JAW BORING TOOLS

JAW BORING RINGS
No need to look all over the shop for a setup piece and waste time. Our jaw boring ring is essential for boring soft jaws and round jaws.

FEATURES:
- Ideal for machining soft jaws.
- Attaches quickly without tools.
- Applies equal pressure on all jaws.
- Attaches to front of jaws, compensating for "jaw lift."
- Since no discs or bungs are used to clamp jaws, through boring of jaws is possible.

Save Set-Up Time!

How to install:
1. Place the jaw boring ring over your chuck and locate the boring ring pins in the counterbore of your chuck jaws.
2. Turn the jaw boring ring until snug.
3. Activate your jaws.

The jaw boring ring will apply equal pressure on all jaws, allowing for a consistent bore.

BORING STARS
A valuable time saver for your lathes and turning centers! Every ring you will ever need for boring out your soft jaws on one convenient wooden rack.

FEATURES:
- Save setup time
- Obtain any diameter easily and quickly.
- Reduces soft jaw costs
- Allows straight through boring of soft jaws.

Jaw Boring Ring (comes complete with 3 pin assemblies) Extra Pin Assemblies

<table>
<thead>
<tr>
<th>Description</th>
<th>Part Number</th>
<th>Price Each</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jaw Boring Ring-Set of 4</td>
<td>JBT-100</td>
<td>$27.00</td>
</tr>
</tbody>
</table>

INDEXABLE DRILLS

TRU JAWS CHUCK ADAPTERS
Remachine soft top jaws on power & manual chucks in 60 seconds! Replaces thousands of rings and spiders. Designed for use with 3 jaw power chucks.

FEATURES:
- OD and ID soft jaw remachining.
- Perfect concentricity & squareness of jaws.
- Maximum rigidity of jaws.
- Minimum stock removal.


cnc spindle workstop

ABRASIVES

WEIGHT & SAFETY

Additional Pin Diameters Available. Please Call For More Information.
LATHE & CHUCK STOPS

CNC LATHE STOPS

The Accu-Stop Assembly is constructed of low carbon steel coated with zinc oxide for lasting strength and durability. The faceplate of the assembly mounts to the front of a draw tube style manual or power chuck, while the extension tubes extend back into the draw tube to accommodate workpieces of any length. The Accu-Stop block to the machine chuck, expanding 3 keys than one time or where more than one part is to be machined. Just slide the body into the spindle of the machine, rotate the T-handle wrench which expands 3 keys instantly, eliminating friction damage. Easily pays for itself in just a few jobs by eliminating the time it takes to use the turret to locate your work piece.

PACKAGE INCLUDES: Complete Assembly, Accu-Stop Special Vise & Stop Wrench

**Ordering Information:**
- Please have the following available when placing order:
  1. Make/Model of lathe
  2. Date manufactured
  3. Make/Model of chuck

**Features:**
- Completely self-centering
- Cannot vibrate or change position
- Greater rigidity insures duplication
- Installs in seconds!
- Completely self-centering

**Unversal Lathe Spindle & Collet Stops**

For CNC, Manual Lathes & Indexing Heads

• Precise, easy to use and inexpensive stop for CNC lathes
• Made in the USA

**Ordering Information:**
- Please have the following available when placing order:
  1. Make/Model of lathe
  2. Date manufactured
  3. Make/Model of chuck

**Features:**
- Ensures accuracy/repeatability within .0005".
- Heavy duty and highly accurate
- Replaces inaccurate and expensive stopping mechanisms
- Precise, easy to use and inexpensive stop for CNC lathes

**Standard Set:**
- 15, 20, 25, 30 & 35mm stops

**Deluxe Set:**
- 15, 20 & 25mm stops

**Assembly 20.25" (under 3" dia drawtube):**
- AS-4000SB $621.30

**Assembly 16.5" (under 3" dia drawtube):**
- AS-3000 $564.30

**Assembly 12.5" (under 3" dia drawtube):**
- AS-2000 $507.25

**Assembly 9.25" (under 3" dia drawtube):**
- AS-1000 $507.25

**Assembly 12.5" (under 3" dia drawtube):**
- AS-3000 $564.30

**Assembly 9.25" (under 3" dia drawtube):**
- AS-2000 $507.25

**Assembly 6.5" (under 3" dia drawtube):**
- AS-1000 $507.25

**Assembly 4.5" (under 3" dia drawtube):**
- AS-2000 $507.25

**Assembly 2.5" (under 3" dia drawtube):**
- AS-1000 $507.25

**Assembly 1.5" (under 3" dia drawtube):**
- AS-2000 $507.25

**Assembly 1.0" (under 3" dia drawtube):**
- AS-1000 $507.25

**Assembly 0.75" (under 3" dia drawtube):**
- AS-2000 $507.25

**Assembly 0.50" (under 3" dia drawtube):**
- AS-1000 $507.25

**Assembly 0.25" (under 3" dia drawtube):**
- AS-1000 $507.25

**Extra Tube (5" Long):**
- AS-1003 $61.45

**Tubing Stop Option:**
- AS-TSO1000 $57.28
- AS-TSO2000 $57.28
- AS-TSO3000 $67.70

**Tubing Stop Option (over 3" dia drawtube):**
- AS-TSO4000 $78.12

**Tubing Stop Option (under 3" dia drawtube):**
- AS-TSO1000 $57.28
- AS-TSO2000 $57.28
- AS-TSO3000 $67.70

**Cutting Tools Storage:**

- U S Shop Tools Sales: 800-243-7701 Fax: 800-342-3311 www.usshoptools.com

2012-13 Master Catalog 11
**HARD JAWS-1.5mm X 60° Serrations**

**1.5mm x 60° Serration Hard Jaws**

*For Kitagawa®, Samchully® Strong®, MMK & Howa Chucks*

**FEATURES:**
- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversable-suitable for OD & ID workholding.
- GRIP-RITE/E OEM Style hard jaws have ground tips and provide better runout.
- XTRA BITE very aggressive bite. They have conical teeth for extra gripping power and ground body to provide improved runout.
- SHARK JAW have conical teeth for extra gripping power and black code for long life. Ideal for casting! Made in the USA.
- 1 & 2 step jaws available.

**We offer one of the largest selections of Hard Jaws in the USA.**

For your convenience, we offer 3 unique styles of hard jaws. Choose the best fit for your application!

<table>
<thead>
<tr>
<th>Group Number</th>
<th>Chuck Size</th>
<th>Critical Dimensions</th>
<th>Height (inch)</th>
<th>Width (inch)</th>
<th>No. of Steps</th>
<th>Top Step Height</th>
<th>Mid Step Height</th>
<th>Back Step Height</th>
<th>Part Number</th>
<th>Price (Per Set)</th>
</tr>
</thead>
<tbody>
<tr>
<td>K1-10-2</td>
<td>6</td>
<td>0.432 (16/32)</td>
<td>12mm</td>
<td>5.986 (235mm)</td>
<td>2</td>
<td>0.800</td>
<td>0.500</td>
<td>0.260</td>
<td>KT-100HJ2</td>
<td>$352.95</td>
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<tr>
<td>K1-12-6</td>
<td>6</td>
<td>0.472 (16/32)</td>
<td>16mm</td>
<td>8.787 (222mm)</td>
<td>2</td>
<td>0.800</td>
<td>0.500</td>
<td>0.420</td>
<td>KT-120HJ2</td>
<td>$399.25</td>
</tr>
</tbody>
</table>

**Retaining Knobs for T-Gibs to Collets**

**TOOL HOLDERS**

**INDEXABLE DRILLS**

**ENDMILLS DRILLS & SPOON DRILLS**

**ABRASIVES & MACHINING TOOLS**

**WEIGHT & SAFETY**

**For your convenience, we offer 3 unique styles of hard jaws. Choose the best fit for your application!**

*Made in the USA.*

**Shark Jaws D**

**XTRA-BITE E**

**OEM Style E**
### 3.0mm x 60° Serrations Hard Jaws-For Kitagawa, MMK, Howa & Other Chucks

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group</th>
<th>Number</th>
<th>Chuck</th>
<th>Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>Width</th>
<th>Overall Length</th>
<th>Height</th>
<th>No. of Holes</th>
<th>No. of Steps</th>
<th>Top Step Height</th>
<th>Mid Step Height</th>
<th>Bottom Step Height</th>
<th>Part Number</th>
<th>Price Per Set</th>
</tr>
</thead>
<tbody>
<tr>
<td>K3-16-9 6</td>
<td>0.433</td>
<td>(11mm)</td>
<td>0.719</td>
<td>2.500</td>
<td>3.000</td>
<td>1.250</td>
<td>3</td>
<td>0.500</td>
<td>0.500</td>
<td>0.650</td>
<td>1.569</td>
<td>PH-60HJ2-X</td>
<td>$395.00</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>K3-18-9 6</td>
<td>0.551</td>
<td>(14mm)</td>
<td>0.875</td>
<td>2.500</td>
<td>3.000</td>
<td>1.250</td>
<td>3</td>
<td>0.500</td>
<td>0.500</td>
<td>0.909</td>
<td>1.569</td>
<td>PH-80HJ2-X</td>
<td>$427.50</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>K3-26-5 15-20</td>
<td>1.023</td>
<td>(26mm)</td>
<td>1.907</td>
<td>2.500</td>
<td>6.500</td>
<td>3.469</td>
<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-150HJ2-X</td>
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<tr>
<td>K3-22-5 15</td>
<td>0.866</td>
<td>(22mm)</td>
<td>1.969</td>
<td>2.500</td>
<td>6.500</td>
<td>3.469</td>
<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-120HJ2-X</td>
<td>$791.67</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>K3-25-4 18-24</td>
<td>0.984</td>
<td>(25mm)</td>
<td>1.907</td>
<td>2.500</td>
<td>6.500</td>
<td>3.469</td>
<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-150HJ2-X</td>
<td>$791.67</td>
<td></td>
<td></td>
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<tr>
<td>K3-240-5</td>
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<td>(21mm)</td>
<td>1.181</td>
<td>2.500</td>
<td>6.500</td>
<td>3.469</td>
<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-120HJ2-X</td>
<td>$791.67</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**FEATURES:**
- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- XTRA BITE-very aggressive bite. Hex conical teeth for extra gripping power and ground body to provide improved runout.

### 1/16" x 90° Serrations Hard Jaws- For SMW Autoblok, Rohm, Pratt Burnerd & Other Chucks

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group</th>
<th>Number</th>
<th>Chuck</th>
<th>Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>Width</th>
<th>Overall Length</th>
<th>Height</th>
<th>No. of Holes</th>
<th>No. of Steps</th>
<th>Top Step Height</th>
<th>Mid Step Height</th>
<th>Bottom Step Height</th>
<th>Part Number</th>
<th>Price Per Set</th>
</tr>
</thead>
<tbody>
<tr>
<td>I1-43-9</td>
<td>6</td>
<td>0.433</td>
<td>(11mm)</td>
<td>0.719</td>
<td>2.500</td>
<td>3.000</td>
<td>1.250</td>
<td>3</td>
<td>0.500</td>
<td>0.500</td>
<td>0.650</td>
<td>PH-60HJ2-X</td>
<td>$395.00</td>
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<td></td>
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</tr>
<tr>
<td>I1-55-9</td>
<td>6</td>
<td>0.551</td>
<td>(14mm)</td>
<td>0.875</td>
<td>2.500</td>
<td>3.000</td>
<td>1.250</td>
<td>3</td>
<td>0.500</td>
<td>0.500</td>
<td>0.909</td>
<td>PH-80HJ2-X</td>
<td>$427.50</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>I1-66-9</td>
<td>8</td>
<td>0.669</td>
<td>(17mm)</td>
<td>1.181</td>
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<td>3.000</td>
<td>1.250</td>
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<td>0.715</td>
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<td>$791.67</td>
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<tr>
<td>I1-78-9</td>
<td>10 &amp; 12</td>
<td>0.787</td>
<td>(20mm)</td>
<td>1.562</td>
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<td>3.000</td>
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<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-150HJ2-X</td>
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<td></td>
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<tr>
<td>I1-82-9</td>
<td>10 &amp; 12</td>
<td>0.827</td>
<td>(21mm)</td>
<td>1.562</td>
<td>2.500</td>
<td>3.000</td>
<td>1.250</td>
<td>3</td>
<td>0.950</td>
<td>0.950</td>
<td>1.569</td>
<td>PH-120HJ2-X</td>
<td>$791.67</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**FEATURES:**
- XTRA BITE (-X) Very aggressive, ground body and sides for improved runout.

### SPECIAL ORDER JAWS AVAILABLE!

- Super Quick Turnaround Time- 3 Days Or Less In Most Cases!
- Special Order Round Jaws Up To 32" dia! Special Order Soft Jaws Up To 6" Height!
- Soft Jaws Available In Any Length-Steel Or Aluminum
- Tongue And Groove, Square Serrated & Acme Serrated Jaws Up To 8" Height!
- Made Per Your Special Specifications In The USA! Please See Our Special Order Forms On Pages 635-640.

Please Call Today For A Quote!
### HARD JAWS—AMERICAN STANDARD TONGUE & GROOVE

**FEATURES:**
- Designed for first operation roughing, expect standard runout between 0.005–0.010.
- Very aggressive bit for extra gripping power and ground body to provide improved runout.
- XTRA BITE—very aggressive bite.
- Shark jaws have conical teeth for extra gripping power and black oxide for long life. Made in the USA.

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>Size</th>
<th>Length</th>
<th>Width</th>
<th>Width C</th>
<th>Height</th>
<th>Sides</th>
<th>No. of Holes</th>
<th>No. of Steps</th>
<th>Tip</th>
<th>Head</th>
<th>Ref.</th>
<th>Net</th>
<th>Unit Price</th>
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</tr>
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<tbody>
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<td>0.500</td>
<td>1.190</td>
<td>0.799</td>
<td>1.051</td>
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<td>0.500</td>
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<td>1.699</td>
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<td>$151.94</td>
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<tr>
<td>3/4&quot;</td>
<td>0.500</td>
<td>1.389</td>
<td>0.799</td>
<td>1.051</td>
<td>2</td>
<td>2</td>
<td>0.500</td>
<td>0.500</td>
<td>1.699</td>
<td>1.699</td>
<td>0.500</td>
<td>0.500</td>
<td>$164.70</td>
<td>TG-80HJ-3/4</td>
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<tr>
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<td>0.500</td>
<td>1.389</td>
<td>0.799</td>
<td>1.051</td>
<td>2</td>
<td>2</td>
<td>0.500</td>
<td>0.500</td>
<td>1.699</td>
<td>1.699</td>
<td>0.500</td>
<td>0.500</td>
<td>$210.45</td>
<td>TG-80HJ-1</td>
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<tr>
<td>1 1/2&quot;</td>
<td>0.500</td>
<td>1.389</td>
<td>0.799</td>
<td>1.051</td>
<td>2</td>
<td>2</td>
<td>0.500</td>
<td>0.500</td>
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<td>$270.75</td>
<td>TG-80HJ-1 1/2</td>
</tr>
<tr>
<td>2</td>
<td>0.500</td>
<td>1.389</td>
<td>0.799</td>
<td>1.051</td>
<td>2</td>
<td>2</td>
<td>0.500</td>
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<td>0.500</td>
<td>0.500</td>
<td>$371.43</td>
<td>TG-80HJ-2</td>
</tr>
</tbody>
</table>

#### New Features

- XTRA BITE—very aggressive bite.
- GRIP-RITE-OEM style hard jaws have ground tips and ground body to provide improved runout.
- XTRA BITE—very aggressive bite.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life. Made in the USA.

#### XTRA BITE (-X)
- Very aggressive bite.
- Improved runout.
- Made in the USA.

#### GRIP-RITE (-U)
- Very aggressive bite.
- Very aggressive bite.
- Made in the USA.

#### SHARK JAWS
- Conical teeth for extra gripping power.
- Made in the USA.

#### ABRASIVES
- American Standard Tongue & Groove jaws for 3, 4 & 6-jaw self-centering scroll chucks.
- Made in the USA.
ROUND JAWS - 1.5 mm x 60° Serrations
FOR USE ON: Kitagawa®, Samchully®, Strong, MMK, SMW Autoblock, Howa & Hitachi-Seiki Chucks

- 1.5 mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>Hole to Front</th>
<th>Pie Dia</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>K1-08-15</td>
<td>4</td>
<td>0.315 (8mm)</td>
<td>0.535 (10mm)</td>
<td>1.000</td>
<td>0.32</td>
<td>1.000</td>
<td>0.60</td>
</tr>
<tr>
<td>K1-10-14</td>
<td>5</td>
<td>0.394 (10mm)</td>
<td>0.551 (12.7mm)</td>
<td>1.000</td>
<td>0.40</td>
<td>1.250</td>
<td>0.748</td>
</tr>
<tr>
<td>K1-10-17</td>
<td>5</td>
<td>0.394 (10mm)</td>
<td>0.669 (17mm)</td>
<td>1.844</td>
<td>0.40</td>
<td>1.250</td>
<td>0.748</td>
</tr>
<tr>
<td>K1-11-17</td>
<td>5</td>
<td>0.433 (11mm)</td>
<td>0.713 (18mm)</td>
<td>1.250</td>
<td>0.40</td>
<td>1.688</td>
<td>1.000</td>
</tr>
</tbody>
</table>

**Round Jaw Material:**
- ALUMINUM -6061-T6 Bar Stock,
- CAST IRON -Gray,
- STEEL -1018

For complete list of applicable chucks, see pages 622-634.

* denotes non-stock item. Please allow 1 week manufacturing time.

---

**How To Order Soft Jaws, Round Jaws, Hard Jaws and Jaw Nuts**

Using the “Critical Dimensions” Method:
1. Identify the type of jaw from the pictures below.
2. Find the proper chuck size on the left side of the table.
3. Check your Critical Dimensions against the table. Make sure that they match your requirements.
4. Choose your desired jaw height (“A” dimension).
5. Choose the material you require. (Aluminum, Steel, Cast Iron)
6. Use the Part Number shown on the right end of the table. Jaws are sold in sets of 3 pieces.

**Part Numbers are for Flat Nose Jaws.** If you would like your jaws to be pointed, replace the “F” on the end of the part number with a “P”. Example: KT-6200F will be KT-6200P. There is an additional charge for pointing.

**If you cannot find the jaws you are looking for or you require special jaws, please call us so that you may fill out a special jaw order form, located on pages 635-640.**

**If you know your chuck make and model:** See pages 622-634 for our extensive Jaw Finder.

---

SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa, Samchully®, Strong®, MMK, SMW Autoblok, Howe & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

**Please substitute **

**Groove**

**Space**

**Hole**

- 8mm (G)
- 6mm (J)
- 4mm (C)
- 3mm (B)
- 2mm (A)

**Height**

<table>
<thead>
<tr>
<th>Group Number</th>
<th>Check Size</th>
<th>Groove Width D</th>
<th>Screw Size E</th>
<th>Hole Space D</th>
<th>Inch A</th>
<th>Hole to J</th>
<th>Width C</th>
<th>Length D</th>
<th>FLAT END</th>
<th>Part Number</th>
<th>Price Each</th>
<th>Style Code</th>
</tr>
</thead>
<tbody>
<tr>
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**Critical Dimensions**

**ALUMINUM**

**STEEL**

**K1-15-16**

**K1-15-17**

**K1-15-18**

**HARD JAWS-1 STEP**

**Critical Dimensions**

**JAW NUTS & SCREWS**

**Critical Dimensions**

**US Shop Tools**

Sales: 800-243-7701 Fax: 800-342-3311 www.usshoptools.com

2012-13 Master Catalog
### ROUND JAWS- 1.5 mm x 60° Serrations

**FOR USE ON:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5 mm x 60° serrations
- Round jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for RH-welled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA

### Critical Dimensions

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### HARD JAWS

- Designed for first operation roughing, expect standard output between 85% and 89%
- Reversible for OD & ID workholding
- XTRA BITE - very aggressive bite. Conical teeth for extra gripping power and ground body to provide extra gripping power and block code for long life. Ideal for castings and heavy material
- HUSKY JAWS have conical teeth for extra gripping power and block code for long life. Ideal for castings and heavy material
- Shimano jaw features enhanced serrations on gripping surface
- Top 2 step pair available

### Indexable Drills

- Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks
- For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks
- 18-2012 Master Catalog
SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diametral parts
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

Soft Jaw Material:
- ALUMINUM-6061-T6 Bar Stock
- STEEL-1018 or 1050
- "B" JAWS-7075-T6 Aircraft Aluminum

JAW NUTS & SCREWS

Kitagawa:
- K1-14-20
- K1-11-25
- ZA5-6B, ZJA5-6

Samchully:
- Z-6, ZA5-6-0

Strong:
- Z-6
- ZA5-6-0

MMK:
- N206
- HO24M6, HO22M6, HO15M6

SMW Autoblok:
- B-06, B-07

Howa:
- HS-06

Hitachi-Seiki Chucks:
- HS-06

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<th>Chuck Size</th>
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<th>Screw Size</th>
<th>Hole Space</th>
<th>Length</th>
<th>Pitch &amp; Length</th>
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For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

CUTTING TOOLS
- TAP HOLDERS
- STRAIGHT SHANK
- STRAIGHT SHANK
- COOLANT/FLUIDS
- PRECISION TOOLS
- MACHINERY
- DRILL CHUCKS
- THREADING/GROOVING

LATHES
- CHUCKS
- LIVE CENTERS
- COOLANT/FLUIDS
- THREADING/GROOVING
**ENDMILLS, DRILLS INDEXABLE DRILLS MRO & SAFETY ABRASIVES TOOLHOLDERS MACHINE VISES LATHE WORKHOLDING MEASURING TOOLS TAPS & REAMERS TURNING & BORING TAP HOLDERS ER, DA, TG COLLETS VISE JAWS FLAT STOCK/DRILL ROD ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75" (146 mm)
- Special "J" dimensions available
- Made in Aluminium, Cast Iron & Steel
- Aluminium round jaws made from cold extruded aluminium (up to 15")
- Made in the USA

**FEATURES:**
- 1 & 2 step jaws available
- Extra Bite - for castings and scaly material. Made in the USA
- Hard jaws have ground tips and provide better runout.
- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- Conical teeth for extra gripping power and ground body to provide improved runout.
- XTRA BITE - very aggressive bite. Conical teeth for extra gripping power and black oxide for long life. Ideal for hard materials and large workpieces made in the USA.
- Bison jaws feature enhanced serrations on gripping surface.
- Made in the USA

**Round Jaw Material:** ALUMINUM 6061-T6 bar stock, CAST IRON (gray), STEEL 1018 For complete list of applicable chucks, see pages 622-634.* denotes non-stock item. Please allow 1 week manufacturing time.

**Critical Dimensions**

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**Dimensions:**

- 1.5mm x 60° serrations
- 60° threading angle
- 0.005-0.010 standard runout

**Part No.**

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**Price Set of 2**

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- Designed for first operation roughing
- Excellent standard runout of 0.005-0.010
- Reversible-suitable for OD & ID workholding
- XTRA BITE - very aggressive bite. Conical teeth for extra gripping power and black oxide for long life. Ideal for hard materials and large workpieces made in the USA.
- Bison jaws feature enhanced serrations on gripping surface.
- Made in the USA
SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok & Howa Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Will hold parts on the very tightest fit workspace
- Steel jaws can be hardened
- All jaws have 2 holes
- Available flat ended or pointed for smaller diameter parts
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

Group No.

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<td>M12-1.75</td>
<td>0.807 x 1.880</td>
<td>0.958 x 1.500</td>
<td>0.909</td>
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</table>
### ROUND JAWS - 1.5 mm x 60° Serrations

For use on: SMW Autoblok, Howa, Suga & Hitachi-Selki Chucks

#### Critical Dimensions

| Group No. | Chuck Size | Groove Width G | Screw Size E | Hole Space A | Hole To Front J | Pie Dia B | Height C | No. of Steps | Top Step Ht S1 | Mid Step Ht S2 | Bot Step Ht S3 | Part Number | Price Per Set |
|-----------|------------|----------------|--------------|--------------|----------------|-----------|---------|-------------|----------------|----------------|----------------|-------------|---------------|---------------|
| K1-16-05  | 8"         | 0.551 (16mm)   | 10mm         | 1.181        | 1.181         | 2.250     | 2.000   | 3           | 0.500          | 0.500          | 1.000          | RSG-8006A    | $172.30       |
|           |            |                |              |              |                |           |         |             |                |                |                | RSG-8006C    | $179.72       |
|           |            |                |              |              |                |           |         |             |                |                |                | RSG-82006    | $209.36       |
| K1-16-05  | 8"         | 0.630 (16mm)   | 12mm         | 0.984        | 0.984         | 2.250     | 2.000   | 3           | 0.500          | 0.500          | 1.000          | HOWA-8006A   | $175.82       |
|           |            |                |              |              |                |           |         |             |                |                |                | HOWA-8006C   | $183.24       |
|           |            |                |              |              |                |           |         |             |                |                |                | HOWA-82006   | $210.88       |
| K1-17-05  | 8"         | 0.649 (17mm)   | 12mm         | 0.905        | 0.905         | 2.250     | 2.000   | 3           | 0.500          | 0.500          | 1.000          | RAB-8006A    | $112.30       |
|           |            |                |              |              |                |           |         |             |                |                |                | RAB-8006C    | $126.72       |
|           |            |                |              |              |                |           |         |             |                |                |                | RAB-82006    | $254.36       |

### HARD JAWS

- Designed for first operation roughing.
- Designed standard for high production runs.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life.
- Ideal for castings and scaly material.
- Made in the USA.

### ABRASIVES

| Group No. | Chuck Size | Groove Width G | Screw Size E | Hole Space A | Hole To Front J | Pie Dia B | Height C | No. of Steps | Top Step Ht S1 | Mid Step Ht S2 | Bot Step Ht S3 | Part Number | Price Per Set |
|-----------|------------|----------------|--------------|--------------|----------------|-----------|---------|-------------|----------------|----------------|----------------|-------------|---------------|---------------|
| K1-16-05  | 8"         | 0.638 (16mm)   | 12mm         | 3.387        | 3.387         | 1.590     | 1.800   | 2           | 2.000          | 0.500          | 0.500          | RSG-8006A    | $172.30       |
|           |            |                |              |              |                |           |         |             | 5               | 1.000          | 1.000          | RSG-8006C    | $179.72       |

### Need Help Selecting The Correct Jaws For Your Chuck?

Our “Easy Jaw Finder” is located on Pages 622-634!

### Need Special Order Jaws? Special Orders Are Our Specialty!

Please fill out and fax us a Chuck Jaw Special Order Form, located on Pages 635-640.
SOFT JAWS - 1.5 mm x 60° Serrations

FOR USE ON: SMW Autoblok, Howa, Suga & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Available in Aluminum & Steel

JAW NUTS AND SCREWS

Jaw Boring Ring (comes complete with 3 pin assemblies)

FEATURES:

- Ideal for machining soft jaws.
- Attaches quickly without tools.
- Applies equal pressure on all jaws.
- Attaches to front of jaws, compensating for jaw lift.
- Pin or bungy are used to clamp jaws, through boring of jaws is possible.

Save Set-Up Time!
ROUND JAWS- 1.5 mm x 60° Serrated

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

**Chuck jaws**
- Made in the USA
- Available in Aluminum, Cast Iron & Steel
- Oversized jaws available
- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpiece
- All jaws type 3 holes
- Standard, extra bite, or XTRA-BITE versions available
- Made in the USA

**SHARK JAWS**
- Designed for first operation roughing
- Have ground teeth for extra gripping power and ground body to prevent chatter
- Choose from XTRA-BITE, GIANT JAWS or OEM Style jaws

**FULL SIZE JAWS**
- Choose from Aluminum Casting T6, CAST IRON, STEEL, or Spring Steel Materials

**ABRASIVES MEASURING TOOLS**
- Choose from XTRA-BITE, GIANT JAWS, or OEM Style jaws

**END MILLS, DRILLS, INDEXABLE DRILLS**
- Choose from ER, DA, TG COLLETS

**TOOLHOLDERS & MACHINE VISES**

**MRO & SAFETY**
### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Groove Width A</th>
<th>Screw Size D</th>
<th>Hole Space C</th>
<th>Hub To Front Length B</th>
<th>Length C</th>
<th>Width D</th>
<th>Industry Reference #</th>
<th>Price End Part Number</th>
<th>Price End Part Number</th>
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**Critical Dimensions**
- **ALUMINUM**
- **STEEL**
- **FOR USE ON:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks
- **1.5mm x 60° serrations**
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or rounded for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)
ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

• 1.5mm x 60° serrations
• Round jaws allow for complete gripping of workpiece
• Oversized jaws available
• Ideal for thin-walled or irregular shaped workpieces.
• Can be machined to fit workpiece
• Various length of serrations: 5.12”
• Special J dimensions available
• Available in Aluminum, Cast Iron & Steel
• Aluminum round jaws made from solid extruded aluminum (up to 15” dia)
• Made in the USA

CRITICAL DIMENSIONS

<table>
<thead>
<tr>
<th>Group</th>
<th>No.</th>
<th>Chuck Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Dia.</th>
<th>Industry Ref #</th>
<th>Price Per Set</th>
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HARD JAWS

• Designed for first operation roughing, expect standard runout between 0.005-0.010
• Shark Jaws have conical teeth for extra gripping power and black oxide for long life.
• Ideal for castings and scaly material.
• Made in the USA.

SPECIAL ORDER JAWS AVAILABLE!

• Super Quick Turnaround Time- 3 Days Or Less In Most Cases!
• Special Order Round Jaws Up To 32” dia!
• Special Order Soft Jaws Up To 9” Height!
• Soft Jaws Available In Any Length-Steel Or Aluminum
• Tongue And Groove, Square Serrated & Acme Serrated Jaws Up To 8” Height!
• Made Per Your Special Specifications In The USA! Please See Our Special Order Forms On Pages 635-640.

Please Call Today For A Quote!
SOFT JAWS - 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

CRITICAL DIMENSIONS

<table>
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<tr>
<th>Group No.</th>
<th>Chuck Make &amp; Model</th>
<th>Screw Size</th>
<th>Pitch &amp; Length</th>
<th>Screw Length</th>
<th>Jaw Nut Part Number</th>
<th>Price Each</th>
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<td>M12-1.75 x 35mm</td>
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<td>(39mm)</td>
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<td>MMK ZA-10</td>
<td>M12-1.75 x 35mm</td>
<td>1.525</td>
<td>(39mm)</td>
<td>0.54</td>
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<td>Howa HO15M12, HO22M12</td>
<td>M14-2.00 x 40mm</td>
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<td>(27mm)</td>
<td>0.945</td>
<td>HO-100JN</td>
<td>$31.80</td>
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POWER CHUCK LUBRICANT

FEATURES:
- Double the Triple Clamping Pressure.
- Parts in Place Clamped in Place.
- Provides Boundary Lubrication Protection.
- Lowers Fretz and Shave.
- Assists in Wear-In of New Chucks.
- Lowers Maintenance Costs.
- High Resistance to Centrifuge Forces.

For Best Results, Grease Your Chuck Once Per Shift!

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<th>Container Size</th>
<th>Case Qty</th>
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<th>Price Each</th>
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<td>40 Oz Cartridge</td>
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<td>450 Lb Drum</td>
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For use on standard or special chucks, please consult your U.S. Shop Tools representative.

For more information, visit usshoptools.com or call 800-243-7701.
Chuck Jaws & Workholding

**MRO & SAFETY**

- Abrasives
- Toolholders
- Machine Vises
- Lathe Workholding
- Measuring Tools
- Taps & Reamers
- Turning & Boring
- ER, DA, TG Collets
- Vise Jaws

ENDMILLS, DRILLS

- Indexable Drills

Parts per Group

**INDEXABLE DRILLS TURNING & BORING**

**TOOL HOLDERS FOR CHUCKS & COLLECTORS**

**MACHINES & VISES USEFUL WITH CHUCKS**

** Chuck Jaws (Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks)

**Round Jaws - 1.5 mm x 60° Serrations**

- For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks
- Round jaws allow for complete gripping of the workpiece.
- Oversized jaws available.
- Ideal for thin-walled or irregular workpieces.
- Can be machined to fit the workpiece.
- Max. length of serrations: 5.75 inches.
- All jaws have 2 holes.
- Special J dimensions available.
- Available in Aluminum, Cast Iron & Steel.
- Made in the USA.

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Holes Space</th>
<th>Width</th>
<th>Height</th>
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<td>1/2-13</td>
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</table>

**Round Jaw Material:**

- Aluminum Casting T6
- Cast Iron
- Steel

**Aluminum**

- Made in the USA
- Available in Aluminum, Cast Iron & Steel
- Special "J" dimensions available
- All jaws have 2 holes
- Max. length of serrations: 5.75 inches
- Can be machined to fit the workpiece
- Ideal for thin-walled or irregular workpieces
- Oversized jaws available
- Round Jaws allow for complete gripping of the workpiece

**Hard Jaws**

**Abrasives & Grinding Tools**

**Width & Safety Tools**

**For Use On:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

**Price Set:**

- KT-120HJ1: KT-120HJ1-X $476.28
- KT-120HJ2: KT-120HJ2-U $384.75
- KT-120HJ3: KT-120HJ3-X $405.00
- KT-120HJ4: KT-120HJ4-U $384.75
- KT-120HJ5: KT-120HJ5-U $384.75

**Part Number:**

- KT-120HJ1: KT-120HJ1-X $476.28
- KT-120HJ2: KT-120HJ2-U $384.75
- KT-120HJ3: KT-120HJ3-X $405.00
- KT-120HJ4: KT-120HJ4-U $384.75
- KT-120HJ5: KT-120HJ5-U $384.75

**Style Code:**

- KT-120HJ1: KT-120HJ1-X $476.28
- KT-120HJ2: KT-120HJ2-U $384.75
- KT-120HJ3: KT-120HJ3-X $405.00
- KT-120HJ4: KT-120HJ4-U $384.75
- KT-120HJ5: KT-120HJ5-U $384.75

**Please See Page 12 For Dimensional Diagrams**
SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be turned or turned to fit workspace
- Steel jaws can be hardened
- All jaws have 2 holes
- Available flat ended or pointed for finish turning operations
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Size</th>
<th>Pitch &amp; Length</th>
<th>Length</th>
<th>Width</th>
<th>Industry Code</th>
<th>Flat-End Part Number</th>
<th>Price Each</th>
<th>Price 3 Sets</th>
<th>Price 5 Sets</th>
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<tbody>
<tr>
<td>KT-15-30</td>
<td>10&quot; &amp; 12&quot;</td>
<td>0.709 (16mm)</td>
<td>14mm</td>
<td>1.611 (30mm)</td>
<td>2.005</td>
<td>2.075</td>
<td>4.000</td>
<td>1.360</td>
<td>KT-1500AF</td>
<td>KT-1500AP</td>
<td>$15.70</td>
<td>$45.00</td>
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<td>2.005</td>
<td>2.075</td>
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<td>2.005</td>
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<td>KT-1500AF</td>
<td>KT-1500AP</td>
<td>$15.70</td>
<td>$45.00</td>
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- Soft Jaw Material: ALUMINUM - K1-18-30 10" & SAMCHULLY KITAGAWA HOWA PC-12-93

<table>
<thead>
<tr>
<th>Kitagawa</th>
<th>Check Size</th>
<th>Groove Width</th>
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<th>Pitch &amp; Length</th>
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<th>Width</th>
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<th>Price 3 Sets</th>
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<tr>
<td></td>
<td>12&quot;</td>
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<td>KT-12AF</td>
<td>KT-12AP</td>
<td>$15.70</td>
<td>$45.00</td>
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</table>

- Made in the USA

For “Flat End” Soft Jaws, please substitute “F” in “P” in the part number. Examples KT-1500AF $15.70 KT-1500AF $15.70 For Pointed Jaws

Soft Jaw Material: ALUMINUM-1016Ti Bar Stock, STEEL-5160 or 1018, "K" JAWS-7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item-please allow 1 week manufacturing time.

Critical Dimensions

<table>
<thead>
<tr>
<th>Kitagawa</th>
<th>Check Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Size</th>
<th>Length</th>
<th>Width</th>
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<th>Flat-End Part Number</th>
<th>Price Each</th>
<th>Price 3 Sets</th>
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<tbody>
<tr>
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<td>2.005</td>
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<td>1.360</td>
<td>KT-12AF</td>
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<td>$15.70</td>
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- Screws Included With Each Jaw Nut

Critical Dimensions

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<th>Kitagawa</th>
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<th>Screw Size</th>
<th>Hole Size</th>
<th>Pitch &amp; Length</th>
<th>Length</th>
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<th>Flat-End Part Number</th>
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<th>Price 3 Sets</th>
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<td>$45.00</td>
</tr>
</tbody>
</table>


2012-13 Master Catalog 29
**CHUCKS & JAWS FOR MACHINE TOOLS**

**XTRA BITE**

**ENDMILLS, DRILLS, ABRASIVES**

**MACHINE VISES & TIGHTENING TOOLS**

**TURNING & BORING TAP HOLDERS**

**FLAT STOCK/DRILL ROD MEASURING TOOLS**

**CHUCK JAWS 1.5 mm x 60° Serrations**

For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Round jaws allow for complete gripping surface
- Overized jaws available
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpiece
- Max. length of serration: 5.75"
- All jaws have 2 holes
- Made in USA

**K1**

**MAKINAWA**

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<th>Group No.</th>
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<td>2.875</td>
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**SHARK JAWS GRIP-RITE/OEM Style**

- Aluminum round jaws made from solid extruded aluminum (up to 15” dia)
- Made in USA

**HARD JAWS**

**ABRASIVES**

**INDEXABLE DRILLS & REAMING TOOLS**

**TOOL HOLDERS**

**RETENTION KNOB & TOP COLLET**

**INDEXABLE DRILLS & REAMING TOOLS**

**ENDMILLS, DRILLS & REAMING TOOLS**

**WEIGHT & SAFETY**

**U S Shop Tools** | Sales: 800-243-7701 | Fax: 800-342-3311 | www.usshoptools.com

**2012-13 Master Catalog**
SOFT JAWS - 1.5 mm x 60° Serrations

**FOR USE ON:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- **1.5 mm x 60° serrations**
- Supplies maximum concentricity on finish turning operations.
- **All jaws have 2 holes**
- **80° angle for *90°* workpiece**
- **Steel jaws can be hardened**
- Available flat endwise or point for smaller diameter parts
- **Special orders available**
- **Available in Aluminum, Steel & Aircraft Aluminum (where noted)**

- **Max. length of serrations:** 5.75" (145.0 mm)

---

<table>
<thead>
<tr>
<th>Critical Dimensions</th>
<th>ALUMINUM</th>
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<tr>
<td>Width</td>
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<tr>
<td>3.000</td>
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</tr>
<tr>
<td>3.000</td>
<td>2.250</td>
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</tbody>
</table>

---

**For "Pointed" Soft Jaws, please substitute**

**Example:**

- **KT-12308F $90.67**
- **KT-12308F $75.33**
- **KT-12258-38F $80.00**
- **KT-12258-38F $80.00**
- **KT-12258-28F $80.00**
- **KT-12258-28F $80.00**
- **KT-12258-28F $80.00**
- **KT-12258-28F $80.00**

---

**For complete list of applicable chucks, see pages 622-634**

- **K1-21-30**
- **SAMCHULLY**
- **KITAGAWA**
- **STRONG**
- **HOMA**
- **SMW Autoblok**
- **BBM-305**
- **SMW-350/351**

**QUANTITY DISCOUNTS!**

- **5%  OR MORE**
- **10%**
- **15%**
- **20%**

---

**Critical Dimensions**

**JAW NUTS & SCREWS**

**Critical Dimensions**

**JAW BORING RINGS**

- No need to look all over the shop for a setup piece and waste time. Our jaw boring ring is essential for boring soft jaws and round jaws.

- **Features:**
  - **Made for machining soft jaws.**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**
  - **Attaches to thru-hole soft jaws and round jaws**

**Save Set-Up Time!**

**Jaw Boring Ring (comes complete with 3 pin assemblies)**

**USST**

**U S Shop Tools**

**Sales:** 800-243-7701 **Fax:** 800-342-3311  **www.usshoptools.com**

2012-13 Master Catalog 31
**ROUND JAWS - 1.5 mm x 60° Serrations**

**FOR USE ON:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 3 holes
- Special J dimensions available
- Made in the USA

### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Throat Dia.</th>
<th>Jaw Material</th>
<th>Industry Reference</th>
</tr>
</thead>
</table>
| A1-105-02 | 12         | 1.260 mm    | ALUMINUM     | 1/2-13UN 
|           |            |             | CAST IRON    | K1-21-35          |
|           |            |             | STEEL        |                  |

#### Aluminum Round Jaws

- For complete list of applicable chucks, see pages 622-634.*
- * denotes non-stock item. Please allow 1 week manufacturing time.

- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Round Jaw Material:
  - K1-21-35
  - K1-20-35
  - K1-18-38

- *Kitagawa is a registered trademark of Kitagawa NorthTech.

---

**CNC Hydraulic Power Chucks**

**N-200A SERIES 3 JAW CHUCKS**

- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- For complete list of applicable chucks, see pages 622-634.*
- Special J dimensions available
- Made in the USA

### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Throat Dia.</th>
<th>Jaw Material</th>
<th>Industry Reference</th>
</tr>
</thead>
</table>
| RMT-12000A | 12         | 1.260 mm    | ALUMINUM     | 1/2-13UN 
|           |            |             | CAST IRON    | K1-21-35          |
|           |            |             | STEEL        |                  |

- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Round Jaw Material:
  - K1-21-35
  - K1-20-35
  - K1-18-38

- *Kitagawa is a registered trademark of Kitagawa NorthTech.

---

**U S Shop Tools**

Sales: 800-243-7701  Fax: 800-342-3311  www.usshoptools.com
SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

* Max. length of serrations: 3.75”

- 1.5mm x 60° serrations
- Supplied maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

Critical Dimensions

<table>
<thead>
<tr>
<th>Group #</th>
<th>Check Size</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Spacing</th>
<th>Width</th>
<th>Length</th>
<th>No. of Holes</th>
<th>Price Each</th>
<th>Price Set of 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>K1-10-15</td>
<td>12</td>
<td>0.873 (38mm)</td>
<td>M16-2.00x40mm</td>
<td>Max. 3/4</td>
<td>1.378 (35mm)</td>
<td>1.578</td>
<td>2</td>
<td>$66.46</td>
<td>$132.90</td>
</tr>
<tr>
<td>K1-10-15</td>
<td>12</td>
<td>0.873 (38mm)</td>
<td>M12-1.75x45mm</td>
<td>Max. 3/4</td>
<td>1.378 (35mm)</td>
<td>1.578</td>
<td>2</td>
<td>$50.50</td>
<td>$101.00</td>
</tr>
</tbody>
</table>

For “Pointed” Soft Jaws:

- Soft Jaw Material: ALUMINUM-7075-T6 Aircraft Aluminum
- Available flat ended or pointed for specific applications
- Steel jaws can be hardened
- Can be bored or turned to fit workpiece
- All jaws have 2 holes

Critical Dimensions

<table>
<thead>
<tr>
<th>Check Mate &amp; Model</th>
<th>Groove Width</th>
<th>Screw Size</th>
<th>Hole Spacing</th>
<th>Width</th>
<th>Length</th>
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<tr>
<td>2”</td>
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<td>1.378 (35mm)</td>
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<td>3/4”</td>
<td>0.450</td>
<td>0.927 (38mm)</td>
<td>M16-2.00x40mm</td>
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<td>1.140</td>
<td>2</td>
<td>$50.50</td>
<td>$101.00</td>
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</table>

QUANTITY DISCOUNTS!

Order 1 sets OR MORE of the same part number and receive a 5% DISCOUNT!
**CHUCK JAWS - ENDMILLS & DRILLS**

**MACHINE VISES & CHUCKS**

- **RETENTION KNOBS**
- **TOOL HOLDERS & VISES**
- **INDEXABLE DRILLS & HOLE SAWING TOOLS**
- **ENDMILLS & DRILLS FOR TAPPING & DRILLING**
- **MEASURING TOOLS**
- **ABRASIVES**
- **MACHINE VISES & CHUCKS**
- **SPECIAL ADHESIVES & FASTENERS**

**DIGIT COUNTER MICROMETERS**

**DIGITAL CALIPERS**

**MADE IN THE USA**

**Chuck Jaws- 1.5 mm x 60° Serrations**

For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- **1.5mm x 60° serrations**
  - Round Jaws allow for complete gripping of workplace
  - Oversized jaws available
  - Ideal for thin-walled or irregular shaped workpieces
  - Can be machined to fit workplace
  - Max. length of serrations: 5.75"
  - All jaws have 2 holes
  - Special “Z” dimensions available
  - Available in Aluminum & Cast Iron
  - Made in the USA

**Round Jaw Material:** B-15, B-18, PC-15-120, K1-22-43, N215/18, HAH/HCH 15, HAH/HCH 18

<table>
<thead>
<tr>
<th>Group</th>
<th>Size</th>
<th>Width</th>
<th>Depth</th>
<th>Hole to Front</th>
<th>No. of Steps</th>
</tr>
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<tbody>
<tr>
<td>15&quot; &amp; UP</td>
<td>0.866 (22mm)</td>
<td>20mm</td>
<td>60°</td>
<td>1.602 (64mm)</td>
<td>3.750</td>
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</tbody>
</table>

**Round Jaws- 1.5 mm x 60° Serrations**

- MKHA-15
c
- HAH-15
c
- HOB-18
c
- HOB-15
c
- HOH-18
c

**Critical Dimensions**

- Width G 0.866 (22mm)
- Groove Width D 0.866 (22mm)
- Front Depth J 1.602 (64mm)
- Height A 3.750

**ALUMINUM & CAST IRON/STEEL**


**XTRA-BITE**

- Designed for first operation roughing
- Expect standard runout between 0.000-0.010
- Positive locking nut on spindle
- Carbide tipped measuring faces
- Microfine graduations on satin chrome
- Resolution: .0001" (using vernier)
- Digital counter

**SHARK JAWS**

- Designed for first operation roughing
- Expect standard runout between 0.000-0.010
- Positive locking nut on spindle
- Carbide tipped measuring faces
- Microfine graduations on satin chrome
- Resolution: .0001" (using vernier)
- Digital counter

**HARD JAWS- 2 STEP**

- Sizes over 1" include standard
- Positive locking nut on spindle
- Carbide tipped measuring faces
- Microfine graduations on satin chrome
- Resolution: .0001" (using vernier)
- Digital counter

**DIGITAL CALIPERS**

- Digital counter
- Resolution: .0001" (using vernier)
- Microfine graduations on satin chrome
- Positive locking nut on spindle
- Scales over 1" include standard

**DIGIT COUNTER MICROMETERS**

- Digital counter
- Resolution: .0001" (using vernier)
- Microfine graduations on satin chrome
- Positive locking nut on spindle
- Scales over 1" include standard

**U S Shop Tools**

Sales: 800-243-7701  Fax: 800-342-3311  www.usshoptools.com

2012-13 Master Catalog
SOFT JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bolted or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)

JAW NUTS & SCREWS

Critical Dimensions

<table>
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<th>Group No.</th>
<th>Chuck Size</th>
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<td>2.500</td>
<td>K1-15250BF</td>
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</table>

For complete list of applicable chucks, see pages 622-634 of this master catalog.

Price:
- 1.5mm (43mm) $150.00
- 2.0mm (55mm) $200.00

For further information, please contact US Shop Tools at 800-243-7701 or visit usshoptools.com.
For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Round jaws allow for complete gripping of workpiece
- Oversized jaws available
- Used for thin-walled or irregular shaped workpieces
- Can be machined by fit workpiece
- Max. length of serrations: 5.75”
- All jaws have 2 holes
- Made in Aluminum & Cast Iron
- Made in the USA

Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Groove Width (mm)</th>
<th>Screw Size</th>
<th>Hole Size (mm)</th>
<th>Height in Front (mm)</th>
<th>Industry Reference #</th>
<th>Part Number</th>
<th>Price Set of 5</th>
<th>Price Set of 20</th>
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<tbody>
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<td>416-04-42</td>
<td>15” &amp; Up</td>
<td>1.605 (25.5mm)</td>
<td>20mm</td>
<td>3.750</td>
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<tr>
<td>416-05-42</td>
<td>15” &amp; Up</td>
<td>1.605 (25.5mm)</td>
<td>20mm</td>
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<td>1.500</td>
<td>12-9KT-11501A</td>
<td>500.00</td>
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</table>

Hard Jaws- 2 Step

- Designed for first operation roughing, second operation finishing
- Hard jaws allow for complete gripping of workpiece
- XTRA BITE- very aggressive bite. Has critical tip for work gripping power and ground body
- SPIDER- Diam Style jaws have ground tips for improved gripping power.
- SPIKE- Style jaws have ground tips for extra gripping power and black oxide for long life.
- GRIP RITE- long serrations for extra gripping power and standard length conical hard jaws have ground teeth for extra gripping power and ground body.
- XTRA BITE- suitable for OD & ID workholding.

Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Groove Width (mm)</th>
<th>Screw Size</th>
<th>Hole Size (mm)</th>
<th>Hole to Front (mm)</th>
<th>Industry Reference #</th>
<th>Part Number</th>
<th>Price Set of 5</th>
<th>Price Set of 20</th>
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<td>416-04-42</td>
<td>15” &amp; Up</td>
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<td>12-9KT-11501A</td>
<td>315.00</td>
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<tr>
<td>416-05-42</td>
<td>15” &amp; Up</td>
<td>1.605 (25.5mm)</td>
<td>20mm</td>
<td>3.750</td>
<td>1.500</td>
<td>12-9KT-11501A</td>
<td>500.00</td>
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</table>

Denim Shop Aprons

- 100% blue cotton denim
- “E” version includes waist pocket
- “PP” version includes chest pocket or arm holder
- One size fits all
- 35” length w/ 20” wide

USST

- Noise buds secure the glasses and prevent slipping while providing a pillow soft fit
- Temples adjust to four different lengths
- Lenses provide 99% protection against harmful UV rays
- Exceed ANSI Z87.1-2003 standards

<table>
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<th>Style</th>
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<th>Lens Color</th>
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<td>Blue</td>
<td>Clear</td>
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<td>$16.99</td>
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U S Shop Tools
Sales: 800-243-7701
Fax: 800-342-3311
www.usshoptools.com

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2012-13 Master Catalog
### LATHE CHUCKS

- Live Centers
- Vise Jaws
- Vise Accessories
- Straight Shank
- Tap Holders
- Drill Chucks
- Precision Tool Holders
- Coolant/Fluids
- Tool Storage
- Cutting Tools
- Machinists Tools
- Precision Tools
- Deburring
- Critical Dimensions

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Make &amp; Model</th>
<th>Blank Width G</th>
<th>Screw Size E</th>
<th>Height A</th>
<th>Height to Front J</th>
<th>Width B</th>
<th>Length H</th>
<th>Industry Reference</th>
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<td>(41.9mm)</td>
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<td>K1-26-41</td>
<td>Strong®</td>
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<td>(41.9mm)</td>
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<td>(41.9mm)</td>
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<td>K1-26-41</td>
<td>SMW Autoblok</td>
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<td>25mm</td>
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<td>K1-26-41</td>
<td>Howa</td>
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<td>25mm</td>
<td>1.650</td>
<td>(41.9mm)</td>
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<td>K1-26-41</td>
<td>Hitachi-Seiki</td>
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<td>(41.9mm)</td>
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</table>

#### Soft Jaws- 1.5 mm x 60° Serrations

*For Use On: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks*

- 1.5 mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workplace
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)
- Max. length of serrations: 5.75"

#### Soft Jaw Material:

- ALUMINUM - 6061-T6 Bar Stock,
- STEEL - 1018,
- "B" JAWS - 7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 622-634

* denotes non-stock item. Please allow 1 week manufacturing time.

#### JAW NUTS & SCREWS

- Max. length of serrations: 5.75"
- Flat End of serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workplace
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum

#### LATHE TOOLHOLDER BUSHINGS

Please See Pages 128-132 For More Information!

- Increased step diameter for easy and perfect sealing.
- Conforming ground and diamond polished OD & ID
- "Easy Entry" feature on OD for quick insertion
- Wrench flats for easy removal
- Step relief for easy removal and gripping on Z style bushings
- Type and size clearly marked on surface of head diameter for easy identification
- 100% Satisfaction Guaranteed

#### SPECIFICATIONS:

- Material: ALLOY STEEL 8620
- Hardness Data: Rc 55-57 for longer tool life
- Case hardened and ground concentric OD & ID
- Axial Concentricity: OD & ID- 0.002"
- Tolerance: H6 & g6 in grinding the OD & ID
- Made in the USA

#### QUANTITY DISCOUNTS!

- Order 5 SETS OR MORE of the same part number soft jaw and receive a 5% DISCOUNT!
- For “Pointed” Soft Jaws, please substitute “P” for “F” in the part number.
- Example: NK-14250AF will be NK-14250AP. Pointed Jaws add $6.50.

#### JAW NUTS & SCREWS

- Multifunctional design
- Easily adjustable
- Precise tool holding
- Durable and reliable

#### USST

- Critical Dimensions
- Made in the USA

#### US Shop Tools

- Sales: 800-243-7701
- Fax: 800-342-3311
- www.usshoptools.com

2012-13 Master Catalog
**CHUCK JAWS**

- Lathe Workholding
- Machine Vises
- Vise Jaws
- Retention Knobs & Collets
- Er, Da, TG Collets
- Toolholders
- Tap Holders
- Indexable Drills
- Turning & Boring
- Endmills, Drills
- Taps & Reamers
- Abrasives
- Measuring Tools
- MRO & Safety

---

**ROUND JAWS- 1.5 mm x 60° Serrations**

For use on: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- 1.5mm x 60° serrations
- Round jaws allow for complete gripping of workpieces
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpieces to 5/16” in diameter
- All jaws have 2 holes
- Special “J” dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA

---

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Grooves/Rows</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>Hole to Front</th>
<th>Industry Reference #</th>
<th>Part Number</th>
<th>Price Set of 3</th>
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</thead>
<tbody>
<tr>
<td>K1-23-65</td>
<td>15” &amp; Up</td>
<td>0.866 (2 rows)</td>
<td>2.50 (0.63)</td>
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<td>RKT-15252CI</td>
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<tr>
<td>K1-23-66</td>
<td>15” &amp; Up</td>
<td>2.389 (6 rows)</td>
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<td>3.750 (95mm)</td>
<td>2.300 (58mm)</td>
<td>RKT-15302A</td>
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<td>RKT-15302CI</td>
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<tr>
<td>K1-23-67</td>
<td>18” &amp; Up</td>
<td>3.168 (3 rows)</td>
<td>3.00 (0.76)</td>
<td>4.000 (101mm)</td>
<td>2.000 (50mm)</td>
<td>RKT-15402A</td>
<td>$539.82</td>
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<td>K1-23-68</td>
<td>21” &amp; Up</td>
<td>4.188 (4 rows)</td>
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<td>2.000 (50mm)</td>
<td>RKT-15502A</td>
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<td>RKT-15502CI</td>
<td>-</td>
<td>-</td>
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<tr>
<td>K1-23-69</td>
<td>24” &amp; Up</td>
<td>5.188 (5 rows)</td>
<td>4.00 (1.0)</td>
<td>4.000 (101mm)</td>
<td>2.000 (50mm)</td>
<td>RKT-15602A</td>
<td>$971.86</td>
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<td>RKT-15602CI</td>
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<td>-</td>
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</table>

---

- 1.5mm x 60° serrations
- Round jaws allow for complete gripping of workpieces
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpieces to 5/16” in diameter
- All jaws have 2 holes
- Special “J” dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA

---

**Special Orders Are Our Specialty!**

Do you need a special dimension that is not listed in our catalog? No problem! We can supply you with customized chuck jaws to fit your specifications. Whether you need a special height, width, diameter or step height, call us for all of your customized workholding needs!

---

**Please Call Today For A Quote!**

U S Shop Tools  Sales: 800-243-7701  Fax: 800-342-3311  www.usshoptools.com

---

**1.5mm x 60° Serrations**


For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

---

**SUPER QUICK TURNAROUND TIME- 3 DAYS OR LESS IN MOST CASES!**

- Special Order Round Jaws Up To 32” dia!
- Special Order Soft Jaws Up To 8” Height!
- Soft Jaws Available In Any Length-Steel Or Aluminum
- Tongue And Groove, Square Serrated & Acme Serrated Jaws Up To 8” Height!
- Made Per Your Special Specifications In The USA! Please See Our Special Order Forms On Pages 635-640.

---

**Special Orders Are Our Specialty!**

Do you need a special dimension that is not listed in our catalog? No problem! We can supply you with customized chuck jaws to fit your specifications. Whether you need a special height, width, diameter or step height, call us for all of your customized workholding needs!
### SOFT JAWS- 1.5 mm x 60° Serrations

**FOR USE ON:** Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks

- **1.5mm x 60° serrations**
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum & Steel
- Made in the USA

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Groove Width G</th>
<th>Screw Size E</th>
<th>Hole Space D</th>
<th>Height Inch A</th>
<th>Height To Front J</th>
<th>Width Inch C</th>
<th>Length Inch B</th>
<th>No. of Holes</th>
<th>Price Set Of 3</th>
<th>Price Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>K1-24-45</td>
<td>14 or 16</td>
<td>0.827 (21mm)</td>
<td>1.771 (34mm)</td>
<td>2.500</td>
<td>2.893</td>
<td>3.000</td>
<td>2.750</td>
<td>3.000</td>
<td>2</td>
<td>$46.12</td>
<td>$46.12</td>
</tr>
<tr>
<td>K1-25-45</td>
<td>15 &amp; Up</td>
<td>0.886 (22mm)</td>
<td>2.360 (50mm)</td>
<td>3.000</td>
<td>2.893</td>
<td>3.000</td>
<td>2.750</td>
<td>3.000</td>
<td>2</td>
<td>$46.12</td>
<td>$46.12</td>
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<tr>
<td>K1-26-45</td>
<td>16</td>
<td>1.053 (26.5mm)</td>
<td>1.496 (38mm)</td>
<td>3.000</td>
<td>2.893</td>
<td>3.000</td>
<td>2.750</td>
<td>3.000</td>
<td>2</td>
<td>$46.12</td>
<td>$46.12</td>
</tr>
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</table>

#### Soft Jaw Material:
- **Aluminum:** 6061-T6 Bar Stock
- **Steel:** 1018
- **B** Jaws: 7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 622-634 * denotes non-stock item. Please allow 1 week manufacturing time.

#### Jaw Nuts & Screws

- **Flat End**
- **Pointed End**
- **Supplies maximum concentricity on finish turning operations**
- **Can be bored or turned to fit workpiece**
- **Steel jaws can be hardened**
- **Available flat ended or pointed for smaller diameter parts**
- **Special orders available**
- **Available in Aluminum & Steel**
- **Made in the USA**

---

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Chuck Make &amp; Model</th>
<th>Chuck Size</th>
<th>Heat Height B</th>
<th>Groove Width G</th>
<th>Screw Size E</th>
<th>Hole Space D</th>
<th>Height Inch A</th>
<th>Height To Front J</th>
<th>Width Inch C</th>
<th>Length Inch B</th>
<th>No. of Holes</th>
<th>Price 2 Screws Included With Each Jaw Nut</th>
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<td>K1-24-45</td>
<td>14 or 16</td>
<td>0.827 (21mm)</td>
<td>1.771 (34mm)</td>
<td>2.500</td>
<td>2.893</td>
<td>3.000</td>
<td>2.750</td>
<td>3.000</td>
<td>2</td>
<td>$46.12</td>
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<td>3.000</td>
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<td>$46.12</td>
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**ROUND JAWS- 3.0 mm x 60° Serrations**

For use on: MMK Matsumoto, Howa & Other Chucks

- 3.0 mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece.
- Max. length of serrations: 5.75
- All jaws have 2 holes.
- Serrations are fully available on all round and flat jaws.
- Made in the USA

### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Jaw Size</th>
<th>Width</th>
<th>Height</th>
<th>Industry Ref</th>
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</table>

### Features:
- Designed for first operation roughing.
- XTRA BITE:Tooth design allows for improved runout.
- 2 step/jaw available for 0.635 mm & Larger Jaws.

### Abasives Measuring Tools

<table>
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<tr>
<th>Group No.</th>
<th>Jaw Size</th>
<th>Diameter</th>
<th>Size</th>
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<td>1.250 (30mm)</td>
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<td>4.000</td>
<td>$180.00</td>
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</table>
SOFT JAWS- 3.0 mm x 60° Serrations

FOR USE ON: MMK Matsumoto, Howa & Other Chucks

- 3.0mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available in stainless steel (except for Howa-10mm)
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)
- Made in the USA

C

JAW NUTS & SCREWS

FREE SCREWS!

2 High Grade Socket Head Cap Screws Provided With Each Jaw Nut

CRITICAL DIMENSIONS

| Group No. | Screw Size | Hole Space A | Hole Space B | Hole to Front | Length of Groove | Width of Screw
<table>
<thead>
<tr>
<th></th>
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FEATURES:
- Doubles as Triple Clamping Pressure.
- Keeps Work Piece Clamped in Place.
- Provides Extra Lubrication Protection.
- Assists in Wear-In of New Chucks
- Lowers Maintenance Costs.
- Keeps Work Piece Clamped in Place.
- Double to Triple Clamping Pressure.

QUANTITY DISCOUNTS:

- 5% Discount! Ordering 5 or more of the same part number will earn and receive a 5% Discount!
- For optimum performance, it is recommended that you grease your chuck once per shift.


2012-13 Master Catalog 41
### ROUND JAWS- 3.0 mm x 60° Serrations

**FOR USE ON:** Kitagawa®, Samchully®, MMK Matsumoto, Howa & Other Chucks

- **3.0mm x 60° Serrations**
- Round Jaws allow for complete gripping of workpiece
- Do not require clamping at the edge
- For use on lathe workholding

### Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>K3-25-48</th>
<th>K3-32-48</th>
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</thead>
<tbody>
<tr>
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<td>18-24</td>
</tr>
<tr>
<td><strong>System</strong></td>
<td>20mm</td>
<td>20mm</td>
</tr>
<tr>
<td><strong>Groove Width</strong></td>
<td>0.027 (mm)</td>
<td>0.034 (mm)</td>
</tr>
<tr>
<td><strong>Round Jaws</strong></td>
<td>1.575 (mm)</td>
<td>2.50 (mm)</td>
</tr>
<tr>
<td><strong>Height</strong></td>
<td>1.969 (mm)</td>
<td>2.50 (mm)</td>
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### MACHINES & TOOLS

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<td><strong>Size</strong></td>
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<td>18-24</td>
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<td>2.50 (mm)</td>
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<tr>
<td><strong>Height</strong></td>
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### UNITS & DIMENSIONS

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<th>Group</th>
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</tr>
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<tbody>
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<td>18-24</td>
</tr>
<tr>
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<td>20mm</td>
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<td>0.034 (mm)</td>
</tr>
<tr>
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<td>1.575 (mm)</td>
<td>2.50 (mm)</td>
</tr>
<tr>
<td><strong>Height</strong></td>
<td>1.969 (mm)</td>
<td>2.50 (mm)</td>
</tr>
</tbody>
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### MANUFACTURERS & APPLICATIONS

- **K3-25-48**
  - **Samchully**
    - HAH/HCH 24
  - **Kitagawa**
    - H-18-162, HA11-18, HA11-15, HA8-15
  - **MMK**
    - B-24
  - **MTO**
    - B-24

- **K3-32-48**
  - **Samchully**
    - KAA-24 RHH C 250

### HOLE & LENGTH DIMENSIONS

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<th>K3-32-48</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Size</strong></td>
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</tr>
<tr>
<td><strong>System</strong></td>
<td>20mm</td>
<td>20mm</td>
</tr>
<tr>
<td><strong>Groove Width</strong></td>
<td>0.027 (mm)</td>
<td>0.034 (mm)</td>
</tr>
<tr>
<td><strong>Round Jaws</strong></td>
<td>1.575 (mm)</td>
<td>2.50 (mm)</td>
</tr>
<tr>
<td><strong>Height</strong></td>
<td>1.969 (mm)</td>
<td>2.50 (mm)</td>
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</tbody>
</table>

### ALUMINUM & CAST IRON

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<th>K3-32-48</th>
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</thead>
<tbody>
<tr>
<td><strong>Size</strong></td>
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<td>18-24</td>
</tr>
<tr>
<td><strong>System</strong></td>
<td>20mm</td>
<td>20mm</td>
</tr>
<tr>
<td><strong>Groove Width</strong></td>
<td>0.027 (mm)</td>
<td>0.034 (mm)</td>
</tr>
<tr>
<td><strong>Round Jaws</strong></td>
<td>1.575 (mm)</td>
<td>2.50 (mm)</td>
</tr>
<tr>
<td><strong>Height</strong></td>
<td>1.969 (mm)</td>
<td>2.50 (mm)</td>
</tr>
</tbody>
</table>

### Note

- **Made in the USA**
- **Available in Aluminum & Cast Iron**
- **Special "J" dimensions available**
- **Oversized jaws available**
- **Round Jaws allow for complete gripping of workpiece**
- **Do not require clamping at the edge**
- **Round Jaws refer to this as 0.065"**
- **Critical Dimensions ALUMINUM CAST IRON**

### Wholesale USA Shop Tools

- Sales: 800-243-7701
- Fax: 800-342-3311
- www.usshoptools.com

- For complete list of applicable chucks, see pages 622-634.
- * denotes non-stock item.
- Please allow 1 week manufacturing time.
SOFT JAWS- 3.0 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, MMK Matsumoto, Howa & Other Chucks

- 3.0mm x 60° serrations
- Supplies maximum concentricity on soft jaws
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special custom available for use on front & rear of chuck, & Steel
- Made in the USA

QUANTITY DISCOUNTS! Only 5 sets or more of the same part number will receive a 5% discount. Please allow 1 week manufacturing time.

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

CRITICAL DIMENSIONS

ALUMINUM

| K3-25-40 | 15 | 0.827 (30mm) | 16mm | 1.575 (65mm) | 2.50 | 0.117 | 0.300 | 0.050 | 2 | M20-250AF $3.00 M20-250 $3.00 |
| K3-25-41 | 15 | 0.827 (30mm) | 16mm | 1.575 (65mm) | 2.50 | 0.117 | 0.300 | 0.050 | 2 | M16-200AF $3.00 M16-200 $3.00 |

STEEL

| K3-25-41 | 15 | 0.827 (30mm) | 16mm | 1.575 (65mm) | 2.50 | 0.117 | 0.300 | 0.050 | 2 | M20-250AF $3.00 M20-250 $3.00 |
| K3-25-41 | 15 | 0.827 (30mm) | 16mm | 1.575 (65mm) | 2.50 | 0.117 | 0.300 | 0.050 | 2 | M16-200AF $3.00 M16-200 $3.00 |


Soft Jaw Material: 3003-T6 Bar Stock, 6061-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

HARD JAWS-2 STEP 3.0mm x 60° Serrations

- Designed for first operation roughing, second operation finish turning & 888-888-8888 for stock & 888-888-8888 for non-stock items.
- Designed for use with Kitagawa & Can-Queing by Special Order.
- Contains two sub-assemblies for 2 step jaws.
- Has complete set for extra gripping power and ground body to provide better concentricity.
- 1 & 2 step jaws available.

CRITICAL DIMENSIONS

<table>
<thead>
<tr>
<th>Group</th>
<th>Check Size</th>
<th>Width G</th>
<th>Space E</th>
<th>Space D</th>
<th>Height E</th>
<th>Screw A</th>
<th>Screw B</th>
<th>Length D</th>
<th>No. of Screws</th>
<th>Price Set</th>
</tr>
</thead>
<tbody>
<tr>
<td>K3-25-40</td>
<td>15</td>
<td>0.827 (30mm)</td>
<td>16mm</td>
<td>1.575 (65mm)</td>
<td>2.50</td>
<td>0.117</td>
<td>0.300</td>
<td>0.050</td>
<td>2</td>
<td>M20-250AF $3.00 M20-250 $3.00</td>
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</table>

JAW NUTS & SCREWS

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<tr>
<th>Check Make &amp; Model</th>
<th>Check Size</th>
<th>Screw Size</th>
<th>Threads Per Inch</th>
<th>Width G</th>
<th>Space E</th>
<th>Space D</th>
<th>Screw A</th>
<th>Screw B</th>
<th>Length D</th>
<th>No. of Screws</th>
<th>Price Set</th>
</tr>
</thead>
<tbody>
<tr>
<td>K3-25-40</td>
<td>15</td>
<td>0.827 (30mm)</td>
<td>16mm</td>
<td>1.575 (65mm)</td>
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</tbody>
</table>

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

U S Shop Tools Sales: 800-243-7701 Fax: 800-342-3311 www.usshoptools.com

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**ROUND JAWS- 1/16” x 90° Serrations**

**FOR USE ON: SMW Autoblok, Rohm, Pratt Burnerd & Other Chucks**

- 1/16” x 90° serrations
- Round jaws allow for complete gripping of workpiece
- Oversized jaws available
- Can be machined to fill irregular shaped workpieces
- Cast iron machined for workpieces
- Made of 9/16” length of serrations: 5.73
- Special “J” dimensions available
- Made in the USA

### CHUCK JAWS

**Round Jaw Material:**
- aluminum casting t6
- cast iron
- steel

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Number</th>
<th>Critical Width (in)</th>
<th>Critical Width (mm)</th>
<th>Serration Dia (in)</th>
<th>Serration Dia (mm)</th>
<th>Height Front (in)</th>
<th>Height Front (mm)</th>
<th>Net of Holes</th>
<th>Industry Set of 3</th>
<th>Part Number</th>
<th>Price Set of 3</th>
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### INDEXABLE DRILLS TIPS & BACKS

**Features:**
- Designed for operation roughing, expect standard council between 8.005-8.019
- Resilient suitable for CD & ID workholding
- XTRA BITE - very aggressive bite
- Has corntical teeth for extra gripping power on tool grind to provide improved finished.

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group Number</th>
<th>Number</th>
<th>Critical Width</th>
<th>Critical Width</th>
<th>Serration Dia</th>
<th>Serration Dia</th>
<th>Height Front</th>
<th>Height Front</th>
<th>Net of Holes</th>
<th>Industry Set of 3</th>
<th>Part Number</th>
<th>Price Per Set</th>
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<td>$58.74</td>
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### Abrasives

**Features:**
- Designed for operation roughing, expect standard council between 8.005-8.019
- Resilient suitable for CD & ID workholding
- XTRA BITE - very aggressive bite
- Has corntical teeth for extra gripping power on tool grind to provide improved finished.

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group Number</th>
<th>Number</th>
<th>Critical Width</th>
<th>Critical Width</th>
<th>Height Front</th>
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<td>7.620</td>
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<td>0.007</td>
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### Soft Jaws - 1/16" x 90° Serrations

**FOR USE ON:** SMW Autoblok, Rohm, Pratt Burnerd & Other Chucks

**Critical Dimensions**

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<th>Group No.</th>
<th>Chuck No.</th>
<th>Width G</th>
<th>Size E</th>
<th>Space D</th>
<th>Height B</th>
<th>Length C</th>
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<td>5-6</td>
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<td>S/M</td>
<td>0.259</td>
<td>0.259</td>
<td>0.375</td>
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**Material:**

- Soft Jaw Material: I1-71-83
- I1-66-112
- I1-55-87
- I1-55-71
- I1-47-63
- I1-47-59
- I1-43-71
- I1-43-62

**Price and Discounts**

- For complete list of applicable chucks, see pages 622-634.
- * denotes non-stock item.
- Please allow 1 week manufacturing time.

**Quantity Discounts!**

Order 5 or more of the same part number with use and receive a

<table>
<thead>
<tr>
<th>QUANTITY DISCOUNTS!</th>
<th>Order of the same part number</th>
<th>5% DISCOUNT!</th>
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<tbody>
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<td>$17.95</td>
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**Pit Style**


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**Reference:**

- SOFT JAWS-1/16" x 90° Serrations
- For complete list of applicable chucks, see pages 622-634.
- * denotes non-stock item.
- Please allow 1 week manufacturing time.

**Material:**

- Soft Jaw Material: ALUMINUM 6061-T6 Bar Stock, STEEL 1035-T0 Aircraft Structural

For complete list of applicable chucks, see pages 622-634. Please allow 1 week manufacturing time.

---

**USST**

- Made in the USA

---

**TEE NUTS & SCREWS**

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Brand</th>
<th>Size</th>
<th>Height</th>
<th>Width</th>
<th>Length</th>
<th>Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>560573</td>
<td>USST</td>
<td>5</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
</tr>
<tr>
<td>5-6</td>
<td>USST</td>
<td>5-6</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
</tr>
<tr>
<td>5-6</td>
<td>USST</td>
<td>5-6</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
</tr>
<tr>
<td>8</td>
<td>USST</td>
<td>8</td>
<td>0.370</td>
<td>0.680</td>
<td>5/16&quot;</td>
<td>1.050</td>
</tr>
</tbody>
</table>

**Price Each**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Brand</th>
<th>Size</th>
<th>Height</th>
<th>Width</th>
<th>Length</th>
<th>Thickness</th>
<th>Price Each</th>
</tr>
</thead>
<tbody>
<tr>
<td>560573</td>
<td>USST</td>
<td>5</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
<td>$0.36</td>
</tr>
<tr>
<td>5-6</td>
<td>USST</td>
<td>5-6</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
<td>$0.36</td>
</tr>
<tr>
<td>5-6</td>
<td>USST</td>
<td>5-6</td>
<td>0.250</td>
<td>0.450</td>
<td>9/16&quot;</td>
<td>1.375</td>
<td>$0.36</td>
</tr>
<tr>
<td>8</td>
<td>USST</td>
<td>8</td>
<td>0.370</td>
<td>0.680</td>
<td>5/16&quot;</td>
<td>1.050</td>
<td>$3.28</td>
</tr>
</tbody>
</table>
### Round Jaws - 1/16” x 90° Serrations

These round jaws are designed for use in chucks that require a 1/16” x 90° serration pattern. They are ideal for gripping workpieces that require minimal deformation or for irregularly shaped workpieces. The jaws are made from high-quality materials like aluminum, cast iron, and steel, ensuring durability and precision.

#### Critical Dimensions

- **Group 1**: Includes various sizes and dimensions for different applications.

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Size</th>
<th>Groove Width G</th>
<th>Screw Size E</th>
<th>Hole Size F</th>
<th>Height D</th>
<th>Hole to Front Jaw C</th>
<th>Part Number</th>
<th>Price Set of 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>11-12118</td>
<td>10 to 12</td>
<td>0.877 (21mm)</td>
<td>1/2</td>
<td>1.187 (30mm)</td>
<td>1.913</td>
<td>3.100</td>
<td>10</td>
<td>RPH-10250A</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2.000</td>
<td>4.007</td>
<td>10</td>
<td>RPH-10250CI</td>
<td>$190.85</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11-12102</td>
<td>10 to 12</td>
<td>0.827 (21mm)</td>
<td>5/8</td>
<td>1.129 (28.5mm)</td>
<td>3.000</td>
<td>10</td>
<td>-</td>
<td>RPH-10250A</td>
</tr>
<tr>
<td>11-12117</td>
<td>10 to 12</td>
<td>0.827 (21mm)</td>
<td>1/2</td>
<td>1.187 (30mm)</td>
<td>2.075</td>
<td>10</td>
<td>-</td>
<td>RPH-10250A</td>
</tr>
<tr>
<td>11-12119</td>
<td>10</td>
<td>0.827 (21mm)</td>
<td>16mm</td>
<td>1.187 (30mm)</td>
<td>1.918</td>
<td>3.000</td>
<td>10</td>
<td>SMW10P</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2.000</td>
<td>4.007</td>
<td>10</td>
<td>SMW10P</td>
<td>$189.33</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11-12119</td>
<td>12</td>
<td>0.827 (21mm)</td>
<td>16mm</td>
<td>1.187 (30mm)</td>
<td>2.010</td>
<td>4.000</td>
<td>10</td>
<td>SMW12P</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4.000</td>
<td>2.000</td>
<td>10</td>
<td>SMW12P1</td>
<td>$189.33</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

#### Additional Features
- **Material Options**: Available in aluminum, cast iron, and steel.
- **Serrations**: 1/16” x 90° serrations, ideal for precision gripping.
- **Retention Knobs**: Available for added security.
- **Machine Vises**: Suitable for use in machine vises for secure holding.

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.
**ROUND JAWS- 3/32” x 90° Serrations**

**FOR USE ON:** SMW Autoblok, Forkardt, Rohm, Pratt Burnerd & Other Chucks

- 3/32” x 90° serrations
- Round Jaws allow for complete gripping of workpieces
- Ideal for thin-walled or irregular shaped workpieces
- Can be machined to fit workpiece
- Max. length of serrations: 3.75”
- Special 1/2” dimensions available
- Available in Aluminum
- Made in the USA

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Diameter (mm)</th>
<th>Description</th>
<th>Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>20mm</td>
<td>20mm</td>
<td>Adjustable Chuck/Collet Stop</td>
<td>$16.95 each</td>
</tr>
<tr>
<td>2.500</td>
<td>1.500</td>
<td>Stop-Loc Adjustable Stop</td>
<td>$16.95 each</td>
</tr>
</tbody>
</table>

**CHUCK STOPS**

This product is so useful and simple, you’ll wonder why you never thought of it. The Royal chuck stop is a precision machined aluminum extrusion which mounts squarely against the chuck jaws, providing a fixed reference surface for workpieces to locate against.

**FEATURES:**
- Allows short parts to project past chuck jaws.
- Eliminates the need to bore soft jaws.
- Allows short parts to project past the chuck jaws.
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece.
- Max. length of serrations: 3.75”
- Special 1/2” dimensions available.
- Available in Aluminum.
- Made in the USA.

**CHUCK/COLLET STOP**

* Adjustable Precision-Grip lengths up to 3/16” long holding +/-.005" of set in stock.*

* Impressively designed, the Stop-Loc adjustable stop can be used as a bar puller.*

* Consistency-Unique design incorporates contrasting colors to give user confidence by feeling and seeing that the dimension is being controlled.*

* Made in USA.*

**Easy To Use:**
- Measures desired stock length from face of the Stop-Loc guide to top of adjustable side. Ideal for thin-walled or irregular shaped workpieces.

<table>
<thead>
<tr>
<th>Description</th>
<th>Part Number</th>
<th>Set Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard Set, 10, 15 &amp; 20mm stops</td>
<td>ROV-2505</td>
<td>$347.95</td>
</tr>
<tr>
<td>Deluxe Set, 15, 20, 25 &amp; 30mm stops</td>
<td>ROV-2515</td>
<td>$460.25</td>
</tr>
</tbody>
</table>
SOFT JAWS- 3/32" x 90° Serrations

FOR USE ON: SMW Autoblok, Forkardt, Rohm, Pratt Burnerd & Other Chucks

- 3/32" x 90° serrations
- Duplexes maximum concentricity on
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum A Steel
- Made in the USA

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

Soft Jaw Material: For "Pointed" Soft Jaws, please substitute

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Screw Size</th>
<th>Length B</th>
<th>Width C</th>
<th>Height A</th>
<th>Hole J</th>
<th>Hole I</th>
<th>Price Set Off 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>G-10-10C</td>
<td>M8 x .125</td>
<td>1.004</td>
<td>1.380</td>
<td>0.575</td>
<td>3/4&quot;-10</td>
<td>1.752</td>
<td>$156.40</td>
</tr>
<tr>
<td>G-10-11C</td>
<td>M8 x .125</td>
<td>1.200</td>
<td>1.562</td>
<td>0.575</td>
<td>1-8</td>
<td>2.750</td>
<td>$157.78</td>
</tr>
<tr>
<td>110-16C</td>
<td>M8 x .125</td>
<td>1.800</td>
<td>1.750</td>
<td>0.575</td>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
</tr>
<tr>
<td>110-20C</td>
<td>M8 x .125</td>
<td>1.102</td>
<td>1.025</td>
<td>0.575</td>
<td>1-8</td>
<td>2.500</td>
<td>$157.78</td>
</tr>
<tr>
<td>110-25C</td>
<td>M8 x .125</td>
<td>1.181</td>
<td>2.500</td>
<td>0.575</td>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
</tr>
<tr>
<td>110-31C</td>
<td>M8 x .125</td>
<td>1.181</td>
<td>2.750</td>
<td>0.575</td>
<td>1-8</td>
<td>2.750</td>
<td>$159.95</td>
</tr>
</tbody>
</table>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: FK-16250AF will be FK-16250AP. For Pointer Jaws add $.50.


Critical Dimensions

<table>
<thead>
<tr>
<th>Screw Size</th>
<th>Hole J</th>
<th>Hole I</th>
<th>Price Set Off 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
<td></td>
</tr>
<tr>
<td>1-8</td>
<td>2.750</td>
<td>$159.95</td>
<td></td>
</tr>
</tbody>
</table>

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

Critical Dimensions

<table>
<thead>
<tr>
<th>Screw Size</th>
<th>Hole J</th>
<th>Hole I</th>
<th>Price Set Off 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
<td></td>
</tr>
<tr>
<td>1-8</td>
<td>2.750</td>
<td>$159.95</td>
<td></td>
</tr>
</tbody>
</table>

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

Critical Dimensions

<table>
<thead>
<tr>
<th>Screw Size</th>
<th>Hole J</th>
<th>Hole I</th>
<th>Price Set Off 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
<td></td>
</tr>
<tr>
<td>1-8</td>
<td>2.750</td>
<td>$159.95</td>
<td></td>
</tr>
</tbody>
</table>

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

Critical Dimensions

<table>
<thead>
<tr>
<th>Screw Size</th>
<th>Hole J</th>
<th>Hole I</th>
<th>Price Set Off 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4&quot;-10</td>
<td>1.750</td>
<td>$159.95</td>
<td></td>
</tr>
<tr>
<td>1-8</td>
<td>2.750</td>
<td>$159.95</td>
<td></td>
</tr>
</tbody>
</table>

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.
**ROUND JAWS - AMERICAN STANDARD TONGUE & GROOVE**

For use on: Bison, Buck, BTC, Cushman, TMX, PBA, Yuasa & Rohm Chucks

- American Standard Tongue & Groove
- Round jaws allow for complete gripping of workpiece
- Dowelized jaws available
- Ideal for thin-wall or irregular shaped workpieces
- Can be machined to fit workpiece
- All parts have 2 holes for tool holding
- Made in the USA

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Type</th>
<th>Groove Width (G)</th>
<th>Tongue Width (F)</th>
<th>Screw Size (E)</th>
<th>Nut Size (D)</th>
<th>Top Markers</th>
<th>Mid Markers</th>
<th>Bot Markers</th>
<th>Part No.</th>
<th>Price Set 1</th>
<th>Price Set 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>15-31-56-13</td>
<td>5</td>
<td>MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>0</td>
<td>0.354</td>
<td>0.354</td>
<td>0.354</td>
<td>GRP-R-05H 49A</td>
<td>$349.00</td>
</tr>
<tr>
<td>15-31-56-15</td>
<td>6</td>
<td>MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>0</td>
<td>0.354</td>
<td>0.354</td>
<td>0.354</td>
<td>GRP-R-05H 49A</td>
<td>$349.00</td>
</tr>
<tr>
<td>15-31-56-17</td>
<td>8</td>
<td>MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>0</td>
<td>0.354</td>
<td>0.354</td>
<td>0.354</td>
<td>GRP-R-05H 49A</td>
<td>$349.00</td>
</tr>
</tbody>
</table>

**AMERICAN STANDARD TONGUE & GROOVE HARD JAWS**

- Designed for first operation roughing, exceed standard round-applications
- Robust design for OD & ID workholding
- XTRA BITE (4) - very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.
- GRIP-RITE-OEM Style (-U) hard jaws have ground tips and provide better runout.
- Standard jaws have conical teeth for extra gripping power and black oxide for long life. Ideal for OD & ID workholding.

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Type</th>
<th>Groove Width (G)</th>
<th>Tongue Width (F)</th>
<th>Screw Size (E)</th>
<th>Nut Size (D)</th>
<th>Top Markers</th>
<th>Mid Markers</th>
<th>Bot Markers</th>
<th>Part No.</th>
<th>Price Set 1</th>
<th>Price Set 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>15-31-56-13</td>
<td>6</td>
<td>MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>0</td>
<td>0.354</td>
<td>0.354</td>
<td>0.354</td>
<td>GRP-R-05H 49A</td>
<td>$349.00</td>
</tr>
<tr>
<td>15-31-56-15</td>
<td>8</td>
<td>MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>0</td>
<td>0.354</td>
<td>0.354</td>
<td>0.354</td>
<td>GRP-R-05H 49A</td>
<td>$349.00</td>
</tr>
</tbody>
</table>
SOFT JAWS - AMERICAN STANDARD TONGUE & GROOVE

FOR USE ON: Bison, Buck, BTC, Cushman, TMX, PBA, Yuasa & Rohm Chucks

- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Available in Aluminum or Steel
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel
- Made in the USA

For "Pointed" Soft Jaws,

- Soft Jaw Material:
  - ALUMINUM - 6061-T6 Bar Stock
  - STEEL - 88 W & S 8 HEAVY
  - STEEL - 8 MEDIUM

Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Type</th>
<th>Screw Width</th>
<th>Tongue Width</th>
<th>Screw Length</th>
<th>Side Space</th>
<th>Tongue Position</th>
<th>Tongue Length</th>
<th>Width</th>
<th>Flat End</th>
</tr>
</thead>
<tbody>
<tr>
<td>5-01-14-11</td>
<td>4 MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>3/8</td>
<td>1/4</td>
<td>1.188</td>
<td>1.250</td>
<td>0.880</td>
<td>Offset 2.000</td>
<td>0.625</td>
</tr>
<tr>
<td>5-01-14-12</td>
<td>5 MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>5/16</td>
<td>1.250</td>
<td>1.500</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5-01-15-13</td>
<td>6 MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>3/8</td>
<td>1.500</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5-01-15-16</td>
<td>6 HEAVY DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>7/16</td>
<td>1.500</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5-01-15-17</td>
<td>8 MEDIUM DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>3/8</td>
<td>1.750</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5-01-15-19</td>
<td>8 HEAVY DUTY</td>
<td>0.313</td>
<td>0.500</td>
<td>1/2</td>
<td>1.750</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

For “Pointed” Soft Jaws, please substitute “B” for “A” in the part number. Example: TG-4120AF will be TG-4120AP. For Pointed Jaw see 55.25.

Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

For “Pointed” Soft Jaws, please substitute “B” for “A” in the part number. Example: TG-4120AF will be TG-4120AP. For Pointed Jaw see 55.25.

Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock

For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.

U S Shop Tools  Sales: 800-243-7701  Fax: 800-342-3311  www.usshoptools.com  2012-13 Master Catalog  51
### Round Jaws - American Standard Tongue & Groove

**FOR USE ON:** Bison, Buck, BTC, Cushman, TMX, PBA, Yuasa & Rohm Chucks

- American Standard Tongue & Groove
- Round Jaws allow for complete shaping of workpieces.
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- "Special" J dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA

#### Off-Center Tongue

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Type</th>
<th>Groove Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Spacing</th>
<th>Tongue Pie Dia</th>
<th>Head Screws</th>
<th>Price Set Of</th>
<th>Part Number</th>
<th>Price Set Of</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>11-06-10-1</td>
<td>0.500</td>
<td>MED DUTY</td>
<td>0.750</td>
<td>1/2</td>
<td>2.125</td>
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<tr>
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#### Indexable Drills & Turning Tools

<table>
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<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Spacing</th>
<th>Tongue Pie Dia</th>
<th>Head Screws</th>
<th>Price Set Of</th>
<th>Part Number</th>
<th>Price Set Of</th>
<th>Part Number</th>
</tr>
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<td>0.750</td>
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<td>0.750</td>
<td>1/2</td>
<td>2.500</td>
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#### Hard Jaws

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<th>Groove Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Spacing</th>
<th>Tongue Pie Dia</th>
<th>Head Screws</th>
<th>Price Set Of</th>
<th>Part Number</th>
<th>Price Set Of</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
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<td>0.750</td>
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<td>2.125</td>
<td>1.750</td>
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</tr>
<tr>
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<td>MEDIUM DUTY</td>
<td>0.750</td>
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<td>2.125</td>
<td>1.750</td>
<td>64</td>
<td>0.250</td>
<td>64-TIG-0115BA</td>
<td>1915.80</td>
<td>-</td>
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</tbody>
</table>

**Notes:**
- Made in the USA
- Available in Aluminum & Cast Iron
- Can be machined to fit workpiece
- Ideal for thin-walled or irregular shaped workpieces.
- Oversized jaws available
- Round Jaws allow for complete shaping of workpieces.
American Standard Tongue & Groove

- Made in the USA
- Available in Aluminum & Steel
- Special orders available
- Supplies maximum concentricity on smaller diameter parts
- Can be bored or turned to fit workpiece
- For complete list of applicable chucks, see pages 622-634

For "Pointed" Soft Jaws,

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Size</th>
<th>Width</th>
<th>Length</th>
<th>Diameter</th>
<th>Screw Circle</th>
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<tbody>
<tr>
<td>G</td>
<td>C</td>
<td>M</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
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**Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum**

---

**Critical Dimensions**

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>Type</th>
<th>Groove Height</th>
<th>Tongue Width</th>
<th>Screw Circle</th>
<th>Hole Diameter</th>
<th>Length</th>
<th>Width</th>
</tr>
</thead>
<tbody>
<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>MEDIUM DUTY</td>
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<td>1.500</td>
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<td>1.750</td>
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<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>HEAVY DUTY</td>
<td>6.75</td>
<td>5/8</td>
<td>0.750</td>
<td>1.500</td>
<td>2.500</td>
<td>1.750</td>
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<td>7415-25-21</td>
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<td></td>
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<td></td>
</tr>
<tr>
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<td>2&quot;</td>
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</tbody>
</table>

For “Pointed” Soft Jaws, please substitute "F" for "P" in the part number. Example: 7415-25AF will be 7415-25AP. Pointed jaws: Up to 10" add $3.25, 12" & over add $6.50.

**For 3 Jaw Scroll Chucks**

American Standard Tongue & Groove Jaws

**3-Jaw Chucks**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Groove Width</th>
<th>Tongue Width</th>
<th>DIA</th>
<th>Weight</th>
</tr>
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<tbody>
<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>1.500</td>
<td>2.500</td>
<td>1.750</td>
</tr>
<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>1.500</td>
<td>2.500</td>
<td>1.750</td>
</tr>
<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>1.500</td>
<td>2.500</td>
<td>1.750</td>
</tr>
<tr>
<td>7415-25-21</td>
<td>0.500</td>
<td>1.500</td>
<td>2.500</td>
<td>1.750</td>
</tr>
</tbody>
</table>
MACHINE VISES

Chuck Jaw, Indexable Drills, Etc.

MACHINES/ MAINTENANCE/ REPAIR TOOLS

END MILLS/ DRILLS

INDEXABLE DRILLS

ABRASIVES, MEASURING TOOLS

WEIGHT & SAFETY

FOR USE ON: Bison, Buck, BTC, Cushman, TMX, PBA, Yuasa & Rohm Chucks

Chuck Jaw Material:

* Made in the USA

• American Standard Tongue & Groove
• Round jaws allow for complete gripping of workpiece
• Chromed jaws available
• Ideal for thin-walled or irregular shaped workpieces
• Can be machined to fit workpiece
• All jaws have 2 holes

* denotes non-stock item. Please allow 1 week manufacturing time.

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<th>Group</th>
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<th>Width</th>
<th>Material</th>
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<td>0.500</td>
<td>5/8</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>TI</td>
<td>15</td>
<td>0.500</td>
<td>3/4</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>TI</td>
<td>15</td>
<td>0.500</td>
<td>7/8</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>TI</td>
<td>15</td>
<td>0.500</td>
<td>1.000</td>
<td>Cast Iron</td>
</tr>
</tbody>
</table>

For complete list of applicable chucks, see pages 622-634.
SOFT JAWS- AMERICAN STANDARD TONGUE & GROOVE

FOR USE ON: Bison, Buck, BTC, Cushman, TMX, PBA, Yuasa & Rohm Chucks

- American Standard Tongue & Groove
- Supplies maximum concentricity on finish turning operations.
- Can be bored or turned to fit workpiece.
- Steel jaws can be hardened.
- Available flat ended or pointed for boring of soft jaws.
- Special orders available.
- Available in Aluminum & Steel.
- Made in the USA

FEATURES:
- Made in the USA
- Available in Aluminum & Steel
- Special orders available
- Available flat ended or pointed for boring of soft jaws.
- Steel jaws can be hardened
- Supplies maximum concentricity on finish turning operations
- A valuable time-saver for your lathes and turning center. Every ring you still ever need for boring out your soft jaws on one convenient wooden rack.

ANTI-BACKLASH RING SET

A valuable time-saver for your lathes and turning center. Every ring you will ever need for boring out your soft jaws on one convenient wooden rack.

Set of 4 Boring Stars

Part #: JBT-100

$27.00/set

US Shop Tools

Sales: 800-243-7701  Fax: 800-342-3311  www.usshoptools.com

2012-13 Master Catalog  55
### ROUND JAWS - METRIC TONGUE & GROOVE

**FOR USE ON:** SMW Autoblok KNCS, SMW Systems, Schunk, Rohm Chucks Using GBK Master Base Jaws

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Groove Width (mm)</th>
<th>Tongue Width (mm)</th>
<th>Screw Size</th>
<th>Male Spacing (mm)</th>
<th>Tongue Spacing (mm)</th>
<th>Price Set Of 3</th>
<th>Price Set Of 6</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-05-06-12</td>
<td>6</td>
<td>0.315</td>
<td>0.709</td>
<td>8mm</td>
<td>1.260</td>
<td>1.380</td>
<td>$74.63</td>
<td>$149.26</td>
</tr>
<tr>
<td>TK-10-12-46</td>
<td>8</td>
<td>0.383</td>
<td>0.787</td>
<td>8mm</td>
<td>1.575</td>
<td>1.800</td>
<td>$172.80</td>
<td>$345.60</td>
</tr>
<tr>
<td>TK-12-12-46</td>
<td>10</td>
<td>0.472</td>
<td>0.787</td>
<td>12mm</td>
<td>1.575</td>
<td>2.250</td>
<td>$266.76</td>
<td>$533.52</td>
</tr>
<tr>
<td>TK-12-12-46</td>
<td>12</td>
<td>0.472</td>
<td>1.023</td>
<td>12mm</td>
<td>2.126</td>
<td>2.950</td>
<td>$336.96</td>
<td>$673.92</td>
</tr>
</tbody>
</table>

#### Price Set of 3

- **ALUMINUM:** $74.63
- **STEEL:** $149.26

#### Price Set of 6

- **ALUMINUM:** $149.26
- **STEEL:** $298.52

**FOR USE ON:** Forkardt, Rohm & SMW Chucks

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Chuck Size</th>
<th>Groove Width (mm)</th>
<th>Tongue Width (mm)</th>
<th>Screw Size</th>
<th>Male Spacing (mm)</th>
<th>Tongue Spacing (mm)</th>
<th>Price Set Of 3</th>
<th>Price Set Of 6</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-05-5/16-12</td>
<td>6</td>
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<td>0.706</td>
<td>5/16</td>
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<td>1.380</td>
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<td>$142.84</td>
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<td>TK-10-5/16-40</td>
<td>8</td>
<td>0.383</td>
<td>0.787</td>
<td>5/16</td>
<td>1.575</td>
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<td>$172.80</td>
<td>$345.60</td>
</tr>
<tr>
<td>TK-12-5/16-40</td>
<td>10</td>
<td>0.472</td>
<td>0.787</td>
<td>1/2</td>
<td>1.575</td>
<td>2.400</td>
<td>$266.76</td>
<td>$533.52</td>
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<tr>
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<td>12</td>
<td>0.472</td>
<td>1.023</td>
<td>1/2</td>
<td>2.126</td>
<td>2.950</td>
<td>$336.96</td>
<td>$673.92</td>
</tr>
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</table>

#### Price Set of 3

- **ALUMINUM:** $71.42
- **STEEL:** $142.84

#### Price Set of 6

- **ALUMINUM:** $142.84
- **STEEL:** $285.68

*Made in the USA*
SOFT JAWS- METRIC TONGUE & GROOVE

FOR USE ON: SMW Autoblok KNCS, SMW Systems, Schunk, Rohm Chucks
Using GBK Master Base Jaws

- Metric tongue & groove
- Supplies maximum concentricity on steel turning operations
- Can be torqued or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for finer internal or external diameters
- Available in Aluminum & Steel
- Made in the USA

CENTRED & OFFSET TONGUE

Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>Check Size</th>
<th>Socket Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>High</th>
<th>Tongue in Point A</th>
<th>Tongue Position</th>
<th>Width C</th>
<th>Length D</th>
<th>Price Set Of</th>
<th>Price Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-08-00-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
<td></td>
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</tr>
<tr>
<td>TK-12-00-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
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</table>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: WK-0152AF will be WK-0152AP. Pointed Jaws: Up to 10" add $3.25, 12" & over add $6.50.


OFF-CENTERED TONGUE

Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>Check Size</th>
<th>Socket Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>High</th>
<th>Tongue in Point A</th>
<th>Tongue Position</th>
<th>Width C</th>
<th>Length D</th>
<th>Price Set Of</th>
<th>Price Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-08-08-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
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<tr>
<td>TK-12-12-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
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<tr>
<td>TK-08-08-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
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</tbody>
</table>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: WK-0152AF will be WK-0152AP. Pointed Jaws: Up to 10" add $3.25, 12" & over add $6.50.


SOFT JAWS- METRIC TONGUE & GROOVE

FOR USE ON: Forkardt, Rohm & SMW Chucks

CENTRED & OFFSET TONGUE

Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>Check Size</th>
<th>Socket Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>High</th>
<th>Tongue in Point A</th>
<th>Tongue Position</th>
<th>Width C</th>
<th>Length D</th>
<th>Price Set Of</th>
<th>Price Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-08-08-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
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</tr>
<tr>
<td>TK-12-12-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: WK-0152AF will be WK-0152AP. Pointed Jaws: Up to 10" add $3.25, 12" & over add $6.50.


FOR USE ON: Forkardt, Rohm & SMW Chucks

OFT-CENTERED TONGUE

Critical Dimensions

<table>
<thead>
<tr>
<th>Group</th>
<th>Check Size</th>
<th>Socket Width</th>
<th>Tongue Width</th>
<th>Screw Size</th>
<th>Hole Space</th>
<th>High</th>
<th>Tongue in Point A</th>
<th>Tongue Position</th>
<th>Width C</th>
<th>Length D</th>
<th>Price Set Of</th>
<th>Price Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>TK-08-08-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>TK-12-12-00</td>
<td>0.315 (6mm)</td>
<td>0.709 8mm</td>
<td>1.260 (35mm)</td>
<td>1.50 1.390</td>
<td>Other 0.750</td>
<td>2.750</td>
<td>WK-0152AF* $18.43</td>
<td>WK-0152AF* $18.43</td>
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</tbody>
</table>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: WK-0152AF will be WK-0152AP. Pointed Jaws: Up to 10" add $3.25, 12" & over add $6.50.


For complete list of applicable chucks, see pages 622-634. * denotes non-stock item. Please allow 1 week manufacturing time.
**INDEXABLE DRILLS TURNING & BORING**

- Designed for first operation roughing, against standard carbide between E-004-A-010.
- Reversible suitable for OD & ID machining.
- XTRA BITE (-X) very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.

**DIAMOND PLATE SPONGECOTE**

Anti-Fatigue Mats-No. 415

Diamond Plate SpongeCote is the most popular anti-fatigue mat in the industry because no other offers such a complete package of exceptional comfort, long life, and a high-tech, industrial image. Its exceptionally resilient Nitcell sponge base defines the mat by providing true comfort, safety, low maintenance, and ideal ease of replacement. These mats are ideal for use in heavy traffic areas, including small to medium size restaurants, shops, and stores. They are available in almost any color or combination of colors. They are made of a high-quality rubber which is extremely durable and will not tear, split, or crack. They are non-slip and are molded in place. These mats are made in the USA and comply with all OSHA and Federal standards.

**TOOL Holders**

- SEVERAL HANGER OPTIONS AVAILABLE

**CHUCKS**

- Acme Serrated Key Type
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces
- All jaws have 2 holes
- Oversized jaws available
- Available in Aluminum & Cast Iron
- Made in the US

**ENDMILLS, DRILLS INDEXABLE DRILLS**

**RETENTION KNOBS**

- IDEAL FOR USE ON: Cushman, Logansport, Howa, Autoblok, PBA & Other Chucks

**TOE CLIPS**

- IDEAL FOR USE ON: Cushman, Logansport, Howa, Autoblok, PBA & Other Chucks

**ANTI-FATIGUE Mats-No. 415**

- Ideal For Heavily Trafficked Areas!
- For use in heavy work areas
- Anti-fatigue
- Non-skid rubber base for unparalleled comfort
- Safety & wearer friendly edges
- Made from high-quality rubber materials
- 3 Year Warranty

**ABRASIVES**

- BEST SELLER! Ideal For Heavily Trafficked Areas!
**SOFT JAWS- ACME SERRATED KEY TYPE**

**FOR USE ON:** Cushman, Logansport, Howa, Autoblok, PBA & Other Chucks

- Acme Serrated Key Type
- Designed maximum concentricity on the work
- Can be fed in or turned to fit workpiece
- Steel jaws can be hardened
- Available flat rounded or pointed for smaller diameter parts
- Made in the USA

### Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Size</th>
<th>Soft Jaw Material</th>
<th>ALUMINUM</th>
<th>STEEL</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-08-10-12</td>
<td>8</td>
<td>0.870 0.601 1/2 1.250</td>
<td>2.00 2.000 1.50 1.75</td>
<td>AC-0825AF $19.70 AC-0825F $29.70</td>
</tr>
<tr>
<td>0-08-10-12</td>
<td>9</td>
<td>0.870 0.601 1/2 1.250</td>
<td>4.00 2.000 1.50 1.75</td>
<td>AC-0849AF $87.90 AC-0849F $94.48</td>
</tr>
<tr>
<td>0-08-10-12</td>
<td>10</td>
<td>0.870 0.601 1/2 1.250</td>
<td>2.00 2.000 1.50 1.75</td>
<td>AC-1025AF $150.47 AC-1025F $161.41</td>
</tr>
<tr>
<td>0-08-10-12</td>
<td>12</td>
<td>0.870 0.601 1/2 1.250</td>
<td>2.00 2.000 1.50 1.75</td>
<td>AC-1225AF $161.41 AC-1225F $177.75</td>
</tr>
<tr>
<td>0-08-10-12</td>
<td>15</td>
<td>0.870 0.601 1/2 1.250</td>
<td>2.00 2.000 1.50 1.75</td>
<td>AC-1525AF $177.75 AC-1525F $194.90</td>
</tr>
<tr>
<td>0-08-10-12</td>
<td>21</td>
<td>0.870 0.601 1/2 1.250</td>
<td>2.00 2.000 1.50 1.75</td>
<td>AC-2125AF $194.90 AC-2125F $213.07</td>
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### Jaw Nut & Master Keys

#### Critical Dimensions

<table>
<thead>
<tr>
<th>Check Size</th>
<th>Screw Size</th>
<th>Groove Width</th>
<th>Screw Pitch</th>
<th>Depth</th>
<th>Width</th>
<th>Height</th>
<th>Length</th>
<th>Master Key Part Number</th>
<th>Price Each</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>0.870</td>
<td>0.601</td>
<td>1/2-13</td>
<td>1.250</td>
<td>1.000</td>
<td>1.000</td>
<td>2.000</td>
<td>AC-0001F</td>
<td>$25.00</td>
</tr>
<tr>
<td>10</td>
<td>0.870</td>
<td>0.601</td>
<td>1/2-13</td>
<td>1.750</td>
<td>0.641</td>
<td>1.000</td>
<td>2.000</td>
<td>AC-1025F</td>
<td>$47.00</td>
</tr>
<tr>
<td>12</td>
<td>0.870</td>
<td>0.601</td>
<td>1/2-13</td>
<td>2.000</td>
<td>0.744</td>
<td>1.000</td>
<td>2.000</td>
<td>AC-1225F</td>
<td>$50.00</td>
</tr>
<tr>
<td>15-18</td>
<td>0.870</td>
<td>0.601</td>
<td>1/2-13</td>
<td>2.500</td>
<td>0.933</td>
<td>1.000</td>
<td>2.000</td>
<td>AC-1525F</td>
<td>$65.00</td>
</tr>
<tr>
<td>21-24</td>
<td>0.870</td>
<td>0.601</td>
<td>1/2-13</td>
<td>3.000</td>
<td>1.185</td>
<td>1.000</td>
<td>2.000</td>
<td>AC-2125F</td>
<td>$85.99</td>
</tr>
</tbody>
</table>

*For “Soft Jaw” Soft Jaws, please include a “P” in the part number. Example: AC-0825AF will be AC-0825AP. Pointed jaws: Up to 90° add .035, 12° over add .065.

### 2 Screws Included With Each Jaw Nut

*For a full list of specifications, contact your nearest stocking depot. Please allow 3-5 weeks manufacturing time.*
ROUND JAWS- SQUARE SERRATED KEY TYPE

FOR USE ON: S.P., Pratt Burnerd, Warner & Swasey & Other Chucks

- Square Serrated Key Type
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Serrated key provides positive gripping of irregular shaped workpieces.
- Can be machined to fit workpiece
- All jaws have 2 holes
- Special 3/4" dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA

Critical Dimensions

<table>
<thead>
<tr>
<th>Group No.</th>
<th>Check Size</th>
<th>No. Hole T</th>
<th>Key in Front</th>
<th>Screw Size</th>
<th>Width E</th>
<th>Round/Hole</th>
<th>Part Number</th>
<th>Price Per Set of 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>SI-07-1/2-17</td>
<td>12</td>
<td>4.00</td>
<td>1.750</td>
<td>0.75</td>
<td>1.500</td>
<td>3</td>
<td>RSP-12200CA</td>
<td>$191.51</td>
</tr>
<tr>
<td>SI-07-5/8-16</td>
<td>12</td>
<td>4.00</td>
<td>1.750</td>
<td>0.75</td>
<td>1.500</td>
<td>3</td>
<td>RSP-12200CA</td>
<td>$191.51</td>
</tr>
<tr>
<td>SI-07-3/4-25</td>
<td>12</td>
<td>4.00</td>
<td>1.750</td>
<td>0.75</td>
<td>1.500</td>
<td>3</td>
<td>RSP-12200CA</td>
<td>$191.51</td>
</tr>
</tbody>
</table>

FEATURES:
- Designed for first operation machining
- Improved runout
- Reversible-suitable for OD & ID workholding
- XTRA BITE (-X) very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.

COLLET PADS TOP JAWS & COLLET PADS

- Top Jaws available for many popular power chucks
- Collet pad top jaws can help to convert your CNC lathe chuck into a precision bar machine
- Made in the USA

COLLET PAD FEATURES:
- Warner & Swasey
- Xtra Serrated, Square, Hexes & Emergency Pads
- Made in the USA

Please See Pages 98-101 For More Information!
SOFT JAWS- SQUARE SERRATED KEY TYPE

FOR USE ON: Buck & Bison 6” Chucks, S.P., Pratt Burnerd & Other Chucks

- Square Serrated Key Type
- Supplies maximum concentricity on finish turning operations
- Designed for use on three-jaw lathe chucks
- Steel jaws can be hardened
- Available flat end or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum & Steel
- Made in the USA

### Critical Dimensions

<table>
<thead>
<tr>
<th>Groove No.</th>
<th>Chuck Size</th>
<th>Tap Groove</th>
<th>Width B</th>
<th>Screw Length D</th>
<th>Depth E</th>
<th>Head T</th>
<th>Length C</th>
<th>Price Each</th>
</tr>
</thead>
<tbody>
<tr>
<td>5/8-15/16</td>
<td>6</td>
<td>0.738</td>
<td>3/16</td>
<td>0.950</td>
<td>1.460</td>
<td>2.250</td>
<td>3.500</td>
<td>$29.01</td>
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<tr>
<td>5/8-3/16</td>
<td>8</td>
<td>0.501</td>
<td>3/32</td>
<td>1.250</td>
<td>2.000</td>
<td>3.250</td>
<td>5.000</td>
<td>$23.00</td>
</tr>
<tr>
<td>3/4-5/16</td>
<td>8</td>
<td>0.601</td>
<td>1/8</td>
<td>1.350</td>
<td>2.100</td>
<td>3.400</td>
<td>5.500</td>
<td>$29.00</td>
</tr>
<tr>
<td>1-24-1/16</td>
<td>8</td>
<td>0.750</td>
<td>1/8</td>
<td>1.375</td>
<td>2.100</td>
<td>3.400</td>
<td>5.500</td>
<td>$29.00</td>
</tr>
<tr>
<td>1-24-1/8</td>
<td>8</td>
<td>0.750</td>
<td>1/8</td>
<td>1.375</td>
<td>2.100</td>
<td>3.400</td>
<td>5.500</td>
<td>$29.00</td>
</tr>
</tbody>
</table>

### Soft Jaw Material:

- For “Pointed” Soft Jaws:
  - SI-07-1/2-17 10
  - SI-06-1/2-12 8
  - SI-05-3/8-14 8

### Order Information:

- Order S-SETS OR MORE of the same part number for a DISCOUNT!

---

**FOR USE ON:** Buck & Bison 6” Chucks, S.P., Pratt Burnerd & Other Chucks

**Soft Jaw Material:**
- For “Pointed” Soft Jaws:
  - SI-07-1/2-17 10
  - SI-06-1/2-12 8
  - SI-05-3/8-14 8

**Order Information:**
- Order S-SETS OR MORE of the same part number for a DISCOUNT!
### ROUND JAWS

**For Northfield® Type Chucks**

<table>
<thead>
<tr>
<th>Jaw Diameter</th>
<th>Material</th>
<th>Part Number</th>
<th>Price</th>
<th>Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>3&quot; (300)</td>
<td>ALUMINUM</td>
<td>ST-3-1-10-1</td>
<td>$93.96</td>
<td>1000</td>
</tr>
<tr>
<td></td>
<td>STEEL</td>
<td>ST-3-1-10-1</td>
<td>$112.06</td>
<td>1000</td>
</tr>
<tr>
<td>4&quot; (400)</td>
<td>ALUMINUM</td>
<td>ST-4-1-10-1</td>
<td>$505.72</td>
<td>800</td>
</tr>
<tr>
<td></td>
<td>STEEL</td>
<td>ST-4-1-10-1</td>
<td>$593.34</td>
<td>800</td>
</tr>
<tr>
<td>6&quot; (600)</td>
<td>ALUMINUM</td>
<td>ST-6-1-10-1</td>
<td>$236.85</td>
<td>600</td>
</tr>
<tr>
<td></td>
<td>STEEL</td>
<td>ST-6-1-10-1</td>
<td>$226.99</td>
<td>600</td>
</tr>
<tr>
<td>7&quot; (700)</td>
<td>ALUMINUM</td>
<td>ST-7-1-10-1</td>
<td>$185.33</td>
<td>400</td>
</tr>
<tr>
<td></td>
<td>STEEL</td>
<td>ST-7-1-10-1</td>
<td>$174.74</td>
<td>400</td>
</tr>
<tr>
<td>8&quot; (800)</td>
<td>ALUMINUM</td>
<td>ST-8-1-10-1</td>
<td>$121.18</td>
<td>300</td>
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<tr>
<td></td>
<td>STEEL</td>
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<td>$114.75</td>
<td>300</td>
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<tr>
<td>10&quot; (1000)</td>
<td>ALUMINUM</td>
<td>ST-10-1-10-1</td>
<td>$325.97</td>
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<tr>
<td></td>
<td>STEEL</td>
<td>ST-10-1-10-1</td>
<td>$371.14</td>
<td>200</td>
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</tbody>
</table>

**Round Jaw Material:** ALUMINUM-6061-T6 Bar Stock, CAST IRON Corp., STEEL-1018

*denotes non-stock item. Please allow 1 week manufacturing time.

### SOFT JAWS

**For Northfield® Type Chucks**

<table>
<thead>
<tr>
<th>Jaw Diameter</th>
<th>Material</th>
<th>Part Number</th>
<th>Price</th>
<th>Set Of</th>
</tr>
</thead>
<tbody>
<tr>
<td>3&quot; (300)</td>
<td>ALUMINUM</td>
<td>ST-3-1-10-1</td>
<td>$93.96</td>
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<td>STEEL</td>
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<tr>
<td>4&quot; (400)</td>
<td>ALUMINUM</td>
<td>ST-4-1-10-1</td>
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<td>STEEL</td>
<td>ST-4-1-10-1</td>
<td>$593.34</td>
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<td>7&quot; (700)</td>
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<td>ST-7-1-10-1</td>
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<td>STEEL</td>
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<td>400</td>
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<td>8&quot; (800)</td>
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<td>STEEL</td>
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<td>300</td>
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<td>10&quot; (1000)</td>
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<td>ST-10-1-10-1</td>
<td>$325.97</td>
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<td>STEEL</td>
<td>ST-10-1-10-1</td>
<td>$371.14</td>
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</tbody>
</table>

**Soft Jaw Material:** ALUMINUM-6061-T6 Bar Stock, CAST IRON Corp., STEEL-1018

*denotes non-stock item. Please allow 1 week manufacturing time.

**Quantity Discounts!**
Order 5 SETS OR MORE of the same part number and receive a 10% DISCOUNT!
### JAWS FOR QUICK JAW CHANGE CHUCKS

**Base, Monoblock and Hard Jaws for**
- SMW Autoblok KCNS-N Series Quick Change Chucks
- Schunk ROTA-G & THW PLUS Series Quick Change Chucks
- SMW System/Schunk THW Series Quick Change Chucks

### Base Jaws, Monoblock, 1 & 2 Step Hard Jaws

<table>
<thead>
<tr>
<th>SCHUNK</th>
<th>AUTOBLOK</th>
<th>THW Plus</th>
<th>Part No.</th>
<th>Description</th>
<th>Diameter</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
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</thead>
<tbody>
<tr>
<td>110</td>
<td>175</td>
<td>250</td>
<td>310</td>
<td>410</td>
<td>320</td>
<td>56</td>
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<td>105</td>
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<tr>
<td>140</td>
<td>260</td>
<td>250</td>
<td>315</td>
<td>420</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>11</td>
</tr>
<tr>
<td>165</td>
<td>285</td>
<td>250</td>
<td>315</td>
<td>430</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>14</td>
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</tbody>
</table>

**See Tables Below For Pricing**

### Soft Monoblock Jaws

<table>
<thead>
<tr>
<th>SCHUNK</th>
<th>AUTOBLOK</th>
<th>THW Plus</th>
<th>Part No.</th>
<th>Description</th>
<th>Diameter</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>110</td>
<td>175</td>
<td>250</td>
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<td>410</td>
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<td>250</td>
<td>315</td>
<td>430</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>14</td>
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### 2 Step Monoblock Hard Jaws (Dimensions in mm)

<table>
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<tr>
<th>SCHUNK</th>
<th>AUTOBLOK</th>
<th>THW Plus</th>
<th>Part No.</th>
<th>Description</th>
<th>Diameter</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>110</td>
<td>175</td>
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<tr>
<td>165</td>
<td>285</td>
<td>250</td>
<td>315</td>
<td>430</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>14</td>
</tr>
</tbody>
</table>

### 1 Step Hard Top Jaws- Tongue & Groove With Base Jaws (Dimensions in mm)

<table>
<thead>
<tr>
<th>SCHUNK</th>
<th>AUTOBLOK</th>
<th>THW Plus</th>
<th>Part No.</th>
<th>Description</th>
<th>Diameter</th>
<th>Length</th>
<th>Width</th>
<th>Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>110</td>
<td>175</td>
<td>250</td>
<td>310</td>
<td>410</td>
<td>320</td>
<td>56</td>
<td>15</td>
<td>105</td>
</tr>
<tr>
<td>140</td>
<td>260</td>
<td>250</td>
<td>315</td>
<td>420</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>11</td>
</tr>
<tr>
<td>165</td>
<td>285</td>
<td>250</td>
<td>315</td>
<td>430</td>
<td>320</td>
<td>70</td>
<td>36</td>
<td>14</td>
</tr>
</tbody>
</table>

---

**Notes:**
- grain & hard top jaw set of 3
- 1 Step & hard top groove set of 3
### Chuck Jaws

#### Chuck Jaws For Quick Change Schunk Chucks

<table>
<thead>
<tr>
<th>Schunk Chuck Type</th>
<th>Clamping Range mm</th>
<th>Swing Dia mm</th>
<th>Groove Width mm</th>
<th>Work Stop Thread M</th>
<th>Part Number</th>
<th>Set Price</th>
</tr>
</thead>
<tbody>
<tr>
<td>THW 210-R 28-82</td>
<td>10mm 40mm 20mm</td>
<td>26mm 45mm</td>
<td>25mm M 6</td>
<td>W0-080-CO-10-S</td>
<td>$463.60</td>
<td>SZKA 212</td>
</tr>
<tr>
<td>THW 210-R 66-119</td>
<td>12mm 40mm 20mm</td>
<td>30mm 50mm</td>
<td>25mm M 6</td>
<td>W0-080-CO-20-S</td>
<td>$463.60</td>
<td>SZKA 213</td>
</tr>
<tr>
<td>THW 210-R 103-157</td>
<td>10mm 40mm 20mm</td>
<td>40mm 60mm</td>
<td>30mm M 6</td>
<td>W0-100-CO-30-S</td>
<td>$463.60</td>
<td>SZKA 216</td>
</tr>
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</table>

#### Chuck Jaws For Quick Jaw Change Schunk Chucks

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<thead>
<tr>
<th>Kitagawa Chuck Type</th>
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<th>Set Price</th>
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<tbody>
<tr>
<td>KT-060-COD-10-S</td>
<td>12mm 20mm M10</td>
<td>30mm 47mm</td>
<td>20mm M6</td>
<td>W16-6HOH 6/206</td>
<td>$353.58</td>
<td>SZKA 16-6</td>
</tr>
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<td>KT-060-COD-20-S</td>
<td>12mm 20mm M10</td>
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<td>SZKA 16-7</td>
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<td>SZKA 16-8</td>
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<td>KT-060-COD-40-S</td>
<td>12mm 20mm M10</td>
<td>35mm 47mm</td>
<td>20mm M6</td>
<td>W16-9B</td>
<td>$353.58</td>
<td>SZKA 16-9</td>
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<td>12mm 20mm M10</td>
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</tbody>
</table>

### Machine Accessories

#### Chuck Jaws

<table>
<thead>
<tr>
<th>Chuck Jaws Type</th>
<th>Very Aggressive Bite Hard Jaws</th>
<th>Lightweight Claws</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hard Claws</td>
<td></td>
<td></td>
</tr>
<tr>
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<tr>
<td>Drills</td>
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### Abrasives

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LATHE CHUCKS

LIVE CENTERS

VISES

LATHE CENTERS

TOOL HOLDERS

MACHINERY

CUTTING TOOLS

MACHINERY

PRECISION TOOLS

DEBURRING

COOLANT/FLUIDS

TOOL STORAGE

Kitagawa Chuck Type

Kitagawa Chuck Type

8" (210mm) Size Chucks-Group K1-14-25

Kitagawa Chuck Type

16mm 30mm M12 40mm 58mm 25mm M8

KT-120-CO-10-S $535.17

SZAJ 30-1B 250, B 10 45-110 322

HOH 12 K, HOH 250 45-113 322

N 250, N 10 42-113 322

B 300, B 12 45-111 322

KT-120-CO-20-S $535.17

SZAJ 30-2B 250, B 10 89-173 338

HOH 12 K, HOH 250 89-176 338

N 250, N 10 85-172 338

B 300, B 12 89-172 338

KT-120-CO-30-S $535.17

SZAJ 30-3B 250, B 10 143-236 340

HOH 12 K, HOH 250 143-239 340

N 250, N 10 129-232 340

B 300, B 12 143-232 340

KT-120-CO-40-S $535.17

SZAJ 30-4B 250, B 10 217-301 342

HOH 12 K, HOH 250 213-299 342

N 250, N 10 203-300 342

B 300, B 12 217-300 342

21mm 30mm M16 50mm 65mm 25mm M8

2012-13 Master Catalog 65

U S Shop Tools Sales: 800-243-7701 Fax: 800-342-3311 www.usshoptools.com
CUSTOM HARD CHUCK JAWS

We Will Make Any Custom Hard Jaws To Meet Your Work Holding Needs!

- Multiple gripping surface radii on the same jaw to hold different diameter parts
- Hard jaws for three, four or six jaws chucks. Jaws can be tapered to accommodate smaller parts and to get closer to the center of the chuck, if needed
- Reversible to hold OD and ID
- Extra holes if needed
- Weight reduction cuts made where possible
- Option of gripping surface teeth style - smooth or aggressive
- Choice of step heights and number of steps
- Length including extended length, width and height

Specify Your Hard Jaw Requirements Using The Method That Is Most Convenient For You!

Highly Customized Jaws

- We will work with your print or help you develop a print. For highly customized work holding hard jaws, a print and pictures would be ideal. We can make complicated workholding hard jaws with proper prints.

Custom Hard Jaws Which May Not Require A Print From You

- If you would like a modification of standard hard jaws, such as different radii or step heights, we can do that as well. We will do the calculations for you, and send you a print, based on your needs and the chuck make and model.
- If you would like to specify all the dimensions for your engineering needs, you can use diagrams located on the next page.
- If necessary, we will make a print and send it to you for approval.

Special Order Hard Jaws Available!

- Have a print? Great! We'll make it per your print
- Need a slight modification to one of our standard sets? We can do it!
- Simply fill out our special order form
- Need help in developing a print? No problem, give us a call
- Looking for hard jaws with different gripping surfaces or radii? Call us, we'll help you out!

We Make It Easy To Order Special Hard Jaws!