

JAHRLS QUICK-CHANGE CHUCKS



JAHRLS quick-change chucks

Self locking quick-change chuck

Operation:

By raising the locking sleeve the two sets of balls are released and the different types of inserts can be inserted or removed from the chuck.

When the sleeve is pulled down the insert gets locked.

Tool change can occur with both stopped and rotating spindle.

Precision and stability

The design consists of a solid chuck body with an internal taper and locking sleeve. Two sets of three balls serve to lock the inserts.

The first set of balls locks the annular groove on the insert's taper and pulls the insert in axial direction, while the upper set locks in three of the six semispherical recesses and transfers the torque.

Properties:

- The inserts are absolutely stuck.
- Runout accuracy better than 0,01 mm.
- Minimum space required for changing tool thanks to the possibility of oblique insertion.
- For both left- and righthanded tools.
- Works in any spindle position (vertical, horizontal, etc.).

One-hand chuck - type 80-4E

A variant of the chuck that has been simplified even further.

- The tool is released as described above, by lifting the locking sleeve.
- A new tool is applied with one hand since the return of the locking sleeve is done automatically.



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Quick-change chuck Jahrls

With Morse Taper

| Type size | Mount, taper | L mm | ØD mm | Article number |
|-----------|--------------|------|-------|----------------|
| 80-3 | MK 3 | 77 | 65 | 95143 |
| 80-3 | MK 4 | 76 | 65 | 95145 |
| 80-4E * | MK 4 | 93,5 | 83 | 95429 |
| 80-4E * | MK 5 | 91 | 83 | 98220 |

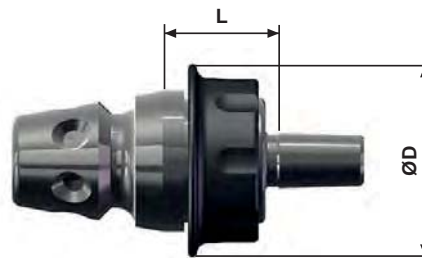
* One-hand chuck



Inserts Jahrls

For tools with Morse Taper

| Type size | Internal taper | L mm | ØD mm | Article number |
|-----------|----------------|------|-------|----------------|
| 80-3 | MK 1 | 29 | 52 | 95164 |
| 80-3 | MK 2 | 29 | 52 | 95165 |
| 80-3 | MK 3 | 43 | 52 | 95166 |
| 80-4 | MK 1 | 34 | 63 | 95167 |
| 80-4 | MK 2 | 34 | 63 | 95168 |
| 80-4 | MK 3 | 34 | 63 | 95169 |
| 80-4 | MK 4 | 65 | 63 | 95170 |



Inserts Jahrls

For chucks / holders with internal B-taper

| Type size | External taper | L mm | ØD mm | Article number |
|-----------|----------------|------|-------|----------------|
| 80-3 | B16 | 33 | 52 | 95187 |
| 80-4 | B16 | 38 | 63 | 95189 |