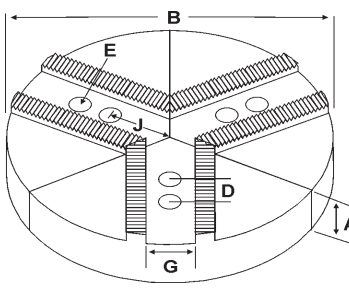
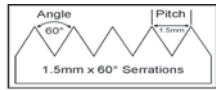
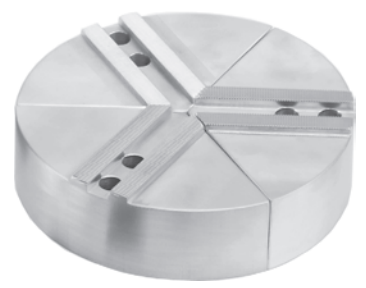


# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: **Kitagawa®, Samchully®, Strong, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA



Group  
**(K1)**



2

3

4

5

Group No.	Chuck Size	Critical Dimensions						Industry Ref #	ALUMINUM		CAST IRON		STEEL	
		Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Pie Dia B	Height Inch A		Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3
K1-08-15	4	0.315 (8mm)	6mm	0.590 (15mm)	1.000	6	2.00	KTT-4P	6-RKT-4200A	\$83.92	6-RKT-4200CI	\$135.12	6-RKT-4200S	\$212.08
		0.314		0.591			4.00	KTT4P1	6-RKT-4300A	\$106.73	-	-	-	-
		0.314		0.591			4.00	KTT4P1	6-RKT-4400A	\$131.58	-	-	-	-
K1-10-14	4	0.394 (10mm)	8mm	0.551 (14mm)	1.000	6	2.00	-	6-RKT-4205A	\$83.92	6-RKT-4205CI	\$144.31	6-RKT-4205S	\$202.43
							4.00	KW4P1	6-RKT-4405A*	\$167.85	-	-	-	-
K1-10-17	5	0.394 (10mm)	8mm	0.709 (18mm)	1.688 (1-11/16)	6	2.00	HAR5MSHP	6-RHA-5200A	\$83.92	-	-	-	-
							4.00	HAR5MSHP1	6-RHA-5400A	\$131.58	-	-	-	-
K1-10-18	5	0.394 (10mm)	8mm	0.713 (18mm)	1.250	6	2.00	KTT5P	6-RKT-5203A	\$76.06	6-RKT-5203CI	\$144.31	6-RKT-5203S	\$201.57
							4.00	KTT5P1	6-RKT-5403A	\$131.58	-	-	-	-
K1-10-19	5	0.394 (10mm)	8mm	0.748 (19mm)	1.250	6	2.00	HOW5P	6-RKT-5200A	\$81.36	6-RKT-5200CI	\$144.31	6-RKT-5200S	\$202.43
							3.00	-	6-RKT-5300A	\$114.33	6-RKT-5300CI	\$226.75	6-RKT-5300S	\$257.66
							4.00	HOW5P1	6-RKT-5400A	\$131.58	-	-	-	-
K1-11-17	5	0.433 (11mm)	8mm	0.669 (17mm)	1.844 (1-27/32)	6	2.00	SUG5PSTS	6-RSG-5200A	\$83.92	-	-	-	-

Round Jaw Material: **ALUMINUM**-6061-T6 Bar Stock, **CAST IRON**-Gray, **STEEL**-1018  
 For complete list of applicable chucks, see pages 542-554.  
 \* denotes non-stock item. Please allow 1 week manufacturing time.

6

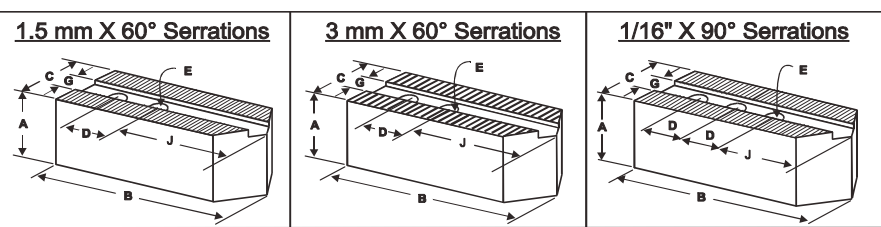
## How To Order Soft Jaws, Round Jaws, Hard Jaws and Jaw Nuts

Using the "Critical Dimensions" Method:

1. Identify the type of jaw from the pictures below.
2. Find the proper chuck size on the left side of the table.
3. Check your **Critical Dimensions** against the table. Make sure that they match your requirements.
4. Choose your desired jaw height ("A" dimension).
5. Choose the material you require. (Aluminum, Steel, Cast Iron)
6. Use the Part Number shown on the right end of the table. Jaws are sold in sets of 3 pieces.

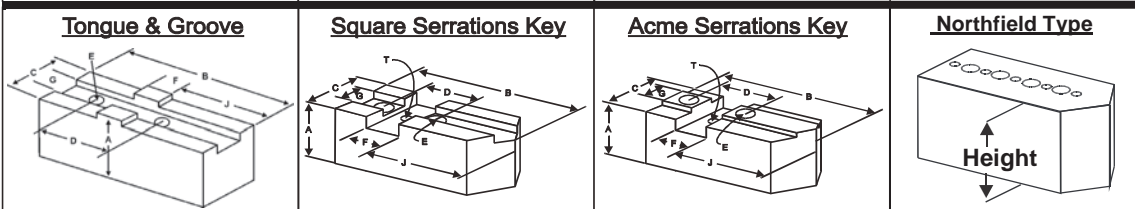
- **Part Numbers are for Flat Nose Jaws.** If you would like your jaws to be pointed, replace the "F" on the end of the part number with a "P". Example: KT-6200F will be KT-6200P. There is an additional charge for pointing.
- **If you cannot find the jaws you are looking for** or you require special jaws, please call us so that you may fill out a special jaw order form, located on pages 555-560.
- **If you know your chuck make and model:** See pages 542-554 for our extensive **Easy Jaw Finder**.
- **Call your distributor-** we can convert any jaw supplier part number

**Need Help Finding The Correct Chuck Jaws? See Our "Easy Jaw Finder" On Page 542!**



1

\*Kitagawa® is a registered trademark of Kitagawa NorthTech. Kitagawa®, Strong®, Samchully®, Bison®, TMX®, Buck®, MMK®, SMW Autoblock®, Howa®, Hitachi-Seiki®, Rohm® Pratt Burnerd®, BTC®, Cushman®, Amestra® and all chucks listed are all registered trademarks of their respective companies.

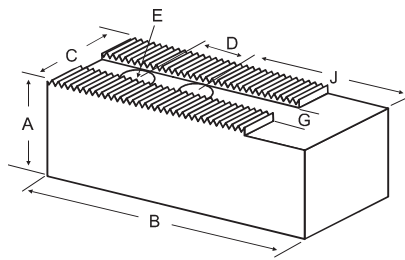


**Call Us Today For All Of Your Machine Tool Needs!**

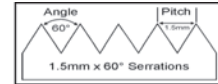
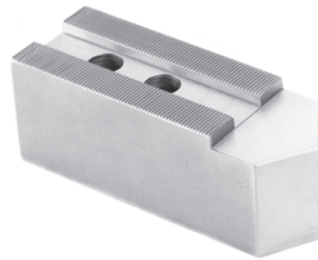
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group  
**K1**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

Group No.	Chuck Size	Critical Dimensions								ALUMINUM		STEEL	
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3
<b>K1-08-15</b>	4"	0.315 (8mm)	6mm	0.590 (15mm)	1.000	1.000	0.750	2.000	2	KT-4100AF	\$37.11	KT-4100F	\$41.71
B-04,BT-04					2.000	1.000	0.750	2.000	2	KT-4200AF	\$45.65	KT-4200F	\$51.19
<b>K1-10-12</b>	4"	0.394 (10mm)	6mm	0.470 (12mm)	1.000	1.000	0.750	2.000	2	KT-4103AF	\$37.11	KT-4103F	\$41.71
					2.000	1.000	0.750	2.000	2	KT-4203AF	\$45.63	KT-4203F	\$51.19
<b>K1-10-14</b>	4 & 4"	0.394 (10mm)	8mm	0.551 (14mm)	1.000	1.000	1.000	2.000	2	KT-4105AF	\$36.61	KT-4105F	\$41.11
B-204,B-205					2.000	1.000	1.000	2.000	2	KT-4205AF	\$30.53	KT-4205F	\$21.93
<b>K1-10-18</b>	5"	0.394 (10mm)	8mm	0.713 (18mm)	1.500	1.250	1.000	2.375	2	KT-5153AF	\$37.28	KT-5153F	\$41.71
B-05, BT-05, HOB-5, HOBT-5					2.000	1.250	1.000	2.375	2	KT-5203AF	\$30.42	KT-5203F	\$45.94
					2.500	1.250	1.000	2.375	2	KT-5253AF	\$55.49	KT-5253F	\$62.56
					3.000	1.250	1.500	2.375	2	KT-5303AF	\$64.75	KT-5303F	\$72.05
					4.000	1.900	1.250	3.000	2	KT-5403AF	\$76.82	KT-5403F	\$85.30
<b>K1-10-19</b>	5"	0.394 (10mm)	8mm	0.748 (19mm)	1.500	1.250	1.000	2.375	2	KT-5150AF	\$37.28	KT-5150F	\$41.71
N-05, NT-05					2.500	1.250	1.500	2.375	2	KT-5250AF	\$45.88	KT-5250F	\$51.19
					3.000	1.250	1.500	2.375	2	KT-5300AF	\$64.75	KT-5300F	\$72.05
<b>K1-11-17</b>	5"	0.433 (11mm)	8mm	0.669 (17mm)	1.500	1.270	1.000	2.375	2	NK-5150AF*	\$37.28	NK-5150F*	\$41.71
Nikko 5"					2.000	1.270	1.000	2.375	2	NK-5200AF*	\$47.48	NK-5200F*	\$53.09

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-4100AF will be KT-4100AP. Add \$4.00 For Pointed Jaws  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS-1 STEP

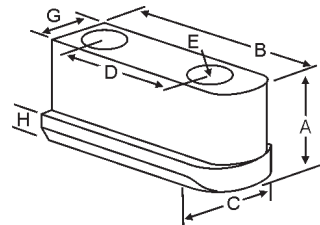
Group Number	Chuck Size	Critical Dimensions											Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D	Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3				
K1-10-14	4/5	0.394 (10mm)	8mm	0.551 (25mm)	0.906	2.087	1.083	3	1	0.394	-	0.672	KT-50HJ1-B	\$281.53	OEM Style	E

Please See Page 51 For Dimensional Diagram

## JAW NUTS & SCREWS



MADE IN THE  
**USA**



**USST**

Kitagawa	MMK Matsumoto	Chuck Size	Critical Dimensions					2 Screws Included With Each Jaw Nut						
			Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each	
B-04,BT-04, HOB-4		4	0.220	0.312 (8mm)	M6-1.00x25mm	0.590 (15mm)	0.531	0.453	0.965	KT-40JN	\$37.14	M0610025	\$2.25	
NL-04,AS-04,AT-04, HJ-4,N-04,NT-04	H-4(HPC),H4 (NAK),HH-4	4	0.220	0.392 (10mm)	M8-1.25x30mm	0.551 (14mm)	0.710	0.590	1.030	KT-45JN	\$37.14	M0812530	\$2.25	
B-204, B-205, N204/205, HS05		4/5	.220	0.394 (10mm)	M8-1.25x25mm	0.551 (14mm)	0.590	0.590	1.026	KT-204JN	\$28.20	M0812525	\$2.25	
HOBT-5,B-05, BT-05,HOB-5		5	0.220	0.392 (10mm)	M8-1.25x25mm	0.713 (18mm)	0.612	0.550	1.180	KT-53JN	\$37.14	M0812525	\$2.25	
HJ-5,N-05, NT-05		4	0.220	0.392 (10mm)	M8-1.25x25mm	0.748 (19mm)	0.612	0.550	1.180	KT-50JN	\$37.14	M0812525	\$2.25	

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**2019-20 MASTER CATALOG**

LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

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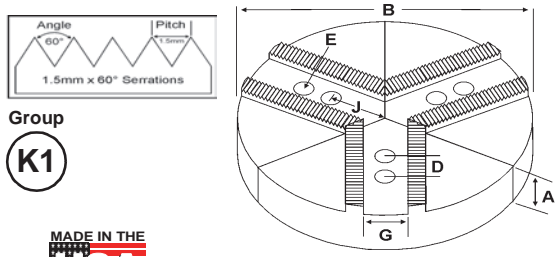
CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

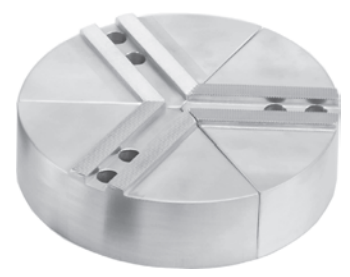
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



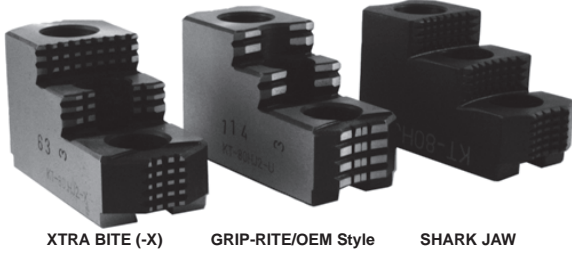
- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- **Made in the USA**



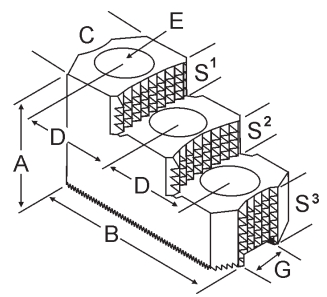
Group No.	Chuck Size	Critical Dimensions			Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	ALUMINUM		CAST IRON		STEEL	
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3
K1-11-20	6"	0.433 (11mm)	10mm	0.787 (20mm)	1.625	6	2.00	-	RHO-6200A	\$83.92	RHO-6200CI	\$144.31	RHO-6200S	\$202.43
							3.00	-	RHO-6300A	\$114.33	RHO-6300CI	\$226.75	RHO-6300S	\$257.66
							4.00	-	RHO-6400A	\$131.58	RHO-6400CI*	\$224.88	RHO-6400S	\$312.86
							8	2.00	-	8-RHO-6200A	\$126.29	8-RHO-6200CI	\$185.53	-
							4.00	-	8-RHO-6400A	\$176.81	8-RHO-6400CI	\$350.44	-	-
K1-11-25	6"	0.433 (11mm)	8mm	0.985 (25mm)	1.625	6	2.00	SUG6PSTS	RSG-6200A	\$77.72	RSG-6200CI	\$144.31	RSG-6200S*	\$202.43
							3.00	-	RSG-6300A	\$114.33	RSG-6300CI	\$226.75	RSG-6300S	\$257.66
							4.00	SUG6P1STS	RSG-6400A	\$120.84	-	-	RSG-6400S	\$312.86
							8	2.00	-	8-RSG-6200A	\$126.29	8-RSG-6200CI	\$185.53	8-RSG-6200S
							4.00	-	8-RSG-6400A	\$176.81	8-RSG-6400CI	\$350.44	-	-
						10	2.00	-	10-RSG-6200A	\$165.73	-	-	-	-
K1-12-20	6"	0.472 (12mm)	10mm	0.787 (20mm)	1.625	6	2.00	AKT6FG	RKT-6200A	\$72.61	RKT-6200CI	\$144.31	RKT-6200S	\$169.12
							3.00	AKT6MHFG	RKT-6300A	\$104.86	RKT-6300CI	\$226.75	RKT-6300S	\$257.66
							4.00	KTT6P1	RKT-6400A	\$118.88	-	-	RKT-6400S	\$312.86
							8	2.00	KTT8-6P	8-RKT-6200A	\$91.39	8-RKT-6200CI	\$185.53	8-RKT-6200S
							4.00	KTT8-6P1	8-RKT-6400A	\$158.83	8-RKT-6400CI	\$350.44	-	-
						10	2.00	KTT10-6P	10-RKT-6200A	\$131.48	-	-	-	-
K1-14-20	6"	0.551 (14mm)	10mm	0.790 (20mm)	1.625	6	2.00	-	RNK-6200A	\$83.92	RNK-6200CI	\$144.31	RNK-6200S	\$202.43
							3.00	-	RNK-6300A	\$114.33	RNK-6300CI	\$226.75	RNK-6300S	\$213.37
							4.00	-	RNK-6400A	\$131.58	-	-	RNK-6400S	\$259.09

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. For complete list of applicable chucks, see pages 542-554.  
\* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS



- FEATURES:**
- Designed for first operation roughing, expect standard runout between **0.005-0.010**
  - Reversible-suitable for OD & ID workholding.
  - **XTRA BITE** -very aggressive bite. Conical teeth for extra gripping power and ground body to provide improved runout.
  - **GRIP-RITE/OEM Style** hard jaws have ground tips and provide better runout.
  - **SHARK JAWS** have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
  - 1 & 2 step jaws available.



Group Number	Chuck Size	Critical Dimensions			Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D												
K1-11-20	6"	0.433 (11mm)	10mm	0.787 (20mm)	1.250	2.900	2.000	3	2	0.500	0.500	1.000	HO-60HJ2	\$431.70	Shark Jaws	D
K1-11-25	6"	0.433 (11mm)	8mm	0.985 (25mm)	1.250	3.000	1.969	3	2	0.500	0.500	0.969	SG-60HJ2-X	\$307.80	Xtra-bite	E
K1-12-20	6"	0.472 (12mm)	10mm	0.787 (20mm)	1.220	2.900	2.000	3	1	0.500	-	1.000	KT-60HJ1	\$355.56	Shark Jaws	D
					1.220	2.646	1.423	3	1	0.359	-	1.064	KT-60HJ1-U	\$273.18	OEM Style	E
					1.250	3.000	1.969	3	1	1.000	-	0.969	KT-60HJ1-X	\$287.55	Xtra-bite	E
					1.220	2.900	2.000	3	2	0.500	0.500	1.000	KT-60HJ2	\$355.56	Shark Jaws	D
					1.220	2.728	1.740	3	2	0.402	0.402	0.936	KT-60HJ2-U	\$245.75	OEM Style	E
					1.250	3.000	1.969	3	2	0.500	0.500	0.969	KT-60HJ2-X	\$256.55	Xtra-bite	E

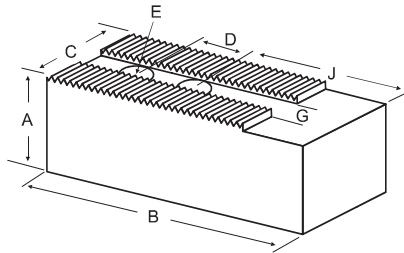
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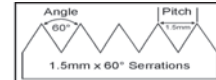
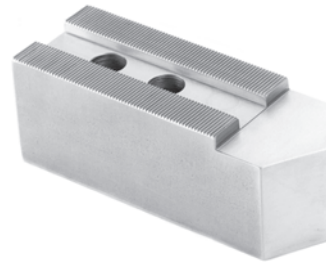
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
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- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group  
**(K1)**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

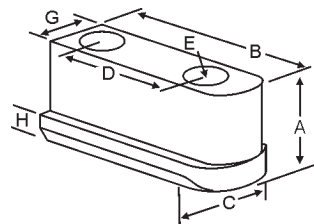
Group No.	Chuck Size	Critical Dimensions								ALUMINUM		STEEL					
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3				
<b>K1-11-20</b>	6"	0.433 (11mm)	10mm	0.787 (20mm)	1.500	1.625	1.250	3.000	2	HO-6150AF	\$39.97	HO-6150F	\$44.57				
2.000					1.625	1.250	3.000	2	HO-6200AF	\$46.02	HO-6200F	\$51.19					
2.500					1.625	1.250	3.000	2	HO-6250AF	\$55.40	HO-6250F	\$61.60					
3.000					1.625	1.250	3.000	2	HO-6300AF	\$65.66	HO-6300F	\$73.00					
<b>K1-11-25</b>	6"	0.433 (11mm)	8mm	0.985 (25mm)	1.500	1.625	1.000	3.000	2	SG-6150AF	\$39.87	SG-6150F	\$41.58				
1.625					1.250	1.000	3.000	2	SG-6152AF	\$44.86	SG-6152F	\$50.06					
2.500					1.625	1.000	3.000	2	SG-6250AF	\$49.69	SG-6250F	\$51.63					
1.625					1.250	1.000	3.000	2	SG-6252AF	\$60.31	SG-6252F	\$67.13					
<b>K1-12-20</b>	6"	0.472 (12mm)	10mm	0.787 (20mm)	1.000	1.625	1.250	3.000	2	KT-6100AF	\$37.84	KT-6100F	\$42.34				
1.625					1.250	1.250	3.000	2	KT-6150AF	\$26.55	KT-6150F	\$22.95					
1.625					1.250	1.250	3.000	2	KT-6150BF	Call	-	-					
1.625					2.000	1.250	3.000	2	KT-6152AF	\$74.18	KT-6152F	\$82.83					
2.125					1.250	1.250	3.500	2	KT-6151AF	\$47.07	KT-6151F	\$52.47					
1.625					1.250	1.250	3.000	2	KT-6200AF	\$31.59	KT-6200F	\$34.37					
1.625					1.250	1.250	3.000	2	KT-6200BF	Call	-	-					
2.500					1.625	1.250	3.000	2	KT-6250AF	\$49.69	KT-6250F	\$39.69					
1.625					1.250	1.250	3.000	2	KT-6300AF	\$41.12	KT-6300F	\$44.99					
1.625					1.250	1.250	3.000	2	KT-6300BF	Call	-	-					
1.625					2.000	1.250	3.000	2	KT-6302AF	\$86.34	KT-6302F	\$95.71					
3.500					1.625	1.250	3.000	2	KT-6350AF	\$78.43	KT-6350F	\$51.51					
4.000					1.625	1.250	3.000	2	KT-6400AF	\$86.08	KT-6400F	\$95.71					
5.000					1.625	1.250	3.000	2	KT-6500AF*	\$174.75	KT-6500F*	\$197.02					
<b>K1-14-20</b>					6"	0.551 (14mm)	10mm	0.790 (20mm)	1.500	1.625	1.250	3.000	2	NK-6150AF	\$39.97	NK-6150F	\$44.57
2.500									1.625	1.250	3.000	2	NK-6250AF	\$55.40	NK-6250F	\$61.60	

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: HO-6200AF will be HO-6200AP. Add \$4.00 For Pointed Jaws  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



MADE IN THE  
**USA**



**USST**

Chuck Make & Model	Chuck Size	Critical Dimensions					2 Screws Included With Each Jaw Nut					
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
-	6	0.295	0.432 (11mm)	M10-1.60x30mm	0.787 (20mm)	0.847	0.669	1.460	HO-62JN	\$33.42	M1016030	\$2.25
MMK: Z-6,ZA5-6-0, ZA5-6B,ZJA5-6	6	0.295	0.432 (11mm)	M8-1.25x30mm	0.984 (25mm)	0.790	0.690	1.570	SG-60JN	\$30.96	M0812530	\$2.25
Kitagawa: B-206,BT-206,BB-06,B-07 Strong: N206 Samchully: HS-06 MMK:PC-6-46	6	0.295	0.472 (12mm)	M10-1.60x30mm	0.787 (20mm)	0.728	0.689	1.417	KT-60JN	\$34.92	M1016030	\$2.25
Kitagawa: B-06	6	0.295	0.472 (12mm)	M10-1.60x30mm	0.787 (20mm)	0.885	0.689	1.440	KT-61JN	\$33.42	M1016030	\$2.25

Call Us Or Visit Our Website For Our Complete Selection!

**2019-20 MASTER CATALOG**

LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

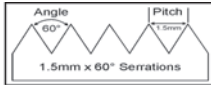
CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

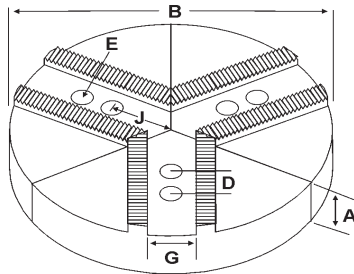
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

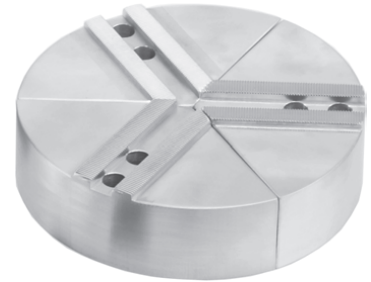
FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Seom Chucks**



Group  
**(K1)**



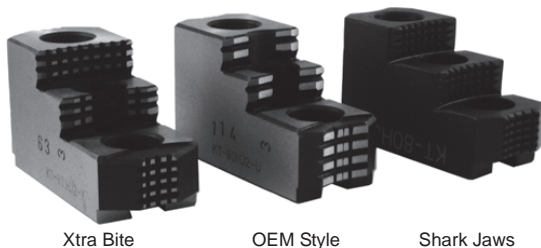
- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA



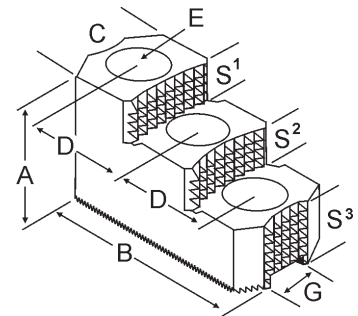
Group No.	Chuck Size	Critical Dimensions			Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	ALUMINUM		CAST IRON		STEEL	
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3
<b>K1-14-25</b>	8"	0.551 (14mm)	12mm	0.984 (25mm)	1.325	6	2.00	-	6-RKT-8200A	\$83.92	6-RKT-8200CI	\$144.31	-	-
3.00							-	6-RKT-8300A*	\$114.33	-	-	-	-	
2.250					8	2.00	KTT8P	RKT-8200A	\$85.36	RKT-8200CI	\$185.53	RKT-8200S	\$239.60	
						3.00	AKT8MHFG	RKT-8300A	\$134.30	-	-	RKT-8300S	\$404.87	
						4.00	KTT8P1	RKT-8400A	\$159.83	RKT-8400CI	\$350.44	RKT-8400S	\$478.49	
						6.00	-	RKT-8600A	\$303.09	-	-	-	-	
2.266					8	2.00	HAR8MSHP	RHA-8200A	\$126.29	-	-	-	-	
						4.00	HAR8MSHP1	RHA-8400A	\$176.81	-	-	-	-	
2.250					10	2.00	KTT10-8P	10-RKT-8200A	\$135.37	10-RKT-8200CI*	\$278.30	10-RKT-8200S	\$423.27	
						3.00	-	10-RKT-8300A	\$194.66	-	-	-	-	
						4.00	KTT10-8P1	10-RKT-8400A	\$227.62	10-RKT-8400CI	\$494.74	-	-	
						6.00	-	10-RKT-8600A*	\$475.52	-	-	-	-	
2.250					12	2.00	KTT12-8P	12-RKT-8200A	\$171.26	-	-	-	-	
						3.00	-	12-RKT-8300A	\$355.20	-	-	-	-	
2.250					15	2.50	-	15-RKT-8250A	\$494.11	-	-	-	-	
						4.00	-	15-RKT-8400A	\$564.72	-	-	-	-	

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018  
For complete list of applicable chucks, see pages 542-554.\* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD CHUCK JAWS 1 & 2 STEPS



- FEATURES:**
- Designed for first operation roughing, expect standard runout between 0.005-0.010
  - Reversible-suitable for OD & ID working.
  - **XTRA BITE** -very aggressive bite. Conical teeth for extra gripping power and ground body to provide improved runout.
  - **GRIP-RITE/OEM Style** hard jaws have ground tips and provide better runout.
  - **SHARK JAWS** have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
  - **Bison** jaws feature enhanced serrations on gripping surface
  - 1 & 2 step jaws available.



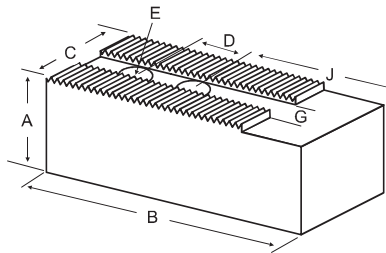
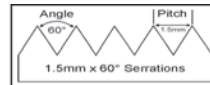
Group Number	Chuck Size	Critical Dimensions			Width C	OAL B	Height A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D												
<b>K1-14-25</b>	8	0.551 (14mm)	12mm	0.984 (25mm)	1.500	3.300	2.000	3	1	0.500	-	1.000	KT-80HJ1	\$420.66	Shark Jaws	D
1.382					3.402	1.669	3	1	0.591	-	1.078	KT-80HJ1-U	\$323.19	OEM Style	E	
1.500					3.500	1.969	3	1	1.030	-	0.938	KT-80HJ1-X	\$340.20	XTRA-BITE	E	
1.500					3.300	2.000	3	2	0.500	0.500	1.000	KT-80HJ2	\$420.66	Shark Jaws	D	
1.382					3.409	2.000	3	2	0.465	0.465	1.070	KT-80HJ2-U	\$294.53	OEM Style	E	
1.500					3.500	1.969	3	2	0.530	0.530	0.909	KT-80HJ2-X	\$312.71	XTRA-BITE	E	

Call Us Today For All Of Your Machine Tool Needs!

# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®**, **Samchully®**, **Strong®**, **MMK**, **SMW Autoblok** & **Howa Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- All jaws have 2 holes
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



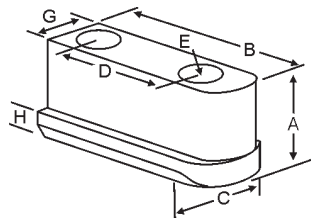
Group  
**K1**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

Group No.	Chuck Size	Critical Dimensions			Hght Inch A	Hole to Front J	Length Inch B	Width Inch C	Industry Reference	ALUMINUM		STEEL				
		Groove Width G	Screw Size E	Hole Space D						FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3			
<b>K1-14-25</b>	8"	0.551 (14mm)	12mm	0.984 (25mm)	1.500	2.000	3.750	1.500	-	KT-8150AF	\$33.35	KT-8150F	\$36.52			
Kitagawa B-08, B-208, BB08, BB208						2.4690	4.250	1.500	HR-149-1.5-O or OP	KT-8150-24AF	\$52.46	KT-8150-24F	\$60.09			
Samchully HS-08, HC-08, HCH-08						1.719	3.500	1.500	HR149-2.0	KT-8200-17AF	\$52.35	KT-8200-17F	\$60.74			
						2.000	3.750	1.500	-	KT-8200AF	\$38.56	KT-8200F	\$40.70			
						2.000	3.750	1.500	-	KT-8200BF	Call	-	-			
						2.016	3.750	1.500	KT-8/KT-8P	-	-	KT-8	\$53.19			
Strong N208, NB208, NT208, NIT208, V208					2.250	4.000	1.500	-	KT-8201AF	\$46.63	KT-8201F	\$46.86				
					2.250	4.000	1.500	-	KT-8201BF	\$71.41	-	-				
					2.266	4.000	1.500	KT-8PL	-	-	KT-8PL	\$84.74				
MMK PC-8-52, ZA6-8, HA6-8, HH-8, HHJ-8					3.000	2.4690	4.250	1.500	1.7190	3.500	1.500	HR-149-2.0-O or OP	KT-8200-25AF	\$52.35	KT-8200-25F	\$60.09
									1.7190	3.500	1.500	HR-149-2.5	KT-8250-17AF	\$47.90	KT-8250-17F	\$60.74
									2.4690	4.250	1.500	HR-149-2.5-O or OP	KT-8250-25AF	\$54.30	KT-8250-25F	\$68.92
									2.000	3.750	1.500	-	KT-8300AF	\$50.90	KT-8300F	\$46.82
									2.000	3.750	1.500	-	KT-8300BF	Call	-	-
									2.016	3.750	1.500	KT-8MH/KT-8MHP	-	-	KT-8MH	\$88.82
HOWA H3KT8, HO15M8, HO7MA8					3.500	1.7190	3.500	1.500	1.7190	3.500	1.500	HR-149-3.5	KT-8350-17AF	\$66.84	KT-8350-17F	\$85.26
									2.4690	4.250	1.500	HR-149-3.5-O or OP	KT-8350-25AF	\$76.97	KT-8350-25F	\$96.94
									2.000	3.750	1.500	-	KT-8400AF	\$62.11	KT-8400F	\$61.00
SMW Autoblok BBM-210, BHM-210					4.000	2.016	3.750	1.500	2.016	3.750	1.500	KT-8EH/KT-8EHP	-	-	KT-8EH	\$101.25
									2.250	4.000	1.500	-	KT-8401AF	\$69.47	KT-8401F	\$77.70
									2.266	4.000	1.500	KT-8EHPL	-	-	KT-8EHPL	\$121.52
									1.7190	3.500	1.500	HR-149-5.0	KT-8500-17AF	\$128.10	KT-8500-17F	\$128.48
6.000					2.000	3.750	1.500	-	KT-8500AF	\$132.85	KT-8500F	\$138.52				
					2.4690	4.250	1.500	HR-149-5.0-O or OP	KT-8500-25AF	\$150.38	KT-8500-25F	\$146.00				
	2.000	3.750	1.500	-	KT-8600AF	\$214.93	KT-8600F	\$204.71								
2.250	4.000	1.500	-	KT-8601AF	\$233.14	KT-8601F	\$262.85									

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-8150AF will be KT-8150AP. Add \$4.00 For Pointed Jaws  
 "Huron Equivalent" jaws are pointed. Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum  
 For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS AND SCREWS



USST

MADE IN THE USA

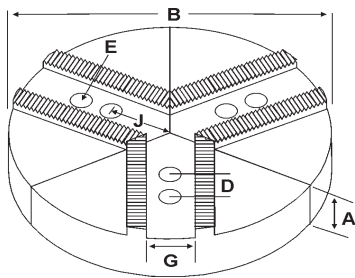
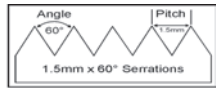
Chuck Make & Model	Chuck Size	Critical Dimensions							2 Screws Included With Each Jaw Nut			
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
MMK: ZA6-8	8	0.335	0.549 (14mm)	M12-1.75x35mm	0.984 (25mm)	0.895	0.807	1.840	KT-82JN	\$36.30	M1217535	\$2.25
Kitagawa: BB-08, B-208 Strong: N208 Samchully: HS-08 MMK: PC-8-52	8	0.335	0.549 (14mm)	M12-1.75x30mm	0.984 (25mm)	0.807	0.807	1.880	KT-81JN	\$37.30	M1217530	\$2.25
Kitagawa: NT-08, B-08, BT-08, HOB-8	8	0.374	0.549 (14mm)	M12-1.75x35mm	0.984 (25mm)	1.000	0.807	1.880	KT-80JN	\$28.31	M1217535	\$2.25

Call Us Or Visit Our Website For Our Complete Selection!

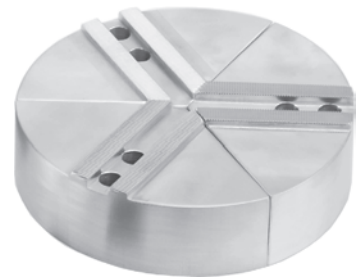
LATHE CHUCKS  
LIVE CENTERS  
VISE JAWS  
VISE ACCESSORIES  
STRAIGHT SHANK  
COLLET HOLDERS  
TAP HOLDERS  
DRILL CHUCKS  
CARBIDE INSERTS  
THREADING/GROOVING  
CUTTING TOOLS  
MACHINERY  
PRECISION TOOLS  
DEBURRING  
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: **SMW Autoblok, Howa, Suga & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA



Group

K1



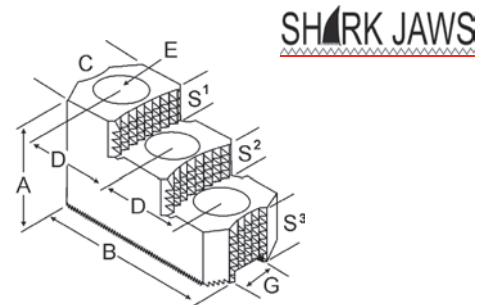
Group No.	Chuck Size	Critical Dimensions			Holeto Front J	Pie Dia B	Height Inch A	Industry Ref #	ALUMINUM		CAST IRON		STEEL			
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3		
K1-14-30	8"	0.551 (14mm)	10mm	1.181 (30mm)	2.250	8	2.00	SUG8PSTS	RSG-8200A	\$126.29	RSG-8200CI	\$185.53	RSG-8200S	\$294.45		
							3.00	-	RSG-8300A	\$154.01	-	-	RSG-8300S	\$404.87		
							4.00	SUG8P1STS	RSG-8400A	\$176.81	RSG-8400CI	\$350.44	-	-		
							2.00	-	10-RSG-8200A	\$165.73	-	-	-	-		
							4.00	-	10-RSG-8400A	\$255.63	-	-	-	-		
2.250	12	2.00	-	12-RSG-8200A	\$215.37	-	-	-	-	-	-	-				
K1-16-25	8"	0.630 (16mm)	12mm	0.984 (25mm)	2.250	8	2.00	HOW27M88P	RHO-8200A	\$111.13	RHO-8200CI	\$185.53	RHO-8200S	\$294.45		
							3.00	-	RHO-8300A	\$146.96	-	-	RHO-8300S	\$404.87		
							4.00	HOW27M88P1	RHO-8400A	\$154.24	RHO-8400CI	\$350.44	-	-		
							2.00	-	10-RHO-8200A	\$146.68	-	-	-	-		
							4.00	-	10-RHO-8400A	\$227.62	-	-	-	-		
							2.250	10	2.00	-	12-RHO-8200A	\$215.37	-	-	-	-
							4.00	-	12-RHO-8400A	\$427.41	-	-	-	-		
K1-17-23	8"	0.669 (17mm)	12mm	0.906 (23mm)	2.250	8	2.00	-	RAB-8200A	\$126.29	RAB-8200CI	\$185.53	RAB-8200S	\$294.45		
							2.500	8	2.00	AUTOBHM8P	RAB-8200A4	\$126.29	-	-	-	-
							2.250	8	3.00	-	RAB-8300A	\$154.01	-	-	RAB-8300S	\$335.29
							4.00	-	RAB-8400A	\$176.81	RAB-8400CI	\$350.44	-	-		
							2.500	8	4.00	AUTOBHM8P1	RAB-8400A4	\$154.01	-	-	-	-

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018  
For complete list of applicable chucks, see pages 542-554.\* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS



- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life.
- Ideal for castings and scaly material.
- Made in the USA.



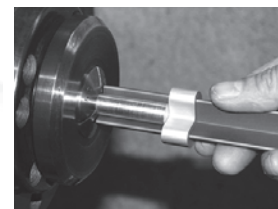
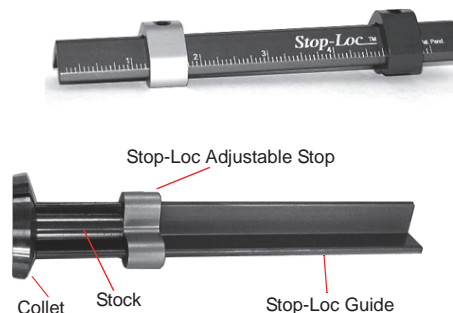
SHARK JAWS

Group Number	Chuck Size	Critical Dimensions			Width C	OAL B	Height A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D												
K1-16-25	8	0.630 (16mm)	12mm	0.984 (25mm)	1.500	3.300	2.000	3	2	0.500	0.500	1.000	HO-80HJ2	\$439.53	Shark Jaws	D

## CHUCK/COLLET STOP

Handheld Lathe & Mill Vise Tool

- Adjustable Precision-Gage lengths up to 5-1/2" long holding +/- .005
- Save Money! No more fixed length dedicated shop-made front collet stops for each job
- Versatile-For use on CNC or manual lathes whether you are running a bar manually or using a bar puller
- Consistency-Unique design incorporates self-centering, unobstructed viewing and contrasting colors to give user confidence
- Dimensions: 6" L x 3/4" H x 3/4" W
- Made in USA



Stop-Loc Pat.Pend.



Graduations	Part Number	Price
Inch	STOPLOC	\$16.00
Inch/Metric	STOPLOC-THSMM	\$18.00
Metric	STOPLOC-MM	\$18.00

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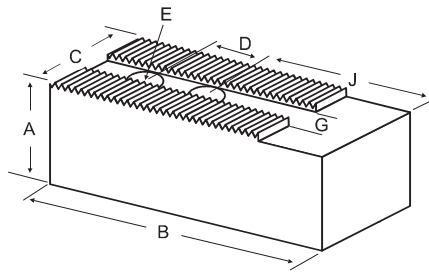
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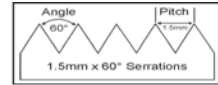
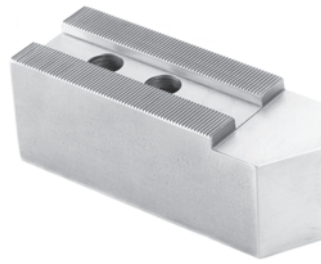
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **SMW Autoblok, Howa, Suga & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum & Steel



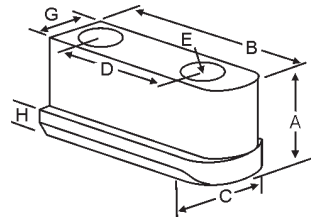
Group  
**K1**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

Group No.	Chuck Size	Critical Dimensions				ALUMINUM					STEEL		
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3
<b>K1-14-30</b> Suga 8"	8"	0.551 (14mm)	10mm	1.181 (30mm)	2.000	1.970	1.500	3.750	2	SG-8200AF	\$56.39	SG-8200F	\$62.56
					3.000	1.970	1.500	3.750	2	SG-8300AF	\$71.99	SG-8300F	\$79.63
					4.000	1.970	1.500	3.750	2	SG-8400AF	\$83.47	SG-8400F	\$92.06
<b>K1-16-25</b> HOWA HO15M10, HO22M8, HO24M8, HO27M8, HO34M8	8"	0.630 (16mm)	12mm	0.984 (25mm)	2.000	2.000	1.500	3.750	2	HO-8200AF	\$56.39	HO-8200F	\$44.99
					2.000	2.250	1.500	4.000	2	HO-8201AF	\$53.84	HO-8201F	\$55.95
					3.000	2.000	1.500	3.750	2	HO-8300AF	\$71.99	HO-8300F	\$81.82
					4.000	2.000	1.500	3.750	2	HO-8400AF	\$74.28	HO-8400F	\$84.55
					6.000	2.000	1.500	3.750	2	HO-8600AF	\$231.26	HO-8600F	\$257.66
<b>K1-17-23</b> SMW 200, SMW 210	8"	0.669 (17mm)	12mm	0.905 (23mm)	2.000	2.000	1.500	3.750	2	AB-8200AF	\$56.39	AB-8200F	\$62.56
					3.000	2.000	1.500	3.750	2	AB-8300AF	\$71.99	AB-8300F	\$79.63
					4.000	2.000	1.500	3.750	2	AB-8400AF	\$83.47	AB-8400F	\$92.06
<b>K1-17-25</b>	8"	0.669 (17mm)	12mm	0.984 (25mm)	2.000	2.000	1.500	3.750	2	AB-8205AF	\$56.39	AB-8205F	\$62.56

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-8150AF will be KT-8150AP. Add \$4.00 For Pointed Jaws "Huron Equivalent" jaws are pointed. Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS AND SCREWS



**USST**

MADE IN THE USA

Chuck Make & Model	Chuck Size	Critical Dimensions							2 Screws Included With Each Jaw Nut			
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
Howa: HO15M10,HO22M10,HO24M10	8	0.335	0.629 (16mm)	M12-1.75x40mm	0.984 (25mm)	1.040	0.807	1.830	HO-80JN	\$35.30	M1217540	\$2.25

## JAW BORING RINGS

No need to look all over the shop for a setup piece and waste time. Our jaw boring ring is essential for boring soft jaws and round jaws.

### FEATURES:

- Ideal for machining soft jaws.
- Attaches quickly without tools.
- Applies equal pressure on all jaws.
- Attaches to front of jaws, compensating for "jaw lift."
- Since no discs or bungs are used to clamp jaws, through boring of jaws is possible.



Save Set-Up Time!

**USST**

Jaw Boring Ring (comes complete with 3 pin assemblies)

Chuck Dia	ID Inch	OD Inch	Pin Depth	Pin Dia	Part Number	Price Each
4"	1.335	4.500	0.350"	0.510"	JBR-04	\$162.00
5"	2.335	5.500	0.350"	0.510"	JBR-05	\$162.00
6"	3.250	6.825	0.350"	0.512"	JBR-06	\$184.25
8"	3.500	8.450	0.350"	0.562"	JBR-08	\$226.48
10"	5.900	10.150	0.350"	0.709"	JBR-10	\$255.67
12"	7.475	12.075	0.400"	0.709"	JBR-12	\$284.23
15"	8.900	15.230	0.600"	0.938"	JBR-15	\$427.06

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LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

CUTTING TOOLS  
MACHINERY

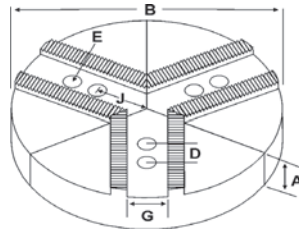
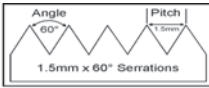
PRECISION TOOLS  
DEBURRING

COOLANT/FLUIDS  
TOOL STORAGE

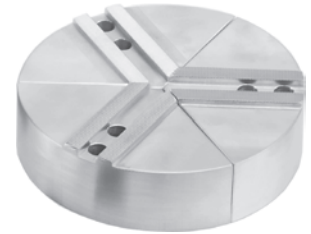


# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Seom Chucks**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- **Made in the USA**



Group

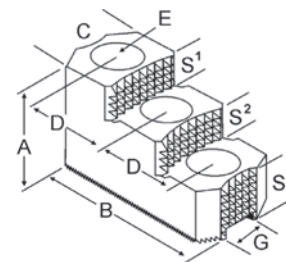


Group No.	Chuck Size	Critical Dimensions			Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	ALUMINUM		CAST IRON		STEEL	
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3
<b>K1-16-30</b>	<b>10"</b>	<b>0.630 (16mm)</b>	<b>12mm</b>	<b>1.181 (30mm)</b>	2.155	8	2.00	-	8-RKT-10200A	\$97.41	-	-	-	-
2.375					10	2.00	-	RKT-10200A	\$126.28	RKT-10200CI	\$278.30	RKT-10200S	\$303.96	
2.500†					10	2.00	KTT10P	RKT-10200A4	\$146.68	-	-	-	-	
2.650†					10	2.00	AKT10FG	RKT-10200A5	\$146.68	-	-	-	-	
2.750†					10	2.00	HAR10MSHP	RHA-10200A	\$146.68	-	-	-	-	
2.375					10	2.50	-	RKT-10250A	\$173.60	-	-	-	-	
					10	3.00	-	RKT-10300A	\$162.89	-	-	RKT-10300S	\$552.10	
2.650†					10	3.00	AKT10MHFG	RKT-10300A5	\$173.60	-	-	-	-	
2.375					10	4.00	-	RKT-10400A	\$193.60	RKT-10400CI	\$494.74	RKT-10400S	\$723.69	
2.500†					10	4.00	KTT10P1	RKT-10400A4	\$227.62	-	-	-	-	
2.650†					10	3.00	AKT10EHFG	RKT-10400A5	\$227.62	-	-	-	-	
2.750†					10	4.00	HAR10MSHP1	RHA-10400A	\$227.62	-	-	-	-	
					10	5.00	-	RKT-10500A	\$340.12	-	-	-	-	
					10	6.00	-	RKT-10600A	\$439.41	-	-	RKT-10600S	\$1,010.88	
					10	8.00	-	RKT-10800A	\$658.27	-	-	-	-	
2.500†					10	6.00	KTT10P6	RKT-10600A4	\$439.41	-	-	-	-	
2.375					12	2.00	-	12-RKT-10200A	\$171.15	12-RKT-10200CI	\$410.50	-	-	
2.500†					12	2.00	KTT12-10P	12-RKT-10200A4	\$184.94	-	-	-	-	
2.375					12	2.50	-	12-RKT-10250A	\$214.25	-	-	-	-	
					12	4.00	-	12-RKT-10400A	\$372.23	-	-	-	-	
2.500†					12	4.00	KTT12-10P1	12-RKT-10400A4	\$372.23	-	-	-	-	
2.375					15	2.50	-	15-RKT-10250A	\$494.11	15-RKT-10250CI	\$721.49	-	-	
2.500†					15	3.00	KTT15-10P	15-RKT-10300A4	\$516.17	-	-	-	-	
2.375					15	4.00	-	15-RKT-10400A	\$607.05	-	-	-	-	
2.500†					15	4.00	KTT15-10P1	15-RKT-10400A4	\$585.38	-	-	-	-	
					15	6.00	-	15-RKT-10600A*	\$1,147.36	-	-	-	-	
					18	2.50	-	18-RKT-10250A	\$630.49	-	-	-	-	
2.500†					18	3.00	KTT18-10P	18-RKT-10300A4	\$710.55	-	-	-	-	
2.375					18	4.00	-	18-RKT-10400A	\$851.69	-	-	-	-	
2.500†					18	4.00	KTT18-10P1	18-RKT-10400A4	\$835.46	-	-	-	-	
	21	3.00	KTT21-10P	21-RKT-10300A4	\$933.38	-	-	-	-					
2.375	21	4.00	-	21-RKT-10400A	\$1,135.76	-	-	-	-					
2.500†	21	4.00	KTT21-10P1	21-RKT-10400A4	\$1,114.13	-	-	-	-					
2.375	24	4.00	-	24-RKT-10400A*	\$1,550.55	-	-	-	-					

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6 For complete list of applicable chucks, see pages 542-554.  
\* denotes non-stock item. Please allow 1 week manufacturing time. † -for big bore chucks.

## HARD CHUCK JAWS

- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- **XTRA BITE** -very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.
- **GRIP-RITE/OEM Style** hard jaws have ground tips and provide better runout.
- **SHARK JAWS** have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
- 1 & 2 step jaws available.



Group Number	Chuck Size	Critical Dimensions			Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D												
<b>K1-16-30</b>	<b>10</b>	<b>0.630 (16mm)</b>	<b>12mm</b>	<b>1.181 (30mm)</b>	1.750	4.000	2.000	3	1	0.750	-	1.250	KT-100HJ1	\$500.80	Shark Jaws	D
1.579					3.980	1.737	3	1	0.635	-	1.102	KT-100HJ1-U	\$384.75	OEM Style	E	
1.750					4.000	2.500	3	2	0.650	0.500	1.350	KT-100HJ2	\$500.80	Shark Jaws	D	
1.579					3.980	2.130	3	2	0.520	0.520	1.090	KT-100HJ2-U	\$336.60	OEM Style	E	
1.750					4.250	2.469	3	2	0.650	0.650	1.169	KT-100HJ2-X	\$370.44	XTRA-BITE	E	

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# SOFT JAWS- 1.5 mm x 60° Serrations

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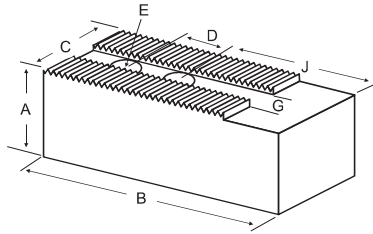
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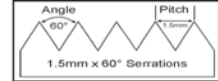
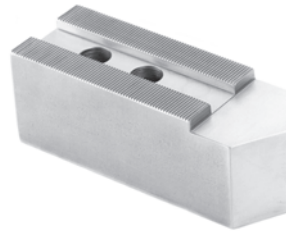
PRECISION TOOLS  
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TOOL STORAGE

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Seom Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group

K1

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

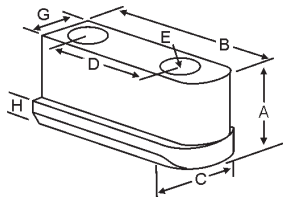
Group No.	Chuck Size	Critical Dimensions			Height A	Hole To Front J	Length B	Width C	Industry Reference #	ALUMINUM		STEEL		
		Groove Width G	Screw Size E	Hole Space D						Flat End Part Number	Price Set of 3 Jaws	Flat End Part Number	Price Set of 3 Jaws	
<b>K1-16-30</b>	10"	0.630 (16mm)	12mm	1.181 (30mm)	2.000	2.169	4.000	1.750	HR-82-2.0	KT-10200-21AF	\$53.47	KT-10200-21F	\$38.56	
KITAGAWA B-10, B-210, BL-210, BLT-210 Big-Bore BB210†						2.375	4.500	1.500	-	KT-10200AF	\$46.66	KT-10200F	\$45.84	
						2.375	4.500	1.500	-	KT-10200BF	Call	-	-	
						2.375	4.500	2.000	-	KT-10202AF	\$43.55	KT-10202F	\$58.85	
						2.404	4.750	1.750	KT-10/KT-10P	-	-	KT-10	\$55.29	
						2.654	5.000	1.750	KT-10PL	-	-	KT-10PL	\$71.10	
						2.875	5.000	1.500	-	KT-10201AF	\$62.74	KT-10201F	\$54.04	
						2.875	5.000	1.500	-	KT-10201BF	Call	-	-	
						2.875	5.250	2.000	-	KT-10205AF	\$73.98	KT-10205F	\$81.51	
						2.875	5.250	2.000	-	KT-10205BF	Call	-	-	
						3.169	5.000	1.750	HR-82-2.0-O or OP	KT-10200-31AF	\$66.84	KT-10200-31F	\$67.74	
						Samchully HS10, HC10 HH210 HCH10	2.500	2.169	4.000	1.750	HR-82-2.5	KT-10250-21AF	\$66.84	KT-10250-21F
					3.169			5.000	1.750	HR-82-2.5-O or OP	KT-10250-31AF	\$83.54	KT-10250-31F	\$91.10
2.375					4.500			1.500	-	KT-10300AF	\$56.71	KT-10300F	\$66.29	
2.375					4.500			1.500	-	KT-10300BF	Call	-	-	
2.404					4.750			1.750	KT-10MH/KT-10MHP	-	-	KT-10MH	\$71.26	
2.654					5.000			1.750	KT-10MHPL	-	-	KT-10MHPL	\$84.85	
STRONG N210 NB210 NIT210 V210					3.000	2.875	5.000	1.500	-	KT-10301AF	\$81.79	KT-10301F	\$73.88	
						2.875	5.000	2.000	-	KT-10305AF	\$89.96	KT-10305F	\$98.57	
						2.169	4.000	1.750	HR-82-3.5	KT-10350-21AF	\$83.54	KT-10350-21F	\$92.28	
						3.169	5.000	1.750	HR-82-3.5-O or OP	KT-10350-31AF	\$94.69	KT-10350-31F	\$101.51	
						2.375	4.500	1.500	-	KT-10400AF	\$67.46	KT-10400F	\$76.14	
						2.375	4.500	1.500	-	KT-10400BF	Call	-	-	
MMK PC-10-78-A6 PC-10-78-A8 HA 8-11, HA6-10, HA8-10					3.500	2.404	4.750	1.750	KT-10EH/KT-10EHP	-	-	KT-10EH	\$83.77	
						2.654	5.000	1.750	KT-10EHPL	-	-	KT-10EHPL	\$96.11	
						2.875	5.000	1.500	-	KT-10401AF	\$93.82	KT-10401F	\$93.50	
						2.875	5.250	2.000	-	KT-10405AF	\$104.25	KT-10405F	\$113.74	
						2.169	4.000	1.750	HR-82-5.0	KT-10500-21AF	\$120.30	KT-10500-21F	\$128.48	
						2.375	4.500	1.500	K1-16-30	KT-10500AF	\$198.60	KT-10500F	\$182.53	
HOWA H3KT10					4.000	3.169	5.000	1.750	HR-82-5.0-O or OP	KT-10500-31AF	\$150.38	KT-10500-31F	\$151.84	
	6.000	2.375	4.500	1.500		-	KT-10600AF	\$248.12	KT-10600F	\$218.90				
	SMW Autoblok ANM 250, BBM-250, BHM-250	5.000	2.169	4.000		1.750	HR-82-5.0	KT-10500-21AF	\$120.30	KT-10500-21F	\$128.48			
			2.375	4.500		1.500	K1-16-30	KT-10500AF	\$198.60	KT-10500F	\$182.53			

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: **KT-10200AF** will be **KT-10200AP**. Add \$4.00 For Pointed Jaws

Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 542-554. \* Denotes non-stock item-Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



MADE IN THE  
USA

USST

Chuck Make & Model	Chuck Size	Critical Dimensions				2 Screws Included With Each Jaw Nut							
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Order Number	Price Each	
Kitagawa: B-210,BT-210 Strong: N210 MMK:H-10,HA8-11 Samchully: HS-10	10	0.335	0.628 (16mm)	M12-1.75x30mm	1.181 (30mm)	0.846	0.886	1.981	KT-100JN	\$31.58	M1217530	\$2.25	
Kitagawa:B-10,HOB-10	10	0.374	0.628 (16mm)	M12-1.75x35mm	1.181 (30mm)	1.000	0.886	2.160	KT-101JN	\$38.14	M1217535	\$2.25	
MMK:ZA-10, PC-10-78	10	0.315	0.628 (16mm)	M12-1.75x35mm	1.181 (30mm)	0.906	0.906	1.971	MT-101JN	\$50.37	M1217535	\$2.25	

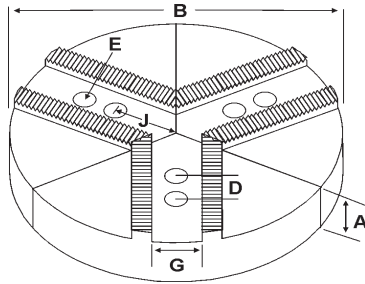
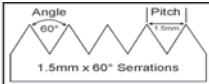
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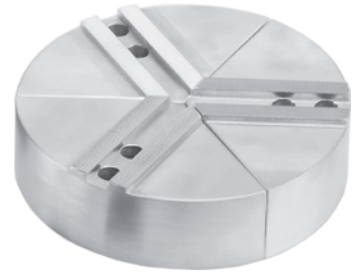
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# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA



Group  
**(K1)**



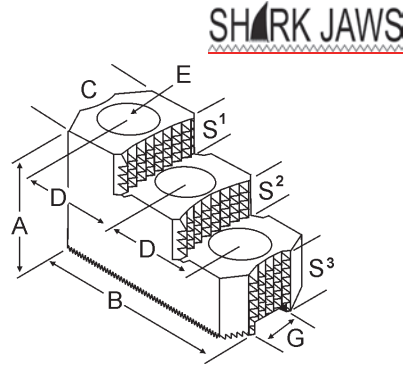
Group No.	Chuck Size	Critical Dimensions							ALUMINUM		CAST IRON		STEEL		
		Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	Part Number	Price Set of 3	Part Number	Price Set of 3	Part Number	Price Set of 3	
K1-16-32	10"	0.630 (16mm)	12mm	1.250	2.375	10	2.00	-	RMT-10200A	\$146.68	RMT-10200CI	\$278.30	RMT-10200S	\$423.27	
				1.260	2.875	10	2.00	MTT10P	RMT-10200A4	\$146.68	-	-	-	-	
				1.250 (32mm)	2.375	10	2.50	-	-	RMT-10250A	\$212.91	-	-	-	-
							3.00	-	-	RMT-10300A	\$194.66	-	-	RMT-10300S	\$552.10
							4.00	-	-	RMT-10400A	\$226.51	RMT-10400CI	\$494.74	-	-
				1.260	2.875	10	4.00	MTT10P1	RMT-10400A4	\$227.62	-	-	-	-	
		1.250 (32mm)	2.375	10	5.00	-	-	RMT-10500A	\$340.12	-	-	-	-		
					6.00	-	-	RMT-10600A	\$474.07	-	-	-	-		
					2.00	-	-	12-RMT-10200A	\$215.37	-	-	-	-		
					4.00	-	-	12-RMT-10400A	\$372.23	-	-	-	-		
					15	2.50	-	15-RMT-10250A	\$494.11	-	-	-	-		
					18	4.00	-	18-RMT-10400A*	\$851.69	-	-	-	-		

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS

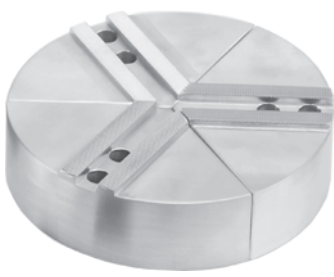


- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life.
- Ideal for castings and scaly material.
- Made in the USA.



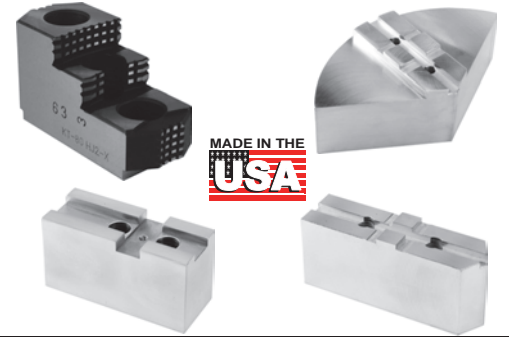
Group Number	Chuck Size	Critical Dimensions				Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D	Hole Space D												
K1-16-32	10	0.630 (16mm)	12mm	1.266 (32mm)	1.500	4.125	2.000	3	2	0.650	0.500	1.350	MT-100HJ2	\$486.63	Shark Jaws	D	

## SPECIAL ORDER JAWS AVAILABLE!



- Super Quick Turnaround Time- 3 Days Or Less In Most Cases!
- Special Order Round Jaws Up To 32" dia!
- Special Order Soft Jaws Up To 8" Height!
- Soft Jaws Available In Any Length-Steel Or Aluminum
- Tongue And Groove, Square Serrated & Acme Serrated Jaws Up To 8" Height!
- Made Per Your Special Specifications In The USA! Please See Our Special Order Forms On Pages 555-560.

Please Call Today For A Quote!



Call Us Today For All Of Your Machine Tool Needs!

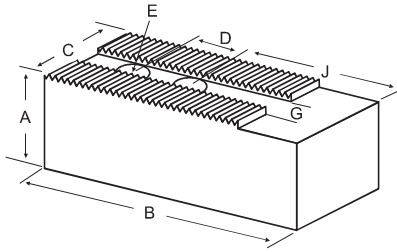


# SOFT JAWS- 1.5 mm x 60° Serrations

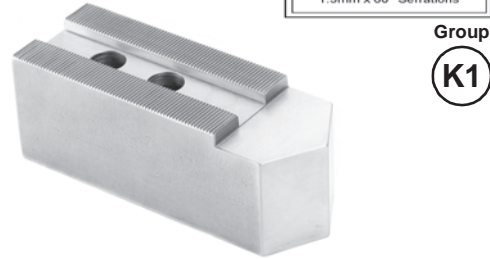
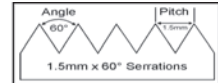
TABLE OF CONTENTS

LATHE CHUCKS  
LIVE CENTERS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



**QUANTITY DISCOUNTS!**

Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

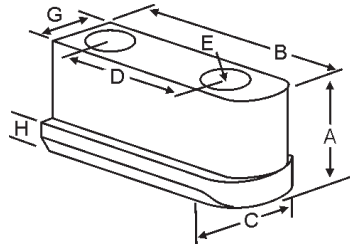
Group No.	Chuck Size	Critical Dimensions									ALUMINUM		STEEL	
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3	
K1-16-32 For Hitachi-Seiki ZA_-10, HA_-10	10"	0.630 (16mm)	12mm	1.250 (32mm)	2.000	2.375	1.500	4.500	2	MT-10200AF	\$61.62	MT-10200F	\$68.26	
					3.000	2.875	1.500	5.000	2	MT-10201AF	\$66.52	MT-10201F	\$73.62	
					4.000	2.375	1.500	4.500	2	MT-10300AF	\$75.62	MT-10300F	\$83.41	
						2.875	1.500	5.000	2	MT-10301AF	\$81.79	MT-10301F	\$90.20	
					5.000	2.375	1.500	4.500	2	MT-10400AF	\$88.69	MT-10400F	\$87.63	
					2.875	1.500	5.000	2	MT-10401AF	\$93.82	MT-10401F	\$103.05		
					2.375	1.500	4.500	2	MT-10500AF	\$198.60	MT-10500F	\$220.85		

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-10200AF will be KT-10200AP. Add \$4.00 For Pointed Jaws

Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item-Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



Chuck Make & Model	Chuck Size	Critical Dimensions					2 Screws Included With Each Jaw Nut						
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Order Number	Price Each	
Hitachi-Seiki ZA/ZA_-10	10	0.315	0.628 (16mm)	M12-1.75x35mm	1.259 (32mm)	0.906	0.906	2.050	MT-100JN	\$37.14	M1217535	\$2.25	
MMK: ZA_-10	10	0.315	0.628 (16mm)	M12-1.75x35mm	1.181 (30mm)	0.906	0.906	1.971	MT-101JN	\$50.37	M1217535	\$2.25	
Howa: HO15M12,HO22M12	10	0.374	0.708 (18mm)	M14-2.00x40mm	1.181 (30mm)	1.083	0.945	2.360	HO-100JN	\$37.14	M1420040	\$2.25	

## POWER CHUCK LUBRICANT

**LOWER FRICTION & INCREASE GRIPPING FORCE!**



**CHUCK-EEZ®** ensures long chuck life, machine accuracy and operator safety. Formulated with a high percentage of molybdenum disulfide to reduce seizing, galling, fretting wear and lower friction under conditions of extreme pressure. Rust and oxidation inhibitors incorporated to maximize complete rust protection. Able to withstand pressures up to 500,000 pounds per square inch!

- Double to triple clamping pressure
- Keeps work piece clamped in place
- Provides boundary lubrication protection
- Lowers friction and wear
- Assists in wear-in of new chucks
- Lowers maintenance costs
- High resistance to centrifuge force
- Greasing chuck once per shift is recommended
- **QUANTITY DISCOUNTS!**



Container Size	Case Qty	Part Number	Price Each
4 Oz Cartridge	24	EZ-21471	\$5.86
4 Oz Cartridge w/ grease gun	1	EZ-OKIT-21471	\$31.93
16 Oz Cartridge	12	EZ-21478	\$17.93
10 Lb Pail	1	EZ-21444	\$146.98
40 Lb Pail	1	EZ-21445	\$561.04
135 Lb Keg	1	EZ-21446	\$1,848.83
450 Lb Drum	1	EZ-21448	\$5,894.85

Call Us Or Visit Our Website For Our Complete Selection!

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

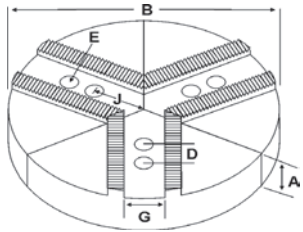
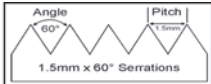
CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

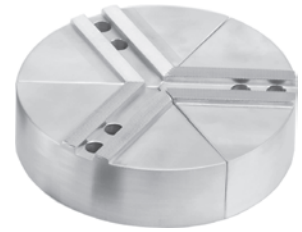
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Made in the USA



Group



Group No.	Chuck Size	Critical Dimensions				ALUMINUM				CAST IRON/STEEL			
		Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	Part Number	Price Set of 3	Part Number	Price Set of 3	
<b>K1-18-30</b>	12"	0.709 (18mm)	14mm	1.181 (30mm)	2.375°	10	2.00	-	RHO-10200A	\$165.73	RHO-10200CI	\$278.30	
KITAGAWA					3.000	10	2.00	HOW27M10P	RHO-10200A4	\$165.73	-	RHO-10200S	\$423.27
B-12, BT-12, HO-12, HOB-12, HOH-12					2.375°	10	2.50	-	RHO-10250A	\$212.91	-	-	-
							3.00	-	RHO-10300A	\$240.33	-	-	-
							3.00	-	-	-	-	RHO-10300S	\$552.10
							4.00	-	RHO-10400A	\$255.63	-	RHO-10400CI	\$494.74
SAMCHULLY					3.000	10	4.00	HOW27M10P1	RHO-10400A4	\$255.63	-	-	-
HAH12, HCH12							5.00	-	RHO-10500A	\$340.12	-	-	-
							6.00	-	RHO-10600A*	\$475.52	-	-	-
MMK					2.375°	10	2.00	-	12-RHO-10200A	\$215.37	-	-	-
H-12, HA8-12, ZA8-12, ZJA8-12							3.00	-	12-RHO-10300A*	\$355.20	-	-	-
							4.00	-	12-RHO-10400A	\$427.41	-	-	-
							2.50	-	15-RHO-10250A*	\$494.11	-	-	-
							4.00	-	15-RHO-10400A*	\$607.05	-	-	-
HOWA					1.250°	8	2.00	-	8-RKT-12200A	\$102.20	-	-	-
HO15M12, HO22M10, HO24M10, HO27M10							10	2.00	10-RKT-12200A*	\$146.86	-	-	-
					2.875	12	2.00	-	RKT-12200A	\$184.71	-	RKT-12200CI	\$431.01
							12	2.00	-	-	-	RKT-12200S	\$551.12
					3.500	12	2.00	KTT12P	RKT-12200A5	\$170.93	-	-	-
					2.875	12	2.50	-	RKT-12250A	\$195.49	-	-	-
					3.290	12	2.50	AKT12FG	RKT-12250A4	\$197.37	-	-	-
					2.875	12	3.00	-	RKT-12300A	\$245.72	-	-	-
							4.00	-	RKT-12400A	\$330.34	-	RKT-12400S	\$1,061.42
					3.500	12	4.00	KTT12P1	RKT-12400A5	\$312.53	-	-	-
					2.875	12	5.00	-	RKT-12500A	\$476.58	-	-	-
					3.290	12	5.00	AKT12EHFG	RKT-12500A4	\$476.58	-	-	-
					2.875	12	6.00	-	RKT-12600A	\$627.94	-	RKT-12600S	\$1,484.51
					2.875	15	2.50	-	15-RKT-12250A	\$494.11	-	15-RKT-12250CI	\$721.49
					3.500	15	3.00	KTT15-12P	15-RKT-12300A5	\$516.17	-	-	-
					2.875	15	4.00	-	15-RKT-12400A	\$607.05	-	-	-
					3.500	15	4.00	KTT15-12P1	15-RKT-12400A4	\$576.89	-	-	-
					2.875	18	2.50	-	18-RKT-12250A	\$630.49	-	-	-
					3.500	18	3.00	KTT18-12P	18-RKT-12300A5	\$710.55	-	-	-
					2.875	18	4.00	-	18-RKT-12400A	\$851.69	-	-	-
					3.500	18	4.00	KTT18-12P1	18-RKT-12400A5	\$835.46	-	-	-
					2.875	21	2.50	-	21-RKT-12250A	\$908.07	-	-	-
					3.500	21	3.00	KTT21-12P	21-RKT-12300A5	\$933.38	-	-	-
					2.875	21	4.00	-	21-RKT-12400A	\$1,135.76	-	-	-
					3.500	21	4.00	KTT21-12P1	21-RKT-12400A5	\$1,114.13	-	-	-
					2.875	24	2.50	-	24-RKT-12250A	\$1,094.92	-	-	-
			4.00	-	24-RKT-12400A*	\$1,550.55	-	-	-				

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6  
For complete list of applicable chucks, see pages 542-554.\* denotes non-stock item. Please allow 1 week manufacturing time.  
° Will not reach center of a 12" chuck

## HARD JAWS

Please See Page 51 For Dimensional Diagrams

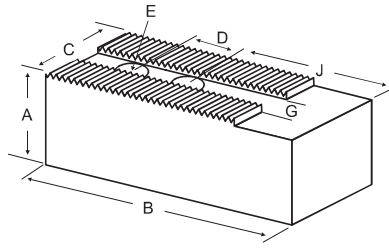
Group Number	Chuck Size	Critical Dimensions				Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D													
<b>K1-18-30</b>	12	0.709 (18mm)	14mm	1.181 (30mm)	1.750	4.600	2.000	3	1	0.750	-	1.250	KT-120HJ1	\$540.84	Shark Jaws	D	
B-12, BT-12, HA8-12, MMK-12, ZA8-12					1.969	4.091	2.051	3	1	0.669	-	1.382	KT-120HJ1-U	\$415.53	OEM Style	E	
					2.000	4.875	2.469	3	1	1.300	-	1.168	KT-120HJ1-X	\$437.40	XTRA-BITE	E	
					1.750	4.600	2.500	3	2	0.650	0.500	1.350	KT-120HJ2	\$540.84	Shark Jaws	D	
					2.000	4.042	2.480	3	2	0.543	0.442	1.495	KT-120HJ2-U	\$391.99	OEM Style	E	
					2.000	4.875	2.469	3	2	0.650	0.650	1.169	KT-120HJ2-X	\$415.42	XTRA-BITE	E	

Call Us Today For All Of Your Machine Tool Needs!

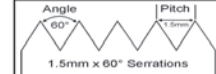
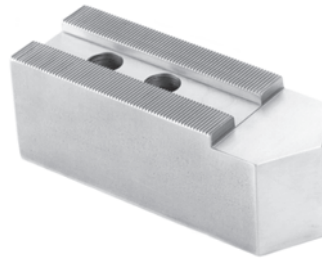
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- All jaws have 2 holes
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group

(K1)

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

COOLANT/FLUIDS  
TOOL STORAGE

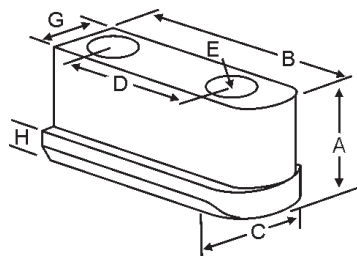
Group No.	Chuck Size	Critical Dimensions								ALUMINUM		STEEL	
		Groove Width G	Screw Size E	Hole Space D	Height A	Hole To Front J	Length B	Width C	Industry Reference #	Flat End Part Number	Price Set of 3 Jaws	Flat End Part Number	Price Set of 3 Jaws
K1-18-30	10" & 12"	0.709 (18mm)	14mm	1.181 (30mm)	2.000	2.375	4.500	1.500	-	HO-10200AF	\$61.62	HO-10200F	\$68.26
					3.000	2.375	4.500	1.500	-	HO-10300AF	\$75.62	HO-10300F	\$83.41
					4.000	2.375	4.500	1.500	-	HO-10400AF	\$88.69	HO-10400F	\$97.53
KITAGAWA B-12, BT-12, HO-12, HOB-12, HOH-12	12"	0.709 (18mm)	14mm	1.181 (30mm)	2.000	2.881	5.250	2.000	HR-108-2.0	KT-12200-28AF	\$74.05	KT-12200-28F	\$70.63
						3.125	5.500	2.000	-	KT-12200AF	\$74.05	KT-12200F	\$72.00
						3.125	5.500	2.000	-	KT-12200BF	Call	-	-
						3.625	6.000	2.000	-	KT-12201AF	\$78.80	KT-12201F	\$87.03
						3.881	6.250	2.000	HR-108-2.0-O or OP	KT-12200-38AF	\$80.21	KT-12200-38F	\$95.78
						2.785	5.500	2.000	KT-12/KT-12P	-	-	KT-12	\$72.51
					2.500	2.881	5.250	2.000	HR-108-2.5	KT-12250-28AF	\$78.80	KT-12250-28F	\$87.99
						3.125	5.500	2.000	-	KT-12250AF	\$77.93	KT-12250F	\$91.70
						3.285	6.000	2.000	KT-12PL	-	-	KT-12PL	\$90.52
						3.881	6.250	2.000	HR-108-2.5-O or OP	KT-12250-38AF	\$90.23	KT-12250-38F	\$93.81
						3.125	5.500	2.000	-	KT-12300AF	\$90.10	KT-12300F	\$107.96
						3.125	5.500	2.000	-	KT-12300BF	Call	-	-
3.000	3.625	6.000	2.000	-	KT-12301AF	\$95.21	KT-12301F	\$104.10					
	2.785	5.500	2.000	KT-12MH/KT-12MHP	-	-	KT-12MH	\$90.02					
	3.285	6.000	2.000	KT-12MHPL	-	-	KT-12MHPL	\$128.47					
3.500	2.881	5.250	2.000	HR-108-3.5	KT-12350-28AF	\$100.26	KT-12350-28F	\$99.28					
	3.881	6.250	2.000	HR-108-3.5-O or P	KT-12350-38AF	\$126.99	KT-12350-38F	\$119.14					
4.000	2.785	5.500	2.000	KT-12EH/KT-12EHP	-	-	KT-12EH	\$96.27					
	3.125	5.500	2.000	-	KT-12400AF	\$94.76	KT-12400F	\$124.39					
	3.125	5.500	2.000	-	KT-12400BF	Call	-	-					
	3.285	6.000	2.000	KT-12EHPL	-	-	KT-12EHPL	\$135.66					
	3.625	6.000	2.000	-	KT-12401AF	\$109.85	KT-12401F	\$119.25					
5.000	2.881	5.250	2.000	HR-108-5.0	KT-12500-28AF	\$144.82	KT-12500-28F	\$142.50					
	3.881	6.250	2.000	HR-108-5.0-O or OP	KT-12500-38AF	\$172.66	KT-12500-38F	\$170.53					
6.000	3.125	5.500	2.000	-	KT-12600AF	\$282.78	KT-12600F	\$312.86					

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-10200AF will be KT-10200AP. Add \$4.00 For Pointed Jaws  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item-Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



MADE IN THE USA



USST

Kitagawa	Chuck Size	Critical Dimensions							2 Screws Included With Each Jaw Nut			
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
Kitagawa:B-12,HOB-12 MMK:HH-12,HHL-12	12	0.531	0.708 (18mm)	M14-2.00 x 45mm	1.181 (30mm)	1.318	1.040	2.185	KT-120JN	\$39.92	M1420045	\$2.25
					1.488 (38mm)	1.318	1.040	2.185	KT-124JN	\$39.00	M1420045	\$2.25

Call Us Or Visit Our Website For Our Complete Selection!

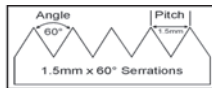
2019-20 MASTER CATALOG

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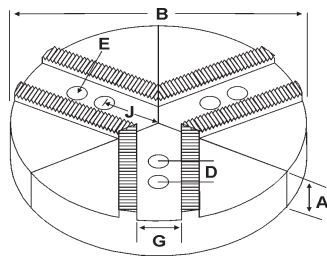


# ROUND JAWS- 1.5 mm x 60° Serrations

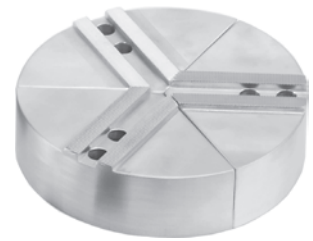
FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



Group  
**(K1)**



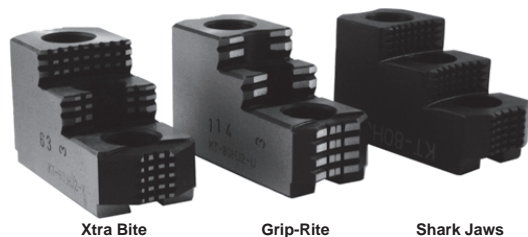
- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- Aluminum round jaws made from solid extruded aluminum (up to 15" dia)
- Made in the USA



Group No.	Chuck Size	Critical Dimensions			Hole to Front J	Pie Dia B	Height Inch A	Industry Ref #	ALUMINUM		CAST IRON	
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3
<b>K1-21-30</b>	12"	0.827 (21mm)	16mm	1.181 (30mm)	2.875	10	2.00	-	10-RKT-12208A	\$146.86	-	-
KITAGAWA B-212, BL-212, BT-212 Big Bore BB-212†					3.000	10	2.00	AUTO10P	10-RKT-12208A4	\$146.86	-	-
					2.875	12	2.00	-	RKT-12208A	\$184.71	RKT-12208CI	\$431.01
12						2.00	-	-	-	-	RKT-12208S	\$551.12
SAMCHULLY HS12, HST12 MH-212†					3.500†	12	2.00	KTTB212P	RKT-12208A4	\$171.04	-	-
					4.000†	12	2.50	AKT212FG	RKT-12258A5	\$197.23	-	-
STRONG N212					2.875	12	3.00	-	RKT-12308A	\$278.56	-	-
					12	4.00	-	-	RKT-12408A	\$330.34	-	-
HOWA H3KT12					3.500†	12	4.00	KTTB212P1	RKT-12408A4	\$328.15	-	-
					4.000†	12	4.00	AKT212MHFG	RKT-12408A5	\$372.23	-	-
SMW Autoblok BBM-305/ 315, BHM-305/315					2.875	12	5.00	-	RKT-12508A	\$476.58	-	-
					4.000†	12	5.00	AKT212EHFG	RKT-12508A5	\$476.58	-	-
SEOAM CAH-12					12	6.00	-	-	RKT-12608A	\$706.20	-	-
					2.875	15	2.00	-	15-RKT-12208A	\$343.73	-	-
MMK PC12-93-02					15	2.50	-	-	15-RKT-12258A	\$494.11	15-RKT-12258CI	\$721.49
					3.500†	15	3.00	KTT15B212P	15-RKT-12308A4	\$516.17	-	-
2.875					15	4.00	-	-	15-RKT-12408A	\$607.05	-	-
					3.500†	15	4.00	KTT15B212P1	15-RKT-12408A4	\$585.38	-	-
2.875					18	2.50	-	-	18-RKT-12258A	\$630.49	-	-
					3.500†	18	3.00	KTT18B212P	18-RKT-12308A4	\$674.05	-	-
2.875					18	4.00	-	-	18-RKT-12408A*	\$851.69	-	-
					3.500†	18	4.00	KTT18B212P1	18-RKT-12408A4	\$835.46	-	-
2.875					21	4.00	-	-	21-RKT-12408A	\$1,135.76	-	-
					3.500†	24	2.00	KTT24B212P2	24-RKT-12208A4	\$1,064.85	-	-

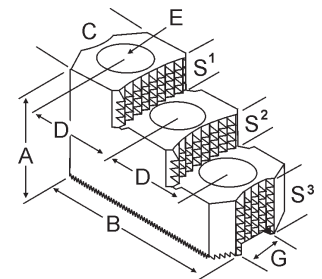
Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.  
† - for big bore chucks.

## HARD JAWS



### FEATURES:

- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- XTRA BITE -very aggressive bite. Conical teeth for extra gripping power and ground body to provide improved runout.
- GRIP-RITE/OEM Style hard jaws have ground tips and provide better runout.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
- Bison jaws feature enhanced serrations on gripping surface
- 1 & 2 step jaws available.



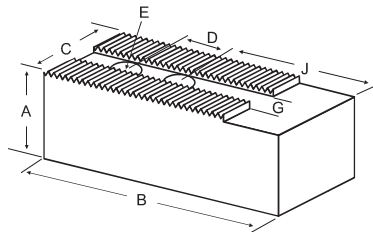
Group Number	Chuck Size	Critical Dimensions			Width Inch C	OAL Inch B	Height Inch A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D												
<b>K1-21-30</b>	12	0.827 (21mm)	16mm	1.181 (30mm)	2.000	4.042	2.480	3	1	0.543	-	1.937	KT-128HJ1-U	\$393.39	OEM Style	E
B-212 BT-212					1.750	4.600	2.500	3	2	0.650	0.500	1.350	KT-128HJ2	\$540.84	Shark Jaws	D
					2.000	4.042	2.480	3	2	0.543	0.442	1.495	KT-128HJ2-U	\$390.92	OEM Style	E
					2.000	4.875	2.469	3	2	0.650	0.650	1.169	KT-128HJ2-X	\$416.29	XTRA-BITE	E

Call Us Today For All Of Your Machine Tool Needs!

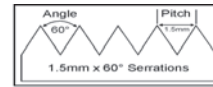
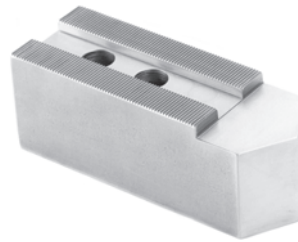
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group

**K1**

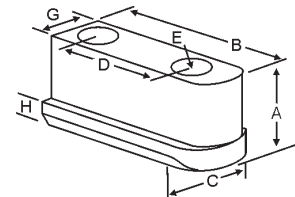
**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

• Max. length of serrations: 5.75"

Group No.	Chuck Size	Critical Dimensions				ALUMINUM				STEEL			
		Groove Width G	Screw Size E	Hole Space D	Height A	Hole To Front J	Length B	Width C	Industry Reference #	Flat End Part Number	Price Set of 3 Jaws	Flat End Part Number	Price Set of 3 Jaws
<b>K1-21-30</b>	12"	0.827 (21mm)	16mm	1.181 (30mm)	2.000	3.125	5.500	2.000	-	KT-12208AF	\$74.05	KT-12208F	\$72.00
<b>KITAGAWA</b> B-212, BB-212, BL-212, BT-212					2.000	3.125	5.500	2.000	-	KT-12208BF	Call	-	-
<b>SAMCHULLY</b> HS12, HST12 MH-212†					2.500	2.881	5.250	2.000	HR-112-2.5	KT-12258-28AF	\$78.80	KT-12258-28F	\$87.99
					2.500	3.125	5.500	2.000	-	KT-12258AF	\$78.80	KT-12258F	\$91.70
					2.500	3.492	5.500	2.000	KT-212 or KT-212P	-	-	KT-212	\$76.13
					2.500	3.881	6.250	2.000	HR-112-2.5-O or OP	KT-12258-38AF	\$90.23	KT-12258-38F	\$93.44
<b>STRONG</b> N212 NT212 NIT212 NB212					2.500	3.992	6.000	2.000	KT-212PL	-	-	KT-212PL	\$82.99
					3.000	3.125	5.500	2.000	-	KT-12308AF	\$90.10	KT-12308F	\$107.96
<b>HOWA</b> H3KT12					3.000	3.125	5.500	2.000	-	KT-12308BF	Call	-	-
					3.250	3.492	5.500	2.000	KT-212MH or MHP	-	-	KT-212MH	\$90.02
<b>SEOAM</b> CAH-12					3.250	3.992	6.000	2.000	KT-212MHPL	-	-	KT-212MHPL	\$128.47
					3.500	2.881	5.250	2.000	HR-112-3.5	KT-12358-28AF	\$100.26	KT-12358-28F	\$99.28
<b>MMK</b> PC12-93-02					3.500	3.881	6.250	2.000	HR-112-3.5-O/OP	KT-12358-38AF	\$126.99	KT-12358-38F	\$119.14
					4.000	3.125	5.500	2.000	-	KT-12408AF	\$92.04	KT-12408F	\$130.41
<b>MMK</b> PC12-93-02					4.000	3.125	5.500	2.000	-	KT-12408BF	Call	-	-
					4.000	3.492	5.500	2.000	KT-212EH or EHP	-	-	KT-212EH	\$101.08
					4.000	3.992	6.000	2.000	KT-212EHPL	-	-	KT-212EHPL	\$128.14
					5.000	2.881	5.250	2.000	HR-112-5.0	KT-12508-28AF	\$144.82	KT-12508-28F	\$142.50
					5.000	3.881	6.250	2.000	HR-112-5.0-O or OP	KT-12508-38AF	\$172.66	KT-12508-38F	\$170.53
					6.000	3.125	5.500	2.000	-	KT-12608AF	\$282.78	KT-12608F	\$312.86

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-12200AF will be KT-12200AP. Pointed Jaws add \$7.00  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



Chuck Make & Model	Chuck Size	Critical Dimensions						2 Screws Included With Each Jaw Nut				
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
B212, HS12, N212	12"	0.453	0.827 (21mm)	M16-2.00x40mm	1.181 (30mm)	1.090	1.160	2.565	KT-128JN	\$39.79	M1620040	\$2.25
Kitagawa: BB212		0.453	0.827 (21mm)	M16-2.00x40mm	1.181 (30mm)	0.896	1.161	2.215	KT-BB212JN	\$42.97	M1620040	\$2.25
-		0.531	0.787 (20mm)	M12-1.75x45mm	1.375 (35mm)	1.320	1.040	2.190	SG-120JN	\$41.54	M1217545	\$2.25
-		0.453	0.827 (21mm)	M16-2.00x40mm	1.378 (35mm)	1.140	1.060	2.429	HO-120JN	\$39.00	M1620040	\$2.25

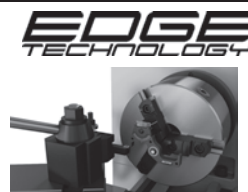
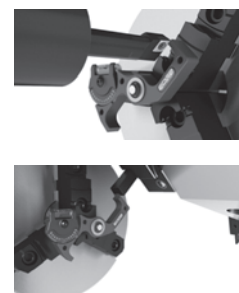
## CNC LATHE GAGE



**NEW ITEM!**

Used to set lathe tools on the spindle axis for optimum cutting conditions. It can be used to set tools on the spindle axis and eliminate the nub left after cutting. Designed with a large amount of angular adjustability, allowing it to be used with any slant bed or Swiss style CNC lathe. Two different contact faces allows it to work with both upward and downward facing cutting tools.

- Set turning, boring, and facing tools on spindle axis for optimum cutting conditions
- Eliminate the "nub" left by poorly set tools.
- Precision glass vial level with 30/2mm sensitivity
- Angular adjustability of +/- 60°
- Ground steel shaft supported by dual ball bearings
- Made from high strength aluminum



**Lathe Gage**  
Part # EDGE-13000  
**\$44.99 ea**

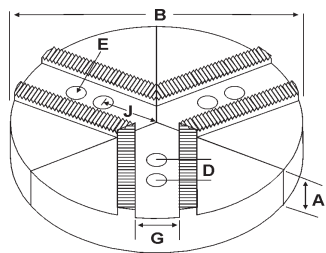
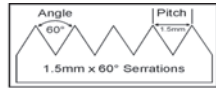
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LATHE CHUCKS  
LIVE CENTERS  
VISE JAWS  
VISE ACCESSORIES  
STRAIGHT SHANK  
COLLET HOLDERS  
TAP HOLDERS  
DRILL CHUCKS  
CARBIDE INSERTS  
THREADING/GROOVING  
CUTTING TOOLS  
MACHINERY  
PRECISION TOOLS  
DEBURRING  
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks



Group  
**(K1)**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum, Cast Iron & Steel
- **Made in the USA**



Group No.	Chuck Size	Critical Dimensions			Hole to Front J	Pie Dia B	Height Inch A	Industry Reference #	ALUMINUM		CAST IRON/STEEL		
		Groove Width G	Screw Size E	Hole Space D					Part Number	Price Set of 3	Part Number	Price Set of 3	
K1-18-32	12	0.710 (18mm)	14mm	1.260 (32mm)	2.875	12	2.00	-	RMT-12200A	\$203.54	-	-	
							2.50	-	RMT-12250A	\$209.50	-	-	
							3.00	-	RMT-12300A	\$355.20	-	-	
K1-18-38	12	0.709 (18mm)	14mm	1.488 (38mm)	2.875	12	2.00	-	RKT-12204A	\$184.71	RKT-12204CI	\$431.01	
							4.00	-	RKT-12404A	\$427.41	-	-	
K1-20-35	12	0.788 (20mm)	12mm	1.377 (35mm)	2.875	10	2.00	-	10-RSG-12200A	\$165.73	-	-	
							4.00	-	10-RSG-12400A*	\$255.63	-	-	
						12	2.00	-	RSG-12200A	\$215.37	RSG-12200CI	\$431.01	
							3.438	12	2.00	SUG12PSTM	RSG-12200A4	\$215.37	-
						12	3.00	-	RSG-12300A	\$355.20	-	-	
							4.00	-	RSG-12400A	\$427.41	-	-	
K1-21-35	12	0.827 (21mm)	16mm	1.378 (35mm)	2.875	12	2.00	-	RHO-12200A	\$215.37	RHO-12200CI	\$431.01	
							4.00	-	RHO-12400A	\$427.41	-	-	
12	15	2.50	-	15-RHO-12250A	\$494.11	-	-						
	18	2.50	-	18-RHO-12250A*	\$618.48	-	-						

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Aluminum Casting T6 Aluminum round jaws made from solid extruded aluminum (up to 15" dia)  
For complete list of applicable chucks, see pages 542-554.\* denotes non-stock item. Please allow 1 week manufacturing time.

## ACCU-STOP

### Customizable Precision Stop For CNC Lathes

Precise. Versatile. Safe.

The Accu-Stop spindle stop provides a solid, precise stopping surface for work pieces. Its modular assembly allows you to stop parts from anywhere outside the chuck's bore to nearly the entire length of the draw tube.

#### How Accu-Stop Works

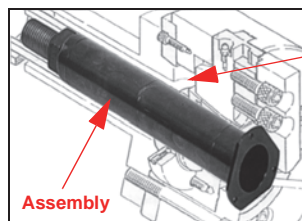
Accu-Stop bolts to the front of your CNC lathe's chuck, allowing the work piece and the stop to turn together to eliminate friction, gouging, and damage to the work piece. Modular assembly makes it easy to configure along the draw tube to accommodate a wide range of work piece lengths.

The Accu-Stop spindle stop is made of low-carbon steel that is coated with zinc oxide for durability. The standard assembly includes: faceplate and sub-faceplate three extension tubes end cap threaded rod and lock nut.

All that is needed to order is the make / model of your chuck and an actual measured ID of your drawtube.

#### Assembly Includes:

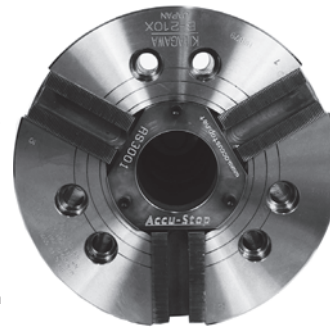
- Face Plate
  - Sub Face Plate
  - 3 extension tubes
  - End Cap
  - Threaded rod & lock nut
- Package Includes:**
- Complete assembly
  - Rigid strap wrench
  - Accu-stop vise



Adjust length by adding or removing tube section and adjusting rod.

#### ORDERING INFORMATION:

- To Order, We Will Need:
1. Make/Model of lathe
  2. Date manufactured
  3. Make/Model of chuck
  4. Inside diameter of the draw tube.



- Ensures accuracy/repeatability within .0005"
- Heavy duty and highly accurate
- Replaces inaccurate and expensive stopping mechanisms
- Customize to precisely fit your needs
- For Big Bore chucks, use next larger size up (ex: BB-208 will use AS-3000)
- Made in the USA



Chuck Size	Description	Part Number	Price Each
6"	Assembly 16.5"	AS-1000	\$554.80
	Accu-Stop Package	AS-P1000	\$893.95
	Tubing stop option*	AS-TSO1000	\$85.00
8"	Assembly 16.5"	AS-2000	\$554.80
	Accu-Stop Package	AS-P2000	\$893.95
	Tubing stop option*	AS-TSO2000	\$85.00
10"	Assembly 16.5"	AS-3000	\$649.80
	Accu-Stop Package	AS-P3000	\$988.95
	Tubing stop option*	AS-TSO3000	\$98.00
12"	Assembly 20.25" (under 3" dia drawtube)	AS-4000SB	\$934.80
	Assembly 20.25" (under 3" dia drawtube)	AS-4000LB	\$944.30
	Package (under 3" dia drawtube)	AS-P4000SB	\$1,273.95
	Package (over 3" dia drawtube)	AS-P4000LB	\$1,283.45
	Extra Tube (6" Long)	AS-4003SB	\$79.00
	Tubing stop option*	AS-TSO4000	\$115.00

\*For Big Bore Chucks, Please Order The Next Larger Size-Ex: BB-208 will use AS-3000 series  
\*If machining tubing, you may need the tubing stop option

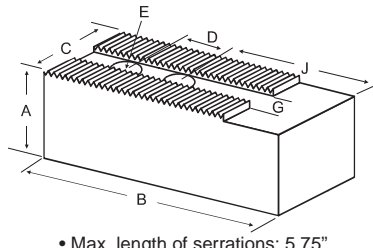
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# SOFT JAWS- 1.5 mm x 60° Serrations

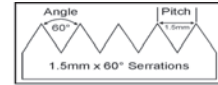
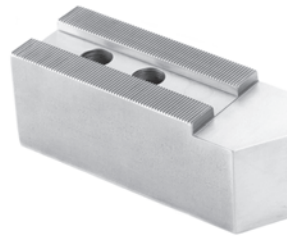
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FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



• Max. length of serrations: 5.75"

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- All jaws have 2 holes
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group

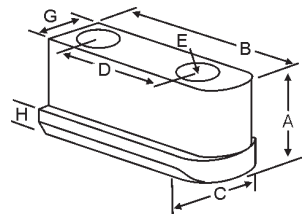
**K1**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

Group No.	Chuck Size	Critical Dimensions			ALUMINUM					STEEL			
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3
K1-20-35	12	0.788 (20mm)	12mm	1.378 (35mm)	2.000	3.125	2.000	5.500	2	SG-12200AF	\$74.05	SG-12200F	\$81.51
					4.000	3.125	2.000	5.500	2	SG-12400AF	\$104.42	SG-12400F	\$113.74
K1-18-32	12	0.710 (18mm)	14mm	1.260 (32mm)	2.000	3.125	2.000	5.500	2	MT-12200AF	\$74.05	MT-12200F	\$81.49
					3.000	3.125	2.000	5.500	2	MT-12300AF	\$85.94	MT-12300F	\$98.29
					4.000	3.125	2.000	5.500	2	MT-12400AF	\$104.41	MT-12400F	\$113.74
K1-18-38	12	0.709 (18mm)	14mm	1.488 (38mm)	2.000	3.125	2.000	5.500	2	KT-12204AF	\$74.26	KT-12204F	\$81.87
					4.000	3.125	2.000	5.500	2	KT-12404AF	\$104.42	KT-12404F	\$113.74
K1-21-35 HOWA HO27M12, HO34M12, HO37M12	12	0.827 (21mm)	16mm	1.378 (35mm)	2.000	3.125	2.000	5.500	2	HO-12200AF	\$74.05	HO-12200F	\$81.51
					3.125	2.000	5.500	2	HO-12250AF	\$86.26	HO-12250F	\$94.77	
					2.500	3.440	2.000	5.500	-	-	-	HO-27M12	\$99.56
					3.931	2.000	6.000	-	-	-	HO-27M12PL	\$109.62	
					3.000	3.125	2.000	5.500	2	HO-12300AF	\$83.27	HO-12300F	\$93.87
K1-21-40	12	0.826	16mm	1.562	2.500	3.000	2.000	5.750	2	JP-15250AF	\$87.09	JP-15250F	\$96.75
					4.000	3.000	2.000	5.750	2	JP-15400AF	\$104.41	JP-15400F	\$113.74
					2.500	2.040	1-3/4	4.813	2	HH-10250AF*	\$69.44	HH-10250F*	\$76.77
K1-21-40 10" Howa Hollow	10	0.827 (21mm)	3/4	1.578 (40mm)	3.500	2.040	1-3/4	4.813	2	HH-10350AF*	\$97.19	HH-10350F*	\$84.43
					5.000	2.040	1-3/4	4.813	2	HH-10500AF*	\$138.86	HH-10500F*	\$97.17

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: KT-10200AF will be KT-10200AP. Add \$4.00 For Pointed Jaws  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018 or 1050, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item-Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



Chuck Make & Model	Chuck Size	Critical Dimensions					2 Screws Included With Each Jaw Nut					
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
-	12"	0.531	0.787 (20mm)	M12-1.75x45mm	1.375 (35mm)	1.320	1.040	2.190	SG-120JN	\$41.54	M1217545	\$2.25
-		0.453	0.827 (21mm)	M16-2.00x40mm	1.378 (35mm)	1.140	1.060	2.429	HO-120JN	\$39.00	M1620040	\$2.25

## LATHESCOOT

Store and organize your turning tools! Chances are, your turning tooling is scattered all over the shop. Here's a storage and organization solution to increase your shop's efficiency.

- Top drawer utilizes welded columns with dividers for tool organization. Comes with 24 adjustable dividers
- Large 6" deep drawer for storing live tooling heads and other large tools
- Two removable top bins store and organize set up tools (See optional divider kit # HU-77030 sold separately)
- Side tray for optional collet racks, presetters, or other items
- Welded frame for rigidity requires no assembly
- Live center shelf holds 3MT and 4MT taper centers
- Open area for collet chucks, 3 jaw chucks, hard and soft jaws
- Blue and black paint combination
- Dimensions: 41" L x 35.25" H x 18" D
- Shipping weight is 92 lbs-ships via truck



**HUOT LATHESCOOT**  
Part #: HU-77300  
**\$749.00**

Call Us Or Visit Our Website For Our Complete Selection!

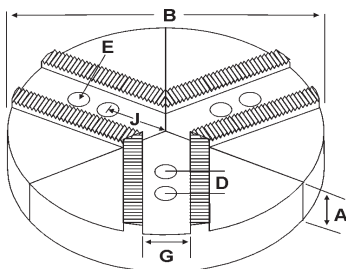
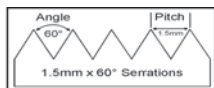
LATHE CHUCKS  
LIVE CENTERS  
VISE JAWS  
VISE ACCESSORIES  
STRAIGHT SHANK  
COLLET HOLDERS  
TAP HOLDERS  
DRILL CHUCKS  
CARBIDE INSERTS  
THREADING/GROOVING  
CUTTING TOOLS  
MACHINERY  
PRECISION TOOLS  
DEBURRING  
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

C

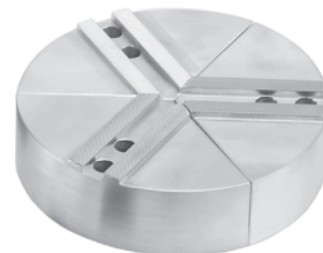
FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



Group  
**(K1)**



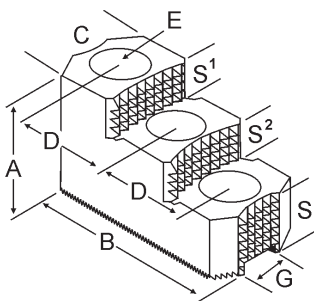
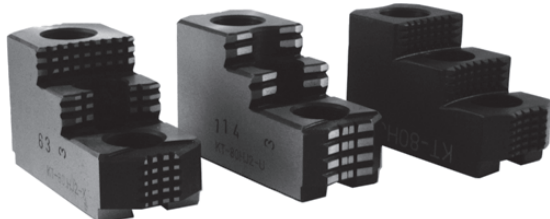
- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA



Group No.	Chuck Size	Critical Dimensions				Hole to Front J	Pie Dia B	Height Inch A	Industry Reference #	ALUMINUM		CAST IRON/STEEL	
		Groove Width G	Screw Size E	Hole Space D	Part Number					Price Set of 3	Part Number	Price Set of 3	
<b>K1-22-43</b>	<b>15" &amp; UP</b>	<b>0.866 (22mm)</b>	<b>20mm</b>	<b>1.690 (43mm)</b>	<b>3.750</b>	12	4.00	-	<b>12-RKT-15400A*</b>	<b>\$372.23</b>	-	-	
KITAGAWA BT-15, B-15,B-18 HOB-15, HOB-18, HOH-15, HOH-18						15	2.50	-	<b>RKT-15250A</b>	<b>\$494.11</b>	<b>RKT-15250CI</b>	<b>\$721.49</b>	
						15	2.50	-	-	-	<b>RKT-15250S</b>	<b>\$938.95</b>	
						15	4.00	-	<b>RKT-15400A</b>	<b>\$499.60</b>	<b>RKT-15400S</b>	<b>\$1,521.63</b>	
						15	5.00	-	<b>RKT-15500A</b>	<b>\$948.92</b>	-	-	
SAMCHULLY HAH/HCH 15 HAH/HCH 18						18	2.50	-	<b>18-RKT-15250A</b>	<b>\$630.49</b>	-	-	
						18	4.00	-	<b>18-RKT-15400A</b>	<b>\$851.69</b>	-	-	
MMK ZA8-15-120						21	2.50	-	<b>21-RKT-15250A</b>	<b>\$908.07</b>	-	-	
						21	4.00	-	<b>21-RKT-15400A*</b>	<b>\$1,135.76</b>	-	-	
						24	2.50	-	<b>24-RKT-15250A*</b>	<b>\$1,094.92</b>	-	-	
						24	4.00	-	<b>24-RKT-15400A</b>	<b>\$1,580.65</b>	-	-	

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018, 18" & Larger- Alum A319 6061-T6  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS- 2 STEP

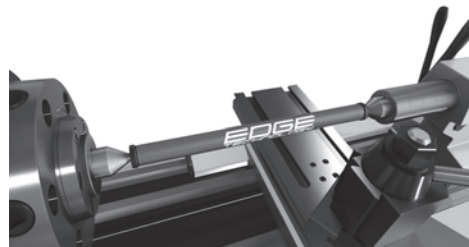


- Designed for first operation roughing, expect standard runoff between **0.005-0.010**
- Reversible-suitable for OD & ID workholding.
- **XTRA BITE** -very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runoff.
- **GRIP-RITE/OEM Style** hard jaws have ground tips and provide better runoff.
- **SHARK JAWS** have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
- 1 & 2 step jaws available.

Group Number	Chuck Size	Critical Dimensions				Width C	OAL B	Height A	No. of Holes	No. of Steps	TopStep Ht S1	MidStep Ht S2	Bot Step Ht S3	Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D													
<b>K1-22-43</b>	<b>15 &amp; 18</b>	<b>0.866 (22mm)</b>	<b>20mm</b>	<b>1.693 (43mm)</b>	2.500	5.400	3.000	3	2	0.730	0.730	1.540	<b>KT-150HJ2</b>	<b>\$701.09</b>	Shark Jaws	D	
B-15, B-18, N215/18 HAH/HCH 15					2.448	5.850	3.385	3	2	0.827	0.827	1.731	<b>KT-150HJ2-U</b>	<b>\$504.90</b>	OEM Style	E	
					2.500	5.500	3.500	3	2	0.950	0.950	1.600	<b>KT-150HJ2-X</b>	<b>\$554.85</b>	XTRA-BITE	E	

## TAILSTOCK ALIGNMENT BAR

The Tailstock Alignment Bar is used to align the tailstock to the headstock. Accurate alignment is critical to eliminate any taper in work pieces that are supported by the tail stock. It makes the process of tailstock alignment fast, easy and accurate.



**Tailstock Alignment Bar**  
Part # **EDGE-27000**  
**\$49.99 ea**

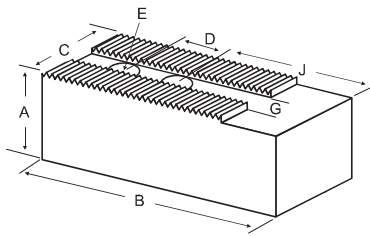
- Hardened steel bar ends are precision ground after assembly for superior accuracy
- Bar end diameters are equal within 0.0001"
- Bar made from high strength aluminum
- Durable anodized finish

Call Us Today For All Of Your Machine Tool Needs!

# SOFT JAWS- 1.5 mm x 60° Serrations

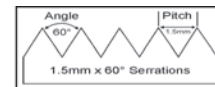
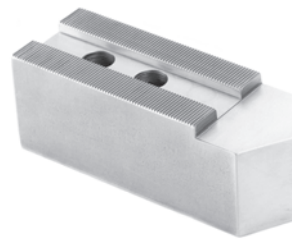
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FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



• Max. length of serrations: 5.75"

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



Group  
**K1**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

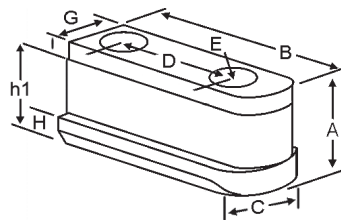
Group No.	Chuck Size	Critical Dimensions			Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	Industry Reference #	ALUMINUM		STEEL				
		Groove Width G	Screw Size E	Hole Space D						FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3			
<b>K1-22-43</b>	<b>15" &amp; 18"</b>	<b>0.866 (22mm)</b>	<b>20mm</b>	<b>1.690 (43mm)</b>	2.500	3.410	2.500	6.500	HR-155-2.5	KT-15250-34AF	<b>\$112.54</b>	KT-15250-34F	<b>\$121.79</b>			
KITAGAWA B-15, BT-15, B-15, B-18 HOB-15, HOB-18, HOH-15, HOH-18						3.437	2.500	6.500	-	KT-15250AF	<b>\$112.54</b>	KT-15250F	<b>\$122.69</b>			
						3.437	2.500	6.500	-	KT-15250BF	Call	-	-			
						4.410	2.500	7.500	HR-155-2.5-O or OP	KT-15250-44AF	<b>\$130.34</b>	KT-15250-44F	<b>\$146.00</b>			
					4.437	2.500	7.500	-	KT-15255AF	<b>\$121.30</b>	KT-15255F	<b>\$132.52</b>				
STRONG N215, N218 NT215 NIT-215/218					3.000	0.866 (22mm)	20mm	1.690 (43mm)	3.437	2.500	6.500	-	KT-15300AF	<b>\$128.86</b>	KT-15300F	<b>\$150.97</b>
									4.410	2.500	7.500	-	KT-15305AF	<b>\$144.82</b>	KT-15305F	<b>\$157.68</b>
									3.410	2.500	6.500	HR-155-3.5	KT-15350-34AF	<b>\$144.82</b>	KT-15350-34F	<b>\$157.68</b>
									4.410	2.500	7.500	HR-155-3.5-O or OP	KT-15350-44AF	<b>\$156.16</b>	KT-15350-44F	<b>\$169.36</b>
MMK PC-15-120					4.000	0.866 (22mm)	20mm	1.690 (43mm)	3.437	2.500	6.500	-	KT-15400AF	<b>\$148.14</b>	KT-15400F	<b>\$179.85</b>
									4.437	2.500	7.500	-	KT-15405AF	<b>\$161.10</b>	KT-15405F	<b>\$189.85</b>
SAMCHULLY HAH/HCH 15 HAH/HCH 18					5.000	0.866 (22mm)	20mm	1.690 (43mm)	3.410	2.500	6.500	HR-155-5.0	KT-15500-34AF	<b>\$241.25</b>	KT-15500-34F	<b>\$206.12</b>
									3.437	2.500	6.500	-	KT-15500AF	<b>\$241.25</b>	KT-15500F	<b>\$223.31</b>
									4.410	2.500	7.500	HR-155-5.0-O or OP	KT-15500-44AF	<b>\$279.60</b>	KT-15500-44F	<b>\$251.12</b>
									3.437	2.500	6.500	-	KT-15600AF	<b>\$333.84</b>	KT-15600F	<b>\$364.66</b>

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: NK-14250AF will be NK-14250AP. Pointed Jaws add **\$7.00**.

Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum

For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



MADE IN THE USA



USST

Chuck Make & Model	Chuck Size	Critical Dimensions					Hght Inch A	h1	Ledge Height I	Width Inch C	Length Inch B	2 Screws Included With Each Jaw Nut		
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Jaw Nut Part Number						Price Each	Screw Part Number	Price Each
-	15	0.649	0.864 (22mm)	M20-2.50x55mm	1.690 (43mm)	1.790	-	-	1.318	3.149	KT-150JN	<b>\$56.83</b>	M2025055	<b>\$3.25</b>
-	15	0.649	0.864 (22mm)	M20-2.50x55mm	2.360 (60mm)	1.798	-	-	1.320	3.820	KT-152JN	<b>\$53.87</b>	M2025055	<b>\$3.25</b>
Kitagawa: B-15, BT-15, B-18	15	0.636	0.861 (22mm)	M20-2.50x50mm	1.690 (43mm)	1.779	1.459	.320	1.317	3.149	KT-153JN	<b>\$52.96</b>	M2025050	<b>\$3.25</b>

## ADJUSTABLE JAW BORING RINGS

For Boring Round & Soft Chuck Jaws

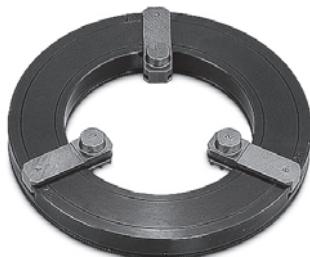


Directions:

- 1) Set jaws to correct position
- 2) Adjust jaw boring ring to fit bolt holes
- 3) Lock the chuck to clamp jaw boring ring
- 4) Machine desired size
- 5) Unlock chuck and remove jaw boring ring

USST

- Quickly bore jaws in a single operation with no plugs or rings
- Suitable for CNC lathes
- Easy to attach-no tools needed!
- Jaws are bored at same clamping pressure used to hold part for higher accuracy
- Economical-3 jaw boring rings cover chucks sizes from 5"-12"!



Chuck Size	ID	OD	Jaw Stroke	Max RPM	Part Number	Price Each
5,6,8"	3.94	6.70	7.40	800	JBR-TL5-8	<b>\$379.00</b>
6,8,10"	4.92	7.90	7.40	700	JBR-TL6-10	<b>\$439.00</b>
8,10,12"	6.30	9.80	8.50	600	JBR-TL8-12	<b>\$519.00</b>

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2019-20 MASTER CATALOG

LATHE CHUCKS  
LIVE CENTERS

WISE JAWS  
WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

CUTTING TOOLS  
MACHINERY

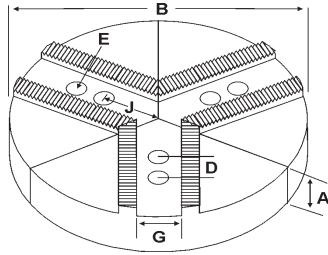
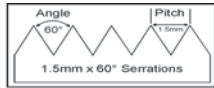
PRECISION TOOLS  
DEBURRING

COOLANT/FLUIDS  
TOOL STORAGE

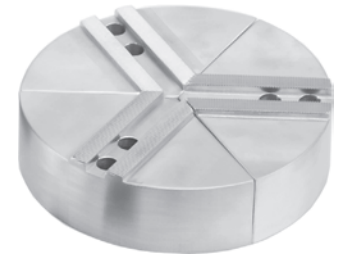


# ROUND JAWS- 1.5 mm x 60° Serrations

FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA



Group

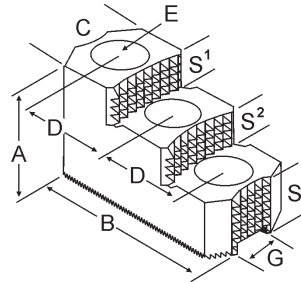
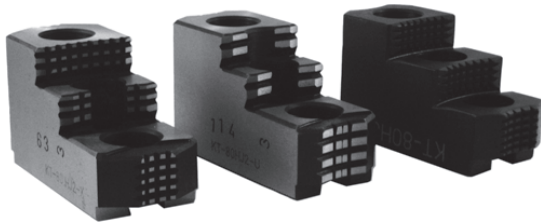
K1



Group No.	Chuck Size	Critical Dimensions							ALUMINUM			CAST IRON/STEEL			
		Groove Width G	Screw Size E	Hole Space D	Hole to Front J	Pie Dia B	Height Inch A	Industry Reference #	Part Number	Price Set of 3	Part Number	Price Set of 3			
K1-26-43 KITAGAWA B-215, N15, N18, BB-218 Samchully HC-15	15" & UP	1.005 (25.5mm)  (some mfg's refer to this as 1.004)	20mm	1.690 (43mm)	3.750	12	3.00	-	12-RKT-15301A	\$355.20	-	-			
									15	2.50	-	RKT-15251A	\$494.11	RKT-15251CI	\$721.49
									15	4.00	-	RKT-15401A	\$607.05	RKT-15401S	\$1,521.63
					4.313 (4-5/16)	15	2.00	KTTB215P2	RKT-15201A4	\$394.72	-	-			
								3.00	KTTB215P	RKT-15301A4	\$516.17	-	-		
								4.00	KTTB215P1	RKT-15401A4	\$499.70	-	-		
				3.750	18	5.00	-	-	RKT-15501A	\$948.92	-	-			
									2.50	-	18-RKT-15251A	\$630.49	-	-	
									4.00	-	18-RKT-15401A	\$851.69	-	-	
				4.313 (4-5/16)	18	3.00	4.00	-	KTT18B215P	18-RKT-15301A4	\$674.05	-	-		
									4.00	KTT18B215P1	18-RKT-15401A4	\$835.46	-	-	
									3.00	KTT21B215P	21-RKT-15301A4	\$933.38	-	-	
3.750	21	4.00	-	-	-	21-RKT-15401A	\$1,135.76	-	-						
					2.50	-	24-RKT-15251A	\$1,094.92	-	-					
3.750	24	4.00	-	-	-	24-RKT-15401A	\$1,550.55	-	-						

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Alum A319 6061-T6  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## HARD JAWS- 2 STEP



- Designed for first operation roughing, expect standard runout between 0.005-0.010
- Reversible-suitable for OD & ID workholding.
- XTRA BITE -very aggressive bite. Has conical teeth for extra gripping power and ground body to provide improved runout.
- GRIP-RITE-OEM Style hard jaws have ground tips and provide better runout.
- SHARK JAWS have conical teeth for extra gripping power and black oxide for long life. Ideal for castings and scaly material. Made in the USA.
- Bison hard jaws feature enhanced serrations on gripping surfaces
- 1 & 2 step jaws available.

Group Number	Chuck Size	Critical Dimensions											Part Number	Price Per Set	Style	Code
		Groove Width G	Screw Size E	Hole Space D	Width C	OAL B	Height A	No. of Holes	No. of Steps	Top Step Ht S1	Mid Step Ht S2	Bot Step Ht S3				
K1-26-43 B-215 N18, N15	15 & 18	1.005 (25.5mm)	20mm	1.690	2.500	5.400	3.000	3	2	0.730	0.730	1.540	KT-151HJ2	\$701.09	Shark Jaws	D
				1.693 (43mm)	2.448	5.850	3.385	3	2	0.827	0.827	1.731	KT-151HJ2-U	\$538.65	OEM Style	E
				2.500	5.500	3.500	3	2	0.950	0.950	1.600	KT-151HJ2-X	\$554.85	XTRA-BITE	E	

## DENIM SHOP APRONS



- 100% blue cotton denim
- "5" version includes 2 large waist pockets, 2 big pencil pockets and 1 long waist pocket
- One size fits all
- 35" length x 28" wide

Description	Part Number	Price
Denim w/ 5 Pockets	SHOP-APRON-5	\$14.99



## VENTURE II® SAFETY GLASSES



- Nose buds secure the glass and prevent slipping while providing a pillow soft fit
- Temples adjust to four different lengths
- Lenses are coated for superior scratch resistance
- Lenses provide 99% protection against harmful UV rays
- Exceeds ANSI Z87.1-2003 standards

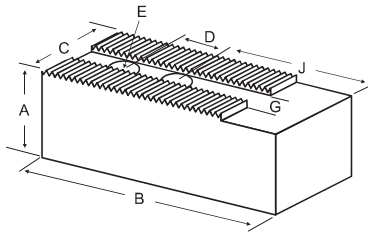
Frame Color	Lens Color	Part Number	Price Each
Black	Clear	PYR-SB1810S	\$4.39
	Gray	PYR-SB1820S	\$4.99
	Blue	PYR-SB1860S	\$4.99

Call Us Today For All Of Your Machine Tool Needs!

# SOFT JAWS- 1.5 mm x 60° Serrations

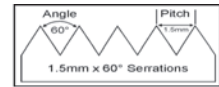
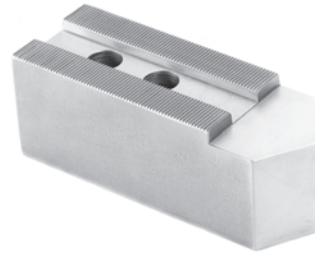
TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



• Max. length of serrations: 5.75"

- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum, Steel & Aircraft Aluminum (where noted)



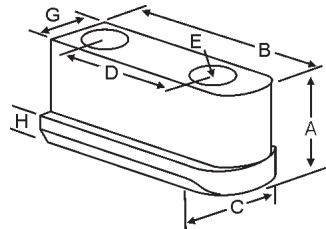
Group  
**(K1)**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

Group No.	Chuck Size	Critical Dimensions								ALUMINUM		STEEL		
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	Industry Reference #	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3	
<b>K1-26-43</b> KITAGAWA B215, N15, N18 BB-218	15 & UP	1.005 (25.5mm)	20mm	1.690 (43mm)	2.500	3.437	2.500	6.500	HR-115-2.5	KT-15251AF	\$112.54	KT-15251F	\$122.68	
					2.500	3.437	2.500	6.500	-	-	KT-15251BF	\$161.41		
					2.500	4.437	2.500	7.500	HR-115-2.5-O or OP	KT-15256AF	\$121.30	KT-15256F	\$132.52	
					3.000	3.437	2.500	6.500	-	-	KT-15301AF	\$137.79	KT-15301F	\$150.97
					3.500	3.410	2.500	6.500	HR-115-3.5	KT-15351-34AF	\$144.82	KT-15351-34F	\$157.68	
					3.500	4.410	2.500	7.500	HR-115-3.5-O or OP	KT-15351-44AF	\$155.95	KT-15351-44F	\$169.36	
					4.000	3.437	2.500	6.500	-	-	KT-15401AF	\$148.35	KT-15401F	\$179.98
					4.000	4.437	2.500	7.500	-	-	KT-15406AF	\$161.31	KT-15406F	\$189.85
					5.000	3.437	2.500	6.500	HR-115-5.0	KT-15501AF	\$241.45	KT-15501F	\$223.31	
					5.000	4.410	2.500	7.500	HR-115-5.0-O or OP	KT-15501-44AF	\$279.60	KT-15501-44F	\$251.12	
				6.000	3.437	2.500	6.500	-	-	KT-15601AF	\$318.16	KT-15601F	\$364.66	

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: NK-14250AF will be NK-14250AP. Pointed Jaws add \$7.00.  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



**USST**

Chuck Make & Model	Chuck Size	Critical Dimensions					2 Screws Included With Each Jaw Nut						
		Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	Jaw Nut Part Number	Price Each	Screw Part Number	Price Each	
Kitagawa: B-215	15	0.758	1.003 (25.5mm)	M20-2.50x50mm	1.690 (43mm)	1.550	1.375	3.149	KT-151JN	\$54.83	M2025050	\$3.25	

## LATHE TOOLHOLDER BUSHINGS



- FEATURES:**
- Increased step diameter for easy and perfect sealing.
  - Concentric ground and diamond polished OD & ID resulting in a mirror smooth finish.
  - "Easy Entry" feature on OD for quick insertion
  - Wrench flats for easy removal
  - Step relief for easy removal and gripping on Z style bushings
  - Type and size clearly marked on surface of head diameter for easy identification
  - 100% Satisfaction Guaranteed

Please See Pages 114-118 For More Information!



**Bush Rite**

**SPECIFICATIONS:**  
Material: ALLOY STEEL 8620  
Hardness Data: Rc 55-57 for longer tool life  
Case Hardened and Ground Concentric OD & ID  
Axial Concentricity: OD & ID - 0.002"  
Tolerance: H6 & g6 in grinding the OD & ID

Call Us Or Visit Our Website For Our Complete Selection!

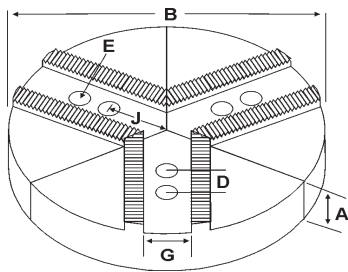
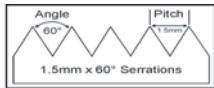
**2019-20 MASTER CATALOG**

**29**

LATHE CHUCKS  
LIVE CENTERS  
VISE JAWS  
VISE ACCESSORIES  
STRAIGHT SHANK  
COLLET HOLDERS  
TAP HOLDERS  
DRILL CHUCKS  
CARBIDE INSERTS  
THREADING/GROOVING  
CUTTING TOOLS  
MACHINERY  
PRECISION TOOLS  
DEBURRING  
COOLANT/FLUIDS  
TOOL STORAGE

# ROUND JAWS- 1.5 mm x 60° Serrations

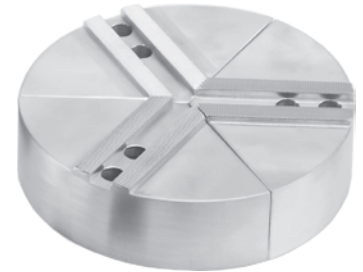
FOR USE ON: Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks



Group  
**(K1)**



- 1.5mm x 60° serrations
- Round Jaws allow for complete gripping of workpiece
- Oversized jaws available
- Ideal for thin-walled or irregular shaped workpieces.
- Can be machined to fit workpiece
- Max. length of serrations: 5.75"
- All jaws have 2 holes
- Special "J" dimensions available
- Available in Aluminum & Cast Iron
- Made in the USA



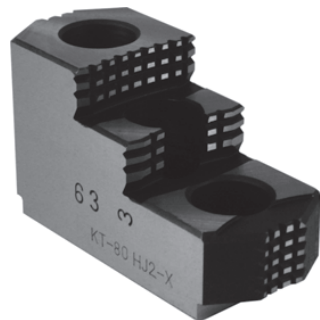
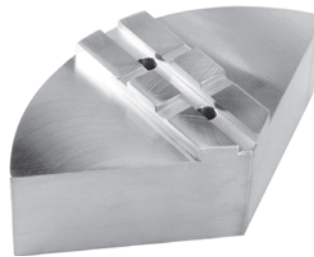
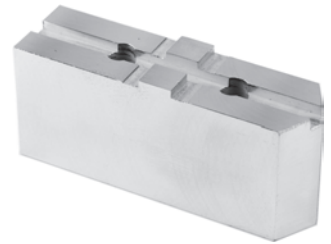
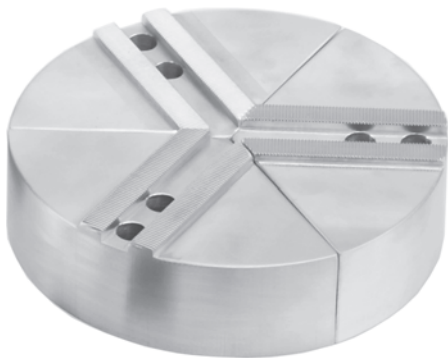
Group No.	Chuck Size	Critical Dimensions				Hole to Front J	Pie Dia B	Height Inch A	Industry Reference #	ALUMINUM		CAST IRON/STEEL	
		Groove Width G	Screw Size E	Hole Space D	Part Number					Price Set of 3	Part Number	Price Set of 3	
K1-22-60	15" & UP	0.866 (22mm)	20mm	2.360 (60mm)	3.750	15	2.50	-	RKT-15252A	\$494.11	RKT-15252CI	\$721.49	
					3.188	15	3.00	KTT15P-2.36	RKT-15302A2	\$516.17	-	-	
					3.750	15	4.00	-	RKT-15402A	\$607.05	-	-	
						18	2.50	-	18-RKT-15252A	\$630.49	-	-	
							4.00	-	18-RKT-15402A	\$851.69	-	-	
						21	4.00	-	21-RKT-15402A	\$1,135.76	-	-	
24	4.00	-	24-RKT-15402A	\$1,550.55	-	-							

Round Jaw Material: ALUMINUM-6061-T6 Bar Stock, CAST IRON-Gray, STEEL-1018. 18" & Larger- Alum A319 6061-T6  
For complete list of applicable chucks, see pages 542-554. \* denotes non-stock item. Please allow 1 week manufacturing time.

## SPECIAL ORDER JAWS AVAILABLE!

*Special Orders Are Our Specialty!*

Do you need a special dimension that is not listed in our catalog? No problem! We can supply you with customized chuck jaws to fit your specifications. Whether you need a special height, width, diameter or step height, call us for all of your customized workholding needs!



- Super Quick Turnaround Time- 3 Days Or Less In Most Cases!
- Special Order Round Jaws Up To 32" dia!
- Special Order Soft Jaws Up To 8" Height!
- Soft Jaws Available In Any Length-Steel Or Aluminum
- Tongue And Groove, Square Serrated & Acme Serrated Jaws Up To 8" Height!
- Made Per Your Special Specifications In The USA! Please See Our Special Order Forms On Pages 555-560.



*Please Call Today For A Quote!*

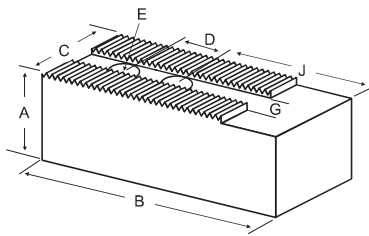
Call Us Today For All Of Your Machine Tool Needs!



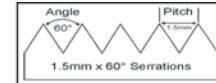
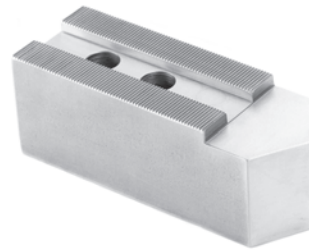
# SOFT JAWS- 1.5 mm x 60° Serrations

TABLE OF CONTENTS

FOR USE ON: **Kitagawa®, Samchully®, Strong®, MMK, SMW Autoblok, Howa & Hitachi-Seiki Chucks**



- 1.5mm x 60° serrations
- Supplies maximum concentricity on finish turning operations
- Can be bored or turned to fit workpiece
- Steel jaws can be hardened
- Available flat ended or pointed for smaller diameter parts
- Special orders available
- Available in Aluminum & Steel
- **Made in the USA**



Group  
**(K1)**

**QUANTITY DISCOUNTS!**  
Order **5 SETS OR MORE** of the same part number soft jaw and receive a **5% DISCOUNT!**

• Max. length of serrations: 5.75"

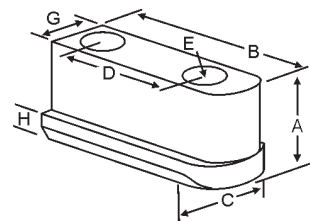
Group No.	Chuck Size	Critical Dimensions				ALUMINUM					STEEL		
		Groove Width G	Screw Size E	Hole Space D	Hght Inch A	Hole to Front J	Width Inch C	Length Inch B	No. of Holes	FLAT END Part Number	Price Set Of 3	FLAT END Part Number	Price Set Of 3
K1-21-45	14 or 16	0.827 (21mm)	16mm	1.771 (45mm)	2.500	2.980	2.000	6.250	2	NK-14250AF*	\$73.96	NK-14250F*	\$76.52
						3.980	2.000	7.250	2	NK-14257AF*	\$85.82	NK-14257F*	\$87.43
					3.500	2.980	2.000	6.250	2	NK-14350AF*	\$103.58	NK-14350F*	\$92.46
						3.980	2.000	7.250	2	NK-14357AF*	\$120.06	NK-14357F*	\$105.64
K1-22-60	15 & Up	0.866 (22mm)	20mm	2.360 (60mm)	2.500	2.750	2.500	6.500	2	KT-15252AF	\$112.54	KT-15252F	\$119.21
						3.750	2.500	7.500	2	KT-15257AF	\$121.30	KT-15257F	\$132.89
					3.000	2.750	2.500	6.500	2	KT-15302AF	\$130.20	KT-15302F	\$142.17
						2.750	2.500	6.500	2	KT-15402AF	\$148.14	KT-15402F	\$161.48
					4.000	3.750	2.500	7.500	2	KT-15407AF	\$161.10	KT-15407F	\$174.85
						6.000	2.750	2.500	6.500	2	KT-15602AF	\$317.95	KT-15602F
K1-26-38	16	1.003 (25.5mm)	20mm	1.496 (38mm)	2.500	2.940	2.500	5.500	2	AB-16250AF*	\$95.24	AB-16250F*	\$103.80
					3.500	2.940	2.500	5.500	2	AB-16350AF*	\$133.35	AB-16350F*	\$145.34
					5.000	2.940	2.500	5.500	2	AB-16500AF*	\$190.48	AB-16500F*	\$172.03
					2.500	3.940	2.500	6.500	2	AB-16257AF*	\$112.54	AB-16257F*	\$122.68
					3.500	3.940	2.500	6.500	2	AB-16357AF*	\$157.56	AB-16357F*	\$171.77
					5.000	3.940	2.500	6.500	2	AB-16507AF*	\$225.11	AB-16507F*	\$203.31

For "Pointed" Soft Jaws, please substitute "P" for "F" in the part number. Example: NK-14250AF will be NK-14250AP. Pointed Jaws add \$7.00.  
Soft Jaw Material: ALUMINUM-6061-T6 Bar Stock, STEEL-1018, "B" JAWS-7075-T6 Aircraft Aluminum  
For complete list of applicable chucks, see pages 542-554.\* denotes non-stock item. Please allow 1 week manufacturing time.

## JAW NUTS & SCREWS



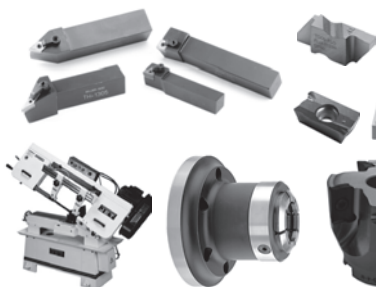
MADE IN THE USA



USST

Chuck Make & Model	Chuck Size	Heel Height H	Groove Width G	Screw Size Pitch & Length E	Hole Space D	Hght Inch A	Width Inch C	Length Inch B	2 Screws Included With Each Jaw Nut			
									Jaw Nut Part Number	Price Each	Screw Part Number	Price Each
-	15	0.649	0.864 (22mm)	M20-2.50x55mm	1.690 (43mm)	1.790	1.318	3.149	KT-150JN	\$56.83	M2025055	\$3.25
-	15	0.649	0.864 (22mm)	M20-2.50x55mm	2.360 (60mm)	1.798	1.320	3.820	KT-152JN	\$53.87	M2025055	\$3.25
UVE-800LB	24	0.414	0.985	M20-2.50x50mm	3.152	1.241	1.418	4.728	KT-241JN	\$75.08	M2025050	\$3.25
HJ-24, HJA11-24	24	0.748	0.985	M20-2.50x50mm	3.152	2.127	1.576	4.728	KT-242JN	\$75.08	M2025050	\$3.25

## WE'VE GOT THE ITEMS YOU NEED!



- Chuck Jaws
- Lathe & Collet Chucks
- Lathe Tooling
- Machine Vises
- Milling Toolholders
- ER, TG & DA Collets
- Carbide Inserts
- Drills, Taps & Reamers
- Threading & Grooving
- Indexable Cutting Tools
- Abrasives
- Cutting Fluids
- Measuring Tools
- MRO & Safety



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2019-20 MASTER CATALOG

LATHE CHUCKS  
LIVE CENTERS

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WISE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

CUTTING TOOLS  
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PRECISION TOOLS  
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TOOL STORAGE