

Top Jaws

Technical Information

Materials

Most *Techleader* standard jaws are manufactured from either 080M15 (En 32) low carbon steel or 590M17 (16MnCr5) alloy steel which can be case-hardened for long-term durability. Other materials can of course be used, for example more exotic steels, aluminums, plastics and composites and these are all available as specials.

T-nuts are manufactured from En24 heat-treated to the 'T' condition.

Heat Treatment

All *Techleader* standard soft jaws can be case-hardened using heat treatment. See chart for guidelines.

Below is a simple table showing British Standard and corresponding German reference numbers for various steels used in the production of *Techleader* products.

MATERIAL	BS 970/83	BS 970/55	GERMAN
Steel	080M15	En32	C15
Steel	665M17	En34	
Steel	080M40	En8	C45
Steel	590M17		16MnCr5
Steel	817M40	En24T	40NiCrMo6

Unless otherwise stated, all special jaws will be manufactured using material specified on the drawings supplied by the customer.

	Depth of Case	MATERIAL TYPE	
		080M15 (EN32)	590M17 (16MnCr5)
		Rockwell Hardness 'C'	
Thin Section	0.38 - 0.5 mm	54 - 56	57 - 59
Normal Section	0.63 - 0.75 mm	56 - 58	58 - 60
Thick Section	0.76- 1 mm	57 - 59	59 - 61

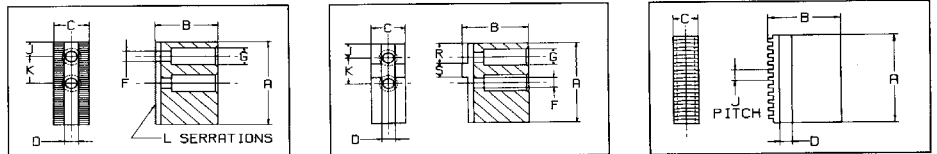
Top Jaw Weights

Careful consideration must be given when fitting oversized top jaws to a rotating chuck because the safety and performance of the chuck may be compromised. Although the calculations given in the chart below can establish approximate theoretical grip loss, the most accurate method is to establish the actual performance of the jaws on the machine, this can usually be carried out by use of a grip meter.

Techleader offers grip meter equipment for sale or hire and in either case full instructions for use and any advice required are included. Please contact our sales office for further details.

Jaw Location Dimensions

Chuck manufacturers occasionally change specifications on location details so it is important to check that the dimensions listed (right) correspond with your existing top jaws, master jaws and chuck.



L = Pitch & angle of serrations
1.5 mm x 60°; 1/16" x 90°
3 mm x 60°; 3/32" x 90°

D = slot width (locates on T-nut) G = bolt hole (see note below)

K = hole Center spacing

G = bolt nut (see note below)

D = slot width

S = tenon width

K = hole Center spacing

G = bolt hole (see note below)

C = jaw width

D = slot width

J = tooth pitch

Note: Remember the bolt hole will have clearance on the bolt. It is important that these dimensions are measured accurately. The use of a vernier or micrometer is recommended.

Warning

While every effort is made to make sure the information relating to technical data is correct, manufacturers do change specifications of their products and subsequently *Techleader* shall not be liable for any loss or consequential damage whatsoever that may arise from the use of the products, the use of information or particulars or any error or omission in this catalogue. The responsibility of correct fit and use lies with the user and the information in this catalogue should be used only as a guide.

Soft Scroll Jaws

Techleader soft scroll jaws have been manufactured to allow for a small degree of wear in the chuck guideway, therefore the slots are slightly undersized and the width slightly oversized. A minor amount of adjustment may be required to obtain a correct fit, particularly if the chuck is new.

Concentricity

Techleader manufactured standard hard jaws are made to a 0.05 - 0.07mm (0.002" - 0.003") micron concentricity tolerance using our purpose made fixtures. For optimum concentricity jaws must be ground on the chuck in the correct position on the machine.

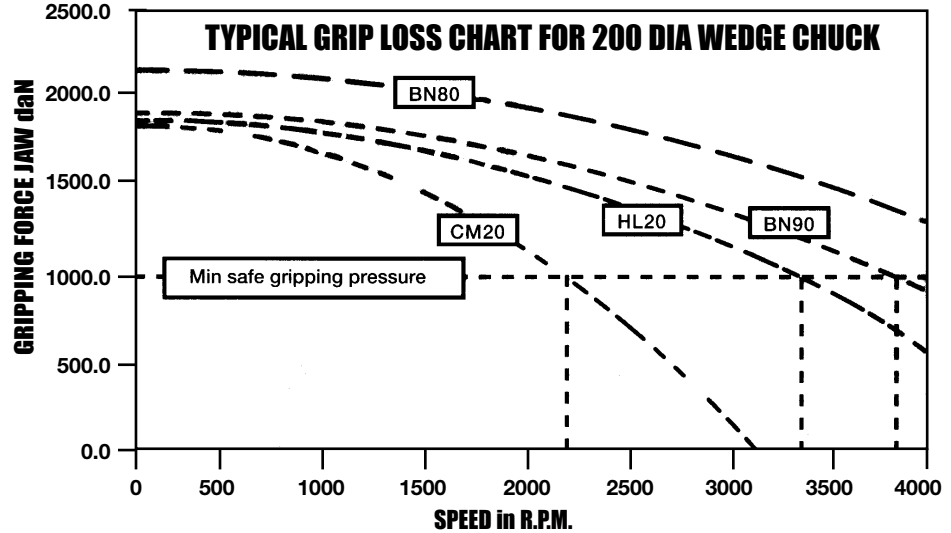
Please Note: The condition of the chuck has a great bearing on concentricity and repeatability of jaw sets. Regular servicing of chucks will prolong their life and maintain a higher level of operating accuracy. For unparalleled concentricity when boring standard soft jaws a *Techleader* Trueborer is available.

Top Jaws

Technical Information

Grip Loss Due to Centrifugal Forces

The following chart shows the typical grip loss for different types of standard jaws on a 200 dia wedge type chuck



Jaw Code	Jaw Type	Jaw Material	Weight per Jaw
BN80	Std. Soft Jaw	Mild Steel	0.93 Kg
BN90	Tall Soft Jaw	Mild Steel	1.23 Kg
CM20	Diamond Jaw	Mild Steel	4.66 Kg
HL20	Diamond Jaw	Aluminum	1.66 Kg

Conversion Factors: 1kN = 100daN 1kgf = 9.806 N

Typical Gripping forces (for external gripping) can be calculated using the following formula

For drawtube/bar operated chucks: $G_i = S_i F_o / (1 + J_i G_i) - G_i S^2 (MR+B)$

For pneumatically operated chucks: $G_i = S_i P_o / (1 + J_i G_i) - G_i S^2 (MR+B)$

Where G_i = Chuck Gripping Force (daN)

F_o = Operating Force of drawtube actuated chucks in daN

P_o = Operating Pressure of pneumatically actuated chucks in bar

S = Speed of chuck in thousandths of R.P.M. (ie. 6000 R.P.M. = 6)

M = Mass of top jaw in Kg

R = Radius of grip in cm

G_i = Height of top jaw in cm

Note: For internal gripping the centrifugal force is additive, the minus sign in the above formula therefore becomes a plus sign.

AND S_i , G_i , B_i , J_i , & P_o are constant values

associated with specific chuck types and typical values are found in tables A, B & C below.

Table A

For standard wedge type chucks

Chuck Size	160	200	250	305	380
S_i	0.80	0.80	0.80	0.80	0.80
G_i	7.5	7.5	7.5	7.5	7.5
B_i	2.3	5.2	8.9	15.9	34.0
J_i	0.08	0.06	0.05	0.04	0.03

Table B

For Compensating chucks

Chuck Size	160	200	250	305	380
S_i	0.75	0.77	0.91	0.91	0.80
G_i	8.0	8.0	8.0	8.0	8.0
B_i	-1.5	-4.2	-6.0	-11.5	-22.0
J_i	0.08	0.06	0.05	0.04	0.03

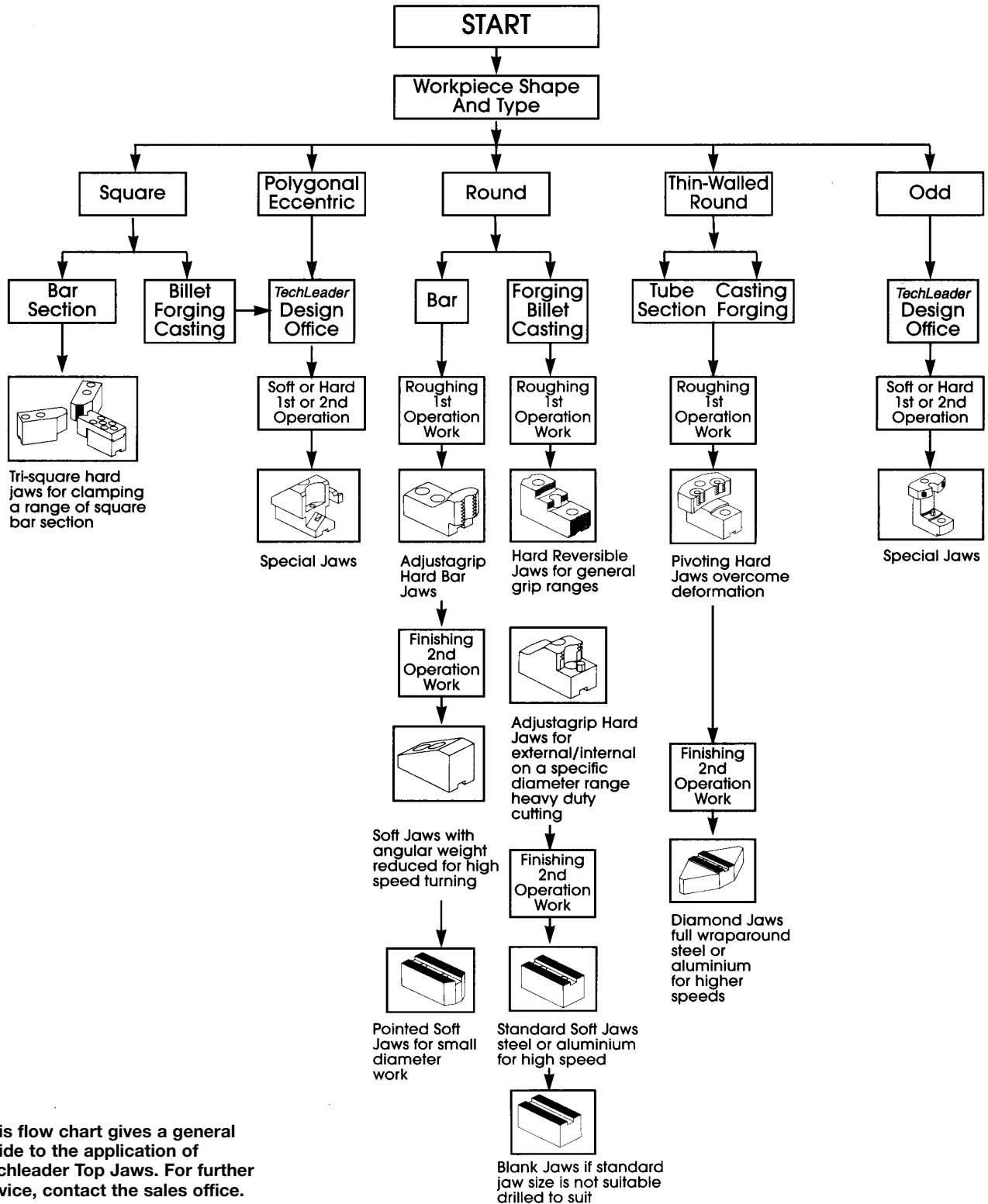
Table C

For Pneumatic chucks

Chuck Size	160	200	250	305	380
P_o	173	256	380	462	473
G_i	6.2	6.2	6.2	6.2	6.2
B_i	2.8	5.3	10.2	15.9	19.6
J_i	0.075	0.070	0.055	0.040	0.045

Note: These charts are typical examples only and should not be applied without consultation with chuck manufacturer or chuck manual.

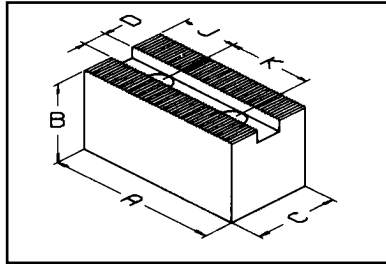
Application Flowchart for Selection of TECHLEADER Top Jaws for Power Chucks



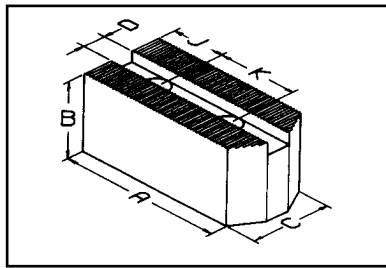
This flow chart gives a general guide to the application of Techleader Top Jaws. For further advice, contact the sales office.

Serrated Soft Top Jaws

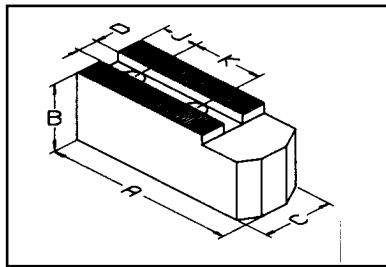
To Suit Hardinge, Howa, Kitagawa, Matsumoto, Pratt Burnerd, Röhms, Schunk & SMW-Autoblok Power Chucks



TYPE A



TYPE B



TYPE C

1.5m x 60° Serrations

**Material: 080M15 (En32)
Black Finish**

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Type	Weight Kg/Set
BO 04	48	25	20	8	15 + 8 M6	1.5 mm x 60°	A	0.5
BR 05	55	25	25	10	14 + 10 M8	1.5 mm x 60°	B	0.5
BB 05	55	40	25				B	
DK 05	55	50	25				A	1.1
BH 05	55	60	25				B	
BO 05	57	35	25	10	18 + 10 M8	1.5 mm x 60°	B	0.8
DJ 05	57	50	25	10			A	1.3
CK 05	62	25	25	10	19 + 8 M8	1.5 mm x 60°	B	0.9
DU 05	48	25	25	11	16 + 9.5 M8	1.5 mm x 60°	A	0.7
CK 06	80	35	30	11	25 + 14 M8	1.5 mm x 60°	C	1.4
BO 06	72	38	30	12	20 + 15 M10	1.5 mm x 60°	A	1.6
BB 06	72	40	30				A	
BC 06	72	50	30				A	3.5
DJ 06	72	60	30				A	1.3
PT 06	82	32	30				B	
BP 06	72	38	32	12	20 + 15 M10	3 mm x 60°	A	1.6
BO 08	95	44	35	14	25 + 25 M12	1.5 mm x 60°	A	2.7
BB 08	95	50	35				A	4.0
DJ 08	95	80	35				C	2.2
CK 09	95	44	32	14	25 + 25 M12		C	2.7
PT 08	102	40	35				B	2.9
BP 08	95	44	32	14	25 + 25 M12	3 mm x 60°	A	2.7
DU 08	85	40	40	16	25 + 20 M12	1.5 mm x 60°	A	2.8
DU 09	85	60	40				A	4.0
BO 10	110	40	40	16	30 + 30 M12	1.5 mm x 60°	A	3.4
BO 10L	4.5"	2"	1.50"				A	5.0
DJ 10	110	80	40				A	6.5
BD 10	110	100	40				A	
PT 10	125	40	40				B	4.5
				16	30 + 21 M12			4.2
DK11	110	60	40				C	5.2
BP 10	110	40	40	16	30 + 30 M12	3 mm x 60°	A	3.4

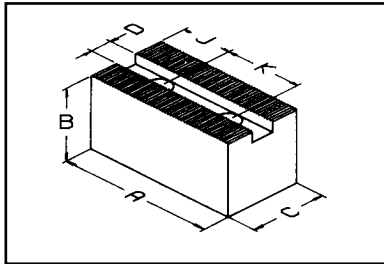
Serrated Soft Top Jaws

To Suit Hardinge, Howa, Kitagawa, Matsumoto, Pratt Burnerd, Röhm, Schunk & SMW-Autoblok Power Chucks

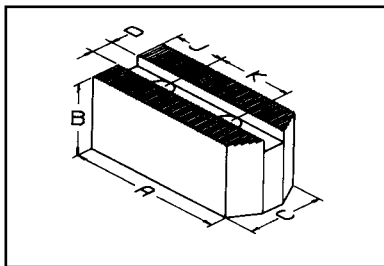
CHUCK Ø	HARDINGE	HOWA	KITAGAWA		MATSUMOTO (MMK)	PRATT BURNERD	RÖHM	SAMCHULLY	SCHUNK AUTOBLOK	SMW	
110			B-04 HOB-4								
105 110 135	4" SURE-GRIP 5" SURE-GRIP	HO1MA4 HO24M5	B204 N-04 HJ-4 B205	AS110	H-4-21		KFD-HE 130 KFN 105	H505			
135			HOB-5 B-05								
135		HO1MA5	HJA-4 N-05		HXA5-6-34 HHXA 5-6 SA 5-6-40						
110 135		HO27M4 HO27M5									
165					HA5-6 HX-6 H-6 ZA-5-6	HH-6 HJ-6 STC-6					
165 170 210	6" SURE-GRIP	HO7MA6 HO15MA6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6 HO23M8	HJA5-6 AS-165 B-160 B-06 HOH-160 HOH-06 N-160 BL206 HOS-6	N-06 B206 HO-6 NL-06 BT206 HOH206 B-07, BB06 B-106 HG738 165 HOB-6		INTERNATIONAL 9821-31723 9821-21723 HIGH SPEED QUICK CHANGE 9121-21723 9121-31723	KFD-HE 170	HC06 HS06 HST06 HH-206	ROTA NCK 165 HSL 165 ROTA NC165 ROTA NCF 165	BBM 175	
165		HO1MA6									
210	8" SURE-GRIP	HO7MA8 HO15M8	B200 B-08 N-200 AS-210 HOS-8 HJA6-8 HO-8 B-108 HOH-8 N-08	B208 HOB-8 HOH-200 NL-08 BT208 HOH208 HOH108 BB-08 BL208 NL200 HG715-210	HA6-8 HX-8 H-8 HJ-8 HHJ-8 STC-8 ZA6-8-52 ZA6-8-66 N-08	INTERNATIONAL 9821-32123 9821-42123 9827-TORNADO HIGH SPEED QUICK CHANGE 9121-32123 9121-42123	KDF-HE 210 210 KB	HC08 HS08 HST08 HH208 HHF208 HSF08	ROTA NCK 210 HSL 210 ROTA NC210 ROTA NCF 210	BBM 210	
210		HO1MA8									
210		HO27M8 HO47M8 HO24M8 HO22M8 HO37M8 HO7MA10 HO23M10 HO15M10									
254											
250 254 265	10" SURE-GRIP		B250 HOH-250 B210 AS-250 N-10 HJA8-10 HO-10 BT210 UVE-K200 UVE-K250 BL210	B-10 HOH-10 HOB-10 N-250 HJA6-10 HOS-10 NL-10 B-110 HOH110 HOH210 HG730-254	HA6-10 ZA6-10-75 H-10 HHL-10 HHJ-10 HA8-11	HA8-10 HX-10 HH-10 HJ-10 STC-10	INTERNATIONAL 9821-42623 9821-52623 9827-TORNADO HIGH SPEED QUICK CHANGE 9121-42623 9121-52623 265 KB	KFD-HE 254	HC10 HS10 HST10 HSF10	ROTA NCK 250 HSL 250 ROTA NC 250 ROTA NCF 250	BBM 250
254		HO1MA10									

Serrated Soft Top Jaws

To Suit Howa, Kitagawa, Matsumoto, Pratt Burnerd, Röhm, Schunk & SMW-Autoblok Power Chucks



TYPE A



TYPE B

60° Serrations

**Material: 080M15 (En32)
Black Finnish**

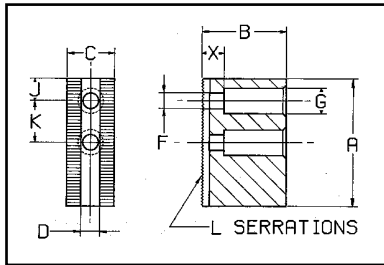
Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Type	Weight Kg/Set
DU 10	105	40	40	18	30 + 24 M14	1.5 mm x 60°	A	4.4
DU 11	105	60	40				A	6.6
BO 12	130	50	50	18	30 + 40 M14	1.5 mm x 60°	A	6.8
DJ 12	130	80	50				A	10.9
DJ 14	130	100	50				A	13.6
PT 12	145	50	50				B	7.3
BP 12	130	50	50	18	30 + 40 M14	3 mm x 60°	A	6.8
BR 13	130	50	50	21	30 + 40 M16	1.5 mm x 60°	A	6.5
DJ 13	130	80	50				A	11.0
BD 13	130	100	50				A	7.3
PT 13	145	50	50				B	7.3
DU12	111	65	50	21	35 + 25 M16	1.5 mm x 60°	A	7.1
BO 15	165	76	64	22	43 + 37 M20	1.5 mm x 60°	A	15.2
DJ 15	165	127	64				A	25.0
BR 15	135	60	50	25.5	43 + 26 M20	1.5 mm x 60°	A	8.2
CK 15	150	76	64	22	50 + 30 M20	3 mm x 60°	A	13.8
BO 18	180	76	64	25	60 + 40 M20	3 mm x 60°	A	16.5
DJ 18	180	127	64					29.0
BO 24	210	102	76	25	80 + 40 M20	3 mm x 60°	A	32.3

Serrated Soft Top Jaws

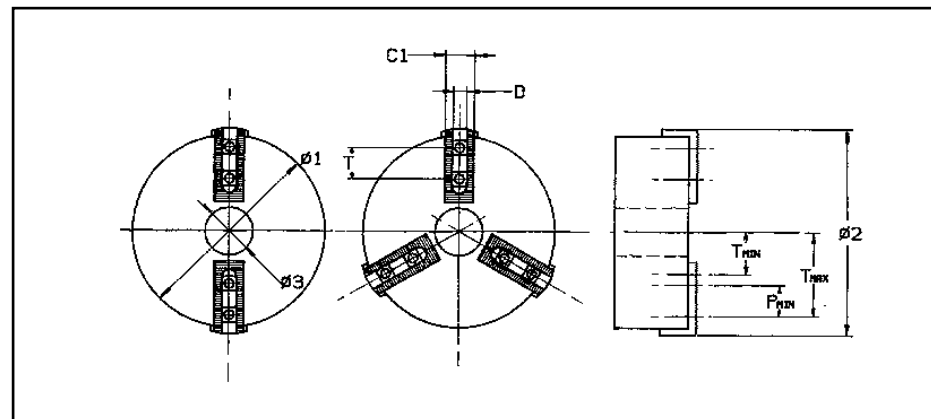
To Suit Howa, Kitagawa, Matsumoto, Pratt Burnerd, Röhm, Schunk & SMW-Autoblok Power Chucks

CHUCK Ø	HOWA	KITAGAWA	MATSUMOTO (MMK)	PRATT BURNERD	RÖHM	SAMCHULLY	SCHUNK AUTOBLOK	SMW
254	HO22M10 HO37M10 HO24M10 HO27M10 HO47M10							
304	HO7MA12 HO23M12 HO15M12							
304 305 381		B300 B-12 HOH-300 HOH-12 N-300 N-12 HOS-12 HO-12 HJA8-12 HOB-12 HJA6-12 HLA6-12 NL-12 HLA8-15 HLA6-15	HA8-12 HX-12 H-12 SH-12 HH-12 HHL-12 HJ-12 HHJ-12 ZA8-12-78 ZA8-12-85	INTERNATIONAL 9821-53123 9821-63123 9827-TORNADO HIGH SPEED QC 9121-53123 9121-63123 305KB		HC12 HCF12	HSL 315 ROTA NCK 315 ROTA NC 315 ROTA NCF 315	
304	HO1MA12							
304 315		B212 BT212 BL212			KFD-HE315	HS12 HST12 HH212 HSF12		BBM 315
304	HO27M12 HO37M12							
380 450		B380 B-15 HOH-380 HOB-15 HOH-15 B-450 B-18 HOB-18		INTERNATIONAL 9821-53823 9821-63823 HIGH SPEED QC 9121-53823 9121-63823		HAH15 HCHF15 HC15 HCF15 HAH18 HCHF18 HC18	ROTA NC 400 ROTA NCF 400	
380		B215, N15, N18						
380 450 450			HA11-15 HHL-15 H-15 HH-15 HA11-18 H-18 HH-18 ZA-15-120				HSL 400	
454 530 610		HJ-450 HJ18 B-530 B-21 HJ-530 HJ-21 HOB-21 N21 B-600 B-24 HJ-610 HJ24 N24 HOB24 UVE-LB500/630				HAH21 HAH24 HC21 HC24 HCHF21 HCHF24		
610		HOB24 HJA24 HJ24 UVE-LB800						

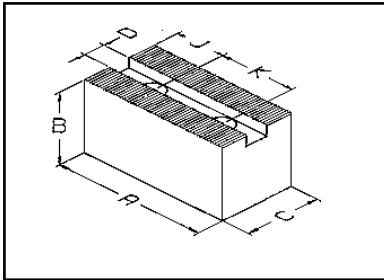
Serrated Top Jaw and Chuck Data Sheet



		2 JAW CHUCK DATA	3 JAW CHUCK DATA	REMARKS
Chuck Manufacturer / Model No.				
Chuck Ø / Type	ø1			
Maximum Swing Ø	ø2			
Chuck Bore Ø	ø3			
Base Jaw Width	C1			
T-Nut Minimum Position	Tmin			
T-Nut Maximum Position	Tmax			
T-Nuts Minimum Hole Pitch	Pmin			
Are Base Jaw Serrations Above Chuck Face	Yes No			
Are T-Nuts Single or Double	Single Double			
Slot Width	D			
Hole Center Spacing	K			
Hole Center To Back of Jaw	J			
Counterbore / Hole Ø	G/F			
Depth Under Bolt Head	X			
Serration Pitch & Angle	L			
Length Of Jaw	A			
Height Of Jaw	B			
Width Of Jaw	C			



Serrated Soft Top Jaws



90° Serrations

**Material: 080M15 (En32)
Black Finish**

To suit Berg KH power chucks

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set	Berg Chuck Type	
CS 14	55	35	22	8	14 +-11 M8	1/16" X90°	0.7	KH 110	
CS 16	70	45	25	10	20 +-15 M10	1/16" X90°	1.4	KH 140-36 / KH 140-45 / KH 160	
CS 18	80	57	32	12	21 +-15 M12	1/16" X90°	3.6	KH 175-56 / KH 200-68	
CS 20	90	57	32	12	21 +-15 M12	1/16" X90°	3.8	KH 175-56 / KH 200-68	
CS 25	111	60	40	16	29 +-18 M16	1/16" X90°	4.7	KH 250-91/ KH 315-117	
CS 40	150	80	50	20	38 +-31 M20	3/32"X90°	8.4	KH 400 / KH 500 / KH 630	

To suit Schunk & SMW-Autoblok pneumatic power chucks

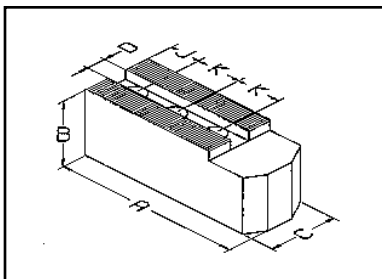
Techleader Part No.	A	B	C	D	K+J Bolt	Serrations	Weight Kg/Set	Chuck Type	
								SMW-Autoblok	Schunk
CO 13	68	40	30	11	18 +21 M8	1/16" X90°	1.6	SP 125 / STP 125 / STWP 125	TP 125
CO 16	88	51	32	14	25+25 M10	1/16" X90°	2.9	SP 160 / STP 160 / STWP 160	TP 160
CO 20	98	50	40	17	29+25 M12	1/16" X90°	4.0	SP 200 / STP 200 / LP 205 / STWP 200	TP 200
CO 25	108	70	50	21	30+28 M14*	1/16" X90°	8.0	SP 250 / STP 250 / LP 250 / STWP 250 SP 315 / STP 315 / LP 305 / STWP 315	TP 250 TP 315
CO 32	120	70	50	21	30+28 M14*	1/16" X90°	10.1	SP 315 / STP 315 / LP 305 / STWP 315	TP 315
CO 35	132	70	50	21	30+28 M14*	1/16" X90°	11.5	SP 315 / STP 315 / STWP 315	

* Please note, for 250mm Chucks upwards after mid 1997 bolt sizes changed to M16. Please specify.

To suit Schunk & SMW-Autoblok big bore power chucks

Techleader Part No.	A	B	C	D	K+J Bolt	Serrations	Weight Kg/Set	Chuck Type	
								SMW-Autoblok	Schunk
CP 40	158	76	64	25.5	40+35 M18*	3/32" X90°	15.0	BB400 / BB400-ES / STP 400 / LP 380-460	TB 400
CP 50	185	76	64	25.5	40+35 M18*	3/32" X90°	18.0	BB500 / BB500-ES / BB630-ES265 STP 500 / LP 500	TB 500
CP 63	240	102	76	30	64+40 M24	3/32" X90°	35.0	BB630 / BB630-ES-ES325 / STP 630	TB 630
CP 80	300	102	76	30	64+40 M24	3/32" X90°	43.0	BB800 / BB1000 / STP 800	TB 800 TB 1000

* Please note, after mid 1997 M18 bolt sizes change to M20. Please specify.

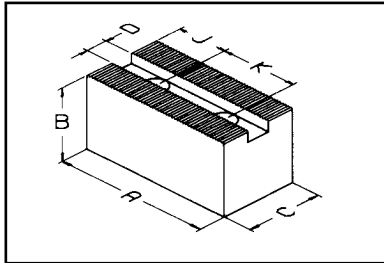


90° Serrations
Material: 080M15 (En32)
Black Finish

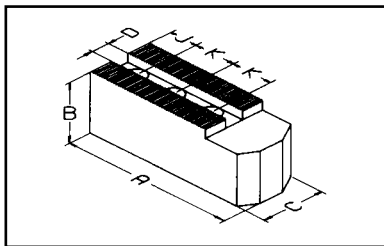
To suit Gamet power chucks

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set	Gamet Chuck Type	
BU 06	77	35	30	11	20 +-9 M8	1/16" X90°	1.3	160 N / 160 MO / 160 GP	
BU 08	102	44	32	14	22 +-10 M10	1/16" X90°	2.6	215 N / 215 MO / 215 GP	
BU 11	130	51	44	20	30 +-13 M12	1/16" X90°	5.4	250/280 N / 280 MO / 280 GP	
BU 14	170	65	50	21	40 +-22 M16	1/16" X90°	10.0	350 N / 350 MO / 350GP	

Serrated Soft Top Jaws



TYPE A



TYPE B

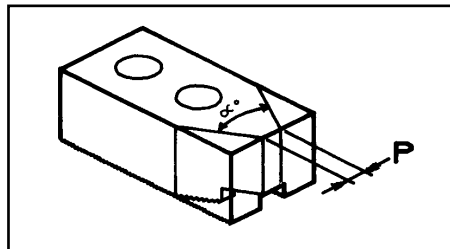
60° Serrations

**Material: 080M15 (En32)
Black Finish**

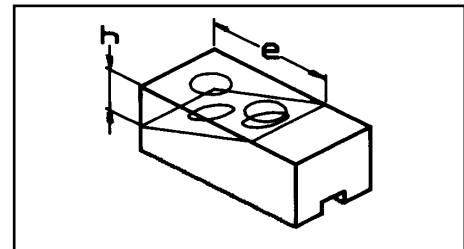
To suit Gamet, Nikko and Röhmm Power Chucks

Techleader Part No.	A	B	C	D	K+J Bolt	SERRATIONS	TYPE	WEIGHT KG/set	GAMET	NIKKO	RÖHM
DL10	53	30	20	10	15+9 M8	1.5 x 60°	A	0.6	105 N 105 MO	HF-4	KFD-HE 130 KFN 105
DL 16	67	40	30	11	20+17 M8	1.5 x 60°	A	1.6	140 DE 160 GO 160 N 170 MF	GO-6 HDM-165 HF-6AB D-170	KFN 160 KFM 160
BT06	77	35	30		20+9 M8		B	1.3	160 MO 130 N 130 MO	HG-6AB MO 6	KFG 160 KFE 170
DL 22	89	57	32	14	26+18 M10	1.5 x 60°	A	3.1	170 DE 215 MF 215 N	GO-8 MO-8 HF-8 MAC 165	KFN 215 KFM 215
BT 08	102	44	32		22+10 M10		B	2.6	215 MO 215 GO	HG-8 HDM 215	KFG 215 KFE 215
DL 28	89	57	44	20	26+18 M12	1.5 x 60°	A	4.1	250 N 280 N	GO-10 HDM 250 GO-12 HDM 300	KFN 250/280 KFM 280
BT 10	117	51	44		30+13 M12		B	4.9	280 MO 280 GO	HF-10 MO-10 HF-12 MO-12	KFG 280 KFE 280
BT 11	130	51	44		30+13 M12		B	5.4	280 MF	HG-10	
DL 35	120	80	50	21	28+25 M16	1.5 x 60°	A	9.4	350 N 350 MO 350 GO 350 MF	HF-14 MAC 250 HF-16 MAC 315	KFN 350 KFM 350
BT 14	170	65	50		40+22 M16		B	10.0		HDM 250 MO-14 HDM 380	KFG 350 KFE 350

Pointed or Weight Reduced Soft Jaws



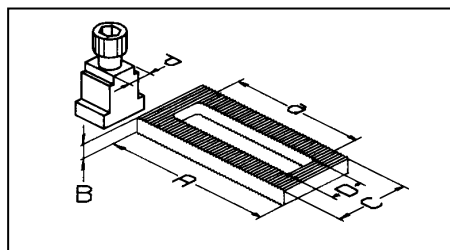
A. Pointed 60° or 120° Inclusive



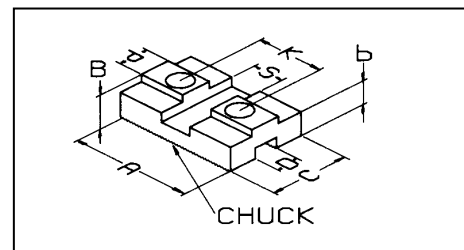
B. Rectangular Weight Reduced

Any standard soft jaw can be pointed or weight reduced, please give the following information:
1. Quantity of sets required. 2. Techleader Part No. 3. Modification required. 4. Relevant dimensions.

Conversion Plates



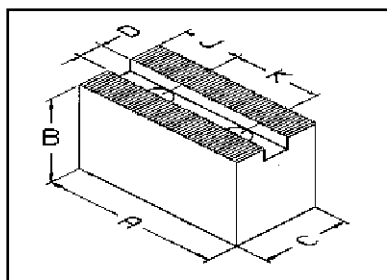
A. Serration to Serration



B. Serration to Slot/Tenon

Allows different top jaws to be used with base jaws of another configuration. Please contact our sales office for a quotation.

Serrated Soft Top Jaws



90° Serrations

**Material: 080M15 (En32)
Black Finish**

To suit SMW-Autoblok large & extra large open Center power chucks

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set	Autoblok Chuck Type Pratt	
CL 12	60	32	32	12	16 +-15 M8	1/16" X90°	1.0	130 BHD 125 ALD	140 BBD 125AND
CH 17	70	38	32	14	16.5+16 M10	1/16" X90°	1.3	165 BHD, BHD/FC 165 ALD	175BBD RCD 165 165 AND
CH 21	90	40	40	17	23 +-20 M12	1/16" X90°	2.8	210 BHD, BHD/FC 210 ALD	210 BBD RCD 210 210 AND
CH 25	110	44	44	21	30 +-20 M16	1/16" X90°	3.8	250 BHD, BHD/FC 250 ALD	250 BBD RCD 250 250 AND
CH 32	125	50	50	21	30 +-20 M16	1/16" X90°	5.5	315 BHD, BND/FC 315 ALD	315 BBD RCD 315 315 AND

To suit Pratt Burnerd closed/open Center wedge power chucks

Techleader Part No.	A	B	C	D	K+J Bolt	Serrations	Weight Kg/Set	Pratt Chuck Type				
BJ 16	62	32	25	12.7	17.5+14 M8	1/16" X90°	1.2	160 TYPES	1160-/	1140-/	1141-/	1180-
BJ 20	71	44	32	14.3	20.6+16 M10	1/16" X90°	2.1	200 TYPES	1160-/	1140-/	1141-/	1180-
BJ 25	83	50	40	15.9	23.8+17 M12	1/16" X90°	3.0	250 TYPES	1160-/	1140-/	1141-/	1180-
BJ 32	108	57	44	17.4	31.8+24 M14	1/16" X90°	5.2	315 TYPES	1160-/	1140-/	1141-/	1180-
BJ 40	124	65	50	20.6	38.1+24 M16	1/16" X90°	8.3	400 TYPES	1160-/	1140-/	1141-/	1180-
BJ 50	146	80	50	25.4	44.5+29 M20	3/32" X90°	12.6	500/630 TYPES	1160-/1140-/	1141-/	1180-	

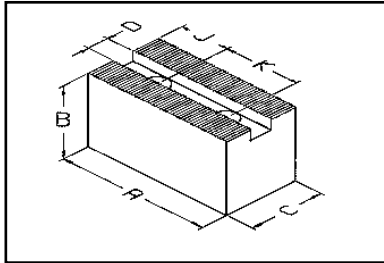
To suit Pratt Burnerd constant grip power chucks

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set	Pratt Chuck Type			
BL 16	50	38	32	15	20.6+11 M10	1/16" X90°	1.0	160 TYPES	1770-/	1771-/	1772-
BL 20	64	40	40	17	25.4+13 M12	1/16" X90°	1.6	200 TYPES	1770-/	1771-/	1772-
BL 25	80	50	40	17	25.4+13 M12	1/16" X90°	2.8	250 TYPES	1770-/	1771-/	1772-
BL 32	105	57	44	21	31.8+17 M16	1/16" X90°	5.0	315 TYPES	1770-/	1771-/	1772-
BL 40	124	65	50	21	31.8+17 M16	3/32" X90°	8.4	380 TYPES	1770-/	1771-/	1772-

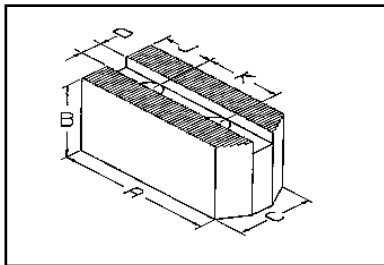
To suit Pratt Burnerd self contained (up to 89) power chucks

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set	Pratt Chuck Type			
BK 16	62	40	25	13	18+14 M8	1/16" X90°	1.1	160 TYPES	1740-/1730-/	1742-/1744-/	1157-
BK 20	76	44	32	17	22+16 M10	1/16" X90°	2.2	200TYPES	1740-/1730-/	1742-/1744-/	1157-
BK 25	89	60	40	21	25+19 M12	1/16" X90°	3.7	250 TYPES	1740-/1730-/	1742-/1744-/	1157-
BK 32	105	60	40	21	30+22 M12	1/16" X90°	4.5	315 TYPES	1740-/1730-/	1742-/1744-/	1157-

Serrated Soft Top Jaws



TYPE A



TYPE B

90° Serrations

**Material: 080M15 (En32)
Black Finish**

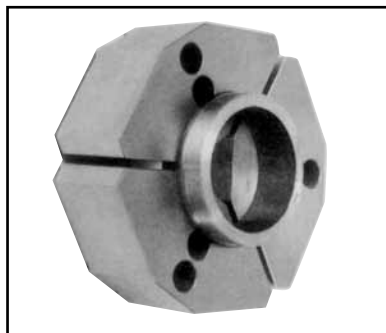
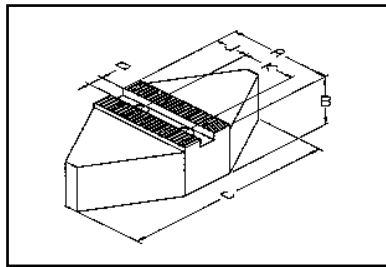
Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Type	Weight Kg/Set
BV 13	52	25	25	12	14 + 8 M8	1/16 x 90°	A	1.0
RD 13	55	38	32	12	16 + 10 M8	1/16 x 90°	A	1.2
CL12	60	32	32		16 + 15 M8		A	1.0
BV 16	72	38	32	12	20 + 10 M10	1/16 x 90°	A	1.4
CL 17	80	38	32	14	20 + 19 M10	1/16 x 90°	A	2.2
BM 16	65	40	40	17	22 + 15 M12	1/16 x 90°	A	1.3
BN 70	70	60	40				A	2.7
BN 75	80	40	40				B	2.5
BL 20	64	40	40	17	25.4 + 13 M12	1/16 x 90°	A	1.6
BL 25	80	50	40				A	2.8
BN 80	90	40	40		22 + 15 M12		A	2.8
BN 85	90	40	40				B	2.7
BN 90	90	60	40				A	3.7
BL 32	105	57	44	21	31.8 + 16 M16	1/16 x 90°	A	5.0
BM 32	116	65	50				A	7.6
BN 10	120	50	50		28 + 20 M16		A	5.4
BN 11	120	50	50				B	5.3
BN 12	120	80	50		28 + 20 M16		A	9.4
BN 14	140	50	50				A	6.3
BN 15	140	50	50				B	6.2
BN 13	140	89	64	25.5	35 + 30 M20	1/16 x 90°	A	15.0
BM 40	152	76	64	25.5	44.5 + 20 M20	3/32 x 90°	A	14.3
BN 23	155	89	64		35 + 30 M20		A	17.4
BJ 50	146	80	50	25.4	44.5 + 29 M20	3/32 x 90°	A	12.6
CL 50	160	76	64	28	38 + 25 M20	3/32 x 90°	A	14.5

Serrated Soft Top Jaws

To suit Autoblok, Forkardt, Gamet, Pratt Burnerd, Röhm, Schunk, SMW-Autoblok & SMW Power Chucks

AUTOBLOK & SMW-AUTOBLOK	FORKARDT	GAMET	PRATT BURNERD	ROHM	SCHUNK	SMW
			125 INTERNATIONAL 150 KB INTERNATIONAL			
IND 125 AND 125 ALD 125 GHDN 125	KTH 130/140		170 KB INTERNATIONAL	KFD 130 KFH 140	HSG 160-46	KDV 130 KMA 140 KMAF 140
			135 HYD. FRONT END 165 INTERNATIONAL 165 HIGH SPEED Q.C.			
IDN 170, HDB 170 IDL 170 HDN 170 GHDN 165 GHD/FC 165 AND 165, ALD 165		MAC 165/170 DE 170 GA 160/170			TP 160	SP 160
IDN 200/220 IDL 200 HDN 200/220 HDL 200 GHDN 210 CD 200 GHD/FC 210 HDB 220 AND 210 ALD 210	3KGH 160/175/200 KTG 160/200 KTN 160/200 3KGFH 160/175/200 KS 160/200/250 KL 160/200 KSPS 160/200 KSF 175/200 3KTGF 200 KSHF 200 UVE 160/200/250 KP 200 KG 200 3NHf 200 3NH 200 KSH 160/200 KLNC 200 KT 160/200 KTF 200 KTH 200/250/315 QLC 175	MAC 200 MAC 220 DE 210 GA 210	160 INTERNATIONAL (UP TO 89) 160 HIGH SPEED Q.C. (UP TO 89) 165 HYD. FRONT END 210 INTERNATIONAL 210 HIGH SPEED Q.C. 210 KB INTERNATIONAL 210 KB HIGH SPEED Q.C.	KFH 160/200 KFH-NC 160/200 KFH-F 160/200 KFH-G 160/200 KFD-HF 160/200 KFD-HE 160/200 KFD-HS 200 KFD 160/200 SPD 160/200 SPO 160/215 KFD-AF 160	THF 165-37 TH 165-37 HGS 200-66 HSL 165-37 ROTA NC 165 ROTA NCF 160 ROTA NCO 165	HFKS 160/200 KDV 160/200/250 KDVG 160/200/250 KDM 160/200 KDMF 160/200/250 KMA 160/200/250 KMAF 160/200/250 KFV 160/200 SP 200 KFMF 160/200 HFK 160/200
IDN 200/220 IDL 200 HDN 200/220 HDL 200 GHDN 210 CD 200 GHD/FC 210 HDB 220 AND 210 ALD 210	3KGH 200 KTG 200 3KGFH 200 KTN 200 KS 200/250 KSH 200 KL 200 KSF 200 3KTGF 200 KSHF 200 UVE 200/250 KG 200 KSPS 200 3NHf 200 KSHF 250-55 (INDEX) 3NH200 3NHf 250-65 (INDEX) 3NHf 290-104 (INDEX) KL 250 MO KS 250 MO KLNC 200 KP 200 KT 200 KTH 200/250/315 QLC 210	MAC 200 MAC 220 DE 210 GA 210	200 INTERNATIONAL (UP TO 89) 200 HIGH SPEED Q.C. (UP TO 89) 210 HYD. FRONT END 250 HIGH SPEED Q.C. (UP TO 89) 254 INTERNATIONAL 265 HIGH SPEED Q.C. 265 KB INTERNATIONAL 265 KB HIGH SPEED Q.C.	KFH 200 KFH-NC 200 KFH-F 200 KFH-G-200 KFH-HF 200 KFD-HE-200 KFD-HS 250 KFD-AF 200 SPO 215 SPD 215 KFD 200/250	THF 210-52 TH 210-52 HSG 250-91 HSL 210-52 ROTA NC 210 ROTA NCD 210 ROTA NCF 200 ROTA NCO 200 TP 200	HFKS 200 KDV 200/250 KDVG 200/250 KDM 200 KDM-F 200/250 KMA 200/250 KMA-F 200/250 KFV 200 KFMF 200 HFK 200
IDN 250/315/400 IDL 250/315/400 HDN 250/315/400 HDL 250/315/400 GHDN 250/315/400 CD 250/315 GHD/FC 250/305/400 HDB 300 AND 250 ALD 250 AND 315 ALD 315	KS 315/400 KSH 250/315/400 KG 250/315 KP 250/315 3KTGF 250/315 KT 250/315 UVE 315 KSHF 250/315/400 KTG 250/315 KLNC 250/315 KTN 250/315 KTF 250/315 3NHf 250/315 3NH 250/315 3NHf 290 3NHf 400 (INDEX) KL 250 KSPS 250/300 QLC 250/315	MAC 250 MAC 315 DE 250/260/320 GA 250/315	250 INTERNATIONAL (UP TO 89) 254 HYD. FRONT END 305 HYD. FRONT END 305 INTERNATIONAL 305 HIGH SPEED Q.C. 315 INTERNATIONAL (UP TO 89) 400 HIGH SPEED Q.C. (UP TO 89) 305 KB INTERNATIONAL 305 KB HIGH SPEED Q.C.	KFH 250/315 KFH-NC 250/315 KFH-F 250/315 KFH-G 250/315 KFH-HF 250/315 KFD 250/315 KFD-HF 250/315 KFD-HE 250/315 KFD-HS 315 KFD-AF 250/315 LVE 305 SPO 300 SPD 300	THF 250-71 TH 250-71 THF 315-86 TH 315-86 HSG 315-108 HSL 250-71 HSL 315-91 ROTA NC 250/ 315 ROTA NCD 250/ 315 ROTA NCF 250/ 315 ROTA NCO 250/ 315 TP 250/315	HFK 250/315 HFKS 250/315 KDV 315/400 KDVG 315/400 KDM 250/315/400 KMA-F 315/400 KMA 315/400 KMA-F 315
	KL 300 KSHF 560	MAC 380				
IDN 500/630/800 IDL 500/630/800 GHDN 500/610/640/800 ALD 400 AND 400	KS 500/620 KSH 500 KSL 630 KSHF 630 3KTGF 400/500 UVE 400/500/630/800 KTG 400/500 KTN 400/500 KG 400/500 3NHf 400/500/630 3NH 400/500/630 KL 400/500 KLNC 400/500 KP 400 KT 400/800 KTF 400/500 QLC 400	DE 400	400 INTERNATIONAL (UP TO 89) 400 HYD. FRONT END 500 HYD. FRONT END	KFH 400/500 KFH-F 400/500 KFH-G 400/500 KFH-NC 400/500 KFD 400/500/630/800 KFD-H 400/500 KFD-HF 400/500 KFD-HS 400/500 LVE 400/500/630/1000 KFL 500/630	THF 400-120 TH 400-120 THF 500-160 TH 500-160 TH 630-180 HSG 400-176 HSG 500-165 HSL 400-120 ROTA NC 400 ROTA NCD 400 ROTA NCF 400 ROTA NCO 400	HFK 400/500 HFKS 400/500 KDV 500 KDVG 500 KDM 500 KFV 400/500/630/800
			380 INTERNATIONAL 380 HIGH SPEED Q.C.			
IDN 500/630/800 IDL 500/630/800 GHDN 500/610/640/800 HDL 500/630/800 HDW/FC 500/630						

Serrated Diamond Soft Top Jaws



90° Serrations

**Material: 080M15 (En32)
Material: Aluminum HE30TF
Black Finish**

Techleader Part No.	A	B	C	D	K + J Bolt	Serrations	Weight Kg/Set
CM 16 STEEL	60	60	120	17	22 + 15 M12	1/16 X 90°	9.0
HL 16 ALUMINUM	64	64	120				3.2
CM 20 STEEL	76	64	150	17	22 + 15 M12	1/16 X 90°	14.0
HL 20 ALUMINUM	76	64	150				5.0
CM 25 STEEL	89	64	170	17	22 + 20 M12	1/16 X 90°	20.0
HL 25 ALUMINUM	89	64	170				7.0
CM 26 STEEL	89	64	170	21	28 + 20 M16	1/16 X 90°	20.0
HL 26 ALUMINUM	89	64	170				7.0
CM 32 STEEL	118	76	240	21	28 + 30 M16	1/16 X 90°	28.0
HL 32 ALUMINUM	118	76	240				10.0
CM 40 STEEL	152	76	280	25.5	M20		
HL 40 ALUMINUM	152	76	280				

Serrated Diamond Soft Top Jaws

To suit Autoblok, Forkardt, Gamet, Pratt Burnerd, Röhme, Schunk, SMW-Autoblok & SMW power chucks

AUTOBLOK	FORKARDT	GAMET	PRATT BURNERD	ROHM	SCHUNK	SMW
	3KGGH 160/175 KL 160, KSH 160 3KGGH 160/175 KS 160, KSPS 160 KG 160, KSF 175 UVE 160 KTG 160, KTN 160 3KTH 160-46/175-46 QLC 175		160 INTERNATIONAL (UP TO 89) 160 HIGH SPEED Q.C. (UP TO 89) 165 HYD. FRONT END	KFH 160, KFD 160 KFH-NC 160 KFH-F 160 KFH-G 160 KFD-HF 160 SPD 160 SPO 160	THF 165-37 TH 165-37 HSL 165-37 ROTA NC 165 ROTA NCF 160 ROTA NCO 165	HFS 160 HFKS 160 KDV 160 KDVG 160 KDV 160
IDN 200/220 IDL 200 HDN 200/220 HDL 200 GHDN 210 CD 200 GHD/FC 210 HDB 220	3KGGH 200, KL 200 3KGGH 200, KSF 200 KS 200, KSH 200 3KTGF 200, KSPS 200 UVE 200, KSHF 200 KG 200, KLNC 200 3NHF 200, KP 200 3NH 200 KTG 200, KTN 200 3KTH 200-66	MAC 200 MAC 220 DE 210	210 NEW INTERNATIONAL 210 NEW HIGH SPEED Q.C. 200 INTERNATIONAL (UP TO 89) 210 HYD. FRONT END 200 HIGH SPEED Q.C. (UP TO 89) 210 KB INTERNATIONAL 210 KB HIGH SPEED Q.C.	KFH 200 KFH-NC 200 KFH-F 200 KFH-G 200 KFH-HF 200 KDF 200 SPD 215 SPO 215	THF 210-52 TH 210-52 HSG 200-66 HSL 210-52 ROTA NC 210 ROTA NCF 210 ROTA NCD 210 ROTA NCO 200 TP 200	HFK 200 HFKS 200 KDV 200 KDVG 200 KDV 200
	QLC 210 KS 250 UVE 250 3NHF 250-65 3NHF 290-104 KL250 MO KS250 MO KSHF 250-55		254/265 NEW INTERNATIONAL 254 NEW HIGH SPEED Q.C. 250 HIGH SPEED Q.C. (UP TO 89) 265 KB INTERNATIONAL 265 KB HIGH SPEED Q.C.	KFL 250	HSG 250-91	KDV 250 KDVG 250
IDN 250 IDL 250 HDN 250 HDL 250 GHDN 250 GHD/FC 250 HDB 300 CD 250	KTG 250, KTN 250 3KTGF 250, KSH 250 KG 250, KP 250 3NHG 250, 3NH 250 3NHF 290, KLNC 250 KSHF 250, KL 250 KSPS 250 QLC 250	MAC 250 DE 250/260	250 INTERNATIONAL (UP TO 89) 254/305 HYD. FRONT END 305 NEW INTERNATIONAL 305 NEW HIGH SPEED Q.C. 305 KB INTERNATIONAL 305 KB HIGH SPEED Q.C.	KFH 250 KFH-NC 250 KFH-F 250 KFH-G 250 KFD 250 KFD-HF 250	THF 250-71 TH 250-71 HSL 250-71 ROTA NC 250 ROTA NCF 250 ROTA NCD 250 ROTA NCO 250 TP 250	HFK 250/270 HFKS 250 KDV 250 KDVG 250 KDV 250
IDN 315/400 IDL 315/400 HDN 315/400 HDL 315/400 GHDN 315/400 CD 315 GHD/FC 305/400	KS 315/400 KTG 315, KTN 315 3KTGF 315, KP 315 UVE 315, KSPS 300 KG 315, KLNC 315 3NHF 315, 3NH 315 KSH 315/400 KSHF 315/400 3NHF 400	MAC 315 DE 320	315 INTERNATIONAL (UP TO 89) 315/400 HIGH SPEED Q.C. (UP TO 89)	KFH 315 KFH-NC 315 KFH-F 315 KFH-G 315 KFD-HF 315 KFD-315 KFL 315 SPD 300 SPO 315	THF 315-86 TH 315-86 HSG 315-108 HSL 315-91 ROTA NC 315 ROTA NCD 315 ROTA NCF 315 ROTA NCO 315 TP 315	HFK 315 HFKS 315 KDV 315/400 KDVG 315/400 KDV 315/400
IDN 500/630/800 IDL 500/630/800 GHDN 500/610/640/800 ALD 400 AND 400	QLC315 KS 500/620 KSH 500 KTG 630, KSJHF 630 3KTGF 400/500 UVE 400/500/630/800 KTG 400/500 KTN 400/500 KG 400/500 3NHF 400/500/630 3NH 400/500/630 KL 400/500 KLNC 400/500/ KP 400 KT 400/800 KTF 400/500 QLC 400	DE 400	400 INTERNATIONAL (UP TO 89) 400 HYD FRONT END 500 HYD FRONT END	KFH 400/500 KFH-F 400/500 KFH-G 400/500 KFH-NC 400/500 KFD 400/500/630/800 KFD-H 400/500 KFD-HF 400/500 KKFD-HS 400/500 LVE 400/500/630/1000 KFL 500/630	THF 400-120 TH 400-120 THF 500-160 TH 500-160 TH 630-180 HSG 400-176 HSG 500-165 HSL 400-120 ROTA NC 400 ROTA NCD 400 ROTA NCF 400 ROTA NCO 400	HFK 400/500 HFKS 400/500 KDV 500 KDVG 500 KDM 500 KDV 400/500/630/800

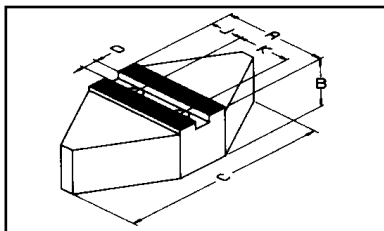
Serrated Diamond Soft Top Jaws

To suit Howa, Kitagawa, Matsumoto, Pratt Burnerd, Röhm & Schunk Power Chucks

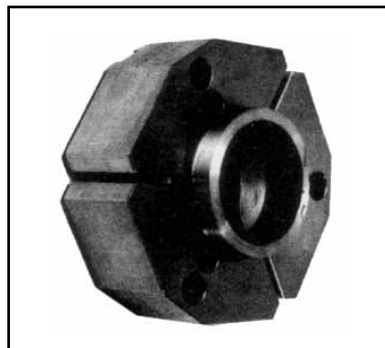
Techleader Part No.	A	B	C	D	K+J Bolt	SERRATIONS	WEIGHT KG/set	HOWA	KITAGAWA	MATSUMOTO MMK	PR11 BURNRED	Röhm	SCHUNK
CN 16 STEEL	60	60	120	12	20+15 M10	1.5 X 60°	9.0	HO1MA6 HO7MA6 HO15M6	AS-65 B-160 B-06	B206 HO-6 HOH-160	INTERNATIONAL 9821-21723 9821-31723	KFD-HE 170	HSL 165-37 ROTA NCK 165
HN16 ALUMINUM	64	64	120				3.2	HO22M6 HO27M6 HO37M6	HOB-6 HOS 6 N-160	HOH-6 HJA5-6 N-6	HIGH SPEED QUICK CHANGE 9121-21723 9121-31723		ROTA NC 165 ROTA NCK 165
*AKT6FG ALUMINUM	2"								HG738-165	BL-206			
CN 20 STEEL	76	64	150	14	25+15 M12	1.5 X 60°	14.0	HO7MA8 HO15M8	B200 B-08 N-200	B208 HOB-8 HOH-200	INTERNATIONAL 9821-32123 9821-42123	KFD-HE 210	HSL 210-52
HN 20 ALUMINUM	76	64	150				5.0		N-08 AS-210 HOS-8	HOH-8 NL-08 HOH 208	HIGH SPEED QUICK CHANGE 9121-32123 9121-42123 210 KB		ROTA NCK 210 ROTA NC 210 ROTA NCF 210
*AKT8FG ALUMINUM	2"								HJA6-8 HO-8	BB-08 BL-208 HG-715-210			
CN 25 STEEL	89	64	170	16	30+20 M12	1.5 X 60°	20.0	HO7MA10 HO15M10	B250 HOH-250 B210	B-10 BL 210 HOH-10	INTERNATIONAL 9821-42623 9821-52623	KFD-HE 254	HSL 250-71
HN 25 ALUMINUM	89	64	170				7.0		AS-250 N-10 HJA8-10	HOB-10 N-250 HJA6-10	HIGH SPEED QUICK CHANGE 9121-42623 9121-52623 265 KB		ROTA NCK 250 ROTA NC 250 ROTA NCF 250
*AKT10FG ALUMINUM	2"								HO-10 HG730 254	HOS-10 NL-10			
CN 32 STEEL	118	76	240	18	30+30 M14	1.5 X 60°	28.0	HO7MA12 HO15M12 HO27M10 HO37M10	B300 HOH-300 N-300	B-12 HOH-12 N-12	INTERNATIONAL 9821-53123 9821-63123		HSL 315-91
HN 32 ALUMINUM	118	76	240				10.0		HOS-12 HJA8-12 HJA6-12 HLA6-12 NL-12	HO-12 HOB-12 HLA8-15 HLA6-16	HIGH SPEED QUICK CHANGE 9121-53123 9121-63123 305 KB		
*AKT12FG ALUMINUM	2.5"									HA8-12 H-12 HH-12 HJ-12 ZA8-12-72 ZA8-12-85			
CN 33 STEEL	118	76	240	21	30+30 M16	1.5 X 60°	28.0		B212			KFD-HE 315	ROTA NCK 315 ROTA NC 315
HN 33 ALUMINUM	118	76	240				10.0						ROTA NCF 315
*AKT212FG ALUMINUM	2.5"												
CN 38 STEEL	152	76	280	22	43+37 M20	1.5 X 60°	48.0		B15				ROTA NC 400
HN 38 ALUMINUM	152	76	280				16.0		B18				ROTA NCF 400

*THESE JAWS ARE ALUMINUM PIE JAW, MADE FROM A ROUND EXTRUSION.

IMPORTANT: Allow for weight of Diamond Jaws at high R.P.M.'s as the grip loss due to the effect of centrifugal forces will be greater.



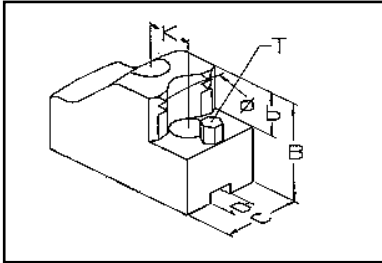
60° Serrations
Material: Steel: 080M15 (En32)
Aluminum: HE30TF



- Can be turned or bored to clamp entire circumference of workpiece
- Choice of steel or aluminum types
- Greater flexibility than pie jaws, can be reversed
- Aluminum diamond jaws - less weight for higher spindle speeds
- Helps stop distortion of thin walled components
- Can be machined to suit irregular parts

Adjustagrip Hard Top Jaws

To Suit Howa, Kitagawa & Matsumoto Power Chucks



To suit power chucks
60° Serrations
External Ø Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	CHUCK TYPES – GRIPPING RANGE								
										HOWA			KITAGAWA			MATSUMOTO (MMK)		
										H07MA	H027M	H037M	BA/H0B/H0H	B200	NL	N/NA	H/HA	ZA
LA 03	49	40	12	20	20	M6	1.5 X 60°	1.7	165	26-49	26-44	26-44		26-47	30-46	26-46		
LA 04								1.4		39-69	32-63	41-63	31-62	37-67	46-65	45-65		
LA 06								1.4		52-83	50-77	55-77	50-77	50-81	63-80	59-79		
LA 07								1.4		66-98	64-92	69-92	64-91	64-96	77-94	73-94		
LA 09								1.2		82-114	74-108	85-108	73-108	80-112	93-111	90-110		
LB 03	49	40	14	25	20	M6	1.5 X 60°	1.9	210	37-75	*26-71	*28-71	25-65	31-68	44-67	42-69	40-71	31-74
LB 06								1.8		66-102	*55-99	*57-99	54-93	60-96	72-98	69-97	69-99	60-101
LB 09								1.7		94-132	*82-128	*85-128	81-121	87-125	97-125	97-126	97-128	88-130
LB 12								1.7		121-159	*108-155	*111-155	108-149	114-152	125-151	125-152	124-155	115-158
LC 04	59	40	16	30	25	M8	1.5 X 60°	2.9	254/	40-100	*41-90	*48-86	41-81	44-85	43-83	42-91	52-92	43-88
LC 08								2.7	305	77-141	*78-130	*86-128	78-121	82-125	80-123	79-131	89-132	80-128
LC 13								2.6		120-185	*121-174	*128-172	121-165	125-169	123-167	122-175	133-176	123-171
LC 17								2.6		163-229	*164-218	*172-214	164-209	168-212	166-211	165-219	176-220	166-215
LD 05	59	50	18	30	25	M8	1.5 X 60°	4.5	304	53-128	*44-119	*54-119	46-114		55-119	51-117	50-126	55-127
LD 11								3.5		109-188	*97-179	*111-179	102-174		112-179	107-177	107-186	112-187
LD 17								3.1		173-253	*160-244	*175-244	165-239		176-244	171-241	170-251	176-252
LD 23								3.5		236-316	*223-307	*238-307	228-302		239-307	234-305	233-314	239-315
LE 05	59	50	21	30	25	M8	1.5 X 60°	4.4	304		†43-114	†50-114		48-112				
LE 10								3.4			†91-171	†104-171		102-168				
LE 16								3.0			†154-236	†167-236		165-233				
LE 23								3.4			†221-303	†234-303		232-300				
LF 05	79	60	22	43	33	M8	1.5 X 60°	9.3	380				50-108					
LF 10								8.3					99-162					
LF 16								6.0					160-224					
LF 22								5.6					220-285					
LF 28								6.0					279-345					
LF 34								7.8					339-404					

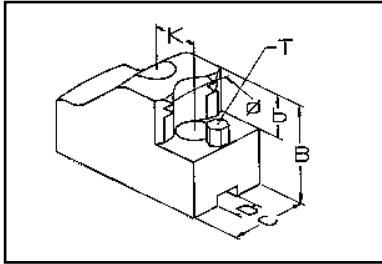
* For the jaws in these ranges to fit, special T-Nuts are required. Types GA08, GA10 & GA12.

† For the jaws in these ranges, standard T-Nuts must be split

Adjustagrip Jaws are available on request in special sizes or to suit other chuck types.

Adjustagrip Hard Top Jaws

To Suit Pratt Burnerd, Schunk & SMW-Autoblok Power Chucks



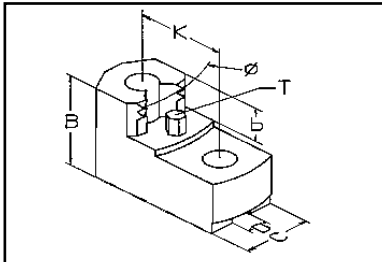
To suit power chucks
60° Serrations
External Ø Clamping Type
Material: Steel: 590M17

CHUCK TYPES – GRIPPING RANGE

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	PRATT BURNERD				SCHUNK		SMW - AUTOBLOK				
										INT'L KB	HSQC KB	INTERNATIONAL	HSQC	HSL	ROTA NCK	BB-M	BH-M	AL-M	AN-M	
LA 03 LA 04 LA 06 LA 07 LA 09	49	40	12	20	20	M6	1.5 X 60°	1.7 1.4 1.4 1.4 1.2	150	27-37 36-56 50-71 64-85 80-102										
LA 03 LA 04 LA 06 LA 07 LA 09	49	40	12	20	20	M6	1.5 X 60°	1.7 1.4 1.4 1.4 1.2	165/ 170/ 175	34-49 53-68 67-83 82-98 97-114		24-46 41-65 55-80 69-94 85-111	30-64 50-78 64-92 72-109	34-59 53-78 67-93 81-108 98-124	26-47 35-67 50-81 71-96 80-112	33-64 52-83 66-98 80-112 97-129	27-52 41-71 55-86 69-101 85-117	27-54 45-79 58-88 73-103 89-119	27-52 43-71 56-86 70-100 87-117	
LA 03 LA04 LA 06 LA 07 LA 09	49	40	12	20	20	M6	1.5 X 60°	1.7 1.4 1.4 1.4 1.2	210	62-88 82-107 96-122 111-137 127-153										
LB 03 LB 06 LB 09 LB 12	49	40	14	25	20	M6	1.5 X 60°	1.9 1.8 1.7 1.7	210		38-68 66-96 94-125 121-153	39-69 68-97 96-126 123-153	25-72 50-100 75-129 102-157	45-79 73-106 101-135 129-163	33-98 62-125 90-154 116-182	46-76 74-103 102-132 130-160	32-75 60-102 88-132 115-159	45-77 74-105 102-134 129-162	42-74 70-101 98-130 125-158	
LC 04 LC 06 LC 08 LC 10 LC 13 LC 15 LC 17	59	40	16	30	25	M8	1.5 X 60°	2.9 2.9 2.7 2.7 2.6 2.6 2.6	254/ 265/ 305	58-100 97-140 140-185 184-228	39-103 69-143 112-188 155-231	43-84 80-124 123-168 166-212	38-91 60-131 102-175 145-219	49-98 87-138 125-202 174-226	45-117 82-158 140-167 168-246	58-83 78-103 97-123 117-143 140-167 160-187 184-210	48-82 68-102 86-122 106-142 130-166 150-186 173-209	53-87 73-107 92-128 112-148 135-172 155-192 179-215	49-83 69-103 87-123 107-143 131-167 151-187 174-210	
LD 05 LD 11 LD 17 LD 23	59	50	18	30	25	M8	1.5 X 60°	4.5 3.5 3.1 3.5	304/ 305/ 315	61-118 118-180 180-245 245-307	44-125 88-185 147-250 210-314	57-124 114-184 178-249 241-312		67-138 125-198 189-263 252-327	61-160 119-220 183-286 246-349					
LE 05 LE 07 LE 10 LE 13 LE 16 LE 20 LE 23	59	50	21	30	25	M8	1.5 X 60°	4.4 4.0 3.4 3.2 3.0 3.2 3.4	304/ 315							89-125 117-153 145-181 175-211 210-246 243-279 277-314	60-126 115-182 179-246 246-315	54-131 109-187 172-252 239-320	49-124 103-181 166-246 233-313	
LF 05 LF 10 LF 16 LF 22 LF 28 LF 34	79	60	22	43	33	M8	1.5 X 60°	9.3 8.3 6.0 5.6 6.0 7.8	380		59-117 110-171 171-234 232-295 291-354 350-414	47-117 82-171 137-234 197-295 255-354 315-414								

Adjustagrip Hard Top Jaws

To Suit Howa, Kitagawa & Matsumoto Power Chucks



To suit power chucks
60° Serrations
Internal Ø Clamping Type
Material: Steel: 590M17

CHUCK TYPES – GRIPPING RANGE

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	GRIPPING RANGE								
										HOWA			KITAGAWA			MATSUMOTO (MMK)		
										H07MA	H027M	H037M	BA/HOB/HOH	B200	NL	N/NA	H/HA	ZA
MA 05	49	40	12	20	20	M6	1.5 X 60°	1.5	165	45-71		45-65		45-69	51-67	47-67		
MA 06								1.4		51-82	47-76	54-76	47-76	49-80	62-80	58-78		
MA 07								1.3		70-102	67-96	72-96	67-95	68-99	80-101	77-99		
MA 09								1.1		92-124	83-118	95-118	83-117	90-122	101-121	99-120		
MB 06	49	40	14	25	20	M6	1.5 X 60°	1.9	210	55-92	*50-88	*50-88	50-82	50-85	61-89	59-89	58-88	50-91
MB 08								1.8		84-122	*72-118	*75-118	72-112	78-115	89-120	80-120	87-120	78-120
MB 11								1.7		117-155	*105-151	*108-151	104-145	110-148	120-152	120-151	120-151	111-155
MB 14								1.7		146-185	*134-181	*137-181	133-174	139-178	152-177	151-177	149-181	140-184
MC 06	59	40	16	30	25	M8	1.5 X 60°	2.7	254/	56-119	*57-109	*65-105	57-100	61-103	59-102	58-109	68-111	59-107
MC 10								2.5	265/	95-159	*96-149	*104-145	96-140	100-143	98-142	97-149	108-151	98-147
MC 14								2.3	305	136-201	*137-190	*145-186	137-181	140-185	139-183	138-191	149-192	139-188
MC 18								2.2		175-240	*176-230	*184-226	176-221	180-224	178-223	177-231	188-232	178-228
MD 08	59	50	18	30	25	M8	1.5 X 60°	3.9	304	81-159	*74-150	*83-150	74-145		84-150	79-148	79-157	83-158
MD 14								3.0		142-221	*129-212	*144-212	134-207		145-212	140-210	139-219	144-220
MD 20								3.0		203-283	*189-273	*204-273	195-269		205-274	200-271	200-280	205-281
ME 08	59	50	21	30	25	M8	1.5 X 60°	3.9	304		†74-148	†80-148		78-145				
ME 14								3.0			†131-212	†144-212		142-209				
ME 20								3.0			†189-271	†203-271		201-269				
MF 10	79	60	22	43	33	M8	1.5 X 60°	8.8	380				100-162					
MF 16								7.1					160-224					
MF 22								4.1					222-287					
MF 28								4.1					280-345					

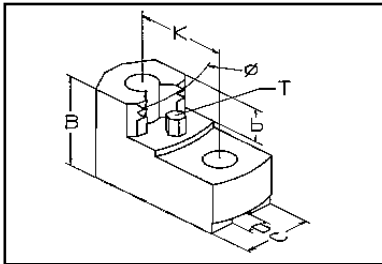
* For the jaws in these ranges to fit, special T-Nuts are required. Types GA08, GA10 & GA12.

† For the jaws in these ranges, standard T-Nuts must be split

Adjustagrip Jaws are available on request in special sizes or to suit other chuck types.

Adjustagrip Hard Top Jaws

To Suit Pratt Burnerd, Schunk & SMW-Autoblok Power Chucks



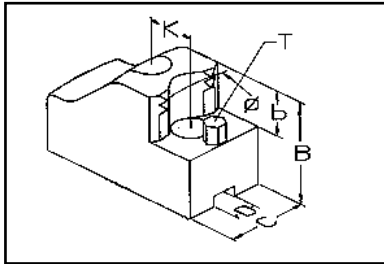
To suit power chucks
60° Serrations
Internal Ø Clamping Type
Material: Steel: 590M17

CHUCK TYPES – GRIPPING RANGE

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	CHUCK TYPES – GRIPPING RANGE										
										PRATT BURNERD				SCHUNK		SMW - AUTOBLOK				
										INT'L. KB	HSQC KB	INTERNATIONAL	HSQC	HSL	ROTA NCK	BB-M	BH-M	AL-M	AN-M	
MA 05 MA 06 MA 07 MA 09	49	40	12	20	20	M6	1.5 X 60°	1.5 1.4 1.3 1.1	150	46-58 48-70 68-89 89-111										
MA 05 MA 06 MA 07 MA 09	49	40	12	20	20	M6	1.5 X 60°	1.5 1.4 1.3 1.1	165/ 170/ 175	55-70 66-83 83-101 108-124		45-67 54-79 73-98 95-120	47-77 67-96 82-119	55-80 66-92 85-111 107-134	47-80 68-99 84-116 75-122	54-85 65-97 84-116 104-139	46-73 54-85 72-104 95-127	47-75 58-87 76-107 99-129	46-73 55-85 74-104 96-126	
MA 05 MA 06 MA 07 MA 09	49	40	12	20	20	M6	1.5 X 60°	1.5 1.4 1.3 1.1	210	84-109 95-121 115-141 137-163										
MB 06 MB 08 MB 11 MB 14	49	40	14	25	20	M6	1.5 X 60°	1.9 1.8 1.7 1.7	210		55-85 85-115 115-149 147-178	57-86 86-119 119-149 148-179	50-89 68-119 98-153 127-182	62-96 92-126 125-159 154-189	51-114 80-144 113-178 142-207	63-93 93-123 126-155 155-186	51-92 79-122 111-155 140-185	63-94 92-125 125-158 155-187	59-90 89-121 121-154 151-183	
MC 06 MC 08 MC 10 MC 12 MC 14 MC 16 MC 18	59	40	16	30	25	M8	1.5 X 60°	2.7 2.5 2.5 2.4 2.3 2.3 2.2	250/ 254/ 265	75-119 115-159 156-201 195-240	54-122 87-162 128-203 167-243	59-103 98-143 139-184 178-224	54-110 77-150 117-191 157-231	66-117 105-157 142-218 186-238	62.137 100-177 142-218 181-258	75-101 95-121 115-141 135-161 155-183 175-201 196-222	65-100 85-120 104-140 124-160 145-182 165-200 185-221	71-106 91-126 110-146 130-161 151-188 171-195 191-227	66-101 86-121 105-141 125-162 146-183 166-201 186-222	
MD 08 MD 14 MD 20	59	50	18	30	25	M8	1.5 X 60°	3.9 3.0 3.0	304/ 305/ 315	91-151 151-212 212-273	74-156 116-218 176-280	86-155 147-217 207-278		97-170 158-232 219-293	90-192 151-254 212-316					
ME 08 ME 10 ME 14 ME 18 ME 20 ME 24	59	50	21	30	25	M8	1.5 X 60°	3.9 3.5 3.0 3.0 3.0 3.1	315						122-158 154-190 186-222 215-251 245-282 275-312	92-159 156-223 215-283	85-164 149-228 208-288	79-158 143-222 201-282		
MF 10 MF 16 MF 22 MF 28	79	60	22	43	33	M8	1.5 X 60°	8.8 7.1 4.1 4.1	380			101-171 171-234 234-297 291-354	96-171 137-234 199-299 256-355							

Adjustagrip Hard Top Jaws

To Suit Autoblok Power Chucks

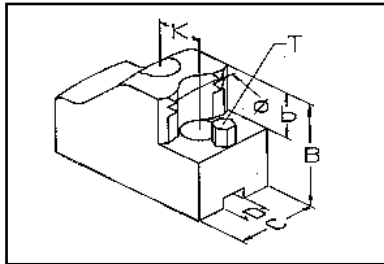


To suit power chucks
90° Serrations
External Ø Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	CHUCK TYPES – GRIPPING RANGE				
										AUTOBLOK				
										IDN/HDN	GDN	GHD/FC	BHD	BBD
IB 03	49	40	17	22	20	M6	1/16"X90°	2.7	200/210					
IB 04								2.3		33-68	34-71	34-71	34-70	41-73
IB 05								2.1		59-96	60-98	60-98	55-97	68-100
IB 08								2.1		86-125	88-127	88-127	82-126	96-129
IB 11								2.0		115-154	116-157	116-157	111-156	125-158
IB 14								1.9		144-184	146-186	146-186	140-185	155-188
IB 03	49	40	17	22	20	M6	1/16"X90°	2.7	220/250					
IB 04								2.3		37-85				
IB 05								2.1		64-113				
IB 08								2.1		92-142				
IB 11								2.0		121-172				
IB 14								1.9		150-202				
IC 04	59	50	21	25	25	M8	1/16"X90°	3.9	250					
IC 05								3.3		45-98	44-96	44-96	45-94	54-98
IC 08								2.7		88-143	87-141	87-141	89-139	98-140
IC 13								2.4		137-194	136-191	136-191	138-189	147-190
IC 18								2.8		188-245	187-243	187-243	188-241	198-242
IC 04	59	50	21	25	25	M8	1/16"X90°	3.9	250/305			50-110		
IC 05								3.3			52-97			
IC 08								2.7			96-145	105-190		
IC 13								2.4			145-195	155-242		
IC 18								2.8			195-244	206-293		
IC 04	59	50	21	25	25	M8	1/16"X90°	3.9	315	50-125	50-120		50-118	66-117
IC 05								3.3						100-152
IC 08								2.7		110-206	115-200		117-198	146-197
IC 13								2.4		160-257	165-252		167-250	196-249
IC 18								2.8		211-309	216-303		218-301	248-300
IC 04	59	50	21	25	25	M8	1/16"X90°	3.9	400	65-208		65-208		
IC 05								3.3						
IC 08								2.7		145-288		145-288		
IC 13								2.4		195-340		195-340		
IC 18								2.8		247-392		247-392		
ID 06	79	60	25.5	35	33	M8	3/32"X90°	9.0	500			90-244		
ID 13								6.3				175-333		
ID 21								4.8				261-420		
ID 30								6.6				350-509		
ID 06	79	60	25.5	35	33	M8	3/32"X90°	9.0	630			91-246		
ID 13								6.3				175-462		
ID 21								4.8				261-549		
ID 30								6.6				350-639		

Adjustagrip Hard Top Jaws

To Suit Schunk & SMW-Autoblok Power Chucks



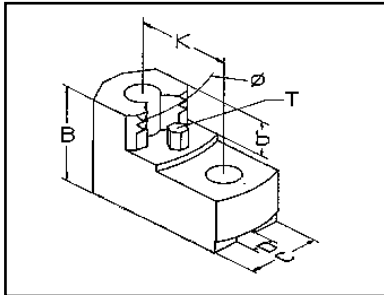
To suit power chucks
90° Serrations
External Ø Clamping Type
Material: Steel: 590M17

CHUCK TYPES – GRIPPING RANGE

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	SCHUNK						SMW - AUTOBLOK			
										SCHUNK		SCHUNK				SMW - AUTOBLOK		SMW - AUTOBLOK	
										TH-THF	HGS	HSL	ROTA NC/INCF	HFK/HFKS	AN-D	AL-D			
IA 03	49	40	17	19	20	M6	1/16" X 90°	1.8	160/165/200	41-76	67-113	45-72	36-64	39-63					
IA 05								1.4		60-95	86-132	64-91	55-83	58-82					
IA 07								1.5		81-118	109-154	86-114	76-106	79-104					
IA 09								1.6		103-140	131-177	108-136	89-128	101-126					
IA 11								1.5		125-162	153-200	130-158	120-150	123-149					
IA 03	49	40	17	19	20	M6	1/16" X 90°	1.8	200/210/250		95-142	59-104		47-97					
IA 05								1.4			114-161	78-123		66-116					
IA 07								1.5			136-183	100-146		88-138					
IA 09								1.6			158-206	122-168		110-161					
IA 11								1.5			181-228	145-191		132-183					
IB 03	49	40	17	22	20	M6	1/16" X 90°	2.7	200/210	34-77			35-69	35-59	35-62				
IB 04								2.3		39-89			44-81	38-70	41-74				
IB 05								2.1		66-116			71-108	65-97	68-101				
IB 08								2.1		94-145			99-137	92-126	96-130				
IB 11								2.0		123-175			128-166	121-156	125-160				
IB 14								1.9		152-205			158-196	151-185	155-189				
IC 04	59	50	21	25	25	M8	1/16" X 90°	3.9	250	34-83		35-75	35-75	34-63	35-60	35-65			
IC 05								3.3		52-118		51-110	49-110	51-97	51-94	55-99			
IC 08								2.7		96-163		95-155	93-155	95-142	94-139	99-144			
IC 11								2.5						120-167	120-164	125-169			
IC 13								2.4		145-214		144-206	142-206	144-193	144-190	149-195			
IC 16								2.6						170-219	170-216	175-220			
IC 18								2.8		196-265		195-257	193-257	195-244	195-241	200-246			
IC 04	59	50	21	25	25	M8	1/16" X 90°	3.9	315	49-136	60-135	46-126	41-135	37-126	35-116	39-122			
IC 05								3.3		82-172	94-170	78-161	72-170	68-161	64-151	70-158			
IC 08								2.7		127-217	139-216	123-206	117-215	113-206	108-197	114-203			
IC 13								2.4		177-268	190-267	174-257	167-267	163-257	158-248	165-254			
IC 18								2.8		229-320	241-319	225-309	218-318	214-309	209-299	216-306			
ID 06	79	60	25.5	35	33	M8	3/32" X 90°	9.0	400	69-154	64-157		60-162	61-155	62-134	66-139			
ID 08								7.4							105-177	109-182			
ID 13								6.3		153-242	148-245		143-249	144-243	145-221	150-227			
ID 18								5.4							187-263	192-269			
ID 21								4.8		238-329	233-332		228-336	229-330	230-308	236-314			
ID 25								5.2							275-353	280-360			
ID 30								6.6		327-418	322-421		317-426	318-419	319-397	324-403			
ID 06	79	60	25.5	35	33	M8	3/32" X 90°	9.0	500	115-272	96-247		111-259	98-249					
ID 13								6.3		202-360	182-336		198-347	185-337					
ID 21								4.8		289-447	268-423		284-435	271-424					
ID 30								6.6		378-537	357-512		373-524	360-514					

Adjustagrip Hard Top Jaws

To Suit Autoblok Power Chucks

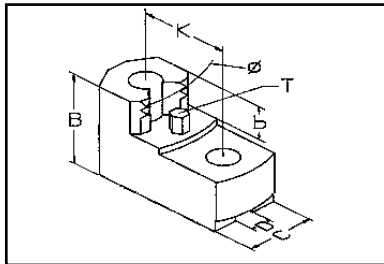


To suit power chucks
90° Serrations
Internal Ø Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	CHUCK TYPES – GRIPPING RANGE				
										AUTOBLOK				
										IDN/HDN	GHDN	GHD/FC	BHD	BBD
JB 06	49	40	17	22	20	M6	1/16"X90°	1.8	200/210	62-101	64-103	64-103	58-102	72-105
JB 09								1.8		94-133	95-135	95-135	89-134	104-137
JB 12								1.7		125-164	126-166	126-166	120-165	135-168
JB 06	49	40	17	22	20	M6	1/16"X90°	1.8	220/250	68-118				
JB 09								1.8		100-150				
JB 12								1.7		131-182				
JC 08	59	50	21	25	25	M8	1/16"X90°	3.9	250	81-117	81-114	81-114	81-114	81-113
JC 10								2.8		114-170	113-168	113-168	114-166	124-167
JC 15								2.6		165-222	163-219	163-219	165-217	175-218
JC 08	59	50	21	25	25	M8	1/16"X90°	3.9	250/305		81-115	81-164		
JC 10								2.8			122-169	132-218		
JC 15								2.6			173-220	183-269		
JC 08	59	50	21	25	25	M8	1/16"X90°	3.9	315	83-180	88-174		89-172	119-173
JC 10								2.8		137-233	142-228		144-226	173-225
JC 15								2.6		188-285	192-279		194-277	224-276
JC 08	59	50	21	25	25	M8	1/16"X90°	3.9	400	118-263		118-263		
JC 10								2.8		172-316		172-316		
JC 15								2.6		223-368		223-368		
JD 10	79	60	25.5	35	33	M8	3/32"X90°	8.6	500			135-291		
JD 17								6.7				212-370		
JD 25								4.0				291-450		
JD 10	79	60	25.5	35	33	M8	3/32"X90°	8.6	630			135-420		
JD 17								6.7				212-499		
JD 25								4.0				291-579		

Adjustagrip Hard Top Jaws

To Suit Schunk & SMW-Autoblok Power Chucks

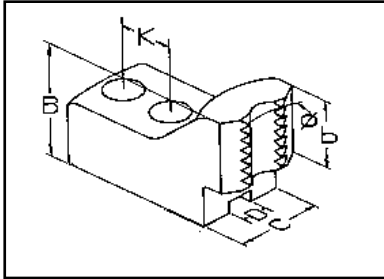


To suit power chucks
90° Serrations
Internal Ø Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	b	T	Serrations	Weight Kg/Set	Chuck Ø	CHUCK TYPES – GRIPPING RANGE						
										SCHUNK			SMW - AUTOBLOK			
										TH-THF	HGS	HSL	ROTA NC/INCF	HFK/HFKS	AN-D	AL-D
JA 05 JA 07 JA 09 JA 11	49	40	17	19	20	M6	1/16" X 90°	1.7 1.6 1.5 1.5	160/165/200	61-97 83-120 104-141 125-162	88-134 110-156 132-178 153-200	66-93 88-115 109-137 130-158	57-85 78-107 99-129 120-150	59-84 81-106 102-127 123-149		
JA 05 JA 07 JA 09 JA 11	49	40	17	19	20	M6	1/16" X 90°	1.7 1.6 1.5 1.5	200/210/250		115-163 138-185 159-207 181-228	80-125 102-148 123-169 145-191		68-118 90-140 111-162 132-183		
JB 06 JB 09 JB 12	49	40	17	22	20	M6	1/16" X 90°	1.8 1.8 1.7	200/210	70-121 102-153 133-185			75-113 107-145 138-176	68-102 100-134 131-165	72-106 104-138 134-169	
JC 08 JC 09 JC 10 JC 12 JC 15	59	50	21	25	25	M8	1/16" X 90°	3.9 3.1 2.8 2.6 2.6	250	81-136 122-190 172-241		81-128 121-182 171-233	81-128 119-182 169-233	81-120 120-172 172-221	81-112 101-144 121-166 156-191 171-217	81-117 101-149 126-171 161-196 176-222
JC 08 JC 10 JC 15	59	50	21	25	25	M8	1/16" X 90°	3.9 2.8 2.6	315	100-191 154-244 205-296	112-190 166-243 218-295	96-180 150-234 201-285	90-190 144-243 195-295	85-180 139-234 190-285	81-170 135-224 186-276	87-177 141-230 192-282
JD 10 JD 17 JD 25	79	60	25.5	35	33	M8	3/32" X 90°	8.6 6.7 4.0	400	113-201 189-279 267-359	108-203 184-282 262-361		103-208 179-287 257-366	104-202 180-280 259-360	105-180 181-258 259-337	110-185 186-264 265-343
JD 10 JD 17 JD 25	79	60	25.5	35	33	M8	3/32" X 90°	8.6 6.7 4.0	500	161-318 239-397 318-477	141-294 219-373 298-453		157-306 234-385 313-464	144-295 221-374 300-454		

Adjustagrip Jaws are available on request in special sizes or to suit other chuck types.

Hard Top Bar Jaws



60° Serrations
Bar Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	Serrations	Weight Kg/Set
KK 16	39	35	12	20	1.5" X 60°	1.5
KK 20	49	40	14	25		2.2
KK 25	49	40	16	30		2.3
KK 32	49	50	18	30		3.7
KK 33	49	50	21	30		3.7

CHUCK TYPES - GRIPPING RANGE

Techleader Part No.	CHUCK Ø	HOWA			KITAGAWA			MATSUMOTO (MMK)		
		H07MA	H027M	H037M	BA/H0B/H0H	B200	NL	N/NA	H/HA	ZA
KK 16	165	13-35	*13-29	*13-29	13-29	13-33	16-32	13-31		
KK 20	210	17-51	*16-48	*16-48	16-41	16-45	16-44	20-44	19-48	22-51
KK 25	254/305	23-81	*23-70	*28-66	23-62	25-65	24-63	23-71	39-72	25-51
KK 32	304		*27-91	*29-91	27-86		29-91	27-89	27-87	33-98
KK 33	304		*27-91	*29-91		27-88				

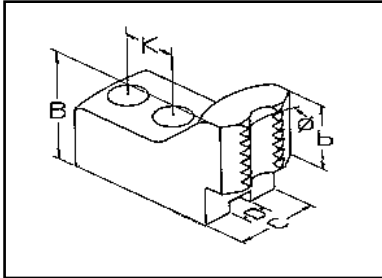
* For the jaws in these ranges to fit, special T-nuts are required Types GA08, GA10 & GA12.

CHUCK TYPES - GRIPPING RANGE

Techleader Part No.	CHUCK Ø	PRATT BURNERD				SCHUNK		SMW-AUTOBLOK			
		INT'L	HSQC	INT'L KB	HSQC KB	HSL	ROTA NCK	BB-M	BH-M	AL-M	
KK 16	150/165/175	13-31	13-30	13-23		20-45	14-33	18-50	13-38	13-40	13-37
KK 20	210	18-45	16-49	48-74	16-45	22-55	16-74	23-52	16-51	23-54	20-50
KK 25	250/254/265/305	33-65	23-71	38-81	23-83	29-79	26-98	38-63	29-62	34-68	30-63
KK 32	304/305/315	30-96	27-97	34-90	27-97	39-90	34-132				
KK 33	315							65-101	37-102	32-107	28-101

Adjustagrip Jaws are available on request in special sizes or to suit other chuck types.

Hard Top Bar Jaws



90° Serrations
Bar Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	Serrations	Weight Kg/Set
KJ 16	39	40	17	19	1/16" X 90°	1.6
KJ 20	49	40	17	22		2.0
KJ 26	49	50	21	25		2.5
KJ 32	49	50	21	25		3.0
KJ 40	59	60	25.5	35	3/32" X 90°	6.0

CHUCK TYPES - GRIPPING RANGE

Techleader Part No.	CHUCK Ø	AUTOBLOK					BERG		ROHM	
		IDN/HDN	GHDN	GHD/FC	BHD	BBD	HES	HESF	KFD	
KJ 16	160/165/175						14-23		14-40	25-71
KJ 20	200/210/250	21-52	19-54	19-54	25-56	19-53	19-38	19-41	19-56	21-94
KJ 26	250/305/315	23-73	28-71	28-71	30-70	23-69	22-64	22-69	24-80	
KJ 32	315/400	36-100	39-100	39-100	67-110	41-110		38-110	30-110	30-110
KJ 40	400/500/600	66-150		50-150			40-90	40-90	40-110	40-110

CHUCK TYPES - GRIPPING RANGE

Techleader Part No.	CHUCK Ø	FORKARDT						PRATT BURNERD	
		KS	KT	KTH	KTGF	NH/NHF	QLC	HS QUICK	
KJ 16	160/165/175	14-26	15-29	24-49		25-40	18-55		
KJ 20	200/210/250	19-40	19-42	27-64	27-64	19-55	33-89	19-56	
KJ 26	250/305/315		22-63		22-63	22-63	28-76		
KJ 32	315/400	29-110	29-110		29-110	31-110	33-128	29-110	
KJ 40	400/500/600	40-150	40-95		40-95	40-100	40-96		

CHUCK TYPES - GRIPPING RANGE

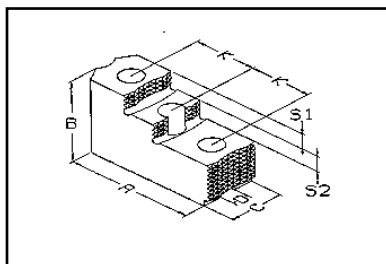
Techleader Part No.	CHUCK Ø	SCHUNK				SMW AUTOBLOK		
		TH/THF	HSG	HSL	Rota NC/NCF	AL-D	AN-D	
KJ 16	160/165/175	23-59	49-96	27-55	18-47	29-60		
KJ 16	200/210/250		77-125	41-87				
KJ 20	200/210/250	23-72			27-64	26-54	25-57	21-53
KJ 26	250/305/315	28-93		27-85	26-85	34-72	30-74	27-69
KJ 32	315/400	50-110	61-137	46-127	41-137	37-110	39-124	34-118
KJ 40	400/500/600	72-110	40-112			57-110	40-95	40-90
KJ 40	500		54-202					

Adjustagrip Jaws are available on request in special sizes or to suit other chuck types.

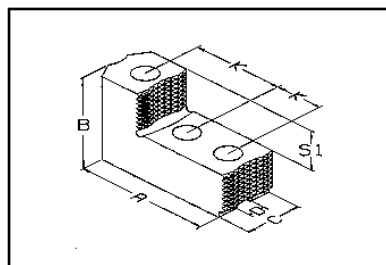


Serrated Hard Top Jaws

To Suit Autoblok & SMW Autoblok Power Chucks



TYPE A



TYPE B

90° Serrations

Reversible Type
Material: Steel: 590M17 or 080M15

Techleader Part No.	A	B	C	D	K	S1	S2	Serrations	Type	Autoblok SMW-Autoblok
GR 20	76	44	32	14	22	24		1/16"X90°	B	IDN 170 HDN 170 GHDN 165 GHD/FC 165 AND 165 ALD 165
GY 16	67	44	35	17	19	10	10	1/16"X90°	A	IDN 200/220
GY 20	74	49	40			12	12			IDL 200 HDN 200/220 HDL 200 GHDN 210 CD 200 GHD/FC 210 HDB 220 BHD 210 BHD/FC 210 BBD 210 AND 210 ALD 210
GY 25	104	59	50	21	25	14	14	1/16"X90°	A	IDN 250/315/400 IDL 250/315/400 HDN 250/315/400 HDL 250/315/400 GHDN 250/315/400 CD 250/315 HD/FC/250/350/400 HDB 300
GY 40	126	75	60	25.5	31	18	18	3/32"X90°	A	IDN 500/630/800 IDL 500/630/800 GHDN 500/610 GHDN 640/800 ALD 400 AND 400

To Suit Gamet Power Chucks

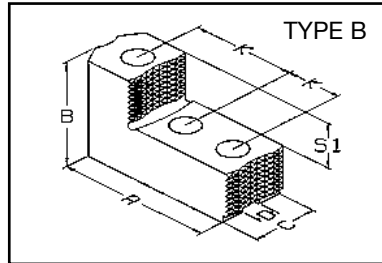
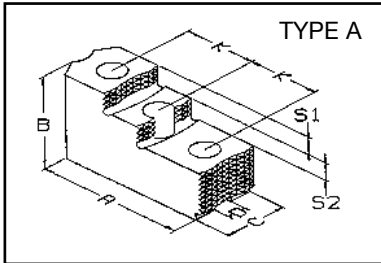
Techleader Part No.	A	B	C	D	K	S1	S2	Serrations	Type	GAMET		
GR 16	65	35	29	11	18.5	17		1/16" X 90°	B	160N	160MO	160GO
GR 20	76	44	32	14	22	24			B	215N	215MO	215GO
GR 28	94	51	44	20	28	24			B	250/280N	280MO	280GO
GR 35	128	65	50	21	40	28			B	350N	350MO	350GO

Serrated Hard Top Jaws

To suit Forkardt, Gamet, Pratt Burnerd, Rohm, Schunk & SMW Power Chucks

FORKARDT	GAMET	PRATT BURNERD	ROHM	SCHUNK	SMW
	MAC 165				
3KGF 160/175/200 3KGF 160/175/200 QLC 175 KTG 160/200 3KTGF 200 KTN 160/200 KS 160/200/250 KL 160/200 KSHF 200 KSPS 160/200 KP 200 KSF 175/200 KG 200 UVE 160/200/250 3NH 200 3NHF 200 KSH 160/200 KLNC 200 KT 160/200 KTF 200 KTH 200/250/315 QLC 210	MAC 200 MAC 220 DE 210 GA 210	160 INTER. (UP TO 89) 160 HIGH SPEED Q.C. (UP TO 89) 165 HYD. FRONT END 210 INTER. 210 HIGH SPEED Q.C. 200 INTER. (UP TO 89) 200 HIGH SPEED Q.C. (UP TO 89) 210 HYD. FRONT END 250 HIGH SPEED Q.C. (UP TO 89) 254 INTER. 265 HIGH SPEED Q.C.	KFH 160/200 KFH-NC 160/200 KFH-F 160/200 KFH-G 160/200 KFD-HF 160/200 KFD-HE 160/200 KFD-HS 200/250 KFD 160/200/250 SPD 160/215 SPO 160/215 KFD-AF 160/200 KFL 250	THF 165-37 TH 165-37 THF 210-52 TH 210-52 HSL 165-37 HSG 200-37 HSL 210-52 HSG 250-91 ROTA NC 165 ROTA NCF 160 ROTA NCO 165 ROTA NC 210 ROTA NCF 200 ROTA NCO 200	HKF 160/200 HFKS 160/200 KDV 160/200/250 KDBG 160/200/250 KDS 160/200 KDM 160/200 KDM-F 160/200/250 KMA 160/200/250 KMA-F 160/200/250 KJV 160/200 SP 200 KFMF 160/200 KDS 160/200
KS 315/400 KG 250/315 KSH 250/315/400 KP 250/315 KT 250/315 3KTGF 250 UVE 315 KSHF 200/315/400 KTG 250/315 KTF 250/315 KLNC 250/315 KTN 250/315 3NHF 250/315 3NH 250/315 3NHF 290 3NHF 400 (INDEX) KL 250 KSPS 250/300 QLC 250/315	MAC 250 MAC 315 DE 250/260/320 GA 250/315	250 INTER. (UP TO 89) 254 HYD. FRONT END 305 HYD. FRONT END 305 INTER. 305 HIGH SPEED Q.C. 315 INTER. (UP TO 89) 400 HIGH SPEED Q.C. (UP TO 89)	KFH 250/315 KFH-NC 250/315 KFH-F 250/315 KFH-G 250/315 KFD-HF 250/315 KFD 250/315 KFD-HF 250/315 KFD-HE 250/315 KFD-HS 315 KFD-AF 250/315 LVE 305 SPO 300 SPD 300	THF 250-71 TH 250-71 THF 315-86 TH 315-86 HSG 315-108 HSL 250-71 HSL 315-91 ROTA NC/250/315 ROTA NCD/250/315 ROTA NCF/250/315 ROTA NCO/250/315	HKF 250/315 HFKS 250/315 KDV 315/400 KDBG 315/400 KDS 250 KDM 250/315/400 KDM-F 315/400 KMA 315/400 KMA-F 315
KS 500/630 KSH 500 KSL 630 KSHF 630 KT 400/500/630 3KTGF 400/500 UVE 400/500/630/800 KTG 400/500 KTN 400/500 KG 400/500 3NHF 400/500/630 3NH 400/500/630 KL 400/500 KLNC 400/500 KP 400 KF 400/500 KTF 400/500 QLC 400	DE 400	400INTER. (UP TO 89) 400 HYD. FRONT END 500 HYD. FRONT END	KFH 400/500 KFH-F 400/500 KFH-G 400/500 KFH-NC 400/500 KFD 400/500/630/800 KFD-H 400/500 KFD-HF 400/500 KFD-HS 400/500 LVE 400/500/630 KFL 500/630	THF 400-120 TH 400-120 THF 500-160 TH 500-160 TH 630-180 HSG 400-126 HSG 500-165 HSL 400-120 ROTA NC 400 ROTA NCD 400 ROTA NCF 400 ROTA NCO 400	HKF 400/500 HFKS 400/500 KDV 500 KDBG 500 KDS 315/400/500 KDM 500 KJV 400/500/630/800

Serrated Hard Top Jaws



60° Serrations
Reversible Type

Material: Steel: 590M17 or 080M15

To Suit HOWA Power Chucks

Techleader Part No.	A	B	C	D	K	S1	S2	Serrations	Style	Chuck Ø	HOWA Chuck Types		
GW 06	66	38	32	12	20	11		1.5 X 60°	B	165Ø	H027M6	H037M6	HO23M08
GW 08	83	40	40	16	25	13		1.5 X 60°	B	210Ø	H027M8	H037M8	HO23M10
GW 10	98	44	44	18	30	15		1.5 X 60°	B	254Ø	H027M10	H037M10	HO23M12
GW 12	111	60	50	21	35	23		1.5 X 60°	B	304Ø	H027M12	H037M12	

To Suit KITAGAWA Power Chucks

Techleader Part No.	A	B	C	D	K	S1	S2	Serrations	Style	Chuck Ø	KITAGAWA Chuck Types	SAMCHULLY
GT 04	53	30	25	10	14	10		1.5 X 60°	B	110Ø 135Ø	B-204 B-205	HS05
GT 05	57	32	25	10	18	13		1.5 X 60°	B	135Ø	HOB-5 B-05	
GT 06	66	38	32	12	20	11	11	1.5 X 60°	A	165Ø	B-206 B-160 HOH-160 N-160 BB-06 HJAS-6 H-06 HOB-6 HOS-6 AS 165	HS06, HC00 HH206
GT 08	86	50	35	14	25	11	11	1.5 X 60°	A	210Ø	B-208 B-200 HOH-200 HJA6-8 HO-8 HOB-8 HOS-8 AS210 BB-08	HS08, HH208 HC08
GT 10	99	60	40	16	30	15	15	1.5 X 60°	A	254Ø	B210 B250 HOH-250 N-250 HJA6-10 HJA8-10 HO-10 HOB-10 HOS-10 AS250	HS10, HC10
GT 12	103	70	50	18	30	17	17	1.5 X 60°	A	304Ø	B300 HOH-300 N-300 HJA6-12 HJA8-12 HLA6-12 HO-12 HOB-12 HOS-12 HLA6-15 HLA8-15	HC12
GT 13	103	70	50	21	30	17	17	1.5 X 60°	A	304Ø	B212	HS12, HH212
GT 15	140	89	64	22	43	22	22	1.5 X 60°	A	380Ø 450Ø	B380 B-15 HOH-380 HOB-15 HOH-15 B450 B-18 HOB-18	HAH15, HAH18 HC15, HC18
GT21	178	90	60	25	60	40		3 X 60°	B	530Ø 610Ø	HJ-450 HJ-18 B-350 B21 HJ-530 HJ-21 HOB-2-1 N-21 B-600 B-24 HJ-610 HJ24 N24 HOB24	HC-21 HC-24 HCH-21 HCH-24

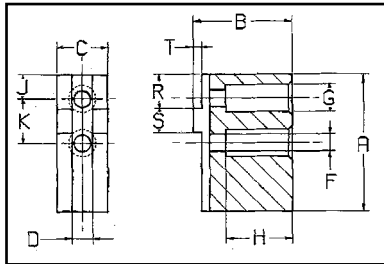
To Suit MMK MATSUMOTO Power Chucks

Techleader Part No.	A	B	C	D	K	S1	S2	Serrations	Style	Chuck Dia	MMK MATSUMOTO Chuck Types
GT 05	57	32	25	10	18	13		1.5 X 60°	B	135Ø	HXA5-6-34 HHXA5-6 SA5-6-40
GU 06	65	35	30	11	20	9	9	1.5 X 60°	A	165Ø	HA5-6 HH-6 HX-6 HJ-6 H-6 STC-6 ZA5-6
GT 08	86	50	35	14	25	11	11	1.5 X 60°	A	210Ø	HA6-8 HX-8 H-8 HH-8 HJ-8 HHJ-8 STC-8 ZA-6-8-52
GT 10	99	60	40	16	30	15	15	1.5 X 60°	A	254Ø	HA6-10 HA8-10 ZA6-10-75 H-10 HX-10 HHL-10 HH-10 HHJ-10 HJ-10 HA8-11 STC-10
GT 12	98	60	50	18	30	17	17	1.5 X 60°	A	304Ø	HA8-12 HX-12 H-12 SH-12 HH-12 HHL-12 HJ-12 HHJ-12 ZA8-12-78 ZA8-12-85
GU 15	140	89	64	22	44.5	22	22	3 X 60°	A	380Ø 450Ø	HA11-15 HHL-15 H-15 HH-15 ZA11-15-120 HA11-18 H-18 HH-18

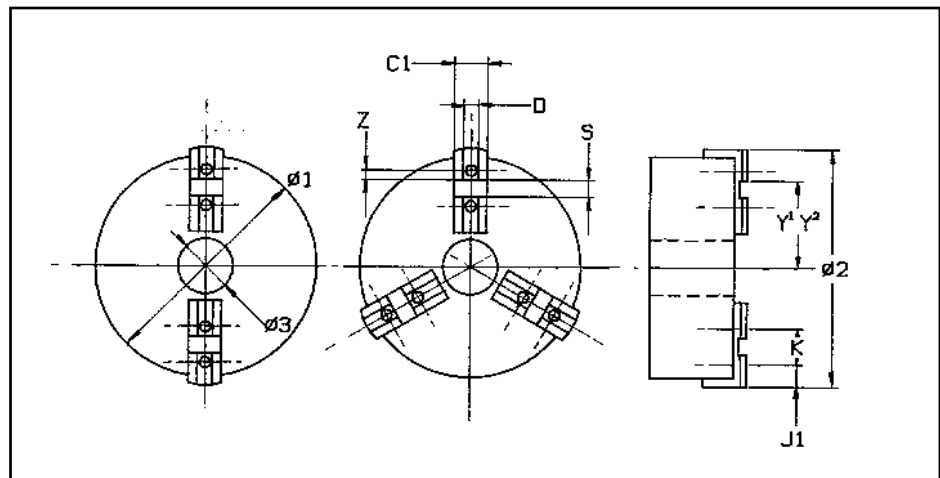
To Suit GAMET, NIKKO and ROHM Power Chucks

Techleader Part No.	A	B	C	D	K	S1	Serrations	Style	Gamet	Nikko	RoHM
GS 16	65	35	29	11	18.5	17	1.5 X 60°	B	160N 160GO 140DE 160MO 170MF	GO-6 MO-6 HDM-165 HF-6AB HG-6AB D-170	KFN160 KFM160 KFG160 KFE160
GS 20	76	44	32	14	22	24	1.5 X 60°	B	215N 215MO 170DE 215GO 215MF	GO-8 MO-8 HDM-215 HF-8 HG-8 MAC165	KFN215 KFM215 KFG215 KFE215
GS 28	94	51	44	20	28	24	1.5 X 60°	B	250-280N 280MO 280GO 280MF	GO-10-12 HF-10/12 HG-10 MO-10/12 HDM-250/300	KFN250/280 KFM280 KFG280 KFE280
GS 35	128	65	50	21	40	28	1.5 X 60°	B	350N 350MO 350GO 350MF	HF-14/16 MO-14 HDM-380 MAC-315	KFN350 KFM350 KFG350 KFE350

Slot/Tenon Top Jaw and Chuck Data Sheet



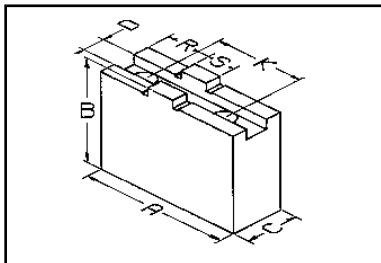
		2 JAW CHUCK DATA	3 JAW CHUCK DATA	REMARKS
Chuck Manufacturer / Model No.				
Chuck Ø / Type	ø1			
Maximum Swing Ø	ø2			
Chuck Bore Ø	ø3			
Base Jaw Width	C1			
Chuck Center to Rear of Slot	Y1 max Y2 min			
Thread	Z			
Center of Hole to Rear of Base Jaw	J1			
Tenon Width	S			
Slot Width	D			
Tenon to Back of Jaw	R			
Hole Center Spacing	K			
Counterbore/ Hole Ø	G/F			
Counterbore Depth	H			
Length of Jaw	A			
Height (Inc. Tenon) of Jaw	B			
Height of Tenon	T			
Width Of Jaw	C			





Slot/Tenon Soft Top Jaws

For Quick Jaw Change Chucks



**Material: Steel: 080M15
Black Finish**

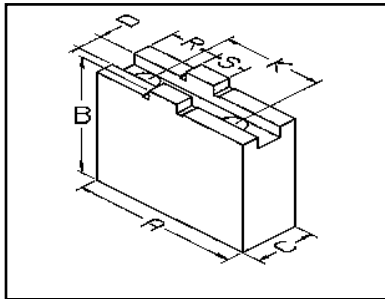
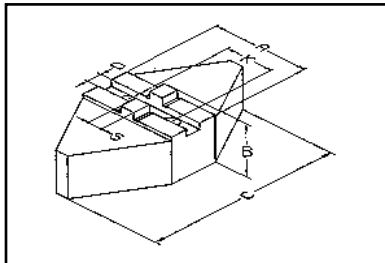
Techleader Bolt Part No.	A	B	C	D	K	R	S		Weight Kg/set
CU 14	69	40	20	8	32	25	18	M8	0.9
CU 141	63	45	30			19			1.7
CU 16	85	40	20	8	32	25	18	M8	1.1
CU 161	85	55	30			19			2.6
DP 16	60	40	40			17			1.8
CU 163	70	60	40			19			3.3
CU 20	105	51	22	10	40	34	20	M8	2.2
CU 201	100	55	30			23			2.9
DP 20	70	40	40			22			2.2
CU 204	85	60	40			23			4.0
CU 205	95	80	40			23			5.8
CU 25	125	55	30	12	40	36	20	M12	3.6
CU 251	90	60	40			26			3.9
CU 252	125	60	40			26			5.8
CU 253	125	80	40			26			7.5
CU 254	125	100	40			26			9.6
CU 255	125	125	40			26			12.0
DP 25	90	60	60			26			6.2
CU 257	90	60	80			26			8.5
CU 32	145	60	40	12	54	45	26	M12	6.8
CU 321	110	60	40			30			4.9
CU 323	145	100	40			30			11.1
CU 324	145	125	40			30			13.9
CU 325	145	150	40			30			16.9
CU 326	110	60	60			30			7.6
DP 32	100	64	76			30			8.4
CU 328	110	80	80			30			14.1
CU 329	145	80	50			30			11.6
CU 40	180	80	50	18	60	50	30	M16	11.2
CU 401	130	76	64			35			11.9
CU 402	180	76	64			35			16.5
CU 403	155	102	64			35			15.3
CU 404	155	127	64			35			18.7
DP 40	130	80	80			35			16.2
CU 406	155	160	50			35			25.2
CU 63	260	127	64	24	82	70	40	M20	42.0

Slot/Tenon Soft Top Jaws

To Suit Forkardt, Gamet, Kitagawa, Rohm, Schunk & SMW-Autoblok Quick Change Chucks

Forkardt	Gamet	Kitagawa	Rohm	Schunk	SMW Autoblok
			DURO NC 140 DURO NC 168		KNCS 140 KNCS 140-32 KNCS-N 140-35
F160 KTNC 160 KTNCV 175 KTNCV 160 FNC 175 F+160	MX 152 MX 175		DURO 160 DURO NC 160 DURO NCE 160 DURO NC 175	ROTA-G 160 ROTA-S 160 ROTA-S plus 160 ROTA NC-W 185 THW 165R	RMG 160 HG 160 HG-F 160 HG-N 160 KNSP 160 KNCS 160 KNCS 175 KNC 160 KNCS 170-43 KNCS-N 170-43
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	MX 215	QJ8	DURO 200 DURO NC 200 DURO NCE 200 DURO NC 225	ROTA-G 200 ROTA-S 200 ROTA-S plus 200 ROTA NC-WF 210 ROTA NC-W 225 THW 210 F THW 210R	RMG 200 HG-F210 HG 200 HG-N210 KNSP 200 KNCS 200 KNCS 225 KNCS 210-52 KNCS-N 210-52 KNCS-N 225-65
F 250 KTNC 250 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 UNC 250/315 FNC 250/315 F+250	MX 252 MX 315 MX 330	QJ 10 QJ 12	DURO 250 DURO NC 250 DURO NCE 250 DURO NCE 315	ROTA-G 250 ROTA NC-WF 250 ROTA-S 250 ROTA-S plus 250 ROTA NC-W 265 ROTA G315 ROTA NC-W 315 ROTA NC-WF 315 THW 250F THW 250R THW 265F THW 265R THW 315R	RMG 250 KNCS 250 KNCS 260 KNCS 315 KNCS 260-71 KNCS 315-91 KNCS-N 260-72 KNCS-N 315-91 HG 250/315 HG-F 260/315 HG-N 260/315
F 315 KTNC 360 KTNC 400 KTNCV 400 UNC 400 FNC 400 F+315	MX 380		DURO 315 DURO NC 315 DURO NCE 400	ROTA-G 400 ROTA-S 315 ROTA-S plus 315 ROTA NC-W 400 THW 315F THW 400F THW 400R	RMG-315 KNCS 400 KNCS 400-120 KNCS-N 400-128 HG 400 KNC 400 HG-N400
F 400/500L UNC 500 KTNC 500 KTNC 630 KTNCV 500 KTNCV 630 FNC 500/630 F+400			DURO 400 DURO NC 400 DURO 500 DURO NC 500 DURO NCE 500	ROTA-S 400 ROTA-S plus 400 ROTA-G 500 ROTA-S 500 ROTA-S plus 500 THW 500F THW 500R THW 630R	HG 500 HG 630 HG-F 400/500 HG-N 500/600 KNCS 500 KNCS 630 KNCS 500-160 KNCS 630/160 KNCS-N 500-165 KNCS-N 630-165 KNCS 800-160
F 630 F+630			DURO NC 630 DURO 630	ROTA-G 630 ROTA-S 630 ROTA-S plus 630	HG-F 630

Slot/Tenon Diamond & Aluminum Top Jaws



**To Suit Quick Jaw
Change Chucks**

**Material: Steel: 080M15
Material: Aluminum HE30TF
Black Finish**

Diamond Top Jaws

Techleader Part No.	A	B	C	D	K	S	Bolt	Weight KG/ set
CQ 16 STEEL	60	60	120	8	32	18	M8	9.0
HT 16 ALUMINUM	64	64	120					3.8
CQ 20 STEEL	76	64	150	10	40	20	M8	14.0
HT 20 ALUMINUM	76	64	150					5.9
CQ 25 STEEL	89	64	170	12	40	20	M12	20.0
HT 25 ALUMINUM	89	64	170					8.4
CQ 32 STEEL	118	76	240	12	54	26	M12	28.0
HT 32 ALUMINUM	118	76	240					10.5

Aluminum Top Jaws

Techleader Part No.	A	B	C	D	K	R	S	Bolt	Weight KG/ set
CW 16	85	50	25	8	32	25	18	M8	0.7
CW 20	105	50	25	10	40	34	20	M8	0.9
CW 25	125	60	40	12	40	36	20	M12	2.0
CW 32	145	60	40	12	54	45	26	M12	2.4
CW 40	180	80	50	18	60	50	30	M16	5.1

Slot/Tenon Diamond & Aluminum Top Jaws

To Suit Forkardt, Gamet, Kitagawa, Rohm, Schunk & SMW-Autoblok Quick Change Chucks

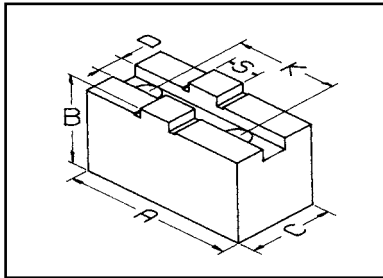
Forkardt	Gamet	Kitagawa	Rohm	Schunk	SMW-Autoblok
F 160 KTNC 160 KTNCV 175 KTNCV 160 FNC 175	MX 152 MX 175		DURO 160 DURO NC 160 DURO NC 175 DURO NCE160	ROTA-G 160 ROTA-S 160 ROTA-S plus 160 ROTA NC-W185 THW 165 R	RMG 160 KNCS 160 KNCS 175 KNCS 170-43 KNCS-N 170-43 KNSP 160 HG 160 HG-F 160 HG-N 160
F 200 KTNC 200 KTNCV 200 FNC 200	MX 215	QJ 8	DURO 200 DURO NC 200 DURO NCE 200	ROTA-G 200 ROTA-S 200 ROTA-S plus 200 ROTA NC-WF 210 ROTA NC-W 225 THW 210 F THF 210 R	RMG 200 HG-F 210 HG 200 HG-N 210 KNSP 200 KNCS 200 KNCS 225 KNCS 210-52 KNCS-N 210-52 KNCS-N 225-65
F 250 KTNC 250 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 UNC 250/315 FNC 250/315	MX 252 MX 315 MX 330	QJ10 QJ 12	DURO 250 DURO NC 250 DURO NCE 250 DURO NCE 315	ROTA-G 250 ROTA NC-WF 250 ROTA-S 250 ROTA-S plus 250 ROTA NCW 265 ROTA-G 315 ROTA NC-W 315 ROTA NC-WF 315 THW 315R THW 250 F/250 R THW 265 F/265 R	RMG 250 KNCS 250 KNCS 260 KNCS 260-71 KNCS 315 KNCS 315-91 KNCS-N 260-72 KNCS-N 315-91 HG-F 260/315 HG-N 260/315 HG 250/315
F 315 KTNC 360 KTNC 400 KTNCV 400 UNC 400 FNC 400	MX 380		DURO 315 DURO NC 315 DURO NCE 315	ROTA-G 400 ROTA-S 315 ROTA-S plus 315 ROTA NC-W 400 THW 315 F/400 F THW 400 R	RMG 315 KNCS 400 HG 400 KNC 400 KNCS 400-120 KNCS-N 400-128 HG-N 400

Aluminum Top Jaws

Forkardt	Gamet	Kitagawa	Rohm	Schunk	SMW-Autoblok
F 160 KTNC 160 KTNCV 175 KTNCV 160 FNC 175	MX 152 MX 175		DURO 160 DURO NC 160 DURO NC 175 DURO NCE160	ROTA-G 160 ROTA-S 160 ROTA-S plus 160 KNCS 170-43 THW 165 R KNSP 160 HG 160	RMG 160 KNCS 160 KNCS 175 KNCS 170-43 KNCS-N 170-43 KNSP 160 HG 160 HG-F 160 HG-N 160
F 200 KTNC 200 KTNCV 200 FNC 200	MX 215	QJ 8	DURO 200 DURO NC 200 DURO NCE 200	ROTA-G 200 ROTA-S 200 ROTA-S plus 200 ROTA NC-WF 210 ROTA NC-W 225 THW 210 F THF 210 R KNCS 210-52 KNCS-N 210-252	RMG 200 HG-F 210 HG 200 HG-N 210 KNSP 200 KNCS 200 KNCS 225 KNCS 210-52 KNCS-N 210-52 KNCS-N 225-65
F 250 KTNC 250 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 UNC 250/315 FNC 250/315	MX 252 MX 315 MX 330	QJ10 QJ 12	DURO 250 DURO NC 250 DURO NCE 250 DURO NCE 315	ROTA-G 250 ROTA NC-WF 250 ROTA-S 250 ROTA-S plus 250 ROTA NC-W 265 ROTA-G 315 ROTA NC-W 315 ROTA NC-WF 315 THW 315R THW 250 F/250 R THW 265 F/265 R	RMG 250 KNCS 250 KNCS 260 KNCS 260-71 KNCS 315 KNCS 315-91 KNCS-N 260-72 KNCS-N 315-91 HG 250/315 HG-F 250/315 HG-N 260/315
F 315 KTNC 360 / 400 KTNCV 400 FNC 400 UNC 400	MX 380		DURO 315 DURO NC 315 DURO NCE 400	ROTA-G 400 DURO S 315 ROTA-S plus 315 ROTA NC-W 400 THW 315 F/400 F THW 400 R	RMG 315 KNCS 400 HG 400 KNC 400 KNCS 400-120 KNCS-N 400-128 HG-N 400
F 400/500L UNC 500 KTNC 500 KTNC 630 KTNCV 500/630 FNC 500/630			DURO 400 DURO NC 400 DURO 500 DURO NC 500 DURO NCE 500		HG 500 HG-F 400/500 HG 630 KNCS 500 HG-N 500/600 HG 630 KNCS 500 KNCS 630 KNCS 500-160 KNCS-N 500-165 KNCS 630-160 KNCS-N 630-165



Slot/Tenon Soft Top Jaws



For Manual and Power Operated Chucks AMERICAN STANDARD BASE JAWS

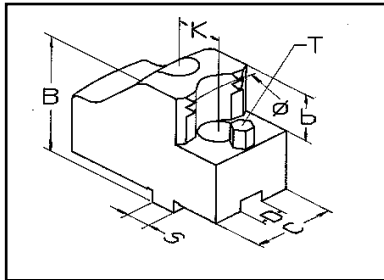
Techleader Part No.	Chuck Diameter	A	B	C	D	K	S	Bolt Size
DM13	5"	2.18"	1.37"	0.75"	0.313"	1.250"	0.436"	5/16"
DM16	6"	2.81"	1.37"	1.00"	0.313"	1.500"	0.499"	3/8"
DM16L	6"	3.25"	1.37"	1.00"	0.313"	1.500"	0.499"	3/8"
DM20	8"	3.31"	1.87"	1.25"	0.313"	1.750"	0.499"	3/8"
DM20L	8"	3.75"	1.88"	1.25"	0.313"	1.750"	0.499"	3/8"
DM25	10"	3.94"	1.87"	1.50"	0.501"	2.125"	0.749"	1/2"
DM25L	10"	4.62"	1.88"	1.50"	0.501"	2.125"	0.749"	1/2"
DM32	12"	4.50"	2.12"	1.75"	0.501"	2.500"	0.749"	1/2"
DM32L	12"	5.37"	2.13"	1.75"	0.501"	2.500"	0.749"	1/2"
DM38	15"	5.18"	2.25"	1.75"	0.501"	3.000"	0.749"	5/8"
DM38L	15"	6.25"	2.25"	1.75"	0.501"	3.000"	0.749"	5/8"
DM46	18"	5.18"	2.75"	2.25"	0.501"	3.000"	0.749"	3/4"
DM46L	18"	6.37"	2.75"	2.25"	0.501"	3.000"	0.749"	3/4"

Adjustagrip Hard Top Jaws

For Slot/Tenon Quick Jaw Change Chucks

FOR SPECIAL SIZE ADJUSTAGRIP JAWS AND FOR CHUCK TYPES NOT LISTED

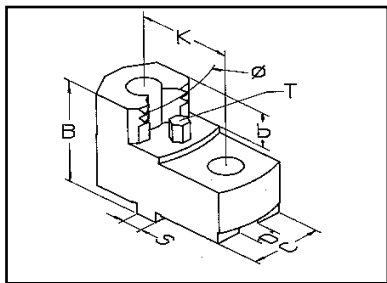
If the standard listed type is not suitable, please fill in the drawing details below and return to us for a quotation.



EXTERNAL GRIPPING

CHUCK MAKE AND TYPE:

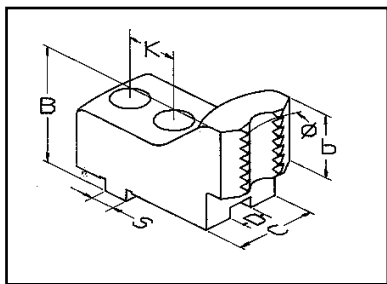
B	
C	
D	
K	
S	
b	
Ø	



INTERNAL GRIPPING

CHUCK MAKE AND TYPE:

B	
C	
D	
K	
S	
b	
Ø	



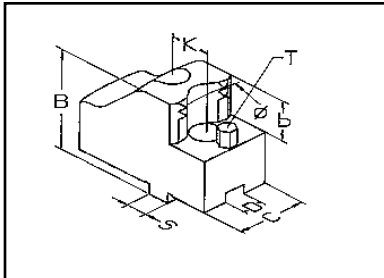
BAR GRIPPING

CHUCK MAKE AND TYPE:

B	
C	
D	
K	
S	
b	
Ø	

Adjustagrip Hard Top Jaws

For Slot/Tenon Quick Jaw Change Chucks



External Ø Clamping Type
Material: Steel: 590M17

Techleader Part No.	B	C	D	K	S	b	T	Weight KG/set
LY10	49	30	8	32	18	20	M6	1.3
LY 11								1.3
LY 12								1.2
LY 13								1.2
LY 14								1.1
LY 15								1.1
LY 16								1.4
LY 17	1.4							
LY20	49	30	10	40	20	20	M6	1.3
LY 21								1.3
LY 22								1.2
LY 23								1.2
LY 24								1.2
LY 25								1.2
LY 30	59	40	12	40	20	25	M6	2.4
LY 31								2.4
LY 32								2.3
LY 33								2.3
LY 34								2.0
LY 35								2.0
LY 40	59	50	12	54	26	25	M8	4.0
LY 41								4.0
LY 42								3.2
LY 43								3.2
LY 50	78	50	18	60	30	33	M8	5.6
LY 51								5.6
LY 52								5.1
LY 53								5.1

These jaws suit the following quick jaw change chuck types:

BERG	KHNC
FORKARDT	KTNC, KTNCs, KTNCV, FNC
ROHM	DURO NC
SCHUNK	THW
SMW	KNCS
SMW-AUTOBLOK	KNCS-N

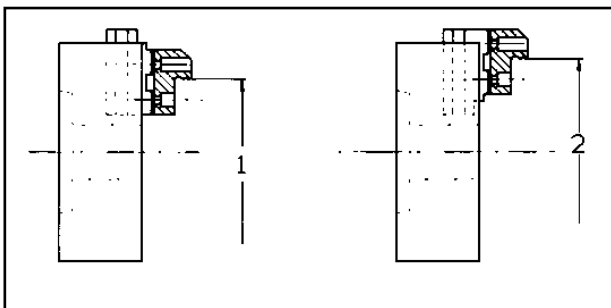
These jaws will also fit Gamet MX, Kitagawa QJ and Reishauer RHU chucks. Grip ranges are available on request. Internal and bar gripping type jaws are also available on request. A grip range table can be supplied if required.

Adjustagrip Hard Top Jaws

**For Slot/Tenon Quick Jaw Change Chucks
To Suit Schunk THW Chucks Material: Steel: 590M17
External Gripping**

THW 165-37				THW 210-52				THW 250-65				THW 265-71				THW 315-86				THW 400-120			
GRIP RANGE Ø	Max Swing	Pos	Part No.	GRIP RANGE Ø	Max Swing	Pos	Part No.	GRIP RANGE Ø	Max Swing	Pos	Part No.	GRIP RANGE Ø	Max Swing	Pos	Part No.	GRIP RANGE Ø	Max Swing	Pos	Part No.	GRIP RANGE Ø	Max Swing	Pos	Part No.
29-33	182	1	LY10	27-30	247	1	LY20	33-38	296	1	LY30	33-38	307	1	LY30	36-42	345	1	LY30	55-61	313	1	LY40
33-37			LY11	30-32			LY21	37-42			LY31	37-42			LY31	41-47			LY31	61-67			LY41
37-41			LY10	31-37			LY20	41-47			LY30	41-47			LY30	46-52			LY31	65-71			LY40
41-46			LY11	36-41			LY21	46-52			LY31	46-52			LY31	50-56			LY31	71-77			LY41
46-50			LY10	40-45			LY20	51-57			LY30	51-57			LY30	56-62			LY30	75-81			LY40
50-54			LY11	44-50			LY21	56-62			LY31	56-62			LY31	61-67			LY31	81-87			LY41
54-60			LY12	49-54			LY20	61-67			LY30	61-67			LY30	66-72			LY30	85-91			LY40
60-64			LY13	53-59			LY21	66-72			LY31	66-72			LY31	71-77			LY31	91-98			LY41
64-69			LY12	58-63			LY20	71-78			LY30	71-78			LY30	76-83			LY30	95-101			LY40
69-73			LY13	62-68			LY21	77-83			LY31	77-83			LY31	81-88			LY31	101-108			LY41
73-78			LY12	67-73			LY20	82-88			LY30	82-88			LY30	87-93			LY30	106-112			LY40
78-82			LY13	71-77			LY21	87-94			LY31	87-94			LY31	92-98			LY31	112-119			LY41
81-85			LY14	76-81			LY23	92-98			LY33	92-98			LY33	98-104			LY30	116-123			LY40
85-90			LY15	80-86			LY22	98-104			LY32	98-104			LY32	103-109			LY31	123-129			LY41
90-95			LY14	85-91			LY23	103-109			LY33	103-109			LY33	108-115			LY33	127-133			LY40
95-99	LY15	89-95	LY22	108-115	LY32	108-115	LY32	114-120	LY31	133-140	LY41												
99-104	LY14	94-100	LY23	114-120	LY33	114-120	LY33	118-125	LY33	138-144	LY40												
104-108	LY15	99-105	LY22	119-126	LY32	119-126	LY32	124-130	LY32	144-151	LY41												
109-113	LY14	103-109	LY23	124-131	LY33	124-131	LY33	129-136	LY33	148-156	LY40												
113-118	LY15	107-113	LY25	128-135	LY35	130-136	LY32	135-141	LY32	155-162	LY41												
118-124	194	1	LY16	112-118	LY24	134-140	LY34	135-142	LY33	140-147	LY33	159-166	LY40										
124-128			LY17	116-122	LY25	139-146	LY35	139-146	LY35	146-152	LY32	166-172	LY41										
128-133			LY16	121-127	LY24	145-151	LY34	145-151	LY34	151-158	LY33	170-176	LY42										
133-137			LY17	125-131	LY25	150-157	LY35	150-157	LY35	155-162	LY35	176-183	LY43										
137-142			LY16	130-136	LY24	156-162	LY34	156-162	LY34	161-167	LY34	181-187	LY42										
142-147			LY17	135-141	LY25	161-167	LY35	161-167	LY35	166-172	LY35	187-194	LY43										
147-151			LY16	140-146	LY24	166-173	LY34	166-173	LY34	171-178	LY34	192-198	LY42										
151-156			LY17	145-150	LY25	172-178	LY35	172-178	LY35	177-183	LY35	198-205	LY43										
155-160			212	2	LY16	149-155	LY24	175-182	LY34	177-184	LY34	182-189	LY34	202-209	LY42								
160-165					LY17	154-160	LY25	181-187	LY35	183-189	LY35	188-194	LY35	209-216	LY43								
165-169					LY16	159-165	LY24	186-193	LY34	186-193	LY34	193-200	LY34	213-220	LY42								
169-174					LY17	163-169	LY25	192-198	LY35	192-198	LY35	199-205	LY35	220-227	LY43								
							LY24	168-174	LY24	197-204	LY34	197-204	LY34	204-211	LY34	224-231	LY42						
							LY25	173-179	LY25	203-209	LY35	203-209	LY35	210-216	LY35	231-238	LY43						
										208-215	LY34	208-215	LY34	215-222	LY34	235-242	LY42						
								214-220	LY35	214-220	LY35	221-227	LY35	242-249	LY43								
								219-226	LY34	219-226	LY34	226-233	LY34	246-253	LY42								
								224-231	LY35	224-231	LY35	231-238	LY35	253-260	LY43								
								230-237	LY34	230-237	LY34	237-244	LY34	257-264	LY42								
								235-242	LY35	235-242	LY35	242-249	LY35	264-270	LY43								
									LY34	241-248	LY34	248-255	LY34	268-274	LY42								
									LY35	246-253	LY35	253-260	LY35	274-281	LY43								
												259-266	LY34	279-286	LY42								
										264-271	LY35	286-292	LY43										
										270-276	LY34	291-297	LY42										
										275-282	LY35	297-304	LY43										
										281-287	LY34	302-308	LY42										
										286-293	LY35	308-315	LY43										
												313-319	LY42										
												319-326	LY43										
												324-330	LY42										
												330-337	LY43										
												335-342	LY42										
												342-348	LY43										
												346-352	LY42										
												352-359	LY43										
												356-363	LY42										
												363-370	LY43										

BASE JAW POSITION



Adjustagrip Hard Top Jaws

**For Slot/Tenon Quick Jaw Change Chucks
To Suit SMW KNCS Chucks Material: Steel: 590M17
EXTERNAL GRIPPING**

KNCS 140-32			
GRIP RANGE Ø	Max Swing	Pos	Part No.
27-30	162	1	LY10
30-34			LY11
34-38			LY10
38-42			LY11
42-47			LY10
47-51			LY11
51-56			LY12
56-61			LY13
61-65			LY12
65-70			LY13
70-74		LY12	
74-78		LY13	
78-82		LY14	
82-86		LY15	
86-91		LY14	
91-96		LY15	
96-100		LY14	
100-105		LY15	
105-110		LY14	
110-115		LY15	
115-121	190	1	LY16
121-125			LY17
125-129			LY16
129-134			LY17
134-139			LY16
139-143			LY17
143-148			LY16
148-151			LY17

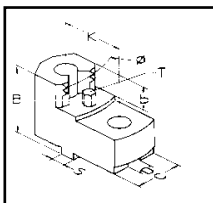
KNCS 160-32					
GRIP RANGE Ø	Max Swing	Pos	Part No.		
27-31	177	1	LY10		
31-34			LY11		
34-39			LY10		
39-43			LY11		
43-47			LY10		
47-52			LY11		
52-57			LY12		
57-61			LY13		
61-66			LY12		
66-70			LY13		
70-75			LY12		
75-78			LY13		
78-82			LY14		
82-87			LY15		
87-91			LY14		
91-96			LY15		
96-101			LY14		
101-105	LY15				
105-110	LY14				
110-115	LY15				
115-120	190	1	LY16		
120-125			LY17		
125-130			LY16		
130-134			LY17		
134-139			LY16		
139-144			LY17		
144-148			208	2	LY16
148-152					LY17
152-157					LY16
157-161					LY17
161-166	LY16				
166-170	LY17				

KNCS 175-40			
GRIP RANGE Ø	Max Swing	Pos	Part No.
27-30	186	1	LY10
30-33			LY11
32-37			LY10
36-41			LY11
41-46			LY10
45-50			LY11
49-54			LY10
54-59			LY11
59-64			LY12
63-68			LY13
68-73			LY12
72-78			LY13
77-82			LY12
81-87			LY13
85-90			LY14
89-94			LY15
94-99			LY14
98-104			LY15
103-108			LY14
108-113			LY15
112-118	LY14		
117-123	LY15		
123-128	199	1	LY16
127-133			LY17
132-137			LY16
137-142			LY17
141-147			LY16
146-151			LY17
151-156			LY16
155-161	LY17		
159-165	217	2	LY16
164-169			LY17
169-174			LY16
173-179			LY17

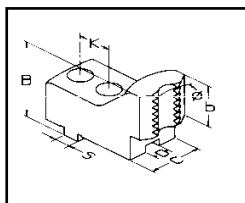
KNCS 200-41			
GRIP RANGE Ø	Max Swing	Pos	Part No.
30-35	235	1	LY20
34-39			LY21
38-43			LY20
42-48			LY21
47-52			LY20
51-57			LY21
56-61			LY20
60-66			LY21
65-70			LY23
69-75			LY22
74-79			LY23
78-84			LY22
83-88			LY23
87-93			LY22
92-97			LY23
96-101			LY25
100-106			LY24
105-110			LY25
110-115			LY24
114-120			LY25
119-125	LY24		
124-129	LY25		
129-134	273	2	LY24
133-139			LY25
138-144			LY24
143-148			LY25
147-153			LY24
152-157			LY25
157-162			LY24
161-167			LY25

KNCS 250-52			
GRIP RANGE Ø	Max Swing	Pos	Part No.
38-43	291	1	LY30
42-48			LY31
47-53			LY30
52-58			LY31
57-63			LY30
62-68			LY31
67-73			LY30
72-79			LY31
78-84			LY30
83-89			LY31
88-94			LY33
93-99			LY32
98-105			LY33
104-110			LY32
109-116			LY33
115-121			LY32
120-126			LY33
124-130			LY35
129-136			LY34
135-141			LY35
140-147	LY34		
145-152	LY35		
151-158	LY34		
156-163	LY35		
162-168	LY34		
167-174	LY35		
171-177	355	2	LY34
176-183			LY35
182-188			LY34
187-194			LY35
193-199			LY34
198-205			LY35
204-210			LY34
209-216			LY35
215-221			LY34
220-226			LY35
225-232	LY34		
231-237	LY35		

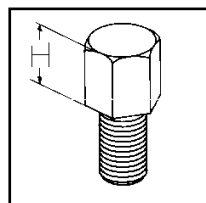
INTERNAL GRIPPING
Available on request



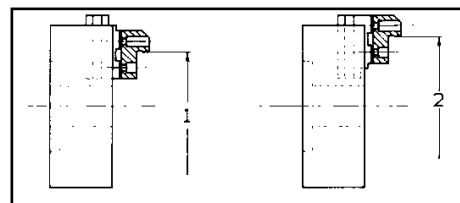
BAR GRIPPING
Available on request



WORKPIECE HEIGHT PINS



BASE JAW POSITION



Adjustagrip Hard Top Jaws

**For Slot/Tenon Quick Jaw Change Chucks
To Suit SMW KNCS Chucks Material: Steel: 590M17**
EXTERNAL GRIPPING

KNCS 260-65			
GRIP RANGE Ø	Max Swing	Pos	Part No.
38-43	302	1	LY30
42-48			LY31
47-53			LY30
52-58			LY31
57-63			LY30
62-68			LY31
67-73			LY30
72-79			LY31
78-84			LY30
83-89			LY31
88-95			LY30
93-100			LY31
98-105			LY33
104-110			LY32
109-116			LY33
115-121			LY32
120-126			LY33
125-132			LY32
131-137			LY33
135-141			LY35
140-147	LY34		
145-152	LY35		
151-158	LY34		
156-163	LY35		
162-168	LY34		
167-174	LY35		
173-179	LY34		
178-185	LY35		
182-188	366	2	LY34
187-194			LY35
193-199			LY34
198-205			LY35
204-210			LY34
209-216			LY35
215-221			LY34
220-226			LY35
225-232			LY34
231-237			LY35
236-243	LY34		
242-248	LY35		

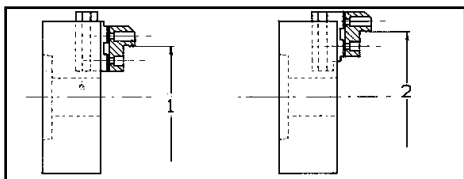
KNCS 315-77			
GRIP RANGE Ø	Max Swing	Pos	Part No.
36-42	344	1	LY30
40-46			LY31
45-51			LY30
50-56			LY31
55-61			LY30
60-67			LY31
65-72			LY30
71-77			LY31
76-82			LY30
81-88			LY31
86-93			LY30
92-98			LY31
97-104			LY30
102-109			LY31
108-115			LY30
113-120			LY31
118-125			LY33
124-130			LY32
129-136			LY33
134-141			LY32
140-146	LY33		
145-152	LY32		
151-157	LY33		
155-161	LY35		
160-167	LY34		
165-172	LY35		
171-178	LY34		
176-183	LY35		
182-189	LY34		
187-194	LY35		
193-200	LY34		
198-205	LY35		
204-211	432	2	LY34
209-216			LY35
215-221			LY34
220-227			LY35
226-232			LY34
231-238			LY35
237-243			LY34
242-249			LY35
248-254			LY34
253-260			LY35
259-265	LY34		
264-271	LY35		
269-276	LY34		
275-282	LY35		
280-287	LY34		
286-293	LY35		

KNCS 315-91			
GRIP RANGE Ø	Max Swing	Pos	Part No.
46-52	356	1	LY30
51-57			LY31
56-52			LY30
61-67			LY31
66-73			LY30
71-78			LY31
77-83			LY30
82-88			LY31
87-94			LY30
93-99			LY31
98-105			LY30
103-110			LY31
109-115			LY30
114-121			LY31
120-126			LY30
125-131			LY31
130-136			LY33
135-142			LY32
141-147			LY33
146-153			LY32
152-158	LY33		
157-164	LY32		
162-169	LY33		
166-173	LY35		
172-179	LY34		
177-184	LY35		
183-189	LY34		
188-195	LY35		
194-200	LY34		
199-206	LY35		
205-211	LY34		
210-217	LY35		
216-222	444	2	LY34
221-228			LY35
227-233			LY34
232-239			LY35
238-244			LY34
243-250			LY35
249-255			LY34
254-261			LY35
260-266			LY34
265-271			LY35
270-277	LY34		
276-282	LY35		
281-288	LY34		
287-293	LY35		
292-299	LY34		
298-304	LY35		

KNCS 400-92			
GRIP RANGE Ø	Max Swing	Pos	Part No.
54-60	419	1	LY40
60-66			LY41
63-70			LY40
70-76			LY41
73-80			LY40
80-86			LY41
83-90			LY40
90-97			LY41
94-101			LY40
100-107			LY41
104-111			LY40
111-118			LY41
115-122			LY40
122-129			LY41
125-132			LY40
132-139			LY41
136-143			LY40
143-150			LY41
147-154			LY40
154-161			LY41
158-165	LY40		
165-172	LY41		
168-176	LY42		
175-182	LY43		
179-186	LY42		
186-193	LY43		
190-197	LY42		
197-204	LY43		
201-208	LY42		
208-215	LY43		
212-219	LY42		
219-226	LY43		
223-230	LY42		
230-237	LY43		
234-241	LY42		
241-248	LY43		
245-252	LY42		
252-259	LY43		
256-263	LY42		
263-270	LY43		
266-274	LY42		
273-281	LY43		
277-285	LY42		
284-292	LY43		
289-297	497	2	LY42
296-303			LY43
300-307			LY42
307-314			LY43
311-318			LY42
318-325			LY43
322-329			LY42
329-336			LY43
333-340			LY42
340-347			LY43
344-351	LY42		
351-358	LY43		
355-362	LY42		
362-369	LY43		

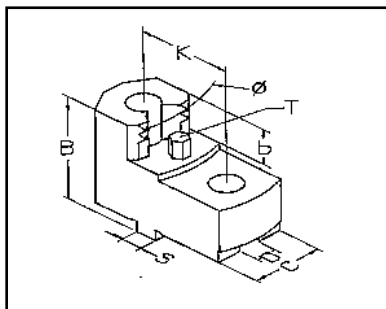
KNCS 500-128			
GRIP RANGE Ø	Max Swing	Pos	Part No.
87-99	515	1	LY50
95-104			LY51
102-112			LY50
108-118			LY51
116-125			LY50
122-131			LY51
129-139			LY50
135-145			LY51
143-153			LY50
149-158			LY51
157-166			LY50
164-174			LY52
171-181			LY53
178-188			LY52
185-194			LY53
191-201			LY52
198-208			LY53
205-215			LY52
212-222			LY53
219-229			LY52
226-236	LY53		
233-243	LY52		
243-253	637	2	LY52
250-260			LY53
257-267			LY52
264-274			LY53
271-281			LY52
278-288			LY53
285-294			LY52
291-301			LY53
298-308			LY52
305-315			LY53
312-322	637	2	LY52
319-329			LY53
326-336			LY52
333-343			LY53
340-350			LY52
347-357			LY53
354-364			LY52
361-371			LY53
368-378			LY52
375-385			LY53
382-392	LY52		
389-399	LY53		

BASE JAW POSITION

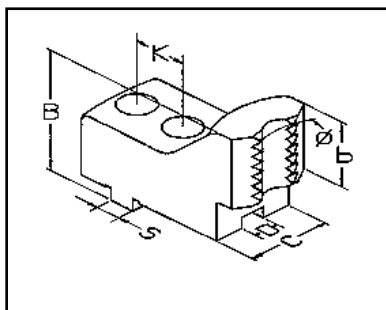


Adjustagrip Hard Top Jaws

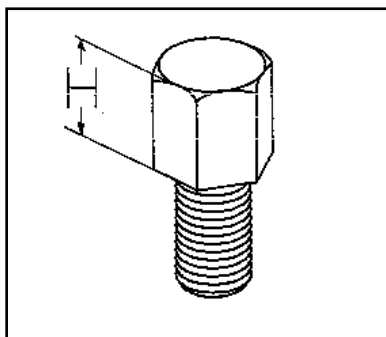
For Slot/Tenon Quick Jaw Change Chucks
To Suit SMW-Autoblok KNCS-N Chucks **Material: Steel: 590M17**
EXTERNAL GRIPPING



INTERNAL GRIPPING



BAR GRIPPING



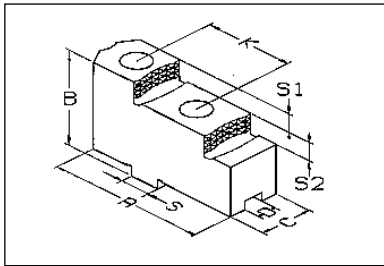
WORKPIECE HEIGHT PINS

KNCS-N 315-91			
GRIP RANGE Ø	Max Swing	Pos	Part No.
46-52	356	1	LY30
50-57			LY31
56-62			LY30
61-67			LY31
66-72			LY30
71-78			LY31
76-83			LY30
81-88			LY31
87-94			LY30
92-99			LY31
98-104			LY30
103-110			LY31
108-115			LY30
114-120			LY31
119-126			LY30
124-131			LY31
128-135			LY34
133-140			LY35
139-146			LY34
144-151			LY35
150-157	LY34		
155-162	LY35		
161-167	LY34		
166-173	LY35		
171-178	LY34		
177-184	LY35		
182-189	LY34		
188-195	LY35		
193-200	LY34		
199-206	LY35		
204-211	LY34		
210-217	LY35		
215-222	444	2	LY34
221-227			LY35
226-233			LY34
231-238			LY35
237-244			LY34
242-249			LY35
248-255			LY34
253-260			LY35
259-266			LY34
264-271			LY35
270-277			LY34
275-282			LY35
281-288			LY34
286-293			LY35
292-299	LY34		
297-304	LY35		

KNCS-N 400-128			
GRIP RANGE Ø	Max Swing	Pos	Part No.
67-74	446	1	LY40
74-80			LY41
77-84			LY40
84-91			LY41
88-94			LY40
94-101			LY41
98-105			LY40
105-112			LY41
108-116			LY40
115-122			LY41
119-126			LY40
126-133			LY41
130-137			LY40
137-144			LY41
140-148			LY40
147-155			LY41
151-158			LY40
158-165			LY41
162-169			LY40
169-176			LY41
173-180	LY40		
180-187	LY41		
184-191	LY40		
191-198	LY41		
195-202	LY42		
201-209	LY43		
205-213	LY42		
212-220	LY43		
216-224	LY42		
223-231	LY43		
227-235	LY42		
234-241	LY43		
238-245	LY42		
245-252	LY43		
249-256	LY42		
256-263	LY43		
260-267	LY42		
267-274	LY43		
271-278	LY42		
278-285	LY43		
282-289	LY42		
289-296	LY43		
293-300	LY42		
300-307	LY43		
304-311	LY42		
311-318	LY43		
317-324	525	2	LY42
324-331			LY43
328-335			LY42
335-342			LY43
339-346			LY42
346-353			LY43
350-357			LY42
357-364			LY43
361-368			LY42
368-375			LY43
372-379			LY42
379-386			LY43
383-390			LY42
390-397			LY43

KNCS-N 500-155			
GRIP RANGE Ø	Max Swing	Pos	Part No.
87-98	636	1	LY50
94-103			LY51
102-111			LY50
107-117			LY51
115-124			LY50
121-130			LY51
128-138			LY50
134-144			LY51
142-152			LY50
148-157			LY51
156-165			LY50
163-173			LY52
170-180			LY53
177-187			LY52
184-193			LY53
190-200			LY52
197-207			LY53
204-214			LY52
211-221			LY53
218-228			LY52
225-235	LY53		
232-242	LY52		
239-249	LY53		
246-256	LY52		
253-263	LY53		
260-270	LY52		
267-277	LY53		
274-284	LY52		
281-290	LY53		
288-297	LY52		
294-304	LY53		
301-311	LY52		
308-318	LY53		
318-328	836	2	LY51
326-336			LY53
333-343			LY52
340-350			LY53
347-357			LY52
354-364			LY53
361-371			LY52
368-378			LY53
375-385			LY52
382-392			LY53
389-399			LY52
396-406			LY53
403-413			LY52
410-420			LY53
417-427	LY52		
424-434	LY53		
431-441	LY52		
438-448	LY53		
445-455	LY52		
452-462	LY53		
459-469	LY52		
466-476	LY53		
473-483	LY52		
480-490	LY53		
487-497	LY52		
494-504	LY53		
501-511	LY52		
508-518	LY53		

Slot/Tenon Hard Top Jaws



Material: Steel: 590M17

Hard Reversible Jaws for Quick Jaw Change Chucks

Techleader Part No.	A	B	C	D	K	S	T	Bolt Type	Weight Kg/Set
GX 16	63	36.5	20	8	32	18	7.5	M8	0.6
GX 20	72	42	22	10	40	20	10	M8	0.8
GX 25	90	55	30	12	40	20	14	M12	1.9
GX 32	105	62	36	12	54	26	15	M12	3.2
GX 40	130	80	45	18	60	30	20	M16	10.8

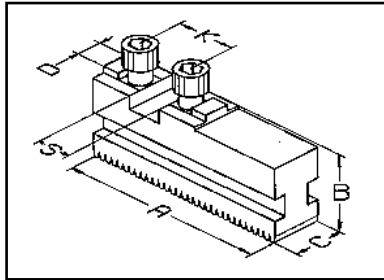
Slot/Tenon Hard Top Jaws

To suit Forkardt, Gamet, Kitagawa, Rohm, Schunk & SMW-Autoblok Quick Jaw Change Chucks

Forkardt	Gamet	Kitagawa	Rohm	Schunk	SMW-Autoblok
F 160 KTNC 160 KTNCV 175 KTNCV 160 FNC 175	MX 152 MX 175		DURO 160 DURO NC 160 DURO NC 175 DURO NCE160	THW 165-37-R ROTA-S 160 ROTA-S plus 160 ROTA-G 160 ROTA NC-W 185	RMG 160 HG 160 HG-F 160 KNCS 160 KNCS 175 KNCS 170-43 KNCS-N 170-43 KNSP 160 HG-N 160 KNC 160
F 200 KTNC 200 KTNCV 200 FNC 200	MX 215	QJ 8	DURO 200 DURO NC 200 DURO NCE 200 DURO NC 225	THW 210 F THW 210 R ROTA-S 200 ROTA-S plus 200 ROTA-G 200 ROTA NC-WF 210 ROTA NC-W 225	RMG 200 HG-F 160 HG 200 HG-N 210 KNSP 200 KNCS 200 KNCS 225 KNCS 210-52 KNCS-N 210-52 KNCS-N 225-65
F 250 KTNC 250 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 UNC 250/315 FNC 250/315	MX 252 MX 315 MX 330	QJ 10 QJ 12	DURO 250 DURO NC 250 DURO NCE 250 DURO NCE 315	THW 250-F THW 250-R THW 265-F THW 265-R THW 315-R ROTA-S 250 ROTA-S plus 250 ROTA-G 250 ROTA-G 315 ROTA NC-WF 250 ROTA NC-W 265 ROTA NC-W 315 ROTA NC-WF 315	RMG 250 KNCS 250 KNCS 260 KNCS 260-71 KNCS 315 KNCS 315-91 KNCS-N 260-72 KNCS-N 315-91 HG 250/315 HG-F 250/315 HG-N 260/315
F 315 KTNC 360 KTNC 400 KTNCV 400 UNC 400 FNC 400	MX 380		DURO 315 DURO NC 315 DURO NCE 400	THW 400 F THW 315 F THW 400 R ROTA-S 315 ROTA-S plus 315 ROTA-G 400 ROTA NC-W 400	RMG 315 KNCS 400 HG 400 KNC 400 KNCS 400-120 KNCS-N 400-128 HG-N 400
F 400/500 L UNC 500 KTNC 500 KTNC 630 KTNCV 500 KTNCV 630 FNC 500/630			DURO 400 DURO NC 400 DURO 500 DURO NC 500 DURO NCE 500	THW 500 F THW 630 R THW 500 R ROTA-S 400 ROTA-S plus 400 ROTA-S 500 ROTA-S plus 500	HG 500 HG-F 400/500 HG 630 HG-N 500/630 KNCS 500 KNCS 630 KNCS 500-160 KNCS 630-160 KNCS-N 500-165 KNCS-N 630-165 KNCS 800-160

Slot/Tenon Hard Base Jaws

To Suit Quick Jaw Change Chucks



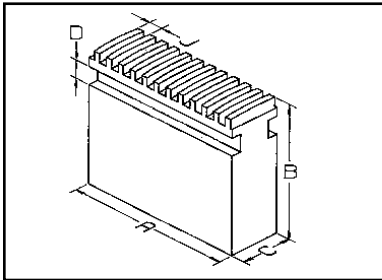
To suit Forkardt, Kitagawa, Rohm, SMW & Schunk Quick Jaw Change Chucks

Techleader Part No.	A	B	C	D	K	S	Bolt Type	Weight KG/set	Forkardt	Kitagawa	Schunk	Rohm	SMW
MFG 160	74	27	20	8	32	18	M8	0.8	F 160 F+160 KTNC 160 KTNCV 175 FNC 175		Rota-S 160 Rota-S plus 160	DURO 160 DURO NC 160 DURO NC 175 DURO NCE 160	HG-F160
MFG 200	90	32	22	10	40	20	M8	1.2	F 200 F+200 KTNC 200 KTNCV 200 FNC 200	QJ 08 QJ 210	THW 210-52F Rota-S 200 Rota-S plus 200 Rota NC-WF 210	DURO 200 DURO NC 200 DURO NCE 200 DURO NC 225	HG-F210
MFG 250	110	37	26	12	40	20	M12	2.0	F 250 F+250 UNC 250/315 KTNC 250/280/315 KTNCV 250/315 FNC 315	QJ 10 QJ 254 QJ 12 QJ 315	THW 250-65F THW 265-71F Rota-S 250 Rota-S plus 250 Rota NC-WF 250 Rota NC-WF 315	DURO 250 DURO NC 250 DURO NCE 250 DURO NCE 315	HG-F260
MFG 315	125	43	32	12	54	26	M12	3.3	F 315 F+315 UNC 400 KTNC 360/400 KTNCV 400 FNC 400		THW 315 F THW 400-120F Rota-S 315 Rota-S plus 315	DURO 315 DURO NC 315 DURO NCE 400	HG-F315
MFG 400	160	51	45	18	60	30	M16	7.3	F 400, F500L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400		THW 500-128 F Rota-S 400 Rota-S 500 Rota-S plus 400 Rota-S plus 500	DURO 400/500 DURO NC 400/500 DURO NCE 500	HG-F400 HG-F500

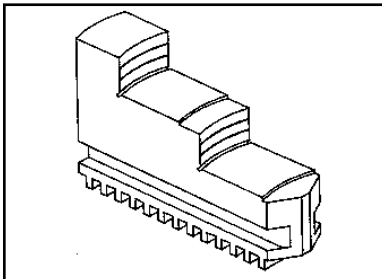
To suit SMW-Autoblok & Schunk Quick Jaw Change Chucks

Techleader Part No.	A	B	C	D	K	S	Bolt Type	Weight KG/set	SMW-Autoblok	Schunk
GBK 140	56	27.5	20	8	32	18	M8	0.6	KNCS 140	KNCS-N140
GBK 160	65	27.5	20	8	32	18	M8	0.7	KNCS 160/125 HG 160 KNCS-N-170	KNSP 160 RMG 160 Rota NC-W 185
GBK 200	85	29.5	22	10	40	20	M8	1.0	KNCS 200 HG 200 KNCS-N-210/225	KNSP 200 RMG 200 Rota NC-W 225
GBK 250	104	37	26	12	40	20	M12	1.8	KNCS 250/260 HG 250 KNCS-N 260	THW250-65R THW265-71R Rota NC-W 265 Rota-G 250
GBK 315	115	43	32	12	40	20	M12	2.7	KNCS 315 KNCS-N 315	HG 315 THW315-86R Rota-G 315 Rota NC-W 400
GBK 400	125	43	32	12	54	26	M12	3.0	KNCS 400 KNCS-N 400 RMG 315	HG 400 THW400-120R Rota-G 400 Rota NC-W 400
GBK 500	160	57	45	18	60	30	M16	7.1	KNCS 500 KNCS-N 500	HG 500 THW500-128R Rota-G 500
GBK 630	200	57	45	18	60	30	M16	9.0	KNCS 630 KNCS-N 630	HG 630 THW630-128R

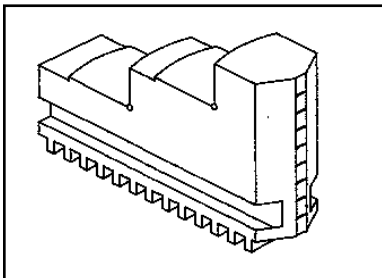
Scroll Jaws Soft and Hard



SOFT



HARD OUTSIDE



HARD INSIDE

**For Manual
Scroll Chucks**

Material: Soft Jaws: O80M15

To suit Rohm ZS & ZG Scroll Chucks

Chuck Diameter	A	B	C	D	J	Weight Kg/Set	Techleader Part No.		
							SOFT JAWS	HARD INSIDE JAWS	HARD OUTSIDE JAWS
140/160	61	51	18	7	8	1.1	EH 16	AVAILABLE ON REQUEST	
200	69	57	20	8	8	1.6	EH 20		
250	90	70	24	10	10	3.0	EH 25		
315/350/400	130	76	34	15	10	7.2	EH 32		

To suit T de G Scroll Chucks

Chuck Diameter	A	B	C	D	J	Weight Kg/Set	Techleader Part No.		
							SOFT JAWS	HARD INSIDE JAWS	HARD OUTSIDE JAWS
85	34	25	12	5	4	0.3	FS 08	AVAILABLE ON REQUEST	
110	47	32	15	6.5	5	0.4	FS 10		
135	56	45	18	8	6	1.0	FS 14		
160	67	51	22	9	7	1.4	FS 16		
200	77	57	25	10.5	8	2.6	FS 20		
250	95	64	32	12.5	10	4.6	FS 25		
315	115	76	40	14	12	8.2	FS 32		
400	140	89	40	14	12	11.8	FS 40		

To suit Bison & Toolmex 3500, 3700 Scroll Chucks

Chuck Diameter	A	B	C	D	J	Weight Kg/Set	Techleader Part No.		
							SOFT JAWS	HARD INSIDE JAWS	HARD OUTSIDE JAWS
125	51	38	20	8	7	0.8	EN 13	AVAILABLE ON REQUEST	
160	70	51	20	8	8	1.3	EN 16		
200	85	57	25	10	8	2.5	EN 20		
250	105	70	28	12	9	4.2	EN 25		
315	127	76	32	12	10	6.3	EN 32		

To suit Pratt Burnerd Metric Scroll Chucks

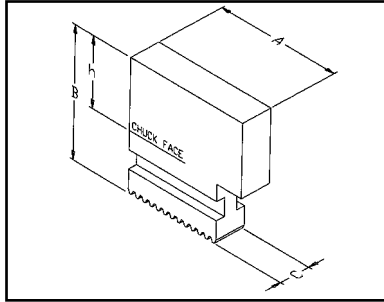
Chuck Diameter	A	B	C	D	J	Weight Kg/Set	Techleader Part No.		
							SOFT JAWS	HARD INSIDE JAWS	HARD OUTSIDE JAWS
80	37	30	10	5	6	0.2	EK 08	AVAILABLE ON REQUEST	
100	42	35	14	7	6	0.4	EK 10		
125	53	38	16	7	6	0.7	EK 13		
160	68	45	18	7	6	1.2	EK 16		
200	78	57	22	8	8	2.1	EK 20		
250	100	70	25	8	8	3.8	EK 25		
315	124	75	32	12	10	6.3	EK 32		
400	154	89	32	12	12	9.5	EK 40		

To Suit Pratt Burnerd Standard Super Precision & Griptru Scroll Chucks

Chuck Diameter	A	B	C	D	J	Weight Kg/Set	Techleader Part No.		
							SOFT JAWS	HARD INSIDE JAWS	HARD OUTSIDE JAWS
80	32	32	9.40	4.85	4.24	0.2	EJB	AVAILABLE ON REQUEST	
100	41	35	14.10	4.85	5.08	0.4	EJC		
125	51	40	15.75	8.03	6.35	0.5	EJE		
160	70	44	18.79	8.03	6.35	1.2	EJG		
200	76	57	20.62	9.53	8.46	1.9	EJJ		
250	102	70	25.40	11.10	8.46	3.8	EJM		
315	114	70	28.19	12.88	8.46	4.7	EJP		
380	127	76	30.15	11.43	10.16	6.2	EJQ		
460/535/610	146	90	38.10	14.30	12.70	10.6	EJR		

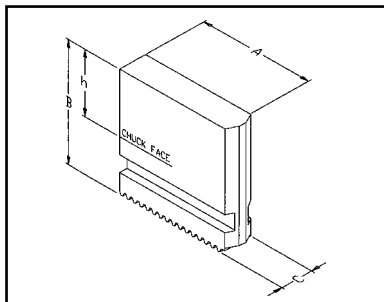
Soft Monoblock Jaws

To Suit Quick Jaw Change Chucks



**To Suit SMW-Autoblok,
Reishauer & Schunk
Quick Jaw Change Chucks**

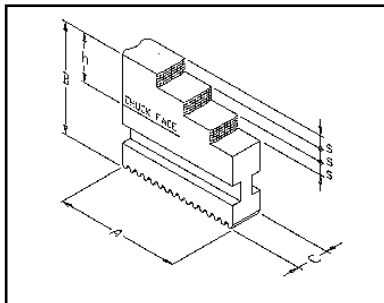
Techleader Part No	A	B	C	h	Weight KG/set	SMW-Autoblok	Reishauer	Schunk
UVB140	58	55.5	20	35	1.3	KNCS 140 KNCSN 140		
UVB170	65	55.5	20	35	1.4	KNCS 160 KNCS 175 KNCSN 170 KNSP 160 RMG 160 HG 160 HGN 160 KNCS-N170	RHU 160	THW 165 R Rota-G 160 Rota NC-W185
UVB200	77	65	22	40	2.0	KNCS 200 KNCSN 210 KNCSN 225 KNSP 200 RMG 200 HG 200 HGN 210	RHU 200	THW 210 R Rota-G 200 Rota NC-W225
UVB250	97	84	26	55	4.2	KNCS 250 KNCS 260 KNCSN 260 RMG 250 HG 250 HGN 260	RHU 250	THW 250 R THW 265 R Rota-G 250 Rota NC-W265
UVB315	118	90	32	56	6.6	KNCS 315 KNCSN 315 HG 315 HGN 315		THW 315 R Rota-G 315 Rota NC-W315
UVB 400	145	100	32	66	9.0	KNCS 400 KNCSN 400 RMG 315 HG 400 HGN 400	RHU 315	THW 400 R Rota-G 400 Rota NC-W400
UVB500	175	124	45	77	19.5	KNCS 500 KNCSN 500 HG 500 HGN 500		THW 500 R Rota-G 500
UVB600	230	134	45	87	27.5	KNCS 630 KNCSN 630 HG 630 HGN 630		THW 630 R



**To Suit Forkardt, Rohm,
SMW-Autoblok & Schunk
Quick Jaw Change Chucks**

Techleader Part No	A	B	C	h	Weight KG/set	Forkardt	Rohm	Schunk	SMW
FVB 170	79	45	20	24	1.4	F 160 F+160 KTNC 160 KTNCV 175 FNC 175	DURO 160 DURO-NC 160 DURO-NC 175 DURO-NCE 160	Rota-S 160 Rota-S plus 160	HGF 160
FVB 200	94	60	22	35	2.5	F 200 F+200 KTNC 200	DURO 200 DURO-NC 200	THW 210 F Rota-S 200	HGF 210
FVB 201	94	80	22	55	2.8	KTNCV 200 FNC 200	DURO-NCE 200	Rota-S plus 200 Rota NC-WF 210	
FVB 250	115	70	26	40	4.3	F250 F+250 KTNC 250/280/315	DURO 250 DURO-NC 250	THW 250-F THW 266-F	HG-F 260
FVB 251	115	100	26	75	4.8	KTNCV 250/315 UNC 250/315 FNC 250/315	DURO-NCE 250/315	Rota-S 250 Rota-S plus 250 Rota NC-WF 250 Rota NC-WF 315	
FVB 315	140	81	32	46	7.3	F 315 F+315 KTNC 360/400 KTNCV 400 UNC 400 FNC 400	DURO 315 DURO-NC 315 DURO-NCE 400	THW 400 F Rota-S 315 THW 315 F Rota-S plus 315	HGF 315
FVB 400	176	93	45	53	15.8	F 400/500E F+400 KTNC 500/630 KTNCV 500/630 UNC 500 FNC 500/630	DURO 400/500 DURO NC 400/500 DURO NCE 500	THW 500 F Rota-S 400 Rota-S 500 Rota-S plus 400 Rota-S plus 500	HGF 400 HGF 500

Monoblock Hard Reversible Jaws To Suit Quick Jaw Change Chucks



**To Suit Forkardt, Rohm,
SMW-Autoblok & Schunk
Quick Jaw Change Chucks**

Techleader Part No	A	B	C	S	h	Weight Kg/set	Forkardt	Rohm	SMW	Schunk
FST 16	79	45	20	7.5	24	1.1	F 160 F+160 KTNCV 175 KTNC 160 FNC 175	DURO 160 DURO-NC 160/175 DURO-NCE 160	HG-F 160	Rota-S 160 Rota-S plus 160
FST 20	94	60	22	10	35	1.9	F 200 F+200 KTNCV 200 KTNC 200 FNC 200	DURO 200 DURO-NC 200 DURO-NCE 200	HG-F 210	THW 210 F Rota-S 200 Rota-S plus 200 Rota NC-WF 210
FST 25	114	70	26	14	40	3.4	F 250 F+250 KTNCV 250 KTNCV 315 KTNC 250/280 KTNC 315 FNC 250/315	DURO 250 DURO-NC 250 DURO-NCE 250 DURO-NCE 315	HGF-260	THW 250 F THW 265 F Rota-S 250 Rota-S plus 250 Rota NC-WF 250 Rota NC-WF 315
FST 31	130	81	32	15	46	5.4	F 315 F+315 KTNCV 400 KTNC 360-400 FNC 400	DURO 315 DURO-NC 315 DURO-NCE 400	HG-F 315	THW 400 F Rota-S 315 THW 315 F Rota-S plus 315
FST 40	167	93	45	20	52	11.0	F 400 F+400 F 500L KTNCV 500 KTNCV 630 KTNC 500/630 FNC 500/630	DURO 400 DURO-NC 400 DURO 500 DURO-NC 500 DURO-NCE 500	HG-F 400 HG-F 500	THW 500 F Rota-S 400 Rota-S 500 Rota-S plus 400 Rota-S plus 500

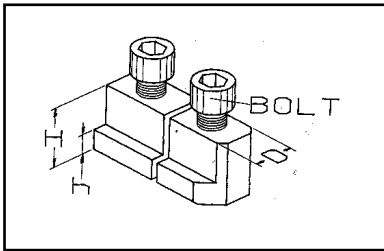
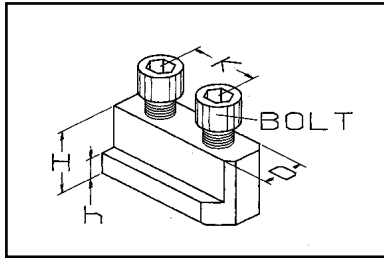
**To Suit SMW-Autoblok
& Schunk Quick Jaw
Change Chucks**

Techleader Part No	A	B	C	S	h	Weight Kg/Set	SMW-Autoblok	Schunk
GST 160-1 GST 160-2	58	43.5	20	7	22	0.6	KNCS 140 KNCS 160 KNCSN 140 KNSP 160 RMG 160 HG 160 HGN 160 KNCS-N 176	THW 160R Rota-G 160 Rota NC-W185
GST 170	65	43.5	20	7	23	0.7	KNCS 160 KNCSN 160 KNSP 160 RMG 160 HG 160 HGN 160 KNCS-N 176	THW 160R Rota-G 160 Rota NC-W185
GST 200 GST 210	75 84	51 51	22 22	8 8	26 26	1.2 1.3	KNCS 200 KNCSN 210 KNCSN 225 KNSP 200 RMG 200 HG 200 HGN 200	THW 210 R Rota-G 200 Rota NC-W225
GST 250	90	60	26	10	31	1.9	KNCS 250 KNCSN 260 RMG 250 HG 250 HGN 250	THW 250 R THW 265 R Rota-G 250 Rota NC-W265
GST 315	117	66	32	11	32	3.4	KNCS 315 KNCSN 315 HG 315 HGN 315	THW 315 R Rota-G 315 Rota NC-W315
GST 400	137	70	32	11	36	4.4	KNCS 400 KNCSN 400 RMG 315 HG 400 HGN 400	THW 400 R Rota-G 400 Rota NC-W400
GST 500	175	93	45	20	46	11.7	KNCS 500 KNCSN 500 HG 500 HGN 500 KNCS 630 KNCSN 630 HG 630 HGN 630	THW 500 R THW 600 R Rota-G 500

T-Nuts

Power Chucks

To Suit Howa, Kitagawa, Samchully & Matsumoto (MMK)



**Material: Steel: 817M40
Blackened and Ground**

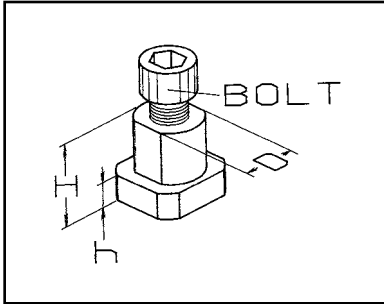
Techleader Part No.	D	H	h	k	Bolt	Howa	Samchully	Kitagawa
GP 03	10	15	5.5	14	M8 x 20	H01MA4 H024M5	HS05	B204 B205
GP 04	8	13.5	4.5	15	M6 x 18			B-04 HOB 4
GR 04	11	16.5	6.5	16	M8 x 20	H027M4 H027M5		
GP 05	10	18	5.5	18	M8 x 22			HOB-5 B-05
GP 06	12	21	7	20	M10 x 25	H01MA6 H015M6 H024M6 H047M6 H07MA6 H022M6 H037M6 H027M6 H023M8		HJA5-6 H06 N-160 AS165 B-160 HOB-6 HOS 6 HOH-160
GP 07	12	18.5	7.5	20	M10 x 25		HS06 HST06 HH206 HC06	B206 B-06 HOH 06 HG738-165 B-07 B-106 B-7 HOH 106 HOH 206
GP 08	14	23	8	25	M12 x 30	H01MA8 H07MA8 H02M8 H015M8		HJA 6-8 B-200 HOB 8 HOS 8 AS 210 HO 8 B-08 N-200 N8 HOH-08K
GP 09	14	20.5	8.2	25	M12 x 30		HS08 HST08 HH208 HC08 HHF208 HSF08	B-108 HOH-108 HG715-210 B 208 HOH 208
GR 10	16	26.5	8.5	25	M12 x 35	H07MA10 H015M10 H022M8 H024M8 H023M10 H027M8 H047M8 H037M8 H034M8		
GP 10	16	23	8	30	M12 x 30	H01MA10 H02M10		B-10 HOH-10 HOB-10 AS 250 N-280 HJA8-10 HOH 250 B-250 HO-10 HOS-10 HG 730-254
GP 11	16	21.5	8.5	30	M12 x 30		HS10 HST10 HC10 HSF10	B-210 HOH 210 B-110 HOH-110
GR 12	18	27.5	9.5	30	M14 x 35	H07MA12 H024M10 H023M12 H037M10 H022M10 H015M12 H027M10 H034M10		
GP 12	18	33	13.5	30	M14 x 45	H01MA12 H02M12		B-300 N-300 HOH-300 HLA6-12 B-12 N-12 HJA8-12 HO-12 HOB-12 HOS-12 HLA6-15 HOH-12 HLA8-15
GP 13	21	28	11.5	30	M16 x 35		HS12 HST12 HH212 HSF12	B-212 B-112 BT-212 HOH-112 HOH-212
GR 13	21	29	10.5	35	M16 x 35	H027M12 H037M12 H034M12 H047M12		
GP 15	22	45.5	16.5	43	M20 x 55		HAH15 HCHF15 HC15 HFC15 HAH18 HCHF18 HC18	B-15 B-380 B-450 HOB-15 HOH-15 HOH-380 B-18 HOB-18
GR 15	26	40	17	42	M20 x 45	H027M15 H047M15		
GP 21	25	45	19	60	M20 x 55			HS450 B530 HS530 HO321 B600 HOB24 H518 B21 HJ21 N21 B24 HS24 N24

Techleader Part No.	D	H	h	K	Bolt	Matsumoto (MMK)		
GS 05	10	16.5	5.5	19	M8 x 20	SA5-6		
GS 06*	11	20	7.5	-	M8 x 25	HA5-6 HH-6 HX-6 HJ-6 H-6 STC-6		
GS 07	11			25		ZA5-6		
GS 08*	14	25.5	9.6	-	M12 x 35	HA6-8 HJ-8 HX-8 HHJ-8 H-8 HH-8 STC-8		
GS 09*	14	24.5	8.5	-	M12 x 35	ZA6-8		
GS 10*	16	23	8	-	M12 x 30	HA8-10 H-10 HHJ-10 HH-10 HHL-10 HX-10 HJ-10 HA8-11 STC-10		
GS 11	16			30		ZA8-10		
GS 12*	18	30	14	-	M14 x 35	HA8-12 HJ-12 HX-12 HHJ-12 H-12 HH-12 HHL12		
GS 13	18			32		ZA8-12		

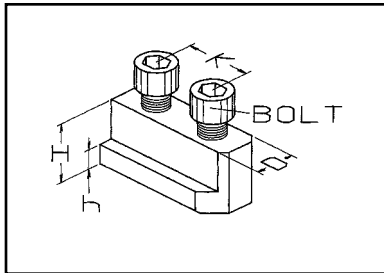
* Split nut type

T-Nuts

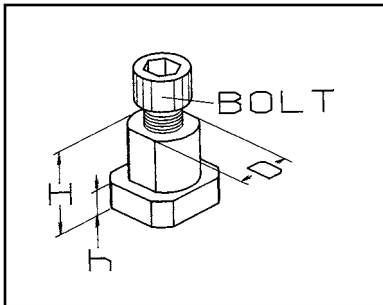
To Suit Forkardt, Pratt Burnerd, Schunk & SMW Power Chucks



GN SINGLE



GG DOUBLE

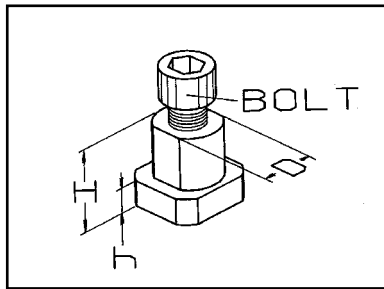


Material:
Steel: 817M40
Blackened and Ground

Techleader Part No.	D	H	h	k	Bolt	Forkardt	Pratt Burnerd	Schunk	SMW
GN 13	12	17	7		M8 x 20	3KTH 130-33 3KTH 140-37			KDV 130
GN 16 GG 20 GG 16	17 17 17	23 23 23	9 9 9	 22 19	M12 X 30 M12 x 30 M12 x 30	3KGF 160/170 KS 160 KGFH 160/175 KSPS 160 KT 160 KL 160 KSH 160 UVE 160 KSF 175 3KSH 200 3KGFH 200 3KTGF 200 3NH200 3NHF 200 KSF200 KS200 KT200 KL200 KSH200 UVE200 KSHF200 KSPS200 KLNC200 KG200 KP200 KS250 UVE250 KSHF 250-55 (Index) 3NHF 250-65 (Index) 3NHF 290-104 (Index) KS250MO KL250MO 2BLE-PS 160 2BLE-PS 200 2BLEF 200	160 International 160 H S Q. C. 165 HYD. Front End 200 International 200 H S Q. C. 210 Hyd. Front End 210 H S Q. C. 250 H S Q. C. 254 International 265 H S Q. C.	TH 165-37 THF 165-37 TH 210-52 THF 210-52 TP 200-52	HFKS 160 KDV 160 KDVG 160 HFK 200/160 HFKS 200 KDV 200 KDVG 200 KDV 250 KDVG 250 KKA 200 KMA 160 KMA 200 KMA 250 KFV 160 KFV 200
GN 25 GG 32 GG 25	21 21 21	27 27 27	11 11 11	 28 25	M16 x 35 M16 x 35 M16 x 35	3NH 250/315 3NHF 250/315 KT 250/315 KSH 250/315 KSHF 250/315 3KTGF 210/315 KG 250/315 KP 250/315 KLNC 250/315 KL 250 KSPS 250/300 3NHF 280 KS 315/400 KSH 400 KSHF 400 UVE 315 3NHF 400 (Index) 2BLE 200 2BLE 250MO	250 International 254 Hyd. Front End 305 Hyd Front End 305 International 305 H S Q. C. 315 International 400 H S Q. C.	TH 250-71 THF 250-71 TP 250-68 TH 315-86 THF 315-86 KDV 315 TP 315-90 TP 315-105 KKA 250/315 KMA 315/400	HFK 250/270 HFK 315 HFKS 250 HFKS 315 KDV 315 KDV 400 KDVG 315 KDVG 400 KZF 200 KFV 250/315
GN 40 GG 40	25.5 25.5	29 29	11 11	 35	M20 x 40 M20 x 40	3NH 400/500/630 3NHF 400/500/630 3KTGF 400/500 UVE 400/500/630/800 KT 400/500 KG 400/500 KL 400/500 KLNC 400/500 KP 400 KS 500/630 KHS 500 KSL 630 KSHF 630 KL 300 KSHF 560 2BLE 250 2BLE 315 2BLE-PS 300 2BLE-PS 315 2BLE 400 2BLE 500 2BLE-PS 400/500	400 International 400 Hyd. Front End 500 Hyd. Front End	TH 380-120 THF 380-120 TH 500-128 THF 500-160 THF 630-160	HFK 400 HFK 500 HFKS 400 HFKS 500 KDV 500 KDVG 500 KDS 630 KZF 250 KZF 315 KZF 400 KKA 400 KFV 400/500 KFV 630/500

T-Nuts

To Suit Autoblok, Gamet, Mikko-Suga, Rohm & SMW-Autoblok Power Chucks



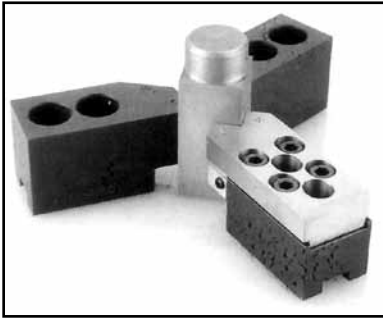
**Material: Steel: 817M40
Blackened and Ground**

Techleader Part No.	D	H	h	K	Bolt	Autoblok & SMW-Autoblok
GF 17	14	20	7.5	-	M10 x 25	IDN 170 HDN 170 IDL 170 HDL 170 GHDN 165 GHDN 170 GHD/FC 170 HDB 170 IMN 170 HMN 170 IML 170 HML 170
GF 18	14	18.5	6.5	16.5	M10 x 20	BHD 165 RCD 165 BBD 175 AND/ALD 165
GF 20	17	22	8	-	M12 x 30	IDN 200 HDN 200 IDL 200 HDL 200 IMN 200 HDN 200 HMN 200 HML 200 CD 200 IDN 220 HDN 220 GHD/FC 210 HDB 220 IML 200
GF 21	17	20.5	7.5	23	M12 x 20	BHD 210 BBD 210 RCD 210 AND/ALD 210
GF 25	21	25	11	-	M16 x 30	IDN 250/315/400 IMN 250/315/400 IDL 250/315/400 IML 250/315/400 HDN 250/315/400 HDM 250/315/400 HDL 250/315/400 HML 250/315/400 GHDN 400 GHDM 400 HDN/FC 400 HDB 300
GF 26	21	26.5	10	30	M16 x 30	BHD 250/315 RCD 250/305 BBD 250/315 AND 250/315 ALD 250/315 HBD 250/315

Techleader Part No.	D	H	h	K	Bolt	Gamet	Nikko-Suga	Rohm
GO 06	11	14.5	6.5	-	M8 x 20	130 N 130 MO 160 GO 160 N 160 MO 170 MF	HF-5 MO-5 HG-5 HF-6AB GO-6 HG-6AB HDM 165 MO-6	KFN 130/160 KFE 170 KFG 160 KFM 130/160
GO 08	14	15.5	6.5	-	M10 x 20	215 N 215 MO 215 GO 215 MF	HF8 MO-8 HG-8 GO-8 MAC 165 HDM-215	KFN 215 KFM 215 KFG 215 KFE 215
GO 11	20	21.5	8.25	-	M12 x 30	250 N 280 N 280 MF 280 MO 280 GO	HF-10 HF-12 HG-10 MO-10/12 GO 10/12 HDM 250/310	KFN 250 KFN 280 KFM 280 KFG 280 KFE 280
GO 14	21	25.5	11	-	M16 x 35	350 N 350 MO 350 GO 350 MF	HF-14 HF-16 MO-14 MAC 250/315 HDM 250/280	KFM 350 KFG 350 KFE 280

TRI Square Top Jaws

For Clamping Square Section on 3 Jaw Chucks



Tri square top jaws are adjustable hard top jaws used on three jaw chucks to clamp a range of square sections. This simple but clever top jaw system removes the need in many instances to use 2 or 4 jaw chucks for the clamping of square section.

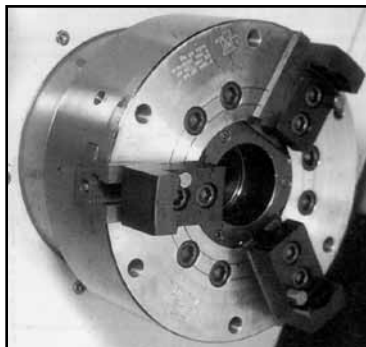
Tri square top jaws are ideal for clamping a series of square parts of different size because of the quick and easy adjustment from one size to another. Tri square top jaws allow more universal use of three jaw chucks allowing the clamping of square and round section – when using chucks as fixtures horizontally on machining centers this can save costs on special fixtures.

Techleader Part No.	Chuck Diameter	Serration	Chuck Type and A/F Clamping Range			
			HOWA H027M	HOWA H037M	KITAGAWA B	KITAGAWA B200
KS 06	160	1.5mm X 60°	10-31.5 A/F	10-31.5 A/F	10-28.0 A/F	10-31.5 A/F
KS 08	200	1.5mm X 60°	11-41.0 A/F	11-41.0 A/F	11-39.5 A/F	12-39.5 A/F
KS 10	250	1.5mm X 60°	14-45.0 A/F	14-43.0 A/F	15-40.0 A/F	14-43.0 A/F
KS 12	315	1.5mm X 60°	23-68.0 A/F	25-68.0 A/F	23-70.0 A/F	

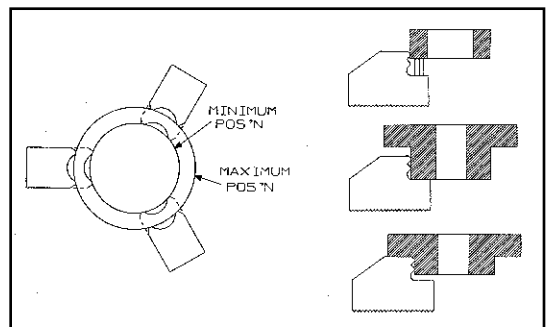
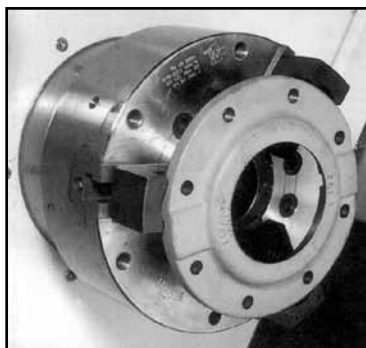
All Tri square top jaw sets are supplied fully assembled and come complete with T-nuts to suit your chuck, jaw bolts and 1 set of the required Allen keys.

Tri square top jaws for other types of chuck are available to order, plus special types to suit irregular, rectangular and polygonal shapes.

ADJUSTAGRIPS – See pages 5-17 to 5-24 & 5-36 to 5-41



- Covering chuck diameters 160 mm to 600 mm
- Gripping range from 15 mm up to 630 mm
- One set will grip various diameters
- Clamping depth varied by a range of height pins
- Radial gripping teeth for high torque and greater safety
- Manufactured in alloy steel for strength
- Lightweight for higher R.P.M.'s with more grip
- Competitively priced
- Stock or short delivery



Adjustagrip jaws give superior grip to standard hard reversible jaws and at lower cost than specially designed hard jaws.

Serration Cleaning Plate



Serration plates are available in three standard types, each supplied in a wooden case with a tube of lapping paste

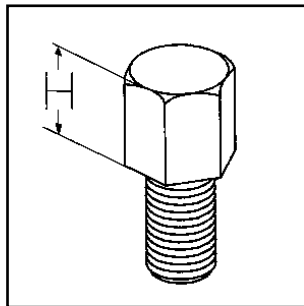
- Allows quick and easy cleaning and deburring of serrated chuck jaws.
- Improved accuracy of mounting to base jaws.
- Extends the working life and precision of the top jaws.
- Keeps jaw serrations in perfect condition.
- Different serration type on reverse of plate.

Simply apply lapping paste and guide jaw onto serrations on plate, move jaw back and forth until serrations are in top condition.

Techleader Part No.	Serration Type		
ES96	1/16" X 90°	and reverse	1.5 mm X 60°
ES99	1/16" X 90°	" "	3/32" x 90°
ES66	1.5mm X 60°	" "	3 mm X 60°



Workpiece Height Pins



- Material: En32 Hardened & Ground.
- Ordering: Please state Techleader Part No.
- Workpiece height pins are for use with Adjustagrip hard jaws or with special jaws requiring a workpiece height location.

Techleader Part No.	H	Width Across Flats	"P" Thread	Suits Adjustagrip Jaw Ranges
IT05 IT10 IT15 IT20	5 10 15 20	10	M6	LA, LB, MA, MB LY 10 - 35
IU05 IU10 IU15 IU20 IU25	5 10 15 20 25	13	M8	LC, LD, LE, LF, MC, MD, ME, MF LY 40 - 43

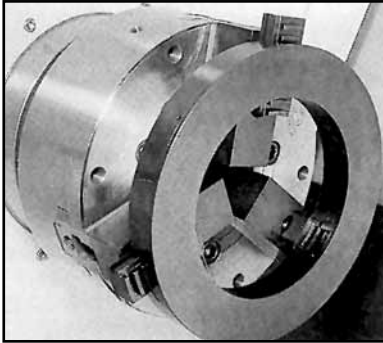


Quick Jaw Change Base Jaw Bolts

Techleader Part No.	Bolt Size	To Suit Base Jaw Type	Techleader Part No.	Bolt Size	To Suit Base Jaw Type
QA12	M8 x 1 x 20	MFG 160, MFG 200	QB 12	M8 x 20	GBK 140, GBK 160, GBK 200
QA32	M12 x 1.5 x 30	MFG 250	QB31	M12 x 25	GBK 250, GBK 315
QA33	M12 x 1.5 x 35	MFG 315	QB32	M12 x 30	GBK 400
QA54	M16 x 1.5 x 40	MFG 400	QB55	M16 x 45	GBK 500, GBK 630

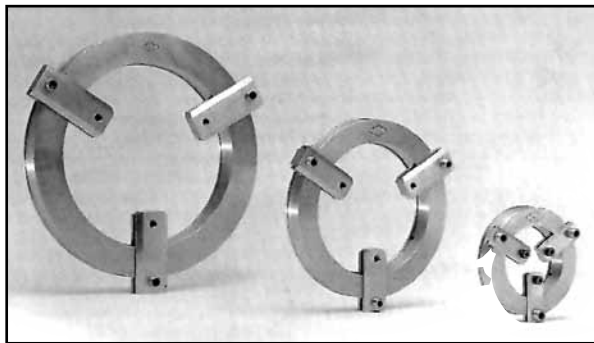
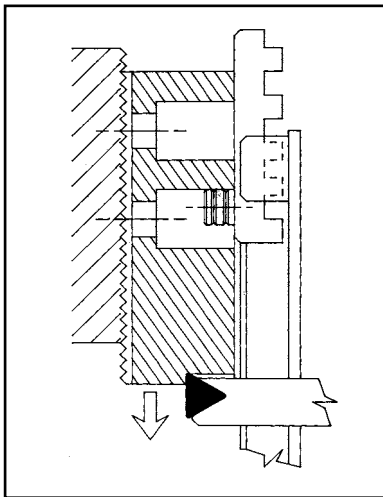
Trueborer

Jaw Boring-Turning Fixture for Power Chucks



- Quick clamping of top jaws to produce perfectly concentric bores or turned diameters
- Allows jaws to be bored or turned at the same clamping pressure required to hold the workpiece
- Only one operation even if through boring jaws
- Saves on jaw usage because of fine adjustment allowing minimal skimming of jaws
- No time wasted looking for, or turning clamping rings
- One Trueborer can be used on many chucks
- For grinding, boring or turning of soft or hard top jaws

Techleader Part No.	Best Suited For Chuck Diameter	Ring Internal Diameter	Ring External Diameter	Jaw Golt Diameter Range	Bolt Diameter	Weight Kg	Max Clamping Pressure
ES 16	125-200	100	180	30-250	13 & 16	4	8000 da N
ES 25	250-315	195	295	100-340	16	10	10000 da N
ES 42	400-600	310	420	180-550	18.5	20	13000 da N



Available in three sizes to cover chuck diameters from 125mm up to 600mm

Operation

- Set top jaws on chuck master jaws to obtain required clamping diameter
- Rotate the back plate on the Trueborer to position the jaw slides so the boltheads can be inserted into the counterbore holes of the top jaws (make sure the bolts are in the correct hole on the slides).
- When in position continue to turn the backplate clockwise for boring or anti-clockwise for turning until it stops and is held tight and parallel against the top jaws.
- Clamp up chuck, Trueborer will hold jaws in required position of chuck stroke to bore or turn jaws under pressure.

The Easiest Way to Bore Soft Jaws

