

# ADJUSTABLE

## THREE JAW SCROLL CHUCKS WITH TOP REVERSIBLE JAWS

### QU® ADJ

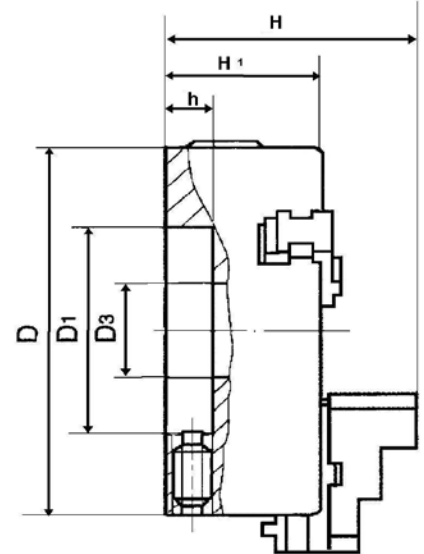
**.0005" repeatability on duplicate parts.** This accuracy is possible by having a clearance of .020" between the chuck cavity and the mounting plate hub. Opposing adjusting screws allow alignment to adjust work to "dead true" accuracy and repeatability on duplicate parts. With proper care QU® Chucks useful life is approximately 2.5 times longer than standard self centering scroll chucks.

### SUPPLIED WITH:

Chuck - Hardend Scroll,  
Master Jaws and Top Jaws  
T-Wrench  
Mounting Screws

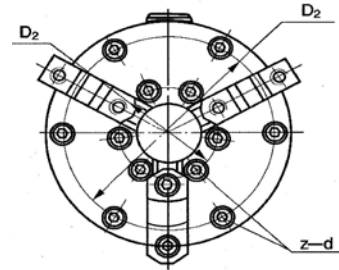
### OPTIONS:

Backplates (page 8)



### WORKHOLDING CAPACITIES AND MAXIMUM RPM LIMITS

SIZE	MODEL	OD MIN	OD MAX	ID MIN	ID MAX	MAX RPM
4"	1043	0.031	3.640	1.031	3.500	3600
5"	1053R	0.118	5.000	1.575	4.724	3200
6"	1063R	0.125	6.000	1.875	5.750	3000
8"	1083R	0.200	8.250	2.125	6.750	2500
10"	1103R	0.500	9.360	2.937	8.718	2000
12"	1123R	0.500	11.312	3.281	10.125	1500
15"	1153R	0.562	15.000	4.000	15.748	1000
21"	1213R	1.5000	21.000	4.750	20.250	800



### PRINCIPAL SPECIFICATIONS

SIZE	MODEL	WEIGHT	D	D1	D2	D3	H	H1	h	z-d
4" <sub>2</sub>	1043	10	4.000	2.750	3.530	1.040	3.130	2.380	0.420	10-32
5" <sub>2</sub>	1053R	15	5.000	2.716	4.438	1.299	3.768	2.205	0.657	1/4-20
6" <sub>2</sub>	1063R	19	6.000	3.125	5.343	1.535	3.882	2.323	0.689	1/4-20
8" <sub>2</sub>	1083R	50	8.270	4.750	7.500	2.264	5.206	3.122	0.752	3/8-16
10" <sub>1</sub>	1103R	70	10.000	6.374	4.375	2.835	6.056	3.492	0.803	7/16-14
12" <sub>1</sub>	1123R	116	12.000	7.905	5.250	3.268	6.569	3.980	0.803	1/2-13
15" <sub>1</sub>	1153R	200	15.000	11.781	6.750	4.252	8.799	5.362	1.063	5/8-11
21" <sub>1</sub>	1213R	395	21.000	16.030	9.250	5.275	9.520	6.250	1.188	3/4-10

<sub>1</sub> Inner Mtg. Holes D2    <sub>2</sub> Outer Mtg. Holes D2

### CHUCKS WITH 5C and MORSE TAPER MOUNTS

SIZE	MODEL 3 Jaw	MODEL 6 Jaw	O.A. Length	MTG
4"	10435C		7.091	5C
5"	1053R5C		7.788	5C
6"	1063R5C	1066R5C	7.902	5C
5"	1053R3MT		7.788	3MT
5"	1053R4MT		7.788	4MT
6"	1063R5MT	1066R5MT	7.902	5MT

**.0005" repeatability on duplicate parts.**



# ADJUSTABLE

## SIX JAW SCROLL CHUCKS WITH TOP REVERSIBLE JAWS

### QU® ADJ

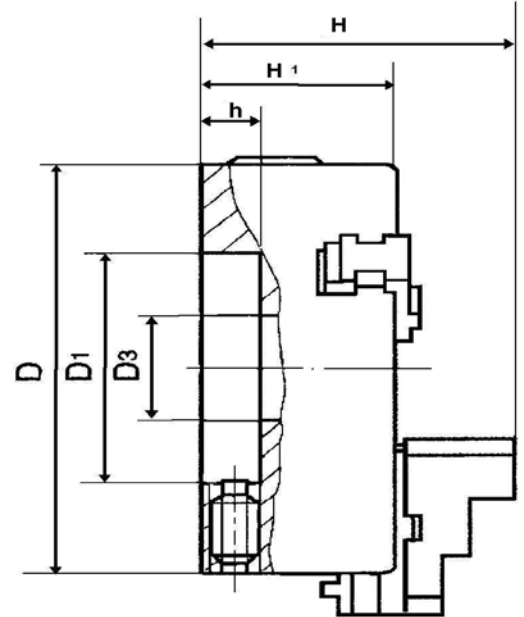
**.0005" repeatability on duplicate parts.** This accuracy is possible by having a clearance of .020" between the chuck cavity and the mounting plate hub. Opposing adjusting screws allow alignment to adjust work to "dead true" accuracy and repeatability on duplicate parts. With proper care QU® Chucks useful life is approximately 2.5 times longer than standard self centering scroll chucks.

### SUPPLIED WITH:

Chuck - Hardend Scroll,  
Master Jaws and Top Jaws  
T-Wrench  
Mounting Screws

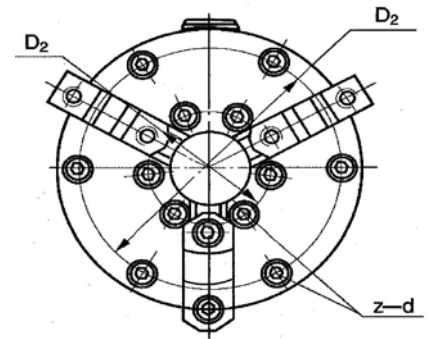
### OPTIONS:

Backplates (page 8)



### WORKHOLDING CAPACITIES AND MAXIMUM RPM LIMITS

SIZE	MODEL	OD MIN	OD MAX	ID MIN	ID MAX	MAX RPM
6"	<a href="#">1066R</a>	0.200	6.000	1.875	5.750	2200
8"	<a href="#">1086R</a>	0.425	8.250	2.125	6.750	1900
10"	<a href="#">1106R</a>	0.625	9.360	2.937	8.718	1500
12"	<a href="#">1126R</a>	0.775	11.312	3.281	10.125	1100
15"	<a href="#">1156R</a>	0.875	15.000	4.000	15.748	1000



### Solid Soft Jaws Now Available for ADJ 3 and 6 Jaw Chucks

#### 3 Jaw

SIZE	MODEL
6"	<a href="#">630-9</a>
8"	<a href="#">830-9</a>
10"	<a href="#">103-9</a>
12"	<a href="#">123-9</a>
15"	<a href="#">153-9</a>

#### 6 Jaw 60° Point

SIZE	MODEL
6"	<a href="#">660-9</a>
8"	<a href="#">860-9</a>
10"	<a href="#">106-9</a>
12"	<a href="#">126-9</a>



### PRINCIPAL SPECIFICATIONS

SIZE	MODEL	WEIGHT	D	D1	D2	D3	H	H1	h	z-d
6" <sub>2</sub>	<a href="#">1066R</a>	19	6.000	3.125	5.343	1.535	3.882	2.323	0.689	1/4-20
8" <sub>2</sub>	<a href="#">1086R</a>	50	8.270	4.750	7.500	2.264	5.206	3.122	0.752	3/8-16
10" <sub>1</sub>	<a href="#">1106R</a>	70	10.000	6.374	4.375	2.835	6.056	3.492	0.803	7/16-14
12" <sub>1</sub>	<a href="#">1126R</a>	116	12.000	7.905	5.250	3.268	6.569	3.980	0.803	1/2-13
15" <sub>1</sub>	<a href="#">1156R</a>	200	15.000	11.781	6.750	4.252	8.799	5.362	1.063	5/8-11

<sub>1</sub> Inner Mtg. Holes D2

<sub>2</sub> Outer Mtg. Holes D2

# ADJUSTABLE - STEEL FORGED STEEL BODY

## THREE JAW SCROLL CHUCKS WITH TOP REVERSIBLE JAWS

### QU® ADJ

.0005" repeatability on duplicate parts. This accuracy is possible by having a clearance of .020" between the chuck cavity and the mounting plate hub. Opposing adjusting screws allow alignment to adjust work to "dead true" accuracy and repeatability on duplicate parts.

### ADJ STEEL FEATURES:

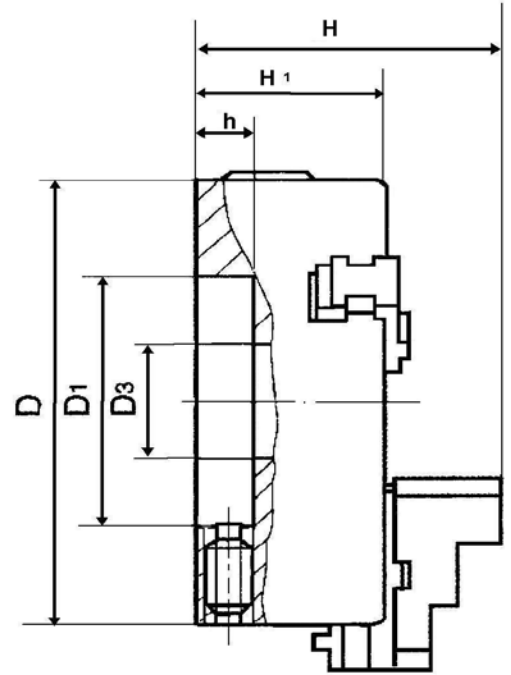
- Forged steel for higher speeds.
- Scroll hardened ground and balanced.
- Jaws ground and hardened.
- Fits all standard QU mounting plates.
- All QU chuck jaws are:  
American Standard tongue and groove.

### SUPPLIED WITH:

Chuck  
Master Jaws and Top Jaws  
T-Wrench  
Mounting Screws

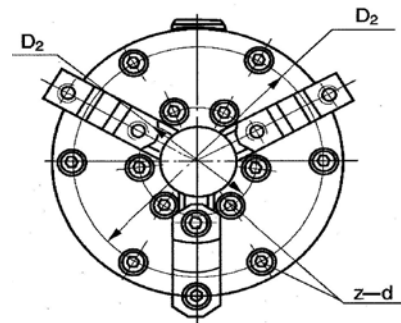
### OPTIONS:

Backplates (page 8)



### WORKHOLDING CAPACITIES AND MAXIMUM RPM LIMITS

SIZE	MODEL	OD MIN	OD MAX	ID MIN	ID MAX	MAX RPM
4"	<b>S1043</b>	0.031	3.640	1.031	3.500	4200
5"	<b>S1053R</b>	0.118	5.000	1.575	4.724	3800
6"	<b>S1063R</b>	0.125	6.000	1.875	5.750	3500
8"	<b>S1083R</b>	0.200	8.250	2.125	6.750	3100
10"	<b>S1103R</b>	0.500	9.360	2.937	8.718	2700
12"	<b>S1123R</b>	0.500	11.312	3.281	10.125	2200
15"	<b>S1153R</b>	0.562	15.000	4.000	17.748	1800



### PRINCIPAL SPECIFICATIONS

SIZE	MODEL	WEIGHT	D	D1	D2	D3	H	H1	h	z-d
4"	<b>S1043</b>	11	4.000	2.750	3.530	1.040	3.130	2.380	0.420	10-32
5"	<b>S1053R</b>	16	5.000	2.716	4.438	1.299	3.768	2.205	0.657	1/4-20
6" <sub>2</sub>	<b>S1063R</b>	22	6.000	3.125	5.343	1.535	3.882	2.323	0.689	1/4-20
8" <sub>2</sub>	<b>S1083R</b>	52	8.270	4.750	7.500	2.264	5.206	3.122	0.752	3/8-16
10" <sub>1</sub>	<b>S1103R</b>	73	10.000	6.374	4.375	2.835	6.056	3.492	0.803	7/16-14
12" <sub>1</sub>	<b>S1123R</b>	120	12.000	7.905	5.250	3.268	6.569	3.980	0.803	1/2-13
15" <sub>1</sub>	<b>S1153R</b>	200	15.000	11.781	6.750	4.252	8.799	5.362	1.063	5/8-11

<sub>1</sub> Inner Mtg. Holes D2

<sub>2</sub> Outer Mtg. Holes D2

# ADJUSTABLE - STEEL

## FORGED STEEL BODY

### SIX JAW SCROLL CHUCKS WITH TOP REVERSIBLE JAWS

#### QU® ADJ

.0005" repeatability on duplicate parts. This accuracy is possible by having a clearance of .020" between the chuck cavity and the mounting plate hub. Opposing adjusting screws allow alignment to adjust work to "dead true" accuracy and repeatability on duplicate parts.

#### ADJ STEEL FEATURES:

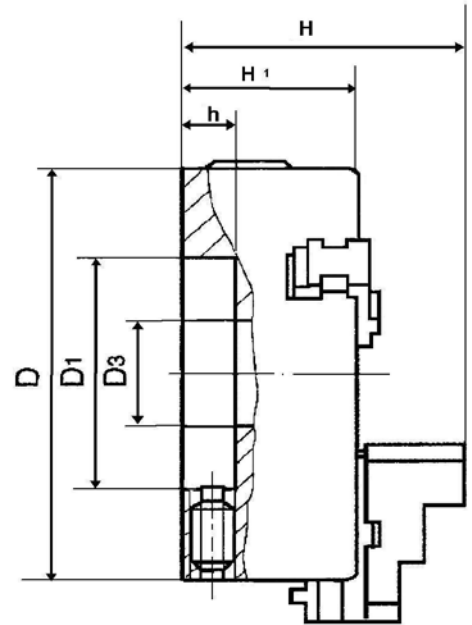
- Forged steel for higher speeds.
- Scroll hardened ground and balanced.
- Jaws ground and hardened.
- Fits all standard QU mounting plates.
- All QU chuck jaws are:  
American Standard tongue and groove.

#### SUPPLIED WITH:

Chuck  
Master Jaws and Top Jaws  
T-Wrench  
Mounting Screws

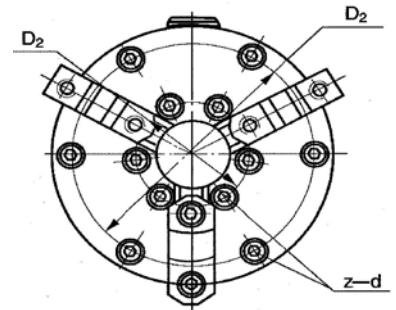
#### OPTIONS:

Backplates (page 8)



#### WORKHOLDING CAPACITIES AND MAXIMUM RPM LIMITS

SIZE	MODEL	OD MIN	OD MAX	ID MIN	ID MAX	MAX RPM
6"	S1066R	0.200	6.000	1.875	5.750	2500
8"	S1086R	0.425	8.250	2.125	6.750	2200
10"	S1106R	0.625	9.360	2.937	8.718	1900
12"	S1126R	0.775	11.312	3.281	10.125	1500
15"	S1156R	0.875	15.000	4.000	15.748	1300



#### Solid Soft Jaws Now Available for ADJ 3 and 6 Jaw Chucks

3 Jaw

SIZE	MODEL
6"	630-9
8"	830-9
10"	103-9
12"	123-9
15"	153-9

6 Jaw 60° Point

SIZE	MODEL
6"	660-9
8"	860-9
10"	106-9
12"	126-9



#### PRINCIPAL SPECIFICATIONS

SIZE	MODEL	WEIGHT	D	D1	D2	D3	H	H1	h	z-d
6" <sub>2</sub>	S1066R	22	6.000	3.125	5.343	1.535	3.882	2.323	0.689	1/4-20
8" <sub>2</sub>	S1086R	52	8.270	4.750	7.500	2.264	5.206	3.122	0.752	3/8-16
10" <sub>1</sub>	S1106R	73	10.000	6.374	4.375	2.835	6.056	3.492	0.803	7/16-14
12" <sub>1</sub>	S1126R	120	12.000	7.905	5.250	3.268	6.569	3.980	0.803	1/2-13
15" <sub>1</sub>	S1156R	200	15.000	11.781	6.75	4.252	8.799	5.362	1.063	5/8-11

<sub>1</sub> Inner Mtg. Holes D2

<sub>2</sub> Outer Mtg. Holes D2

## ADJ MOUNTING PLATES

QU® mountings are designed for the easiest possible installation. They also minimize overhang by using our ADJ recessed design. All QU mountings are interchangeable on the same size chuck. Fits all forged steel and semi steel ADJ chucks

### AMERICAN STANDARD FLANGE NOSE - TYPE A

Spindle Nose	"A" Dia.	Chuck Size							
		4"	5"	6"	8 1/4"	10"	12"	15"	21"
A-3	2.130	AS-318	AS-300						
A-4	2.500	AS-319	AS-304	AS-301	AS-306				
A-5	3.250		AS-305	AS-302	AS-307	AS-311	AS-314		
A-6	4.190			AS-303	AS-308	AS-312	AS-315	AS-343	
A-8	5.500			AS-310	AS-309	AS-313	AS-316	AS-344	AS-351
A-11	7.750						AS-317	AS-349	AS-350
A-15	11.250							AS342	AS-352



### CAMLOCK - TYPE D

Spindle Nose	"A" Dia.	Chuck Size							
		4"	5"	6"	8 1/4"	10"	12"	15"	21"
D-3	2.130	CD-216	CD-205	CD-203	CD-220				
D-4	2.500	CD-217	CD-221	CD-201	CD-204	CD-219			
D-5	3.250			CD-202	CD-208	CD-210	CD-213		
D-6	4.190			CD-206	CD-209	CD-211	CD-214	CD-238	
D-8	5.500			CD-247	CD-207	CD-212	CD-215	CD-267	CD-271
D-11	7.750						CD-273	CD-266	CD-272
D-15	11.251								CD-273



### LONG TAPER KEY DRIVE - TYPE L

Spindle Nose	"A" Dia.	Chuck Size					
		5"	6"	8 1/4"	10"	12"	15"
L-00	2.750	LT-103	LT-100	LT-108	LT-111		
L-0	3.250	LT-104	LT-101	LT-109	LT-112	LT-115	
L-1	4.130			LT-110	LT-113	LT-116	LT-176
L-2	5.250					LT-117	LT-177
L-3	6.500						LT-178



### HARDINGE® STYLE MOUNTING PLATES

Spindle Nose	Mounting Number	Chuck Size	Chuck Number	Spindle Nose	Mounting Number	Chuck Size	Chuck Number
4° Taper	HS-120	5"-3 JAW	1053R	2 3/16-10	HK-790	5"-3 JAW	1053R
4° Taper	HS-357	6"-3 JAW	1063R	2 3/16-10	HK-276	6"-3 JAW	1063R
4° Taper	HS-357	6"-6 JAW	1066R	2 3/16-10	HK-276	6"-6 JAW	1066R
4° Taper	HS-362	6"-4 JAW	4064	2 3/16-10	HK-673	6"-4 JAW	4064



### THREADED MOUNTING PLATES

Spindle Nose	"A" Dia.	Chuck size				
		5"	6"	8 1/4"	10"	12"
1 1/2-8	1.500	TH-903	TH-950			
1 3/4-8	1.750	TH-904	TH-951			
2 1/4-8	2.250		TH-955	TH-985	TH-994	
2 3/8-6	2.375		TH-958	TH-986	TH-995	TH-997
2 3/4-8	2.750				TH-989	TH-999



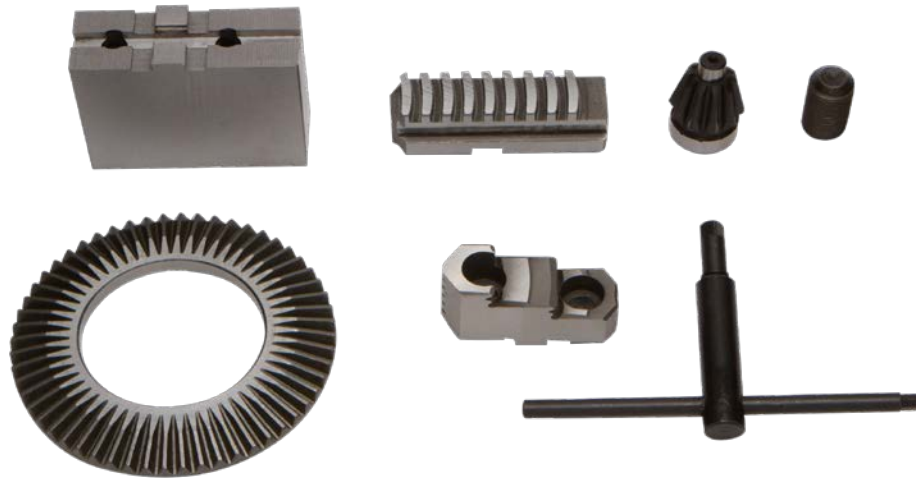
### ROTARY TABLE PLATES

Rotary Table	Mounting Number	Chuck Size	Chuck Number
HRT-160	AS-160-H	6" 3-Jaw	1063R
	J4-160-H	6" 4-Jaw	4064
HRT-210	AS-210-H	8" 3-Jaw	1083R
	J4-210-H	8" 4-Jaw	4084
HRT-310	AS-310-H	12" 3-Jaw	1123R
	J4-310-H	12" 4-Jaw	4124



Rotary table plates available for other models

# REPLACEMENT PARTS AND JAWS FOR ADJ CHUCKS



## 3 Jaw Chucks

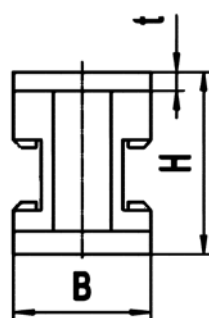
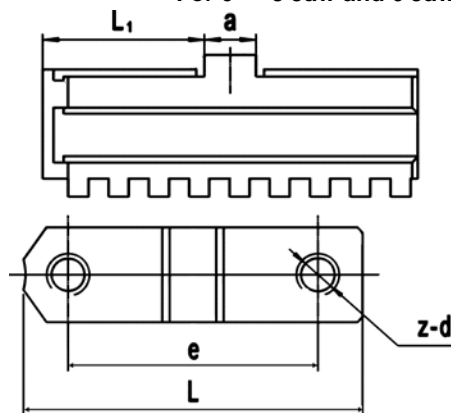
CHUCK SIZE	CHUCK MODEL	HARD TOP JAW SET	SOFT TOP JAW SET	MASTER JAW SET	CHUCK			ZERO SET SCREW	CHUCK WRENCH
					BODY	SCROLL	PINION		
4"	<a href="#">1043</a>	N/A	N/A	N/A	430-8	430-1	430-2	430-4	430-3
5"	<a href="#">1053R</a>	530-7	530-0	530-6	530-8	530-1	530-2	530-4	530-3
6"	<a href="#">1063R</a>	630-7	630-0	630-6	630-8	630-1	630-2	630-4	630-3
8"	<a href="#">1083R</a>	830-7	830-0	830-6	830-8	830-1	830-2	830-4	830-3
10"	<a href="#">1103R</a>	103-7	103-0	103-6	103-8	103-1	103-2	103-4	103-3
12"	<a href="#">1123R</a>	123-7	123-0	123-6	123-8	123-1	123-2	123-4	123-3
15"	<a href="#">1153R</a>	153-7	153-0	153-6	153-8	153-1	153-2	153-4	153-3
21"	<a href="#">1213R</a>	213-7	213-0	213-6	213-8	213-1	213-2	213-4	213-3

## 6 Jaw Chucks

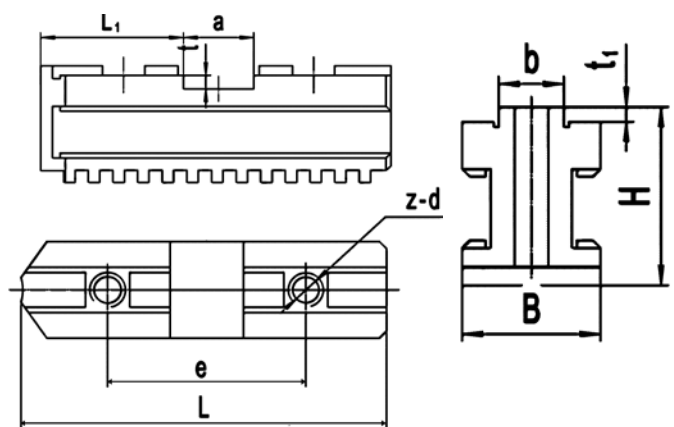
6"	<a href="#">1066R</a>	660-7	660-0	660-6	660-8	660-1	660-2	660-4	660-3
8"	<a href="#">1086R</a>	860-7	860-0	860-6	860-8	860-1	860-2	860-4	860-3
10"	<a href="#">1106R</a>	106-7	106-0	106-6	106-8	106-1	106-2	106-4	106-3
12"	<a href="#">1126R</a>	126-7	126-0	126-6	126-8	126-1	126-2	126-4	126-3
15"	<a href="#">1156R</a>	156-7	156-0	156-6	156-8	156-1	156-2	156-4	156-3

LONG HANDLED HEX KEYS AVAILABLE FOR 10, 12 INCH CHUCKS - PART # 103-5

For 6" - 3 Jaw and 6 Jaw ADJ Chucks



For other ADJ Chucks



SIZE	MODEL	L	L1	B	H	t	t1	a	b	e	z - d
5"	<a href="#">1053R</a>	2.008	0.784	0.629	1.023	0.157	0.118	0.499	0.313	1.250	5/16 - 18
6"	<a href="#">1063R</a>	2.500	1.063	0.736	1.000	0.098	0.098	0.375	0.736	1.686	5/16 - 18
8"	<a href="#">1083R</a>	3.504	1.319	0.952	1.260	0.157	0.118	0.499	0.313	1.748	3/8 - 16
10"	<a href="#">1103R</a>	3.622	1.531	1.235	1.516	0.157	0.118	0.749	0.500	2.126	1/2 - 13
12"	<a href="#">1123R</a>	4.252	1.843	1.485	1.575	0.157	0.118	0.749	0.500	2.500	1/2 - 13
15"	<a href="#">1153R</a>	5.275	2.362	1.771	2.205	0.287	0.118	0.749	0.500	3.000	5/8 - 11
21"	<a href="#">1213R</a>	8.000	2.240	1.970	2.205	.2870	0.125	0.749	.500	3.000	3/4 - 10

6" Chucks have a backward cross-key. Refer to the drawings on the left for 6" chucks.