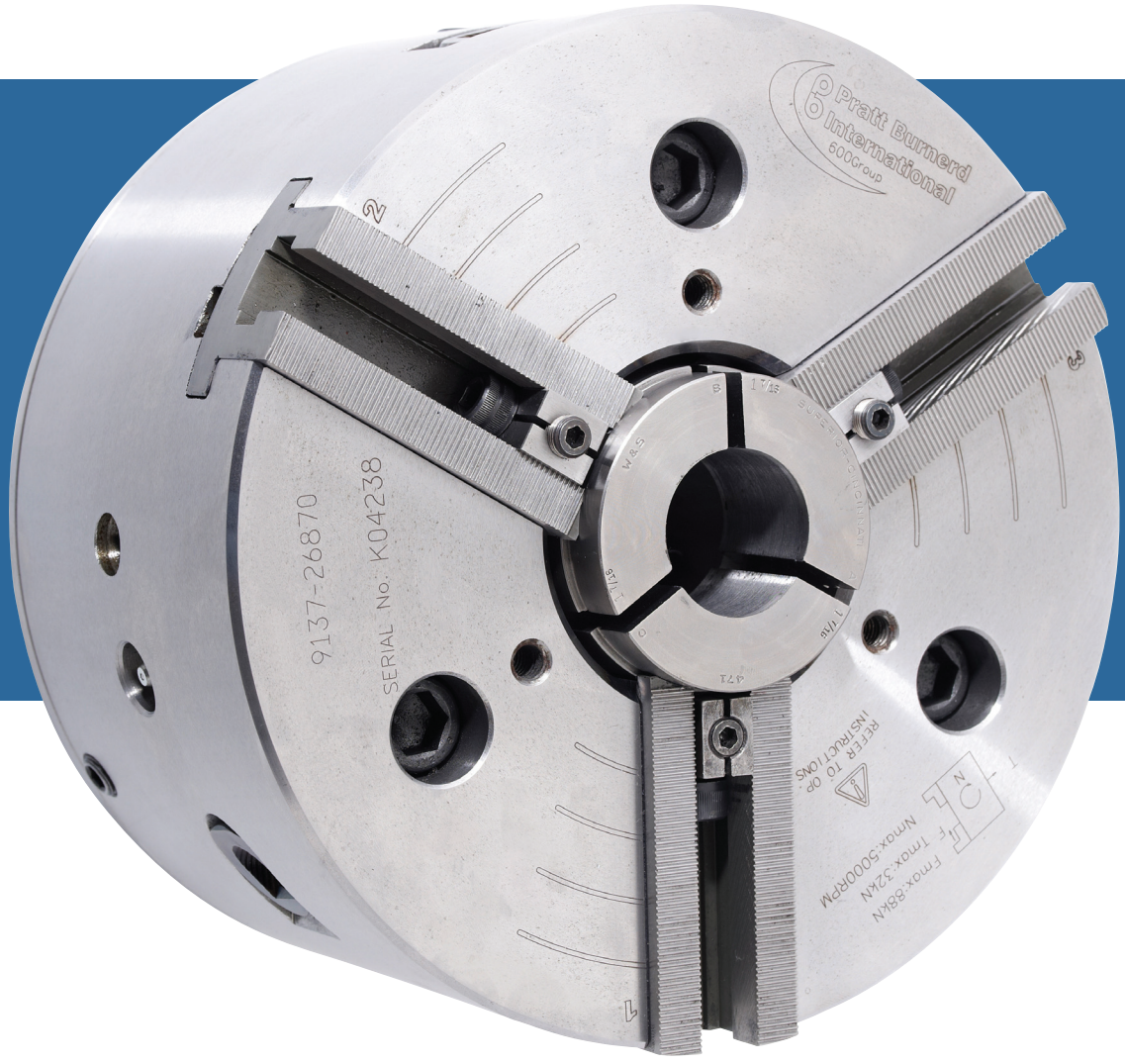
Pratt Burnerd International 600Group

Pratt Burnerd

World leading Chucks and Chucking Systems



GRIPFAST COMBINATION POWER CHUCKING SYSTEM

NEW Gripfast Combination Power Chucking System

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The Gripfast Chucking System dramatically reduces unproductive time when changing or resetting power chuck top jaws.

Chuck, Collet or Mandrel workholding modes can be set in seconds.

Optional large base versions available.

Quick Change Jaw System

With the half turn of a key, each jaw can be released, removed and replaced with a re-set second set of jaws that are locked in position, simply by returning the key to its original position.

There is a positive feel and smoothness of action along with a physical indication that the jaw is correctly secured in the jaw-way.

Each chuck is supplied with two sets of base jaws that can be exchanged in 40 to 60 seconds.

Additional sets of base jaws can be supplied suitable for your existing library of top jaws. If top jaws are left undisturbed then repeatability remains the same, whether simply operating the chuck or returning the jaws to the chuck hours or days later.

Standard Base Jaws have ground surface to accept Collet Pads

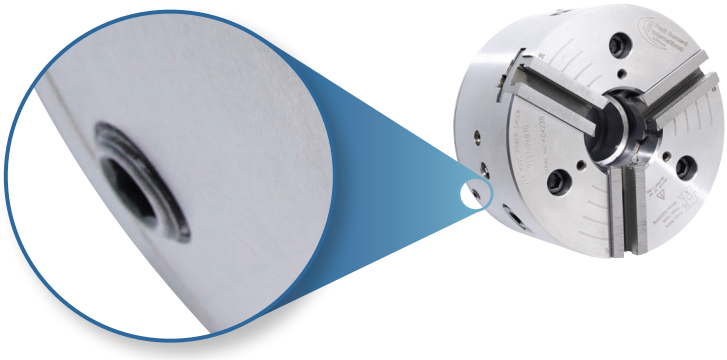
Significant time saving as the chuck doubles as a collet chuck, saving the necessity to exchange chucks when component size requires.

A more consistent gripping force is transmitted directly through the pad which is seated within the chuck bore because the workpiece is not subject to the bending moment inherent with top jaws.

Comprehensive range of standard and special collet pads available.

Setrite Adjustment

- Fast runout adjustment of chuck body or component if required
- Better and more consistent surface finish of the component
- Increased durability of tools
- Consistent quality standards
- User confidence in process and tools



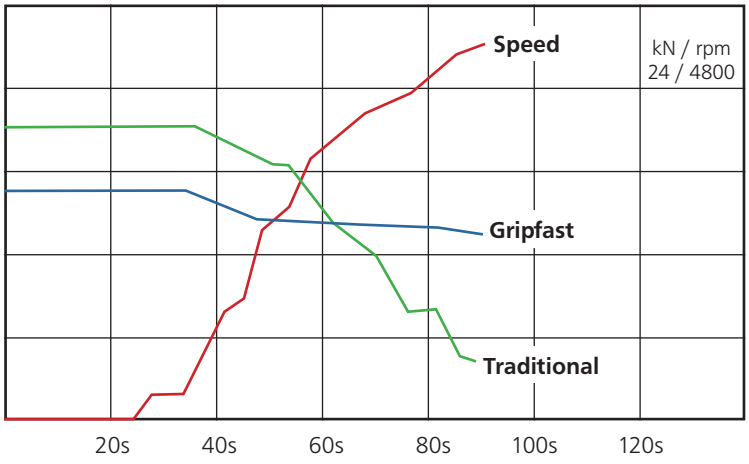
Arbour attachment

Allows internal gripping without the necessity to remove and replace the chuck.

Operation of the chuck releases the component, fail safe in use.

Top Jaw Setting Fixture

Allows the operator to accurately set top tooling for the next job while the machine is cutting metal, saving downtime and reducing possibility of error.



Counterbalanced

Gripfast chucks have a unique in-built anti-centrifugal counterbalance mechanism that reduces the loss of grip at high speeds allowing a 'constant' level of grip compared to the excessive grip loss of traditional power chucks.

Economics

It is only after you have purchased your CNC lathe that you become aware of lost production time and extra costs in fitting jaws.

Economics	Standard Power Chuck		Gripfast Change	
A				
4 changes/week	4x20 min	= 80 min	4x2 mins	= 8 mins
Cost at £40/hour		= £53.34/week		= £5.33
40 weeks/year		= £2134/year		= £213.20
Lost machining time		= 53 hours		= 5.3 hours
			Savings	= 47.7 hours
B				
Assume you have 4 CNC Lathes	4x53 hour	= 212 hours	4x5.3 hours	= 21.2 hours
Cost at £40/hour		= £8480		= £848
			Savings	= £7632

The PBI Gripfast system costs approximately £1000 more than a standard power chuck. The time taken to recover this at £40/hour is 25 hours. In example A, this would equate to a payback period of about 6 months and in example B, **less than 6 weeks**.

Gripfast Chuck Model	Body Dia (mm)	Mount Size	Speed (RPM)	Jaw Movement (mm)	Sleeve Movement (mm)	Chuck Bore (mm)	Collet pad bar capacity diameter (mm)	Tooling holes	Operating force (KN)	Gripping force (KN)	Chuck Weight (Kg)
9131-217**	160	A2-4	6000	3.5	16	42	38	5/16 UNC	24	47	18
9131-317**	160	A2-5	6000	3.5	16	42	38	5/16 UNC	24	47	17
9131-417**	160	A2-6	6000	3.5	16	42	38	5/16 UNC	24	47	16
9131-321**	210	A2-5	5500	3.5	16	52	51	5/16 UNC	24	66	30
9131-421**	210	A2-6	5500	3.5	16	52	51	5/16 UNC	24	66	29
9131-522**	210	A2-8	5500	3.5	16	52	51	5/16 UNC	24	66	28
9131-422**	210KB	A2-6	5500	3.5	16	66	63	5/16 UNC	24	66	28
9131-426**	254	A2-6	5000	4	18.5	66	63	3/8 UNC	32	88	42
9131-526**	254	A2-8	5000	4	18.5	66	63	3/8 UNC	32	88	41
9131-527**	265KB	A2-8	5000	4	18.5	77	76	3/8 UNC	32	88	51
9131-531**	305	A2-8	4200	4	18.5	90	76	3/8 UNC	44	121	68
9131-631**	305	A2-11	4200	4	18.5	90	76	3/8 UNC	44	121	67
9131-532**	315KB	A2-8	4200	4	18.5	102	101.6	3/8 UNC	44	121	70
9131-632**	315KB	A2-11	4200	4	18.5	102	101.6	3/8 UNC	44	121	69
9131-538**	380	A2-8	3000	5	20	125	114	3/8 UNC	60	139	135
9131-638**	380	A2-11	3000	5	20	125	114	3/8 UNC	60	139	134
9131-645**	450	A2-11	2500	6	25	142	139	1/2 UNC	69	170	145
9131-646**	460	A2-11	2500	6	25	142	139	1/2 UNC	69	170	144
9131-650**	500	A2-11	2500	6	25	142	139	1/2 UNC	69	250	160
9131-750**	500	A2-15	2500	6	25	142	139	1/2 UNC	69	250	159
9131-661**	610	A2-11	1800	6	25	160	158	1/2 UNC	92	345	180
9131-761**	610	A2-15	1800	6	25	160	158	1/2 UNC	92	345	179

** For base jaws with 60deg serration part number ends 23
** For base jaws with 90deg serration part number ends 10
** For base jaws with cross tenon part number ends

Larger diameters and bore sizes available on request.
2 jaw chuck also available on request.

Larger sizes available on request

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