

31-32 SERIES – SELF CENTERING CHUCKS

THE
BEST.

3 Jaw, Scroll-Type, Heavy Duty Oil & Gas Chucks



The 31– 32 Series are heavy duty, 3 jaw, self-centering Chucks suitable for pipe threading, large diameter shaft turning and other large diameter turning applications.

- Chuck sizes: 18"– 42" (457 mm – 1067 mm)
- Suitable for a wide range of Oil & Gas industry Workholding applications
- For direct mounting on Type A1/A2 spindle
- Forged steel body for maximum strength
- Large through-hole design

OIL & GAS

SCROLL-TYPE

HEAVY DUTY

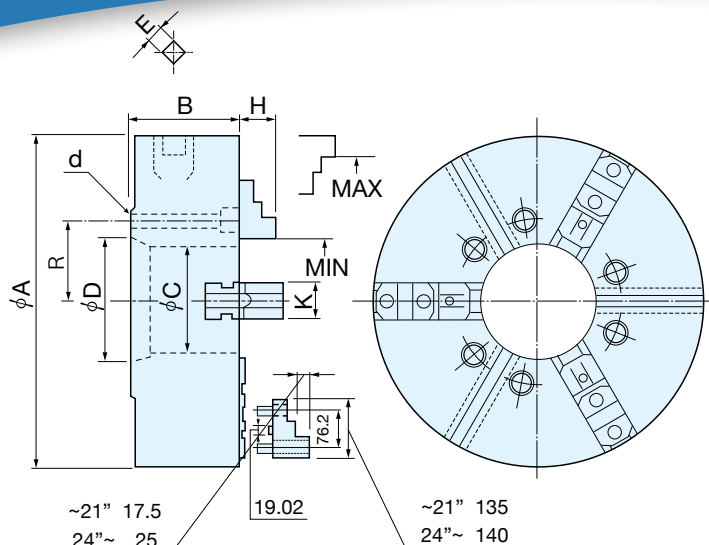
CHUCKS

kitagawa[®]
NORTHTECH
The Best Workholding.

31-32 SERIES TECHNICAL SPECIFICATIONS

THE BEST.

31- 32 Series Oil & Gas Self-Centering Chucks



MODEL	Spindle Nose	A		B		C		D		Gripping Range				R	
		(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	(mm)	(inch)	MIN		MAX		(mm)	(inch)
										(mm)	(inch)	(mm)	(inch)		
321-18-A8	A1•A2-8	457	18	140	5.51	115(130)	4.53(5.12)	139.7	5.5	65	2.6	430	16.9	85.7	3.37
311-18-A11	A1•A2-11	457	18	152	5.98	152(160)	5.98(6.3)	196.9	7.8	65	2.6	430	16.9	117.5	4.63
311-21-A11	A1•A2-11	535	21	152	5.98	152(160)	5.98(6.3)	196.9	7.8	80	3.1	490	19.3	117.5	4.63
311-21-A15	A1-15	535	21	152	5.98	204	8.03	285.8	11.3	90	3.5	490	19.3	123.8	4.87
311-24-A11	A1•A2-11	610	24	167	6.57	172(185)	6.77(7.28)	196.9	7.8	80	3.1	560	22	117.5	4.63
311-24-A15	A1•A2-11	610	24	167	6.57	241(259)	9.49(10.2)	285.8	11.3	90	3.5	560	22	165.1	6.5
311-24-A20	A1-20	610	24	167	6.57	266(280)	10.47(11.02)	412.8	16.3	90	3.5	560	22	184.2	7.25
311-28-A11	A1•A2-11	710	28	180	7.09	172(185)	6.77(7.28)	196.9	7.8	90	3.5	660	26	117.5	4.63
311-28-A15	A1•A2-15	710	28	180	7.09	241(259)	9.49(10.2)	285.8	11.3	110	4.3	660	26	165.1	6.5
311-28-A20	A1-20	710	28	180	7.09	318	12.52	412.8	16.3	150	5.9	660	26	184.2	7.25
311-32-A11	A1•A2-11	812	32	190	7.48	172(185)	6.77(7.28)	196.9	7.8	100	3.9	760	29.9	117.5	4.63
311-32-A15	A1•A2-15	812	32	190	7.48	266(275)	10.47(10.83)	285.8	11.3	150	5.9	760	29.9	165.1	6.5
311-32-A20	A1•A2-20	812	32	190	7.48	318(370)	12.52(14.57)	412.8	16.3	200	7.9	760	29.9	231.8	9.13
311-36-A15	A1•A2-15	915	36	200	7.87	266(275)	10.47(10.83)	285.8	11.3	150	5.9	860	33.9	165.1	6.5
311-36-A20	A1•A2-20	915	36	200	7.87	318(370)	12.52(14.57)	412.8	16.3	200	7.9	860	33.9	231.8	9.13

MODEL	Weight		Bolt for Top jaw		H		K		E		Gripping Force kN (kgf)	Max. Speed min-1 (r.p.m.)	d
	(kg)	(lb)			(mm)	(inch)	(mm)	(inch)	(mm)	(inch)			
	321-18-A8	145	320	M20	UNC3/4	75	2.95	50	1.97	19	0.75	63(6400)	1250
311-18-A11	170	376	M20	UNC3/4	75	2.95	60	2.36	19	0.75	68(6900)	1200	6-M20
311-21-A11	220	486	M20	UNC3/4	75	2.95	60	2.36	19	0.75	73(7400)	1000	6-M20
311-21-A15	210	464	M20	UNC3/4	75	2.95	60	2.36	19	0.75	73(7400)	1000	6-M22
311-24-A11	325	718	M20	UNC3/4	92	3.62	75	2.95	22	0.87	80(8200)	900	6-M20
311-24-A15	300	663	M20	UNC3/4	92	3.62	75	2.95	22	0.87	80(8200)	900	6-M22
311-24-A20	280	619	M20	UNC3/4	92	3.62	75	2.95	22	0.87	80(8200)	900	6-M24
311-28-A11	465	1028	M22	UNC7/8	92	3.62	75	2.95	22	0.87	83(8500)	650	6-M20
311-28-A15	440	972	M22	UNC7/8	92	3.62	75	2.95	22	0.87	83(8500)	650	6-M22
311-28-A20	410	906	M22	UNC7/8	92	3.62	75	2.95	22	0.87	83(8500)	650	6-M24
311-32-A11	645	1425	M22	UNC7/8	92	3.62	75	2.95	22	0.87	85(8700)	550	6-M20
311-32-A15	600	1326	M22	UNC7/8	92	3.62	75	2.95	22	0.87	85(8700)	550	6-M22
311-32-A20	585	1293	M22	UNC7/8	92	3.62	75	2.95	22	0.87	85(8700)	550	6-M24
311-36-A15	850	1879	M22	UNC7/8	92	3.62	75	2.95	22	0.87	85(8700)	450	6-M22
311-36-A20	810	1790	M22	UNC7/8	92	3.62	75	2.95	22	0.87	85(8700)	450	6-M24

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