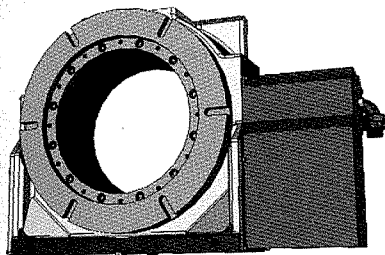


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which has a through-hole only half as large. A lower rotary table weight also means that heavier components can be machined without exceeding the maximum table load of the machine tool.

The centre height is 310mm, maximum rotational speed is 11.1rpm using a gear reduction ratio of 1/180, and indexing accuracy and repeatability are 20 and four seconds of arc respectively. The unit can be mounted vertically or horizontally with the maximum permissible component weights being 350kg and 700kg.

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Oil country expertise

**Workholding specialist
Leader Chuck Systems has
announced an extensive
range of oil country chucks
from Polish workholding
manufacturer Bison-Bial.**

The Tamworth-based company is responsible for the sale of Bison's extensive cost-effective product range in the UK, which includes pre-sales technical support and stockholding of popular items and spare parts at its dedicated logistics facility in Leamington Spa.

The high quality oil country chucks are suited to the oil, gas and petrochemical industry sectors for customers with demanding workholding applications and an extensive range of large through-hole products provides a solution for any manufacturer turning long, large diameter parts.

Mark Jones, Leader Chuck Systems' managing director, expands: "Heavy-duty oil country chucks are designed as an addition to the Bison chuck range. They are dedicated to finishing, medium-duty and heavy-duty machining applications and are available to suit most spindle mount designs. The most popular sizes are stocked in our warehouse."

Like all chucks from Bison, the oil country chucks are made

from forged steel or cast iron and all of the working surfaces are induction hardened and ground to ensure that the finished product is rugged and meets high sliding, stability and durability parameters.

All of the three jaw, self-centring chucks can work individually or in pairs, mounted on opposite sides of the lathe spindle, ensuring the same vertical position of the jaws in both chucks. This allows the accurate turning of very long components such as pipes.

The cast iron-bodied Type 3295 three jaw, self-centring chuck offers a large through-hole compared to its outside diameter. Available body sizes are 400mm, 500mm, 660mm and 800mm diameter with the ability to hold parts from 168mm up to 566mm diameter. Maximum operational speeds range from 500rpm down to 200rpm for the largest chuck.

Providing increased rigidity and greater wear resistance, the steel bodied Type 3597 provides higher gripping forces and can withstand increased machining forces. This allows the chuck to operate at between 2,500rpm and 700rpm for the 315mm and 800mm diameter chucks respectively, with the bore through ranging from 145mm to 460mm diameter.

Also employing a steel body, the extensive heavy-duty Type 3515 HD range supports through-hole, face and internal fixturing for all turning applications. Available in 400mm, 500mm, 630mm and 800mm diameters, the chucks can hold parts between 25mm and 800mm diameter. The gripping force ranges from 6,200daN for the smallest chuck up to 9,000daN for the largest. The maximum operating speeds are 1,400rpm and 600rpm respectively.

All of the heavy-duty four jaw independent chucks feature forged steel bodies and can work individually or in pairs, mounted on opposite sides of the lathe spindle and again, ensuring the same vertical position of the jaws in both chucks. This allows high gripping forces and the accurate turning of very long components such as pipes, flanges, valve bodies and long prismatic parts.

Available in an extensive range of sizes, the Type 4317 HD can hold parts between 45mm and 1,250mm diameter with a gripping force of up to 5,000daN per jaw. Through-hole sizes go from 136mm diameter for the 415mm diameter model up to 530mm diameter for the 1,000mm diameter version.

The Type 4347 HD provides a high precision workholding solution for manufacturers that require increased gripping accuracy to generate tight tolerance parts. Available as 415mm, 500mm or 710mm diameter models, the chucks can accurately hold parts between 45mm and 710mm diameter. The 1,000mm or 1,250mm diameter Type 4307 HD has a gripping range between 50mm and 1,250mm diameter and a 200mm diameter through-hole on both sizes.

Supplied as standard with hard master jaws, all chucks can be specified with soft or hard top jaws. Most models also feature reversible jaws to accommodate internal and external chucking operations. Mountings are available for standard or special spindles.

Each chuck is thoroughly inspected before the product leaves the factory, with checks for gripping force and runout to

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