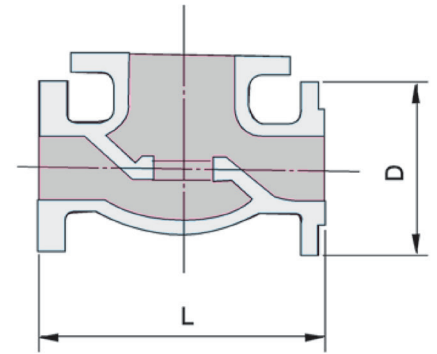


Automatic Indexing chuck with hydraulic clamping and indexing



Identify which chuck suits your work piece

Part No.	WORK PIECE SIZE	
	∅ D (mm)	L (mm)
KSR-225	60	100
KSR-250	65	160
KSR-275	80	220
KSR-315	100	230
KSR-350	135	240
KSR-400	170	260
KSR-500	220	310
KSR-890	400	500



When should I use an indexing chuck?

You can fully automate the machining of work pieces with right angle axis or with 45°, 60° or 120° axis to significantly increase your productivity and reduce your takt time.

Which indexing chuck for my work piece?

Apart from the work piece dimensions identified above many other considerations are required to identify the correct indexing chuck such as overhang of the work piece from the chuck face, clamping force, clamping piston stroke and the work cycle. Therefore full consultation with our experienced technicians is required during the decision process.

Hardened and ground body

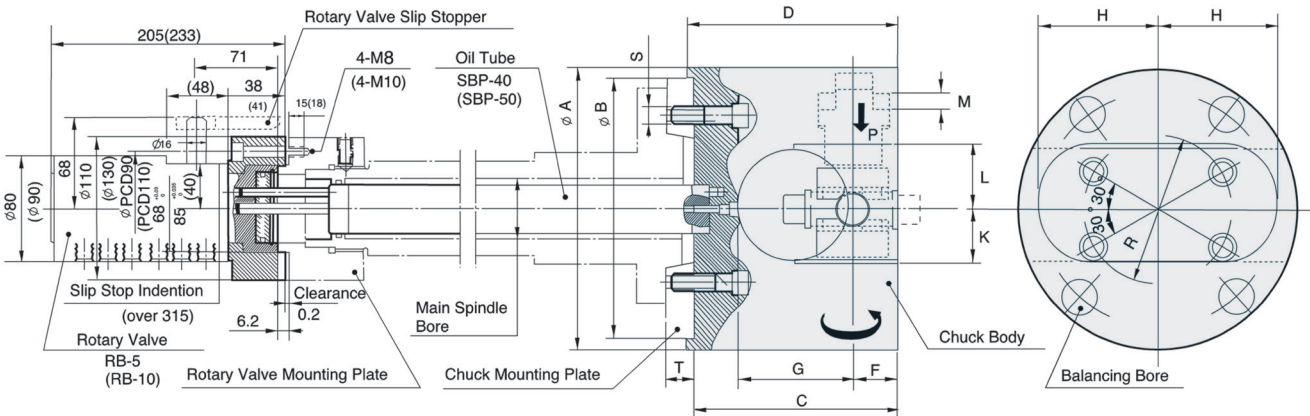
To ensure excellent rigidity and accuracy and complement the design to avoid deformation.

High chip removal rates

High rotation speed and rigity of the chuck allows for fast and deep cutting of the workpiece.

Problem Free Installation

This chuck will require an adaptor to be installed on your machine therefore simply specify which ASA or JIS Spindle nose your machine has and we will provide the correct adaptor to suit.

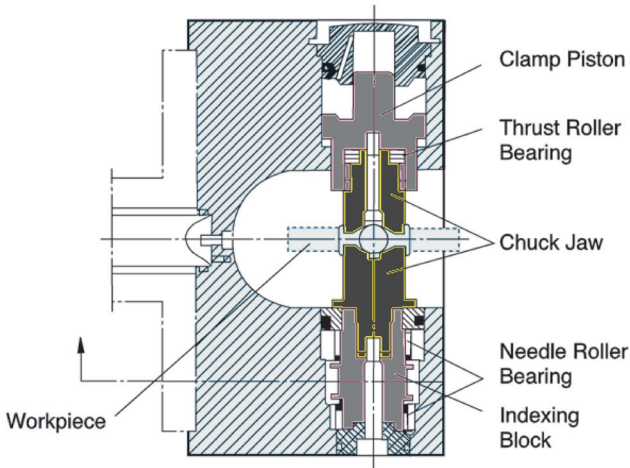


Specifications and Dimensions

Part No.	A	B	C	D	F	G	H	K	L	M	R	S	T	Gripping force kN (kgf)	Moment of Inertia kg.m ²	Lathe Spindle Dia	Lathe Spindle (hole)
KSR-225	225	185	149	154	35	84	95	46	58	11.5	133.4	4-M12	25	12.45 (1270)	0.9	80~100	Over 45
KSR-250	250	210	185	190	40	113	106	46	55	20	133.4	4-M12	25	16.96 (1730)	1.7		
KSR-275	275	210	208	213	48	125	125	57	67	20.5	171.4	4-M16	25	25.00 (2550)	2.8	100~120	Over 55
KSR-315	315	235	227	232	50	136	136	70	58	22	171.4	4-M16	25	25.00 (2550)	5		
KSR-350	350	290	235	240	50	148	145	84	102	23	235	4-M20	30	25.00 (2550)	8	120~130	Over 55
KSR-400	400	290	253	259	60	160	165	100	114	30	235	4-M20	30	34.62 (3530)	15		
KSR-500	500	380	301	308	68	200	205	133	157	35	330.2	4-M24	35	45.80 (4670)	25.4	150~160	
KSR-890	890	380	484	500	105	345	345	210	225	42	330.2	4-M24	-28	62.76 (6400)	37.5	Over 300	Over 150

Automatic Indexing chuck

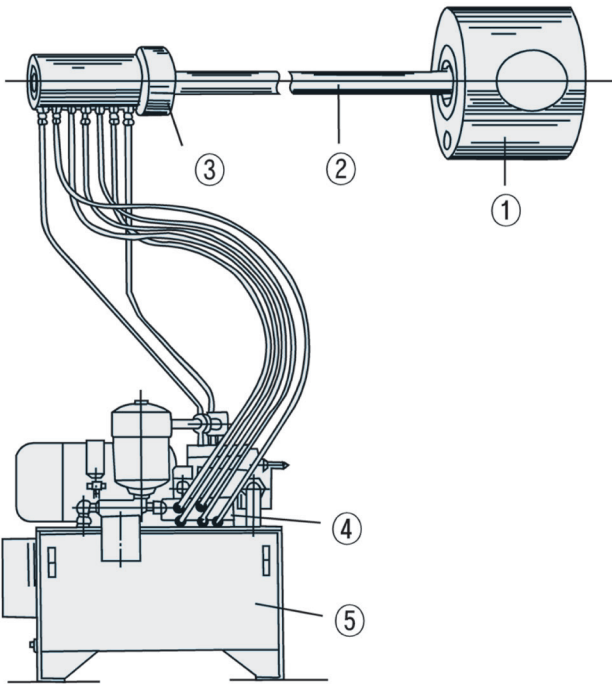
■ Configuration diagram of an automatic indexing chuck



× Clamping and indexing on the work are principally done by the piston movement of the hydraulic plunger within the chuck body.

× Clamping and indexing on the work are done by two different jaws. One jaw clamps by piston and the other indexes by square block and plunger.

■ Configuration diagram of an automatic indexing chucking system



- ① Chuck body
- ② Oil tube
- ③ Rotary valve
- ④ Checking switch
- ⑤ Hydraulic unit consisting of: tank, motor, pump, filter, accumulator, pressure gauge, oil level gauge, magnetic valve and manifold block.

× Auto indexing chuck consists of clamping and indexing functions

× Both clamping and indexing is powered by hydraulics

× Chuck rotates automatically 45°, 90°, 135° and 180° in 45° increments or 60°, 120°, 180° in 60° increments when the work piece is clamped by chuck.

× This chuck is generally used in NC lathe, horizontal, vertical and front turning lathe.

× It can also be used for general purpose lathe and increase the productivity by 5 to 10 times depending on the type of work.

■ Sample of a typical range of work pieces machined using an indexing chuck

