



POWER OPERATED HAND INDEXING CHUCK POHI



POWER OPERATED HAND INDEXING CHUCKS

The production and machining of components with intersecting axes has for a long time involved high processing expenditure. These components were either processed on special machines, transfer lines or on conventional lathes in several chucking operations.

GMT has developed Indexing Chucks to meet the persistent problems in machining components with intersecting axes.

GMT indexing chucks of different sizes are designed for machining typical parts. Universal joints fittings, pumps bodies, valve bodies etc.

GMT's Power Operated Hand Indexing chucks are offered with index position:

1. $4 \times 90^\circ$
2. $3 \times 120^\circ$
3. $2 \times 180^\circ$

Indexing Accuracy

Roughing: Approx. 0.1mm at 100mm from indexing centre.

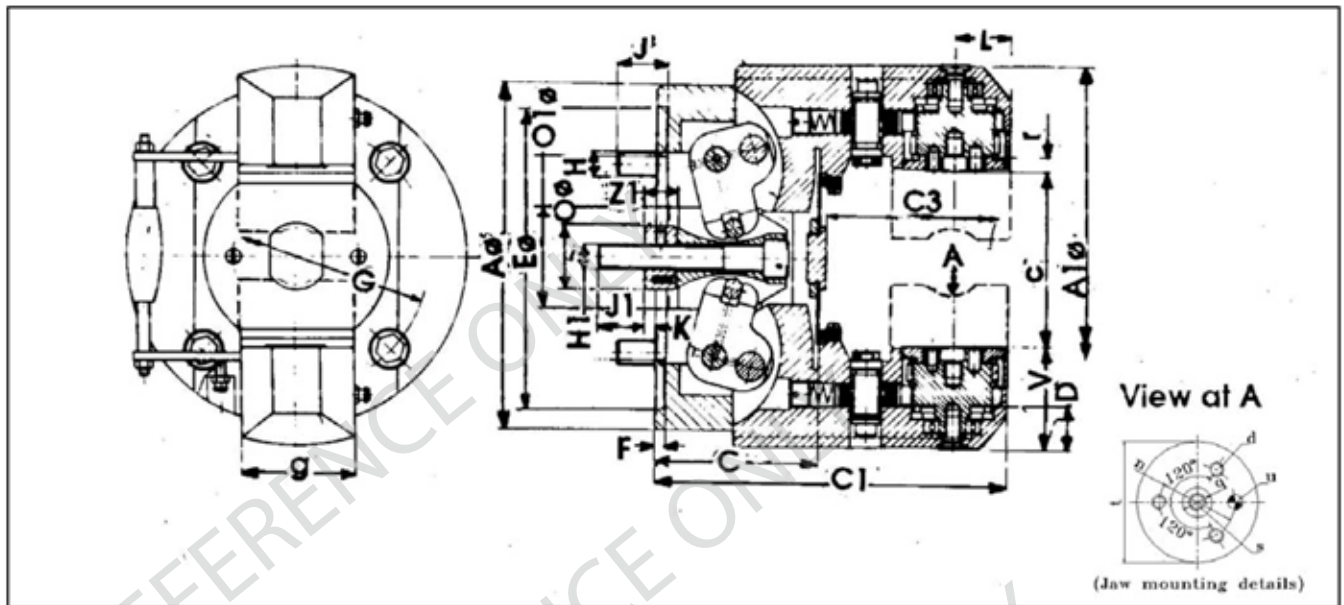
Finishing: 0.03 to 0.05 at 100mm from indexing centre.

The actuation of the two jaw power operated chuck jaws is effected by a pneumatic rotating cylinder, Hydraulic-rotating cylinder or by an Electro Mechanical Actuator.

The component is clamped between the jaws. After the machining operation is over the index lever is lifted and component with the jaws is indexed to the next position. The index lever locks automatically. All parts are made from alloy steel hardened and ground wherever necessary.

Important information required by us for preparing a quotation

1. Component drawing with operation details.
2. Sample component.
3. Machine spindle drawing.
4. Chuck diameter.
5. Voltage and frequency for power unit & solenoid valve.



DIMENSIONAL SPECIFICATIONS (All dimensions are in mm)

Model no	20-02	20-01	20-04	20-05	38-118	20-07	20-08
Size Ø	180	220	250	300	400	500	630
A Ø	180	220	250	300	400	500	630
A1 Ø	197	256	286	331	452	556	670
C	94.8	105	113	135	190	235	260
C1	197.6	225	257	317	473	618	694
C3Øswing for job	145	180	220	260	414	584	650
D Jaw stroke	14	15	17	20	34	34	34
E Ø H6	80	130	235	160	200	290	580
F	7	7	6	8	9	18	6
G PCD	140	170	200	230	325	350	500
H	4XM12	4XM16	4XM16	4XM24	4XM30	4XM30	4XM30
H1	M16	M16	M20	M24	M24	M30	M30
J	23	25	30	35	40	40	50
J1	39	38	45	50	66	62	70
K max	31	38	52	46	44	78	77
K min	8	8	18	10	16.5	14	13
L	30.5	36	42	52	76	108	108
O Ø	38	38	35	60	46	60	60
O1 Ø H5	58	65	75	100	150	170	200
Z1	25	25	30	30	30	32	32
c max	100	126	146	185	284	361	430
c min	72	96	112	145	216	293	362
d [No x size x depth]	3XM5X12	3XM6X12	3XM8X15	3XM10X15	3XM12X25	3XM14X25	3XM12X30
G	65	75	85	110	165	215	215
n PCD	27	31	42	50	84	120	120
q Ø H7	12	16	18	20	35	40	40
R	7.5	8	9	10	11	12	20
s [Size x Depth]	M8X17	M12X12	M10X15	M12X25	M20X39	M20X30	M20X30
t Ø	70	80	100	120	220	320	320
u Ø H7 [Hole size x depth]	5X15	6X15	8X15	10X10	12X21	14X20	12X30
V	48.5	65	70	73	85	98	120
RPM [Max]	2000	1600	1200	800	430	300	250
Max.Draw bar pull in Kgf	1200	1600	2000	2500	4400	6000	7500
Weight of the chuck in Kg	20	32	48	81	170	320	405

Each chuck is supplied with-one set of body clamping screw and one number special box spanner for adjusting the draw bar. Neither Hard jaws nor soft jaws will be supplied along with the chuck. However special Hard jaws and soft jaws will be supplied on request at extra cost.

Recommended Lubricants: OKS260, TP42. Lubricate once every shift, dismantle and clean once a week if service condition is severe, more frequent lubrication and cleaning is required.



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