

Chuck Stop Sets

Standard & Deluxe



- The Royal Chuck Stop provides a simple, consistent method for locating short parts in a 3-jaw lathe chuck
- Captive, web-shaped design eliminates the danger of using spacers or parallels that could come loose and be thrown from a spinning chuck
- Three strong magnets further secure the stop to the chuck face
- Stop allows short parts to project past the chuck jaws, providing clearance for facing operations
- Setup time is greatly reduced - no need to bore soft jaws
- Very accurate - front and back locating surfaces are parallel within $\pm 0.0004"$
- Slot width can be easily enlarged to accommodate wider chuck jaws
- Anodized finish provides good wear-resistance



Description	Code
3-Piece Standard Set - 15, 20 and 25mm stops	355985
5-Piece Deluxe Set - 15, 20, 25, 30 and 35mm stops	355986

Tool Posts, Turrets, Holders & Bushings

40-Position Tool Posts



REPEATABILITY: Guaranteed repeatability of index accuracy is 0.01mm and remains unchanged even after innumerable tool changes

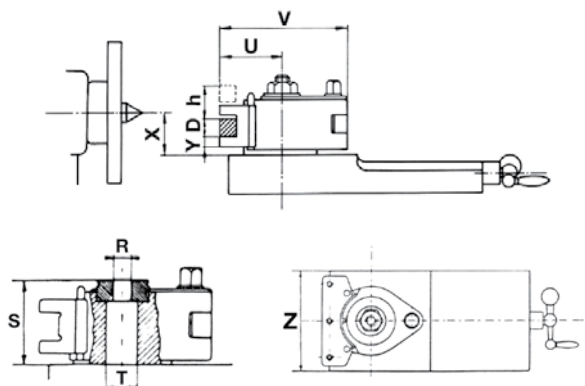
TECHNICAL DATA: When determining the size, the following is important:

1. Driving motor power
2. Center height from carriage "X"
3. Length of tool holder "lg" should possibly correspond to width "z" of top slide
4. Height of tool "D", which together with height "y" and the space that remains underneath makes up the necessary size "X" (See table)

Example for choice of size: Driving power of machine – 6 KW. Width of carriage "Z", 145 mm, then use tool holder turret "B" and tool holders BD 25120. BD 25140, BD 32140 with BH 32130 and BJ 40120

Minimum dimension "X" required for height of tool "D"

Type GS-	Aa	A		E			B		C		D1		D2				
Toolholder D	12	16	20	16	20	25	25	32	32	40	45	40	50	63	50	65	
Tool Height D	X Minimum																
6	12																
8	14	17															
10	16	19	19	19	19	22											
12	18	21	21	21	21	24	25	26									
14		23	23	23	23	26	27	28	29								
16		25	25	25	25	28	29	30	31	31							
20						29	32	33	34	35	35	38					
25							37	38	39	40	40	43	45				
30									44	45	45	48	50	51	52	50	55
32										47	47	50	52	53	54	52	57
40											55	58	60	61	62	60	65
50														71	72	70	75
63															85	88	



Hole "R" in the centring disc must be enlarged up to the size of the clamping screw

Original Wechselfix		Aa	A		E			B		C		D1		D2			
Driving Power	KW	1	2	2	4.5	4.5	4.5	7	7	13	13	13	20	20	28	28	
Change Toolholder Size	D	12	16	20	16	20	25	25	32	32	40	45	40	50	63	50	65
Width of Carriage Max.	Z mm	80	100	100	120	120	120	150	150	180	180	180	200	200	200	250	250
Center Height from Carriage Max.	X mm	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D	Y+D
Center Height from Carriage Max.	X mm	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h	X+h
Change Toolholder Size	h mm	8	11	11	16	11	6	20	11	40	35	30	35	30	20	20	30
Tool Repose	Y mm	6	8.5	8.5	8.5	8.5	12	12	13.5	15	15	18	20	20	20	20	25
Maximum Height of Tool	D mm	12	16	20	16	20	25	25	32	32	40	45	40	50	63	50	65
Total Width	V mm	70	100	100	125	125	125	150	150	200	200	200	230	234	242	275	282
Total Height	S mm	37	56	56	68	68	68	79	79	110	110	110	122	122	122	135	135
Maximum Throat	U mm	30	48	48	60	60	60	71	71	190	190	190	112	116	124	140	147
Boring Diameter	T mm	13	19.5	19.5	19.5	19.5	19.5	31.5	31.5	39.5	39.5	39.5	40	40	40	79	79