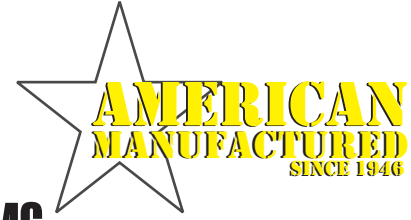


# ACME SERRATED POWER CHUCKS

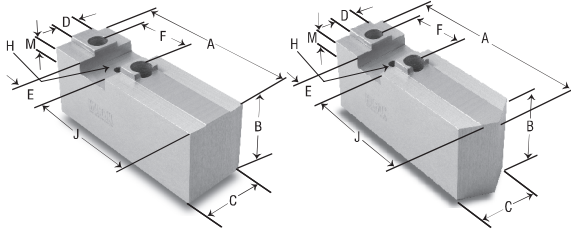


**MODEL: Autoblok, Cushman, Logansport, PBA, Howa HO7MC**

**JAW LOCK: AMCE SERRATED KEY TYPE**

## SOFT JAWS

AVAILABLE IN STEEL, ALUMINUM, OR SPECIAL



CHUCK SIZE	S T E E L								CRITICAL DIMENSIONS				
	STANDARD HEIGHT							EXTRA HIGH	D	E	F	SCREW SIZE	
	ORDER #	A	B	C	H	J	M	ORDER #					B
8	8LSH	3.75	2.00	1.50	10-24	2.000	.283	8LEH	3.500	.670	.601	1.25	1/2
10	T10	4.26	2.31	1.75	5/16-18	2.156	.375	T10EH	3.813	.750	1.031	1.75	1/2
12	T12	5.13	2.31	1.75	5/16-18	2.875	.375	T12EH	3.813	.875	1.031	2.00	5/8
15	T15A7.5	7.50	3.25	2.50	3/8-16	4.469	.375	T15A7.5EH	4.750	1.00	1.531	2.50	3/4
15-18	T15	6.13	3.25	2.50	3/8-16	3.031	.375	T15EH	4.750	1.00	1.531	2.50	3/4
21-24	T21	6.05	3.25	3.00	3/8-16	2.750	.375	T21EH	4.750	1.25	1.531	3.00	7/8

FOR HO7MC SERIES ONLY

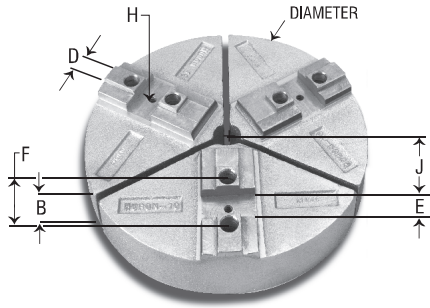
12	T10A5.5	5.63	2.31	1.75	5/16-18	3.562	.375	T10A5.5EH	3.813	.750	1.031	1.75	1/2
15	T12	5.13	2.31	1.75	5/16-18	2.875	.375	T12EH	3.813	.875	1.031	2.00	5/8

SOFT JAWS are for minimum marring and can be bored and turned to suit any work piece. POINTED SOFT JAWS are used for small diameter parts. STEEL soft jaws are made from 1018 Cold Roll and can be case hardened. ALUMINUM soft jaws are made from 6061-T6 weldable.

When ordering ALUMINUM SOFT JAWS put an "A" before order # EX: AT10.  
When ordering POINTED SOFT JAWS put a "P" after order # EX: T10P

## FULL GRIPS

AVAILABLE IN ALUMINUM, CAST IRON, STEEL OR SPECIAL



DIAM. CHUCK SIZE	A L U M I N U M							CRITICAL DIMENSIONS				
	STANDARD HEIGHT				EXTRA HIGH			D	E	F	SCREW SIZE	
	ORDER #	B	B*	H	J	ORDER #	B					B*
8	8LSHFG	2.00	1.75	10-24	2.0000	A8LEHFG	4.00	3.250	.670	.601	1.25	1/2
10	AT10FG	2.00	1.75	5/16-18	2.4600	AT10EHFG	4.00	3.250	.750	1.031	1.75	1/2
12	AT12FG	2.00	2.00	5/16-18	3.2185	AT12EHFG	4.00	3.500	.875	1.031	2.00	5/8
15	AT15FG	2.50	2.13	3/8-16	4.2185	AT15EHFG	4.00	3.625	1.00	1.531	2.50	3/4
18	AT18FG	2.00	2.13	3/8-16	5.7500	AT18EHFG	4.00	3.625	1.00	1.531	2.50	3/4
21	AT21FG	2.00	2.13	3/8-16	7.0620	AT21EHFG	4.00	3.625	1.25	1.531	3.00	7/8
24	AT24FG	2.00	2.50	3/8-16	7.8280	AT24EHFG	4.00	3.625	1.25	1.531	3.00	7/8

FOR HO7MC SERIES ONLY

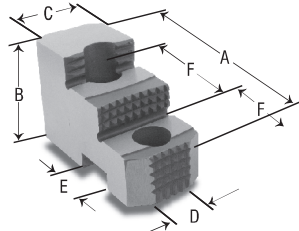
12	AT10A5.5FG	2.00	1.75	5/16-18	2.4600	AT10A5.5EHFG	4.00	3.250	.750	1.031	1.75	1/2
15	AT1215FG	2.50	2.00	5/16-18	3.2185	AT1215EHFG	4.00	3.500	.875	1.031	2.00	5/8

FULL GRIPS are for thin wall and irregular shaped parts and can be machined to suit any work piece. ALUMINUM full grips are made from SR319 Alloy weldable. CAST IRON full grips are made from F/6 weldable gray class 30 with 30,000lbs. Tensile strength.

B\* is the dimension for CAST IRON Full Grips. When ordering CAST IRON FULL GRIPS put a "C" before Order # EX: CT12FG  
When ordering STEEL FULL GRIPS drop "A" OR "C" before order # EX: T12FG.

## HARD JAWS

AVAILABLE IN STEEL OR SPECIAL



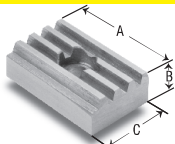
CHUCK SIZE	S T E E L						CRITICAL DIMENSIONS				
	2-STEP		A	B	C	HEIGHT TO 1st STEP	HEIGHT TO 2nd STEP	D	E	F	SCREW SIZE
	ORDER #	ORDER #									
8	8LSHRJ2S		3.37	2.500	1.50	1.125	1.850	.670	.601	1.25	1/2
10	T10RJ2S		4.10	2.500	1.75	1.035	1.715	.750	1.031	1.75	1/2
12	T12RJ2S		5.19	2.563	1.75	1.160	1.750	.875	1.031	2.00	5/8
15-18	T15RJ2S		6.00	3.250	2.50	1.313	2.188	1.00	1.531	2.50	3/4
21-24	T21RJ2S		5.93	3.250	3.00	1.500	2.500	1.25	1.531	3.00	7/8

FOR HO7MC SERIES ONLY

12	T10A5.5RJ2S		5.50	2.313	1.75	1.035	1.715	.750	1.031	1.75	1/2
15	T12RJ2S		5.19	2.563	1.75	1.160	1.750	.875	1.031	2.00	5/8

HARD JAWS are reversible for ID & OD gripping and are for first operation roughing. HARD JAWS are made from 1018 case hardened to 56-58 rockwell .020 to .030 deep.

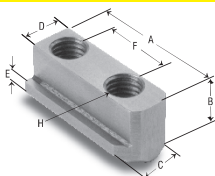
## KEYS



CHUCK SIZE	S T E E L		CRITICAL DIMENSIONS		
	ORDER #	A	B	C	SCREW SIZE
10-15	12AK	1.687	.500	1.030	5/16
15-20	15AK	2.437	.500	1.530	3/8
21-24	21AK	2.875	.500	1.530	3/8

KEYS are for locating and positioning top jaws to the chuck's master jaw. KEYS are made from 4140 Pre-Heat Treat material

## JAW NUTS



CHUCK SIZE	S T E E L				CRITICAL DIMENSIONS			
	ORDER #	A	B	C	D	E	F	THREAD SIZE
8	8LJN	2.00	1.00	1.030	.668	.440	1.25	1/2-13
10	C10JN	2.50	.640	.940	.678	.381	1.75	1/2-13
12	C12JN	2.90	.745	1.060	.802	.440	2.00	5/8-11
15-18	C1518JN	3.50	.931	1.250	.933	.550	2.50	3/4-10
21-24	C2124JN	4.20	1.186	1.555	1.159	.684	3.00	7/8-9

FOR HO7MC SERIES ONLY

12	HC12JN	2.60	.744	.945	.676	.414	1.75	1/2-13
15	HC15JN	3.00	.825	1.062	.805	.486	2.00	5/8-11

JAW NUTS are for locating and positioning top jaws to the chuck's master jaw. JAW NUTS are made from 4140 Pre-Heat Treat to RC 28-32.