

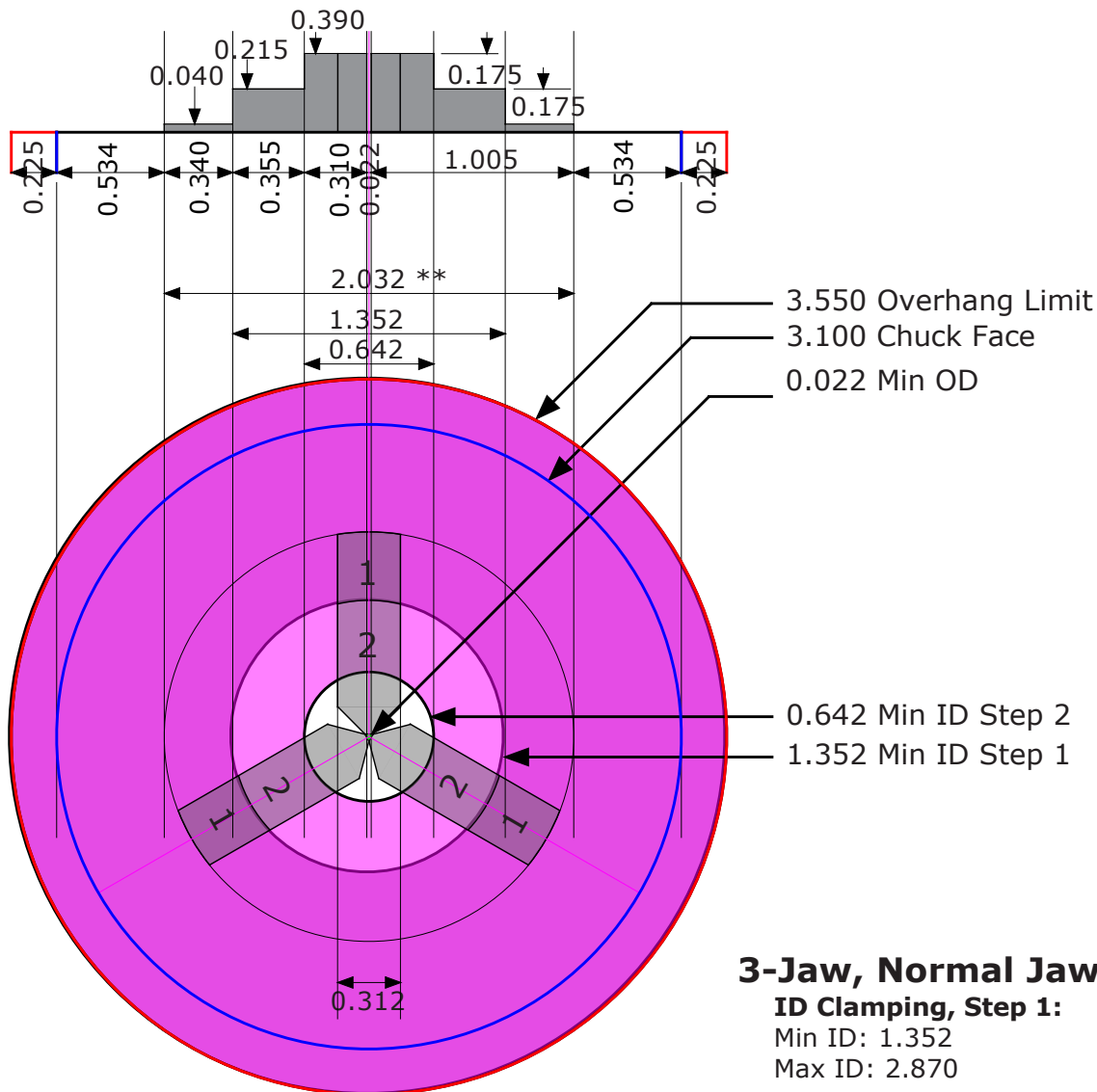
TIP 104 — 3-Jaw Chuck Holding Dimensions/Jack Pantry

Sherline user, Jack Pantry, recently submitted a tip for machining a chuck platform for turning thin parts (TIP 102). This project lead him down the proverbial rabbit hole, and he has gone to great lengths to find the minimum and maximum opening ranges for holding parts. His first submission is for the Sherline 3.1" 3-jaw,

self-centering chuck. He has included dimensions for the jaws in both the standard position and the reverse position, as well as a summary of the clamping ranges.

Thank you,
Sherline Products Inc.

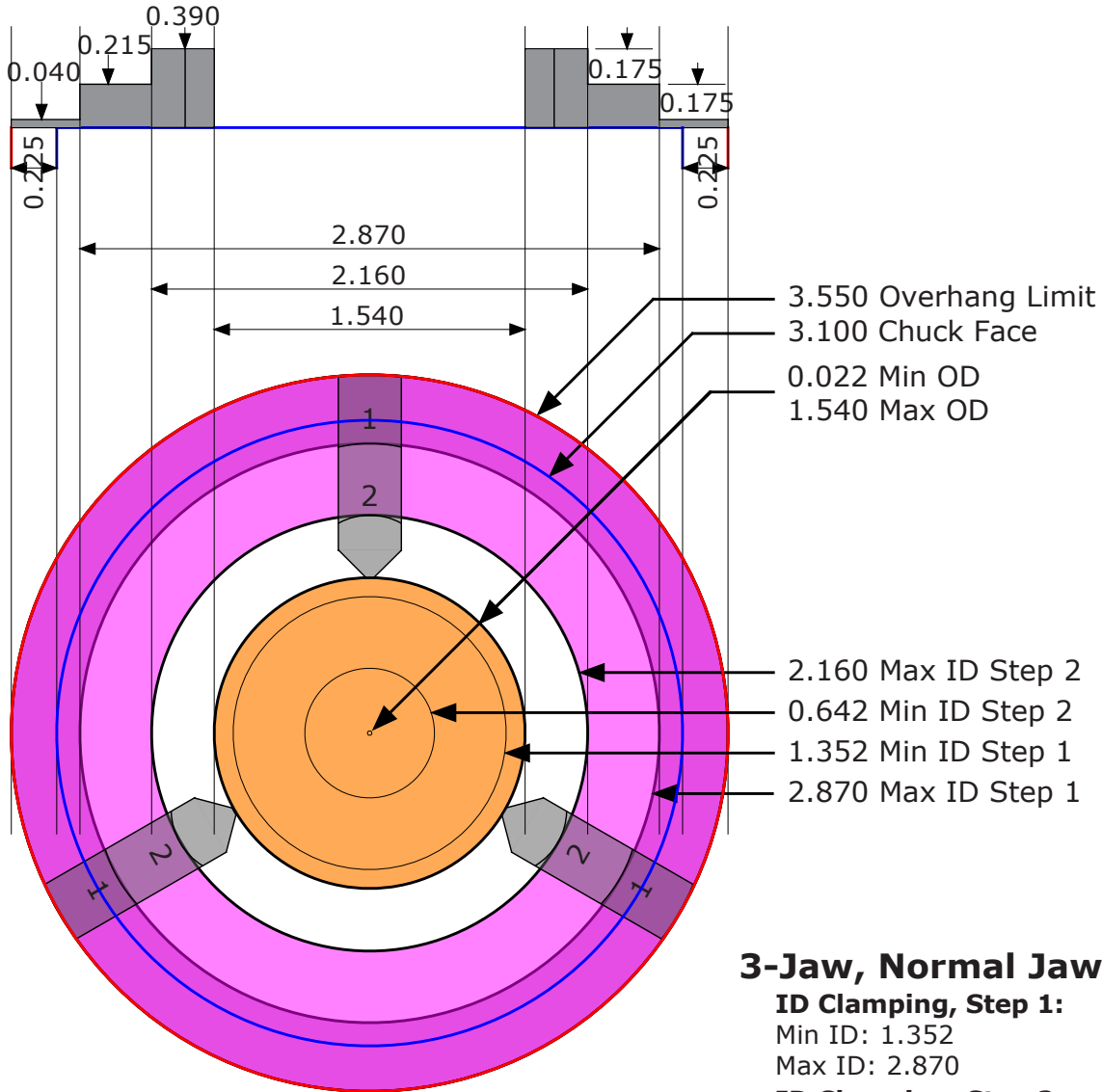
3-Jaw Chuck, Normal Jaws, Min Circles



** The 2.032 dimension is for Reference Only.

When clamping any item in this chuck, no part of the jaws, nor any part of the item itself, can extend beyond the face of the chuck by more than 0.225. This maximum can only be exceeded when using risers.

3-Jaw Chuck, Normal Jaws, Max Circles



3-Jaw, Normal Jaws

ID Clamping, Step 1:

Min ID: 1.352
Max ID: 2.870

ID Clamping, Step 2:

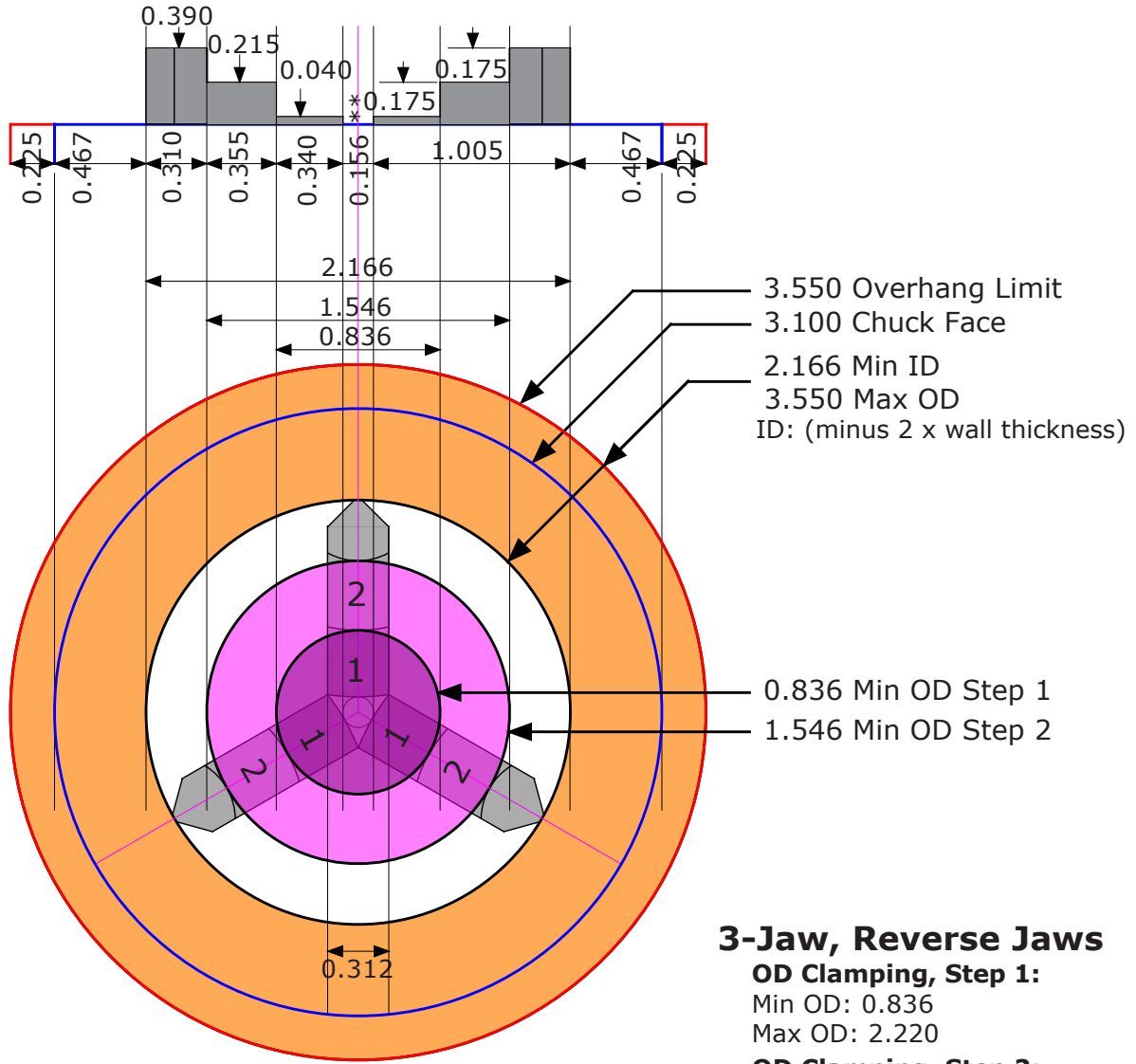
Min ID: 0.642
Max ID: 2.160

OD Clamping:

Min OD: 0.022
Max OD: 1.540

When clamping any item in this chuck, no part of the jaws, nor any part of the item itself, can extend beyond the face of the chuck by more than 0.225. This maximum can only be exceeded when using risers.

3-Jaw Chuck, Reverse Jaws, Min Circles



** The 0.156 dimension is for Reference Only.

When clamping any item in this chuck, no part of the jaws, nor any part of the item itself, can extend beyond the face of the chuck by more than 0.225. This maximum can only be exceeded when using risers.

3-Jaw, Reverse Jaws

OD Clamping, Step 1:

Min OD: 0.836
Max OD: 2.220

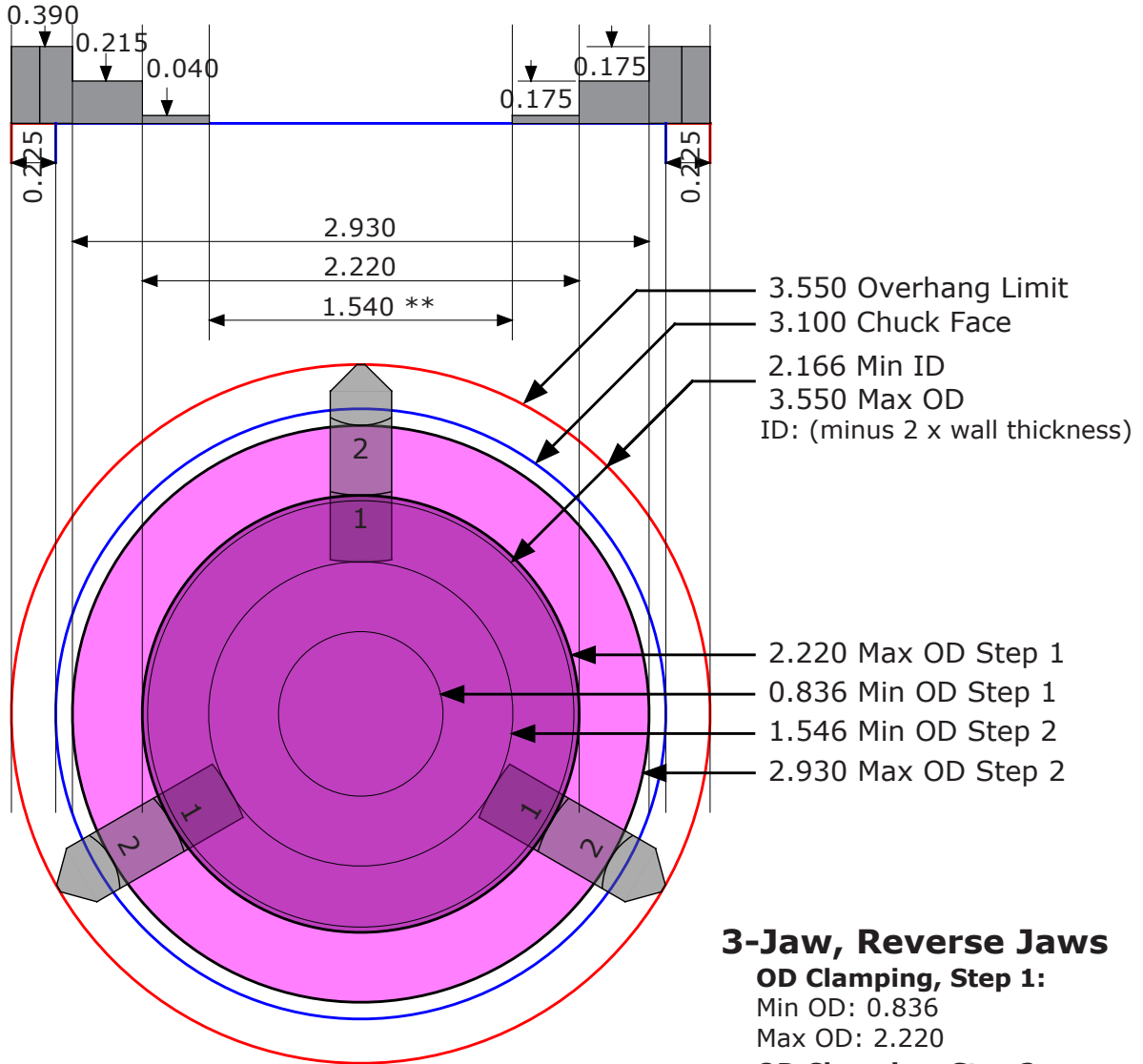
OD Clamping, Step 2:

Min OD: 1.546
Max OD: 2.930

ID Clamping:

Min ID: 2.166
Max OD: 3.550
ID: (minus 2 x wall thickness)

3-Jaw Chuck, Reverse Jaws, Max Circles



** The 1.540 dimension is for Reference Only.

When clamping any item in this chuck, no part of the jaws, nor any part of the item itself, can extend beyond the face of the chuck by more than 0.225. This maximum can only be exceeded when using risers.

3-Jaw, Reverse Jaws

OD Clamping, Step 1:

Min OD: 0.836
Max OD: 2.220

OD Clamping, Step 2:

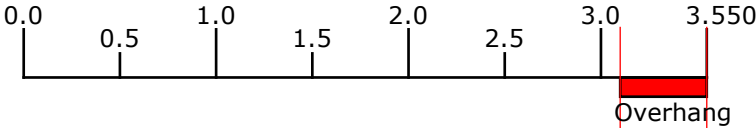
Min OD: 1.546
Max OD: 2.930

ID Clamping:

Min ID: 2.166
Max OD: 3.550
ID: (minus 2 x wall thickness)

Sherline 3-Jaw Chuck Clamping Range Summary

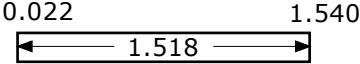
When clamping any item in these chucks, no part of the jaws, nor any part of the item itself, can extend beyond the face of the chuck by more than 0.225, except when using risers.



3-Jaw OD Clamping

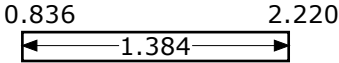
Normal Jaws:

Minimum OD: 0.022
Maximum OD: 1.540



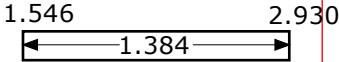
Reverse Jaws, Step 1:

Minimum OD: 0.836
Maximum OD: 2.220



Reverse Jaws, Step 2:

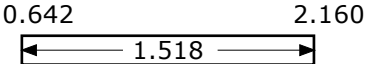
Minimum OD: 1.546
Maximum OD: 2.930



3-Jaw ID Clamping for pipe

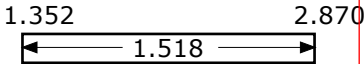
Normal Jaws, Step 2:

Minimum ID: 0.642
Maximum ID: 2.160



Normal Jaws, Step 1:

Minimum ID: 1.352
Maximum ID: 2.870



Reverse Jaws:

Minimum ID: 2.166
Maximum OD: 3.550
Max ID: (Minus 2 x wall thickness)

