

ASME B5.60-2014
(Revision of ASME B5.60-2002)

Workholding Chucks: Jaw-Type Chucks

AN AMERICAN NATIONAL STANDARD



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Mechanical Engineers**

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CONTENTS

Foreword	v
Committee Roster	vi
Correspondence With the B5 Committee	vii
1 General Description and Definitions of Terms	1
2 Chuck-to-Spindle Interface	4
3 Jaw Mountings	37
4 Performance Testing	69
5 Safety Code of Practice	74
Figures	
1-1 Example of a Power Chuck Assembly	2
1-2 Exploded View of a Typical Manual Chuck	3
1-3 Exploded View of a Power Chuck	3
2-1 Type A Spindle Location of Holes and Drive Button for Sizes A-5 Through A-11	6
2-2 Type A Spindle Location of Holes and Drive Button for Sizes A-15 Through A-28	7
2-3 Type A Spindle Dimensions for Sizes A-3 Through A-28 and Location of Holes and Drive Button for Sizes A2-3 and A2-4	8
2-4 Type C Spindle	10
2-5 Type C Spindle Location of Holes	11
2-6 Type D Spindle	13
2-7 Type A Spindle	14
2-8 Type D Spindle Location of Holes for Size D-3	15
2-9 Type D Spindle Location of Holes for Size D-4	16
2-10 Type D Spindle Location of Holes for Sizes D-5 Through D-20	17
2-11 Type D Spindle Cam for Size D-3	18
2-12 Type D Spindle Cam for Size D-4	19
2-13 Type D Spindle Cam for Sizes D-5 Through D-20	20
2-14 Type D Spindle Detent and Cam Screws	21
2-15 Type D Spindle Detent and Cam Springs	21
2-16 Type D Spindle Detent Plunger	21
2-17 Type A Chucks and Faceplates	25
2-18 Type A Chuck and Faceplate Dimensions	26
2-19 Type C Chucks and Faceplates	28
2-20 Type C Chuck and Faceplate Dimensions	29
2-21 Type D Chucks and Faceplates	31
2-22 Types D-3 and D-4 Backs of Chucks and Faceplates	32
2-23 Types D-5 Through D-20 Backs of Chucks and Faceplates	33
2-24 Type D Cam Lock Studs and Stud Locking Screw	34
Fastener Guidelines	38
3-2 Jaw Interface Flatness Guidelines	39
4-1 Spindle Verification Test for Chuck Mounted Directly on the Test Spindle	69
4-2 Spindle Verification Test for Chuck Mounted on an Adapter	70
4-3 Geometric Tests	70
4-4 Manual-Scroll Chucks: Checking Centering Accuracy and Repeatability of Outside-Diameter Grip	71
4-5 Manual-Scroll Chucks: Checking Centering Accuracy and Repeatability of Jaw Steps	72

4-6	Power Chucks: Checking Centering Accuracy and Repeatability for External Chucking	72
4-7	Power Chucks: Checking Centering Accuracy and Repeatability for Internal Chucking	73

Forms

5-1	Sample Maintenance Schedule Sheet	77
5-2	Sample Grip Force Log Sheet	78

Tables

2-1	Type A Spindle Dimensions	9
2-2	Type C Spindle Dimensions	12
2-3	Type D Spindle Dimensions	22
2-4	Type D Spindle Cam Dimensions	23
2-5	Type D Spindle Detent and Cam Screws Dimensions	24
2-6	Type D Spindle Detent and Cam Spring Dimensions	24
2-7	Type D Spindle Detent Plunger Dimensions	24
2-8	Type A Chuck and Faceplate Dimensions	27
2-9	Type C Chuck and Faceplate Dimensions	30
2-10	Type D Chuck and Faceplate Dimensions	35
2-11	Type D Chuck and Faceplate Stud Dimensions	36
2-12	Type D Chuck and Faceplate Stud Locking Screw Dimensions	36
3-1	Top-Jaw Features	40
3-2	Tongue and Groove, Medium Duty Chucks, Wrench Operated	42
3-3	Tongue and Groove, Medium Duty Chucks, Three-Step Reversible Top Jaw, Wrench Operated	44
3-4	Tongue and Groove, Heavy Duty Chucks, Wrench Operated	45
3-5	Tongue and Groove, Heavy Duty Chucks, Three-Step Reversible Top Jaw, Wrench Operated	47
3-6	Tongue and Groove, Heavy Duty Chucks, Drawbar Operated	48
3-7	Metric Tongue and Groove Chucks, Master Jaw	50
3-8	Square Serrated, Heavy Duty Chucks, Wrench or Drawbar Operated	51
3-9	Square Serrated, Heavy Duty Chucks, Top-Jaw Master Key	52
3-10	Square Serrated, Heavy Duty Chucks, Master Jaw Nut	53
3-11	Square Serrated, Heavy Duty Chucks, Three-Step Reversible Top Jaw	54
3-12	Acme Serrated, Heavy Duty Chucks, Power Wrench or Drawbar Operated	55
3-13	Acme Serrated, Master Key	56
3-14	Acme Serrated, Jaw Nut	57
3-15	Acme Serrated, Three-Step Reversible Top Jaw	58
3-16	90 deg Serrated Jaw Interface (Inch), Serration Data	59
3-17	90 deg Serrated Jaw Interface (Inch), Accumulated Pitch Variation	60
3-18	60 deg Serrated Jaw Interface (Metric), Serration Data	61
3-19	60 deg Serrated Jaw Interface (Metric), Accumulated Pitch Variation	62
3-20	60 deg Metric and 90 deg Inch Serrated Jaws and Jaw-Nut Interface	63
3-21	1.5 mm x 60 deg Serrated Top Jaw (Metric)	64
3-22	Pin Locator Chucks, Master Jaw	65
3-23	Ball Style Chucks, Master Jaw	66
3-24	Ball Style Chucks, Top Jaw	67
3-25	Ball Style Chucks, Jaw Nut	68

Mandatory Appendix

I	Calculation of Force, Torque, and Speed	79
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Nonmandatory Appendix

A	Legacy Data	83
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FOREWORD

During the review, revision, and update of the existing inch-based American National Standard B5.8 on Chucks and Chuck Jaws, Technical Committee 11 of the ASME B5 Committee on Machine Tools recognized the need for an industry standard on metric-dimensioned chucks.

This Standard was developed after reviewing currently available national and international standards, which were used as its foundation.

ASME B5.60-2002 was approved by the American National Standards Institute on June 6, 2002. Addenda were approved on February 24, 2005 and February 2, 2009.

ASME B5.60-2014 was approved by the American National Standards Institute on September 15, 2014.

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Machine Tools — Components, Elements, Performance, and Equipment

(The following is the roster of the Committee at the time of approval of this Standard.)

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Edition: Cite the applicable edition of the Standard for which the interpretation is being requested.
Question: Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

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WORKHOLDING CHUCKS: JAW-TYPE CHUCKS

Chapter 1 General Description and Definitions of Terms

1-1 INTRODUCTION

This Standard establishes technical requirements for workholding chucks used primarily in turning operations. It covers jaw-type chucks, whether manual or power-operated.

1-2 SCOPE

This Chapter covers the general description and definitions of terms related to jaw-type workholding chucks.

1-3 TYPES OF JAW CHUCKS BY DESIGN

compensating chuck: a chuck in which the jaw(s) moves to or away from the workpiece without altering the position of the workpiece.

independent chuck: a chuck in which each individual workholding jaw is moved to or from the workpiece without disturbing the position of any other jaw.

self-centering chuck: a chuck in which all jaws move to or away from the workpiece and maintain one common center.

An example of a power chuck assembly is presented in Fig. 1-1.

1-4 METHODS OF ACTUATION

manual: a chuck that is actuated by hand with the aid of human energy (e.g., by means of a chuck wrench). Refer to Fig. 1-2.

power: a chuck that is actuated by means of, e.g., pneumatic, hydraulic, or electrical energy. Refer to Fig. 1-3.

1-5 DEFINITIONS

actuator: a component within a chuck's body, used to operate the chuck's mechanism, e.g., a wedge, lever, or scroll.

base jaw: see *master jaw*.

centrifugal force: force generated by rotation that tends to move all parts radially away from the axis of rotation of the chuck.

chuck adapter: interface between the machine and the chuck. It can be a separate component or integral to the chuck body.

chuck body: that part of the chuck that contains the actuator and master jaws.

clamping cylinder: device that actuates the chuck through a drawbar or drawtube with the aid of pneumatic or hydraulic energy.

clamping force: algebraic sum of the individual radial forces applied by the top jaws on the workpiece.

clamping torque: product of the clamping force, clamping radius, and the coefficient of friction between the top jaw(s) and the workpiece.

countercentrifugal chuck: a chuck in which there is a system that permits compensation for the loss of clamping force due to centrifugal force.

drawbar: a bar or tube that connects the clamping cylinder to the chuck's actuator to transmit the input force to the chuck.

dynamic clamping force: actual clamping force when the chuck is rotating.

hysteresis: change in static clamping force after the chuck has been rotated at working rotational speed with a constant input force.

indicating band: a diameter on the chuck body designated for measuring runout of a chuck.

input force: force acting on the chuck's actuator, applied from an external energy source.

input torque: torque acting on the chuck's actuator, applied from an external energy source.

master jaw: radial moving part within the chuck body to which the top jaw is mounted.

maximum rotational speed: maximum rotational speed in rpm specified by the manufacturer for a chuck with