



CNC MACHINE TOOL ACCESSORIES

Chuck Jaws

QUICK REFERENCE GUIDE



MADE IN AUSTRALIA
• FOR OVER 35 YEARS •



dimac.com.au



TURNING



MILLING



ENVIRONMENTAL



ACCESSORIES

Why Dimac Soft Jaws?

- Premium quality at an affordable price
- Australian made at Dimac's Victorian manufacturing facility
- Jaws listed here are commonly ex stock
- Precision engineered and made from carbon steel
- Large selection of sizes covering all brands of chucks
- Custom sizes also available
- Safely packed into a convenient and robust storage box for maximum protection.

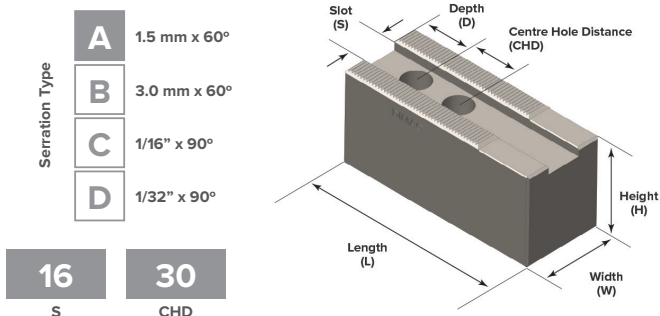
View the full range at dimac.com.au – click **Soft Jaw Search**.

How to choose the right soft jaw.

The correct Dimac jaw can be identified based on a combination of the criteria below.

1. Serration: A= 1.5x60°. B= 3.0x60°. C= 1/16"x90°. D= 3/32"x90°
2. Slot Width (mm)
3. Centre Hole Distance CHD (mm).

Example: A jaw with a 1.5mm serration, slot width of 16mm and a CHD of 30mm would be A1630 – refer selection of jaws on the following pages.



SOFT JAWS: METRIC SERRATIONS 1.5 X 60°

Part No.	L	W	H	D	KG
A0815 8 Slot 15 CHD			Kitagawa B-04		
8240	50	19	25	10	1.0
8234	55	19	38	10	1.0
A1014 10 Slot 14 CHD			Kitagawa B-204/B-205		
8273	55	25	40	12	1.0
8322	60	25	60	12	1.5
A1018 10 Slot 18 CHD			Kitagawa B-05		
8165	73	25	32	12	1.2
A1125 11 Slot 25 CHD			MMK 6"		
8081	80	30	35	14	1.5
A1220 12 Slot 20 CHD			Kitagawa B-206		
8471	65	25	30	12	1.0
8108	70	30	35	15	1.5
8415	85	30	35	15	2.0
8135	85	40	60	15	4.1
A1425 14 Slot 25 CHD			Kitagawa B-208/BB-208		
8075	90	35	40	20	3.0
8182	110	35	40	20	3.1
8214	80	40	60	20	3.5
8233	110	40	60	20	5.0
8076	90	40	75	20	5.0
8201	110	40	75	20	6.0
8155	90	40	110	20	7.5

SOFT JAWS: METRIC SERRATIONS 1.5 X 60°

Part No.	L	W	H	D	KG
A1630 16 Slot 30 CHD			Kitagawa B-210/BB-210		
8032	110	40	40	30	3.2
8219	120	40	40	30	3.4
8128	130	40	40	30	3.6
8215	100	40	60	35	4.5
8326	120	40	60	25	6.0
8034	110	40	75	30	6.5
8357	120	75	75	30	14.5
8131	130	40	75	30	7.2
8133	100	50	90	25	9.0
8197	150	40	90	30	12.0
8578	150	50	100	30	16.1
A1830 18 Slot 30 CHD			Kitagawa B/N12/VE315K		
8531	105	40	40	26	4.0
8033	130	50	50	40	6.5
8210	150	50	50	40	8.0
8541	150	60	60	20	11.5
8098	130	50	75	40	9.5
8099	130	50	100	40	13.5
8329	150	50	100	40	15.0

* Aluminium versions also available.

SOFT JAWS: METRIC SERRATIONS 1.5 X 60°

Part No.	L	W	H	D	KG
A2130 21 Slot 30 CHD			Kitagawa B-212/BB-212		
8451	110	50	50	20	5.0
8529	110	50	50	40	5.5
8298	130	50	50	20	6.5
8365	150	50	50	20	7.5
8526	150	50	50	60	7.5
8452	110	50	75	20	8.0
8299	130	50	75	20	8.0
8528	130	50	75	40	10.0
8340	170	50	75	20	13.0
8453	110	50	100	20	10.0
8300	130	50	100	20	13.0
A2243 22 Slot 43 CHD			Kitagawa B-15/18		
8146	165	60	60	37	11.3
8517	190	60	60	37	13.5
8323	165	60	100	37	20.5
8661	165	60	80	37	16.5
8674	210	60	100	37	27.0
A2543 25.5 Slot 43 CHD			Kitagawa N-15/18/B-215		
8297	165	60	60	37	13.0
8370	135	50	75	27	9.5
8537	165	60	100	37	20.0
8371	185	50	75	27	13.0

SOFT JAWS: METRIC SERRATIONS 3 X 60°

Part No.	L	W	H	D	KG
B2250 22 Slot 50 CHD				MMK 15"/18"	
8194	150	60	60	30	10.8
8435	190	60	60	30	15.0
8274	150	60	100	30	18.5
B2560 25 Slot 60 CHD			Kitagawa UVE 500-630/B21/B24		
8360	180	60	120	40	29.5
8601	180	65	70	40	19.0
8337	200	75	150	60	49.5

SOFT JAWS: IMPERIAL SERRATIONS 1/16 X 90°

Part No.	L	W	H	D	KG
C1416 14 Slot 16 CHD				Autoblok 165/175	
8485	70	30	35	16	1.5
8652	70	35	40	17.5	1.5
C1712 17 Slot 22 CHD				Autoblok 200/210/220	
8072	90	40	40	20	2.5
8242	110	40	40	20	3.0
8251	75	33	50	12	2.5
8241	90	40	60	20	4.0
8067	90	40	75	20	5.0

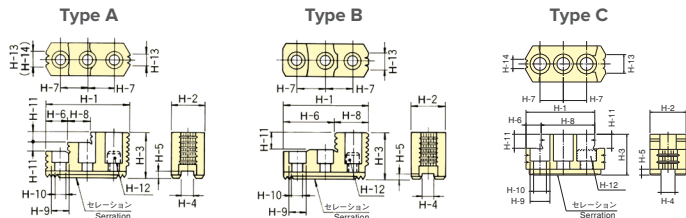
SOFT JAWS: IMPERIAL SERRATIONS 1/16 X 90°

Part No.	L	W	H	D	KG
C2130A 21 Slot 30 CHD			Autoblok 250/315		
8048	110	50	50	20	5.0
8049	125	50	50	22	6.0
8107	170	50	50	22	8.5
8446	120	50	75	45	8.5
8059	125	50	75	22	8.5
8068	150	50	75	22	11.5
8080	125	50	100	22	12.0
C2130B 21 Slot 30 CHD			Autoblok 400		
8332	156	60	60	25	11.5
8367	200	60	60	25	15.0

SOFT JAWS: IMPERIAL SERRATIONS 3/32 X 90°

Part No.	L	W	H	D	KG
D2535 25.5 Slot 35CHD			Forkhardt 15"/18"		
8287	140	60	60	30	11.0
8284	155	60	100	30	19.5
D2535 25.5 Slot 38CHD			Autoblok 500/800		
8369	160	60	60	27	11.5
8275	200	60	60	27	14.0
8384	180	60	90	28	20.0
8372	150	75	115	37	25.0

Hard Jaws



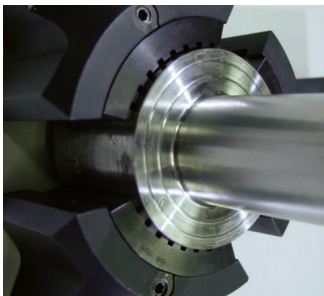
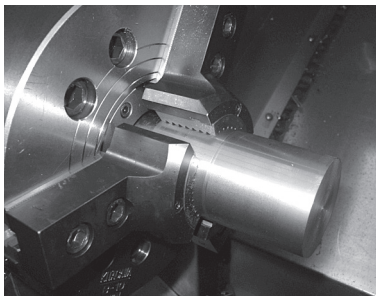
Kitagawa BB versions also available.

Part No.	Chuck Model	L	W	H	S	F	K	S1	Serration	Type
HB04B1	B-04	46	19	23	8	15	15	9	1.5x60	C
HB04N1	B-204, B-205	53	23	27.5	10	30.5	14	10	1.5x60	B
HB05B1	B-05	55.5	23	31	10	22.5	18	14	1.5x60	C
HB05C1	N-05	61	23	30	10	7.5	19	12	1.5x60	B
HB06A1	B-206, B-06, N-06	66.6	31	36	12	40	20	12	1.5x60	B
HB06B1	B-206, B-06, N-06	67.5	31	35	12	13	20	12	1.5x60	C
HB08A1	B-208, B-08, N-08	86	35	5	14	31	25	12	1.5x60	A
HB10A1	B-10, B-210, N-10	99.5	40	54	16	43	30	13	1.5x60	A
HB12B1	B-12, N-12	97.5	50	55	18	64	30	20	1.5x60	B
HB12N1	B-212	103	50	52	21	62.5	30	17	1.5x60	B
HB15A1	B-15, B-18	149	62	86	22	63	43	20	1.5x60	A
HB15B1	B-15, B-18	142	70	77	22	87.75	43	30	1.5x60	B
HB15N1	B-215, N-15, N-18	149	62	86	25.5	69	43	20	1.5x60	A
HB18B2	N-21, N-24, B-21, B-24	159.5	80	90	25	104.5	50	40	3x60	B
HB24B2	UVE800	183.5	90	105	25	116.5	60	50	3x60	B

Collet Jaws

The Dimac Collet Jaw system allows you to dramatically reduce your set-up times when dealing with multiple bar sizes. The Base Jaw stays on the chuck at all times and the operator simply changes over a set of 3 Collet Pads to suit the required gripping size. Collet Pads are securely held in position using a dovetail anchor clamp assembly for fast changeover.

- Convert your 3 jaw chuck into a pseudo collet chuck
- Eliminates the need to change and reposition soft jaws
- Change gripping size in seconds
- To suit Round, Hex or Square
- Available for most brands and sizes of chuck
- Utilises readily available S Style Collet Pads.



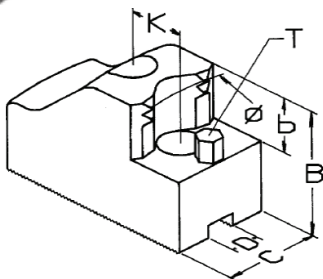
The table below outlines the capacities using a standard Kitagawa B200 series of chucks – other combinations available.

Chuck Size	Collet Pad	Round Capacity		Hex Capacity		Square Capacity	
		Min	Max	Min	Max	Min	Max
6"	S20	3.5mm	45mm	6.35mm	38mm	6.35mm	30mm
8"	S20	3.5mm	52mm	6.35mm	44mm	6.35mm	35mm
10"	S30	3.5mm	75mm	6.35mm	64mm	6.35mm	50mm
12"	S40	3.5mm	91mm	6.35mm	77mm	6.35mm	63mm

TuffGrip Hard Jaws

TuffGrip Hard Jaws are highly suited for aggressive gripping of 1st OP work and generally on black bar, castings or forgings. They provide secure grip and torque transmission.

- Available as both External Grip and Internal Grip Jaw
- Metric and Imperial Serrations
- Lightweight for higher surface speeds
- Available for all brands of chuck from 6" to 24" Chucks
- Secure grip face with aggressive serration on the surface
- Workpiece Stand-Off Pins from 5mm to 25mm height.



EXTERNAL STANDARD HARD SERRATED GRIPPER JAWS

Chuck Model	Grip Range (mm)		Part No.	B	C	D	K	b	T
	MIN	MAX							
B-206 A1220	26	47	TG-A1220-EX-A3	49	40	12	20	20	M6
	37	67	TG-A1220-EX-A4						
	50	81	TG-A1220-EX-A6						
	64	96	TG-A1220-EX-A7						
	80	112	TG-A1220-EX-A9						
B-208 A1425	31	68	TG-A1425-EX-B3	49	40	14	25	20	M6
	60	96	TG-A1425-EX-B6						
	87	125	TG-A1425-EX-B9						
	114	152	TG-A1425-EX-B12						
B-210 A1630	44	85	TG-A1630-EX-C4	59	40	16	30	25	M8
	82	125	TG-A1630-EX-C8						
	125	169	TG-A1630-EX-C13						
	168	212	TG-A1630-EX-C17						
B-212 A2130	48	112	TG-A2130-EX-E5	59	50	21	30	25	M8
	102	168	TG-A2130-EX-E10						
	165	233	TG-A2130-EX-E16						
	232	300	TG-A2130-EX-E23						

*Approx. grip ranges. Above jaws are 1.5mm x 60° Serrations; other variations available.

Custom Rotary Work Holding

When faced with castings, forgings or unusual shaped work pieces that need to be processed in your CNC turning centre then turn to Dimac to design and manufacture a custom solution to securely and accurately grip your work piece. As part of the service we can provide CAD models along with 3D printed jaws for evaluation purposes.

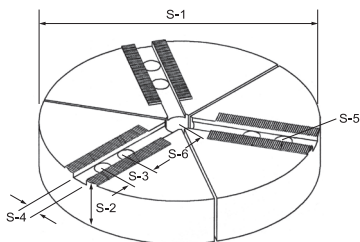


T: 1800 335 272

Pie Jaws

Pie Jaws are highly suited for gripping thin walled parts or where maximum “wrap-around” of the grip surface is required. They are available in either aluminium or steel to suit most makes and sizes of power chucks.

- Can be machined for both external and internal gripping
- Lightweight for higher surface speeds (aluminium)
- Secure gripping by nesting your workpiece
- Minimal workpiece distortion due to wrap around grip area.



Part No	Chuck	Model	S1	S2	S3	S4	S6	Material
PJ-A1220-40-45	B-206	A1220	169	40	20	12	49.5	Steel
PJ-A1220-40-21								Alum
PJ-A1425-40-45	B-208	A1425	206	40	25	14	54	Steel
PJ-A1425-40-21			200				51	Alum
PJ-A1425-50-45	B-208	A1425	206	50	25	14	54	Steel
PJ-A1425-50-21			200				51	Alum
PJ-A1630-50-45	B-210	A1630	250	50	30	16	65	Steel
PJ-A1630-50-21								Alum
PJ-A2130-50-45	B-212	A2130	300	50	30	21	81	Steel
PJ-A2130-50-21								Alum

Above jaws are 1.5mm x 60° Serrations with thru hole of 25mm; other variations available.

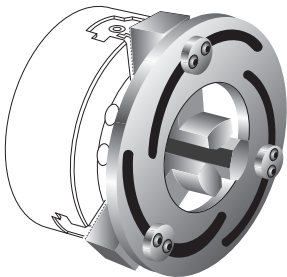
Soft Jaws Boring Fixtures

Dimac Boring Fixtures eliminate the need to use a disc or bung when boring jaws.

- Fixture for accurate and reliable machining of Soft Jaws
- Reduces set-up time
- Attaches quickly, no need for tools
- Compensates for “Jaw Lift”.

Part No.	Chuck Size	
BF05	5"	125mm
BF06	6"	150mm
BF08	8"	200mm
BF10	10"	250mm
BF12	12"	300mm
BF15	15"	380mm

Variable 8" and 12" also available.



Power Chuck Grease

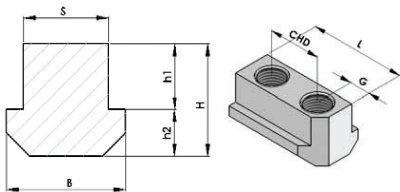
Power chucks are a critical element of your CNC turning centre and require the appropriate amount of attention and maintenance to ensure secure work holding and a long, accurate life. It is essential that your power chucks are regularly greased with most manufacturers recommending a dose of the correct grease at least daily. Grease Pro from Kitagawa has been specifically formulated for use in modern power chucks and is now available in a variety of packaging including the popular 450g Cartridge. Regular greasing can boost work holding performance by up to 50%.

Part No.	Description
CGDC450-GPW	450g Cartridge
CGKC1	1kg Tin
CGKP18	18kg Pail
GGMN450	Grease Gun



Power Chuck T-Nuts

T-Nuts listed below are generally ex stock and suit Kitagawa power chucks; please call or check our website for T-Nuts to suit other brands of power chucks.



T-NUTS FOR KITAGAWA CHUCKS

Part No.	H	h1	h2	B	L	G	CHD	S
TN1014B204/5	15	9.5	5.5	15	26	6	14	10
TN1220B206	18.5	11	7.5	17.5	36	8.25	20	12
TN1220BB206	18.5	11	7.5	17	36.5	8.25	20	12
TN1425B208	20	12	8.5	20.5	46.5	10.5	25	14
TN1425BB208	20	12	8.5	20.5	46.5	10.5	25	14
TN1630B/N10	25.5	16	9.5	22.5	55	11	30	16
TN1630B210	21.5	13	8.5	22.5	51	11	30	16
TN1630BB210	21.5	13	8.5	22.5	51	11	30	16
TN1830B/N12	33.5	20	13.5	26.5	56.5	11.5	30	18
TN2130B212	27.75	16.25	11.5	29.5	55.5	12	30	21
TN2130BB212	22.75	11.25	11.5	29.5	56.25	12	30	21
TN2243B15	45.5	29	16.5	33.5	80	17	43	22
TN2543B215	39	20	19	35	80	17	43	25

SAFETY WARNING

Please follow all safety procedures with this product – safety details can be found on page 18 of the Dimac Product catalogue available on-line at www.dimac.com.au/resources

Royal Live Centres

Royal live centres are widely regarded by top metalworking professionals as the best live centres available anywhere in the world. Each Royal live centre is a finely crafted tool, incorporating the highest quality steels, bearings and seals and manufactured to exacting tolerances.



Royal Products offer a broad range of standard live centre models to suit virtually all turning applications. Competitively priced custom live centres are also available and manufactured to the same high tolerances as our standard models.

Carbide application service improves clamping force by a significant 50%.

Insufficient grip can cause slipping of parts, push back in chuck jaws and collets, leading to premature wear. The resultant production downtime, operator idle time, and expense of new or re-worked jaws is a significant problem. Our carbide application service is designed to eliminate such issues, using equipment called Rocklinizer from the USA.



The application process improves clamping force by a significant 50% thereby providing extra grip on workholding equipment such as jaws and collets whilst wear is accordingly reduced.

THE HYDRAFEED BARFEEDER AND ROYAL ROTA-RACK ARE THE KEYS TO INCREASED PRODUCTIVITY.



 Hydrafeed



ROYAL
PRODUCTS
Optimize everything.



By using a Hydrafeed Barfeeder and a Royal Rota Rack working in conjunction, you can add a massive dose of productivity, keep your machines running long after your last employee has left for the night or weekend and improve your competitiveness in the market. They can be retrofitted to any entry level CNC machine as well as multi-tasking turning centres.

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