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FULL GRIP JAWS * SOFT JAWS * SPECIAL JAWS

CHUCK JAWS CATALOG

Issue Date: December 01, 2017

**DESIGNED &
 ENGINEERED IN
 THE USA**

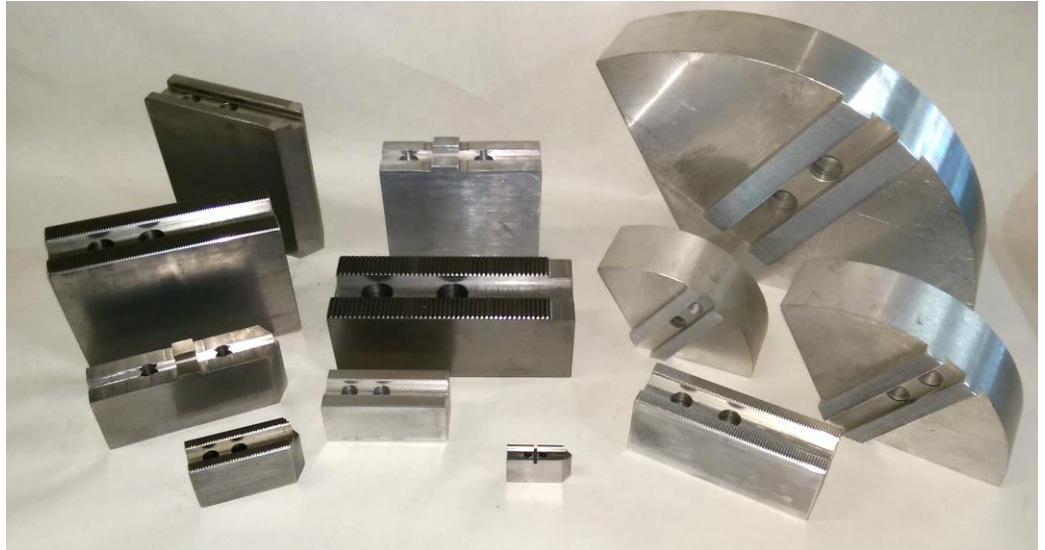


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For over 15 years, VERTECH INTERNATIONAL, INC. has been a reliable source of quality made Chuck Jaws. We are committed to bringing you the service you expect and deserve.

If for any reason(s) you're not satisfied with our product(s) you can return it to us within 30 days from the date of purchase for an exchange of identical part number or 100% refund (minus shipping cost) with NO RESTOCKING FEE.

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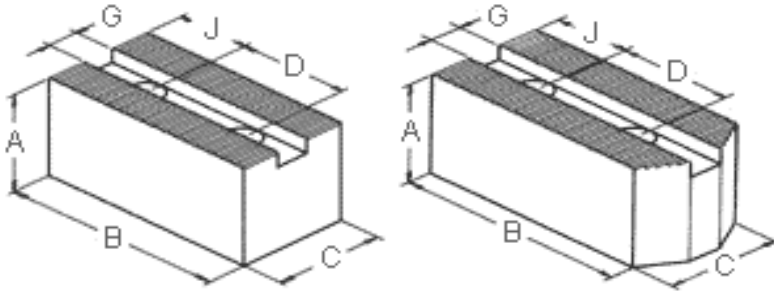
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



FEATURES: General-purpose blank top jaws, also referred to as “long” or “offset” jaws. Standard steel jaws can be case hardened after machining, or left soft. Optional aluminum material reduces surface marring, ideal for chucking on finished surfaces. 1.5mm x 60° serrations.

Chuck Dia Inch	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
4"	0.394	8MM	0.551	1.000	1.000	2.000	1.00	VKT 4105F
	0.394	8MM	0.551	1.000	1.000	2.000	2.00	VKT 4205F
5"	0.394	8MM	0.748	1.250	1.000	2.375	1.50	VKT 5150F
	0.394	8MM	0.713	1.250	1.000	2.375	1.50	VKT 5153F
6"	0.472	10MM	0.787	1.625	1.250	3.000	1.00	VKT 6100F
	0.472	10MM	0.787	1.625	1.250	3.000	1.50	VKT 6150F
	0.472	10MM	0.787	1.625	2.000	3.000	1.50	VKT 6152F
	0.472	10MM	0.787	1.625	1.250	3.000	2.00	VKT 6200F
	0.472	10MM	0.787	1.625	1.250	3.000	2.50	VKT 6250F
	0.472	10MM	0.787	1.625	1.250	3.000	3.00	VKT 6300F
	0.472	10MM	0.787	1.625	1.250	3.000	4.00	VKT 6400F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VKT 5150P)

When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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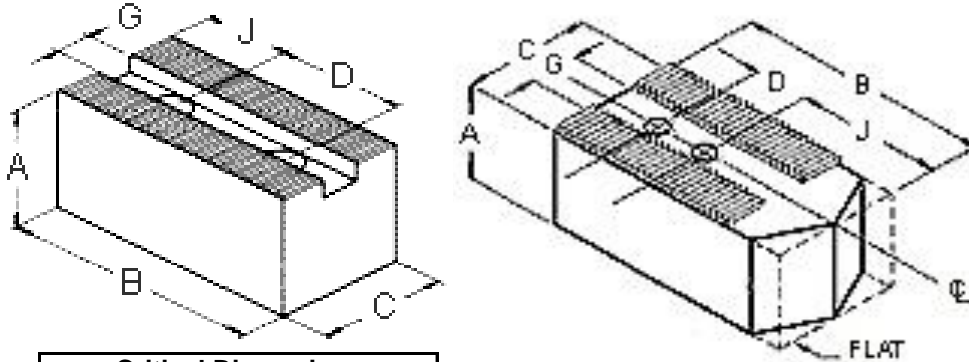
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



Critical Dimensions								STEEL
Chuck Dia Inch	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
8"	0.551	12MM	0.984	2.000	1.500	3.75	1.50	VKT 8150F
	0.551	12MM	0.984	2.000	1.500	3.75	2.00	VKT 8200F
	0.551	12MM	0.984	2.000	1.500	3.75	3.00	VKT 8300F
	0.551	12MM	0.984	2.000	1.500	3.75	4.00	VKT 8400F
	0.551	12MM	0.984	2.000	1.500	3.75	5.00	VKT 8500F
	0.551	12MM	0.984	2.250	1.500	4.00	2.00	VKT 8201F
	0.551	12MM	0.984	2.250	1.500	4.00	3.00	VKT 8301F
	0.551	12MM	0.984	2.250	1.500	4.00	4.00	VKT 8401F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VKT 5150P)

When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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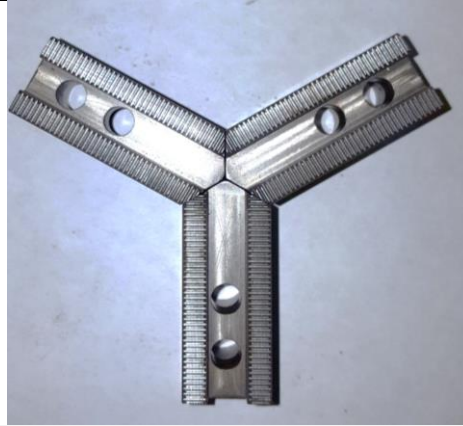
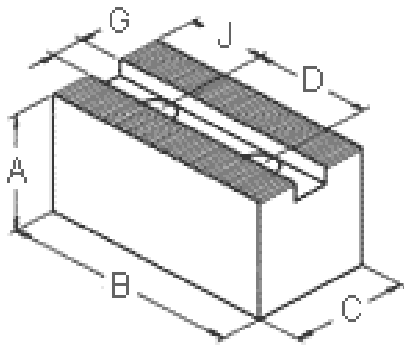
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



Chuck Dia Inch	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
10"	0.630	12MM	1.181	2.375	1.50	4.50	2.00	VKT 10200F
	0.630	12MM	1.181	2.375	1.50	4.50	3.00	VKT 10300F
	0.630	12MM	1.181	2.375	1.50	4.50	4.00	VKT 10400F
	0.630	12MM	1.181	2.375	1.50	4.50	6.00	VKT 10600F
	0.630	12MM	1.181	2.875	1.50	5.00	2.00	VKT 10201F
	0.630	12MM	1.181	2.875	1.50	5.00	3.00	VKT 10301F
	0.630	12MM	1.181	2.875	2.00	5.25	2.00	VKT 10205F
	0.630	12MM	1.181	2.875	2.00	5.25	3.00	VKT 10305F
	0.630	12MM	1.181	2.875	2.00	5.25	4.00	VKT 10405F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VKT 5150P)

When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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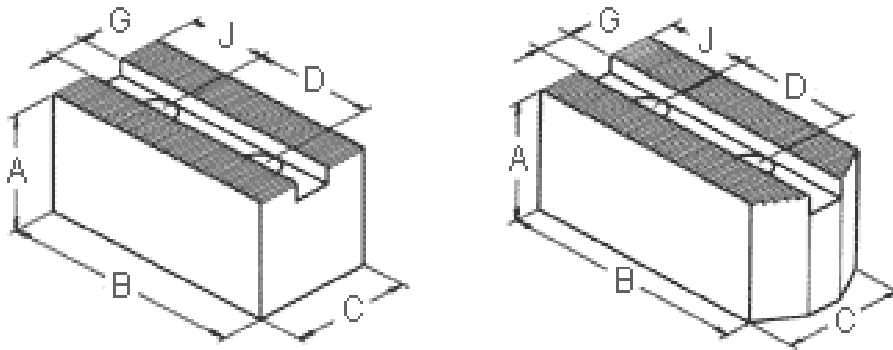
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



Chuck Dia Inch	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
12"	0.709	14MM	1.181	3.125	2.00	5.50	2.00	VKT 12200F
	0.709	14MM	1.181	3.125	2.00	5.50	2.50	VKT 12250F
	0.709	14MM	1.181	3.125	2.00	5.50	3.00	VKT 12300F
	0.709	14MM	1.181	3.125	2.00	5.50	4.00	VKT 12400F
	0.709	14MM	1.181	3.125	2.00	5.50	5.00	VKT 12500F
	0.709	14MM	1.181	3.125	2.00	5.50	6.00	VKT 12600F
	0.827	16MM	1.181	3.125	2.00	5.50	2.00	VKT 12208F
	0.827	16MM	1.181	3.125	2.00	5.50	2.50	VKT 12258F
	0.827	16MM	1.181	3.125	2.00	5.50	3.00	VKT 12308F
	0.827	16MM	1.181	3.125	2.00	5.50	4.00	VKT 12408F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VKT 5150P)

When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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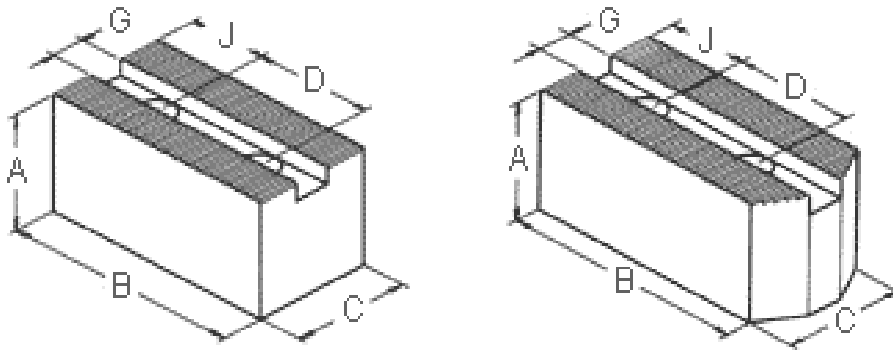
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



Chuck Dia Inch	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
15"	0.866	20MM	1.690	3.437	2.50	6.50	2.50	VKT 15250F
	0.866	20MM	1.690	3.437	2.50	6.50	3.00	VKT 15300F
	0.866	20MM	1.690	3.437	2.50	6.50	4.00	VKT 15400F
	0.866	20MM	1.690	3.437	2.50	6.50	6.00	VKT 15600F
	0.866	20MM	2.360	2.750	2.50	6.50	2.50	VKT 15252F
	0.866	20MM	1.690	4.437	2.50	7.50	2.50	VKT 15255F
	1.005	20MM	1.690	3.437	2.50	6.50	3.00	VKT 15301F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VKT 5150P)

When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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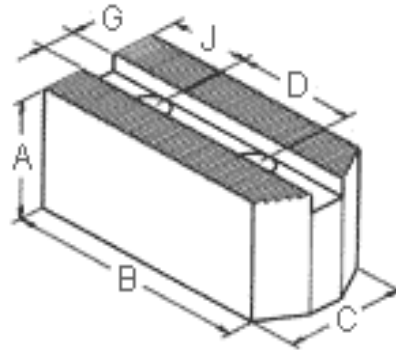
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SOFT JAWS - 1.5MM X 60 SERRATIONS

For Kitagawa, Howa, Samchully, Suga, Nikko, Matsumoto & other Chucks



Chuck Dia Inch	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Part Number
8"	0.630	12MM	0.984	2.000	1.50	3.750	2.00	VHO 8200
	0.630	12MM	0.984	2.000	1.50	3.750	3.00	VHO 8300
10"	0.709	14MM	1.181	2.375	1.50	4.500	2.00	VHO 10200
12"	0.827	16MM	1.378	3.125	2.00	5.500	2.00	VHO 12200
	0.827	16MM	1.378	3.125	2.00	5.500	2.50	VHO 12250
	0.827	16MM	1.378	3.125	2.00	5.500	4.00	VHO 12400

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VHO 8200P)

Steel Material: AISI 1018

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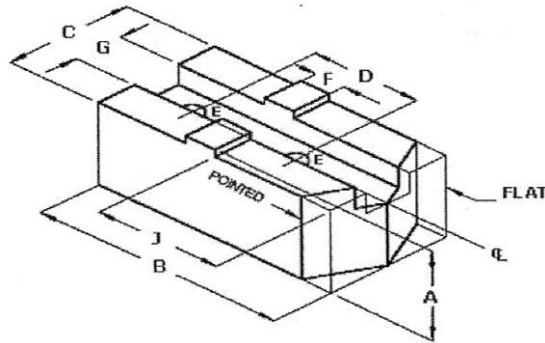
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SOFT JAWS- TONGUE AND GROOVE
 For Bison, Buck, BTC, Cushman, Rohm, SMW, TMX, & Yuassa Chucks



Critical Dimensions								STEEL
Tongue to Front J	Groove Width G	Tongue Width F	Bolt Size	Center to Center D	Width Inch C	Length Inch B	Height Inch A	Part Number
1.360	0.312	0.499	3/8	1.500	1.000	2.750	1.500	VTG 6150F
1.360	0.312	0.499	3/8	1.500	1.000	2.750	2.000	VTG 6200F
1.360	0.312	0.499	3/8	1.500	1.000	2.750	3.000	VTG 6300F
1.360	0.312	0.499	3/8	1.500	1.000	2.750	4.000	VTG 6400F
2.000	0.312	0.499	3/8	1.750	1.250	3.750	2.000	VTG 8200F
2.000	0.312	0.499	3/8	1.750	1.250	3.750	2.500	VTG 8250F
2.000	0.312	0.499	3/8	1.750	1.250	3.750	3.000	VTG 8300F
2.300	0.501	0.749	1/2	2.125	1.500	4.500	2.000	VTG 10200F
2.300	0.501	0.749	1/2	2.125	1.500	4.500	2.500	VTG 10250F
2.300	0.501	0.749	1/2	2.125	1.500	4.500	3.000	VTG 10300F
2.300	0.501	0.749	1/2	2.125	1.500	4.500	4.000	VTG 10400F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VTG 8200P)
 When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

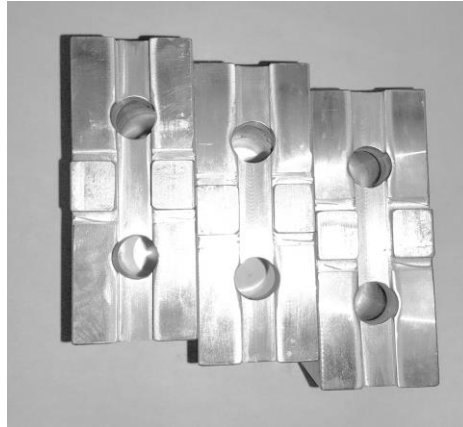
Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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SOFT JAWS- TONGUE AND GROOVE
 For Bison, Buck, BTC, Cushman, Rohm, SMW, TMX, & Yuassa Chucks



Critical Dimensions								STEEL
Tongue to Front J	Groove Width G	Tongue Width F	Bolt Size	Center to Center D	Width Inch C	Length Inch B	Height Inch A	Part Number
2.900	0.501	0.749	1/2	2.500	1.750	5.250	2.000	VTG 12200F
2.900	0.501	0.749	1/2	2.500	1.750	5.250	2.500	VTG 12250F
2.900	0.501	0.749	1/2	2.500	1.750	5.250	3.000	VTG 12300F
2.900	0.501	0.749	1/2	2.500	1.750	5.250	4.000	VTG 12400F
2.900	0.501	0.749	5/8	3.000	1.750	5.750	2.500	VTG 15250F
3.200	0.501	0.749	3/4	3.000	2.500	6.000	4.000	VTG 15406F
3.660	0.501	0.749	3/4	3.000	2.250	6.500	2.500	VTG 18250F
3.660	0.501	0.749	3/4	3.000	2.500	6.500	2.500	VTG 18252F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VTG 12200P)
 When ordering Aluminum specify "AP" for Aluminum Pointed, or "AF" for Aluminum Flat at the end of the part number.

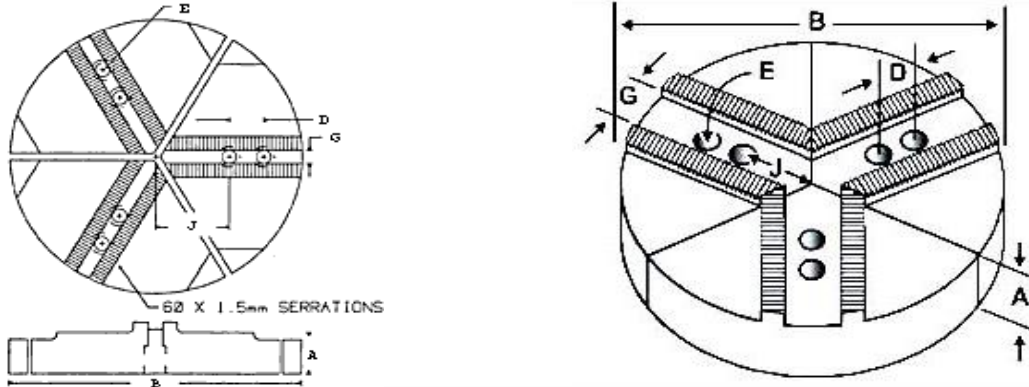
Steel Material: AISI 1018

Aluminum Material: Aluminum 6061-T6 Bar Stock

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FULL GRIP SOFT JAWS
1.5 MM X 60 SERRATIONS



Critical Dimensions						ALUMINUM	Available in Steel*
Height Inches A	Pie Diameter B	Center to Center D	Screw Size E	Groove Width G	Hole to Front J	Part Number	
2.000	6	0.787	10MM	0.472	1.625	VRKT 6200A	
3.000	6	0.787	10MM	0.472	1.625	VRKT 6300A	
2.000	8	0.984	12MM	0.551	2.250	VRKT 8200A	VRKT 8200S*
3.000	8	0.984	12MM	0.551	2.250	VRKT 8300A	
4.000	8	0.984	12MM	0.551	2.250	VRKT 8400A	
2.000	10	1.181	12MM	0.630	2.375	VRKT 10200A	
3.000	10	1.181	12MM	0.630	2.375	VRKT 10300A	
4.000	10	1.181	12MM	0.630	2.375	VRKT 10400A	
2.000	12	1.181	14MM	0.709	2.875	VRKT 12200A	
3.000	12	1.181	14MM	0.709	2.875	VRKT 12300A	
4.000	12	1.181	14MM	0.709	2.875	VRKT 12400A	
2.500	15	1.690	20MM	0.866	3.750	VRKT 15250A	
4.000	15	1.690	20MM	0.866	3.750	VRKT 15400A	

* VRKT 8200 - Available in Aluminum & Steel. Specify "S" for Steel & "A" for Aluminum at end of part number. (example: VRKT 8200S)

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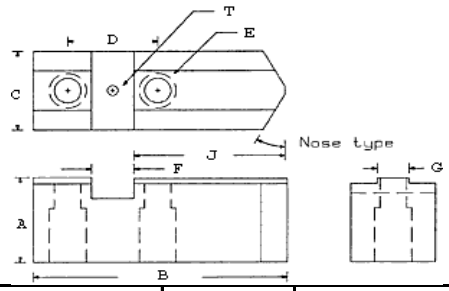
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SOFT JAWS - 1/16" X 90 SERRATIONS
For SMW, Autoblok, Rohm, PBA & other Chucks

Critical Dimensions								STEEL
Chuck Dia. Inches	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Vertech Part Number
6"	0.433	5/16	0.718	1.250	1.250	3.125	1.500	VPH 6150F
8"	0.669	1/2	0.875	2.125	1.500	4.375	2.000	VPH 8200F
10"	0.787	1/2	1.187	2.250	1.750	5.250	2.500	VPH 10250F
15"	0.827	5/8	1.562	2.875	2.000	6.750	2.500	VPH 15250F

ACME SERRATED KEY TYPE
For Cushman, Logansport, Howa, Autoblok, PBA & other Chucks



Critical Dimensions										STEEL
Tap Hole T	Dist. To Key J	Groove Width G	Key Width F	Bolt Size	Center to Center D	Width Inch C	Length Inch B	Height Inch A	Vertech Part Number	
5/16-18	2.250	0.750	1.031	1/2	1.750	1.750	4.250	2.500	VAC 10250	
5/16-18	3.125	0.875	1.031	5/8	2.000	1.750	5.250	2.500	VAC 12250	
3/8-16	3.000	1.000	1.531	3/4	2.500	2.000	6.250	2.500	VAC 15250	
3/8-16	3.400	1.000	1.531	3/4	2.500	2.500	6.250	2.500	VAC 18250	

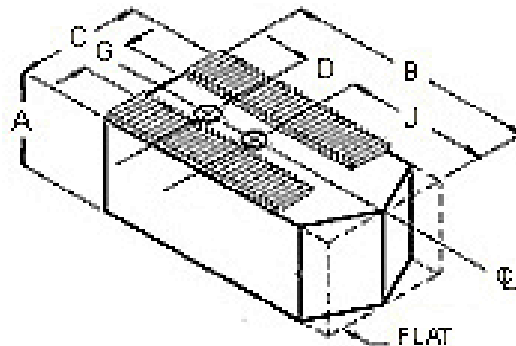
When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VAC 10250P)
Steel Material: AISI 1018 - not available in aluminum

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SOFT JAWS - 3MM X 60 SERRATIONS

For Matsumoto, Howa & other Chucks



Chuck Dia. Inches	Critical Dimensions							STEEL
	Groove Width G	Bolt Size	Center to Center D	Hole to Front J	Width Inch C	Length Inch B	Height Inch A	Vertech Part Number
8"	0.551	12MM	0.985	2.000	1.500	3.750	2.000	VH3 8200F
	0.551	12MM	0.985	2.000	1.500	3.750	4.000	VH3 8400F
10"	0.630	12MM	1.181	2.625	1.500	4.750	2.000	VH3 10200F
	0.630	12MM	1.181	2.625	1.500	4.750	4.000	VH3 10400F
12"	0.709	14MM	1.181	3.125	2.000	5.500	2.000	VH3 12200F
15"	1.023	20MM	1.656	2.687	2.000	5.750	2.500	VH3 15254F
21"	0.984	20MM	2.360	3.070	2.500	7.000	2.500	VK3 21250F
	0.984	20MM	2.360	3.070	2.500	7.000	4.000	VK3 21400F
	0.984	20MM	3.150	3.850	3.000	8.500	4.000	VK3 24400F

When ordering Steel specify "P" for Pointed or "F" for Flat at the end of the part number. (example: VH3 10200P)

Steel Material: AISI 1018 - not available in aluminum

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Toll Free: 877-WORK HOLD (967-5465)

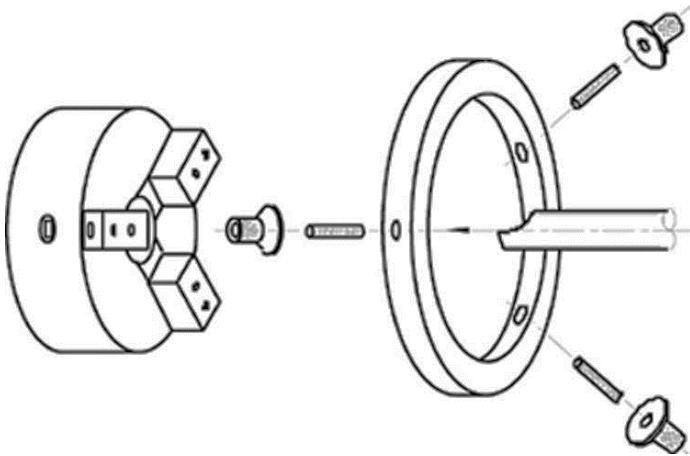
For orders or Requests for Quotes please Email: info@vertechinternational.com

Website: <http://www.877workhold.com> Catalog: http://www.vertechinternational.com/more_Products.html

ACCU-RING JAW BORING TOOL

Boring System:

The Accu-Ring Jaws System is an engineering break-thru in boring soft jaws. It guarantees spindle accuracy. It was specifically designed to eliminate jaw deflection in manual and hydraulic chucks.



FEATURES:

- Ideal for machining soft jaws
- Attach quickly without tools
- Applies equal pressure to all jaws

With the ACCU-RING JAW SYSTEM you will bore soft jaws...

SAFELY: ACCU-RING securely bolted to chuck - will not fly off!

ACCURATELY: Guaranteed spindle accuracy.

QUICKLY: Set up and bore time will be minimized.

ECONOMICALLY: Save usable jaw life - re-bore in .005 increments by setting micrometer adjusting nuts on ACCU-RING.

Chuck Size	Accu-Ring Size	Part Number
6"	8"	VAR-06
8"	10"	VAR-08
10"	12"	VAR-10
12"	15"	VAR-12
16"	18"	VAR-15

Ask your Representative for more information!

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ACCU-RING JAW SYSTEM INSTRUCTIONS

HOW TO USE THE ACCU-RING ASSEMBLY

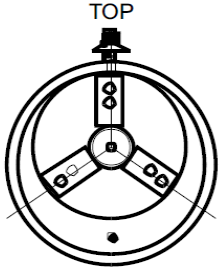


FIG 1
INSTALLING ALL THE PARTS

1. ACCU-RING SOFT JAWS HAVE 1/2"-20 THREADED HOLES FOR FASTENING TO THE ACCU-RING.
2. INSTALL THE SOFT JAWS WITH 1/2" THREADED HOLE TO THE PERMANANT JAWS OF THE CHUCK CLAMP THE WORKPIECE TIGHTLY IN THE CHUCK..
3. INSTALL THE PROPER SIZE RING AROUND THE OUTSIDE OF THE JAWS AND INSERT (1) ONE THREADED STUD WITH THE MICROMETER NUT JAW AT TOP POSITION.
4. SCREW THE THREADED STUDS AND MICROMETER NUTS IN THE OTHER (2) TWO JAWS AND CENTER THE RING IN RELATION TO THE CHUCK O.D. USING THE THREE (3) MICROMETER ADJUSTING NUTS.

5. BACK OFF THE MICROMETER ADJUSTING NUTS COUNTER CLOCKWISE ON ALL THREE JAWS TO THE DESIRED AMOUNT YOU PLAN TO BORE OUT, UTILIZING THE INCREMENTAL DIVISIONS ON THE ADJUSTING NUTS, AS A GUIDE.

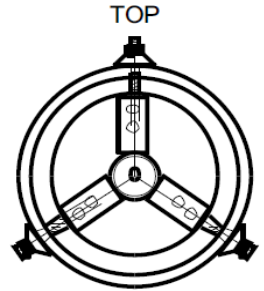


FIG 2
SETTING THE JAWS
TO THE WORK PIECE

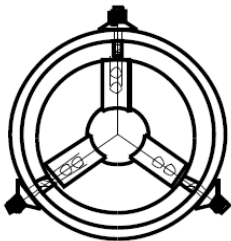


FIG 3
FINISHED JAWS
BORING THE JAWS
AND REMOVE THE RING

6. REMOVE THE WORKPIECE, RE-CLAMP THE JAWS AND BORE THE JAWS TO FIT THE WORKPIECE.
7. REMOVE THE ACCU-RING, NUTS AND STUDS.
8. CHECK THE WORKPIECE AND BE AMAZED.

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