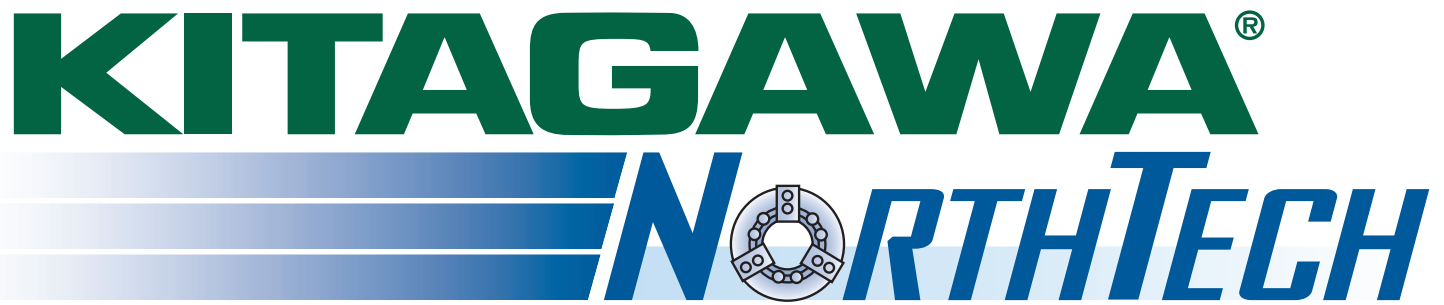
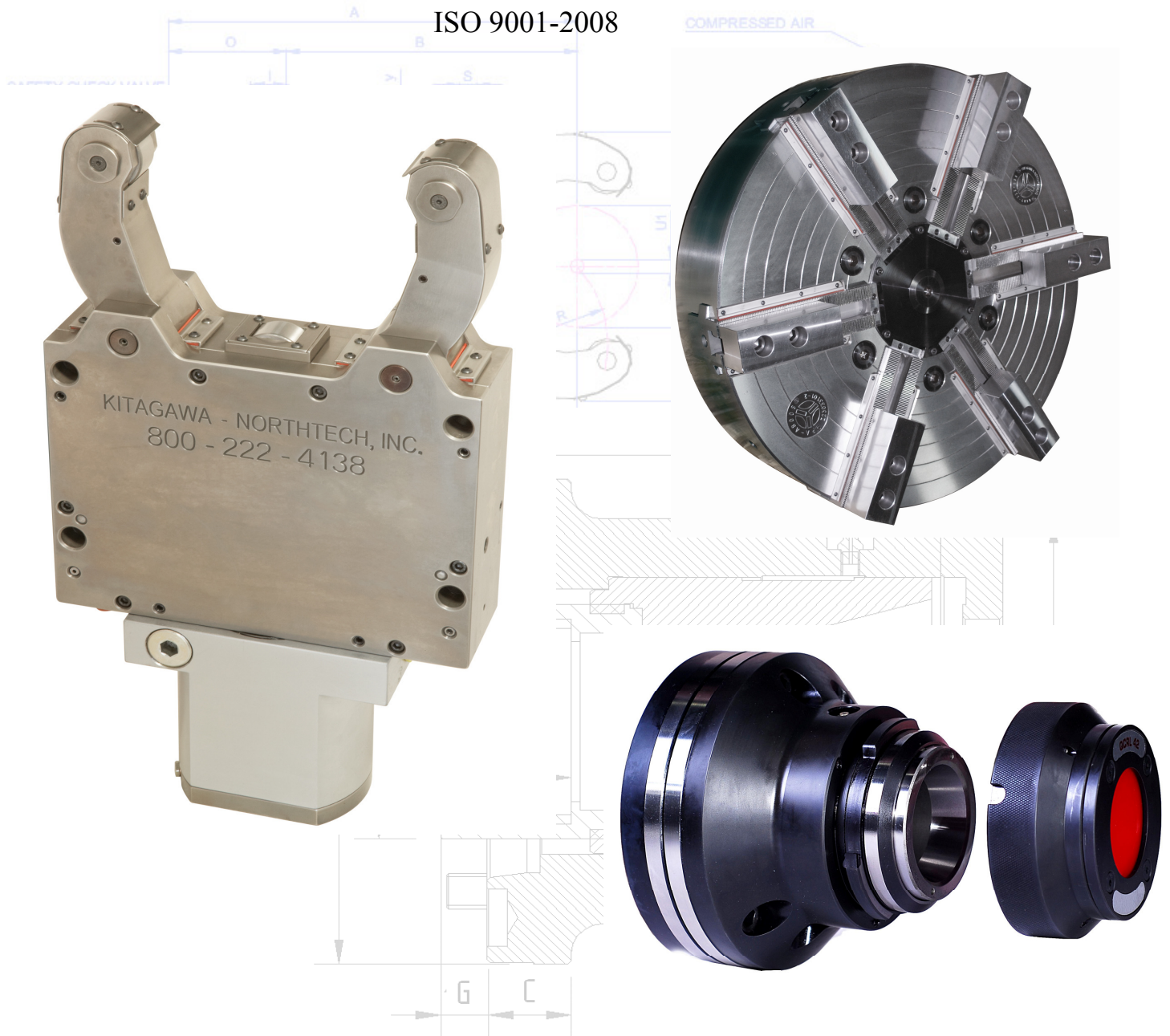




THE MOST TRUSTED NAME IN WORKHOLDING

Collet Chucks, Steady Rests and Large Chucks



800-222-4138

WWW.KITAGAWA.COM

Steady Rests

FRU : Standard steady rest with grip range of 4 mm to 530 mm.	Page 4
--	---------------

FRUA : Standard steady rest with grip range of 4 mm to 460 mm. Extra opening top arm for vertical loading.	Page 5
---	---------------

FRUB : Steady rest with grip range of 12 mm to 630 mm. Side mounted cylinder for compact space.	Page 6
--	---------------

FRUAB : Steady rest with grip range of 12 mm to 630 mm. Side mounted cylinder for compact space. Extra Opening top arm for vertical loading.	Page 7
---	---------------

KRHS : Steady rest for crank shaft machining.	Page 8
--	---------------

KRSHS : Steady rest with side mounted actuator for crank shaft Machining.	Page 9
--	---------------

VLHS : Steady rest with extra wide opening top arm for vertical loading.	Page 10
---	----------------

CS : Compact steady rest to fit smaller machines.	Page 11
--	----------------

Heavy Duty : Steady rest for heavy components up to 40 tonnes.	Page 12
---	----------------

Collet Chucks

CRS : Short series collet chucks.	Page 13
--	----------------

CRL : Long series collet chucks.	Page 14
---	----------------

QCRL : Quick change series collet chucks.	Page 15
--	----------------

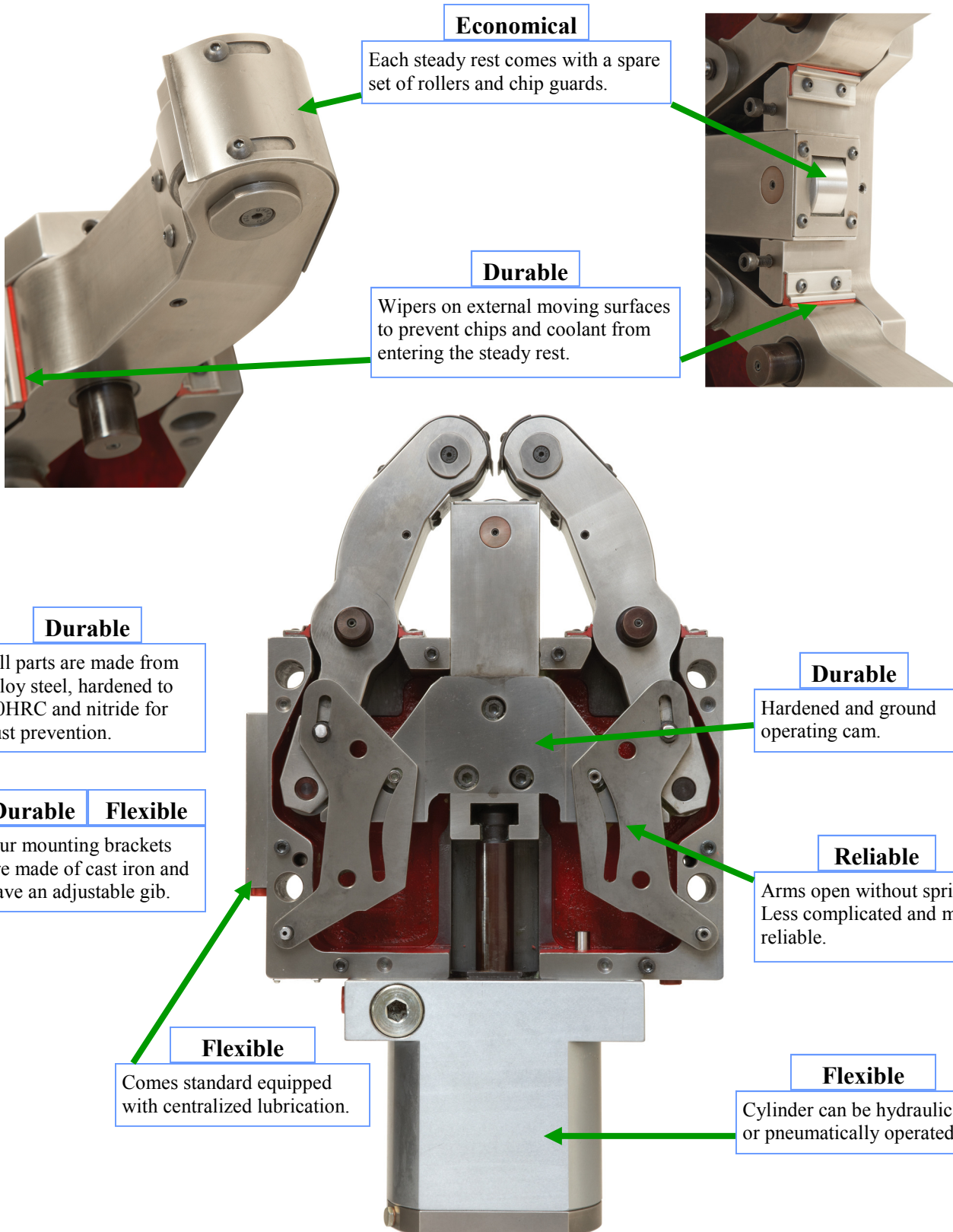
QCRL/S 66/80 : Quick change series collet chucks.	Page 16
--	----------------

Pull Back : 5C and 16C pull back series collet chucks.	Page 17
---	----------------

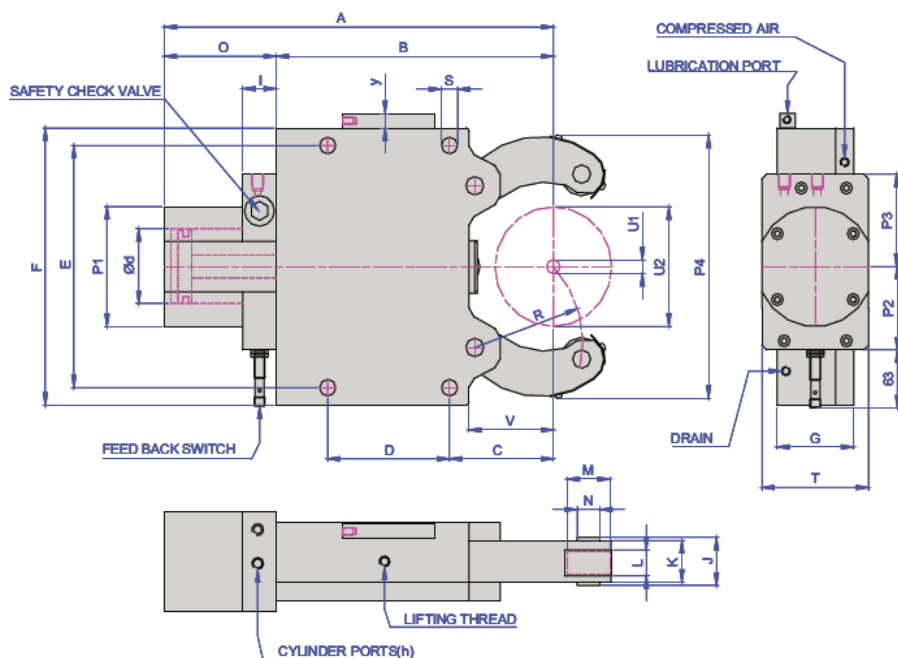
Large Chucks : 3, 4 and 6 jaw open center or closed center. Sizes up to 63"	Page 18
--	----------------

Steady Rest Features

More For Your Money



STEADY REST MODEL: FRU



This series is for all standard applications. Available with clamp ranges from 4 mm to 1100 mm. Can be mounted to flat or slant bed lathes. We can supply mounting brackets to meet your needs.

All our steady rests come with a spare set of rollers and spare chip guard.

STANDARD FEATURES

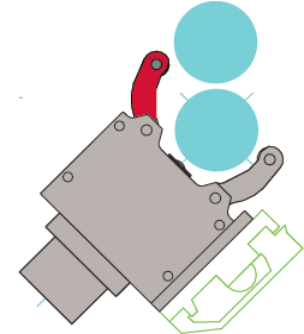
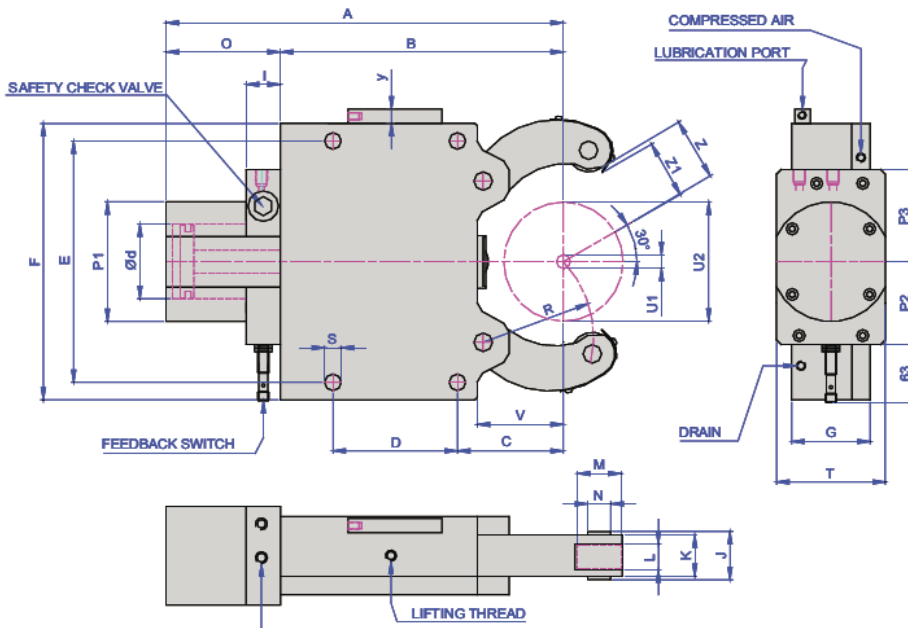
- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

Steady Rest Type	FRU1	FRU2	FRU3	FRU3.1	FRU3.2	FRU4	FRU5	FRU5.1	FRU6	FRU7
A	222	299	457	465	486	624	710	746.5	980	1240
B	137	195	308	316	332	437	500	530	709	900
C	51	70	115	123	138	146	178	198	215	320
D	64	85	135	135	135	240	270	270	330	440
E	118	170	262	262	262	365	400	400	610/640	650
F	132	205	290	290	290	400	450	450	705	710
G	55	70	85	85	85	110	145	145	145	162
I	15	33	37	37	37	37	37	37	37	60
J	33	42	52	52	52	67	83	83	83	94
K	25	35	45	45	45	60	75	75	75	82
L	12	19	25	25	25	25	29	29	29	32
M	19	35	47	47	47	52	62	62	80	100
N	10	21	25	25	25	32	36	36	42	55
O	71.5	104	149	149	154	187	210	216.5	271	340
P1	82.5	102	137	137	137	165	165	165	200	238
P2	27.5	72	90	90	90	102	102	102	120	143
P3	55	75	94	94	94	110	110	110	135	158
P4	119	190	285	280	323	425	478	512	680	820
R	51.5	75	119	124	139	172	209	229	290	398
S	11	14	18	18	18	23	23	23	27	27
T	49	70	102	102	102	126	144	144	258	190
V	42.5	60	92	99	103	128	160	180	175	283
Y		19	19	19	19	19	19	19	19	19
Centering range without chip guard	U1	4	8	12	20	30	45	85	125	200
	U2	64	101	152	165	245	310	350	460	530
Centering range with 3 piece chip guard	U1	11	16	16	20	30	45	85	125	200
	U2	64	101	152	165	245	310	350	460	530
Cylinder bore	d	30	50	80	80	80	100	100	100	130
Hydraulic connection (BSP)	h	1/4"	1/4"	1/4"	1/4"	3/8"	3/8"	3/8"	3/8"	3/8"
Operating pressure min(max)	bar	6(50)	8(60)	8(60)	8(60)	8(60)	8(80)	8(80)	8(70)	6(70)
Max clamp force/roller	daN	100	350	1000	1000	1000	1500	2000	2000	4000
Clamping pressure/roller at 15 bar	daN	35	100	250	250	500	500	500	500	900
Centering accuracy over entire clamping range	mm	0.02	0.02	0.04	0.04	0.04	0.05	0.06	0.06	0.08
Repeatability	mm	0.01	0.01	0.01	0.007	0.007	0.01	0.01	0.01	0.02
Max peripheral speed	m/min	850	950	800	800	725	725	670	670	570
Approx weight	kg	7	18.5	48	48	50	104	155	155	430



STEADY REST MODEL: FRUA

This series is made for applications where vertical loading is required e.g. using a gantry loader.



Steady Rest Type



STANDARD FEATURES

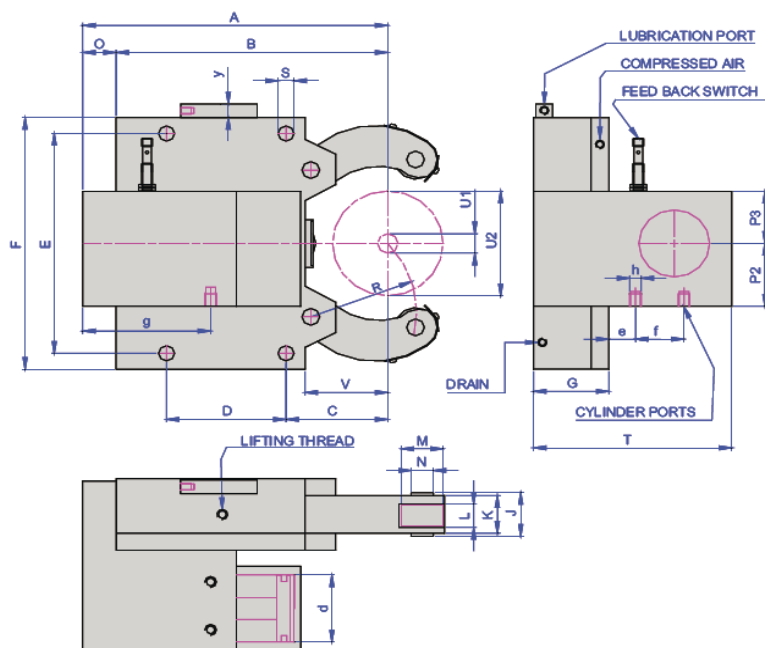
- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

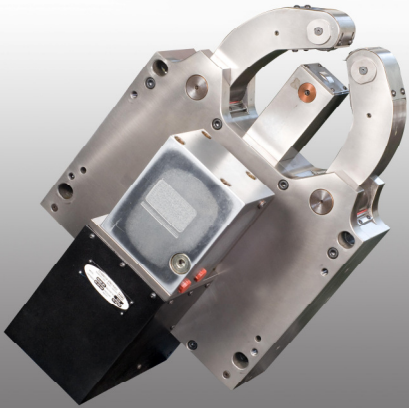
		FRUA 1	FRUA 2	FRUA 3	FRUA 3.1	FRUA 4	FRUA 5	FRUA 6
A		208.5	299	457	465	624	686	980
B		137	195	308	316	437	500	709
C		51	70	115	123	146	178	215
D		64	85	135	135	240	270	330
E		118	170	262	262	365	400	610/640
F		132	205	290	290	400	450	705
G		55	70	85	85	110	145	145
I		15	33	37	37	37	37	37
J		33	42	52	52	67	83	83
K		25	35	45	45	60	75	75
L		12	19	25	25	25	29	29
M		19	35	47	47	52	62	80
N		10	21	25	25	32	40	42
O		71.5	104	149	149	187	186	271
P1		82.5	102	137	137	165	168	200
P2		27.5	72	90	90	102	94	120
P3		55	75	94	94	110	118	135
R		51.5	75	119	124	172	209	290
S		11	14	18	18	23	23	27
T		49	70	102	102	126	144	158
V		42.5	60	92	99	128	160	175
Y			19	19	19	19	20	19
U1		4	8	12	20	30	48	160
U2		52	80	130	150	220	268	460**
U1		11	16	20	20	30	48	160
U2		52	80	130	150	220	268	460**
Z		26.5	41	66	76	111	135	230**
Z1		24	34	62	72	106	130	225**
Cylinder bore	d	30	50	80	80	100	100	130
Hydraulic connection (BSP)	h	1/4"	1/4"	1/4"	1/4"	3/8"	3/8"	3/8"
Operating pressure min(max)	bar	6(50)	8(60)	8(60)	8(60)	8(60)	8(60)	8(70)
Max clamp force/roller	daN	100	350	1000	1000	1500	2000	3000
Clamping pressure/roller at 15 bar	daN	35	100	250	250	500	500	670
Centering accuracy over entire clamping range	mm	0.02	0.02	0.04	0.04	0.05	0.06	0.06
Repeatability	mm	0.005	0.005	0.007	0.007	0.007	0.01	0.01
Max peripheral speed	m/min	850	950	800	800	725	670	525
Approx weight	kg	7	18.5	48	48	104	160	430

** Angle of inclination is 19 degree instead of 30 degree

STEADY REST MODEL: FRUB

This series is made for machines where the rear mounted cylinder may interfere with the sheet metal. The side mounted cylinder makes for a more compact steady rest.



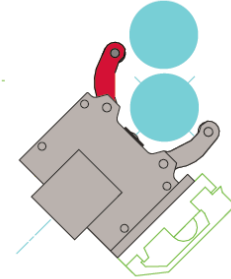
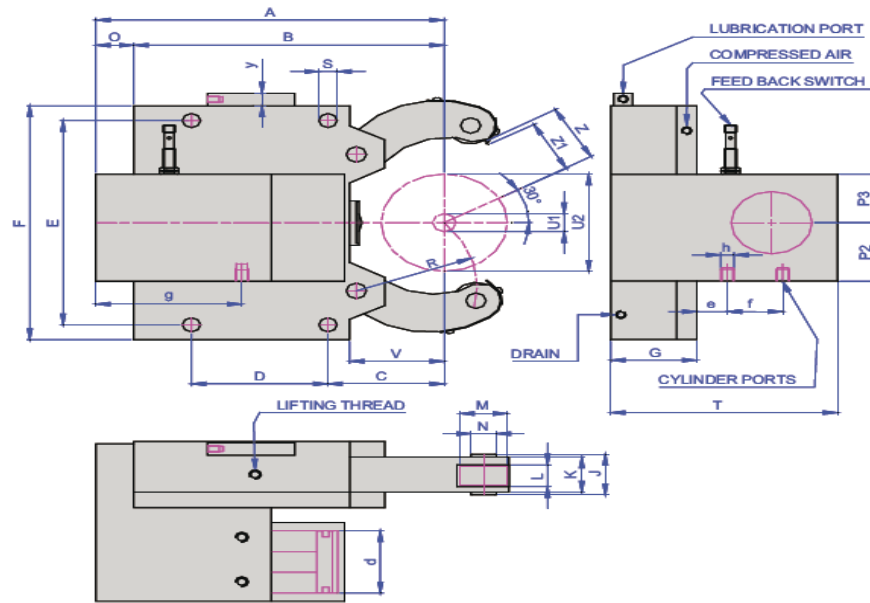
Steady Rest Type		FRUB 3	FRUB 3.1	FRUB 4	FRUB 5	FRUB 6	FRUB 7	FRUB 8
	A	346	356	480	624	810	1001	1130
	B	308	316	437	500	709	897.5	1020
	C	115	123	146	178	215	320	375
	D	135	135	240	270	330	440	500
	E	262	262	365	400	610/640	650	855
	F	290	290	400	450	705	710	930
	G	85	85	110	145	145	180	190
	J	52	52	67	83	83	112	110
	K	45	45	60	75	75	100	100
	L	25	25	25	29	29	32	32
	M	47	47	52	62	80	100	100
	N	25	25	32	36	42	55	60
	O	40	40	43	124	101	103.5	110
	P2	75	75	85	85	135	130	130
	P3	58	58	68	85	115	130	130
	R	119	124	172	209	290	398	402
	S	18	18	23	23	27	27	35
	T	198	198	244	325	350	405	487
	V	92	99	128	160	175	283	290
	Y	19	19	19	19	19	19	27
	U1	12	20	30	45	125	200	230
	U2	152	165	245	310	460	530	630
Centering range without chip guard	U1	16	20	30	45	125	200	230
Centering range with 3 piece chip guard	U1	16	20	30	45	125	200	230
	U2	152	165	245	310	460	530	630
Cylinder bore	d	80	80	100	100	130	150	150
	e	58	58	68	85	55	191	191
	f	27	27	39	40	50	50	50
	g	180	180	220	270	430	450	450
	h	1/4"	1/4"	3/8"	3/8"	3/8"	3/8"	3/8"
Hydraulic connection (BSP)	h	1/4"	1/4"	3/8"	3/8"	3/8"	3/8"	3/8"
Operating pressure min(max)	bar	8(60)	8(60)	8(60)	8(80)	8(70)	8(70)	8(70)
Max clamp force/roller	daN	1000	1000	1500	2000	3000	4000	4000
Clamping pressure/roller at 15 bar	daN	250	250	400	400	600	880	880
Centering accuracy over entire clamping range	mm	0.04	0.04	0.05	0.06	0.06	0.08	0.08
Repeatability	mm	0.0007	0.0007	0.0007	0.01	0.01	0.02	0.02
Max peripheral speed	m/min	800	800	720	650	525	570	570
Approx weight	kg	53	53	115	190	500	1000	1300

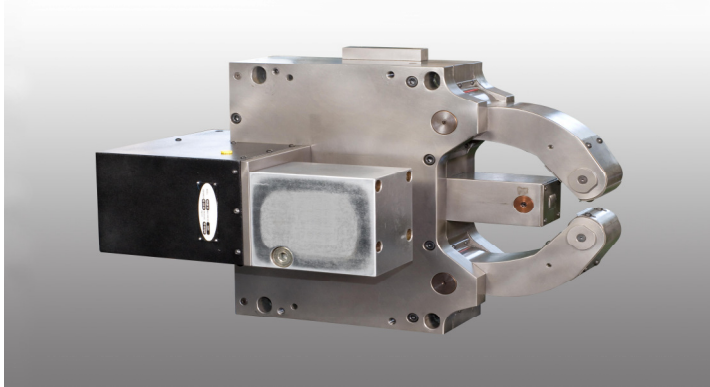
STANDARD FEATURES

- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

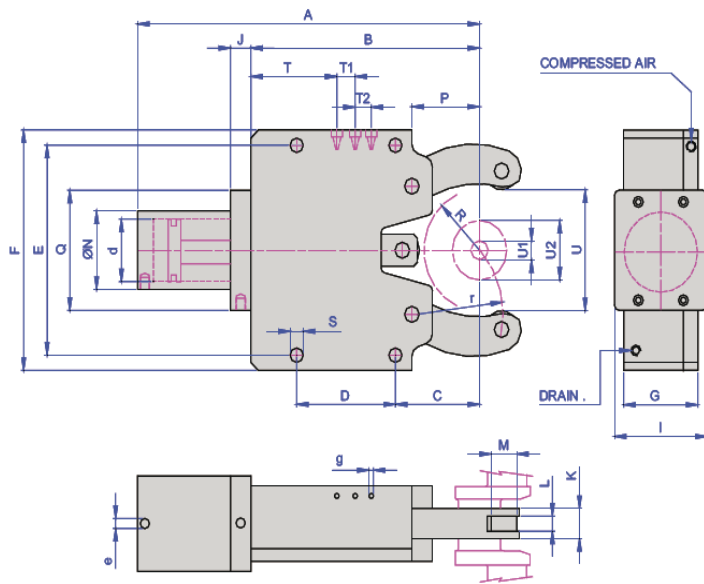
STEADY REST MODEL: FRUAB

Steady rest with side mounted actuating cylinder and extra wide opening top arm.



Steady Rest Type		FRUAB 3	FRUAB 3.1	FRUAB 4	FRUAB 5	FRUAB 6
 STANDARD FEATURES • Safety valve • Provision for max. opening feedback • Spare set of chip guards • Spare set of rollers • Automatic lubrication • Compressed air connection	A	346	356	480	624	810
	B	308	316	437	500	709
	C	115	123	146	178	215
	D	135	135	240	270	330
	E	262	262	365	400	610/640
	F	290	290	400	450	705
	G	85	85	110	145	145
	J	52	52	67	83	83
	K	45	45	60	75	75
	L	25	25	25	29	29
	M	47	47	52	62	80
	N	25	25	32	36	42
	O	40	40	43	124	101
	P2	75	75	85	85	135
	P3	58	58	68	85	115
	R	119	124	172	209	290
	S	18	18	23	23	27
	T	198	198	244	325	350
	V	92	99	128	160	175
	Y	19	19	19	19	19
Centering range without chip guard	U1	12	20	30	50	160
	U2	130	150	220	268	460
Centering range with 3 piece chip guard	U1	20	20	30	50	160
	U2	130	150	220	268	460
	Z	66	76	111	135	230
	Z1	62	72	106.5	130	225
Cylinder bore	d	80	80	100	100	130
	e	58	58	68	85	55
	f	27	27	39	40	50
	g	180	180	220	270	430
Hydraulic connection (BSP)	h	1/4"	1/4"	3/8"	3/8"	3/8"
Operating pressure min(max)	bar	8(60)	8(60)	8(60)	8(80)	8(70)
Max clamp force/roller	daN	1000	1000	1500	2000	3000
Clamping pressure/roller at 15 bar	daN	250	250	400	400	660
Centering accuracy over entire clamping range	mm	0.04	0.04	0.05	0.06	0.06
Repeatability	mm	0.007	0.007	0.007	0.01	0.01
Max peripheral speed	m/min	800	800	720	650	525
Approx weight	kg	55	55	115	190	500

STEADY REST MODEL: KRHS



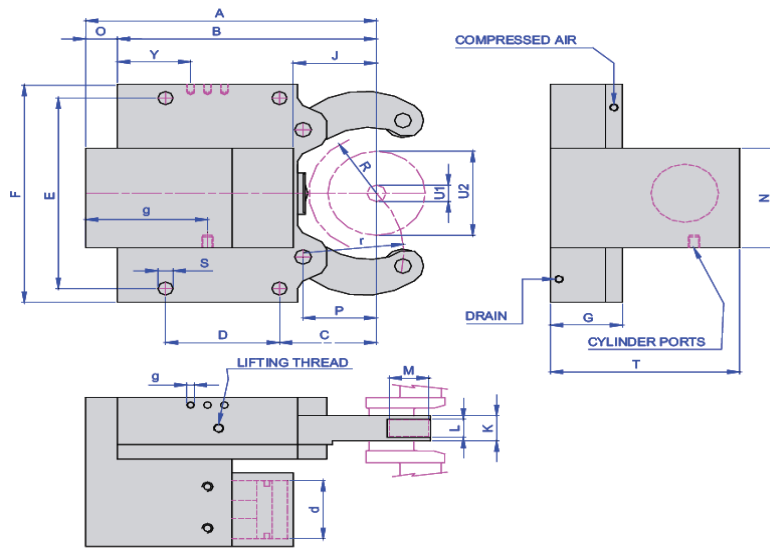
Model KRHS is a steady rest designed for crank shaft machining. Kitagawa-NorthTech can supply a full range of steady rests for crank shaft applications from automotive to heavy railway and marine.

STANDARD FEATURES

- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

Steady Rest Type		KRHS315P	KRHS520D	KRHS528C	KRHS930	KRHS839
	A	503	621	731	710	861
	B	331	442	515	500	619
	C	138	180	178	178	233
	D	135	210	270	270	270
	E	266	330	400	400	400
	F	300	370	450	450	450
	G	80	67	102	145	145
	I	100	118	102	144	145
	J	31	40	40	40	40
	K	22	26	32	40	38
	L	14	16	20	20	20
	M	35	40	62	62	62
	N (dia)	137	132	147	147	147
	P	108	160	160	160	215
	Q	161	196	186	186	186
	r	139	187.5	209	209	250
	S	18	20	23	23	23
	T	113	170	183	163	227
	T1	25	27	32	32	23
	T2	25	27	32	32	23
Clamping range without chip guard	U1	40	45	70	90	80
	U2	85	100	150	300	190
Max. axial opening	U	220	236	322	303	402
Clamping range with 3 piece chip guard	U1	40	45	70	90	80
	U2	85	100	150	300	190
Max. axial opening	U	220	236	322	303	380
Eccentric throw	R	110	120	155	150	195
Cylinder bore	d	80	80	80	80	80
Hydraulic connection (BSP)	e	1/4"	1/4"	1/4"	3/8"	3/8"
Lubrication ports	g	M8X1	M8X1	M10X1	M10X2	M10X3
Standard operating pressure	bar	5-30	5-40	5-55	5-55	5-55
Max. operating pressure	bar	35	45	60	60	60
Max clamp force/roller	daN	500	1000	1400	1400	1400
Clamping pressure/roller at 6 bar	daN	100	100	100	100	100
Centering accuracy over entire clamping range	mm	0.04	0.05	0.05	0.05	0.05
Repeatability	mm	0.01	0.01	0.01	0.01	0.01
Max peripheral speed	m/min	500	525	350	350	350
Max peripheral speed at half max. clamping pressure	m/min	850	865	850	850	850
Approx weight	kg	50	70	150	185	190

STEADY REST MODEL: KRSHS



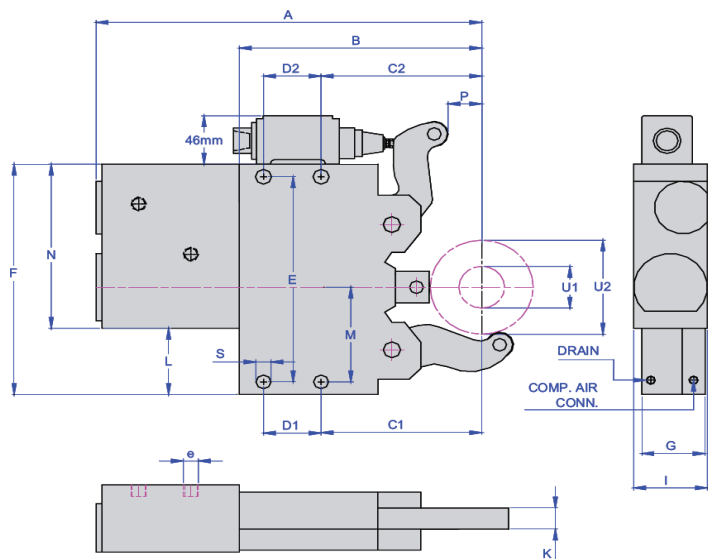
Specially designed for crank shaft machining with a space saving side mounted cylinder

STANDARD FEATURES

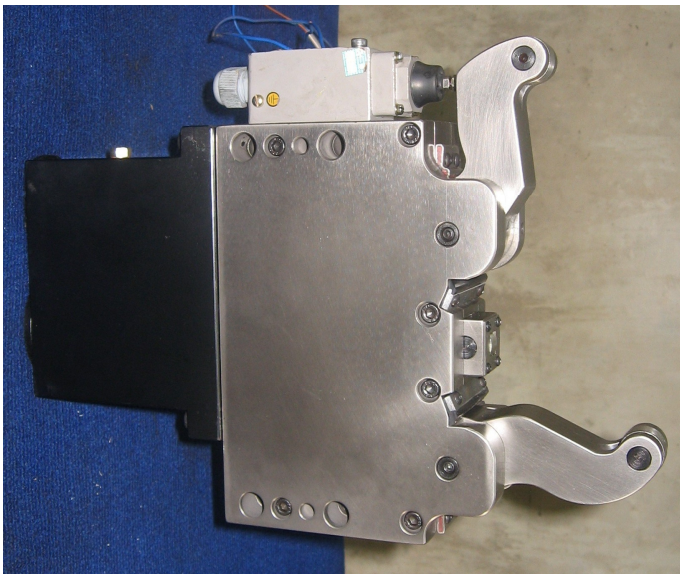
- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

Steady Rest Type		KRSHS 315D	KRSHS 315H	KRSHS 510	KRSHS 521
	A	355	367	334	340
	B	332	363	296	340
	C	138	170	103	133
	D	135	135	135	135
	E	266	266	266	288
	F	300	300	300	315
	G	80	85	82	89
	J	108	135	83	110
	K	22	45	22	28
	L	14	18	14	18
	M	35	47	35	47
	N	130	130	130	139
	O	24	4	38	0
	P	108	140	73	110
	r	139.5	174	115	144
	S	M20 X 2.5	18	M20 X 2.5	M20 X 2.5
	T	220	211	206	224
	Y	113	113	113	133
Clamping range without chip guard	U1	40	70	45	50
	U2	70	150	110	100
Max. axial opening	U	216	170	160	211
Clamping range with chip guard	U1	40	70	45	50
	U2	70	150	110	100
Max. axial opening	U	216	170	160	211
Eccentric throw	R	108	85	75	105
Cylinder bore	d	50	80	50	80
Hydraulic connection (BSP)	e	1/4"	1/4"	1/4"	1/4"
Lubrication ports	g	M8X1	M8X2	M8X3	M8X4
Standard operating pressure	bar	5 - 30	5 - 30	5 - 30	5 - 30
Max. operating pressure	bar	35	35	35	35
Max clamp force/roller	daN	500	520	240	520
Clamping pressure/roller at 6 bar	daN	39	100	39	100
Centering accuracy over entire clamping range	mm	0.04	0.04	0.04	0.04
Repeatability	mm	0.01	0.01	0.01	0.01
Max peripheral speed	m/min	500	450	500	450
Max peripheral speed at half max. clamping pressure	m/min	850	825	950	825
Approx weight	kg	50	50	40	55

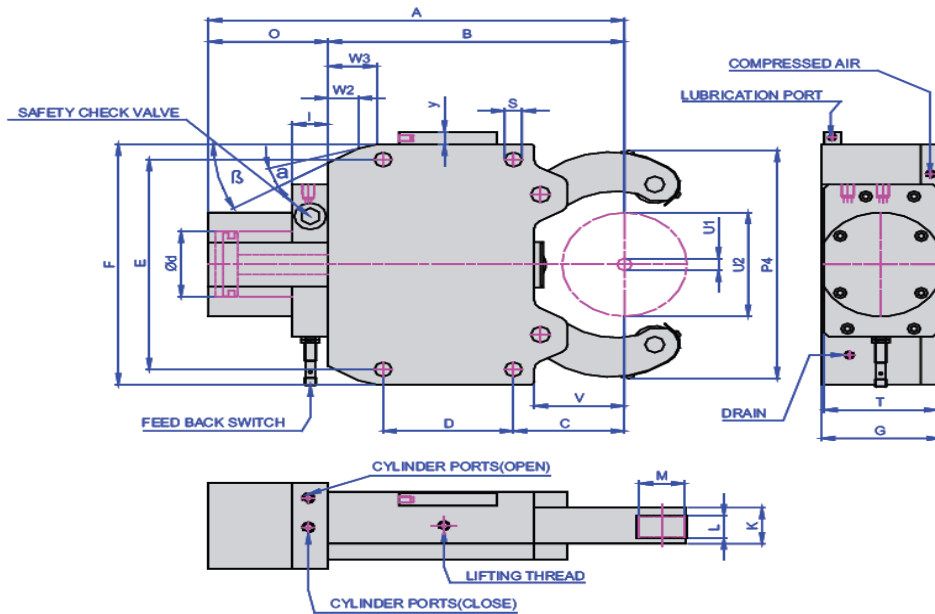
STEADY REST MODEL: VLHS



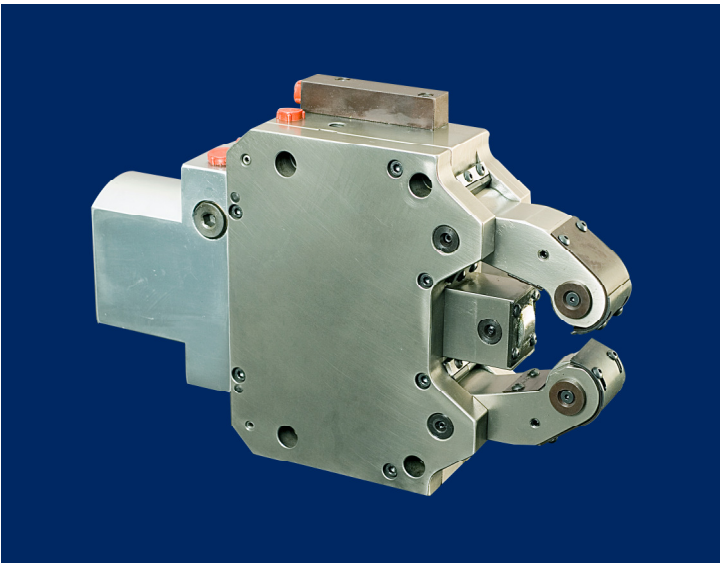
Steady rest with extra wide opening top arm for vertical loading.

Steady Rest Type			VLHS 480	VLHS 480A	VLHS 7513
		A	335	335	420
		B	207	207	291
		C1	139.5	139.5	155
		C2	139.5	139.5	200
		D1	50	50	105
		D2	50	50	60
		E	195	195	305
		F	219	219	340
		G	65	65	90
		I	74	74	90
		K	30	30	45
		L	102	102	152.5
		M	90	90	135
		N	140	140	209
		P	29	22	70
	S	13	13	18	
Centering Ranges	U1	40	15	75	
	U2	80	67	130	
Cylinder bore	d	50	50	50	
Hydraulic connection (BSP)	e	1/4"	1/4"	1/4"	
Standard operating pressure	bar	8 - 20	8 - 20	8 - 30	
Max. operating pressure	bar	25	25	35	
Max clamp force/roller	daN	150	150	200	
Clamping pressure/roller at 6 bar	daN	40	40	40	
Centering accuracy over entire clamping range	mm	0.02	0.02	0.02	
Repeatability	mm	0.005	0.005	0.005	

STEADY REST MODEL: CS



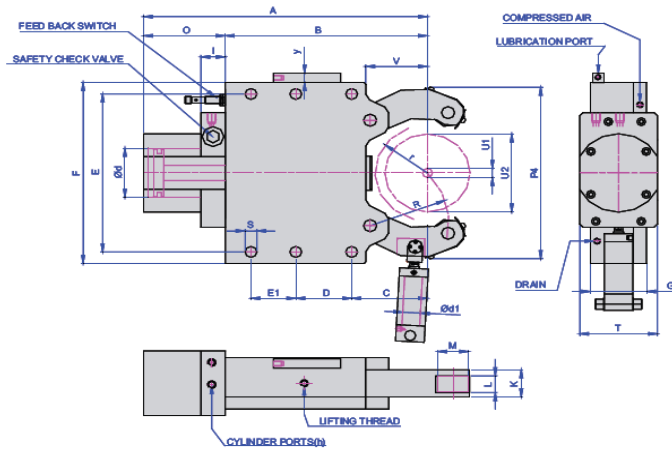
Compact steady rest to fit smaller machines.

Steady Rest Type		CS4	CS5.1
	A	609	812
	B	450	622
	C	168	240
	D	180	240
	E	360	445
	F	400	485
	G	125	150
	I	45	40
	K	60	75
	L	25	29
	M	52	62
	O	159	190
	P4	468	632.5
	R	200	283.5
	S	23	23
	T	111	121
	V	146	215
	Y	20	20
	W1	100	135
	W2	62	56
Centering Range with chip guard	B<	30	30
	a<	15	15
	U1	60	100
Cylinder bore	U2	280	410
	d	90	100
Hydraulic connection (BSP)	h	3/8"	3/8"
Operating pressure Min(Max)	bar	8(70)	8(80)
Max clamp force/roller	daN	1500	2000
Max. peripheral roller speed	m/min.	700	700
Centering accuracy over entire clamping range	mm	0.05	0.06
Repeatability	mm	0.007	0.01
Weight Approx.	kg	90	180

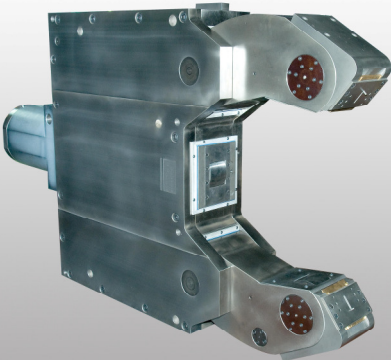
STANDARD FEATURES

- Safety valve
- Provision for max. opening feedback
- Spare set of chip guards
- Spare set of rollers
- Automatic lubrication
- Compressed air connection

STEADY REST MODEL: HEAVY DUTY



Heavy duty steady rest for component weight from 10 to 40 tones.

Steady Rest Type		HL80130	HS1060SAL	KRHS1540
Application		Standard Turning		Crank Shaft
	A	2266	1600	1505
	B	1760	1105	1176.5
	C	680	358	462.5
	D	310	525	365
	E	1440	970	760
	E1	310		
	F	1500	1110	840
	G	306	296	150
	I	80	80	40
	K	186	186	75
	L	116	96	32
	M	186	200	110
	O	506	495	328.5
	P3	1700	1070	1122
	R	805	420	498
	r			400
	s	39	34	39
	T	276	276	132
	V	620	288	425.5
	Y	30	27	27
Centering Range with chip guard	U1	600	100	150
	U2	1050	520	400
Cylinder bore	d	200	200	100
	d1	200	80	80
Max. load capacity	daN	30,000	12,000	4000
Cylinder support of bottom arm	daN	20,000	7,000	1500
Min(Max) pressure for bottom arm	daN	25(80)	20(75)	15(40)
Hydraulic connection (BSP)	h	1/2"	1/2"	3/8"
Operating pressure Min(Max)	bar	15(80)	10(60)	8(115)
Max clamp force/roller	daN	8300	6500	8300
Clamp pressure/roller at 15 bar	daN	1200	1200	500
Max. peripheral roller speed	m/min.	200	200	550
Centering accuracy over entire clamping range	mm	0.08	0.06	0.04
Repeatability	mm	0.01	0.01	0.01
Weight Approx.	kg	3000	2200	750

Features:

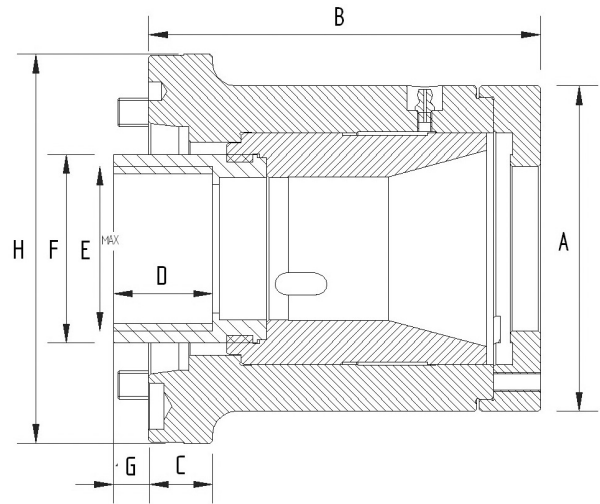
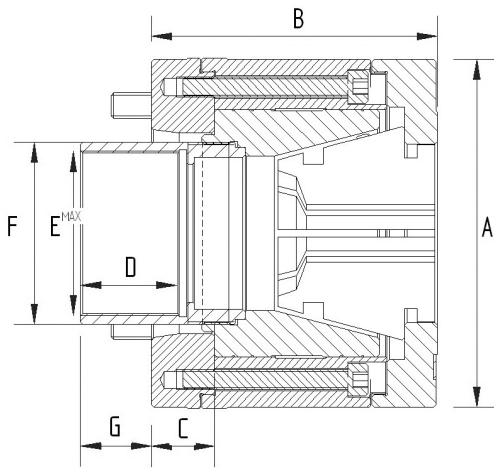
- Very heavy duty construction
- Large rollers that can handle 10-40 tones
- Hydraulic support of bottom arm for flat bed lathe use
- For use in turbine shafts, windmill shafts, and marine crank shafts

COLLET CHUCK MODEL: CRS



CRS Short Series Collet Chucks

- Ultra compact chuck design for first operations
- Ideally suited for use with bar feeders
- Short length maximizes lathe work envelope
- Bolt on cap
- Uses vari-bore type collets only. CRS 36 also accepts spring collets
- Large capacity in small diameter and short length



SPECIFICATIONS	CRS 36	CRS 54A5	CRS 66	CRS 66A6	CRS 66A8
Gripping Range mm	3 - 36	3 - 54	4 - 66	4 - 66	4 - 66
Collet Increment mm	2	3	3	3	3
Sleeve Stroke mm	7	10	10	10	10
Max Drawbar Pull kN	22	34	39	39	39
Max Gripping Force kN	49	60	68	68	68
Max Speed rpm	7000	6300	4500	4500	4500
Net Weight kg	8	10.5	19	24	18
Matching Cylinder	S1036	S1552/S1875	S1875	S1875	S1875
Varibore Collet Type	D671	D120	D285	D285	D285
Spring Collet	D171E	x	x	x	x

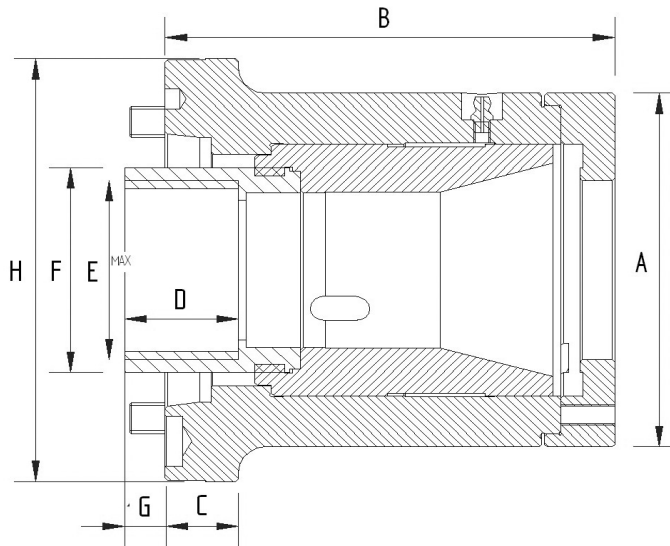
DIMENSIONS	CRS 36	CRS 54A5	CRS 66	CRS 66A6	CRS 66A8
Mount	115	A2-5	220	A2-6	A2-8
A	105	138	150	165	150
B	125	113	140	131	140
C	23	25	30	NA	30
D	18	38	66	66	66
E Max	M50 X 1.5	M65 X 1.5	M80 X 2	M80 X 2	M80 X 2
F	58	72	90	90	90
G Max	-6	28	22	29.5	21
G Min	-14	18	11	19.5	11
H	135	NA	230	166	210

COLLET CHUCK MODEL: CRL



CRL Long Series Collet Chucks

- Fixed length for all second operations
- Compact design for minimum overhang
- Interchangeable with Kitagawa B200 series power chucks
- High concentric accuracy
- Supplied complete with blank connector for threading to match drawtube
- All parts made of alloy steel hardened and precision ground



SPECIFICATIONS	CRL42	CRL42A5	CRL42A6	CRL54A6	CRL60	CRL60A6	CRL60A8
Gripping Range mm	1.6 - 42	1.6 - 42	1.6 - 42	1.6 - 54	1.6 - 60	1.6 - 60	1.6 - 60
Collet Increment mm	3	3	3	3	3	3	3
Sleeve Stroke mm	7	7	7	10	7	7	7
Max Drawbar Pull kN	25	25	25	30	30	30, 33.4	33.3
Max Gripping Force kN	55	55	55	60	60	60, 56.9	58.8
Max Speed rpm	7100	7100	7100	6300	6300	6300	6300
Net Weight kg	10	9.5	10.7	15	15.2	15	18.5
Matching Cylinder	S1246	S1246	S1246	S1552/S1875	S1552/S1875	S1552/S1875	S1552/S1875
Varibore Collet Type	D-673 (DIN6343)	D-673 (DIN6343)	D-673 (DIN6343)	D-120	D-677 (DIN6343)	D-677 (DIN6343)	D-677 (DIN6343)
Spring Collet Type	173E 4728	173E 4729	173E 4730	D853	D185E 4291	D185E 4292	D185E 4293

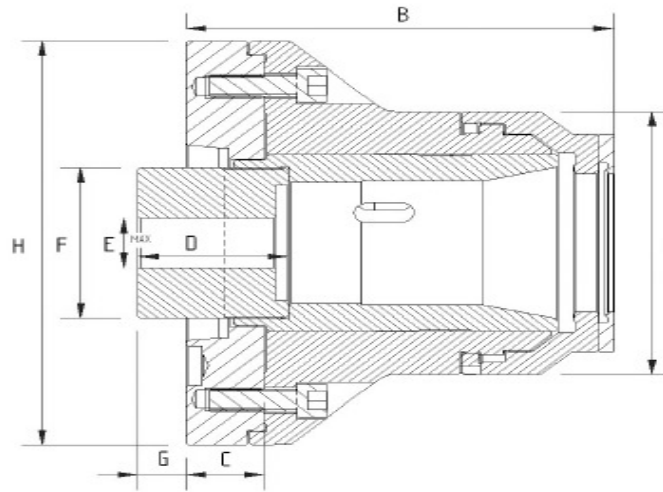
DIMENSIONS	CRL42	CRL42A5	CRL42A6	CRL54A6	CRL60	CRL60A6	CRL60A8
Mount	140	A2-5	A2-6	A2-6	170	A2-6	A2-8
A	110	110	110	138	138	138	138
B	133	143	145	160	148	160	156
C	20	20	30	27	24	27	36
D	30	30	30	25	30	30	30
E Max	M55 X 1.5	M55 X 1.5	M55 X 1.5	M70 X 1.5	M70 X 1.5	M70 X 1.5	M70 X 1.5
F	62	62	62	80	80	80	80
G Max	11	1	-1	-2	10	-2	2
G Min	4	-6	-8	-12	3	-9	-5
H	160	135	165	165	190	165	210

COLLET CHUCK MODEL: QCRL



Quick Change Series Collet Chucks

- Quick change design for 1st or 2nd operations
- Ideally suited for use with bar feeders
- Fixed length collet—no part movement
- Uses varibore, spring and master collets
- Exceptional accuracy in a small package



SPECIFICATIONS	QCRL42 INCH	QCRL42 DIN	QCRL 54 INCH	QCRL60 DIN
Gripping Range mm	1.6 - 42	4 - 42	1.6 - 54	4 - 60
Collet Increment mm	3	2	3	2
Sleeve Stroke mm	7	7	10	7
Max Drawbar Pull kN	22	22	34	34
Max Gripping Force kN	49	49	60	60
Max Speed rpm	7100	7100	6300	6300
Net Weight kg	13.5	13.5	29	29
Matching Cylinder	S1246	S1246	S1552/S1875	S1552/S1875
Varibore Collet Type	D-850	D-673	D-120	D-677
Spring Collet Type	D-286	D173E	D-853	D185E

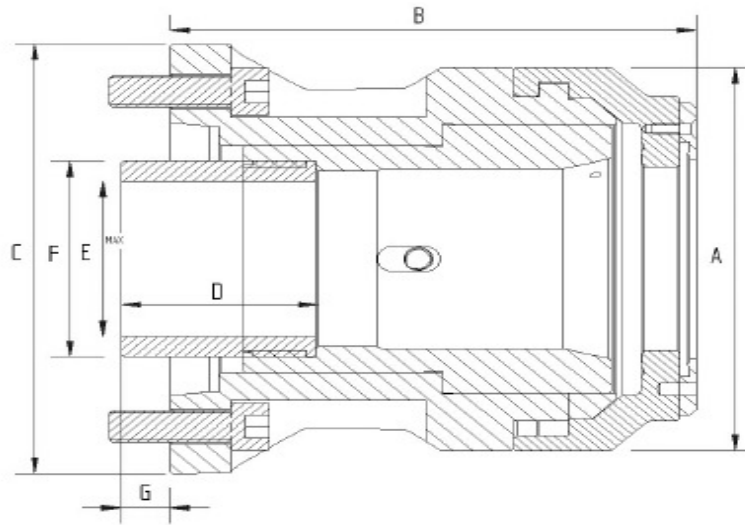
DIMENSIONS	QCRL42 INCH	QCRL42 DIN	QCRL 54 INCH	QCRL60 DIN
Mount	140 A5 A6	140 A5 A6	170 A5 A6 A8	170 A5 A6 A8
A	113	113	143	143
B	149 143 143	149 143 143	177 184 175 175	164.5 180 165 165
C	30 30 30	30 30 30	36.5 46.5 31.5 31.5	36.5 46.5 31.5 31.5
D	60	60	60	60
E Max	M58 X 1.5	M58 X 1.5	M75 X 1.5	M75 X 1.5
F	65	65	82	82
G Max	17 23 23	17 23 23	15 5 21 21	14 5 21 21
G Min	10 16 16	10 16 16	5 -5 11 11	7 -2 14 14
H	165	165	220	220

COLLET CHUCK
MODEL: QCRL/S 66/80



Quick Change Series Collet Chucks

- Quick change design for 1st or 2nd operations
- Ideally suited for use with bar feeders
- Fixed length collet—no part movement
- Uses varibore, spring and master collets
- Exceptional accuracy in a small package



SPECIFICATIONS	QCRS 66	QCRS 80	QCRL 80
Gripping Range mm	3 - 66	12 - 80	12 - 80
Collet Increment mm	3	3	3
Sleeve Stroke mm	10	12	12
Max Drawbar Pull kN	39	44	44
Max Gripping Force kN	68	78	78
Max Speed rpm	4500	4500	4500
Net Weight kg	24	29	37
Matching Cylinder	S1875	S2091	S2091
Varibore Collet Type	D-285	D-175	D-660
Spring Collet Type	x	x	D-193 E

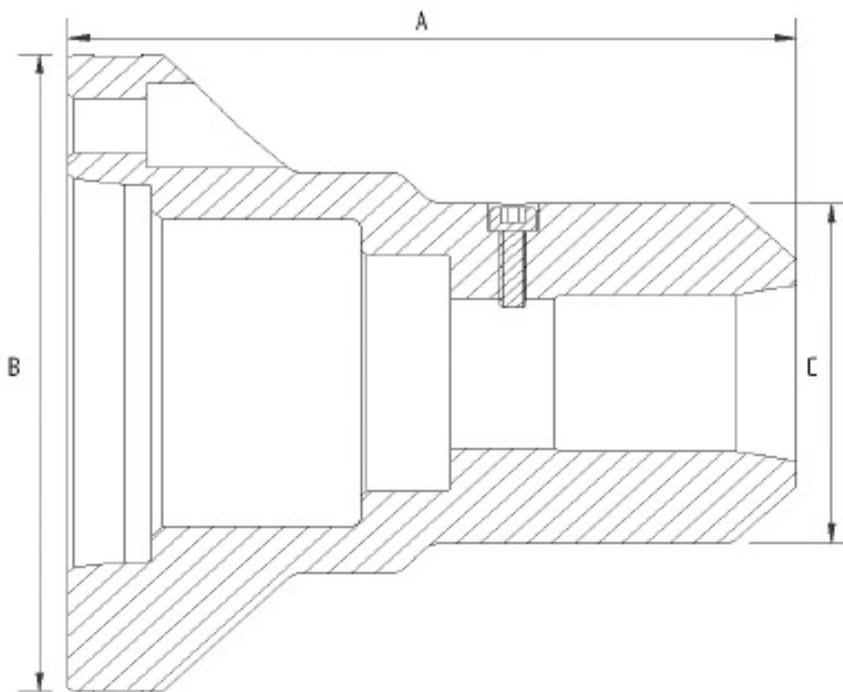
DIMENSIONS	QCRS 66	QCRS 80	QCRL 80
Mount	220 A8	A8	A8
A	162	196	196
B	158 152	168	210
C	230 220	220	220
D	80	80	80
E Max	M90 X 2	M90 X 2	M90 X 2
F	100	100	100
G Max	19 25	20	40
G Min	9 15	8	28

COLLET CHUCK MODEL: PULL BACK



Pull Back Series Collet Chucks

- Pull back design for 1st operation
- Use 5C & 16C collets
- Ejectors available
- Collet wrench included with chuck
- Exceptional accuracy in a small package



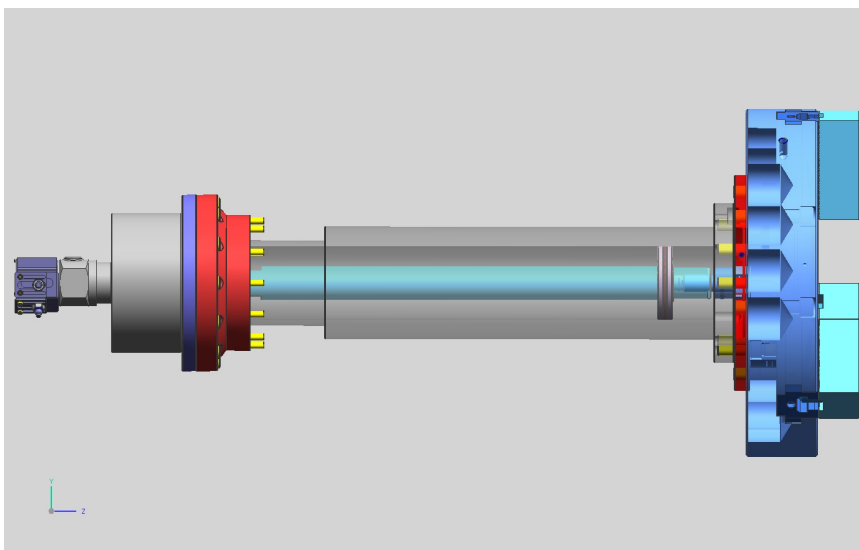
SPECIFICATIONS	DEL 5C	DEL 16C
Gripping Range mm	.5 - 27	.5 - 42
Pull Back Ratio	1 : 3	1 : 3
Max Drawbar Pull kN	20	24
Max Speed rpm	6000	6000
Net Weight kg	7, 11	6, 8
Coll Type	5C	16C

DIMENSIONS	DEL 5C	DEL 16C
Mount	A5 A6	A5 A6
A	138 148	152 160
B	135 165	135 165
C	72	85

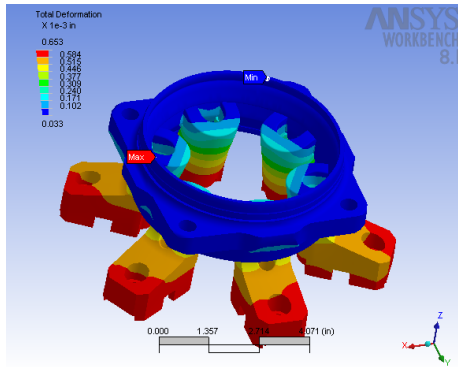


- Available in 3, 4 and 6 jaw configuration
- Sizes up to 63"
- Thru hole up to 230mm available
- Closed center with vertical mounting sealing provisions
- Custom configuration available

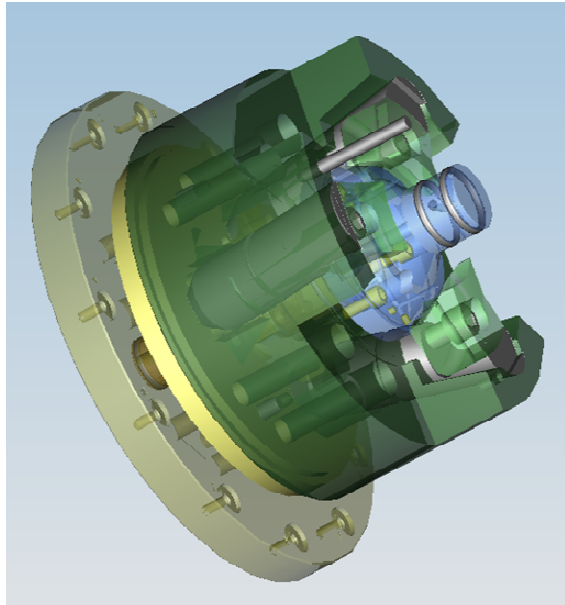
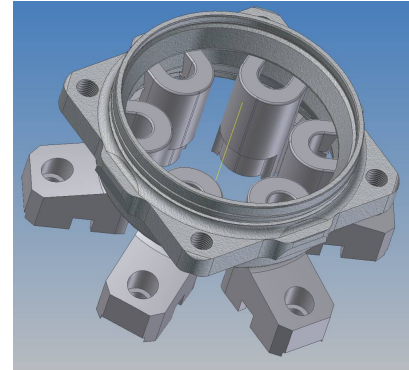
	Available
Sizes up to 63"	YES
Thru hole up to 230mm	YES
Closed center with vertical mount sealing	YES
3 Jaw available	YES
4 Jaw available	YES
6 Jaw available	YES
Custom configurations	YES
Installation available	YES



Your Engineered Solution Partner

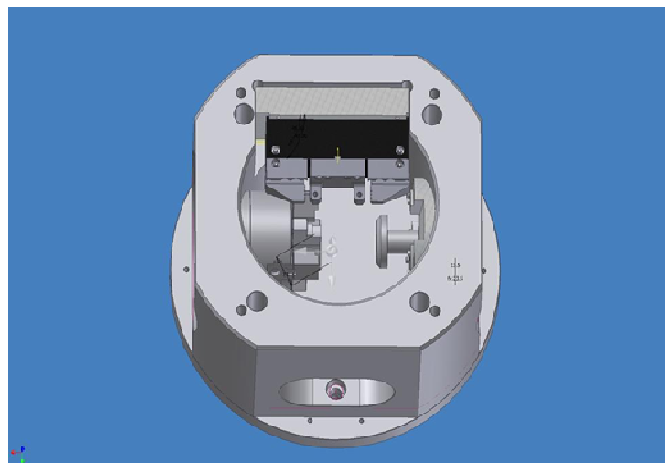
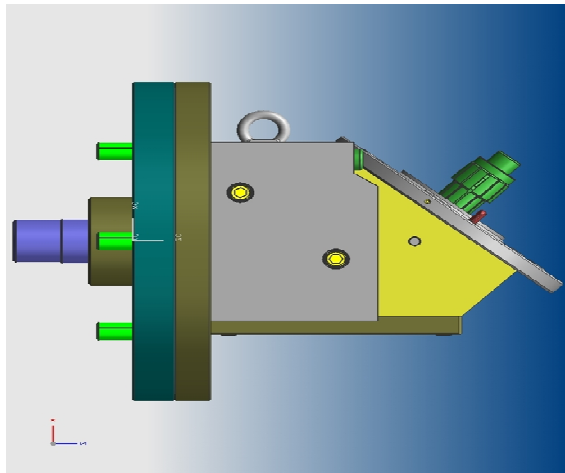


We utilize NX 6 software to design in a full 3D environment. This allows us to run simulations on our designs to ensure that you get the solution that will maximize thru put of your process. The solutions we supply to you are fully tested before they ship to ensure trouble free installation and operation.



Whether it's adding custom jaws and locators to production chucks or a fully custom fixture, we are your partner. Utilizing the latest in software, highly skilled engineers, refined processes and a commitment to you we can deliver the game changing solutions to your most difficult machining applications.

- NX 6 software
- ISO 9001-2008 registered
- Stress and deformation analysis
- Process improvement
- Fully tested
- Lathe and machining center applications



KITAGAWA[®]

NORTHTECH

800-222-4138

WWW.KITAGAWA.COM

ISO 9001-2008

Order parts online
WWW.KITAGAWA.COM



Kitagawa-NorthTech Inc.
301 E. Commerce Dr.
Schaumburg, IL 60173
800-222-4138