

SERRATED CHUCK JAWS
POINTED & FLAT END
 1.5MM X 60 Degree Serrations
 1018 Steel Soft Jaws

For Flat Jaws Change The Last Letter Of The Part Number From “P” To “F.”

CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	G GROOVE WIDTH	D HOLE SPACE	SCREW SIZE
4" Kitagawa	B204 B205	EA-KIT-4105P	1	2	1	.394	.551	8MM
		EA-KIT-4205P	2					
4" Matsumoto 5" Matsumoto MMK	Z	EA-KIT-4105P	1	2	1	.394	.551	8MM
		EA-KIT-4205P	2					
5" Kitagawa	B05	EA-KIT-5153P	1-1/2	2-3/8	1	.394	.709	8MM
5" Samchully	HS05	EA-KIT-4105P	1	2	1	.394	.551	8MM
		EA-KIT-4205P	2					
5" Kitagawa	N05	EA-KIT-5150P	1-1/2	2-3/8	1	.394	.748	8MM
		EA-KIT-5250P	2-1/2					
6" Kitagawa	N06, B06, B206, BB206, BS306	EA-KIT-6150P	1-1/2	3	1-1/4	.473	.787	10MM
		EA-KIT-6250P	2-1/2					
		EA-KIT-6300P	3					
6" Samchully	HS06, HAS06, HH206, HCH06, HAH06	EA-KIT-6150P	1-1/2	3	1-1/4	.473	.787	10MM
		EA-KIT-6250P	2-1/2					
		EA-KIT-6300P	3					
6" Howa	H027M, H034M, H037M, H047M, H07MA, H015M, H022M, H024M	EA-KIT-6150P	1-1/2	3	1-1/4	.473	.787	10MM
		EA-KIT-6250P	2-1/2					
		EA-KIT-6300P	3					
6" Matsumoto MMK, Seiki	ZA, HA ---	EA-SG-6152P	1-1/2	3	1-1/4	.433	.984	8MM
		EA-SG-6252P	2-1/2					

For Aluminum Jaws, Add “A” To The End Of The Part Number.
 Please Call For Jaws And T-nuts Not Listed.

T-Nut with Screws

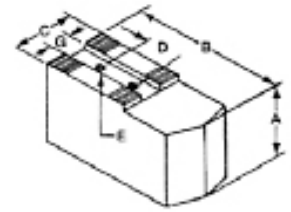
CHUCK	SERIES	EA PART NUMBER
5" Kitagawa	B05	EA-KIT-53JN
6" Kitagawa	B06, N06	EA-KIT-61JN
	B206	EA-KIT-60JN
6" Samchully	HS-06, HAS-06, HH-206	EA-KIT-60JN
	HCH06, HAH06, HC06, HCA06	EA-KIT-61JN

Also See Samchully Brand
 Top Jaws and T-Nuts
 on Pages 69 and 70



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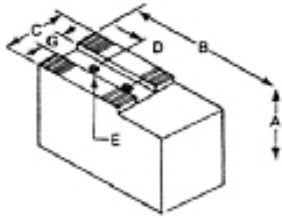
CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	G GROOVE WIDTH	D HOLE SPACE	SCREW SIZE
8" Kitagawa	N08, B08 B208, BB208, BS308	EA-KIT-8200P	2	3-3/4	1-1/2	.551	.984	12MM
		EA-KIT-8201P	2	4				
		EA-KIT-8300P	3	3-3/4				
		EA-KIT-8400P	4	3-3/4				
8" Samchully	HS08, HAS08, H08, HH208, HCH08, HAH08, HC08, HCA08	EA-KIT-8200P	2	3-3/4	1-1/2	.551	.984	12MM
		EA-KIT-8201P	2	4				
		EA-KIT-8300P	3	3-3/4				
		EA-KIT-8400P	4	3-3/4				
8" Howa	H027M, H034M, H037M, H047M	EA-HOWA-8200P	2	3-3/4	1-1/2	.630	.984	12MM
		EA-HOWA-8300P	3					
8" Howa	H07MA, H015M, H022M, H024M	EA-KIT-8200P	2	3-3/4	1-1/2	.551	.984	12MM
		EA-KIT-8201P	2	4				
		EA-KIT-8300P	3	3-3/4				
		EA-KIT-8400P	4	3-3/4				
8" Matsumoto MMK, Seiki	ZA, HA ----	EA-KIT-8200P	2	3-3/4	1-1/2	.551	.984	12MM
		EA-KIT-8201P	2	4				
		EA-KIT-8300P	3	3-3/4				
		EA-KIT-8400P	4	3-3/4				

For Aluminum Jaws, Add “A” To The End Of The Part Number.
 Please Call For Jaws And T-nuts Not Listed.

T-Nut with Screws

CHUCK	SERIES	EA PART NUMBER
8" Kitagawa	B08, N08	EA-KIT-80JN
	B208, BB208	EA-KIT-81JN
8" Samchully	HS-08, HAS-08, HH-208, H-08	EA-KIT-81JN
	HCH08, HAH08, HC08, HCA08	EA-KIT-60JN

Also See Samchully Brand
 Top Jaws and T-Nuts
 on Pages 69 and 70



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For Pointed Jaws Change The Last Letter Of The Part Number From “F” To “P.”

CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	G GROOVE WIDTH	D HOLE SPACE	SCREW SIZE
10" Kitagawa	N10, B10 B210, BB210, BS310	EA-KIT-10200F	2	4-1/2	1-1/2	.630	1.181	12MM
		EA-KIT-10201F	2	5				
		EA-KIT-10300F	3	4-1/2				
		EA-KIT-10400F	4	4-1/2				
10" Samchully	HS10, HAS10, HCH10, HAH10, HC10, HCA10	EA-KIT-10200F	2	4-1/2	1-1/2	.630	1.181	12MM
		EA-KIT-10201F	2	5				
		EA-KIT-10300F	3	4-1/2				
		EA-KIT-10400F	4	4-1/2				
10" Howa	H07MA, H015M, H022M, H024M	EA-HOWA-8200F	2	3-3/4	1-1/2	.630	.984	12MM
		EA-HOWA-8300F	3					
10" Howa	H027M, H034M, H037M, H047M	EA-HOWA-10200F	2	4-1/2	1-1/2	.710	1.181	14MM
		EA-HOWA-10300F	3					
10" Matsumoto MMK	ZA, HA	EA-KIT-10200F	2	4-1/2	1-1/2	.630	1.181	12MM
		EA-KIT-10201F	2	5				
		EA-KIT-10300F	3	4-1/2				
		EA-KIT-10400F	4	4-1/2				

For Aluminum Jaws, Add “A” To The End Of The Part Number.
 Please Call For Jaws And T-nuts Not Listed.

T-Nut with Screws

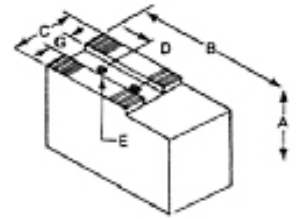
CHUCK	SERIES	EA PART NUMBER
10" Kitagawa	B210, BB210	EA-KIT-100JN
	B10, N10	EA-KIT-101JN
10" Samchully	HS-10, HAS10,	EA-KIT-100JN
	HCH10, HAH10, HC10, HCA10	EA-KIT-101JN

Also See Samchully Brand
 Top Jaws and T-Nuts
 on Pages 69 and 70



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POINTED & FLAT END

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 1018 Steel Soft Jaws



For Pointed Jaws Change The Last Letter Of The Part Number From “F” To “P.”

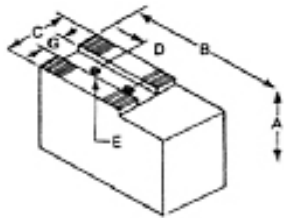
CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	G GROOVE WIDTH	D HOLE SPACE	SCREW SIZE
12" Kitagawa	N12, B12	EA-KIT-12200F	2	5-1/2	2	.710	.984	14MM
		EA-KIT-12300F	3					
		EA-KIT-12400F	4					
12" Kitagawa	B212, BB212	EA-KIT-12208F	2	5-1/2	2	.827	1.181	16MM
		EA-KIT-12308F	3					
		EA-KIT-12408F	4					
12" Samchully	HCH12, HAH12, HC12, HCA12	EA-KIT-12200F	2	5-1/2	2	.710	1.181	14MM
		EA-KIT-12300F	3					
		EA-KIT-12400F	4					
12" Samchully	HS-12, HAS-12, HH212	EA-KIT-12208F	2	5-1/2	2	.827	1.181	16MM
		EA-KIT-12308F	3					
		EA-KIT-12408F	4					
12" Howa	H07MA, H015MA, H022M, H024M	EA-KIT-12200F	2	5-1/2	2	.710	1.181	14MM
		EA-KIT-12300F	3					
		EA-KIT-12400F	4					
12" Howa	H027MA, H034M, H037M, H047M	EA-HOWA-12250F	2-1/2	5-1/2	2	.827	1.378	16MM
		EA-HOWA-12400F	4					
12" Matsumoto	ZA, HA	EA-KIT-12200F	2	5-1/2	2	.710	1.181	14MM
		EA-KIT-12300F	3					
		EA-KIT-12400F	4					

For Aluminum Jaws, Add “A” To The End Of The Part Number.
 Please Call For Jaws And T-nuts Not Listed.

T-Nut with Screws

CHUCK	SERIES	EA PART NUMBER
12" Kitagawa	B212	EA-KIT-128JN
	B12, N12	EA-KIT-120JN
12" Samchully	HS12, HAS12, HH-212	EA-KIT-128JN
	HCH12, HAH12, HC12, HCA12	EA-KIT-120JN

Also See Samchully Brand
 Top Jaws and T-Nuts
 on Pages 69 and 70



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1.5MM X 60 Degree Serrations
 1018 Steel Soft Jaws

For Pointed Jaws Change The Last Letter Of The Part Number From “F” To “P.”

CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	G GROOVE WIDTH	D HOLE SPACE	SCREW SIZE
15" & 18" Samchully	HCH15, HAH15, HCH18, HAH18, HCH18B	EA-KIT-15250F*	2-1/2	6-1/2	2-1/2	.866	1.693	20MM
		EA-KIT-15400F*	4					
15" & 18" Samchully	HC15, HCA15, HC18, HCA18	EA-KIT-15251F*	2-1/2	6-1/2	2-1/2	1.005	1.693	20MM
		EA-KIT-15401F*	4					
15" & 18" Kitagawa	B15, B18	EA-KIT-15250F*	2-1/2	6-1/2	2-1/2	.866	1.693	20MM
		EA-KIT-15400F*	4					
15" & 18" Kitagawa	N15, N18, B215	EA-KIT-15251F*	2-1/2	6-1/2	2-1/2	1.005	1.693	20MM
		EA-KIT-15401F*	4					
21" & 24" Samchully	HCH21, HCH21B, HAH21, HC21, HCA21, HCH24, HAH24, HC24, HCA24	EA-K3-21250F**	2-1/2	7	2-1/2	.984	2.360	20MM
		EA-K3-21400F**	4					
		EA-K3-21600F**	6					
21" & 24" Kitagawa	B21, B24, N21, N24	EA-K3-21250F**	2-1/2	7	2-1/2	.984	2.360	20MM
		EA-K3-21400F**	4					
		EA-K3-21600F**	6					

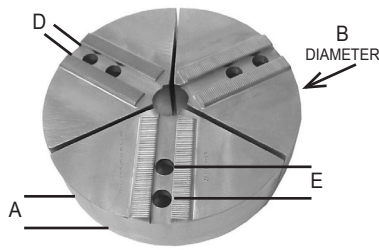
* 1.5 mm x 60 Degree Serrations
 ** 3.0mm x 60 Degree Serrations

T-Nut with Screws

CHUCK	SERIES	EA PART NUMBER
15" & 18" Samchully	HCH15, HAH15, HCH18, HCH18B, HAH18	SAM TN-HCH-15-18
	HC15, HCA15, HC18, HCA18	SAM TNX-HC-15-18***
15" Kitagawa	B215	EA-KIT-151JN
15" & 18" Kitagawa	B15, B18	SAM TN-HCH-15-18
	N15, N18	SAM TNX-HC-15-18***
21" & 24" Samchully	HCH21, HCH21B, HAH21, HC21, HCA21, HCH24, HAH24, HC24, HCA24	SAM TN-HCH-21-24 (FOR SOFT JAWS ONLY)
		SAM TNX-HC-21-24*** (FOR SOFT JAWS OR HARD JAWS)
21" & 24" Kitagawa	B21, B24, N21, N24	SAM TN-HCH-21-24 (FOR SOFT JAWS ONLY)
		SAM TNX-HC-21-24*** (FOR SOFT JAWS OR HARD JAWS)

*** SAM TNX-HC-15-18 and SAM TNX-HC-21-24
 Require two T-nuts per jaw.

Also See Samchully Brand
 Top Jaws and T-Nuts
 on Pages 69 and 70



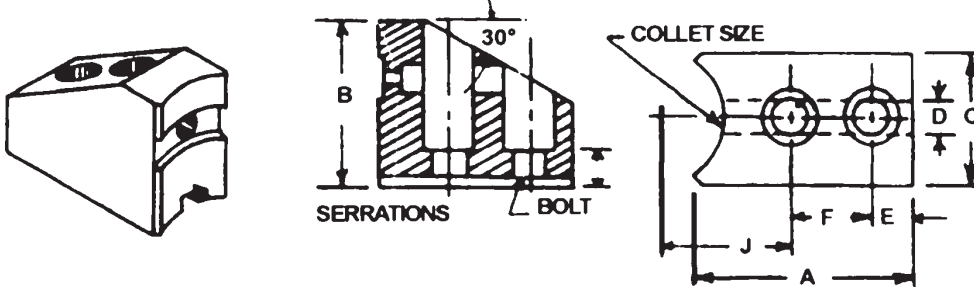
ALUMINIUM ROUND JAWS
 1.5mm x 60 Degree Serrations

CHUCK	SERIES	EA PART NUMBER	A HEIGHT	B DIA.	D GROOVE WIDTH	E HOLE SPACE	SCREW SIZE
6" Kitagawa	B06, B206, BB206, N06, BS306	EA-KIT-662R	2	6	.473	.787	10MM
		EA-KIT-664R	4				
6" Samchully	HS06, HAS06, HH206, HCH06	EA-KIT-662R	2	6	.473	.787	10MM
		EA-KIT-664R	4				
8" Kitagawa	B08, B208, BB208, N08, BS308	EA-KIT-882R	2	8	.551	.984	12MM
		EA-KIT-883R	3				
		EA-KIT-884R	4				
8" Samchully	HS08, HAS08, H08, HH208, HCH08, HAH08, HC08, HCA08	EA-KIT-882R	2	8	.551	.984	12MM
		EA-KIT-883R	3				
		EA-KIT-884R	4				
8" Matsumoto MMK,SEIKI	ZA, HA ---	EA-KIT-882R	2	8	.551	.984	12MM
		EA-KIT-883R	3				
		EA-KIT-884R	4				
10" Kitagawa	B10, B210, BB210, N10, BS310	EA-KIT-10102R	2	10	.630	1.181	12MM
		EA-KIT-10103R	3				
		EA-KIT-10104R	4				
10" Samchully	HS10, HAS10, HCH10, HAH10, HC10, HCA10	EA-KIT-10102R	2	10	.630	1.181	12MM
		EA-KIT-10103R	3				
		EA-KIT-10104R	4				
10" Matsumoto MMK	ZA, HA	EA-KIT-10102R	2	10	630	1.181	12MM
		EA-KIT-10103R	3				
		EA-KIT-10104R	4				
12" Kitagawa	B12, N12	EA-KIT-121225R	2-1/2	12	710	1.181	14MM
12" Samchully	HCH12, HAH12, HC12, HCA12	EA-KIT-121225R	2-1/2	12	710	1.181	14MM
12" Kitagawa	B212, BB212	EA-KIT-1212208R	2	12	.827	1.181	16MM
		EA-KIT-121248R	4				
12" Samchully	HS-12, HAS-12, HH212	EA-KIT-1212208R	2	12	.827	1.181	16MM
		EA-KIT-121248R	4				
12" Howa	H07MA, H015M, H022M, H024M	EA-KIT-121225R	2-1/2	12	.710	1.181	14MM
12" Matsumoto MMK	ZA, HA	EA-KIT-121225R	2-1/2	12	.710	1.181	14MM

For Cast Iron Jaws Add The Suffix "CI" To Part Number.
 For Steel Jaws Add The Suffix "S" To The Part Number.



COLLET PAD TOP JAWS



CHUCK	SERIES	EA PART NUMBER	PAD SERIES	A	B	C	D	E	F	J	BOLT SIZE
6"	KITAGAWA B06, B206, BB206, BS306, N06	EA-B206CPJ3	#3	2-1/4	2	1-1/4	.473	.4	.787	1.81	10MM
8"	KITAGAWA B08, B208, BB208, BS308, N08, MATSUMOTO MMK ZA, HA	EA-B208CPJ3	#3	3-1/2	2-1/2	1-1/2	.551	3/4	.984	2.25	12MM
		EA-B208CPJ4	#4	3-1/8							
		EA-B208CPJ5	#5	3/4							
10"	KITAGAWA B10, B210, BB210, BS310, N10 MATSUMOTO MMK ZA, HA	EA-B210CPJ3	#3	4-1/2	2-1/2	2	.630	13/16	1.181	3.00	12MM
		EA-B210CPJ4	#4	4-1/8							
		EA-B210CPJ5	#5	3-13/16							
		EA-B210CPJ6	#6*	3-1/2							
12"	KITAGAWA B12, N12 MATSUMOTO MMK ZA, HA	EA-B12CPJ4	#4	4-1/2	2-1/2	2	.710	13/16	1.181	3.00	14MM
		EA-B12CPJ5	#5	4							
		EA-B12CPJ6	#6*	3-3/4							
12"	KITAGAWA B212, BB212	EA-B212CPJ4	#4	4-1/2	2-1/2	2	.827	13/16	1.181	3.00	16MM
		EA-B212CPJ5	#5	4							
		EA-B212CPJ6	#6*	3-3/4							
15" & 18"	KITAGAWA B15, B18	EA-B15CPJ6	#6*	4-7/8	3-1/2	2-1/2	.866	1	1.693	3.50	20MM

BORING INSTRUCTIONS:

Note: Other serrations and types of Collet Pad Top Jaws are available.
* #6 IS THE #5 3" CAPACITY PAD.

Collet Pad Bore To Size

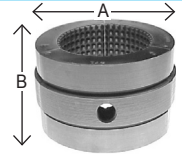
#3	1.875"
#4	2.375"
#5	3.000"
#6	3.500"

COLLET PAD TOP JAWS are supplied with material left for boring to ensure accuracy and concentricity.

- 1) Clean serrations on master jaws in the chuck and on the collet pad top jaws.
- 2) Mark jaws with the number of the master jaw you bolt them on. If removed, always put them back on the same master jaw.
- 3) Bolt on two jaws. Position the triangle truing plate between the jaws. The edge of the plate stamped "O" goes on the flat surface towards the bottom of the jaw. Bolt on the third jaw.
- 4) When chucking on the triangle truing plate, the I.D. of the collet pad top jaw should be approximately .050" undersize.
- 5) While chucking on the triangle truing plate bore the collet pad top jaw to the correct size listed above.
- 6) Remove the truing plate, debur the bored area and bolt on your collet pads.



COLLET PADS



#3 Warner & Swasey Style Collet Pads

EA PART NUMBERS	DESCRIPTION	STANDARD SIZES	PAD DIMENSIONS	
			A	B
461-1003	Round Smooth	9/64" to 1-1/2"	1-7/8"	1-3/8"
461-1004	Round Serrated	9/32" to 1-1/2"		
461-1023	Square Smooth	3/16" to 1-1/16"		
461-1025	Square Serrated	3/8" to 1-1/16"		
461-1024	Hex Smooth	1/8" to 1-3/8"		
461-1026	Hex Serrated	3/8" to 1-5/16"		
461-BLANK	Machineable Blank	-----		

#4 Warner & Swasey Style Collet Pads

EA PART NUMBERS	DESCRIPTION	STANDARD SIZES	PAD DIMENSIONS	
			A	B
1129-1004	Round Smooth	1/8" to 2"	2-3/8"	1-3/4"
1129-1007	Round Serrated	1/4" to 2"		
1129-1005	Square Smooth	3/16" to 1-3/8"		
1129-1008	Square Serrated	3/8" to 1-3/8"		
1129-1006	Hex Smooth	1/4" to 1-3/4"		
1129-1009	Hex Serrated	3/8" to 1-3/4"		
461-BLANK	Machinable Blank	-----		

#5 (std.) Warner & Swasey Style Collet Pads

EA PART NUMBERS	DESCRIPTION	STANDARD SIZES	PAD DIMENSIONS	
			A	B
471-1002	Round Smooth	3/16" to 2-1/2"	3"	1-7/8"
471-1005	Round Serrated	5/16" to 2-1/2"		
471-1023	Square Smooth	1/4" to 1-3/4"		
471-1026	Square Serrated	3/8" to 1-3/4"		
471-1024	Hex Smooth	1/4" to 2-3/16"		
471-1027	Hex Serrated	3/8" to 2-3/16"		
471-BLANK	Machineable Blank	-----		

#5 (3" cap) Warner & Swasey Style Collet Pads

EA PART NUMBERS	DESCRIPTION	STANDARD SIZES	PAD DIMENSIONS	
			A	B
4669-1165	Round Smooth	1/4" to 3"	3-1/2"	2-5/16"
4669-1162	Round Serrated	5/16" to 3"		
4669-1166	Square Smooth	1/4" to 2-1/8"		
4669-1163	Square Serrated	5/8" to 2-1/8"		
4669-1167	Hex Smooth	1/4" to 2-5/8"		
4669-1164	Hex Serrated	3/8" to 2-5/8"		
4669-BLANK	Machineable Blank	-----		

"S20" Style Collet Pads

EA PART NUMBER	DESCRIPTION	PAD CAPACITY
EA70-S20RSM	Round Smooth	2"
EA70-S20RSE	Round Serrated	1-5/16"
EA70-S20HSM	Hex Smooth	1-23/32"
EA70-S20HSE	Hex Serrated	
EA70-S20SSM	Square Smooth	1-13/32"
EA70-S20SSE	Square Serrated	
EA70-S20-BLANK	Machineable Blank	-----



"S30" Style Collet Pads

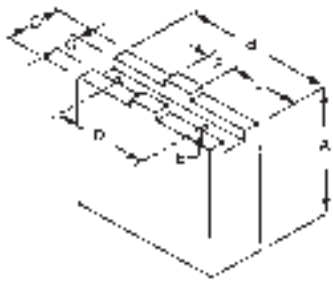
EA PART NUMBER	DESCRIPTION	PAD CAPACITY
EA70-S30RSM	Round Smooth	3"
EA70-S30RSE	Round Serrated	
EA70-S30HSM	Hex Smooth	2-19/32"
EA70-S30HSE	Hex Serrated	
EA70-S30SSM	Square Smooth	2-3/32"
EA70-S30SSE	Square Serrated	
EA70-S30-BLANK	Machineable Blank	-----

"S26" Style Collet Pads

EA PART NUMBER	DESCRIPTION	PAD CAPACITY
EA70-S26RSM	Round Smooth	2-5/8"
EA70-S26RSE	Round Serrated	1-9/16"
EA70-S26HSM	Hex Smooth	2-1/4"
EA70-S26HSE	Hex Serrated	
EA70-S26SSM	Square Smooth	1-27/32"
EA70-S26SSE	Square Serrated	
EA70-S26-BLANK	Machineable Blank	-----

"S" Style Accessories

EA PART NUMBER	DESCRIPTION
EA70-S-CLAMP	Clamp Assembly For S20, S26
EA70-S-CLAMP-2	Clamp Assembly For S30, S35, S40, S50
EA70-S-WRENCH	Wrench For S20, S26
EA70-S-WRENCH-2	Wrench For S30, S35, S40, S50



TONGUE & GROOVE SOFT CHUCK JAWS
 1018 Steel

MEDIUM DUTY For Pointed Jaws Change The Last Letter Of The Part Number From "F" To "P."

CHUCK SIZE	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	D HOLE SPACE	E SCREW SIZE	F TONGUE WIDTH	G GROOVE WIDTH
6"	EA-TG-6200F	2	2-3/4	1	1-1/2	3/8	.499	.312
	EA-TG-6300F	3						
6" BUCK	EA-BUCK-TGBT06F*	1-1/2	3	1	1-11/16	5/16	.376	.741
8"	EA-TG-8200F	2	3-3/4	1-1/4	1-3/4	3/8	.499	.312
	EA-TG-8300F	3						
	EA-TG-8400F	4						
10"	EA-TG-10200F	2	4-1/2	1-1/2	2-1/8	1/2	.749	.501
	EA-TG-10300F	3						
	EA-TG-10400F	4						
12"	EA-TG-12200F	2	5-1/4	1-3/4	2-1/2	1/2	.749	.501
	EA-TG-12300F	3						
	EA-TG-12400F	4						
15"	EA-TG-15250F	2-1/2	5-3/4	1-3/4	3	5/8	.749	.501
	EA-TG-15400F	4						

* This Jaw Is For A 6" Buck Chuck That Uses Seperate Top Jaws. This Is Not A True Tongue & Groove, But The Reverse Of A Tongue & Groove Jaw.

HEAVY DUTY For Pointed Jaws Change The Last Letter Of The Part Number From "F" To "P."

CHUCK SIZE	EA PART NUMBER	A HEIGHT	B LENGTH	C WIDTH	D HOLE SPACE	E SCREW SIZE	F TONGUE WIDTH	G GROOVE WIDTH
8"	EA-TG-8205F	2	3-3/4	1-1/2	1-3/4	1/2	.499	.312
	EA-TG-8305F	3						
10"	EA-TG-10205F	2	4-1/2	1-3/4	2-1/8	5/8	.749	.501
	EA-TG-10305F	3						
	EA-TG-10405F	4						
12"	EA-TG-12255F	2-1/2	5-1/4	2	2-1/2	5/8	.749	.501
	EA-TG-12405F	4						