

JACOBS®

Chucks

SuperChuck® - Ball Bearing - Keyed



For heavy duty close tolerance production drilling. Use on wide range of production drilling equipment, milling machines, lathes, jig borers, radials. Use ball thrust bearing to reduce friction in chuck closing mechanism. Permit application of more gripping force on drill shanks to maximize drilling torque under demanding machining conditions. One-piece sleeve eliminates crack between driving teeth. Through-hardened sleeve teeth plus hardened nose and keyholes for wear resistance. Fluted sleeve standard, include jaws, nuts, caged bearing and thrust washer.

No.	Model No.	Cap. In.	Mount	Key No.	Dia., In.	
					Closed	Open
/73230215	11N	0-.375	2JT	K32	2.88	2.26
/73230221	14N	0-.500	3JT	K3	3.88	2.97
/73230227	16N	.125-.625	3JT	K4	4.31	3.26
/73230233	18N	.125-.750	4JT	K4	5.12	3.95
...30239	20N	.375-1.000	5JT	K5	5.50	4.23

JACOBS®

Chucks

Plain Bearing - Key Type



For use with bench or floor mounted power tools. Heavy and medium duty. Jaws center-ground for absolute straightness and alignment. Jaws treated to ensure extended thread life and high gripping surface

hardness. One-piece sleeves. Through-hardened sleeve teeth, hardened nose and keyholes.

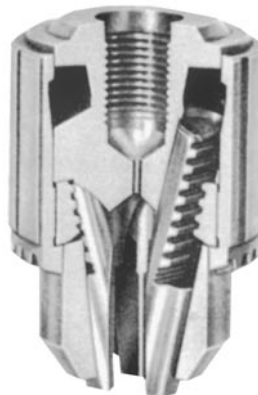
No.	Model No.	Cap. In.	Key No.	Wt. Oz.	Sleeve Fin.
Heavy Duty - Taper Mounted					
...06223	3A	.125-.625	K3	32	Fluted
/73214442	34-02	0-.500	K3	23	Fluted
/73214445	34-33	0-.500	K3	23	Fluted
/73214451	34-33C	0-.500	K3C	26	Sm. Grd.
/7326309	36	.180-.800	K4	45	Fluted
Medium Duty - Taper Mounted					
/7326200	0	0-.156	K0	2	Sm. Grd.
/7326206	1A	0-.250	K1	5	Sm. Grd.
/7326214	2A	0-.375	K2	13	Fluted
/73214698	31-02	0-.375	K30	8	Fluted
...06279	33	.080-.500	K32	16	Fluted

No.	Model No.	Cap. In.	Key No.	Wt. Oz.	Sleeve Fin.
Heavy Duty - Thread Mounted					
/7326232	3B 5/8	.125-.625	K3	32	Fluted
/7326255	7BA 3/8	0-.250	K7	7	Fluted
...08859	32BA 1/2	0-.375	K32	14	Fluted
...14723	35B 1/2	.156-.625	K3	25	Fluted
...06316	36B 3/4	.188-.800	K4	46	Fluted
...06314	36B 5/8	.188-.800	K4	46	Fluted
Medium Duty - Thread Mounted					
/7326204	0B 5/16	0-.156	K0	2	Sm. Grd.
/7326208	1B 3/8	0-.250	K1	5	Sm. Grd.
/7326219	2BA 3/8	0-.375	K2	13	Fluted
/73230728	41BA 3/8	0-.375	K30	8	Fluted
/73231138	41BA 3/8-S	0-.375	K30	8	Sm. Grd.
.73231090	41BA 1/2	0-.375	K30	8	Fluted
/7326287	33BA 1/2	.080-.500	K32	17	Fluted
/7326283	33BA 3/8	.080-.500	K32	17	Fluted
/7326289	33BA 5/8	.080-.500	K32	17	Fluted

JACOBS®

Chucks

Thread Mounted - Plain Bearing



Industrial grade. Fully hardened and ground components for accuracy, gripping power and durability. For threaded or taper mounting. Fluted sleeve on all models except No. 41BA-3/8-S, which is smooth and ground. Minimum capacity will hold a #60 (0.040") drill. Maximum capacity is .375".

No.	Model No.	Cap. In.	Mount Thrd.	Key No.	Closed Lgth. In.	Open Lgth. In.	Sleeve Dia. In.
...41B-3/8	41B-3/8	0-0.375	3/8-24	K30	63.5	2.5	1.43
...41BA-3/8-S	41BA-3/8-S	0-0.375	3/8-24	K30	63.5	2.5	1.43
/73231090	41BA-1/2	0-0.375	1/2-20	K30	63.5	2.5	1.43

JACOBS®

Chuck Keys

For Plain Bearing & Ball Bearing Chucks



T-Handle

No.	Model No.	Pilot Size In.	For Chuck
/73400	K0	1/8	0 Series
/7343649	K2	1/4	2 Series
/7343651	K3	5/16	3, 34 Series, 14N
...03653	K3C	5/16	34-33C
/7343655	K4	3/8	36, 16, 18N
/7343657	K5	7/16	20N
/7343659	K7	7/32	7 Series
/7343664	K30	15/64	31 Series, 8 1/2N
/7343666	K32	1/4	32, 33 Series, 11N

JACOBS®

Chuck Key Holders



No.	Desc.
...30253	Chuck Key Holder

JACOBS®

Keyleashes
Rubber-Flex®



No.	Model No.	Fits Key No.
...3685	A	K0, K1, K7, KG
...3686	B	K30, K2, K32, KK
...3687	C	K3

JACOBS®

Arbors
Taper Chuck



Morse taper to Jacobs® taper. Precision machined and ground to master gages. For use with custom tool and work holder designs and for specialized machining applications.

No.	Taper Morse	Jacobs	OA Lgth. In.
/7347299	1	1	3.38
/7347300	1	2	3.59
/7347303	1	6	3.72
/7347304	1	33	3.72
/7347306	2	1	3.94
/7347307	2	2	4.16
/7347308	2	3	4.50
/7347309	2	4	4.94
/7347311	2	6	4.28
/7347312	2	33	4.28
...A0301	3	1	4.69
/7347314	3	2	4.94
/7347315	3	3	5.27
/7347316	3	4	5.70
...A0305	3	5	5.94
/7347318	3	6	5.06
/7347319	3	33	5.06
/7347320	4	2	5.91
/7347321	4	3	6.25
/7347322	4	4	6.69
...A0405	4	5	6.91
/7347324	4	6	6.03
/7347325	4	33	6.06
/7347327	5	3	7.50
...A0504	5	4	7.94
/7347329	5	5	8.16

JACOBS®

Arbors
Straight Shank



Straight shank to Jacobs® taper. For turret lathe and screw machine. Fit chucks to spindles w/straight holes.

No.	Desc.	Shank Lgth. In.	OA Lgth. In.
/7347348	1/2"×0JT	2.500	3.094
/7347349	1/2"×1JT	2.500	3.312
/7347350	1/2"×2JT	2.500	3.531
/7347351	1/2"×3JT	2.500	3.875
/7347353	1/2"×6JT	2.500	3.656
/7347354	1/2"×33JT	2.500	3.656
/7347355	5/8"×1JT	2.500	3.312
/7347356	5/8"×2JT	2.500	3.531
/7347357	5/8"×3JT	2.500	3.875
/7347359	5/8"×6JT	2.500	3.656
/7347360	5/8"×33JT	2.500	3.656
/7347361	3/4"×2JT	3.000	4.031
/7347362	3/4"×3JT	3.000	4.375
/7347364	3/4"×6JT	3.000	4.156
/7347365	3/4"×33JT	3.000	4.156
/7347367	1"×3JT	3.000	4.375
/7347368	1"×6JT	3.000	4.156

JACOBS®

Drill Sleeves
Archer® - Morse Taper

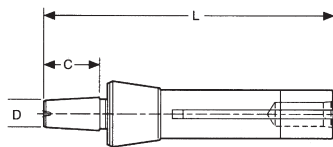


Adapt smaller Morse taper shank tools to larger machine spindles. Hardened tang. Oil toughened and externally precision ground.

No.	Morse Taper No.		OA Lgth. In.	Wt. Oz.
	Outside	Inside		
Series 600				
...610	1	0	2.56	1
/74030422	2	1	3.62	2
/74030423	3	2	4.38	5
/74030424	3	1	3.88	6
/74030425	4	3	5.50	13
/74030426	4	2	4.88	14
/74030427	4	1	4.88	17
/74030638	5	1	6.12	47
/74030428	5	4	6.69	35
/74030429	5	3	6.12	41
/74030430	5	2	6.12	46
/74030639	6	4	8.56	88
...665	6	5	8.56	90

JACOBS®

Arbors
Bridgeport® Taper to Jacobs® Taper



No.	Model No.	Jacobs Mount	L In.	C In.	D In.
/7347339	A0802	2JT	5.18-5.20	.91-.92	0.49-0.49
/7347340	A0803	3JT	5.53-5.55	1.25-1.27	0.75-0.75
/7347341	A0804	4JT	5.97-5.98	1.69-1.70	1.04-1.04
...7342	A0806	6JT	5.31-5.33	1.03-1.05	0.62-0.63
/7347343	A0833	33JT	5.31-5.33	1.03-1.05	0.56-0.56

JACOBS®
Extension Sockets
 Archer® Series 800 - Morse Taper



Extend tool length and application distance. Multiple inside and outside Morse taper sizes. Externally precision ground with hardened tang.

No.	Model No.	Outside Morse Taper No.	Inside Morse Taper No.	OA Lgth. In.	Sleeve Lgth. In.	Sleeve Dia. In.	Wt. Oz.
/74030443	811	1	1	5.71	2.99	0.79	5
/74030445	821	2	1	6.30	2.99	0.79	9
/74030446	822	2	2	6.89	3.58	1.18	16
/74030448	831	3	1	6.89	2.99	0.79	14
/74030449	832	3	2	7.64	3.58	1.18	23
/74030450	833	3	3	8.46	4.41	1.42	30
/74030640	842	4	2	8.46	3.58	1.18	41
/74030452	843	4	3	9.45	4.41	1.42	42
/74030453	844	4	4	10.43	5.39	1.89	65
/74030641	853	5	3	10.35	4.41	1.42	100
/74030455	854	5	4	11.81	5.39	1.89	102
/74030456	855	5	5	13.19	6.77	2.48	76

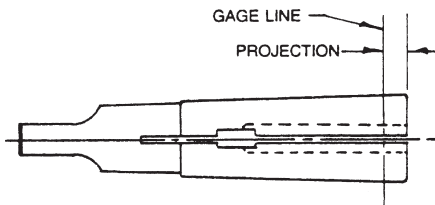
JACOBS®
Ejecting Drifts



Hardened. Tempered. Eject Morse taper attachments from sleeves, sockets, machine spindles.

No.	Model No.	Morse Taper Size	Wt. Oz.
/74230484	900	0	1
/74230485	902	1 & 2	3
/74230486	903	3 & 4	6
/74230487	904	4 & 5	12
/74230488	906	6	21
...30489	914	1-4	10

COLLIS TOOL
Drill & Reamer Drivers
 Split Sleeve



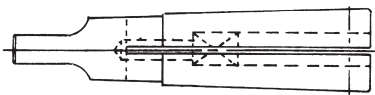
For tanged straight shank tools. Accurately adapt straight shank drills to Morse taper spindles and other taper hole holders. Resist drill pull-out. Bore and outside taper held to close concentricity.

No.	Drill Size	Dec. Equiv. In.	Hole Size In.*	Morse Taper No.
/744-71159	25	.1495	.1490	1
/744-71181	13/64	.2031	.2026	2
/744-71186	7/32	.2188	.2183	2
/744-71203	J	.2770	.2760	1
...72298	5/16	.3125	.3115	2
...72304	11/32	.3438	.3428	2
...72310	3/8	.3750	.3640	2
...73008	11.10 mm	.4370	.4360	3
...72323	1/2	.5000	.4990	2
...73014	17/32	.5313	.5318	3

*+.000, -.001

COLLIS TOOL
Tap Drivers
 Style A - Split Sleeve

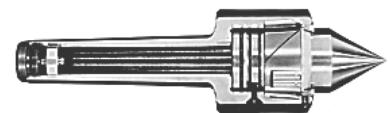
Morse Taper



Utilize the four way split to provide maximum gripping of tap, to minimize pull-out and reduce down time. Made of high quality steel and properly heat treated.

No.	Size	Outside No.	Tap Shank Dia. In.	Tap Square In.	Tap Dpth. In.
Machine Screw Taps					
/744-71300	0-6	1	.141	.110	23/32
/744-71301	8	1	.168	.131	59/64
/744-71302	10	1	.195	.152	57/64
/744-71303	12	1	.220	.165	29/32
Hand Tap Size					
/744-71320	1/4	1	.255	.191	31/32
/744-72420	1/4	2	.255	.191	31/32
/744-71321	5/16	1	.318	.238	1
/744-72421	5/16	2	.318	.238	1
/744-71322	3/8	1	.275	.206	1.05
...72422	3/8	2	.275	.206	19/64
/744-72423	3/8	2	.381	.286	19/64
/744-72424	7/16	2	.323	.242	15/64
/744-72425	1/2	2	.367	.275	19/32
/744-73420	1/2	3	.367	.275	19/32
/744-72426	9/16	2	.429	.322	19/32
/744-73421	9/16	3	.429	.322	19/32
/744-72427	5/8	2	.480	.360	129/64
/744-73422	5/8	3	.480	.360	129/64
/744-72428	11/16	2	.542	.406	19/16
/744-73423	11/16	3	.542	.406	19/16
/744-73424	3/4	3	.590	.442	151/64
/744-74420	3/4	4	.590	.442	151/64
/744-73425	7/8	3	.697	.523	129/32
/744-74421	7/8	4	.697	.523	129/32
/744-74422	1	3	.800	.600	21/32
/744-74423	1 1/8	4	.896	.672	29/64
/744-74424	1 1/4	4	1.021	.766	219/64

LIVE CENTERS
 Skoda - Heavy Duty



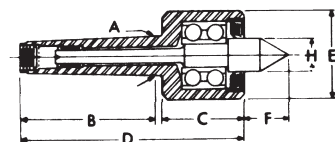
Rotating spindle extended through tapered shank. Radial loads carried by 2 adjustable needle-roller bearings.

Ball bearing takes axial thrust. Built-in oil seal protects bearings from entry of contaminants and prevents lubricant loss. Center angle 60°.

No.	Morse Taper	Point Dia. In.	Body Dia. In.	Body Lgth. In.	Max. Work-piece Wt. Lbs.
/73610201	1	5/8	1 3/8	4 3/8	200
/73610202	2	7/8	1 1/2	5	600
/73610203	3	1 1/8	1 7/8	6 1/4	900
/73610204	4	1 1/2	2 3/16	7 1/2	1800
/73610205	5	1 3/4	2 3/4	9 1/2	3000
/73610206	6	2 3/8	3 1/2	12 3/4	7500

RITEN INDUSTRIES
Live Centers

Morse Tapers - General Purpose

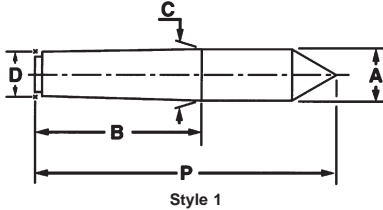


We also have Royal Products live centers available.

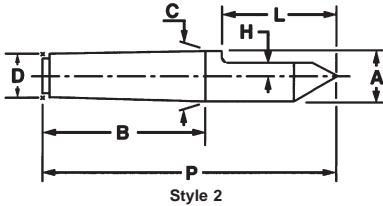
Complete Information Available on Request.

RITEN INDUSTRIES
Dead Centers
High Speed - Information

Accurate to ±.0001. Through-hardened to 61-63 Rc specifications for extra regrinds. Carbide tipped centers hardened on knock-out ends only. Can reduce friction with Moly EP632 grease on point.



Style 1. Steel full center.



Style 2. Steel half center.

Morse Taper Specifications

No.	Taper No.	P In.	B In.	C/A In.	D In.	T In.*	H In.	L In.
67101	1	3 9/16	2 1/8	.475	.369	1/4	1/8	1
67102	2	4 3/16	2 9/16	.700	.572	3/8	3/16	1 3/8
67103	3	5 1/4	3 3/16	.938	.778	1/2	1/4	1 11/16
67104	4	6 3/4	4 1/16	1.231	1.020	3/4	3/8	2 1/4
67105	5	8 1/2	5 3/16	1.748	1.475	7/8	1/2	2 3/4
67106	6	11 1/2	7 1/4	2.494	2.116	1	3/4	3 1/2
67107	7	15	10	3.270	2.750	1 1/4	1	4

*Carbide diameter.

Jarno Taper Specifications

No.	Taper No.	P In.	B In.	C/A In.	D In.	T In.†	H In.	L In.
67204	6	4 1/2	3	.750	.600	3/8	3/16	1 1/8
67205	6	5 1/2	3	.750	.600	3/8	3/16	2 3/16
67206	6	6	3	.750	.600	3/8	3/16	2 1/2
67207	7	5 1/4	3 1/2	.875	.700	3/8	3/16	1 3/16
67208	8	6	4	1.000	.800	1/2	1/4	1 5/8
67209	9	6 3/4	4 1/2	1.125	.900	1/2	1/4	1 7/8
67210	10	7 1/2	5	1.250	1.000	1/2	1/4	2
67211	11	8 1/4	5 1/2	1.375	1.100	1/2	1/4	2
67212	12	9	6	1.500	1.200	5/8	3/16	2 1/4
67213	13	9 3/4	6 1/2	1.625	1.300	5/8	3/16	2 1/2
67214	14	10 1/2	7	1.750	1.400	5/8	3/16	3
67215	15	11 1/4	7 1/2	1.875	1.500	5/8	3/16	3
67216	16	12	8	2.000	1.600	3/4	3/8	3
67218	18	13 1/2	9	2.250	1.800	7/8	7/16	3 1/2
67220	20	15	10	2.500	2.000	1	1/2	4
67236	36	27	18	4.500	3.600	1 3/4	7/8	7

†Carbide diameter.

Complete Information Available on Request.

VIKING DRILL & TOOL
Jobbers Length Drills
Type 643



For drilling broken studs with fast penetration and accurate starting without center punch. Made of special Hi-Molybdenum tool steel. Gold surface treated for maximum lubricity. Heat treated at 2185°F. Nitro-carburize finished at 950°F. Withstand high drilling temperatures and maintain hardness. Precision ground point, flutes, body, clearance and drill diameter. 135° split point.

Type 240. Features metric dimensions.

No.	Dia. mm	Lgth. mm	Flute Lgth. mm	Pkg. Qty.
.....	.35	19	3	10
.....	.40	19	5	10
.....	.45	22	5	10
/570050	.50	22	5	10
.....	.55	25	8	10
/570060	.60	29	8	10
/570065	.65	32	10	10
/570070	.70	32	10	10
/570075	.75	35	13	10
/570080	.80	35	13	10
/570085	.85	38	16	10
.....	.90	38	16	10
.....	.95	38	16	10
/570100	1.00	41	17	10
.....	1.05	41	17	10
.....	1.10	44	19	10
.....	1.15	44	19	10
.....	1.20	48	22	10
/570125	1.25	48	22	10
.....	1.30	48	22	10
.....	1.35	48	22	10
.....	1.40	48	22	10
.....	1.45	48	22	10
/570150	1.50	48	22	10
.....	1.55	48	22	10
.....	1.60	48	22	10
.....	1.65	51	25	10
.....	1.70	51	25	10
.....	1.75	51	25	10
.....	1.80	51	25	10
.....	1.85	51	25	10
.....	1.90	51	25	10
.....	1.95	51	25	10
/570200	2.00	51	25	10
/570205	2.05	54	29	10
.....	2.10	54	29	10
.....	2.15	54	29	10
.....	2.20	57	32	10
.....	2.25	57	32	10
.....	2.30	57	32	10
/570235	2.35	57	32	10
.....	2.40	60	35	10
.....	2.45	60	35	10
/570250	2.50	60	35	10
.....	2.60	64	37	10
.....	2.70	64	37	10
.....	2.80	67	38	10
/570290	2.90	70	41	10
/570300	3.00	70	41	10
/570310	3.10	70	41	10
.....	3.20	70	41	10
/570330	3.30	73	45	10
.....	3.40	73	45	10
/570350	3.50	73	45	10
.....	3.60	76	48	10
.....	3.70	76	48	10

No.	Dia. mm	Lgth. mm	Flute Lgth. mm	Pkg. Qty.
.....	3.80	76	48	10
.....	3.90	79	51	10
/570400	4.00	83	54	10
.....	4.10	83	54	10
/570420	4.20	83	54	10
.....	4.30	83	54	10
.....	4.40	86	56	10
/570450	4.50	86	56	10
.....	4.60	86	56	10
.....	4.70	89	59	10
.....	4.80	89	59	10
.....	4.90	92	62	10
/570500	5.00	92	62	10
.....	5.10	92	62	10
.....	5.20	95	64	10
.....	5.30	95	64	10
.....	5.40	95	64	10
/570550	5.50	95	64	10
.....	5.60	98	67	10
/570570	5.70	98	67	10
.....	5.80	98	67	10
.....	5.90	98	67	10
/570600	6.00	102	70	10
.....	6.10	102	70	10
.....	6.20	102	70	10
.....	6.30	102	70	10
.....	6.40	105	73	10
/570650	6.50	105	73	10
.....	6.60	105	73	10
/570670	6.70	105	73	10
.....	6.80	105	73	10
.....	6.90	105	73	10
/570700	7.00	105	73	10
/570710	7.10	108	75	10
/570720	7.20	108	75	10
.....	7.30	108	76	10
.....	7.40	111	78	5
/570750	7.50	111	78	5
.....	7.60	111	78	5
.....	7.70	114	81	5
.....	7.80	114	81	5
.....	7.90	114	81	5
/570800	8.00	114	81	5
.....	8.10	117	84	5
.....	8.20	117	84	5
.....	8.30	117	84	5
/570840	8.40	121	87	5
/570850	8.50	121	87	5
.....	8.60	121	87	5
.....	8.70	121	87	5
.....	8.80	124	89	5
.....	8.90	124	89	5
/570900	9.00	124	89	5
.....	9.10	124	89	5
.....	9.20	127	92	5
.....	9.30	127	92	5
.....	9.40	127	92	5
/570950	9.50	127	92	5
.....	9.60	130	95	5
.....	9.70	130	95	5
.....	9.80	130	95	5
.....	9.90	130	95	5
/5701000	10.00	130	95	5
/5701020	10.20	133	98	5
/5701050	10.50	133	98	5
.....	10.80	140	103	5
/5701100	11.00	140	103	5
.....	11.20	143	106	5
/5701150	11.50	143	106	5
.....	11.80	146	110	5
/5701200	12.00	148	111	5
.....	12.20	148	111	5
.....	12.50	152	114	5
.....	13.00	152	114	5
/5702250	22.50	152	114	5