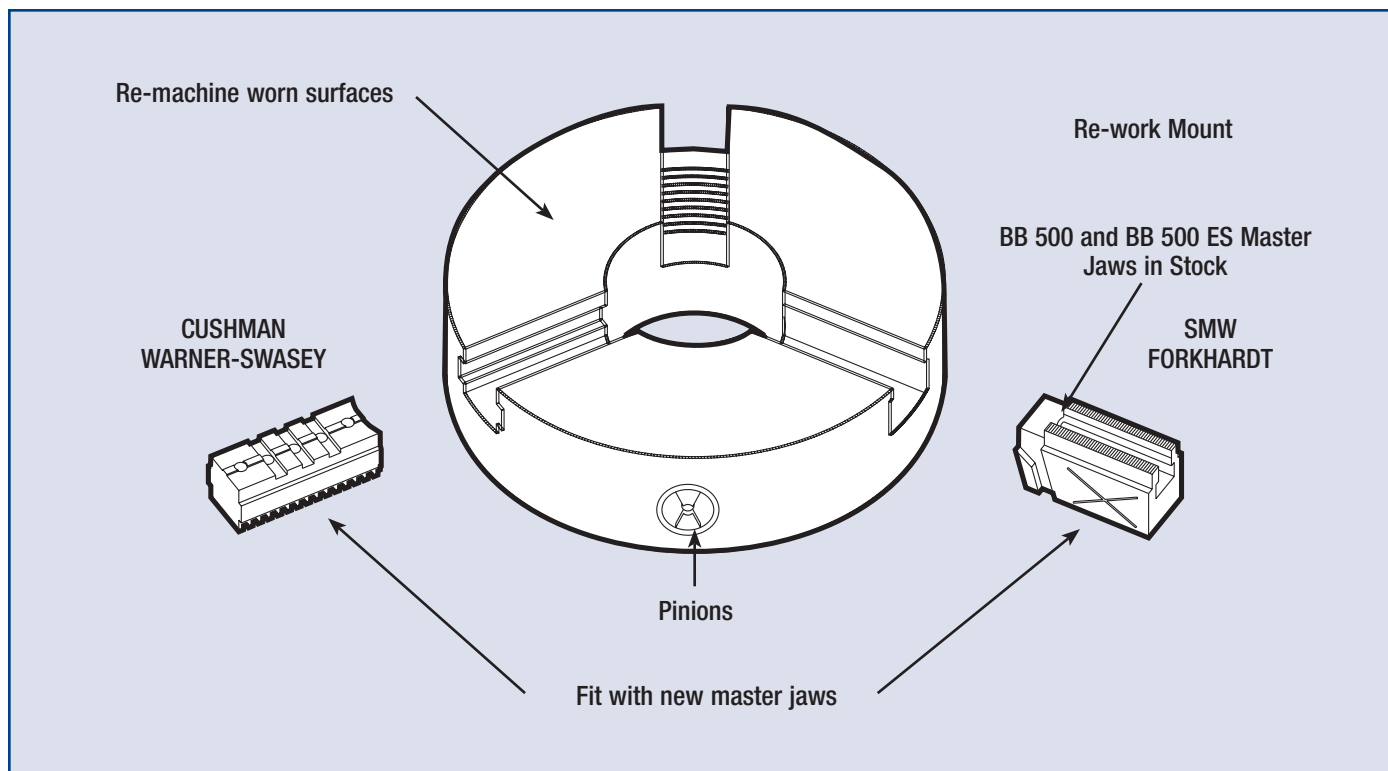
American Standard Type D-1

DIM	D-5	D-6	D-8	D-11	D-15	D-20
S 1	5.750	7.125	8.875	11.750	15.875	21.500
S 2	3.250	4.187	5.500	7.750	11.250	16.250
S 3	.500	.562	.625	.687	.750	.812
S 4	2.063	2.625	3.375	4.625	6.5	9.125
S 19	.781	.906	1.031	1.218	1.406	1.656



Self Centering Chucks

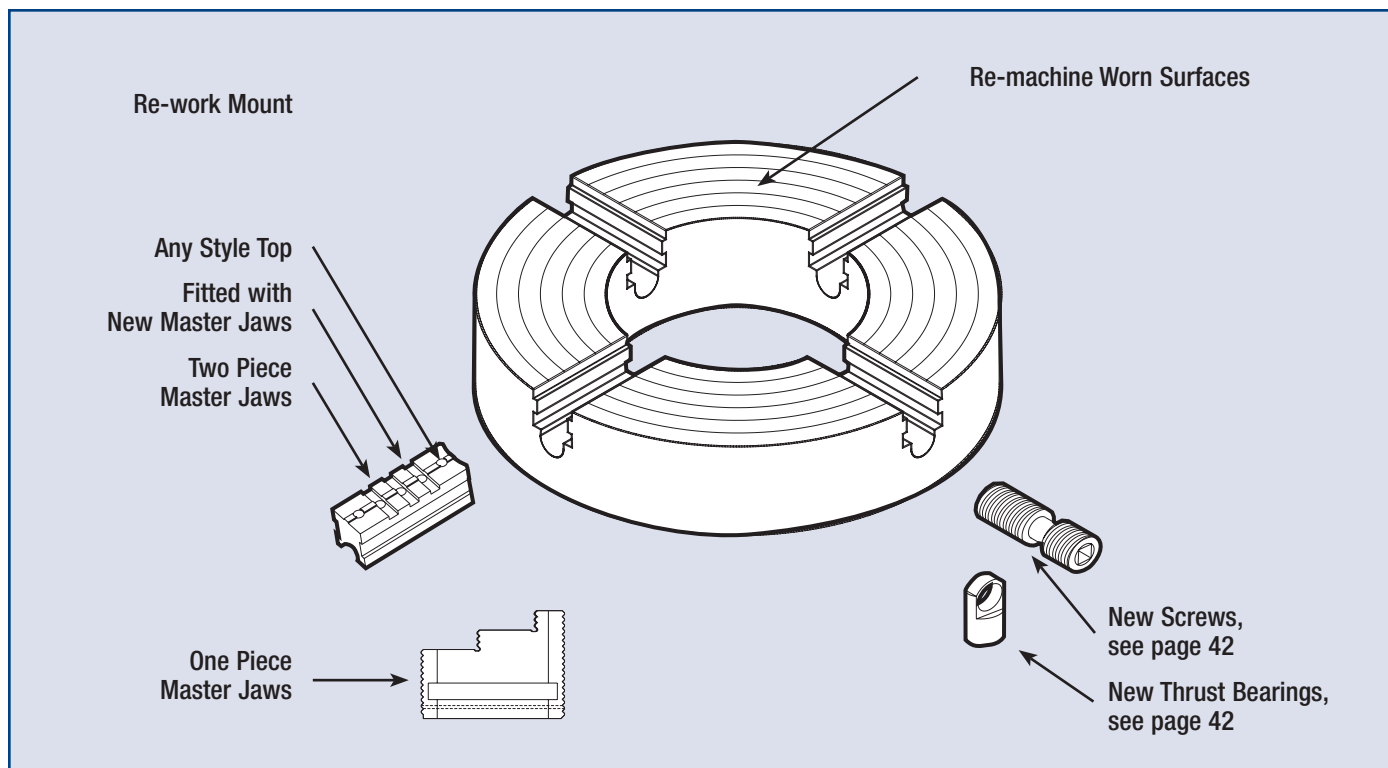
Air Chucks, Power Chucks and Scroll Chucks



O-Ring Kits for Air Chucks in Stock

Independent Chucks and Boring Mill Jaws

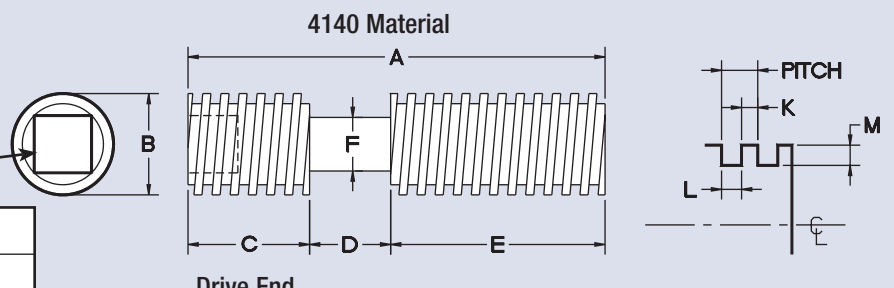
Cushman, Warner-Swasey, Union, SCA, Nobel, Skinner, Gisholt and Others



CALLFORQUOTE

Cushman Union Skinner and Others

Single End	
Double End	
Internal	
External	
Hex	
Square	
Depth	



4140 Material

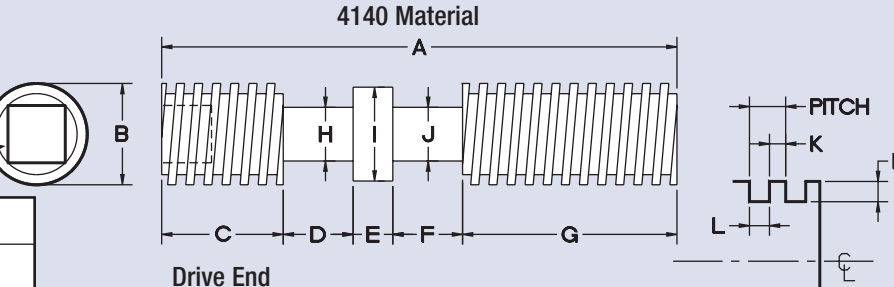
Drive End

Pitch	
Right Hand	
Left Hand	
Acme	
Square	

Qty. _____ Approved By _____ Date _____

A	B	C	D	E	F	K	L	M

Single End	
Double End	
Internal	
External	
Hex	
Square	
Depth	



4140 Material

Drive End

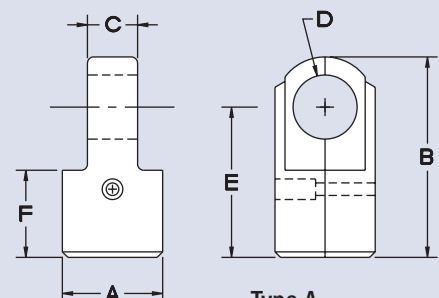
Pitch	
Right Hand	
Left Hand	
Acme	
Square	

Qty. _____ Approved By _____ Date _____

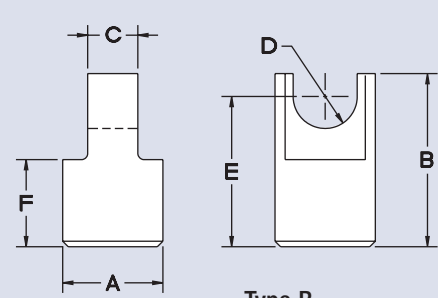
A	B	C	D	E	F	G	H	I	J	K	L	M

THRUST BEARINGS

Cushman Union Skinner and Others



Type A



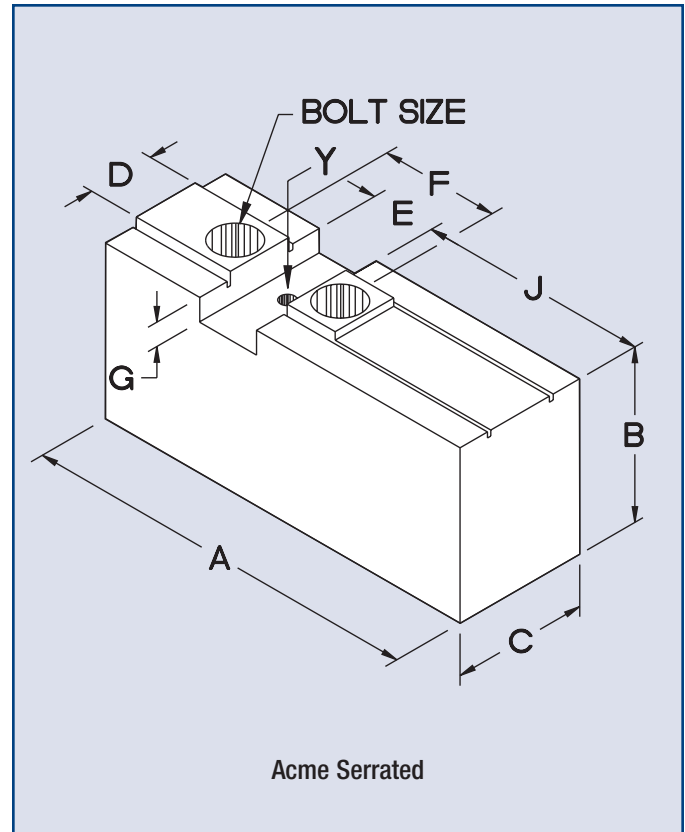
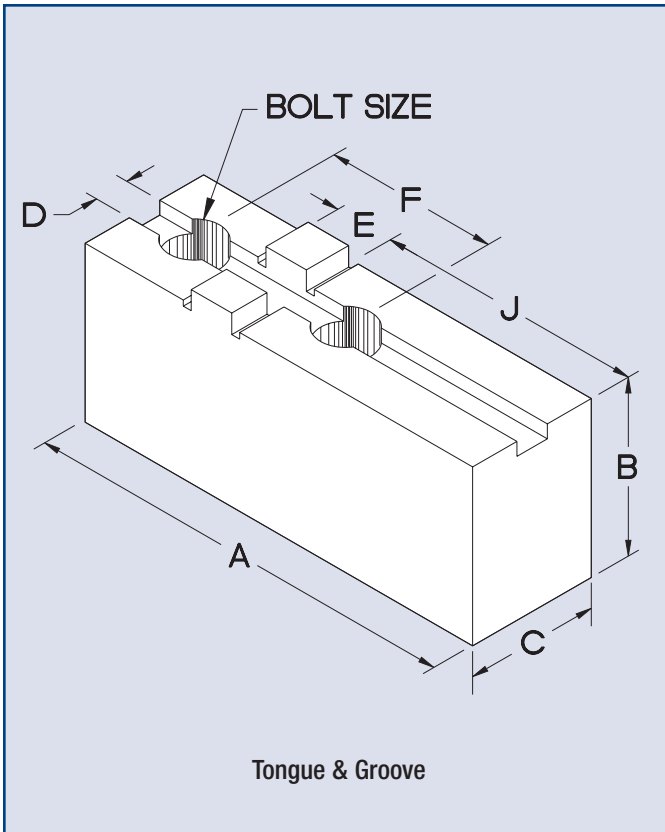
Type B

A*	B	C	D*	E	F

A*	B	C	D*	E	F

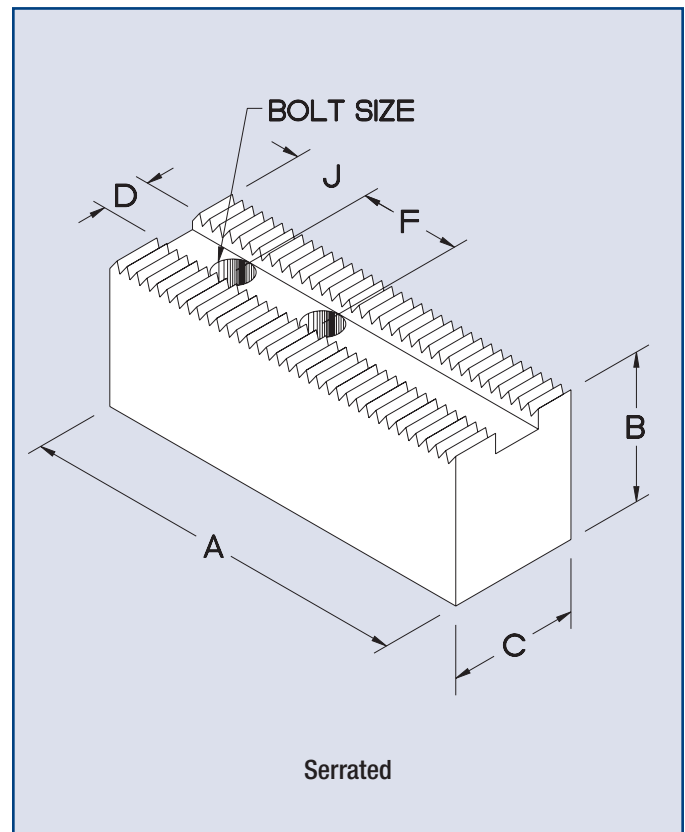
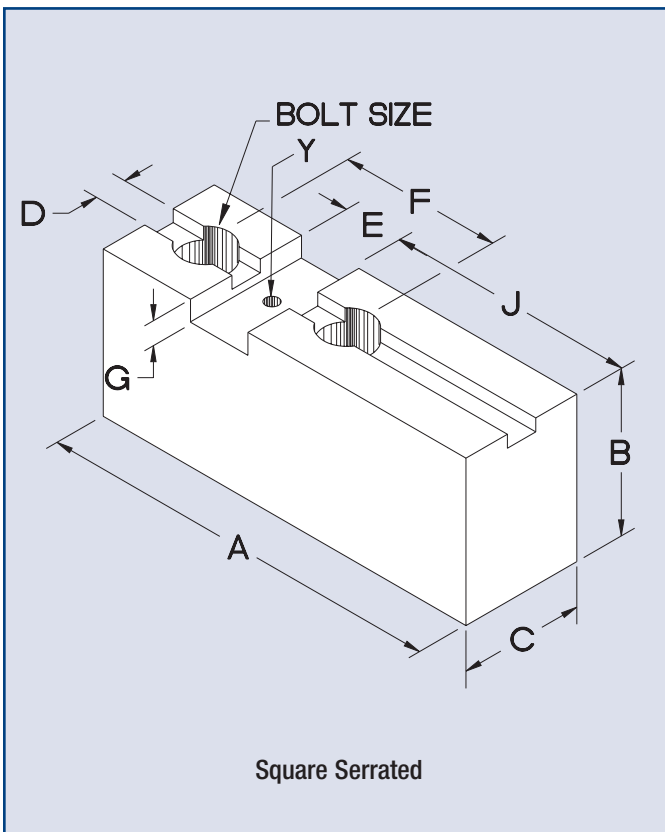
Type _____ Qty. _____ Approved By _____ Date _____

*Diameter



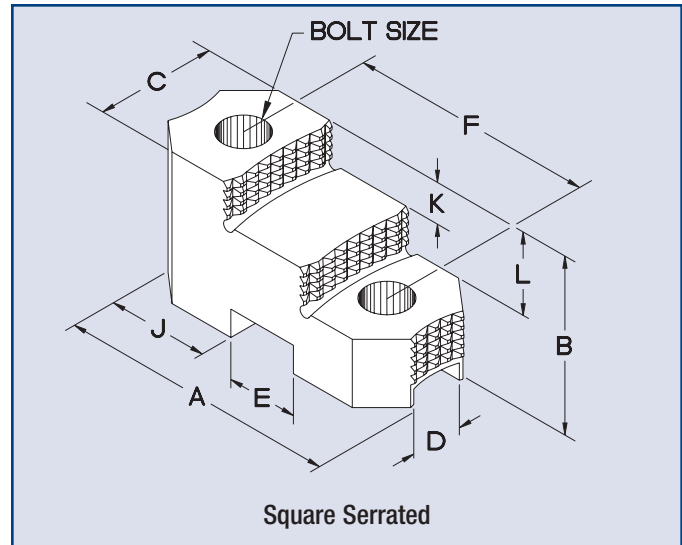
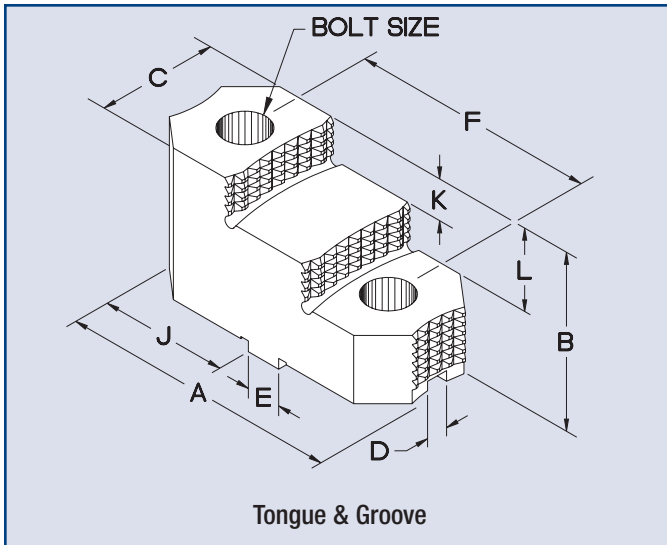
See web site for additional prints

www.hrmfg.com



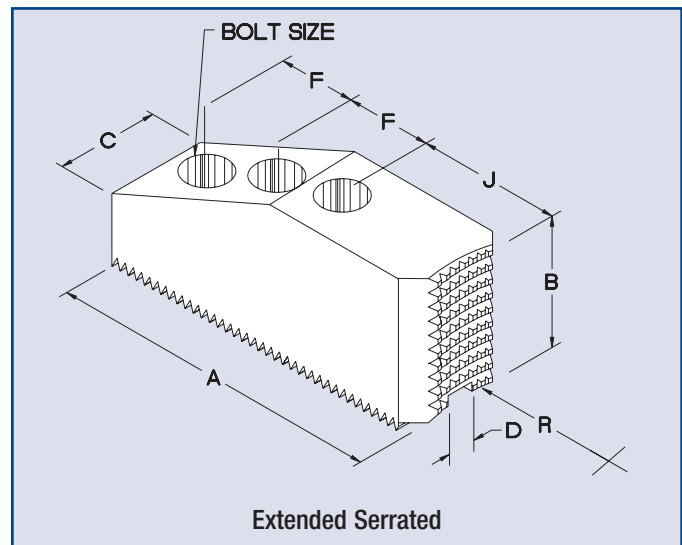
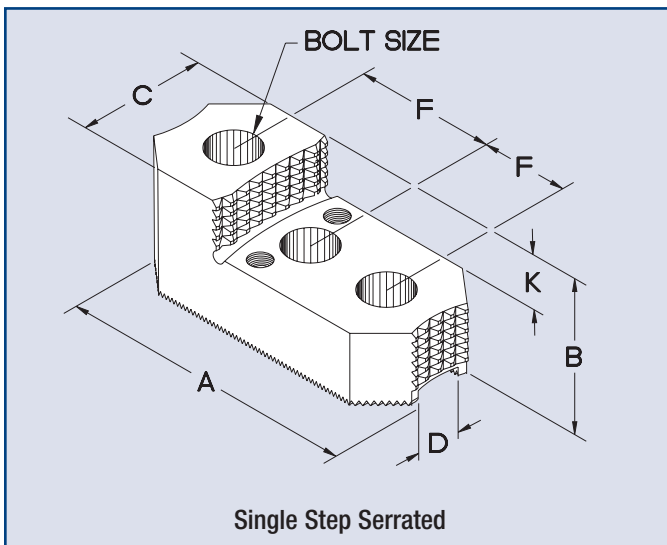
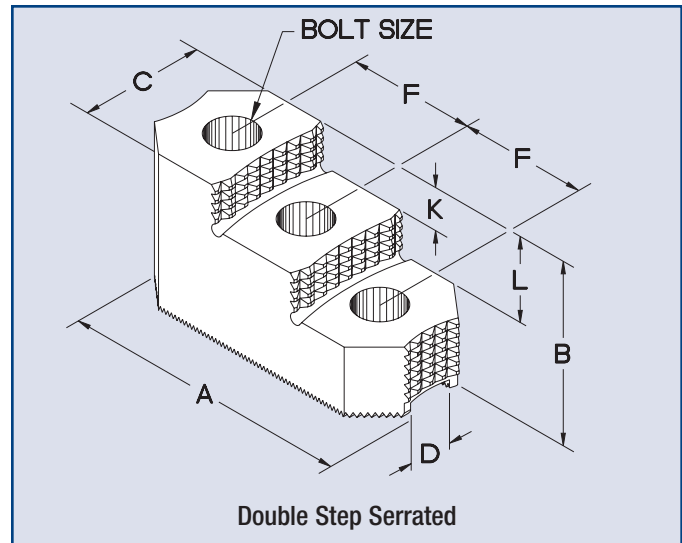
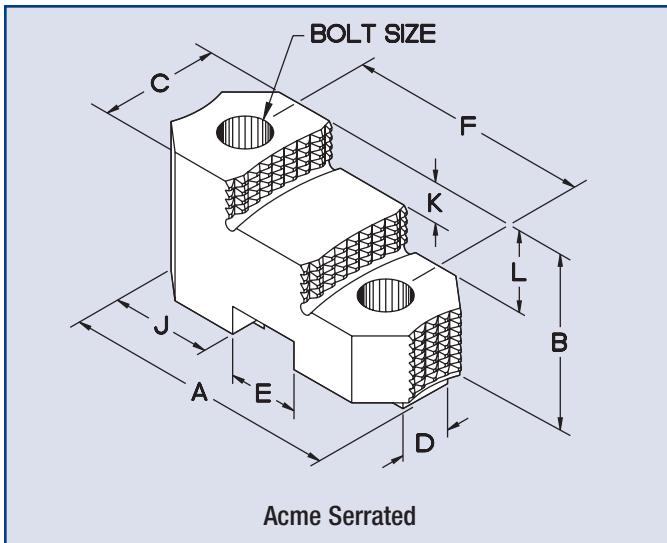
Qty. _____ Approved By _____ Date _____

A	B	C	D	E	F	G	J	Y	Bolt Size	Serration



See web site for additional prints

www.hrmfg.com



Qty. _____ Approved By _____ Date _____

A	B	C	D	E	F	J	K	L	Bolt Size	Serration



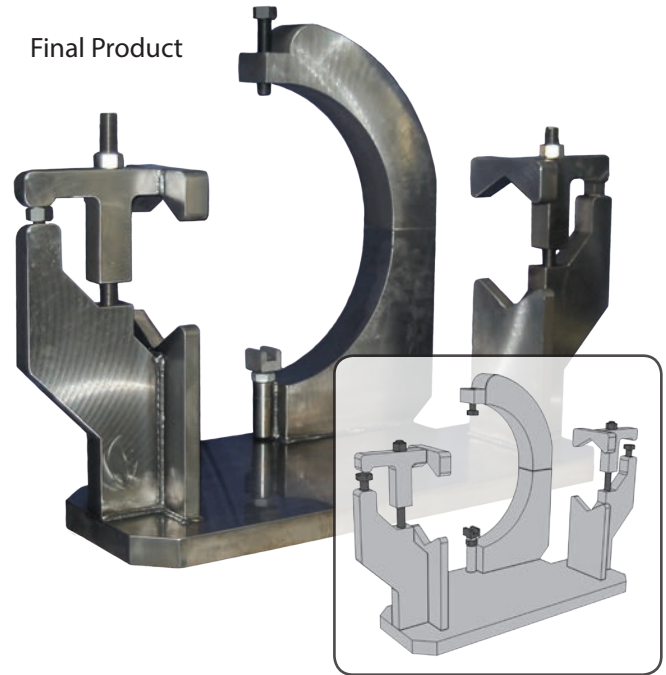
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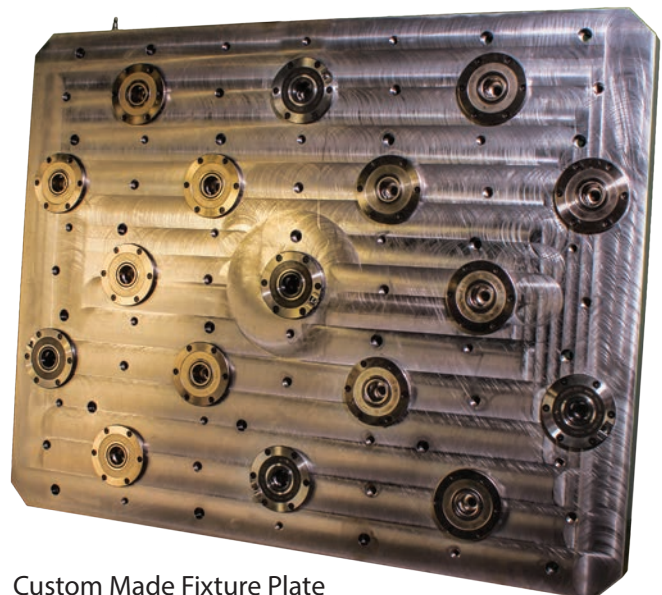
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