



# Pratt Burnerd Constant Grip Quick Change and Non-Quick

## Closed Center Power Chucks Designed for Vertical Turning Lathes



Power Chucks

Jaw Presetting Fixture Order number 1009-07090

for use with 6", 8", 10", 12", 15", 18", and 20" sizes Standard Bore and King Bore Models Quick Change Jaw Power Chucks.

- ⌚ One Year Warranty
- ⌚ ±.0005" Repeatability
- ⌚ 3-Point Adjusting Feature in the chuck body permits indicating in to zero. Increase Soft Jaw Life by using adjustment feature. Reduce or eliminate re-boring of Soft Jaws.
- ⌚ Close center design with chip ejecting discharge chutes in the chuck body face reducing build-up to near zero.
- ⌚ High RPM ... up to 5,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design.
- ⌚ Quick Change Master Jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job reducing traditional setup time by 95%.
- ⌚ SAFE Visual Indicator shows when Master Jaws are in the unlocked mode.
- ⌚ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16 x 90, Am. Std. Acme, Am. Std Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- ⌚ Doubles as collet chuck as master jaws have keyed radius in front that accept standard W & S collet pads. Eliminate time wasted on switching over to collet chuck.
- ⌚ Utilize the machine's existing actuating cylinder - including Japanese types.
- ⌚ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube of drawbar PBA can supply chuck sleeve prethreaded on request, at a nominal charge.
- ⌚ Optional Jaw Setting Fixture (as shown) for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- ⌚ Sizes 6", 8", 10", 12", 15", 18", 20", and 24" diameters.

Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
<b>Quick Change Jaw VTL Chucks</b>										
10.0"	A2-6(I)	5000	9101-426__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9101-526__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9101-531__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9101-631__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9101-538__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9101-638__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9101-546__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9101-646__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9101-650__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	1800	9101-660__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(I)	1800	9101-760__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
<b>Non-Quick Change Jaw VTL Chucks</b>										
10.0"	A2-6(I)	5000	9111-426__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9111-526__	.160"	.730"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9111-531__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9111-631__	.160"	.730"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9111-538__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9111-638__	.200"	.790"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9111-546__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9111-646__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9111-650__	.236"	.984"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	1800	9111-660__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(I)	1800	9111-760__	.315"	.984"	6.25"	1/2" UNC	20,700	38,250	760

① Insert last two digits for Master Jaw type...Example 9101-42623...Indicates 1.5mm x 60°: Master Jaw Required  
 Use 23 for 1.5mm x 60° Japanese type.\*\* Use 07 for Am. Std Tongue & Groove. Use 10 for 1/16 X 90° Serrations.\*  
 Use 26 for Acme Serration. Use 27 for Square Serration.

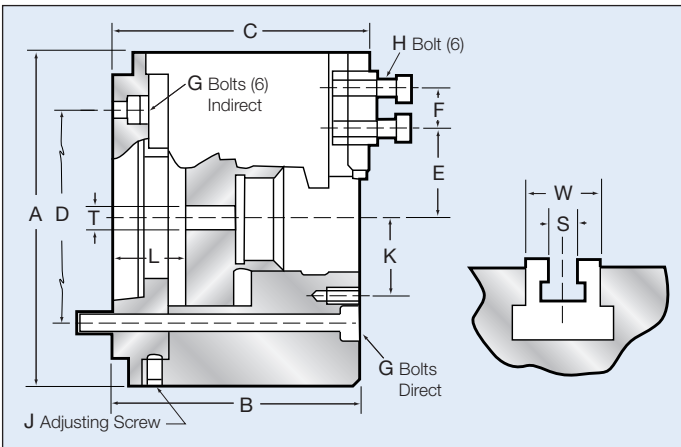
HOW TO ORDER: State quantity, Model Number of chuck, Machine make & Model, and shipping instructions.

# Change Chucks

## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	½ UNFx¾	4.53	1.42	2.15	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	½ UNFx¾	4.53	1.30	2.03	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	½ UNFx¾	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M20x110(3)	M14x45	½ UNFx¾	5.71	1.38	2.16	.710	1.81
15-A8	15	6.929	7.086	6.750	1.693	5.000	3.228	M16x35(6)	M20x55	½ UNFx¾	7.08/11.81	1.38	2.16	.866	2.36
15-A11	15	6.929	7.086	9.250	1.693	5.000	3.228	M20x180(6)	M20x55	½ UNFx¾	7.08/11.81	1.38	2.36	.866	2.36
18-A8	18	7.720	7.780	6.750	1.693	6.772	4.527	M16x40(6)	M20x55	½ UNFx¾	8.66/12.6	1.38	2.36	.984	2.36
18-A11	18	7.720	7.780	9.250	1.693	6.772	4.527	M20x35(6)	M20x55	½ UNFx¾	8.66/12.6	1.38	2.36	.984	2.36
20-A11	19.7	7.362	7.499	9.250	2.362	8.090	5.059	M20x45(6)	M20x35	½ UNFx¾	8.66/12.21	1.38	3.36	.984	2.36
24-A11	24	7.560	7.720	9.250	2.362	10.090	5.770	M20x45(6)	M20x35	½ UNFx¾	***	1.57	2.56	.984	2.36
24-A15	24	7.560	7.720	13.000	2.362	10.090	5.770	7/8-9x8(6)	M20x35	½ UNFx¾	***	1.57	2.56	.984	2.36

\*\*\*9.45"/13"/16.53"/20.08"



(T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service **Mono Block Jaws** are made from a nitride hardening material to allow hardening after forming without major distortion.

**Mono Block Jaws**  
See page 46 for Dimensions.

## Extra Sets of Master Jaws for Quick Change Jaw Power Chucks

	10"	12"	15"	18"	20"	24"
Master Jaw Type - 15mm x 60° Fine Serration (Japanese Type)	8130-26623	8130-31623	8130-40623	8130-46623	8130-50623**	8130-61623**
1/16 x 90° Fine serration (European Type)	8130-26610	8130-31610	8130-38610*	8130-46610*	8130-50610*	8130-61610*
Acme Serration	8130-26626	8130-31626	8130-40626	8130-46626	8130-50626	8130-61626
American Std. Tongue & Groove	8130-26607	8130-31607	8130-40607	8130-46607	8130-50607	8130-61607
Square Serration	8130-26627	8130-31627	8130-40627	8130-46627	8130-50627	8130-61627
Mono Block Jaw ***	8130-26601	8130-31601	8130-38601	8130-46601	8130-50601	8130-61601

\*\* 20" and 24" diameter chucks supplied with 3mm x 60° serrations

\* 15", 18", 20" and 24" diameter chucks supplied with 3/32" x 90° serrations

\*\*\* Also available in long pointed design