



# Atlas Workholding Ball Lock Power Chuck

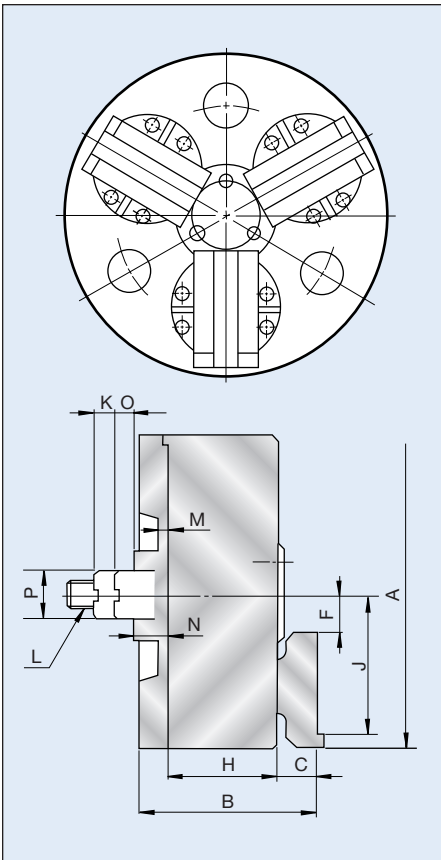
## BL 6" - 21" Chucks



- ⊕ This chuck is used for gripping castings and forgings. It pulls back workpieces with tapered surfaces of up to 10 degrees while providing a right and left compliance of 5 degrees resulting in strong clamping force.
- ⊕ Available in self-centering version (add "CT" to end of part number "BL8-A5CT")
- ⊕ Available as compensating chuck with center or plug (add "CP" to end of part number "BL8-A5CP")
- ⊕ Also available in 2 jaw configuration (add "2" to end of part number "BL8-A5PT2")
- ⊕ Available as adapter or direct mount

Power Chucks

Model* No.	Jaw Stroke Dia	Sleeve Stroke	Gripping Capacity		Draw Bar Pull lb/f	Grip Force lb/f	Max RPM	Wt lbs
			Max	Min				
BL6-A4	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL6-A5	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL6-A6	.311"	.445"	4.72"	.500"	5,950	17,850	4000	40
BL8-A5	.374"	.563"	5.98"	.630"	7,950	23,800	3500	60
BL8-A6	.374"	.563"	5.98"	.630"	7,950	23,800	3500	60
BL10-A6	.500"	.689"	7.99"	1.969"	9,900	29,750	3000	99
BL10-A8	.500"	.689"	7.99"	1.969"	9,900	29,750	3000	99
BL12-A8	.500"	.689"	9.49"	2.480"	9,900	35,700	2500	149
BL12-A11	.500"	.689"	9.49"	2.480"	9,900	35,700	2500	149
BL15-A8	.622"	.878"	12.48"	2.992"	15,000	45,000	2000	186
BL15-A11	.622"	.878"	12.48"	2.992"	15,000	45,000	2000	186
BL18-A8	.622"	.878"	15.51"	3.504"	15,000	45,000	1500	265
BL18-A11	.622"	.878"	15.51"	3.504"	15,000	45,000	1500	265
BL21-A11	.622"	.878"	18.50"	6.378"	15,000	45,000	1000	397



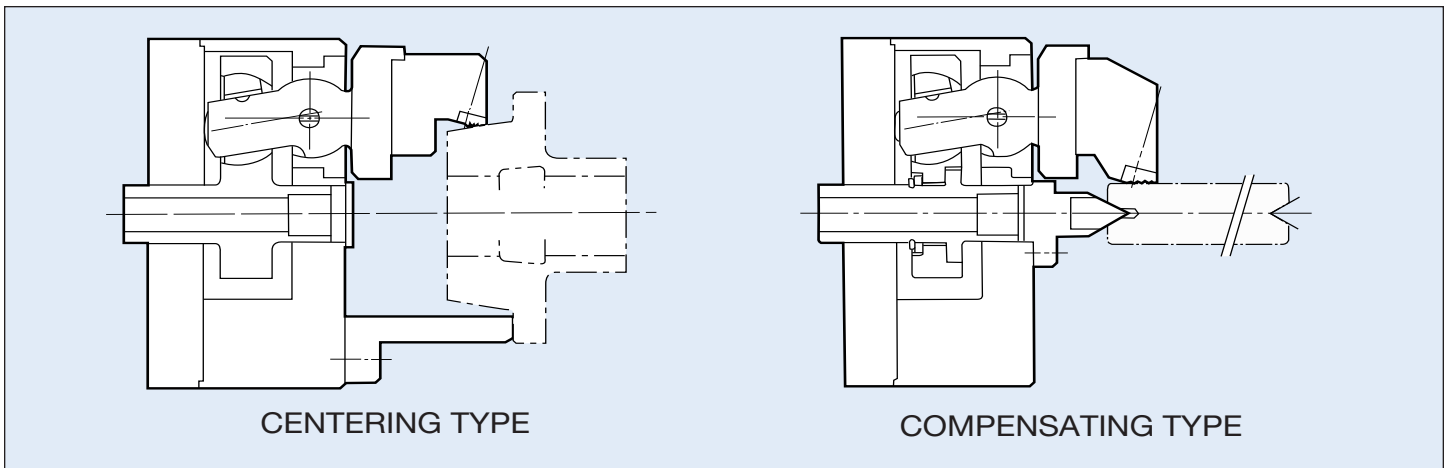
### Dimensional Data

MODEL	BL6	BL8	BL10	BL12	BL15	BL18	BL21
A	6.38	7.87	10	11.81	15	18	21
B	4.12	4.85	5.79	5.79	6.433	6.433	6.433
C	.760	.917	1.146	1.46	1.276	1.276	1.276
F	.799	.990	1.181	1.988	2.991	4.091	5.591
H	2.331	2.756	3.409	3.409	3.783	3.783	3.783
J Outer Dia.	2.880	3.502	4.437	1.307	6.750	8.250	9.750
J Inner Dia.	.874	.998	1.193	2.0	2.748	4.248	5.748
K max.	.445	.563	.689	.689	.878	.878	.878
K min	.244	.354	.374	.374	.472	.472	.472
L	M16	M16	M18	M18	M24	M24	M24
M	.189	.236	.279	.276	.276	.276	.394
N	.780	.846	1.023	1.023	1.441	1.441	1.441
O	.173	.118	.157	.157	.500	.500	.500
P	1.187	1.250	1.625	1.625	2.250	3.500	3.500

2 jaw dimensions same as 3 jaw

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

## BL Chuck Structure



## BL Chuck Features

- ⊕ Centers work, pulls work back and clamps firm
- ⊕ Clamps tapered parts up to 10°
- ⊕ Automatic radial adjustment of ± 5°
- ⊕ I.D. and O.D. clamping of forgings or castings
- ⊕ O.D. clamping of shafts
- ⊕ Sealed against contamination
- ⊕ High speed rotation
- ⊕ Excellent retention of clamp force
- ⊕ Also available as a 2 jaw

<h3>Automatic Adjustable Angle</h3> <p>Adjustable Angle Max. 5°</p> <p>Before      After</p>	<h3>Min. Length in Chucking Parts</h3> <p>Gap before chucking min .118"</p> <p>Min. chucking length min .276"</p> <p>10° chucking for taper parts</p>	<h3>Smooth Rotating Standard</h3> <p>&lt;Wedge type&gt;      &lt;Bearing Race type&gt;</p> <p>resistance &amp; friction      Smooth Rotating</p>	<h3>Max. Taper Angle in Chucking Parts</h3> <p>10°</p>
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## BL Inserts

