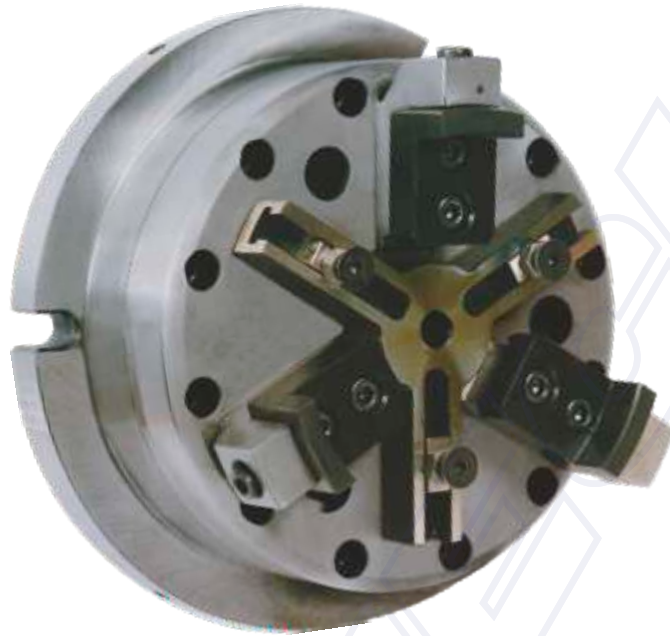


Diaphragm Chucks



These diaphragm chucks make use of the inherent resilience and spring action of steel to achieve chucking pressure on the job. Absence of sliding parts for clamping of the job, makes these chucks highly reliable and ensure a long trouble free life. To get a better grip, higher concentricity and minimum distortion, the number of jaws could be increased depending on the configuration of the component.

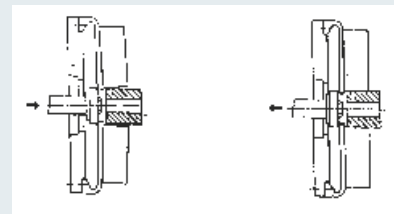
These chucks are mainly used for secondary operations like grinding, facing and boring where a high degree of concentricity is required.

They are offered in two versions:

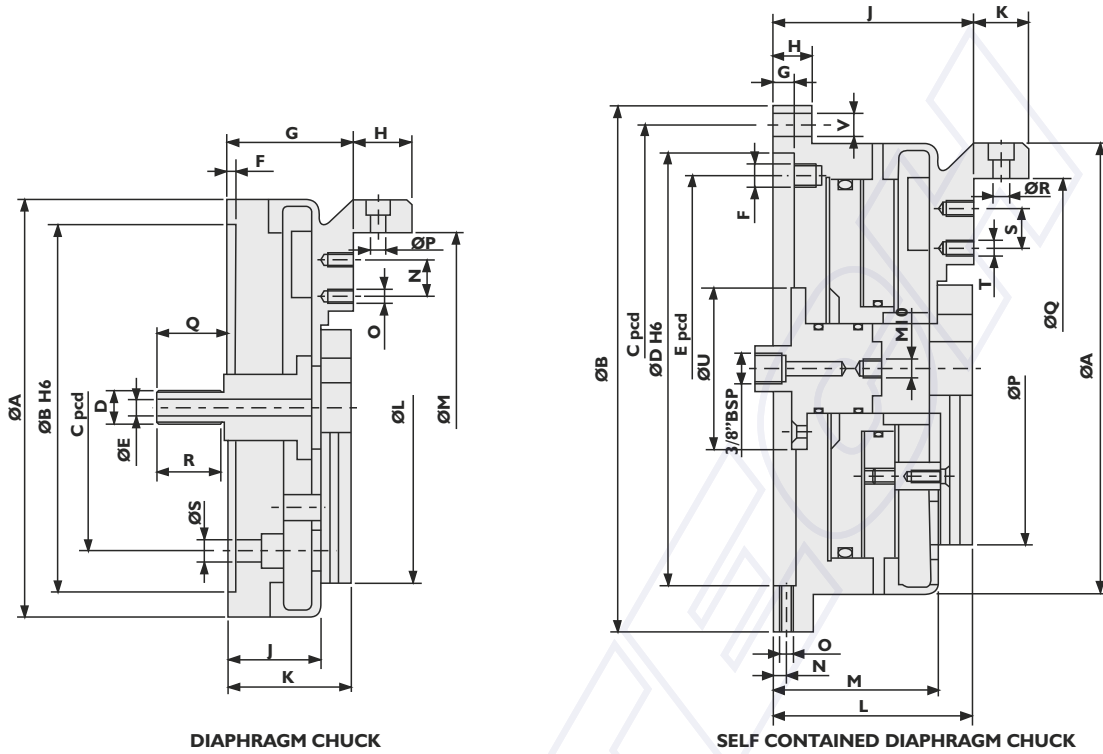
- Self contained where the cylinder and the piston are an integral part of the chuck.
- Standard Where the chuck is in front of the spindle and the cylinder is mounted on the rear end of the machine spindle.

How a diaphragm works

Air is introduced through the spindle and adaptor plate by means of a $\frac{1}{4}$ " pipe. When air pressure is applied, the piston moves forward by about 0.030" and this movement is transmitted to the diaphragm by a push sleeve. As the diaphragm is pushed, the jaws open out and the work piece is loaded. To grip the work piece, the air is turned off and the jaws move towards the relaxed position until they contact the work piece, which is located at the centre.



Diaphragm Chucks



DIAPHRAGM CHUCK

SELF CONTAINED DIAPHRAGM CHUCK

Dimensions : Diaphragm Chuck

Model	160 SD	200 SD	225 SD	250 SD	300 SD	325 SD	400 SD
A	165	200	225	250	300	325	400
B (H6)	140	170	170	220	220	220	300
C	104.78	133.35	133.35	171.45	171.45	171.45	235
D	M 16	M 20	M 20	M 20	M 24	M 24	M 24
E	8	10	10	10	12	12	12
F	5	5	5	5	6	6	6
G	63	73	73	75	80	80	84
H	25	25	25	30	30	30	30
J	48	53	53	55	55	55	57
K	67	72	72	74	74	74	76
L	120	150	175	185	240	265	335
M	135	165	190	210	256	281	356
N	18	22	22	22	25	25	25
O	M6	M8	M8	M8	M10	M10	M10
P	7	9	9	9	11	11	11
Q (Max.)	32	43	43	50	56	56	48
R (Min.)	26.5	35	35	40	46	46	38
R	25	33	33	38	38	38	38
S	3 x M10	3 x M12	3 x M12	3 x M12	3 x M16	3 x M16	3 x M16

Dimensions : Self Contained Diaphragm Chuck

Model	160 SCD	200 SCD	225 SCD	250 SCD	300 SCD	325 SCD	400 SCD
A	165	200	225	250	300	325	400
B	198	242	265	292	352	378	452
C	182	220	245	271	326	351	462
D (H6)	155	197	220	240	294	321	394
E	135	175	196	215	270	293	366
F	6 x M10	6 x M12	6 x M12	6 x M12	6 x M12	6 x M16	6 x M16
G	10	10	12	12	12	12	12
H	18	20	22	22	25	25	25
J	99	105	107	111	120	119.5	123.5
K	25	25	25	30	30	30	30
L	103	104	106	110	114	113.5	115.5
M	84	85	87	91	95	94.5	96.5
N	6	6	7	7	7	7	7
O	3 x M6	3 x M8	3 x M8	3 x M8	3 x M8	3 x M8	3 x M8
P	120	150	175	195	240	265	335
Q	135	165	190	210	256	281	356
R	7	9	9	9	11	11	11
S	18	22	22	22	25	25	25
T	M6	M8	M8	M8	M10	M10	M10
U	70	80	80	90	90	90	94
V	3 x M10	3 x M12	3 x M12	6 x M12	6 x M16	6 x M16	6 x M16

Note: The information set out in this catalogue is subject to any changes made since its publication. Further changes may be made without giving any notice.