



# PBA Pratt Burnerd Quick-Change 2-Jaw Power Chucks

## Constant Grip High Speed Thru-Hole Power Chucks

Jaw Presetting Fixture Order number 1009-07090

for use with 6", 8", 10", 12", 15", 18", and 20" sizes Standard Bore and King Bore Models Quick Change Jaw Power Chucks.

- ⌚ One Year Warranty
- ⌚ ±.0005" Repeatability
- ⌚ 4-Point Adjusting Feature in the chuck body allows you to true up to virtually zero. Increase Soft Jaw Life by using the adjustment feature instead of skim cutting soft jaws as often. 6 points on 15" chucks and larger
- ⌚ High RPM ... up to 6,000 using standard top jaws ... without loss of gripping force, due to internally counter-balanced design.
- ⌚ Quick Change Master Jaws, 2 sets supplied with each chuck permits offline pre-assembly of top tooling for next job **reducing traditional setup time by 95%**.
- ⌚ SAFE Visual Indicator shows when Master Jaws are in the unlocked mode.
- ⌚ Master jaws available in 1.5mm x 60° (Japanese type), 1/16" x 90°, Acme serration and square serration, American Standard tongue and groove.
- ⌚ Utilize existing top tooling by selecting style of master jaws from 1.5 x 60, 1/16" x 90, Am. Std. Acme, Am. Std Tongue & Groove and Square Serrations or substitute mono block jaws. Sets can be mixed styles.
- ⌚ Large Thru-Hole Capacity
- ⌚ Utilize the machine's existing actuating cylinder - including Japanese types.
- ⌚ Easy Installation - removable blank sleeve in the chuck allows the customer to bore and thread the sleeve of the chuck to match existing drawtube of drawbar PBA can supply chuck sleeve pre-threaded on request, at a nominal charge.
- ⌚ Optional Jaw Setting Fixture for presetting top jaws off the machine for the next job, while the machine is still running. A real timesaver!
- ⌚ Sizes 6", 8", 10", and 12", diameters...other sizes available on request.

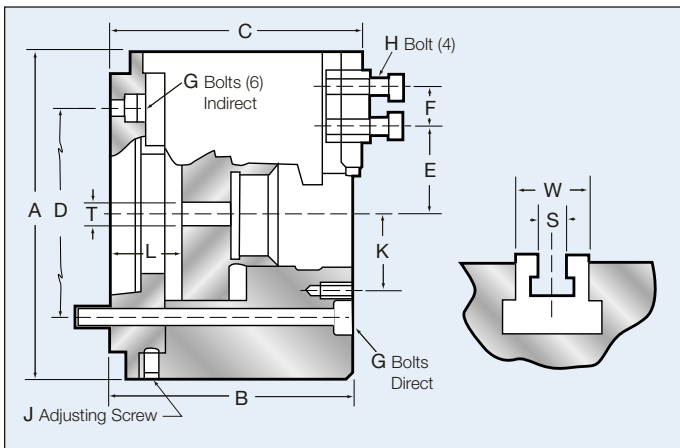
Chuck Size	Mount (D)Direct (I)Indirect	RPM	Model No. ①	Jaw Stroke	Sleeve Stroke	Thru Hole	Collet Pad Bar Capacity	Tooling Hole Size	Operating Force lbs/f	Grip Force lbs/f	Wt (lbs)
6.5"	A2-4(I)	6000	9141-217__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
6.5"	A2-5(D)	6000	9141-317__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
6.5"	A2-6(I)	6000	9141-417__	.140"	.630"	1.65"	1.5"	5/16" UNC	2,400	6,600	31
8.25"	A2-5(I)	5500	9141-321__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
8.25"	A2-6(D)	5500	9141-421__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
8.25"	A2-8(I)	5500	9141-521__	.140"	.630"	2.05"	2.0"	5/16" UNC	4,100	10,000	53
10.0"	A2-6(I)	5000	9141-426__	.160"	.730"	2.56"	2.5"	3/8" UNC	4,800	13,200	82
10.0"	A2-8(D)	5000	9141-526__	.160"	.730"	2.56"	2.5"	3/8" UNC	4,800	13,200	82
12.0"	A2-8(I)	4200	9141-531__	.160"	.730"	3.54"	3.0"	3/8" UNC	6,600	18,000	150
12.0"	A2-11(D)	4200	9141-631__	.160"	.730"	3.54"	3.0"	3/8" UNC	6,600	18,000	150

① Insert last two digits for Master Jaw type...Example 9141-21723...Indicates 1.5mm x 60°: Master Jaw Required  
 Use 23 for 1.5mm x 60° Japanese type.  
 Use 26 for Acme Serration.  
 Use 10 for 1/16 X 90° Serrations.  
 Use 07 for Am. Std Tongue & Groove.  
 Use 27 for Square Serration.

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

## Dimensional and Performance Data (in inch)

Chuck Size	A	B	C	D	F	E		G	H	J	K	L		S	W
						Max	Min					Min	Max		
6-A4	6.5	4.685	4.803	3.250	.787	2.126	1.339	M10x25(6)	M10x25	5/16 UNFx1/2	2.99	.94	1.57	.475	1.22
6-A5	6.5	4.842	4.960	4.125	.787	2.126	1.339	M10x130(4)	M10x25	5/16 UNFx1/2	2.99	1.10	1.73	.475	1.22
6-A6	6.5	5.078	5.196	5.250	.787	2.126	1.339	M12x30(6)	M10x25	5/16 UNFx1/2	2.99	1.50	2.13	.475	1.22
8-A5	8.25	5.119	5.275	4.125	1.000	2.637	1.733	M10x30(6)	M12x35	3/8 UNFx3/4	3.94	.98	1.61	.551	1.57
8-A6	8.25	5.354	5.510	5.250	1.000	2.637	1.733	M12x130(4)	M12x35	3/8 UNFx3/4	3.94	1.19	1.81	.551	1.57
8-A8	8.25	5.705	5.862	6.750	1.000	2.637	1.733	M16x30(6)	M12x35	3/8 UNFx3/4	3.94	2.02	2.65	.551	1.57
10-A6	10	5.511	5.669	5.250	1.181	3.268	2.087	M12x35(6)	M12x35	1/2 UNFx3/4	4.53	1.02	1.75	.630	1.57
10-A8	10	5.905	6.063	6.750	1.181	3.268	2.087	M16x150(4)	M12x35	1/2 UNFx3/4	4.53	1.44	2.15	.630	1.57
12-A8	12	6.614	6.771	6.750	1.181	4.291	2.362	M16x40(6)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81
12-A11	12	6.614	6.771	9.250	1.181	4.291	2.362	M16x160(4)	M14x45	1/2 UNFx3/4	5.71	1.30	2.03	.710	1.81



### (T) Draw Tube Thread Blank

1. Dimensions listed are with 1.5 x 60° Japanese type master jaws. Some dimensions will vary using other Master Jaw types such as Acme, 1/16" x 90° or Am. Std. Tongue & Groove.
2. Chuck is at mid stroke with master jaws flush with the body O.D.
3. UNC mounting bolts available upon request.



Mono block jaws are extremely accurate solid one piece design ideal for dedicated jobs, and will allow you to work closer to the chuck face, due to no jaw bolt obstructions. For longer service **Mono Block Jaws** are made from a nitride hardening material to allow hardening after forming without major distortion.

**Mono Block Jaws**  
See page 70 Dimensions.

## Extra Sets of Master Jaws for Quick Change Jaw Power Chucks

	6"	8"	10"	12"
Master Jaw Type - 15mm x 60° Fine Serration (Japanese Type)	8140-17623	8140-21623	8140-26623	8140-31623
1/16 x 90° Fine serration (European Type)	8140-17610	8140-21610	8140-26610	8140-31610
Acme Serration	N/A	8140-21626	8140-26626	8140-31626
American Std. Tongue & Groove	8140-17607	8140-21607	8140-26607	8140-31607
Square Serration	N/A	8140-21627	8140-26627	8140-31627
Mono Block Jaw***	8130-17601P	8130-21601	8130-26601	8130-31601

\*\*\* Also available in longer pointed design