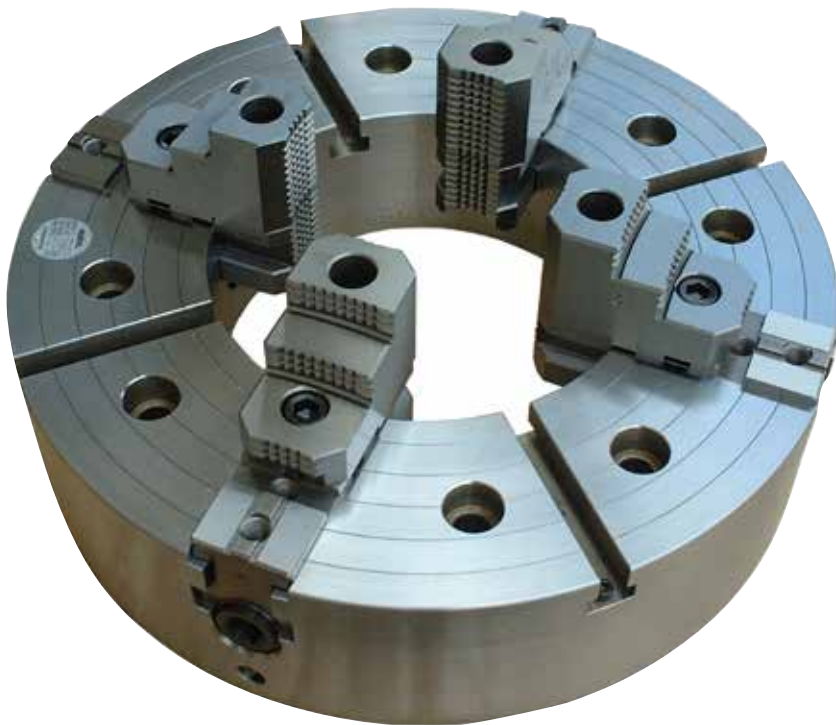


41-42 SERIES INDEPENDENT MANUAL CHUCKS

THE
BEST.

Heavy Duty 4 Jaw Independent Manual Chucks



The 41 – 42 Series is a heavy duty, forged steel, 4 Jaw Independent Manual Chuck designed for Oil & Gas applications. Suitable for pipe threading, large shaft turning and other large diameter turning applications.

- Heavy duty manual chucks with direct mount
- Popular for machining large, out of round and irregular shaped parts
- Chucks sizes: 18" – 42" (300 mm – 810 mm)
- Larger sizes are available upon request
- Forged steel body
- In stock at Kitagawa NorthTech in Schaumburg, Illinois

OIL & GAS

HEAVY DUTY

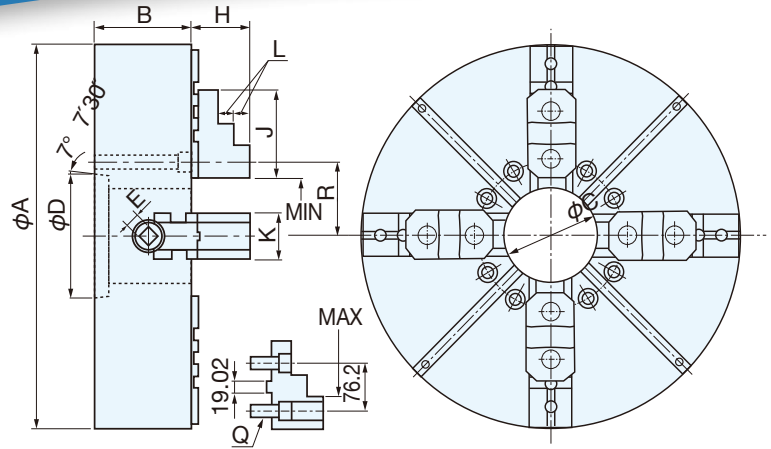
MANUAL

CHUCKS

kitagawa[®]
NORTHTECH
The Best Workholding.

41-42 SERIES TECHNICAL SPECIFICATIONS

THE BEST.



| MODEL | Spindle Nose | A | | B | | C | | D | | Gripping Range | | | | R | |
|------------|--------------|------|--------|------|--------|----------|------------|-------|--------|----------------|--------|------|--------|-------|--------|
| | | | | | | | | | | MIN | | MAX | | | |
| | | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) |
| 420-18-A8 | A1•A2-8 | 457 | 18 | 127 | 5.0 | 115 | 4.5 | 139.7 | 5.5 | 35 | 1.4 | 430 | 17 | 85.7 | 3.37 |
| 420-18-A11 | A1•A2-11 | 457 | 18 | 127 | 5.0 | 152 | 6.0 | 196.9 | 7.8 | 35 | 1.4 | 430 | 17 | 117.5 | 4.63 |
| 420-21-A8 | A1•A2-8 | 535 | 21 | 127 | 5.0 | 115 | 4.5 | 139.7 | 5.5 | 35 | 1.4 | 500 | 20 | 85.7 | 3.37 |
| 410-21-A11 | A1•A2-11 | 535 | 21 | 146 | 5.7 | 152(160) | 6.0(6.3) | 196.9 | 7.8 | 45 | 1.8 | 490 | 19 | 117.5 | 4.63 |
| 410-21-A15 | A1•A2-15 | 535 | 21 | 146 | 5.7 | 204 | 8.0 | 285.8 | 11.3 | 74 | 2.9 | 490 | 19 | 165.1 | 6.5 |
| 410-24-A11 | A1•A2-11 | 610 | 24 | 155 | 6.1 | 172(185) | 6.8(7.3) | 196.9 | 7.8 | 55 | 2.2 | 560 | 22 | 117.5 | 4.63 |
| 410-24-A15 | A1•A2-15 | 610 | 24 | 155 | 6.1 | 241(259) | 9.5(10.2) | 285.8 | 11.3 | 110 | 4.3 | 560 | 22 | 165.1 | 6.5 |
| 410-24-A20 | A1•A2-20 | 610 | 24 | 155 | 6.1 | 318 | 12.5 | 412.8 | 16.3 | 185 | 7.3 | 560 | 22 | 231.8 | 9.13 |
| 420-28-A11 | A1•A2-11 | 710 | 28 | 134 | 5.3 | 172 | 6.8 | 196.9 | 7.8 | 45 | 1.8 | 680 | 27 | 117.5 | 4.63 |
| 410-28-A15 | A1•A2-15 | 710 | 28 | 155 | 6.1 | 268(275) | 10.6(10.8) | 285.8 | 11.3 | 125 | 4.9 | 660 | 26 | 165.1 | 6.5 |
| 410-28-A20 | A1•A2-20 | 710 | 28 | 155 | 6.1 | 318 | 12.5 | 412.8 | 16.3 | 175 | 6.9 | 660 | 26 | 231.8 | 9.13 |
| 420-32-A11 | A1•A2-11 | 810 | 32 | 134 | 5.3 | 172 | 6.8 | 196.9 | 7.8 | 45 | 1.8 | 780 | 31 | 117.5 | 4.63 |
| 410-32-A15 | A1•A2-15 | 810 | 32 | 165 | 6.5 | 268(275) | 10.6(10.8) | 285.8 | 11.3 | 125 | 4.9 | 760 | 30 | 165.1 | 6.5 |
| 410-32-A20 | A1•A2-20 | 812 | 32 | 165 | 6.5 | 318(370) | 12.5(14.6) | 412.8 | 16.3 | 175 | 6.9 | 760 | 30 | 231.8 | 9.13 |
| 410-36-A15 | A1•A2-15 | 915 | 36 | 175 | 6.9 | 268(275) | 10.6(10.8) | 285.8 | 11.3 | 125 | 4.9 | 860 | 34 | 165.1 | 6.5 |
| 410-36-A20 | A1•A2-20 | 915 | 36 | 175 | 6.9 | 318(370) | 12.5(14.6) | 412.8 | 16.3 | 175 | 6.9 | 860 | 34 | 231.8 | 9.13 |
| 410-42-A15 | A1•A2-15 | 1067 | 42 | 175 | 6.9 | 268(275) | 10.6(10.8) | 285.8 | 11.3 | 125 | 4.9 | 1010 | 40 | 165.1 | 6.5 |
| 410-42-A20 | A1•A2-20 | 1067 | 42 | 175 | 6.9 | 318(370) | 12.5(14.6) | 412.8 | 16.3 | 175 | 6.9 | 1010 | 40 | 231.8 | 9.13 |

| MODEL | Weight | | E | | Q | | J | | K | | H | | d | Wrench Torque | Gripping Force per Jaw | Max. Speed |
|------------|--------|------|------|--------|------------------|--------|--------|------|--------|------|--------|-------------|-------|---------------|------------------------|------------|
| | (kg) | (lb) | (mm) | (inch) | Bolt for Top jaw | (mm) | (inch) | (mm) | (inch) | (mm) | (inch) | N•m (kgf•m) | | kN (kgf) | min-1(r.p.m.) | |
| | | | | | | | | | | | | | | | | |
| 420-18-A8 | 165 | 365 | 16 | 0.63 | M20 | UNC3/4 | 135 | 5.3 | 50 | 1.97 | 75 | 2.95 | 4-M16 | 314(32) | 29(3000) | 1200 |
| 420-18-A11 | 156 | 345 | 16 | 0.63 | M20 | UNC3/4 | 135 | 5.3 | 50 | 1.97 | 75 | 2.95 | 4-M20 | 314(32) | 29(3000) | 1200 |
| 420-21-A8 | 225 | 497 | 16 | 0.63 | M20 | UNC3/4 | 135 | 5.3 | 50 | 1.97 | 75 | 2.95 | 4-M16 | 314(32) | 29(3000) | 1000 |
| 410-21-A11 | 240 | 530 | 19 | 0.75 | M20 | UNC3/4 | 135 | 5.3 | 60 | 2.36 | 75 | 2.95 | 8-M20 | 343(35) | 31(3200) | 1000 |
| 410-21-A15 | 230 | 508 | 19 | 0.75 | M20 | UNC3/4 | 135 | 5.3 | 60 | 2.36 | 75 | 2.95 | 8-M21 | 343(35) | 31(3200) | 1000 |
| 410-24-A11 | 342 | 756 | 22 | 0.87 | M20 | UNC3/4 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M22 | 392(40) | 36(3700) | 850 |
| 410-24-A15 | 310 | 685 | 22 | 0.87 | M20 | UNC3/4 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M23 | 392(40) | 36(3700) | 850 |
| 410-24-A20 | 278 | 614 | 22 | 0.87 | M20 | UNC3/4 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M24 | 392(40) | 36(3700) | 850 |
| 420-28-A11 | 390 | 862 | 19 | 0.75 | M20 | UNC3/4 | 135 | 5.3 | 60 | 2.36 | 75 | 2.95 | 8-M25 | 392(40) | 36(3700) | 650 |
| 410-28-A15 | 430 | 950 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M26 | 441(45) | 40(4100) | 650 |
| 410-28-A20 | 395 | 873 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M27 | 441(45) | 40(4100) | 650 |
| 420-32-A11 | 510 | 1127 | 19 | 0.75 | M20 | UNC3/4 | 135 | 5.3 | 60 | 2.36 | 75 | 2.95 | 8-M28 | 392(40) | 36(3700) | 550 |
| 410-32-A15 | 595 | 1315 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M29 | 441(45) | 40(4100) | 550 |
| 410-32-A20 | 565 | 1249 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M30 | 441(45) | 40(4100) | 550 |
| 410-36-A15 | 820 | 1812 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M31 | 490(50) | 44(4500) | 500 |
| 410-36-A20 | 790 | 1746 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M32 | 490(50) | 44(4500) | 500 |
| 410-42-A15 | 1150 | 2542 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M33 | 490(50) | 44(4500) | 400 |
| 410-42-A20 | 1120 | 2475 | 22 | 0.87 | M22 | UNC7/8 | 135 | 5.5 | 75 | 2.95 | 92 | 3.62 | 8-M34 | 490(50) | 44(4500) | 400 |

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