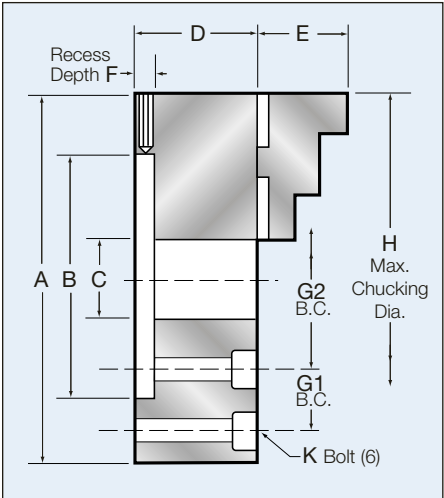




# PBA Pratt Burnerd Self-Centering Universal SETRITE Chuck

## 253 Series - 3 Jaw • 263 Series - 6 Jaw Direct Replacement for the Buck Ajust-Tru® Early Design

- Ⓐ Two-year warranty   Ⓐ Precision manufactured for adapter mounting
- Ⓐ .0005 TIR repeatability on duplicate parts   Ⓐ Steel body on sizes 6" thru 24"
- Ⓐ Semi-steel body on the 5" chucks   Ⓐ 4 adjusting screws - 5", 6", 8", 10", 12"
- Ⓐ 8 adjusting screws - 15"   Ⓐ Sizes 5" to 15", larger sizes available on request
- Ⓐ Nitride hardened scroll   Ⓐ Hardened pinion
- Ⓐ Two-piece American standard tongue and groove jaws on chuck sizes 6" thru 24"
- Ⓐ 5" chucks equipped with one set of solid I.D. jaws and one set of solid O.D. jaws
- Ⓐ One pinion - 5", 6", 8", 10", 12"; 3 pinions - 15", 18", 24" - **Larger Models Available**
- Ⓐ Durability - double the contact surface of the master jaw and body versus our competitor's chucks



Jaws shown in O.D. position

Chuck Size (in)	Model Number	Approx. Weight (lbs)	Maximum RPM*
<b>253 Series - 3 Jaw</b>			
5	0515400	14	5000
6	0625300	26	4900
8	0825300	46	4200
10	1025300	71	3300
12	1225300	112	2300
15	1525300	146	2000
18	1825300	270	1300
24	2425300	550	850
<b>263 Series - 6 Jaw</b>			
5	0516400	15	2600
6	0626300	27	2500
8	0826300	49	2200
10	1026300	76	1900
12	1226300	116	1500
15	1526300	205	1300
18	1826300	290	1100
24	2426300	570	700

\*Eccentric adjustment of chuck on mounting plate to obtain required TIR on the workpiece may result in unacceptable vibration at these speeds. Reduce RPMs accordingly. Jaws must be fully engaged in the chuck body.

### Dimensional Data for Series 253 & 263 Adapter Mounting Self-Centering Chucks

Chuck Size	A	B*	C	D	E	F	G1	G2	H	K	Gripping Capacity	
											Min.**	Max.
5"	5.00"	2.375"	1.30"	2.84"		.66"	4.44"	-	5.00"	1/4"	1/16"	4"
6"	6.31"	3.125"	1.81"	2.88"	1.59"	0.69"	5.34"	-	7.31"	1/4"	3/16"	5"
8"	8.25"	4.750"	2.25"	3.25"	1.75"	0.75"	7.50"	-	9.25"	3/8"	3/16"	6 1/2"
10"	9.85"	6.375"	3.00"	3.63"	2.13"	0.81"	-	4.38"	11.00"	7/16"	3/16"	8"
12"	12.20"	7.906"	4.06"	4.00"	2.28"	0.84"	-	5.25"	14.00"	1/2"	3/4"	10"
15"	15.74"	11.7812"	4.56"	5.13"	3.16"	1.13"	-	6.75"	17.00"	5/8"	1 1/2"	13"
18"	18.00"	11.781"	5.04"	5.781"	3.27"	1.125"	-	6.75"	19.00"	5/8"	1 1/2"	16"
24"	24.00"	16.030"	7.025"	6.530"	3.27"	1.188"	-	9.25"	25.00"	3/4"	2	22"

\* Tolerance - .000/+ .001   \*\*6-Jaw Chuck minimum grip, consult factory   Ⓐ Recess can be opened up to 2.745" - 2.755"  
Soft top jaws shown on page 75. © Ajust-Tru is a registered trade mark of Illinois Tool Works.

HOW TO ORDER: State quantity, Model Number of chuck, Part Number of adapter, and shipping instructions.

## Pratt Burnerd Mounting Plates For "SETRITE"™ 3 Jaw and 6 Jaw - 253 & 263 Series Chucks

PBA offers a full line of Mounting Plates type "D", "A", "L" and threaded plates for the "SETRITE" Chucks. PBA Mounting Plates are interchangeable with other popular adjustable universal style Chucks.

Mounting plates are precision machined to suit the spindle nose of your machine. For maximum accuracy of "SETRITE" mounting plates, mount plate on machine spindle nose, place a dial indicator on the chuck side face of the adapter close to the mounting holes, rotate the adapter and if the total indicator reading (TIR) exceeds .0005" take a light truing cut across the face of the mounting plate.

### Type D Mounting Plates "Camlock"

Spindle	6"	8"	10"	12"	15"	18"	24"
D-3	0605020	0805020	-	-	-	-	-
D-4	0605021	0805021	1005021	-	-	-	-
D-5	0605022	0805022	1005022	-	-	-	-
D-6	-	0805023	1005023	1205023	1505023	-	-
D-8	-	-	1005024	1205024	1505024	1805024	2405024
D-11	-	-	-	1205025	1505025	1805025	2405025

### Type A American Standard Short Taper A-1 & A-2, Spindles

Spindle	6"	8"	10"	12"	15"	18"	24"
A-4	0605009	-	-	-	-	-	-
A-5	0605010	0805010	1005010	-	-	-	-
A-6	-	0805011	1005011	1205011	-	-	-
A-8	-	-	1005012	1205012	1505012	1805012	-
A-11	-	-	-	-	1505013	1805013	2405013
A-15	-	-	-	-	-	-	2405014

### Type L American Standard Long Taper Key Drive Spindle

Spindle	6"	8"	10"	12"	15"	18"	24"
L-00	0605031	0805031	1005031	-	-	-	-
L-0	0605032	0805032	1005032	1205032	-	-	-
L-1	-	0805033	1005033	1205033	1505033	1805033	2405033
L-2	-	-	1005034	1205034	1505034	1805034	2405034
L-3	-	-	-	-	1505035	1805035	2405035

### For Hardinge® and Elgin Lathe Threaded & Blank Mountings for SETRITE™ Chucks

Spindle	5"	6"	Spindle	5"	6"	8"	10"	12"
4° Taper	0505044	0605044	Blank	0505040	0605040	0805040	1005040	1205040
2 <sup>3</sup> / <sub>16</sub> "-10	0505045	0605045	1 <sup>1</sup> / <sub>2</sub> "-8	0505041	0605041	0805041	-	-
Threaded			1 <sup>3</sup> / <sub>4</sub> "-8	0505042	0605042	0805042	-	-
			2 <sup>1</sup> / <sub>4</sub> "-8	0505043	0605043	0805043	-	-
			2 <sup>3</sup> / <sub>8</sub> "-6	-	0605046	0805046	-	-

Also available plates for rotary tables

\*Threaded adapter plates and special plates are available upon request.

"SETRITE" chucks and adapters are shipped unassembled unless ordered assembled at extra charge.

When ordering special adapters give make, model number, size, and spindle dimensions of machine.

For standard spindle dimensions, see page 109.