


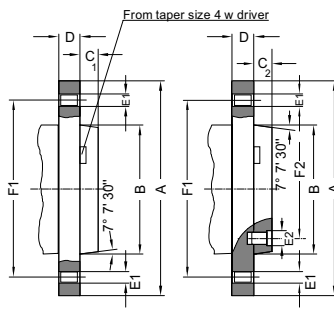
PRECISION SELF-CENTERING SCROLL LATHE CHUCK TYPE CT


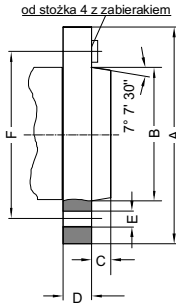
ISO 9001



BISON-BIAL

MACHINE SPINDLE NOSES TO DIN

DIN 55026 and ISO 702/I			spindle nose size	A	B max	C1	C2	D	E1	F1	E2	F2
 <p>DIN 55026 ISO 702/I</p> <p>Type A Type A2</p> <p>Type B Type A1-A2</p> <p>From taper size 4 w driver</p> 	3	92	53.983	11	-	16	3xM10	70.6	-	-	-	-
	4	108	63.521	11	-	20	11xM10	82.6	-	-	-	-
	5	133	82.573	13	14.288	22	11xM10	104.8	8xM10	61.9	-	-
	6	165	106.385	14	15.875	25	11xM12	133.4	8xM12	82.6	-	-
	8	210	139.731	16	17.462	28	11xM16	171.4	8xM16	111.1	-	-
	11	280	196.883	18	19.05	35	11xM20 (11xM18)	235	8xM20 (8xM18)	165.1	-	-
	15	380	285.791	19	20.638	42	12xM24 (12xM22)	330.2	11xM24 (11xM22)	247.6	-	-
	20	520	412.795	21	22.225	48	12xM24	463.6	11xM24	368.3	-	-
<p>Type A: Tapped holes in flange (outer bolt circle) without inner bolt circle. Type B: Tapped holes in flange (outer bolt circle) and in inner bolt circle. Dimensions in brackets according to ISO 702/I.</p>												

DIN 55027 and ISO 702/III		WITH BAYONET RING FIXING						
		spindle nose size	A	B max	C	D	E	F
 <p>od stożka 4 z zabierakiem</p> 	3	102	53.983	11	16	3x21	75	
	4	112	63.521	11	20	3x21	85	
	5	135	82.573	13	22	4x21	104.8	
	6	170	106.385	14	25	4x23	133.4	
	8	220	139.731	16	28	4x29	171.4	
	11	290	196.883	18	35	6x36	235	
	15	400	285.791	19	42	6x43	330.2	
	20	540	412.795	21	48	6x43	463.6	

BISON PRECISION SELF-CENTERING LATHE CHUCKS - TYPE CT

Precision chucks - with steel body for precision and high precision machining.

Extended period of life - expectancy.

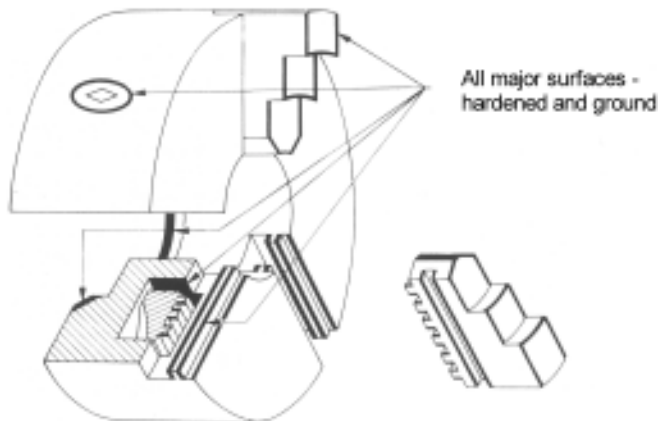
All components which are important for transmitting the chucking force are of modern and compact design.

BODY - drop - forged of highest grade steel, hardened and ground.

SCROLL PLATE - drop - forged of fine alloy steel, carburized and hardened. Thread flanks ground on both sides.

JAWS - of fine alloy steel, teeth, guides and other working surfaces carburized, hardened and ground.

PINIONS - of alloy steel, carburized, hardened and ground.



Pinions are recessed into the chuck body and special safety spring is mounted on the operating wrench preventing against the risk of accidents.

Each scroll plate and assembled precision chuck are statically balanced within fine limits.

Lathe chucks must be lubricated regularly to maintain their gripping force. Appropriate directions are included in the operating instructions supplied with each chuck.

All chuck are equipped with grease nipples for convenient maintenance.

BISON PRECISION SELF-CENTERING LATHE CHUCKS - TYPE CT

Standard accessories (chucks Ø 80, 100, 125) :

- 1 set of outside hard solid jaws
- 1 set of inside hard solid jaws
- 1 wrench
- 1 set of mounting screws

Standard accessories (chucks Ø 160-400) :

- 1 set of outside hard solid jaws
- 1 set of inside hard solid jaws
- 1 set of hard master jaws
- 1 wrench
- 1 set of mounting screws

Special accessories - without hard master jaws (chucks Ø 160-400) :

- 1 set of outside hard solid jaws
- 1 set of inside hard solid jaws
- 1 wrench
- 1 set of mounting screws

Optional accessories (chucks Ø 160-400) :

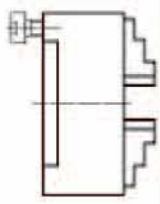
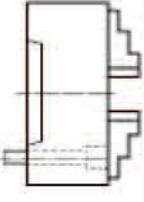
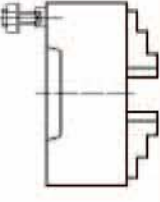
- hard 2-piece reversible jaws
- hard top jaws
- soft 2-piece jaws
- soft top jaws

Accuracy class :

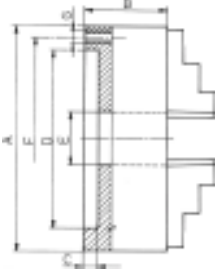
A - very high accuracy

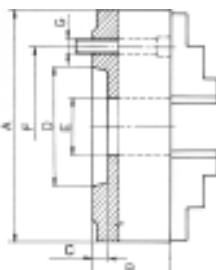
B - high accuracy

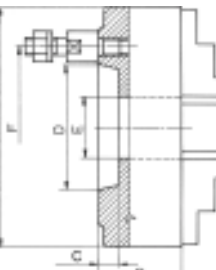
P - increased accuracy

	chuck size	short taper	through hole	Standard accessories						Special accessories					
				accuracy class						accuracy class					
				A		B		P		A		B		P	
				Code No 0642 535						Code No 0642 535					
DIN 6350	mm		mm		US\$		US\$		US\$		US\$		US\$		
	80	-	15	850 101		850 203		850 305		-		-		-	
	100	-	20	850 509		850 600		850 702		-		-		-	
	125	-	25	850 906		851 000		851 102		-		-		-	
	250	-	65	852 103		852 205		852 307		879 004		879 017		879 020	
Example of order :				CT-250A or 0642 535 852 103						CT-250A-S or 0642 535 879 004					
DIN 55026	mm		mm		US\$		US\$		US\$		US\$		US\$		
	200	4	50	861 701		861 803		861 905							
	250	5	65	862 906		863 000		863 102							
	315	6	80	864 103		864 205		864 307							
Example of order :				CT-250-F5-95A or 0642 535 862 906											
DIN 55027	mm		mm		US\$		US\$		US\$		US\$		US\$		
	125	3	25	870 505		870 607		870 709		-		-		-	
		4*	25	870 902		871 007		871 109		-		-		-	
	160	4*	40	871 700		871 802		871 903		879 060		879 073		879 086	
		5	40	872 100		872 201		872 303		879 099		879 106		879 119	
	200	5	50	873 701		873 803		873 905		879 121		879 134		879 147	
		6	50	874 101		874 203		874 305		879 150		879 162		879 175	
	250	6	65	875 306		875 408		875 500		879 188		879 190		879 208	
		8	65	875 703		875 805		875 907		-		-		-	
	315	6	80	876 500		876 602		876 704		879 210		879 223		879 236	
		8	80	876 908		877 002		877 104		879 249		879 251		879 264	
	400	8	100	878 105		878 207		878 309		879 277		879 280		879 292	
		11	100	878 502		878 604		878 706		879 300		879 312		879 325	
* stud and locknut non conformed to DIN															
Example of order :				CT-250-F6-A or 0642 535 875 306						CT-250-F6-A-S or 0642 535 879 188					

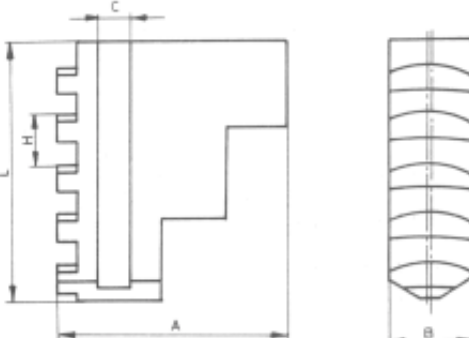
MAIN DIMENSIONS - LATHE CHUCK TYPE CT

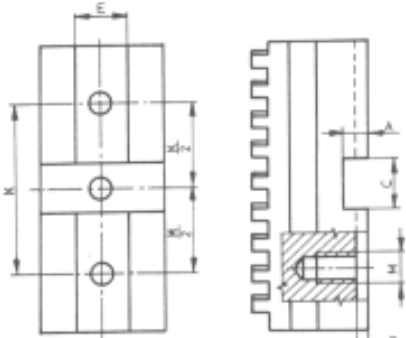
DIN 6350	Plain Back Mounting							
	Chuck size A	D	F	C min	B max	E min	G	Weight kg
	80	55	66	3	45	15	3xM6	2
	100	72	86	3	50	20	3xM8	4
	125	95	108	4	65	25	3xM8	6
	250	210	226	5	95	65	6xM12	31

DIN 55026	A - Type Mounting								
	Chuck size A	short taper	D	F-0,2	C min	E min	B max	G	Weight kg
	200	4	63,513	82,6	12,7	50	80	M10	17
	250	5	82,563	104,8	14,3	65	95	M10	31
	315	6	106,375	133,4	15,9	80	100	M12	50

DIN 55027	C - Type Mounting (Bayonet)							
	Chuck size A	short taper	D	F±0,2	C min	B	E min	Weight kg
	125	3	53,975	75	12,7	65	25	6
		4*	63,513	85	12,7			
	160	4*	63,513	85	12,7	70	40	12
		5	82,563	104,8	14,3			
	200	5	82,563	104,8	14,3	80	50	17
		6	106,375	133,4	15,9			
	250	6	106,375	133,4	15,9	95	65	31
		8	139,719	171,4	17,5			
	315	6	106,375	133,4	15,9	100	80	50
		8	139,719	171,4	17,5			
	400	8	139,719	171,4	17,5	110	100	90
11		196,869	235	19,1				

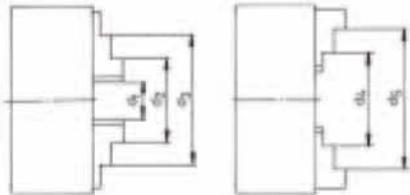
* stud and locknut non conformed to DIN

Hard solid jaws							
	Chuck size	A	B	C	H	L	
	80	28	11	6	4	32	
	100	32	15	6	6	42	
	125	40	20	8	7	51	
	160	53	20	8	8	70	
	200	54	25	10	8	85	
	250	63	28	12	10	105	
	315	73	32	12	10	125	
	400	92	36	14	12	145	

Hard master jaws							
	Chuck size	A ^{+0,8}	B ^{+0,5}	C	E	M	K
	160	5	3	12	12	2xM8	40
	200	5	3	15	15	2xM10	50
	250	7	3	20	20	2xM12	65
	315	8	4	20	20	3xM12	80
	400	9	4	25	25	3xM16	95

ENGINEERING DATA - LATHE CHUCK TYPE CT

Gripping Range Diameter

	Chuck size	d ₁ min-max	d ₂ min	d ₃ max	d ₄ max	d ₅ max
	80	4 27	22	69	26	75
100	4 34	27	88	34	93	
125	5 45	35	110	45	125	
160	5 65	55	145	50	160	
200	6 90	70	190	60	200	
250	6 120	75	240	80	250	
315	10 140	80	280	100	315	
400	10 170	95	355	120	400	

Max speed

Chuck size	80	100	125	160	200	250	315	400
r.p.m. max	6000	5500	5000	4500	4000	3500	2800	2000

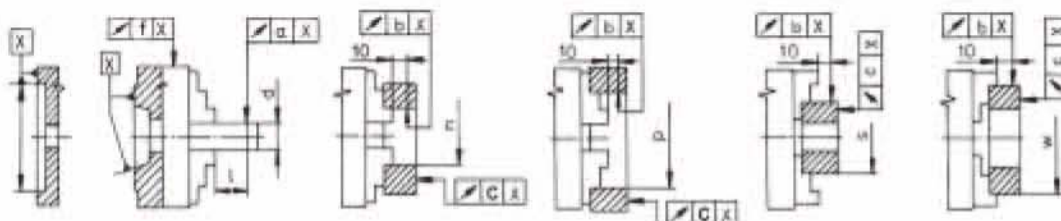
Value of balancing

Chuck size	80	100	125	160	200	250	315	400	
Balancing gcm	A	11	16	23	32	45	63	90	140
	B	18	25	35	50	71	100	140	200
	P	28	40	56	80	112	160	224	310

Total gripping force



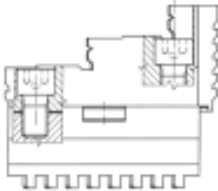
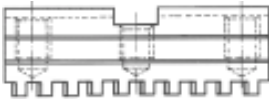

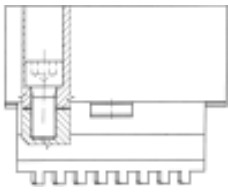

Chuck size	80	100	125	160	200	250	315	400
Torque on wrench Nm	35	50	75	120	160	180	200	280
Min. gripping force daN	650	750	1400	2000	2500	3800	4500	5500







Centering accuracy



Chuck size	80	100	125	160	200	250	315	400	
d	8	12	16	20	25	32	50	50	
	12	16	20	32	32	50	80	80	
	15	18	28	40	45	55	100	100	
l	40	40	50	50	80	80	120	120	
n	45	52	62	62	92	135	202	202	
p	60	75	100	135	162	200	252	282	
s	35	50	62	88	96	150	210	250	
w	63	80	100	100	160	160	250	250	
a	A	0,010	0,010	0,010	0,012	0,012	0,015	0,018	0,024
	B	0,015	0,015	0,015	0,020	0,020	0,024	0,024	0,036
	P	0,025	0,025	0,025	0,030	0,030	0,040	0,040	0,060
b	A	0,012	0,012	0,012	0,015	0,015	0,018	0,018	0,024
	B	0,018	0,018	0,018	0,024	0,024	0,030	0,030	0,036
	P	0,030	0,030	0,030	0,036	0,036	0,048	0,048	0,060
c	A	0,006	0,006	0,006	0,009	0,009	0,009	0,012	0,012
	B	0,012	0,012	0,012	0,015	0,015	0,018	0,024	0,024
	P	0,018	0,018	0,018	0,024	0,024	0,024	0,030	0,030
f	A	0,010	0,010	0,010	0,012	0,012	0,015	0,015	0,020
	B	0,015	0,015	0,015	0,020	0,020	0,025	0,025	0,030
	P	0,025	0,025	0,025	0,030	0,030	0,040	0,040	0,050

SPARE PARTS - LATHE CHUCK TYPE CT

Hard outside solid jaws - sets			
	Chuck size	Code No 0642 985	US\$
	80	350 009	
	100	350 100	
	125	350 202	
	160	350 304	
	200	350 406	
	250	390 908	
	315	350 600	
	400	350 701	
Hard inside solid jaws - sets			
	Chuck size	Code No 0642 985	US\$
	80	351 000	
	100	351 101	
	125	351 203	
	160	351 305	
	200	351 407	
	250	352 204	
	315	351 600	
	400	351 702	
Hard 2-piece reversible jaws - sets			
	Chuck size	Code No 0642 985	US\$
	160	353 310	
	200	353 411	
	250	353 513	
	315	353 615	
Hard master jaws - sets			
	Chuck size	Code No 0642 985	US\$
	160	358 301	
	200	358 403	
	250	358 505	
	315	358 607	
400	358 709		
Hard top jaws - sets			
	Chuck size	Code No 0642 985	US\$
	160	328 310	
	200	328 411	
	250	328 513	
315	328 615		
Soft 2-piece jaws - sets			
	Chuck size	Code No 0642 985	US\$
	160	355 324	
	200	355 413	
	250	355 515	
315	355 617		
Soft top jaws - sets			
	Chuck size	Code No 0642 985	US\$
	160	330 323	
	200	330 425	
	250	330 527	
	315	330 629	
400	330 720		

Pinion			
	Chuck size	Code No 0642 985	US\$
	80	334 006	
	100	334 108	
	125	362 202	
	160	362 304	
	200	362 406	
	250	362 508	
	315	362 600	
400	362 701		
Scroll plate			
	Chuck size	Code No 0642 985	US\$
	80	361 010	
	100	361 112	
	125	361 201	
	160	361 303	
	200	361 405	
	250	361 802	
	315	361 609	
400	361 700		
Locking half-ring			
	Chuck size	Code No 0642 985	US\$
	125	363 203	
	160	363 305	
	200	363 407	
	250	363 509	
	315	363 600	
	400	363 702	
Sleeve bearing			
	Chuck size	Code No 0642 985	US\$
	125	364 204	
	160	364 306	
	200	364 408	
	250	364 500	
	315	364 601	
400	364 703		
Stud bolt			
	Chuck size	Code No 0642 985	US\$
	80	335 109	
	100	335 109	
Wrench			
	Chuck size	Code No 0642 985	US\$
	80	340 102	
	100	340 204	
	125	340 204	
	160	340 306	
	200	340 306	
	250	342 911	
	315	340 408	
400	340 500		

Example of order : Wrench CT-250 or 0642 985 342 911



FABRYKA PRZYRZĄDÓW I UCHWYTÓW
BISON-BIAL S.A.

ul. Łąkowa 3, 15-950 Białystok, POLAND
Tel. +48 (85) 741 63 00, 741 64 20, Fax +48 (85) 741 52 23
e-mail: bison-bial@bison-bial.pl www.bison-bial.pl