

PBA Pratt Burnerd Quick-Change 3-Jaw Power Chucks



Shown with optional jaw setting fixture and hard reversible top jaws.

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.

Constant Grip High Speed Thru-Hole Power Chucks Sizes 6" Thru 24"

- ⌚ 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.
- ⌚ High RPM ... up to 6,000 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.
- ⌚ Large Thru-Hole Capacity (can seal thru hole for VTL use... page 38 and 39)
- ⌚ Quick conversion to an Expanding Mandrel, ref. page 30
- ⌚ Utilize the machine's existing actuating cylinder - does not require long stroke cylinder.
- ⌚ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube or 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	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9131-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-5(D)	6000	9131-317__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
6.5"	A2-6(I)	6000	9131-417__	.140"	.630"	1.65"	1.5"	5/16" UNC	3,600	9,900	31
8.25"	A2-5(I)	5500	9131-321__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
8.25"	A2-6(D)	5500	9131-421__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
8.25"	A2-8(I)	5500	9131-521__	.140"	.630"	2.05"	2.0"	5/16" UNC	5,400	15,000	53
10.0"	A2-6(I)	5000	9131-426__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
10.0"	A2-8(D)	5000	9131-526__	.160"	.730"	2.56"	2.5"	3/8" UNC	7,200	19,800	82
12.0"	A2-8(I)	4200	9131-531__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
12.0"	A2-11(D)	4200	9131-631__	.160"	.730"	3.54"	3.0"	3/8" UNC	9,900	27,000	150
15.0"	A2-8(I)	3000	9131-538__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
15.0"	A2-11(D)	3000	9131-638__	.200"	.790"	4.92"	4.5"	3/8" UNC	13,500	31,500	280
18.0"	A2-8(I)	2500	9131-546__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
18.0"	A2-11(I)	2500	9131-646__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	375
20.0"	A2-11(I)	2500	9131-650__	.236"	.984"	5.59"	5.5"	1/2" UNC	15,500	38,250	550
24.0"	A2-11(I)	2000	9131-660__	.315"	.984"	6.299"	6.0"	1/2" UNC	20,700	38,250	760
24.0"	A2-15(D)	2000	9131-760__	.315"	.984"	6.299"	6.0"	1/2" UNC	20,700	38,250	760
King Bore Quick-Change Chucks											
8.25"	A2-6(D)	5500	9171-421__	.140"	.630"	2.59"	2.5"	5/16" UNC	5,400	15,000	53
10.43"	A2-6(I)	5000	9171-426__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82
10.43"	A2-8(D)	5000	9171-526__	.160"	.730"	3.03"	3.0"	3/8" UNC	7,200	19,800	82

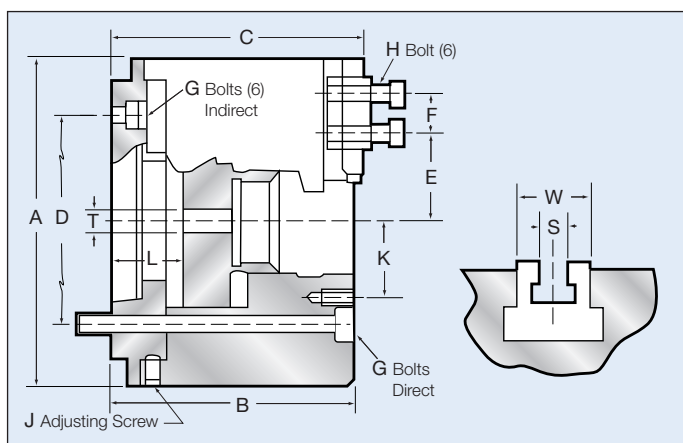
① Insert last two digits for Master Jaw type...Example 9131-21723...Indicates 1.5mm x 60°: Master Jaw Required
 Use 23 for 1.5mm x 60° Japanese type.** Use 07 for Am. Std Tongue & Groove. Use 10 for 1/16 X 90° Serrations.*
 Use 26 for Acme Serration. Use 27 for Square Serration.
NOTE: 18, 20" & 24" dia. chucks require separate collet pad master jaws: 18"-#8130-46696, 20"-#8130-50696 & 24"-#8130-61696.

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

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		
6-A4	6.496	4.685	4.803	3.250	.787	2.126	1.339	M10x25(6)	M10x25	5/16 UNFx1/2	2.99	.94	1.57	.475	1.22
6-A5	6.496	4.842	4.960	4.125	.787	2.126	1.339	M10x130(3)	M10x25	5/16 UNFx1/2	2.99	1.10	1.73	.475	1.22
6-A6	6.496	5.078	5.196	5.250	.787	2.126	1.339	M12x30(6)	M10x25	5/16 UNFx1/2	2.99	1.50	2.13	.475	1.22
8-A5	8.26	5.119	5.275	4.125	1.000	2.637	1.733	M10x30(6)	M12x35	3/8 UNFx3/4	3.94	.98	1.61	.551	1.57
8-A6	8.26	5.354	5.510	5.250	1.000	2.637	1.733	M12x130(3)	M12x35	3/8 UNFx3/4	3.94	1.19	1.81	.551	1.57
8-A8	8.26	5.705	5.862	6.750	1.000	2.637	1.733	M16x30(6)	M12x35	3/8 UNFx3/4	3.94	2.02	1.75	.551	1.57
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	1/2 UNFx3/4	4.53	1.02	2.15	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(3)	M12x35	1/2 UNFx3/4	4.53	1.41	2.03	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M20x160(3)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
15-A8	15	6.929	7.086	6.750	1.693	5.000	3.228	M16x35(6)	M20x55	1/2 UNFx3/4	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	1/2 UNFx3/4	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	1/2 UNFx3/4	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	1/2 UNFx3/4	8.66/12.6	1.38	2.36	.984	2.36
20-A11	19.68	7.362	7.499	9.250	2.362	8.090	5.059	M20x45(6)	M20x35	1/2 UNFx3/4	8.66/12.21	1.38	2-.36	.984	2.36
24-A11	24.02	7.560	7.720	9.250	2.362	10.09	5.770	M20x45(6)	M20x35	1/2 UNFx3/4	***	1.57	2.56	.984	2.36
24-A15	24.02	7.560	7.720	13.000	2.362	10.09	5.770	7/8-9x3(6)	M20x35	1/2 UNFx3/4	***	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

	6"	8"	10"	12"	15"	18"	20"	24"
Master Jaw Type - 1.5mm x 60° Fine Serration (Japanese Type)	8130-17623	8130-21623	8130-26623	8130-31623	8130-40623	8130-46623	8130-50623**	8130-61623**
1/16 x 90° Fine serration (European Type)	8130-17610	8130-21610	8130-26610	8130-31610	8130-38610*	8130-46610*	8130-50610*	8130-61610*
Acme Serration	N/A	8130-21626	8130-26626	8130-31626	8130-40626	8130-46626	8130-50626	8130-61626
American Std. Tongue & Groove	8130-17607	8130-21607	8130-26607	8130-31607	8130-38607	8130-46607	8130-50607	8130-61607
Square Serration	N/A	8130-21627	8130-26627	8130-31627	8130-38627	8130-46627	8130-50627	8130-61627
Mono Block Jaw***	8130-17601P	8130-21601	8130-26601	8130-31601	8130-38601	8130-46601	8130-50601	8130-61601

**20" & 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 longer pointed design