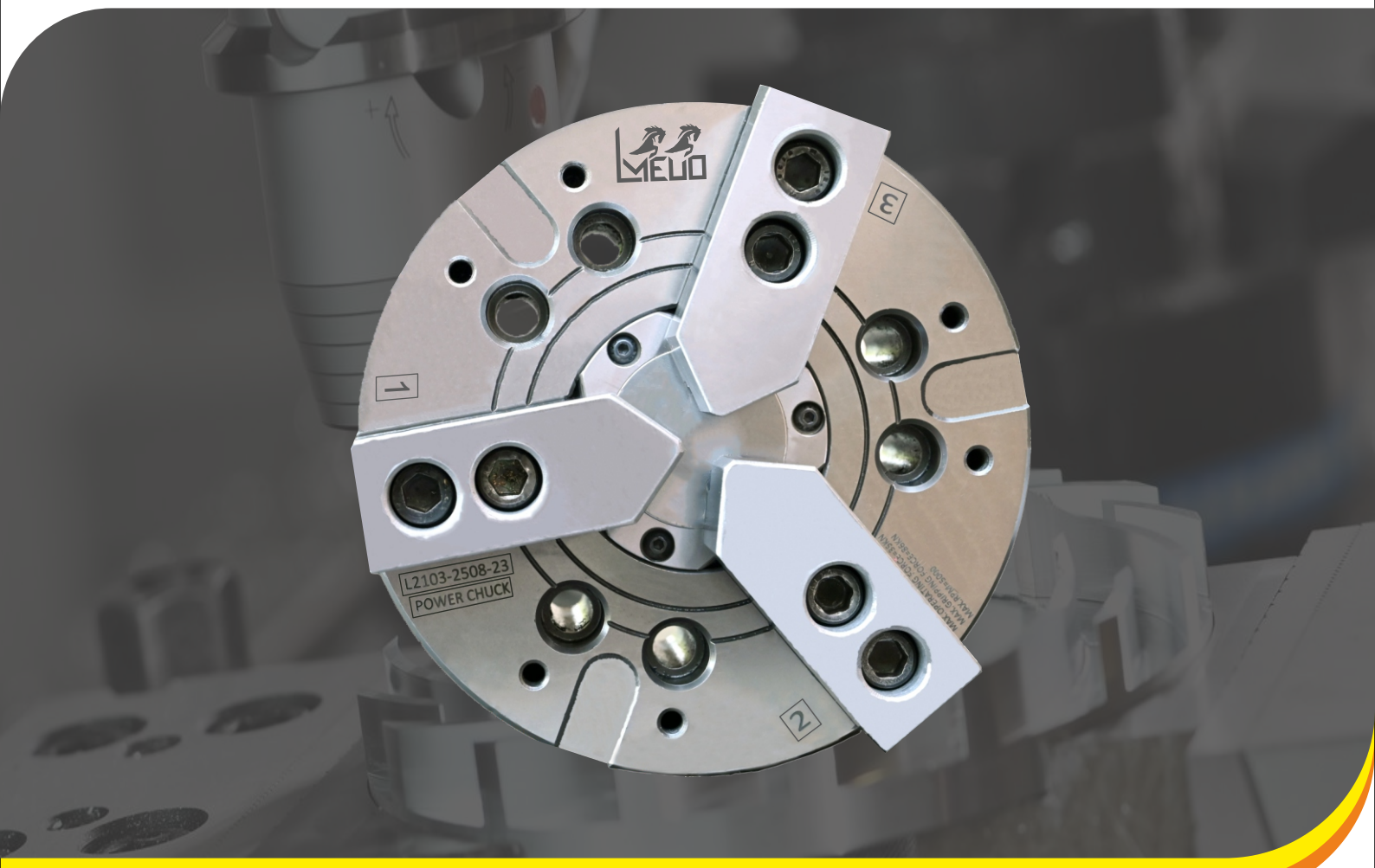
POWER CHUCK

Ensure consistency, repeatability and efficiency to maximize your production capacity



CHOOSE LMEUO POWER CHUCK

We are working towards supporting manufacturing around the world via our range of Chucks, Power chucks and accessories.

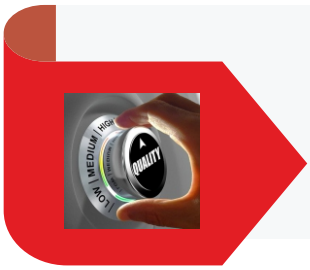
VISION & MISSION

We are working towards supporting manufacturing around the world via our range of Chucks, Power chucks and accessories to ensure consistency, repeatability and efficiency to maximize your production capacity

CREDO

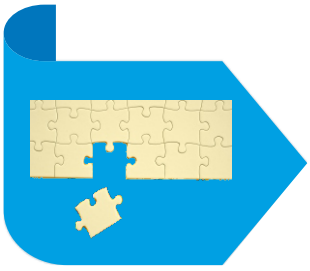
We deliver what we show and promise

Every time and everything we commit and promise, small or large, we deliver the same. That's how we have built trust amongst you all. Rather we are planning to go above and beyond to make even stronger impression.



Consistent quality every time

For us consistent quality isn't just about offering a product that exceeds the industry standard, but it's also the main reason for the reputation we have gained.



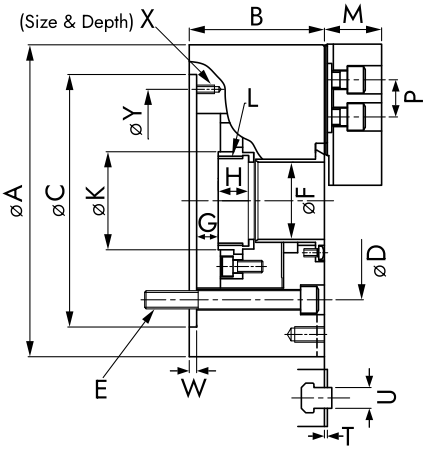
Perfect Products and its durability

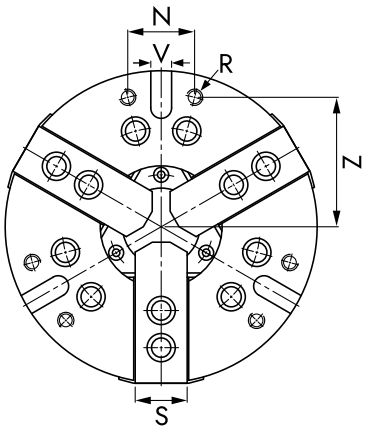
Latest Technology : We use latest machines and our team is committed to consistent quality.

OPEN CENTER POWER CHUCK

SERRATION PITCH 1.5mm X 60°

LMEUO Large Thru-Hole (Open Center) Wedge Type Power Operated Chucks are ideal for high speed Universal machining requirements. These are manufactured out of High Quality alloyed steels which are tested metallurgically and physically before processing. All the parts are suitably heat treated and are precisely ground to perfection which ensures high accuracy and a long service life. These chucks need to be fitted with suitable Mounting flanges. All sizes are available in 2, 3 & 4 Jaw configurations except 110mm size in which 4 - Jaw is not available.





2 - JAW

4 - JAW

DIMENSIONS

Size	A	B	C (H6)	W	D	E Allen Bolt	F (Bore)	G Max.	G Min.	H	K	M
110	110	59	85	4	70.6	M10	26	3.5	-6.5	17.5	38	24
135	135	60	110	4	82.6	M10	33	1	-9	20	45	26
170	169	81	140	5	104.8	M10	45	11	-1	19	60	29
210	210	91	170	5	133.4	M12	52	14.5	-1.5	20.5	66	39
254	254	100	220	5	171.4	M16	75	8.5	-10.5	25	94	43
304	304	110	220	6	171.4	M16	91	8	-15	28	108	51
380	381	133	300	6	235	M20	117.5	9	-14	34	139	80

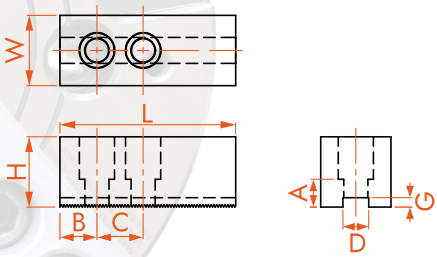
Size	U	P	T	S	V	Z	N	R	L Max. Draw Nut Thread	X (3 Holes)	Y
110	10	14	2	23	10	45	25	M6	M32 x 1.5	–	–
135	10	14	2	23	10	52	30	M6	M40 x 1.5	–	–
170	12	20	2	32	16	65	36	M8	M55 x 2	M6 x 10	116
210	14	25	2	37	16	85	45	M8	M60 x 2	M6 x 12	150
254	16	30	2	42	16	105	60	M10	M85 x 2	M8 x 15	190
304	21	30	2	52	20	125	60	M10	M100 x 2	M8 x 15	190
380	25.5	43	5.5	62	20	155	80	M12	M130 x 2	M10 x 20	260

SPECIFICATIONS

Size	Serration Pitch	Jaw Stroke Diametrically (mm)	Plunger Stroke (mm)	Maximum RPM	Max. Operating Pressure Kgf/cm²	Mpa	Max. Draw Bar Pull Force kN	Kgf	Max. Gripping Force kN	Kgf	Gripping Range (mm) Max.	Min.	Wt. Approx. With Top Soft Jaws**
110	1.5mm x 60°	5.4	10	7000	28.6	2.80	14.0	1428	28.5	2906	110	7	4.0
135	1.5mm x 60°	5.4	10	6000	28.6	2.80	17.5	1784	36.0	3671	135	12	6.7
170	1.5mm x 60°	5.5	12	6000	28.6	2.80	22.0	2243	57.0	5812	169	16	11.9
210	1.5mm x 60°	7.4	16	5000	27.0	2.65	34.8	3549	86.0	8769	210	13	22.3
254	1.5mm x 60°	8.8	19	4200	27.5	2.70	43.0	4385	111.0	11319	254	31	34.5
304	1.5mm x 60°	10.6	23	3200	27.5	2.70	55.0	5608	144.0	14686	304	34	55.3
380	1.5mm x 60°	10.6	23	2500	33.7	3.30	88.2	9000	223.0	22800	380	50	97.0

SOFT JAWS

FLAT

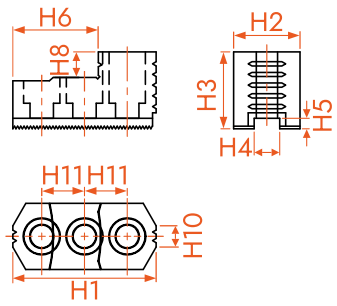


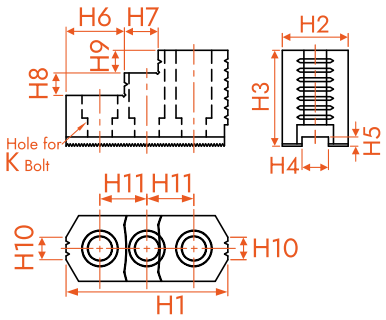
POINTED

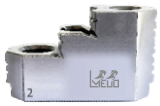
Size	L	H	H (Extra Height)	W	A	B	C	D	G	K	K1	K2	Pointed		Serration Pitch
													R	S	
110	55	30	56, 76	23	8.5	10	14	10	4	M8 x 20	13.5	8.5	4	8	1.5mm x 60°
135	55	30	56, 76	23	8.5	12	14	10	4	M8 x 20	13.5	8.5	4	8	1.5mm x 60°
170	75	38	56, 76, 100	31	12	15	20	12	5	M10 x 25	17	11	8	15	1.5mm x 60°
210	95	38	56, 76, 100, 120	38	15	20	25	14	5	M12 x 30	19	13	8	20	1.5mm x 60°
254	115	50	80, 100, 120	45	15	25	30	16	5	M12 x 30	19	13	8	20	1.5mm x 60°
304	120	60	80, 100, 120	48	17	30	30	21	4	M16 x 40	25	17	12	20	1.5mm x 60°
380	165	75	100, 127	62	**21**	26	43	25.5	5	M20 x 60	32	21	12	25	1.5mmx60°

HARD JAWS

SINGLE STEP







DOUBLE STEP

Size	H1	H2	H3	H4	H5	H6	H7	H8	H9	H10	H11	K	Serration Pitch
110	53	23	27.5	10	4	30.5	-	10	-	6	14	M8 x 20	1.5mm x 60°
135	53	23	27.5	10	4	30.5	-	10	-	6	14	M8 x 20	1.5mm x 60°
170	67	31	41	12	5	18	17	9	9	10	20	M10 x 25	1.5mm x 60°
210	86	35	51	14	5	31	18	12	12	12	25	M12 x 30	1.5mm x 60°
254	99.5	40	54	16	5	43	17	13	13	15	30	M12 x 30	1.5mm x 60°
304	103	50	52	21	4	62.5	-	17	-	30	30	M16 x 40	1.5mm x 60°
380	149	62	86	25.5	5	69	27	20	20	43	43	M20 x 60	1.5mm x 60°

PRECAUTIONS & FEATURES

Lubricate the chuck every day.

Use recommended grease.

Operate the full stroke of the chuck at least once a day.

Disassemble & assemble the chuck at periodic intervals for checking the wear of contact surfaces and ensuring that Adequate grease is being fed to contact surfaces through grease nipple.

While forming soft jaws, take care to form and keep the height of soft jaws as low as possible.

Maximum length of job to be clamped should be less than thrice the height of top jaws.

Adjust the rotational speed accordingly for special purpose jaws.

Before running the chuck at higher speeds always keep a check on max. Input force and static Gripping force.

Prefer steady rests or tail stock while machining long job.

Always clamp the component in the middle of jaw stroke.

Always follow the cutting parameters recommended by manufacturers of tooling providers.

Replace the damaged part immediately, if any.

Height of top jaws should always be less than its length.

While clamping from internal diameter, reduce the input force accordingly.

Ensure that while mounting the chuck, there is a gap of 0.5mm approx. between the bottom face of wedge and inner face of body.

Ensure that T-nut does not protrudes outside the periphery of the base jaw while clamping the top jaw

Do not try to redesign the chuck in any manner.

Do not operate the opening/shutting valve while the chuck is Rotating, work could fly out causing serious injury.

Do not use too long clamping screws for attaching top jaw to base jaw.

Do not operate the chuck at higher than recommended speeds.

Do not operate the chuck with more than recommended input force; it may damage the mating parts.

Do not tighten the clamping screws with excess of tightening torque than recommended. This may cause the screws to break while in operation causing serious accident.

Never use iron hammer on any part of the chuck

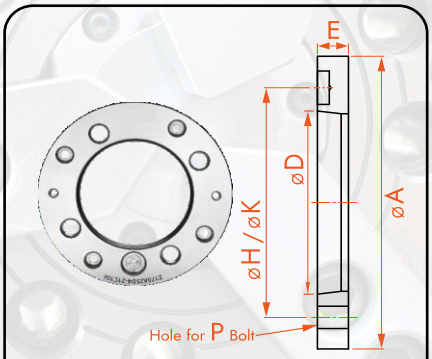
Don't hit the wedge with inner surface of chuck body. This might cause the body to deform.

Do not operate the chuck with dust cover removed.

Do not repair any broken or worn part on your own by welding or any other method. This may cause inappropriate working of chuck.

Use coolant with anti-rust properties only.

MOUNTING FLANGES FOR POWER CHUCKS



Spindle PCD (øH) is EQUAL to Chuck PCD (øK)

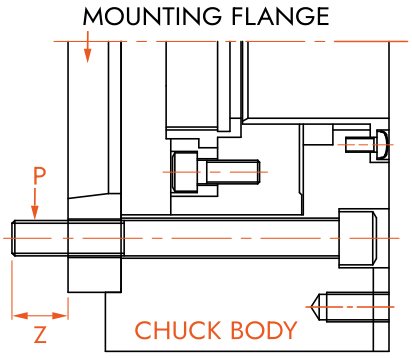
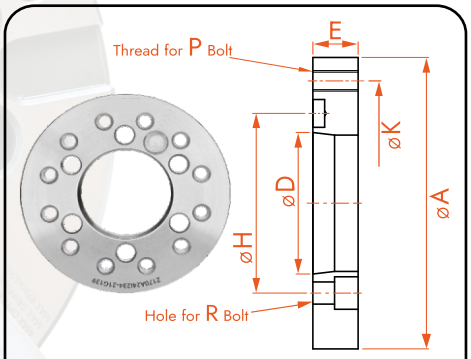


Fig. 1 (DIRECT Type)



Spindle PCD (øH) is SMALLER than Chuck PCD (øK)

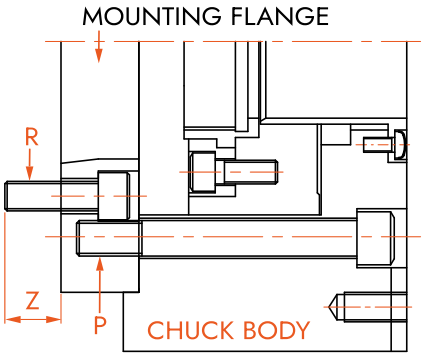
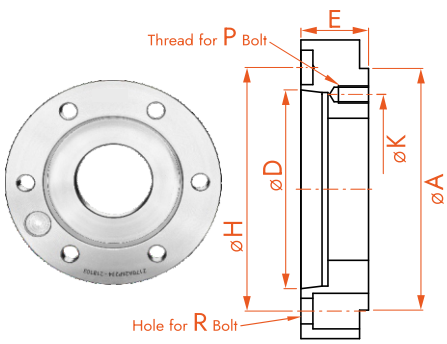


Fig. 2 (INDIRECT Type)



Spindle PCD (øH) is LARGER than Chuck PCD (øK)

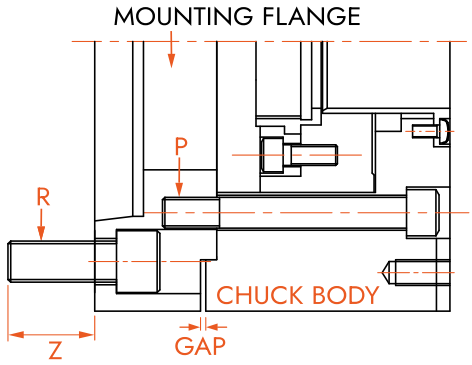
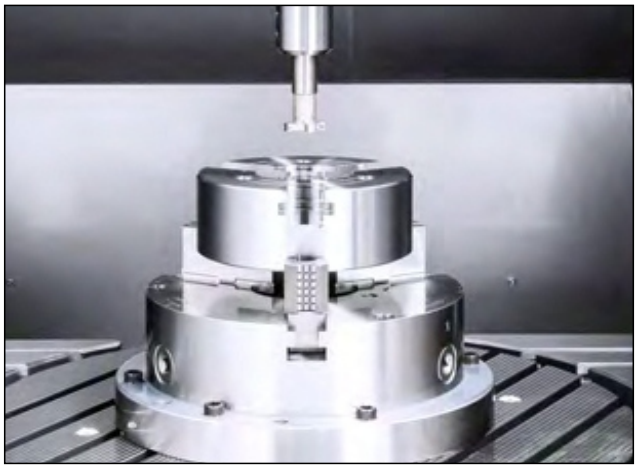


Fig. 3 (PLATE Type)

Chuck Size	Spindle Nose	D	H Spindle PCD	K Chuck PCD	Type of Mounting	Figure	A	E	P Allen Bolt	R Allen Bolt	Z
110	A2-4	63.513	82.6	70.6	Plate Type	Fig. 3	85	40	M10	M10	15
	A2-5	82.563	104.8	70.6	Plate Type	Fig. 3	85	40	M10	M10	15
135	A2-4	63.513	82.6	82.6	Direct Type	Fig. 1	110	15	M10	-	15
	A2-5	82.563	104.8	82.6	Plate Type	Fig. 3	110	40	M10	M10	15
170	A2-4	63.513	82.6	104.8	Indirect Type	Fig. 2	140	20	M10	M10	16
	A2-5	82.563	104.8	104.8	Direct Type	Fig. 1	140	15	M10	-	15
	A2-6	106.375	133.4	104.8	Plate Type	Fig. 3	140	40	M10	M12	17
	A2-8	139.719	171.4	104.8	Plate Type	Fig. 3	140	45	M10	M16	20
210	A2-4	63.513	82.6	133.4	Indirect Type	Fig. 2	170	25	M12	M10	17
	A2-5	82.563	104.8	133.4	Indirect Type	Fig. 2	170	25	M12	M10	17
	A2-6	106.375	133.4	133.4	Direct Type	Fig. 1	170	17	M12	-	18
	A2-8	139.719	171.4	133.4	Plate Type	Fig. 3	170	45	M12	M16	20
	A2-11	196.869	235	133.4	Plate Type	Fig. 3	170	55	M12	M20	28
254	A2-5	82.563	104.8	171.4	Indirect Type	Fig. 2	220	25	M16	M10	17
	A2-6	106.375	133.4	171.4	Indirect Type	Fig. 2	220	25	M16	M12	19
	A2-8	139.719	171.4	171.4	Direct Type	Fig. 1	220	18	M16	-	24
	A2-11	196.869	235	171.4	Plate Type	Fig. 3	220	55	M16	M20	28
304	A2-6	106.375	133.4	171.4	Indirect Type	Fig. 2	220	25	M16	M12	19
	A2-8	139.719	171.4	171.4	Direct Type	Fig. 1	220	18	M16	-	24
	A2-11	196.869	235	171.4	Plate Type	Fig. 3	220	55	M16	M20	28
325	A2-6	106.375	133.4	235	Indirect Type	Fig. 2	300	33	M20	M12	19
	A2-8	139.719	171.4	235	Indirect Type	Fig. 2	300	33	M20	M16	22
	A2-11	196.869	235	235	Direct Type	Fig. 1	300	22	M20	-	28
380	A2-6	106.375	133.4	235	Indirect Type	Fig. 2	300	33	M20	M12	19
	A2-8	139.719	171.4	235	Indirect Type	Fig. 2	300	33	M20	M16	22
	A2-11	196.869	235	235	Direct Type	Fig. 1	300	22	M20	-	28

Why Choose Lemuo

We follow
In-Process Quality Management



NW TECHNOLOGY
Phagwara Road, Jandiala,
Jalandhar-144 033 (Pb.) INDIA
E-mail : nwtechnology@gmail.com

Customer Care :
+91-73472-53824

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