STAR TOOL SUPPLY / GRAND TOOL SUPPLY
Tel: 201-518-8461 / Fax: 201-596-3427
650 Huyler St / So. Hackensack, NJ 07606 USA

5-C EXPANDING COLLETS

SERIES 326:

EAGLE ROCK®

Made In U.S.A.

MEDA Superior Import

5-C EXPANDING COLLET SETS

4 Piece Set allows "internal chucking" within the range .250" through 1.937". Heads are machinable. Shanks are precision ground to maintain concentricity with ±.0005".

Size	Range	MEDA Order No.	MEDA Price	EAGLE ROCK Order No.	EAGLE ROCK Price
1	.250 - .468	1980001		3260121	
2	.437 - .800	1980002		3260110	
3	.750 - 1.437	1980003		3260112	
4	.750 - 1.937	1980004		3261201	
Complete set of 4 on a wooden rack.					
1-4	.250 - 1.937	1980005		3260005	

The most effective and accurate means of internal chucking for short runs to mass production. Once seated in spindle and machined to size, these collets can hold concentricity well within .0005". Applicable on any manual or CNC Lathe, Milling Machine or Grinder with a 5C spindle. Machinable to any configuration within their stock and minimum machinable diameters. Collets with diameters 4" and larger have a lock ring for greater stability and accuracy while machining to their specific application.

EAGLE ROCK

Dia.	Lgth.	Min. Mach. Dia.	Order No.	Price
1/2"	1"	.250"	3260121	
1/2"	*2"	.250"	3260122	
1/2"	*3"	.250"	3260123	
1"	1"	.437"	3260110	
1"	*2"	.437"	3260120	
1"	*3"	.437"	3260130	
1-1/2"	1"	.750"	3260112	
1-1/2"	1-1/2"	.750"	3261121	
1-1/2"	2"	.750"	3261122	
1-1/2"	2-1/2"	.750"	3261212	
1-1/2"	3"	.750"	3261123	
2"	1"	.750"	3261201	
2"	1-1/2"	.750"	3262212	
2"	2"	.750"	3262203	
2"	2-1/2"	.750"	3262221	
2"	3"	.750"	3262230	
2-1/2"	1"	.750"	3262121	
2-1/2"	1-1/2"	.750"	3262122	
2-1/2"	2"	.750"	3262120	
2-1/2"	2-1/2"	.750"	3262222	
2-1/2"	3"	.750"	3262123	
3"	1"	.750"	3263010	
3"	1-1/2"	.750"	3263015	
3"	2"	.750"	3263020	
3"	2-1/2"	.750"	3263025	
3"	3"	.750"	3263030	
4"	1"	.750"	3264010	
4"	1-1/2"	.750"	3264012	
4"	2"	.750"	3264020	
4"	2-1/2"	.750"	3264212	
4"	3"	.750"	3264030	
5"	2"	.750"	3265020	
6"	2"	.750"	3266020	

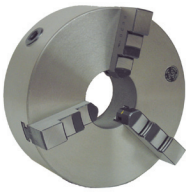
* Extended 5C Expanding Collets - Made for holding delicate or long and narrow parts or where there is a machine clearance problem. Machinable to any dimension within their range, only the front (1" long) expands.

THREE-JAW SELF-CENTERING UNIVERSAL LATHE CHUCKS

MEDA Superior Import

SERIES 995:

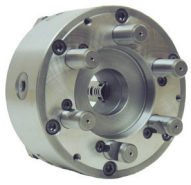
Reversible 2 piece jaws except where noted



Plain Back

Chuck Dia.	Thru Hole	Order No.	Price
3"	.630"	2670003	
4"	.866"	2670004	
5"	1.181"	2670005	
6"	1.575"	2670006	
8"	2.559"	2670008	
10"	3.150"	2670010	
12"	3.937"	2670012	

* 2 sets of solid jaws.



D-1 Type Mount

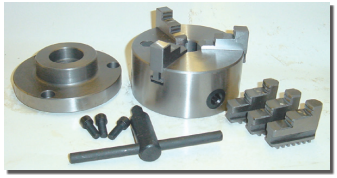
Chuck Dia.	Spindle	Thru Hole	Order No.	Price
6"	D1-4	1.575"	2670604	
8"	D1-4	1.969"	9670804	
8"	D1-6	1.969"	2670806	
10"	D1-6	2.756"	2671006	
12"	D1-6	3.937"	2671206	
12"	D1-8	3.937"	2671208	

THREE-JAW SELF CENTERING THREADED BACK UNIVERSAL CHUCKS

MEDA Superior Import

SERIES 995:

5" & 6" x 1 - 1/2 - 8



5" or 6" Diameter 3-Jaw Universal Lathe Chuck, Plain Back. 2 sets of hardened and ground jaws for inside and outside holding. Chuck Key. High quality cast iron body.

Plus 5" or 6" x 1-1/2"-8 Back Plate made for the chuck (Chuck can be used by itself or with included back plate.)

5" Order No. 2670512	Price	
6" Order No. 2670612	Price	

Tel: 201-518-8461 / Fax: 201-596-3427
650 Huyler St / So. Hackensack, NJ 07606 USA

CUSHMAN INDUSTRIES

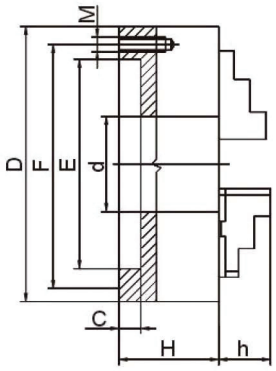
THREE-JAW, SELF-CENTERING SCROLL CHUCKS
PRECISION, PLAIN BACK
SERIES 269:

CUSHMAN INDUSTRIES

Forged Steel Body, Medium Duty

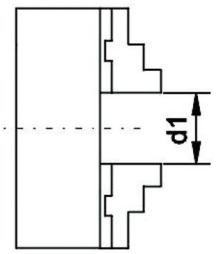
Special Features:
- Medium Duty Forged Steel Body Chucks, for use on all types of lathes, and on a different kinds of milling, drilling and CNC attachments
- Chucks come with two sets of hard top reversible jaws and hard master jaws
- Plain back mount, for use with mounting plates
- Chuck body is made of high quality forged steel. All guide ways and bearing surfaces are heat treated and precisely ground.
- Scroll plate, pinions and jaws are drop forged of fine alloy steel, hardened and ground
- Each scroll and chuck are balanced

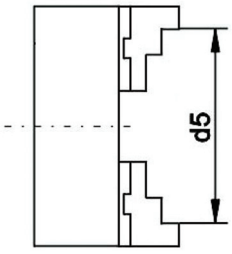
Standard Accessories:
- 1 set of hard top jaws
- 1 set of hard master jaws
- 1 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- 2 lifting eye bolts
- Chuck Manual
- Q.A. Certificate



Chuck Dia. D	Bolt Pattern F	E (H7)	d	H	h	C	Mounting Bolts M		Max. RPM	Est. Gross Weight (lbs)	Order No.	Price
							Thread	Qty.				
6-1/4"	5.5118	4.9213	1.6535	2.756	1.693	0.1575	M8X1.25	6	4500	22.5	**2690001**	
8"	6.9291	6.2992	2.1654	3.15	1.772	0.1575	M10X1.5	6	4000	42	**2690002**	
10"	8.8189	7.874	2.9921	3.543	2.087	0.1969	M10X1.5	6	3500	73	**2690003**	
12-1/2"	11.2598	10.236	4.0551	3.937	2.244	0.1969	M12X1.75	6	2800	129	**2690004**	
15-3/4"	14.2519	12.9921	5.3543	4.331	2.693	0.1969	M16X2	6	2000	227	**2690005**	
20"	18.0314	16.5354	7.4803	4.685	3.15	0.1969	M16X2	6	1200	361	**2690006**	
25"	23.0709	21.4567	9.9212	5.079	3.425	0.2756	M16X2	6	1000	592	**2690007**	

Gripping Capacity





Chuck Dia. D	Gripping Capacity	
	Min. d1	Max. d5
6-1/4"	0.118	6.3
8"	0.157	7.87
10"	0.197	9.84
12-1/2"	0.394	12.4
15-3/4"	0.394	15.75
20"	0.787	19.69
25"	1.18	24.8

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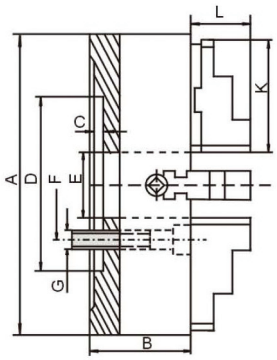
650 Huyler St / So. Hackensack, NJ 07606 USA

FOUR-JAW, INDEPENDENT CHUCKS
PLAIN BACK
SERIES 269:

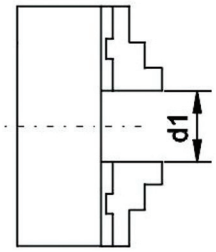
Semi Steel Body, 2 Piece Jaws, Medium Duty

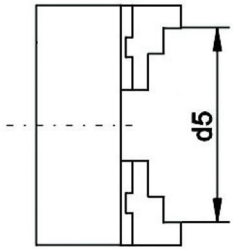
Special Features:
- Medium Duty Semi-Steel Body
- American Standard Tongue and Groove Jaw Mount
- Hard Top and Master Jaws and operating screws are case hardened and precisely ground
- Chuck guideway surfaces are precisely machined
- All chuck face and OD surfaces are precisely ground to insure highest accuracy of every chuck
- Heavy jaw serration ensures high gripping power
- 10" - 50" chucks are provided with the T-Slots

Standard Accessories:
- 1 set of hard top jaws
- 1 set of hard master jaws
- 1 T wrench
- 1 L wrench (40" and 50" chucks only)
- 1 set of chuck mounting bolts
- 2 hex keys
- 2 eye bolts (chucks 10" and up)
- 2 lifting eye bolts



Gripping Capacity





Chuck Dia. D	Bolt Pattern F	D (H7)	E	B	L	K	C	Mounting Bolts G		Max. RPM	Est. Gross Weight (lbs)	Gripping Capacity		Order No.	Price
								Thread	Qty.			Min. d1	Max. d5		
8"	3.74	2.953	2.205	2.953	1.827	3.228	0.236	M10	4	1800	36	0.394	7.874	**2690008**	
10"	4.126	5.906	2.559	3.347	2.378	3.799	0.276	M12	4	1500	62	0.591	9.843	**2690009**	
12-1/2"	5.252	6.89	3.15	3.74	2.398	4.429	0.276	M16	4	1200	97	0.787	12.402	**2690010**	
15-3/4"	6.748	7.874	3.937	4.134	2.847	5.079	0.394	M16	4	800	158	0.984	15.748	**2690011**	
20"	9.252	10.63	4.921	4.724	3.555	5.354	0.472	M20	4	500	246	1.378	19.685	**2690012**	
25"	9.252	10.63	6.299	5.512	3.85	5.354	0.472	M20	4	400	385	1.969	24.803	**2690013**	
32"	11.811	9.843	8.268	5.315	3.693	5.354	0.472	M20	8	300	730	2.756	31.496	**2690014**	
40" *	14.567	12.598	10.236	5.906	4.685	6.299	0.591	M20	8	150	850	3.937	39.73	**2690015**	
50" *	19.685	15.748	12.008	6.496	4.685	6.299	0.591	M20	8	100	1650	4.921	49.213	**2690016**	

*Cast Steel Body

While we show some of the most popular CUSHMAN INDUSTRIES items, we can supply their entire range of products. See our website or inquire.

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CUSHMAN INDUSTRIES

THREE AND SIX JAW, SELF-CENTERING SCROLL CHUCKS

HIGH PRECISION, 0.0004" T.I.R., ADJUSTABLE

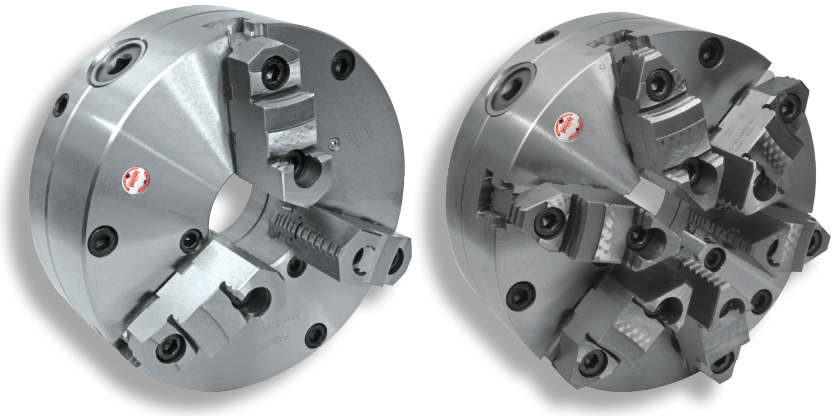
SERIES 269:

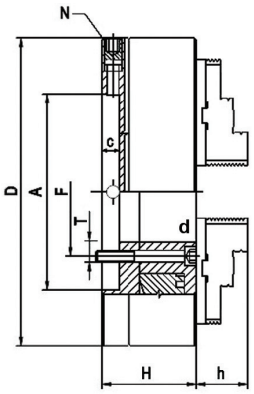
CUSHMAN INDUSTRIES

Forged Steel Body, Medium Duty

Special Features:
- Medium Duty Forged Steel Body
- American Standard Tongue and Groove Jaw Mount
- Two Piece/Reversible Stepped Hard Jaws
- Micro Adjustable Screws provide 0.0004" T.I.R repeatability
- 3 pinion design
- Scrolls, pinions, jaw guideways, hub and jaws are precisely hardened and ground
- Wide selection of precision steel adapters are available from stock
- All chuck two piece bodies are made of high quality forged steel guaranteeing high rigidity, accuracy and long life

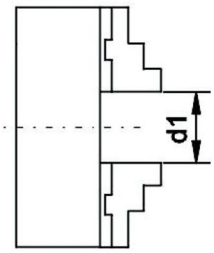
Standard Accessories:
- 1 set of hard top jaws
- 1 set of hard master jaws
- 1 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- 2 lifting eye bolts
- Chuck Manual
- Q.A. Certificate

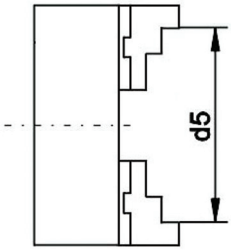




Chuck Dia. D	Bolt Pattern F	A	Thru Holed	H	h	c	Mounting Bolts T		Fine Adjustment Screws N		Max. RPM		Est. Gross Weight (lbs)		3 Jaw Chuck		6 Jaw Chuck	
							Thread	Qty.	Thread	Qty.	3 Jaw	6 Jaw	3 Jaw	6 Jaw	Order No.	Price	Order No.	Price
6-1/4"	5.5118	3.386	1.654	2.677	1.71	0.67	M10x1.5	3	M12x1	4	3500	2500	21	25	**2690017**		**2690024**	
8"	6.9291	4.331	2.165	3.071	1.77	0.71	M10x1.5	3	M18x1.5	4	3100	2200	35	42	**2690018**		**2690025**	
10"	8.8189	5.709	2.992	3.054	2.05	0.79	M12x1.75	3	M18x1.5	4	2700	1900	59	78	**2690019**		**2690026**	
12-1/2"	11.2598	7.087	4.055	3.819	2.24	0.79	M16x2	3	M18x1.5	4	2200	1500	105	128	**2690020**		**2690027**	
15-3/4"	6.750	11.782	5.354	4.803	2.64	0.87	5/8x11	6	M18x1.5	8	1800	1500	201	250	**2690021**		**2690028**	
20"	9.252	16.032	7.480	5.669	3.11	1.18	3/4x10	6	M18x1.5	8	1200	800	377	397	**2690022**		**2690029**	
25"	13.000	16.032	9.921	5.905	3.43	1.18	3/4x10	6	M18x1.5	8	1000	700	630	647	**2690023**		**2690030**	

Gripping Capacity





3 Jaw Chucks

Chuck Dia. D	Gripping Capacity	
	Min. d1	Max. d5
6-1/4"	0.118	6.3
8"	0.157	7.87
10"	0.197	9.84
12-1/2"	0.394	12.4
15-3/4"	0.394	15.75
20"	0.787	19.69
25"	1.18	24.8

6 Jaw Chucks

Chuck Dia. D	Gripping Capacity	
	Min. d1	Max. d5
6-1/4"	0.315	6.3
8"	0.315	7.87
10"	0.47	9.84
12-1/2"	0.47	12.4
15-3/4"	0.59	15.75
20"	1.18	19.69
25"	1.57	24.8

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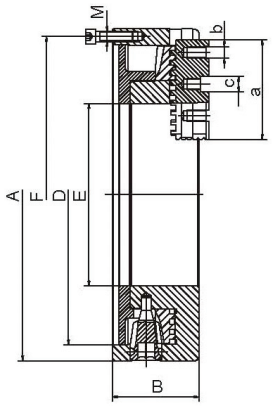
THREE-JAW SELF-CENTERING PRECISION CHUCKS
WITH EXTRA LARGE THRU-HOLE
SERIES 269:

Forged Steel Body, Low Profile Design

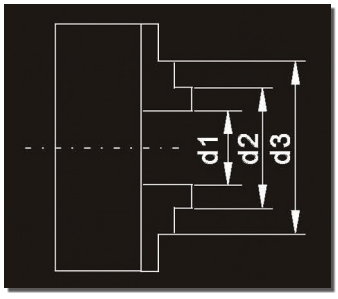
Special Features:
- Designed for pipe machining, such as pipe welding and cut off operations
- Chucks can be used on lathes, milling machines, rotary tables, indexers or welding fixtures
- Chucks are provided with two-piece reversible American Standard Tongue and Groove jaws
- Forged Steel Body
- 3 Pinion design
- Each forged scroll is precisely balanced
- Chuck body guideways and hub are heat treated and ground
- Jaws, scroll and pinions are heat treated and ground

Standard Accessories:
- 1 set of hard top jaws
- 1 set of master jaws
- 1 chuck wrench
- 1 set of mounting bolts
- 2 hex keys
- 2 lifting eye bolts
- Chuck Manual
- Q.A. Certificate

Optional Accessories:
- HD hard top jaws
- Soft top jaws
- Adapter plates
- Semi-finished adapters



Chuck Dia. A	Thru Hole E	Jaw Stroke		Weight of Workpiece lbs.		B	Bolt Pattern F	D (H7)	a	M	b	c	Max RPM	Est. Gross Weight (lbs)	Order No.	Price
		min.	max.	without support	with support											
15 ¾"	8.66	6.614	11.34	110	3307	4.13	15.000	14.252	4.72	M12x40	5/8"-11	.74996	650	158	**2690031**	
20"	12.60	9.874	14.96	177	5512	4.72	18.957	18.189	4.75	M12x40	3/4"-10	.74996	460	260	**2690032**	
26"	15.98	14.800	19.57	265	7716	5.32	24.409	22.835	5.00	M16x40	3/4"-10	.74996	325	325	**2690033**	
31 ½"	16.14	7.402	22.28	441	8820	5.95	18.110	27.953	8.86	M24x160	3/4"-10	.74996	260	598	**2690034**	



Chuck Dia.	d1		d2		d3	
	min.	max.	min.	max.	min.	max.
15 ¾"	5.12	10.63	9.06	13.78	11.81	15.75
20"	9.84	14.96	12.99	17.72	15.16	19.69
26"	14.8	18.5	17.91	22.64	20.28	25
31 ½"	10.24	22.28	14.17	29.53	16.54	31.5

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CUSHMAN INDUSTRIES

ADAPTERS

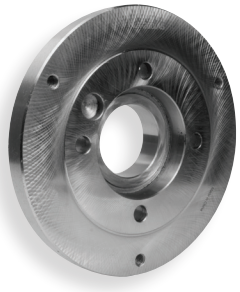
SERIES 269:

CUSHMAN INDUSTRIES

Fully Machined Steel Adapters for 3 Jaw and 6 Jaw Adjustable Chucks

Type D Mounting Plates - "Camlock"

Spindle	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Price							
D-3	2690035	-	-	-	-	-	-
D-4	2690036	2690038	-	-	-	-	-
D-5	2690037	2690039	2690041	-	-	-	-
D-6	-	2690040	2690042	2690044	2690047	-	-
D-8	-	-	2690043	2690045	2690048	2690050	2690053
D-11	-	-	-	2690046	2690049	2690051	2690054
D-15	-	-	-	-	-	2690052	2690055



Type A American Standard Short Taper A-1 and A-2 Spindles

Spindle	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Price							
A-5	2690057	2690058	2690060	-	-	-	-
A-6	-	2690059	2690061	2690063	2690066	-	-
A-8	-	-	2690062	2690064	2690067	2690069	2690072
A-11	-	-	-	2690065	2690068	2690070	2690073
A-15	-	-	-	-	-	2690071	2690074

Threaded Spindles

Spindle	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Price							
1-1/2"-8	2690075	2690077	-	-	-	-	-
2-1/4"-8	2690076	2690078	-	-	-	-	-
2-3/8"-6	-	2690079	2690080	2690081	-	-	-

Fully machined Adapters, Semi-Steel for 3 Jaw Plain Back Chucks

Type D Mounting Plates - "Camlock"

Spindle	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
Price							
D-3	2690082	-	-	-	-	-	-
D-4	2690083	2690085	-	-	-	-	-
D-5	2690084	2690086	2690088	-	-	-	-
D-6	-	2690087	2690089	2690090	2690093	-	-
D-8	-	-	2690143	2690091	2690094	-	-
D-11	-	-	-	2690092	2690095	2690096	2690098
D-15	-	-	-	-	-	2690097	2690099

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CUSHMAN INDUSTRIES

ADAPTERS
SERIES 269:

CUSHMAN INDUSTRIES

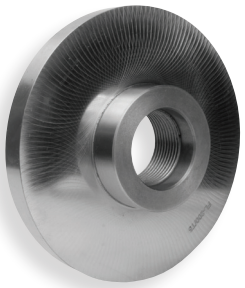
Semi Finished Adapters for 3 Jaw Scroll and 4 Jaw Independent Chucks

Type A American Standard Short Taper A-1 and A-2 Spindles

Spindle / Price	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
A-4	-	2690100	-	-	-	-	-
A-5	-	2690101	2690103	-	-	-	-
A-6	-	2690102	2690104	2690106	2690109	-	-
A-8	-	-	2690105	2690107	2690110	2690112	2690114
A-11	-	-	-	2690108	2690111	2690113	2690115
A-15	-	-	-	-	-	2690144	2690116

Threaded Spindles

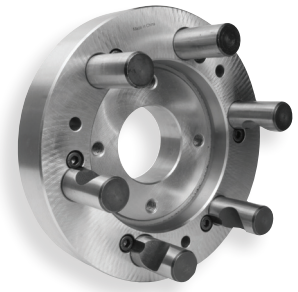
Spindle / Price	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"	25"
1-1/2"-8	-	2690117	-	-	-	-	-
2-1/4"-8	-	2690118	-	-	-	-	-
2-3/8"-6	-	2690119	2690120	2690121	-	-	-



Fully Machined Adapters, Semi-Steel for 4 Jaw Independent Chucks

Type D Mounting Plates - “Camlock”

Spindle / Price	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"
D-4	2690122	2690123	-	-	-	-
D-5	-	-	-	-	-	-
D-6	-	2690124	2690125	-	2690129	-
D-8	-	-	2690126	2690127	-	2690131
D-11	-	-	-	2690128	2690130	2690132



Type A American Standard Short Taper A-1 and A-2 Spindles

Spindle / Price	6-1/4"	8"	10"	12-1/2"	15-3/4"	20"
A-5	2690133	2690134	-	-	-	-
A-6	-	-	2690135	2690136	2690138	-
A-8	-	-	-	2690137	2690139	2690141
A-11	-	-	-	-	2690140	2690142

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UNIVERSAL THREE-JAW SELF-CENTERING SCROLL CHUCKS

SERIES 267:

These Bison modern, precision lathe chucks can be used on all types of lathes and different kinds of milling, drilling, CNC attachments. Chucks are provided with **American Standard Two-Piece Tongue & Groove Jaws** or with two sets of hard solid OD & ID jaws.

BODY - is made of high quality cast iron. All guideways and bearing surfaces are precisely machined.

SCROLL PLATE - drop forged of fine alloy steel, carefully case hardened. Thread flanks ground on both sides.

JAWS - the teeth and guides are hardened and fully ground on both sides.

PINIONS - hardened and ground.

Two-Piece Jaw Chuck Standard Accessories:
1 set of two-piece reversible jaws (hard top jaws and hard master jaws), 1self - ejecting wrench, 1 set of mounting screws, 2 allen keys.
Optional Accessories: Soft top jaws.

Solid Jaw Chuck Standard Accessories:
2 sets of hard solid jaws (inside and outside), 1 self - ejecting wrench, mounting bolts, 1 hex key.
Optional Accessories: Soft solid jaws.

Solid Jaw 3" to 25"

Two-Piece Jaw 5" to 25"

Spare parts see pages 511.
Adapter plates see page 520 - 521.

Chuck Grease
Order No. 7799025
Price

PLAIN BACK

Chuck Dia.	Hole Dia.	RPM max.	2-pc. Jaws (3205) Wt. lbs.	2-pc. Jaws (3205) Order No.	2-pc. Jaws (3205) Price	Solid Jaws (3204) Wt. lbs.	Solid Jaws (3204) Order No.	Solid Jaws (3204) Price
3"	.6299	4000	-	-		3.1	7810030	
4"	.7874	3500	-	-		5.3	7810040	
5"	1.2598	3200	10.0	8000500		9.3	7810050	
6-1/4"	1.6535	3000	19.0	8000600		17.0	7810060	
8"	2.1654	2500	34.0	8000800		32.0	7810080	
10"	2.9921	2000	57.0	8001000		52.0	7810100	
12-1/2"	4.0551	1500	96.0	9001200		87.0	7810120	
15-3/4"	5.3543	1000	176	8001600		163	7810160	
20"	7.4803	700	295	8002000		271	7810200	
25"	9.9212	500	529	8002500		469	7810250	
32"*	10.5	300	740	8003200		-		

Note: Plain back chucks require adapter plates which may require machining to fit.

Back View

* 32" Chuck - for more information see page 512.

A-1/A-2 Type Mount (3215)

Chuck Dia.	Taper Size	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
6-1/4"	A1-5	1.653	3000	22	8010615	
8"	A1-5 A1-6	1.653 2.165	2500 2500	42 42	8010815 8010816	
10"	A2-5 A1-6 A1-8	2.992 2.165 2.992	2000 2000 2000	71 71 71	8011015 8011016 8011018	
12-1/2"	A2-6 A1-8	4.055 3.150	1500 1500	121 121	8011226 8011218	
15-3/4"	A2-6 A2-8 A1-11	4.055 5.354 5.118	1000 1000 1000	203 203 203	8011616 8011618 8011619	
20"	A2-11	7.590	700	353	8012029	
25"	A2-11 A2-15	7.590 7.590	500 500	628 628	8012511 8012515	
32"	A2-20	12.598	300	847	8013220	

(Continued)

See page 514
for accuracy and runout specifications.

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UNIVERSAL THREE-JAW SELF-CENTERING SCROLL CHUCKS

SERIES 267:

D-1 Type Mount (3245)

Chuck Dia.	Taper Size	Stud Dia.	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
5”	D1-4	5/8	1.260	3000	11	**8030534**	
6-1/4”	D1-3 D1-4	9/16 5/8	1.654 1.654	3000 3000	20 20	**8030633** **8030634**	
8”	D1-3 D1-4 D1-5 D1-6	9/16 5/8 3/4 7/8	2.028 2.165 2.165 2.165	2500 2500 2500 2500	42 42 42 42	**8030833** **8030834** **8030835** **8030836**	
10”	D1-5 D1-6 D1-8	3/4 7/8 1	2.992 2.992 2.992	2000 2000 2000	71 71 71	**8031035** **8031036** **8031038**	
12-1/2”	D1-6 D1-8 D1-11	7/8 1 1-3/16	4.055 4.055 4.055	1500 1500 1500	112 112 112	**8031236** **8031238** **8031239**	
15-3/4”	D1-6 D1-8 D1-11	7/8 1 1-3/16	4.055 5.354 5.354	1000 1000 1000	223 223 223	**8031636** **8031638** **8031639**	
20”	D1-8 D1-11	1 1-3/16	5.354 7.598	700 700	331 331	**8032038** **8032039**	
25”	D1-11	1-3/16	7.598	500	604	**8032539**	

“L” Type Mount (3255)

Chuck Dia.	Taper Size	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
6-1/4”	L00 L0	2.20 2.60	3000 3000	23 23	**8040641** **8040642**	
8”	L00 L0 L1	2.20 2.60 3.35	2500 2500 2500	42 42 42	**8040841** **8040842** **8040843**	
10”	L0 L1 L2	2.60 3.35 4.29	2000 2000 2000	64 64 64	**8041042** **8041043** **8041044**	
12-1/2”	L0 L1 L2	2.60 3.35 4.29	1500 1500 1500	134 134 134	**8041242** **8041243** **8041244**	
15-3/4”	L1 L2	3.35 4.29	1000 1000	251 251	**8041643** **8041644**	

***4” only (Solid Jaw)**

Threaded (3285/3284)

Chuck Dia.	Thread Dia.	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
4”*	1” - 10 1-1/2” - 8	.79 .79	3500 3500	8.8 8.8	**8050451** **8050452**	
5”	1” - 10 1-1/2” - 8	1.26 1.26	3200 3200	12 12	**8050551** **8050552**	
6-1/4”	1-1/2” - 8 2-1/4”- 8	1.57 1.57	3000 3000	23 23	**8050652** **8050653**	
8”	1-1/2” - 8 2-1/4”- 8 2-3/8” - 6	2.17 2.17 2.17	2500 2500 2500	45 45 45	**8050852** **8050853** **8050854**	
10”	2-1/4” - 8	2.99	2000	75	**8051053**	
12-1/2”	2-3/4” - 8	4.06	1500	121	**8051255****	

****LIMITED QUANTITY.**

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UNIVERSAL THREE-JAW SELF-CENTERING SCROLL CHUCKS SPARE PARTS

SERIES 287:

Chuck Dia.	Hard Master Jaws 3 Pc. Set		Hard Top Jaws 3 Pc. Set		OD Jaws 3 Pc. Set		ID Jaws 3 Pc. Set		Soft Solid Jaws 3 Pc. Set		3, 4, 6 Jaw Soft Top Jaws 1 Pc.	
	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price
3”	-		-		7880303		7881303		7882303		-	
4”	-		-		7880304		7881304		7882304		-	
5”	7885305		7883305		7880305		7881305		7882305		7884305	
6-1/4”	7885306		7883306		7880306		7881306		7882306		7884306	
8”	7885308		7883308		7880308		7881308		7882308		7884308	
10”	7885310		7883310		7880310		7881310		7882310		7884310	
12-1/2”	7885312		7883312		7880312		7881312		7882312		7884312	
15-3/4”	7885316		7883316		7880316		7881316		7882316		7884316	
20”	7885320		7883320		-		7881320		7882320		7884320	
25”	7885325		7883325		7880325		7881325		7882325		7884325	
32”	7885332		-		-		-		-		7884325	

Chuck Dia.	Scroll		Pinion		Wrench			Pinion Screw	
	2-3-4 Jaw Order No.	Price	2-3-4 Jaw Order No.	Price	2-3-4 Jaw Order No.	Square Size	Price	2-3-4Jaw Order No.	Price
3”	7887303		7886303		7889003	.2344		7888904	
4”	7887304		7886304		7889005	.3543		7888904	
5”	7887305		7886305		7889005	.3543		7888906	
6-1/4”	7887306		7886306		7889008	.4331		7888906	
8”	7887308		7886308		7889008	.4331		7888910	
10”	7887310		7886310		7889012	.5512		7888910	
12-1/2”	7887312		7886312		7889012	.5512		7888910	
15-3/4”	7887316		7886316		7889016	.6693		7888920	
20”	7887320		7886320		7889025	.7480		7888920	
25”	7887325		7886325		7889025	.7480		7888920	
32”	7887332		7886332		7889332	.7480		7888920	

All above spare parts sold by piece.

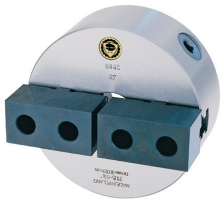
TWO-JAW SELF-CENTERING SCROLL CHUCKS

SERIES 284:

These modern Bison, Two-Jaw, precision lathe chucks can be used on all types of lathes and with different kinds of milling, drilling, CNC attachments. Chucks are provided with **American Standard Two-Piece Tongue & Groove Jaws.** Soft top jaws are shaped by user to fit the workpiece.

BODY - is made of high quality cast iron. All guideways and bearing surfaces are precisely machined.
SCROLL PLATE - drop forged of fine alloy steel, carefully case hard. Thread flanks ground on both sides.
MASTER JAWS - the teeth and guides are hardened and fully ground on both sides.
PINIONS - hardened and ground.

Standard Accessories:
1 set of two-piece reversible jaws (soft top jaws and hard master jaws), 1self - ejecting wrench, 1 set of mounting screws, 2 hex keys.



Adapter plates see pages 520 - 521. All spare parts available. See our website or inquire.

PLAIN BACK (3105)

Chuck Dia.	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
6-1/4”	1.65	3000	19.0	8300600	
8”	2.17	2500	34.0	8300800	
10”	2.99	2000	57.0	8301000	
12-1/2”	4.06	1500	96.0	8301200	
15-3/4”	5.35	1000	176	8301600	

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FOUR-JAW, SELF-CENTERING SCROLL CHUCKS, PLAIN BACK

SERIES 283:

Solid Jaws

3605 Universal and 3705 Precision, Four-Jaw, Scroll Lathe Chucks with two-piece hard reversible jaws. Semi-steel body or Forged Steel Body. Scroll and jaws hardened and ground.

Standard Accessories:
1 set of two-piece reversible jaws
(hard top jaws and hard master jaws),
1 wrench, 1 set of mounting screws.

3604 Universal, Four-Jaw, Scroll Lathe Chucks with two-sets of hard solid jaws. Semi-steel body. Scroll and jaws hardened and ground.

Standard Accessories:
2 sets of hard solid jaws (inside and outside), 1 wrench, 1 set of mounting screws.

Optional Accessories:
Soft solid jaws.

Adapter Plates see pages 520 - 521.
All spare parts available.
See our website or inquire.

Chuck Dia.	Hole Dia.	Semi - Steel Body							Forged Steel Body			
			2 pc. Jaws (3605)			Solid Jaws (3604)			2 pc. Jaws (3705)			
		RPM Max.	Wt. lbs.	Order No.	Price	Wt. lbs.	Order No.	Price	RPM Max.	Weight lbs.	Order No.	Price
5”	1.26	3200	10	**8400500**		9.3	**8450500**		-	-	-	
6-1/4”	1.65	3000	19	**8400600**		17	**8450600**		4500	21	**8410600**	
8”	2.17	2500	34	**8400800**		32	**8450800**		4000	36	**8410800**	
10”	2.99	2000	57	**8401000**		52	**8451000**		3500	75	**8411000**	
12-1/2”	4.06	1500	96	**8401200**		87	**8451200**				-	
15-3/4”	5.35	1000	176	**8401600**		163	**8451600**		2000	198	**8411601**	
20”	7.48	700	295	**8402000**		271	**8452000**					
25”	9.92	500	529	**8402500**		-	-					

LARGE THROUGH-HOLE THREE-JAW SELF-CENTERING SCROLL CHUCKS, PLAIN BACK

SERIES 267:

STEEL & SEMI-STEEL BODY

Universal, Three-Jaw, Scroll Lathe Chucks with large through hole. Two-piece reversible tongue and groove jaws. Semi-steel body or steel body. Plain back mount. Jaws, scroll plate and pinions are made of fine alloy steel, carefully heat treated and ground; balanced scroll. Chucks are available with 10-1/2” through-hole which can be increased by the user to 12-1/2”.

Standard Accessories:
1 set of two-piece reversible jaws
(hard top jaws and hard master jaws),
1 wrench, 1 set of mounting screws.

Optional Accessories:
Soft top jaws.

Adapter Plates see pages 520 -521.

3205/3307

Chuck Dia.	Chuck Body	Hole Dia.	R.P.M. max.	Weight lbs.	Order No.	Price
31-1/2”	semi-steel	10-1/2”	300	738	**8003200**	
	steel		450	772	**8203200**	

EXTRA LARGE THROUGH-HOLE THREE-JAW SELF-CENTERING SCROLL CHUCKS, PLAIN BACK

SERIES 267:
Large Diameter through-hole Chucks are designed for pipe machining or pipe welding/cut off operations. They can also be used on lathes, rotary tables, welding devices.

Two-piece reversible American Standard Tongue and Groove jaws. Semi-steel body. Plain back mount. Jaws, scroll plate and pinions are made of fine alloy steel, heat treated and ground. Balanced scroll.

Standard Accessories:
1 set of master jaws.
1 wrench, 1 set of mounting screws.

Optional Accessories:
Hard top jaws.
Soft top jaws.

Adapter Plates see pages 520 - 521.

3295

Chuck Dia.	Hole Dia.	Jaw Stroke		Weight lbs.	R.P.M. max.	Order No.	Price
		min.	max.				
16”	8.66	6.61	11.34	127	500	**8191600**	
20”	12.60	9.87	14.96	167	350	**8192000**	
26”	15.98	14.80	19.57	300	250	**8192600**	

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FRONT MOUNTING 3 & 4 JAW SELF-CENTERING SCROLL CHUCKS, PLAIN BACK

SERIES 283:

3275

3274

3675

3 and 4-Jaw Universal Scroll Chucks are designed for use with rotary tables and other devices where back mounting chucks cannot be used.

They can be mounted directly on 3-slot rotary tables or on base plates when rotary table has 4 or 8 T-slots.

Chuck Dia.	Hole Dia.	Weight lbs.	3 - Jaw				4 - Jaw	
			Solid Jaws		2 pc. Jaws			
			Order No. (3274)	Price	Order No. (3275)	Price	Order No. (3675)	Price
4”	0.7874	5.3	**8110400**		-		-	
5”	1.2598	9.3	**8110500**		**8120500**		**8140500**	
6-1/4”	1.6535	17.0	**8110600**		**8120600**		**8140600**	
8”	2.1654	32.0	**8110800**		**8120800**		**8140800**	
10”	2.9921	52.0	**8111000**		**8121000**		**8141000**	
12-1/2”	4.0551	87.0	**8111200**		**8121200**		**8141200**	

All spare parts available. See our website or inquire.

MINI THREE-JAW, SELF CENTERING SCROLL CHUCKS

SERIES 267:

WITH HARD REVERSIBLE JAWS, STEEL BODY

Special compact design to achieve very small turned diameters. These Chucks are suitable for EMCO, UNIMAT 3 & Prazi MD200 Lathes with threaded spindle.

Mounting Thread M14 x 1.

Standard Accessories:
1 set of hard solid reversible jaws and 1 chuck wrench.

Optional Accessories:
1 set of solid jaws.

3286

Chuck Dia.	Weight w/Wrench lbs.	Clamping Ranges min.-max.	Chuck Order No.	Price
2-1/3”	.98	.02 - 2.36	**8100214**	

THREE JAW & SIX JAW “SET-TRU” SCROLL CHUCKS

SERIES 642:
With Fine Adjustment, Forged Steel Body, 3 - pinion design.

Chuck - back view

3565

3865

BISON “SET-TRU” chucks can be used for many machining operations for which universal scroll chucks are unsuitable and all operations for which universal chucks are used. 6-jaw grips firmly with less pressure and less distortion per jaw. Ideal for thin wall and second operation work. Eliminates the need for spring collets.

Outstanding accuracy, versatility and long life make **BISON “SET-TRU”** chucks invaluable in the modern workshop and indispensable in the toolroom.

- **4 micro adjustment screws** provide **.0004” T.I.R.** repeatability.
- **16”, 20” & 25”** 3- & 6-jaw chucks use 8 micro adjustment screws.
- Extremely high gripping concentricity.
- 2-piece top & master jaws are **American Standard Tongue & Groove.**
- 4” chuck has 2 sets of solid jaws.
- Chuck body - made of high quality **forged steel**, is safe at high lathe speeds.
- **Forged scroll** fully hardened with thread flanks ground on both sides for longer life and higher accuracy.
- Each scroll is precisely balanced.
- Jaws - the teeth and guides on both sides are fully hardened and ground.
- Hardened and ground bushings are pressed into the pinion seats.
- **3 pinions** are hardened and ground.
- Each chuck is **balanced** within fine limits.
- Steel adapter plates for the same size of **BISON “SET-TRU”** chuck are interchangeable so that one chuck can be used on different spindles.
- The life of **BISON “SET-TRU”** chucks is approximately **2.5 times** longer than universal chucks.

3 & 6 Jaw Chucks With American Standard Two-Piece Tongue & Groove Jaws.

Chuck Dia.	Hole Dia.	3 - Jaw (3565)				6 - Jaw (3865)			
		RPM max.	Wt. lbs.	Order No.	Price	RPM max.	Wt. lbs.	Order No.	Price
4”*	.787	4200	7.3	**8668040**		-	-	**8688040**	
5”	1.378	3800	11	**8660500**		3000	13.7	**8680500**	
6-1/4”	1.654	3500	21	**8660600**		2500	25	**8680600**	
8”	2.165	3100	35	**8660800**		2200	42	**8680800**	
10”	2.992	2700	59	**8661000**		1900	78	**8681000**	
12-1/2”	4.955	2200	105	**8661200**		1500	128	**8681200**	
15-3/4”	5.354	1800	201	**8661600**		1300	250	**8681600**	
20”	7.480	1200	374	**8662000**		800	365	**8682000**	
25”	9.921	1000	630	**8662500**		700	647	**8682500**	

Standard Accessories:
4” - 2 sets of hard solid jaws (OD & ID)
5” - 25” - 1 set of two-piece reversible jaws (hard top jaws and hard master jaws) 1 wrench, 1 set of mounting bolts, 2 hex keys, 1 set of fine adjustment screws.

Optional Accessories:
Soft top jaws, solid ID & OD jaws. Rotating Body for 4”, 5” & 6”.

Spare Parts see page 514.
Adapter Plates see page 522.

* 2 sets of hard solid jaws

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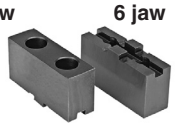
SPARE PARTS FOR "SET-TRU" CHUCKS

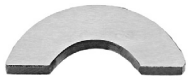
SERIES 287:



3pc. set | 6pc. set | 3pc. set | 6pc. set | 3 jaw | 6 jaw

Hard Top Jaws | Hard Master Jaws | Soft Top Jaws

Chuck Dia.	(Sold in Sets) 3-Jaw Chucks	Price	6-Jaw Chucks	Price	(Sold in Sets) 3-Jaw Chucks	Price	6-Jaw Chucks	Price	(Sold by Piece) 3-Jaw Chucks	Price	6-Jaw Chucks	Price
5"	7883305		7883605		7885305		7885605		7884305		-	
6"	7883306		7883606		7885306		7885606		7884306		7884606	
8"	7883308		7883608		7885308		7885608		7884308		7884608	
10"	7883310		7883610		7885310		7885610		7884310		7884610	
12"	7883312		7883612		7885312		7885612		7884312		7884612	
16"	7883316		7883616		7885316		7885616		7884316		7884616	
20"	7883320		7883620		7885320		7885620		7884320		-	
25"	7883325		7883625		7885325		7885625		7884325		-	



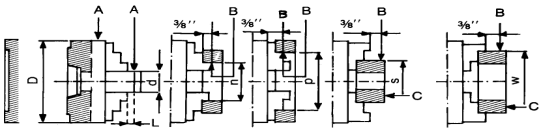
Chuck Dia.	Scroll 3 & 6 Jaw Order No.	Price	Pinion 3 & 6 Jaw Order No.	Price	Wrench 3 & 6 Jaw Order No.	Square Size	Price	Pinion Sleeve 3 & 6 Jaw Order No.	Price	Half Ring 3 & 6Jaw Order No.	Price
4"	7887304		7886304		7889005	.35		-		7888904*	
5"	7887505		7886505		7889005	.35		-		7888705	
6"	7887506		7886506		7889008	.43		7888506		7888706	
8"	7887508		7886508		7889008	.43		7888508		7888708	
10"	7887510		7886510		7889012	.55		7888510		7888710	
12"	7887512		7886512		7889012	.55		7888512		7888712	
16"	7887516		7886516		7889016	.67		7888516		7888716	
20"	7887520		7886520		7889020	.75		7888520		7888720	
25"	7887525		7886525		7889025	.75		7888525		7888725	

All above spare parts sold by the piece.

* Pinion Retaining Screw

ACCURACY OF BISON SELF-CENTERING SCROLL CHUCKS

All allowable runouts which are specified below concern measurements at three different jaw openings d (1, 2, and 3).



Size of Chuck D	Universal and Precision Chucks Series 3200, 3500, 3600, and 3700 d 1	d 2	d 3	L	n	p	s	w*	w**
3-1/2"	.39	-	.55	1.57	1.57	2.36	1.38	2.48	-
4"	.39	.55	.71	1.57	1.57	2.95	1.97	3.15	-
5"	.71	.98	1.18	2.36	1.97	3.94	2.44	3.94	4.72
6-1/4"	.71	1.18	1.57	2.36	1.97	5.31	3.46	3.94	5.90
8"	1.18	1.57	2.08	3.15	3.15	6.38	3.78	6.30	7.28
10"	1.18	2.08	2.95	3.15	3.15	7.87	5.90	6.30	8.86
12-1/2"	2.08	2.95	3.94	4.72	4.92	9.92	8.27	9.84	11.81
15-3/4"	2.08	3.94	4.92	4.72	4.92	11.10	9.84	9.84	13.78
20"	2.95	3.94	4.92	6.30	7.87	11.10	11.81	15.75	15.75
25"	2.95	4.92	6.30	6.30	7.87	12.79	15.75	15.75	15.75
31-1/2"	6.30	7.87	9.84	6.30	12.80	19.70	15.75	19.70	19.70

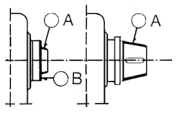
*For solid jaws **For two-piece jaws

Runouts on Universal and Precision Chucks Size of Chuck	Radial Runout A	Radial Runout B	Axial Runout C
3-1/2"	.0008	.0010	.0006
4"	.0008	.0010	.0006
5"	.0012	.0014	.0008
6-1/4"	.0012	.0014	.0008
8"	.0016	.0018	.0010
10"	.0016	.0018	.0010
12-1/2"	.0020	.0022	.0012
15-3/4"	.0024	.0025	.0012
20"	.0040	.0040	.0020
25"	.0040	.0040	.0020
31-1/2"	.0059	.0059	.0024

PERMISSIBLE SPINDLE RUNOUT

Radial Runout A
.0002

Axial Runout B
.00012



Short Taper Long Taper

For spindle noses: A, D & L.
For threaded spindles: See Chuck Manual.

NOTE!
To obtain the specified clamping accuracy of a chuck mounted on a machine tool, it is necessary:
- to reduce play in the spindle bearings to the allowable minimum
- to ensure the machine spindle nose runout not exceed the values specified
- to meet the basic requirements for correct mounting of chuck on the spindle nose.

Tel: 201-518-8461 / Fax: 201-596-3427
650 Huyler St / So. Hackensack, NJ 07606 USA

THREE-JAW SELF-CENTERING SCROLL CHUCKS, FORGED STEEL

SERIES 276:

Precision lathe chucks have top accuracy and the guarantee to maintain this accuracy for an extended period of time. These chucks have a modern and compact design. They are able to fulfill the highest demands of our customers. They can be used wherever precision and high precision machining is demanded.

BODY - drop-forged of highest grade steel and put through precise machining operations. All bearings surfaces are carefully hardened and precisely ground.

SCROLL PLATE - drop-forged of fine alloy steel and carefully case hardened. Thread flanks are ground on both sides.

JAWS - the teeth and guides are hardened and fully ground on both sides.

PINIONS - hardened and ground.

BUSHINGS - hardened and ground, pressed into the pinion seats. Jaws, pinions and bushings are made of fine alloy steel. Precision grinding of scroll and jaws teeth will permit you to:
-eliminate possible deformation as a result of heat treatment
-reach uniform radial gripping force on all teeth of jaws
-increase guarantee period for high centering accuracy
-increase gripping force

Each chuck is provided with lubricator enabling current maintenance and extending chuck components life. Each scroll and assembled chuck is statically balanced within fine limits.

Interstage and final inspection assure high quality of our chucks.

Standard Accessories:
4" - 2 sets of hard solid jaws (inside and outside)
5" - 25" - 1 set of two-piece reversible jaws (hard top jaws and hard master jaws).
1 wrench, 1 set of mounting screws

Optional Accessories:
Soft top jaws. Solid I.D. & O.D. jaws.

See page 514 for accuracy and runout specifications.

AMERICAN STANDARD TONGUE & GROOVE JAWS.

32" STEEL BODY CHUCK

Note: Plain back chucks require adapter plates which may require machining to fit.

Plain Back (3505)

Chuck Dia.	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
5"	1.26	4800	10	**8200500**	
6-1/4"	1.65	4500	21	**8200600**	
8"	2.17	4000	36	**8200800**	
10"	2.99	3500	75	**8201000**	
12-1/2"	4.06	2800	123	**8201200**	
15-3/4"	5.35	2000	198	**8201600**	
20"	7.48	1200	276	**8202000**	
25"	9.92	1000	485	**8202500**	
32"	See Page 512				

Spare Parts see page 516.
& Adapter Plates see pages 522.

CHUCK GREASE
Order No. 7799025
Price

A-1/A-2 TYPE MOUNT (3515)

Chuck Dia.	Taper Size	Hole Dia.	RPM max.	Wt. lbs.	Order No.	Price
6-1/4"	A1-5	1.65	4500	22	**8210615**	
8"	A1-5	1.65	4000	42	**8210815**	
	A1-6	2.17	4000	42	**8210816**	
10"	A1-6	2.17	3500	71	**8211016**	
	A1-8	2.99	3500	71	**8211018**	
12-1/2"	A2-6	4.06	2800	121	**8211226**	
	A1-8	3.15	2800	121	**8211228**	
15-3/4"	A2-8	5.35	2000	203	**8211628**	
	A1-11	5.12	2000	203	**8211629**	
20"	A2-8	5.35	1200	353	**8212028**	
	A2-11	7.48	1200	353	**8212029**	
25"	A2-11	7.48	1000	628	**8212529**	
	A2-15	9.92	1000	628	**8212530**	

D-1 TYPE MOUNT (3545)

Chuck Dia.	Taper Size	Stud Dia.	Hole Dia.	RPM max.	Weight lbs.	Order No.	Price
6-1/4"	D1-3	9/16	1.65	4500	20	**8230633**	
	D1-4	5/8	1.65	4500	20	**8230634**	
	D1-5	3/4	1.65	4500	20	**8230635**	
8"	D1-5	3/4	2.17	4000	42	**8230835**	
	D1-6	7/8	2.17	4000	42	**8230836**	
10"	D1-6	7/8	2.99	3500	71	**8231036**	
	D1-8	1	2.99	3500	71	**8231038**	
12-1/2"	D1-6	7/8	4.06	2800	112	**8231236**	
	D1-8	1	4.06	2800	112	**8231238**	
	D1-11	1-3/16	4.06	2800	112	**8231239**	
15-3/4"	D1-8	1	5.35	2000	223	**8231638**	
	D1-11	1-3/16	5.35	2000	223	**8231639**	
20"	D1-8	1	5.35	1200	331	**8232038**	
	D1-11	1-3/16	7.48	1200	331	**8232039**	
25"	D1-8	1	5.35	1000	604	**8232538**	
	D1-11	1-3/16	7.48	1000	604	**8232539**	

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FORGED STEEL SCROLL CHUCKS SPARE PARTS

SERIES 287:

Chuck Dia.	Hard Master Jaws 3 Pc. Set		Hard Top Jaws 3 Pc. Set		OD Jaws 3 Pc. Set		ID Jaws 3 Pc. Set		Soft Solid Jaws 3 Pc. Set		Soft Top Jaw 1 Pc.	
	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price
5”	7885305		7883305		7880305		7881305		7882305		7884305	
6-1/4”	7885306		7883306		7880306		7881306		7882306		7884306	
8”	7885308		7883308		7880308		7881308		7882308		7884308	
10”	7885310		7883310		7880310		7881310		7882310		7884310	
12-1/2”	7885312		7883312		7880312		7881312		7882312		7884312	
15-3/4”	7885316		7883316		7880316		7881316		7882316		7884316	
20”	7885320		7883320		-		7881320		7882320		7884320	
25”	7885325		7883325		7880325		7881325		7882325		7884325	

Chuck Dia.	Scroll		Pinion		Wrench			Pinion Sleeve		Half Ring	
	Order No.	Price	Order No.	Price	Order No.	Square Size	Price	Order No.	Price	Order No.	Price
5”	7887505		7886505		7889005	.35		-		7888705	
6-1/4”	7887506		7886506		7889008	.43		7888506		7888706	
8”	7887508		7886508		7889008	.43		7888508		7888708	
10”	7887510		7886510		7889012	.55		7888510		7888710	
12-1/2”	7887512		7886512		7889012	.55		7888512		7888712	
15-3/4”	7887516		7886516		7889016	.66		7888516		7888716	
20”	7887520		7886520		7889025	.75		7888520		7888720	
25”	7887525		7886525		7889025	.75		7888525		7888725	

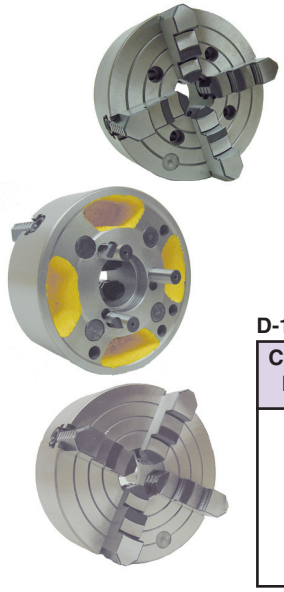
All above spare parts sold by the piece.

FOUR - JAW INDEPENDENT CHUCKS

MEDA Superior Import

SERIES 995:

The chuck body is made of cast iron. The reversible jaws and operating screw are made of high quality carbon steel, hardened and precision ground.



Plain Back

Chuck Dia.	Thru Hole	Order No.	Price
6”	1-1/2”	6251006	
8”	1-15/16”	6251008	
10”	2-1/2”	6251010	
12”	3-3/4”	6251012	
16”	3-1/2”	6251016	

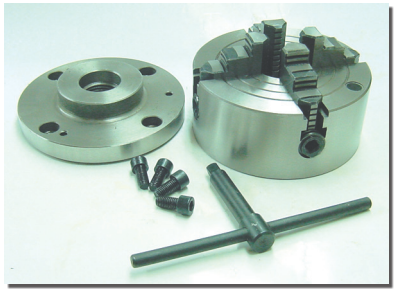
D-1 Type Mount

Chuck Dia.	Spindle	Thru Hole	Order No.	Price
8”	D1-4	2.165”	6250804	
10”	D1-4	2.953”	6251104	
10”	D1-5	2.953”	6251105	
10”	D1-6	2.953”	6251106	
12”	D1-6	3.740”	6251206	
16”	D1-8	4.921”	6251608	

FOUR - JAW INDEPENDENT THREADED BACK CHUCKS

MEDA Superior Import

SERIES 995:



6” Diameter 4-Jaw Independer Plain Back Chuck
PLUS 6” x 1.1/2”-8 or 2-1/4-8 Finished Backplate made for the chuck mounts instantly
(Chuck can be used by itself or with included back plate.)
Chuck body is made of high quality semi-steel.
Hardened and ground scroll.
Heat treated operation screws. Includes chuck wrench and mounting screws.

Chuck Dia.	Thru Hole	Order No.	Price
6”	1-1/2-8	6250612	
6”	2-1/4-8	6250622	

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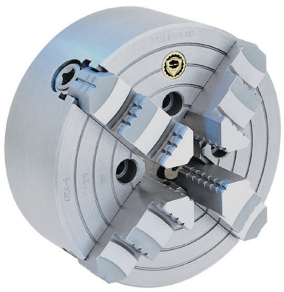
FOUR-JAW INDEPENDENT LATHE CHUCKS

SERIES 279: SEMI-STEEL BODY
SERIES 268: STEEL BODY



BISON medium duty and heavy duty, 4-Jaw independent chucks are designed to grip round or odd shaped work.
Medium duty chuck has semi-steel body and hard solid reversible jaws (36" has two-piece hard reversible jaws).
Heavy duty has steel body and two-piece hard reversible jaws.
Solid jaws are made of high quality carbon steel and hardened.
Hard Top and Hard Master Jaws are made of high quality alloy steel, hardened and ground.

Larger Diameter chucks (from 10" to 49") are supplied with T-slots.

Four jaw, steel body independent Lathe Chucks with two-piece reversible hard jaws.

Standard Accessories:
1 set of two-piece reversible jaws (hard top jaws and hard master jaws), 1 wrench, 1 set of mounting bolts.

Optional Accessories:
Soft jaws.

Four jaw semi-steel body Lathe Chucks with hard solid reversible jaws.

Standard Accessories:
Chuck with Dia. 3-1/2" to 32" are provided with 1 set of hard solid reversible jaws, 1 wrench, 1 set of clamping bolts.
36" chuck is provided with two-piece reversible jaws (hard top jaws and hard master jaws).

Optional Accessories:
Hard top jaws, hard master jaws and soft top jaws.
Adapter Plates: (Note: Some machining is required.)
See pages 520 - 521.
Spare Parts:
See page 519.

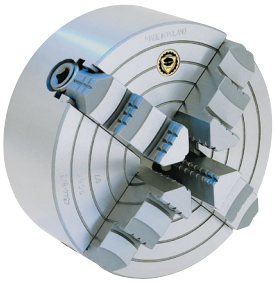
Plain Back 4304 4303

Chuck Dia.	Hole Dia.	Semi-Steel Weight lbs.	Semi-Steel Order No.	Semi-Steel Price	Steel* Weight lbs.	Steel* Order No.	Steel* Price
3-1/2"**	1.000	3.4	**8500300**		-	-	
5"**	1.0236	8.0	**8500500**		-	-	
6-1/4"	1.6535	9.0	**8500600**		-	-	
8"	1.9685	32	**8500800**		35	**8550800**	
10"	2.5591	55	**8501000**		59	**8551000**	
12-1/2"	3.1496	88	**8501200**		95	**8551200**	
15-3/4"	3.9370	139	**8501600**		150	**8551600**	
20"	4.9313	231	**8502000**		250	**8552000**	
25"	6.2992	364	**8502500**		390	**8552500**	
32"	7.8740	700	**8503200**		750	**8553200**	
32"/T	10.500	672	**8503300**		-	-	
36"	7.4809	800	**8503600***		856	**8553600**	
40"	7.4809	-	-		1367	**8554000**	
49"	7.4809	-	-		2138	**8554900**	

CHUCK GREASE
Order No. 7799025
Price

*With two-piece jaws.
**Steel body.

NOTE: Plain back chucks require adapter or back plate which require machining to fit.



"L" TYPE MOUNT* 4354

Chuck Dia.	Taper Dia.	Hole Dia.	Weight lbs.	Order No.	Price
8"	L00	1.96	34	**8540841**	
8"	L0	1.96	34	**8540842**	
10"	L00	2.56	57	**8541041**	
10"	L0	2.56	57	**8541042**	
10"	L1	2.56	57	**8541043**	
12-1/2"	L0	3.15	119	**8541242**	
12-1/2"	L1	3.15	119	**8541243**	
12-1/2"	L2	3.15	119	**8541244**	
15-3/4"	L1	3.93	154	**8541643**	
15-3/4"	L2	3.93	154	**8541644**	
20"	L2	4.92	256	**8542044**	

***Semi-Steel only.**

(Continued)

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FOUR-JAW INDEPENDENT LATHE CHUCKS (Continued)

SERIES 279: SEMI-STEEL BODY
SERIES 268: STEEL BODY

A1/A2 TYPE MOUNT

Chuck Dia.	Taper Dia.	Hole Dia.	Weight lbs.	Semi-Steel Order No.	4314 Price	Weight lbs.	Steel Order No.	4313 Price
8”	A2-5	1.969	38	**9510815**			-	
8”	A2-6	1.969	38	**9510816**		41	**8560816**	
10”	A2-5	2.559	56	**8511025**			-	
10”	A2-6	2.559	56	**0911016**		60	**8561016**	
10”	A2-8	2.559	56	**9911018**		60	-	
12-1/2”	A2-5	3.150	88	**8511215**			-	
12-1/2”	A2-6	3.150	88	**8511226**		94	**8561216**	
12-1/2”	A2-8	3.150	88	**8511218**		94	**8561218**	
15-3/4”	A2-6	3.937	143	**8511626**		153	**8561616**	
15-3/4”	A2-8	3.937	143	**8511628**		153	**8561618**	
15-3/4”	A2-11	3.937	143	**8511619**		153	**8561619**	
20”	A2-8	4.921	251	-		269	**8562018**	
20”	A2-11	4.921	251	**8512019**		269	**8562019**	
20”	A2-15	4.921	251	-		269	**8562020**	
25”	A2-11	6.299	364	**9512519**		389	**8562519**	
25”	A2-15	6.299	364	-		389	**8562520**	
32”	A2-11	6.299	672	**8513219**		719	**8563219**	
32”	A2-15	6.299	672	-		719	**8563220**	
40”	A2-15	6.693		-		744	**8564015**	

D1 TYPE MOUNT

Chuck Dia.	Taper Size	Stud Dia.	Stud Qty.	Hole Dia.	Weight lbs.	Semi-Steel Order No.	4344 Price	Weight lbs.	Steel Order No.	4343 Price
8”	D1-3	9/16	3	3.150	37	**8530833**		-	-	
8”	D1-4	5/8	3	3.150	37	**8530834**		40	**8570834**	
8”	D1-5	3/4	6	3.150	37	**8530835**		-	-	
8”	D1-6	7/8	6	3.150	-	-		40	**8570836**	
10”	D1-4	5/8	3	3.346	61	**8531034**		-	-	
10”	D1-5	3/4	6	3.346	61	**8531035**		65	**8571035**	
10”	D1-6	7/8	6	3.346	61	**8531036**		65	**8571036**	
10”	D1-8	1	6	3.346	-	-		65	**8571038**	
12-1/2”	D1-6	7/8	6	3.740	87	**8531236**		93	**8571236**	
12-1/2”	D1-8	1	6	3.740	87	**8531238**		93	**8571238**	
15-3/4”	D1-6	7/8	6	4.134	132	**8531636**		141	**8571636**	
15-3/4”	D1-8	1	6	4.134	132	**8531638**		141	**8571638**	
15-3/4”	D1-11	1-3/16	6	4.134	132	**8531639**		141	**8571639**	
20”	D1-8	1	6	4.724	211	**8532038**		226	**8572038**	
20”	D1-11	1-3/16	6	4.724	211	**8532039**		226	**8572039**	
25”	D1-8	1	6	5.512	364	**8532539**		389	**8572538**	
25”	D1-11	1-3/16	6	5.512	-	-		389	**8572539**	
32”	D1-11	1-3/16	6	6.199	-	-		703	**8573239**	

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SPARE PARTS FOR FOUR - JAW INDEPENDENT LATHE CHUCKS

SERIES 296:

Chuck Dia.	Hard Reversible Jaws		Hard Master Jaws		Hard Solid Jaws		Medium Soft Top Jaws /1pc.	
	Order No.	Price/ Each	Order No.	Price/ Each	Order No.	Price/ Each	Order No.	Price/ Each
3-1/2”	-		-		8901030		-	
5”	-		-		8901050		7884305	
6-1/4”	-		-		8901060		7884306	
8”	7890208		7890308		8901080		7884308	
10”	7890210		7890310		8901100		7884310	
12-1/2”	7890212		7890312		8901120		7884312	
15-3/4”	7890216		7890316		8901160		7884316	
20”	7890220		7890320		8901200		7884320	
25”	7890225		7890325		8901250		7884325	
32”	7890232		7890332		8901320		7884325	
32”/T	7890232		7890332		8901320		7884325	
36”	7890236		7890336		-		7884332	
40”	7890236		7890336		-		7884332	
49”	7890249		7890336		-		7884332	

All above spare parts sold by piece.

Chuck Dia.	Heavy Duty Soft Top Jaws		Operating Screws		Thrust Bearing		Wrench	
	Order No.	Price	Order No.	Price	Order No.	Price	Order No.	Price
3-1/2”	-		7890603		7890703		-	
5”	-		7890606		7890706		7890906	
6-1/4”	7884206		7890606		7890706		7890906	
8”	7884208		7890608		7890708		7890910	
10”	7884210		7890610		7890710		7890910	
12-1/2”	7884212		7890612		7890712		7890916	
15-3/4”	7884216		7890616		7890716		7890916	
20”	-		7890620		7890720		7890925	
25”	-		7890625		7890725		7890925	
32”	-		7890632		7890732		7890932	
32”/T	-		7890633		7890732		7890932	
36”	-		7890636		7890736		7890932	
40”	-		7890640		7890736		7890932	
49”	-		7890649		7890736		7890932	

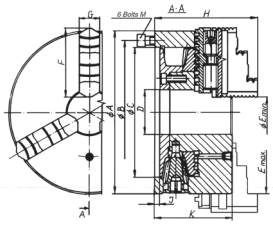
All above spare parts sold by piece.

FOUR-JAW COMBINATION LATHE CHUCKS

SERIES 270:

BISON Plain Back combination chucks combine the advantages of a scroll chuck and an independent chuck in one. Each jaw may be adjusted individually with an independent operating screw. After the desired eccentric setting has been made, all jaws can then be opened and closed simultaneously with the use of a scroll and pinion. The jaws are reversible and may be used as both inside and outside jaws.

4605


4805

Standard Accessories:
1 set of hard solid reversible jaws, 1 wrench, 1 set of mounting screws.

Optional Accessories:
Soft solid jaws.

Adapter Plates:
See pages 520-521.

Chuck Dia.	Hole Dia.	Semi-Steel				Steel			
		RPM	Weight lbs.	Order No.	Price	RPM	Wt. lbs.	Order No.	Price
8”	2.17	2000	41.4	8480800		2500	43.0	8490800	
10”	2.99	1800	65.0	8481000		2000	68.3	8491000	
12-1/2”	4.05	1500	120	8481200*		1700	124	8491200	
15-3/4”	5.35	1000	194	8481600		-	-	-	
20”	7.351	500	330	8482000		1000	342	8492000	
25”	9.92	350	551	8482500		750	573	8492500	

*LIMITED QUANTITY

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5C ADAPTERS FOR BISON LATHE CHUCKS

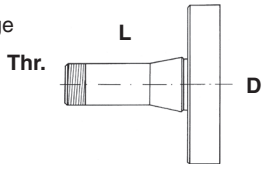
SERIES 291:

SEMI-FINISHED

5C Adapters are designed for use with Self-Centering or Independent Lathe Chucks.

Made of high quality forged steel. 5C shank is hardened and precision ground for maximum accuracy.
Soft flange. Wide clamping range and high accuracy makes them very useful in many precision drilling, turning, grinding and milling operations.

BISON Chucks and 5C Adapters give accuracy not available with standard and precision 5C collets.



5C						For use with the following Lathe Chucks		
Shank	Flange Dia. D	Hole D	L	Order No.	Price	Chuck Dia.	3 & 4 Jaw Order No.	4 Jaw Order No.
5C	4”	.866	4.41	7909304		3” & 4”	8100300 8100400 8110400	8500300
	5”			7909305		5” & 6”	8000500 8100500 8120500 8140500	8500500 8500600
	6”			7909306		6”	8000600 8120600 8140600	

CAST-IRON ADAPTERS

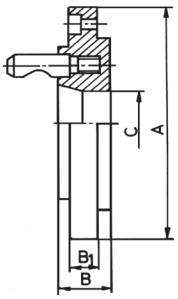
SERIES 291:

D1 ADAPTERS

8240 Fully Machined Adapters for **BISON** plain back, self-centering Chucks - designed for direct mounting on camlock spindle noses.
8242 Semi Machined Adapters for plain back Chucks - designed for direct mounting on camlock spindle noses.

Fully Machined

Semi Machined



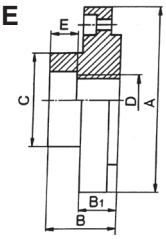
NOTE: Number of camlock studs depends on spindle size. See Table.

					8240			8242		
					Fully Machined			Semi Machined		
Chuck Dia.	Taper Size	Stud Dia.	No. of Studs	Hole Dia. C	Wt. lbs.	Order No.	Price	Wt. lbs.	Order No.	Price
5”	D1-3	9/16	3	2.02	5.3	7878053		-	-	
5”	D1-4	5/8	3	2.40	5.3	7878054		-	-	
6-1/4”	D1-3	9/16	3	2.02	9.5	7878063		9.3	8780630	
6-1/4”	D1-4	5/8	3	2.40	9.5	7878064		9.3	8780640	
6-1/4”	D1-5	3/4	6	3.13	9.5	7878065		9.3	8780650	
6-1/4”	D1-6	7/8	6	4.06	9.5	7878066		-	-	
8”	D1-3	9/16	3	2.02	15.4	7878083			-	
8”	D1-4	5/8	3	2.40	15.4	7878084		27	8780840	
8”	D1-5	3/4	6	3.13	15.4	7878085		27	8780850*	
8”	D1-6	7/8	6	4.06	15.4	7878086		27	8780860	
10”	D1-5	3/4	6	3.13	24.3	7878105		35	8781050*	
10”	D1-6	7/8	6	4.06	24.3	7878106		35	8781060	
10”	D1-8	1	6	5.35	24.3	7878108		35	8781080	
12-1/2”	D1-6	7/8	6	4.06	39.7	7878126		49	8781260*	
12-1/2”	D1-8	1	6	5.35	39.7	7878128		49	8781280	
12-1/2”	D1-11	1-3/16	6	7.59	39.7	7878129		49	8781290	
15-3/4”	D1-6	7/8	6	4.06	79	7878166		93	8781660*	
15-3/4”	D1-8	1	6	5.35	79	7878168		93	8781680	
15-3/4”	D1-11	1-3/16	6	7.59	79	7878169		93	8781690	
20”	D1-8	1	6	5.35	132	7878208		159	8782080	
20”	D1-11	1-3/16	6	7.59	132	7878209		159	8782090	
25”	D1-8	1	6	5.35	232	-		232	8782580*	
25”	D1-11	13/16	6	7.59	232	7878259		232	8782590	

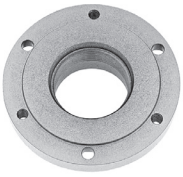
*LIMITED QUANTITY

THREADED ADAPTERS FOR HARDINGE LATHE

			8204	
Chuck Dia.	Thread D	Weight lbs.	Order No.	Price
5”	M39 x 4	11	7922051	
5”	2-3/16 - 10	11	7922053	
6-1/4”	2-3/16 - 10	13	7922063	



Fully Machined Adapters for **BISON** plain back, self-centering Chucks - designed for direct mounting on Hardinge 2-3/16” - 10 spindle noses.



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CAST-IRON ADAPTERS

SERIES 291:

Rough Adapters for Scroll Chucks

Chuck Dia.	Weight lbs.	Order No.	Price
3", 4", 5"	4.4	**7870105**	
6-1/4"	12	**7870106**	
8"	22	**7870108**	
10"	34	**7870110**	
12-1/2"	66	**7870112**	
15-3/4"	154	**7870116**	

Rough Adapters for 4 Jaw Independent Chucks

8262

Chuck Dia.	Weight lbs.	Order No.	Price
6-1/4"*	8	**7870306**	
8"	11	**7870308**	
10"	25	**7870310**	
12-1/2"	49	**7870312**	

*LIMITED QUANTITY

Semi-Finished Threaded Adapters

8206

Chuck Dia.	Thread Size	Weight lbs.	Order No.	Price
4"	1-10	8	**7871041**	
4"	1-1/2-8	8	**7871042**	
5"	1-10	10	**7871051**	
5"	1-1/2-8	10	**7871052**	
6-1/4"	1-1/2-8	12	**7871062**	
6-1/4"	2-1/4-8	12	**7871063**	
8"	1-1/2-8	12	**7871082**	
8"	2-1/4-8	13	**7871083**	
8"	2-3/8 - 6	13	**7871084**	
10"	2-1/4-8	22	**7871103**	
10"	2-3/8-6	25	**7871104**	
12-1/2"	2-3/8-6	33	**7871124**	

Semi Machined and Fully Machined Adapters for plain back chucks - designed for direct mounting on A1 and A2 spindle noses.
May be used for both scroll and independent chucks.

A1/A2 TYPE ADAPTERS

8212 8210

Chuck Dia.	Taper No.	Weight lbs.	SemiMach. Order No.	Price	Weight lbs.	Fully Mach. Order No.	Price
6-1/4"	A-5	6.5	**7873065**		-		
8"	A-5	19.0	**7873085**		18	**8730850**	
8"	A-6	15.5	**7873086**		-		
10"	A-6	38	**7873106**		-		
10"	A-8	33	**7873108**		-		
12-1/2"	A-6	45	**7873126**		-		
12-1/2"	A-8	62	**7873128**		-		
15-3/4"	A-6	85	**7873168**		-		
15-3/4"	A-11	141	**7873169**		-		
20"	A-11	133	**7873209**		-		
25"	A-11	158	**7873259**		-		
25"	A-15	-	**7873260**		231	**8732600**	
36",40",49"	A-15	242	**8733615**		-		
36",40",49"	A-20	249	**8733620**		-		

Fully Machined Adapters for **BISON** plain back, self-centering Chucks - designed for direct mounting on L type spindle noses.

L TYPE ADAPTERS

8250

Chuck Dia.	Taper No.	Thread Dia.	Weight lbs.	Order No.	Price
6-1/4"	L00	3-3/4"-6	13	**7879061**	
6-1/4"	L0	4-1/2"-6	13	**7879062**	
8"	L00	3-3/4"-6	22	**7879081**	
8"	L0	4-1/2"-6	22	**7879082**	
8"	L1	6"-6	22	**7879083**	
10"	L00	3-3/4"-6	33	**7879101**	
10"	L0	4-1/2"-6	33	**7879102**	
10"	L1	6"-6	33	**7879103**	
10"	L2	7-3/4"-5	33	**7879104**	
12-1/2"	L0	4-1/2"-6	57	**7879122**	
12-1/2"	L1	6"-6	57	**7879123**	
12-1/2"	L2	7-3/4"-5	57	**7879124**	
15-3/4"	L0	4-1/2"-6	95	**7879162**	
15-3/4"	L1	6"-6	95	**7879163**	
15-3/4"	L2	7-3/4"-5	95	**7879164**	
15-3/4"	L3	10-3/8"-4	95	**7879165**	
20"	L2	7-3/4"-5	159	**7879204**	
20"	L3	10-3/8"-4	159	**7879205**	
25"	L2	7-3/4"-5	397	**7879254**	
25"	L3	10-3/8"-4	397	**7879255**	

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STEEL ADAPTERS FOR "SET-THRU" CHUCKS (A & D TYPES)

SERIES 266:

D-Type

D-Type (8245)

Chuck Dia.	Taper Size	Studs Qty.	Studs Dia.	Weight lbs.	Order No.	Price
4"	D1-3	3	9/16"	3.31	**7875043**	
	D1-4	3	5/8"	3.97	**7875044**	
5"	D1-3	3	9/16"	5.95	**7875053**	
	D1-4	3	5/8"	5.73	**7875054**	
	D1-5	6	3/4"	6.92	**7875055**	
	D1-6	6	7/8"	13.06	**7875056**	
6-1/4"	D1-3	3	9/16"	10.80	**7875063**	
	D1-4	3	5/8"	9.92	**7875064**	
	D1-5	6	3/4"	9.89	**7875065**	
	D1-6	6	7/8"	13.00	**7875066**	
8"	D1-3	3	9/16"	10.36	**7875083**	
	D1-4	3	5/8"	10.36	**7875084**	
	D1-5	6	3/4"	15.87	**7875085**	
	D1-6	6	7/8"	17.64	**7875086**	
10"	D1-4	3	5/8"	18.84	**7875104**	
	D1-5	6	3/4"	17.64	**7875105**	
	D1-6	6	7/8"	28.44	**7875106**	
	D1-8	6	1"	32.41	**7875108**	
12-1/2"	D1-6	6	7/8"	28.44	**7875126**	
	D1-8	6	1"	47.84	**7875128**	
	D1-11	6	1-3/16"	52.91	**7875129**	
15-3/4"	D1-6	6	7/8"	29.0	**7875166**	
	D1-8	6	1"	27.2	**7875168**	
	D1-11	6	1-3/16"	26.8	**7875169**	
20"	D1-8	6	1"	74	**7875208**	
	D1-11	6	1-3/16"	78	**7875209**	
	D1-15	6	1-3/8"	83	**7875215**	
25"	D1-8	6	1"	74	**7875258**	
	D1-11	6	1-3/16	78	**7875259**	

A-Type (8215)

Chuck Dia.	Taper Size	Weight lbs.	Order No.	Price
5"	A4	4.8	**7874054**	
	A5	4.2	**7874055**	
	A6	9.1	**7874056**	
6-1/4"	A5	6.77	**7874065**	
8"	A5	9.3	**7874085**	
	A6	13.5	**7874086**	
10"	A5	17.3	**7874105**	
	A6	17.3	**7874106**	
	A8	20.2	**7874108**	
12-1/2"	A6	27.3	**7874126**	
	A8	35.7	**7874128**	
	A11	41.20	**7874129**	
15-3/4"	A6	31.4	**7874166**	
	A8	28.8	**7874168**	
	A11	35.8	**7874169**	
20"	A8	69	**7874208**	
	A11	61	**7874209**	
	A15	76	**7874215**	
25"	A8	69	**7874258**	
	A11	61	**7874259**	
	A15	76	**7874260**	
	A20	90	**7874265**	

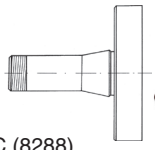
A-Type

NOTE!
THESE ADAPTERS ARE DESIGNED TO MOUNT ON A1 & A2 SPINDLES.

5C FULLY MACHINED STEEL ADAPTERS

SERIES 266:

T.I.R. 0.0005"



5C (8288)

Chuck Dia.	5C Adapters	Price
4"*	**7-912-304**	
5"	**7-912-305**	
6-1/4"	**7-912-306**	

Adapters & SET-TRU (3 & 6 Jaw) Chucks are sold separately.

*4" Solid Jaws only.

STEEL ADAPTERS FOR "SET-TRU" CHUCKS (THREADED & L TYPES)

SERIES 266:

THREADED (8285)

Chuck Dia.	D	Thread	Weight lbs.	Order No.	Price
4"	3.94	1-1/2 - 8 UN-2B	5.29	**7876042**	
5"	4.92	1-1/2 - 8 UN-2B	6.61	**7876052**	
		2-3/16-10 HARDINGE	7.05	**7876054**	
		2-1/4 - 8 UN-2B	6.8	**7876056**	
6-1/4"	6.30	1-1/2 - 8 UN-2B	7.05	**7876062**	
		2-3/16 - 10 HARDINGE	7.50	**7876064**	
		2-1/4 - 8 UN-2B	7.94	**7876066**	
8"	7.87	1-1/2 - 8 UN-2B	9.92	**7876082**	
		2-1/4 - 8 UN-2B	11.46	**7876083**	
		2-3/8 - 6 UN-2B	13.89	**7876084**	

L-TYPE (8255)

Chuck Dia.	D	Taper Size	Thread T-UNS3	Weight lbs.	Order No.	Price
6-1/4"	6.30	L00	3-3/4-6	9.0	**7879061**	
		L0	4-1/2-6	9.5	**7879062**	
8"	7.87	L00	3-3/4-6	15.0	**7879081**	
		L0	4-1/2-6	15.4	**7879082**	
		L1	6-6	16.5	**7879083**	
10"	9.84	L00	3-3/4-6	25.0	**7879101**	
		L0	4-1/2-6	26.1	**7879102**	
		L1	6-6	37.0	**7879103**	
12-1/2"	12.40	L0	4-1/2-6	37.0	**7879122**	
		L1	6-6	37.0	**7879123**	
		L2	7-3/4-5	38.8	**7879124**	
15-3/4"	11.75	L1	6-6	34.2	**7879163**	
		L2	7-3/4-5	45.4	**7879164**	
		L3	10-3/8-4	67.2	**7879165**	
20"	19.68	L2	7-3/4-5	60.2	**7879204**	
		L3	10-3/8-4	81.3	**7879205**	

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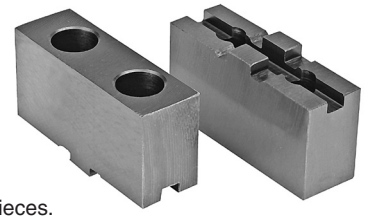
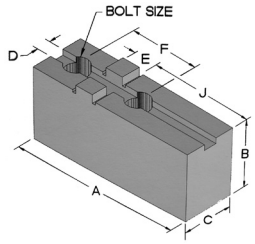
SOFT TOP JAWS

SERIES 290:

For all chucks with American Standard Tongue and Groove Master Jaws
(Bergman, Bison, Buck, Cushman, Huron, Rohm, Forkhardt, Pratt Burnerd America, SCA, S.P., W & S, Nobel, and Yuasa)





- Easily machined to desired shape to hold irregular workpieces.
- Furnished in low carbon steel for carburizing and hardening after machining.

O - Tongue is offset (See J dimensions) Tongue Height is 1/8".

Chuck Size	Model No.	A	B	C	D	E	F	Bolt Size	J	Order No.	Price
Medium Duty Soft Jaws											
6	447	2-5/8	1-5/8	1-1/4	0.313	0.5	1.5	3/8	1-1/8	**5201447**	
6	6MSH-O	3-1/4	1-3/8	1	0.313	0.5	1.5	3/8	1-13/16	**2900006**	
8	450	3-1/2	1-5/8	1-1/4	0.313	0.5	1.75	3/8	1-5/8	**5201450**	
8	8MSH-O	3-3/4	1-7/8	1-1/4	0.313	0.5	1.75	3/8	2-3/16	**2900008**	
10	452	4-1/4	1-7/8	1-1/2	0.5	0.75	2.12	1/2	1-15/16	**5201452**	
10	10MSH-O	4-5/8	1-7/8	1-1/2	0.5	0.75	2.12	1/2	2-5/8	**2900010**	
12	454	4-7/8	2-3/8	1-3/4	0.5	0.75	2.5	1/2	2-5/16	**5201454**	
12	12MSH-O	5-3/8	2-1/8	1-3/4	0.5	0.75	2.5	1/2	3-1/8	**2900012**	
15	456	5-5/8	2-5/16	2	0.5	0.75	3	5/8	2-3/4	**5201456**	
15	15MSH-O	6-1/4	2-5/16	1-3/4	0.5	0.75	3	5/8	3-5/8	**2900015**	
18-21	457	5-5/8	2-5/16	2	0.5	0.75	3	3/4	2-3/4	**5201457**	
18-21	18MSH-O	6-3/8	2-13/16	2-1/4	0.5	0.75	3	3/4	3-3/4	**2900018**	
Heavy Duty Soft Jaws											
6	448	2-5/8	1-5/8	1-1/4	0.313	0.5	1.5	7/16	1-1/8	**5201448**	
6	6HSH-O	3-1/4	1-3/8	1-1/2	0.313	0.5	1.5	7/16	1-13/16	**2900106**	
8	451	3-1/2	1-7/8	1-1/2	0.313	0.5	1.75	1/2	1-5/8	**5201451**	
8	8HSH-O	3-3/4	1-7/8	1-1/2	0.313	0.5	1.75	1/2	2-3/16	**2900108**	
10	453	4-1/2	2-3/8	1-3/4	0.5	0.75	2.12	5/8	1-15/16	**5201453**	
10	10HSH-O	4-5/8	1-7/8	1-3/4	0.5	0.75	2.12	5/8	2-5/8	**2900110**	
12	455	4-7/8	2-3/8	2	0.5	0.75	2.5	5/8	2-5/16	**5201455**	
12	12HSH-O	5-3/8	2-1/8	2	0.5	0.75	2.5	5/8	3-1/8	**2900112**	
15-36	457	5-5/8	2-5/16	2	0.5	0.75	3	3/4	2-3/4	**5201457**	
15-36	15HSH-O	6-1/4	2-5/16	2-1/2	0.5	0.75	3	3/4	3-5/8	**2900115**	
18-36	458	5-5/8	3-5/16	2-1/2	0.5	0.75	3	3/4	2-3/4	**5201458**	
18-36	18HSH-O	6-3/8	2-13/16	3	0.5	0.75	3	3/4	3-3/4	**2900118**	

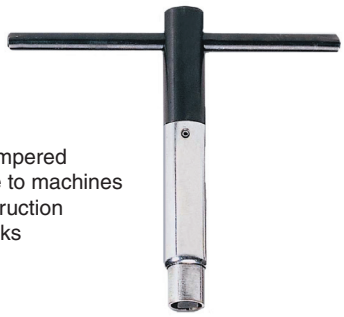
Many other styles such as pointed, serrated, etc. are available; please inquire.

Aluminum jaws available; please inquire.

SAFETY SELF EJECTING LATHE CHUCK WRENCHES

MEDA Superior Import

Series 643:



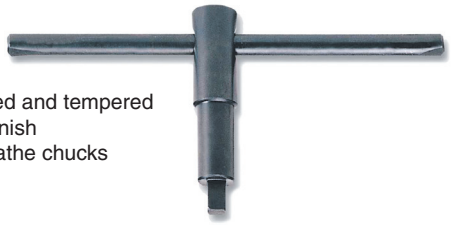
- Hardened and tempered
- Prevents damage to machines
- Heavy duty construction
- Fits all lathe chucks

Approximate Size of Square	Order No.	Price
1/4	**6430016**	
5/16	**6430020**	
3/8	**6430024**	
7/16	**6430028**	
1/2	**6430032**	
9/16	**6430036**	

WRENCHES FOR LATHE CHUCKS

MEDA Superior Import

Series 285:



- Hardened and tempered
- Black Finish
- Fits all lathe chucks

Approximate Size of Square	Order No.	Price
15/64	**6551564**	
1/4	**6550014**	
9/32	**6550932**	
5/16	**6550516**	
3/8	**6550038**	
7/16	**6550716**	
1/2	**6550112**	
9/16	**6550916**	
5/8	**6550058**	
11/16	**6551116**	
3/4	**6550034**	

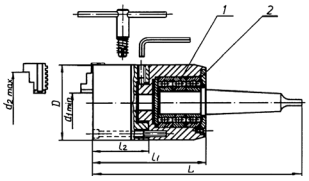
STAR TOOL SUPPLY / GRAND TOOL SUPPLY
Tel: 201-518-8461 / Fax: 201-596-3427
650 Huyler St / So. Hackensack, NJ 07606 USA

ROTATING CHUCKS WITH MT SHANKS, THREE-JAW SELF CENTERING WITH FINE ADJUSTMENT

SERIES 645:

SET-TRU .0005" T.I.R.

- These precision chucks are used in tail stocks for jobs where centers can not be used (example: machining of tube).
- Steel body.
- Hardened and ground scroll and pinions.
- Hardened and ground MT shank.
- Sealed ball bearings: lubrication through oiler.
- 4 fine adjustment screws provide .0005 T.I.R. repeatability.



Rotating chucks are provided in a wooden case.

Standard Accessories:
4" 2-sets of hard solid jaws (ID & OD), 1 chuck wrench and 1 hex key.
5" & 6" 1 set of two-piece reversible jaws (hard top jaws & hard master jaws), 1 chuck wrench and 1 hex key.

Optional Accessories:
4" soft solid jaws,
5" & 6" soft top jaws,
6-Jaw SET-TRU chuck,
5" 5C Collet Chuck

9164

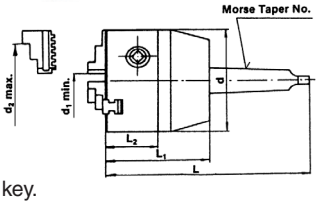
Chuck Dia.	Max. R.P.M.	MT No.	Weight lbs.	Rotating Chuck Order No.	Price
4"	3500	3	13.5	8610400	
5"	3200	4	25.0	8610500	
6-1/4"	3000	5	34.0	8610600	

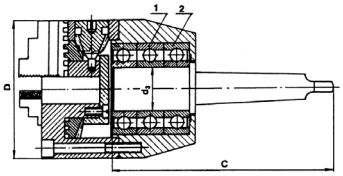
ROTATING CHUCKS WITH MT SHANKS, THREE-JAW SELF CENTERING

SERIES 645:

These precision rotating chucks are used in tailstocks for jobs where centers cannot be used (example: machining of tube).

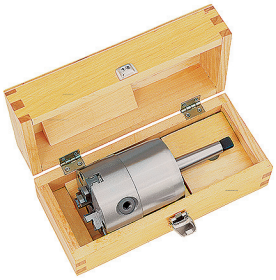
- Steel body.
- Hardened and ground scroll and pinions.
- Hardened and ground MT shank.
- Sealed ball bearings lubrication through oiler.
- 3-Jaw Lathe Chucks and can be easily removed and replaced by 4-Jaw Scroll Chucks (5", 6"), Faceplate (6"), and by the 5C Collet Chuck (5").





Standard Accessories:
3" & 4" 2-sets of hard solid jaws (ID & OD), 1 chuck wrench and 1 hex key.
5" & 6" 1-set of two-piece reversible jaws (hard top jaws & hard master jaws), 1 chuck wrench and 1 hex key.

Optional Accessories:
3" & 4" soft solid jaws,
5" & 6" soft top jaws,
4-Jaw Scroll Chuck,
6" Faceplate and 5" 5C Collet Chuck.



Rotating chucks are provided in a wooden case.

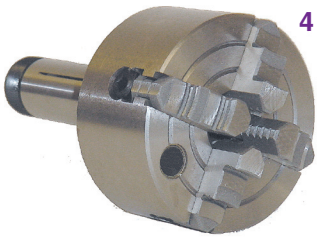
5" & 6" with American Standard Two-Piece Tongue & Groove Jaws

Chuck Dia.	Max. R.P.M.	MT No.	Weight lbs.	Solid Jaws 9154		2-Piece Jaws 9155	
				Order No.	Price	Order No.	Price
3"	4000	2	8.0	8600300		-	
4"	3500	3	13.5	8600400		-	
5"	3200	4	25.0	8600500		8650500	
6-1/4"	3000	5	34.0	8600600		8650600	

3" LATHE CHUCKS WITH 5C MOUNT

SERIES 995:

- For use in fixtures and 5C spindles for economical set-up
- Hole thru 5C adaptor .75"



4 - Jaw

MEDA Superior Import

3 - Jaw	Order No. 6000330	Price	
4 - Jaw	Order No. 6000063	Price	

Tel: 201-518-8461 / Fax: 201-596-3427
650 Huyler St / So. Hackensack, NJ 07606 USA

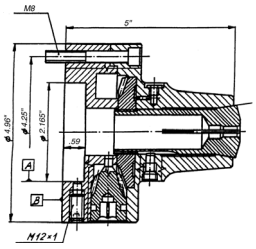
SUPER PRECISION 5C COLLET CHUCKS WITH FINE ADJUSTMENT

SERIES 292:

FOR MOUNTING WITH ADAPTER PLATES (SEE BELOW) 0.0004" T.I.R. AND 6000 R.P.M.

The Super Precision 5C Collet Chucks are designed for use with all 5C Collets. They can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines. The simple key operated scroll provides a uniform, distortion free clamping of the workpiece and low collet exchange time.
Four fine adjustment screws are used to set up the chuck on its mounting plate to get precision within **.0004" T.I.R.** on duplicate parts.
Outstanding accuracy, low cost, versatility and long life make **BISON** 5" **5-C SET TRU** Chucks invaluable in the workshop and indispensable in the toolroom.
BODY - made of high quality **FORGED STEEL.**
FORGED SCROLL - fully hardened & ground for longer life.
PINIONS - hardened and ground.

Standard Accessories:
1 Chuck Wrench,
1 set of mounting bolts,
1 hex key.



3960-5C

Chuck Dia.	5C Collet Holding Capacity In.	R.P.M.	Weight lbs.	Order No.	Price
5"	3/64 x 1-1/8	6000	12	**9620505**	

FULLY MACHINED STEEL ADAPTERS FOR A, D, DIN AND THREADED SPINDLES

SERIES 266:

Chuck Dia.	Taper Size	Order No.	Price
5"	A-4 A-5 A-6	**7874054** **7874055** **7874056**	
	D1-3 D1-4 D1-5 D1-6	**7875053** **7875054** **7875055** **7875056**	
	L00	**7879905**	
	1-1/2" x 8 2-3/16" x 10 2-1/4" x 8	**7876052** **7876054** **7876056**	

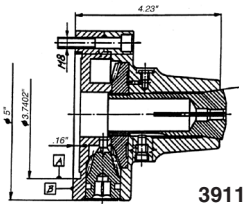
5C COLLET CHUCKS

SERIES 292:

FOR MOUNTING WITH ADAPTER PLATES (SEE BELOW) 6000 R.P.M.

The 5C Collet Chucks are designed for use with all 5C Collets. They can be used for turning, facing, boring, grinding and milling operations on center lathes and grinding machines.
The simple key operated scroll provides a uniform, distortion free clamping of workpieces and low collet exchange times. Their simple design, rugged construction and fine workmanship assures high quality and long service life.
BODY - made of high quality **FORGED STEEL.**
FORGED SCROLL - fully hardened and ground for longer life.
PINIONS - hardened and ground.

Standard Accessories:
1 Chuck Wrench, 1 set of mounting bolts, 1 Hex Key.



3911-5C

Chuck Dia.	5C Collet Holding Capacity In.	R.P.M.	Weight lbs.	Order No.	Price
5"	3/64 x 1-1/8	6000	10	**620501**	

MACHINED ADAPTERS FOR A,D, DIN, NST & THREADED LATHE SPINDLES

SERIES 291:

Chuck Dia.	Taper Size	Order No.	Price
5"	A-6 A-8	**7877001** **7877002**	
	D1-3 D1-4 D1-5 D1-6	**7878053** **7878054** **7878055** **7878056**	
	L00	**7879051**	
	M39 x 4	**7922051**	
	2-3/16" - 10	**7922053**	

SEMI-MACHINED ADAPTERS FOR THREADED LATHE SPINDLES

SERIES 291:

Chuck Dia.	Spindle Size	Order No.	Price
5"	1 x 10 1-1/2 x 8 Rough	**7871051** **7871052** **7870105**	