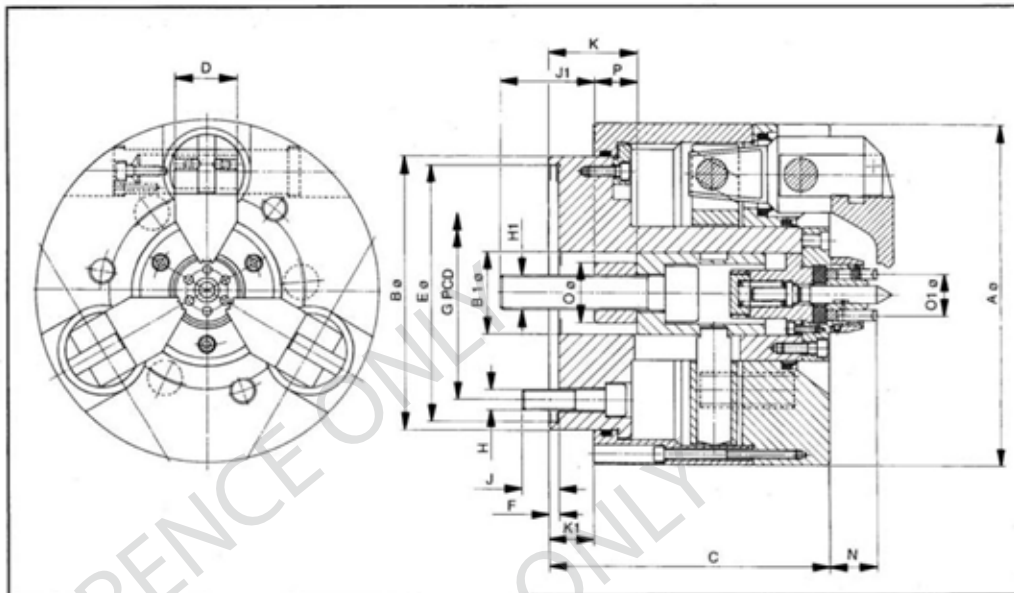




**POWER OPERATED ECCENTRIC
COMPENSATING CHUCK WITH
RETRACTABLE JAWS AND FACE DRIVER**





GMT Eccentric Compensating Chuck with Retractable Jaws and face drive (PER) is used for machining forgings and black bars between centres in single setup, (i.e.) no second operation necessary.

This Chuck is designed to machine components centre to centre with great accuracy.

The retractable jaws are actuated by a hydraulic cylinder or an also centre to centre, since the jaws have an eccentric clamping drive. After various machining operations are done on the component, without stopping the machine the clamping jaws are retracted. The torque is then transmitted through the face driver for driving the

jaws. The gripped portion can now be finished with fine depth of cut. This ensures that the component is machined right up to the chuck face and the centre to centre machining of component is completed. The chuck body is made from forged medium carbon steel and toughened. The levers and hinge pins are made from nickel chrome steel, case hardened and ground in all working surfaces. The hard jaws are made from low carbon steel, case hardened and ground.

The special jaws are designed to clamp the component as close to the centre to avoid distortion of the component and provide inconsistent gripping.

All dimensions in mm

Model	Size ϕ	A ϕ	B ϕ	B1 ϕ	C	D	E ϕ H6	F	G (PCD)	H x 3 Nos.	H1	J	J1	K		K1	
														Min.	Max.	Min.	Max.
28-21	160	160	125	38	131	29	115	6	92	M 10	M 16	15	55	13.5	43.5	1	21
28-22	200	200	160	48	164	36	150	6	125	M 12	M 20	18	70	16.5	54.5	1	21
28-23	250	250	200	60	205	45	185	6	160	M 16	M 24	30	70	20.5	68	1.5	33
28-24	315	315	250	90	205	55	220	6	171.4	M 16	M 24	25	70	20.5	68	1.5	33
28-25	400	400	335	135	205	55	300	6	235	M 20	M 24	30	70	20.5	68	1.5	33

Model	N	O ϕ	O1 ϕ	P	Jaw Movement	Wedge Stroke	Body Stroke	Compensation on dia	Min. Clamping dia.	Speed in rpm	Drawbar pull in Kg	Gripping Force in kgf	Weight in Kg
28-21	22.5	31.5	19	25	5.5	10	20	2	25	2600	2500	2500	23
28-22	28	35	24	30	6.5	13	25	3	32	2400	3100	3100	39
28-23	35	40	30	30	8	16	31.5	4	38	2400	4000	4000	74
28-24	35	40	30	30	8	16	31.5	4	38	1900	4000	4000	105
28-25	35	40	30	30	9	16	31.5	4	38	1500	4000	4000	170



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