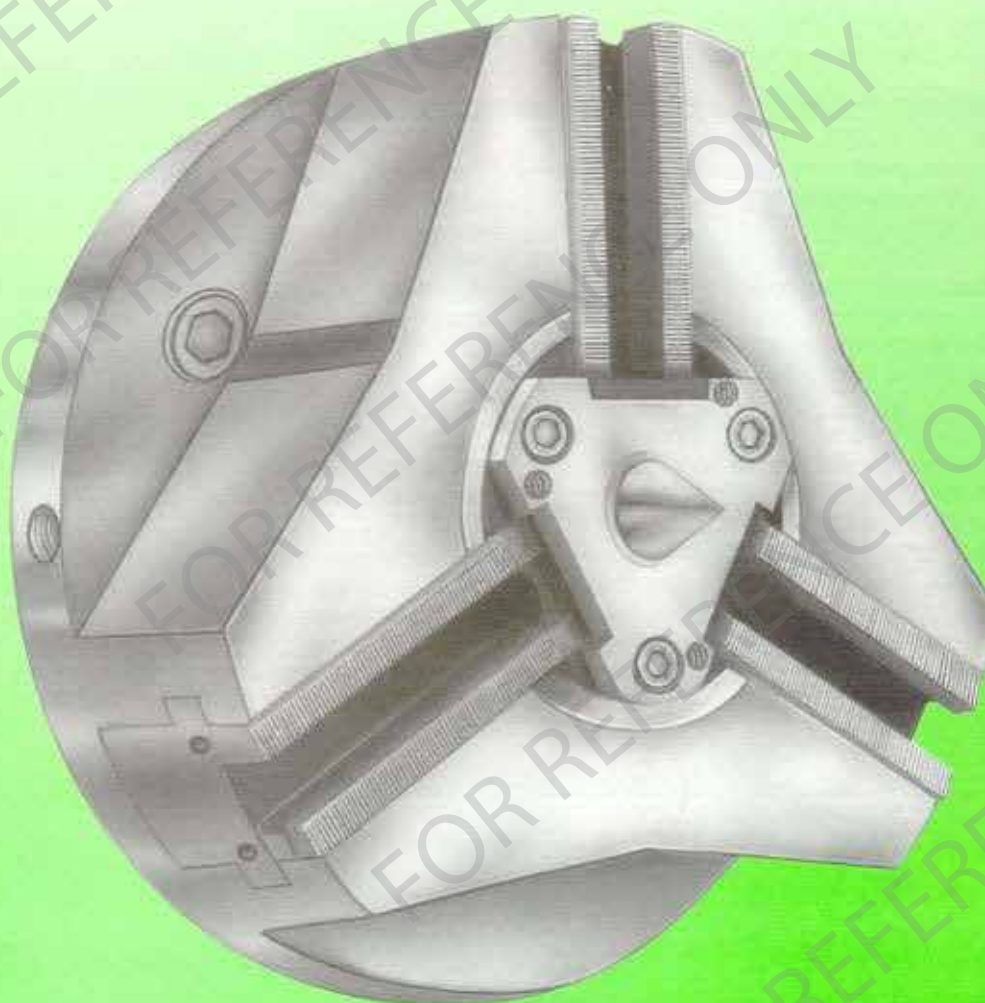
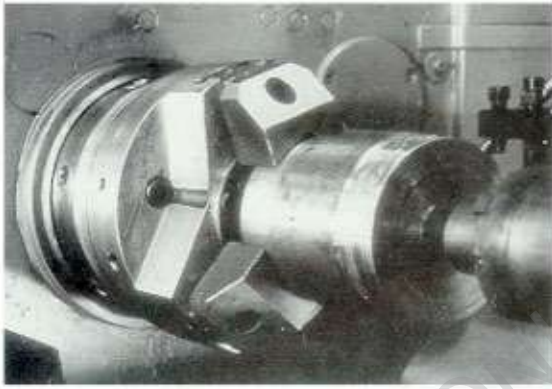


POWER OPERATED ECCENTRIC COMPENSATING CHUCK - PE





GMT Eccentric compensating chuck is used for machining forgings and black bars between centres on copy turning lathes.

GMT Eccentric compensating chucks are supplied with special cover at extra cost. This special cover fitted on the chuck in lieu of spring loaded centre to ensure that the chuck works as a self-centering type.

GMT Eccentric compensating chucks are supplied with spring loaded centre. The function of this spring loaded centre is to ensure that the component rests against its face.

GMT Eccentric compensating chuck is essentially designed where the component is usually located between two centres. One on the chuck body and one on the tail stock of the machine. Since the line of centres is defined, concentricity is guaranteed, but the function of the jaws is that they are designed to adjust and accommodate the lack of concentricity between the centre line of the component and its outside diameter.

The chuck has floating wedge for compensation

and is operated by power - hydraulic or pneumatic rotating cylinder or by an electro mechanical actuator.

In this chuck, gripping is achieved through a radially floating wedge. This wedge floats to the required extent in the body of the chuck to compensate the irregularities in the roundness of the component.

The chuck body and wedge are designed to withstand heavy cutting loads. The floating wedge is capable of withstanding high operating forces. The floating wedge with its mechanical advantage, converts the operating force into a high clamping force.

Construction

The body is of forged steel. The guideways are hardened and ground. The chuck body is suitably recessed to remove large amount of material.

The floating wedge and base jaws are made from nickel chrome steel, casehardened and ground on all working surfaces.

The base jaws are guided in the deep, wide, hardened slots in the body, which provide the ample bearing area necessary to withstand the forces resulting from high gripping forces.

Provision has been made for manual lubrication of the sliding surfaces periodically through grease nipples.

Serrations are provided on the top face of the base jaws.



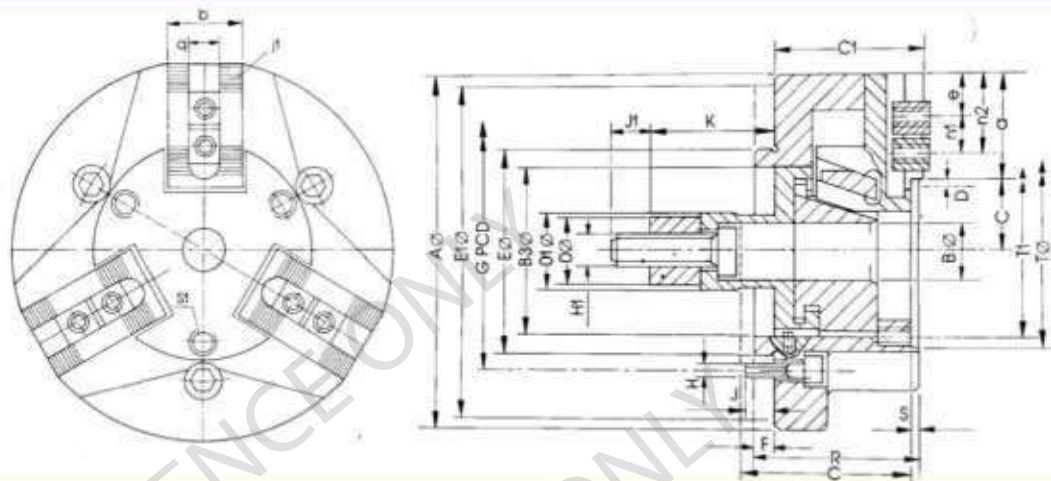
Special Cover



Spring loaded center



Solid Centre



Dimensional Specifications (All dimensions are in mm)

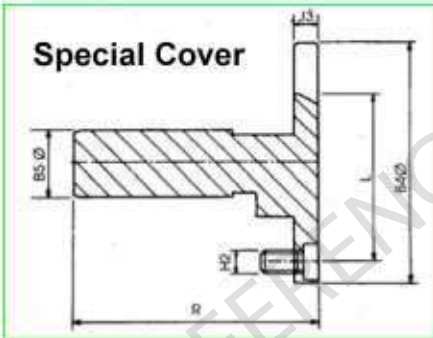
MODEL NO.	28-12	28-13	28-17	28-14	28-18	28-15	28-16
SIZE Ø	160	200	215	250	280	315	400
A Ø	160	200	215	250	280	315	400
B Ø H7	28	32	36	36	40	45	52
B3 Ø H7	82	95	116	116	136	136	155
C	84	105	118	118	118	137	157
C1	84	90	108	98.5	116	116	126
D Jaw Stroke	5	5.5	5.5	6	6	6.2	7
E Ø h6	100	115	-	130	-	152	190
E1 Ø H6	-	-	185	-	255	-	-
F	9	14	6	14	6	14	14
G (PCD)	133.4	133.4	160	171.4	171.4	235	235
H	3XM 12	3XM 12	3XM 12	3XM 16	3XM 16	3XM20	3XM20
H 1	M16	M20	M24	M24	M24	M24	M24
J	28	15	-	22.5	26	32	32
J1	40	40	55	55	50	60	60
K min	63	83	89	100	86	104	122
K max	79	100	106	119	105	123	144
O Ø	30	35	46	46	46	46	46
O1 Ø g6	38	42	50	50	50	60	70
R	91	102	112	110	120	127	136
S	6	4	4	5	5	12	12
S1	M8	M10	M10	M12	M12	M12	M12
T Ø H6	92	115	115	136	136	160	185
T1 (PCD)	76	95	95	115	115	135	160
a	49	59	66.5	79	90	108	140
b	35	40	40	40	45	45	45
c min	27	37	37	41.7	38	42.4	50.7
c max	32	42.5	42.5	48	44	48.6	57.7
d	M12	M12	M12	M12	M12	M16	M16
e min	10	10	10	10	17.5	12	12
j1 x 90°	1/16"	1/16"	1/16"	1/16"	1/16"	1/16"	1/16"
n 1	20	20	20	25	25	25	25
n2 max	38	53	62.5	66.5	77	90	128
qH7	17	17	17	17	21	21	21

Shaded sizes are special

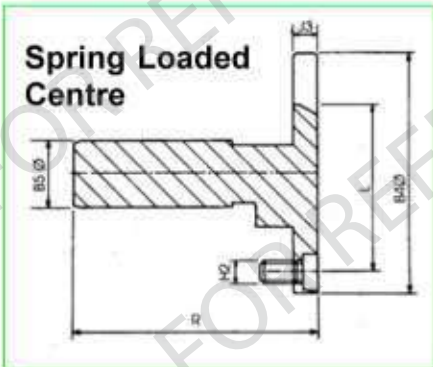
Each chuck is supplied with - one set of body champing screws, one set of jaw screws, one number spring loaded centre and one number box spanner for adjusting the drawbar. Neither Hard Jaws nor soft Jaws will be supplied with the chuck. Special Hard Jaws, and Soft Jaws, special Cover Solid centre can be supplied on request at extra cost.

Chuck performance details

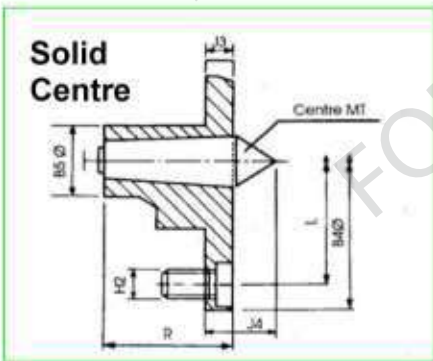
SIZE Ø	160	200	215	250	280	315	400
Drawbar pull (Kgf)	2500	3600	3000	5000	6000	6500	8000
Max gripping force (Kgf)	4500	6500	5600	9000	11000	12000	16000
RPM max	3500	3200	3200	3000	2500	2300	2200
Jaw stroke (mm)	5	5.5	5.5	6	6	6.2	7
Diametrical Compensation (mm)	3	4	4	4	4	4	4
Gd ² in kpm ²	0.16	0.31	0.46	0.9	1.5	2.1	5.7
Weight (Kgs)	13	16.5	20	27.5	30	60	74



Dimensions/Size	160	200	215	250	280	315	400
B4Ø h6	92	115	115	136	136	160	185
B5Ø h6	28	32	36	36	40	45	52
L ± 0.2	76	95	95	115	115	135	160
R	98	122	135	138	137	151	177
J3	14	17	17	20	19	20	20
H2	M8X16	M10X20	M10X20	M12X20	M12X20	M12X20	M12X20



Dimensions/Size	160	200	215	250	280	315	400
B4Ø h6	92	115	115	136	136	160	185
B5Ø	25	31	34	34	34	42	48
L ± 0.2	76	95	95	115	115	135	160
B6 Ø	18	20	25	25	25	30	32
R	98	122	135	138	137	157	177
J3	14	17	17	20	19	20	20
J4 max	26	32	33.5	38	37	44	46
J4 min	20	22	25.5	30	29	32	30
H2	M8x16	M10x20	M10X20	M12X20	M12X20	M12X20	M12X20



Dimensions/Size	160	200	215	250	280	315	400
B4Ø h6	92	115	115	136	136	160	185
B5Ø	25	27.2	27.2	32	32	40	45
L ± 0.2	76	95	95	115	115	135	160
R	53	56	56	78	78	90	90
J3-0.1	14	17	17	20	19	20	20
J4	33	36	33	42	41	44	46
H2	M8x16	M10x20	M10X20	M12X20	M12X20	M12X20	M12X20
MT Centre	MT2	MT2	MT2	MT3	MT3	MT4	MT4

Shaded sizes are special



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