

# DIN ISO 3442-3:2010-08 (E)

## Machine tools - Dimensions and geometric tests for self-centring chucks with two-piece jaws - Part 3: Power-operated chucks with serrated jaws (ISO 3442-3:2007)

---

<b>Contents</b>		<b>Page</b>
National foreword .....		3
National Annex NA (informative) Bibliography .....		3
<b>1</b>	<b>Scope .....</b>	<b>4</b>
<b>2</b>	<b>Normative references .....</b>	<b>4</b>
<b>3</b>	<b>Preliminary remarks .....</b>	<b>4</b>
<b>3.1</b>	<b>Measuring units .....</b>	<b>4</b>
<b>3.2</b>	<b>Geometric tests .....</b>	<b>4</b>
<b>3.3</b>	<b>Tests to be performed .....</b>	<b>4</b>
<b>5</b>	<b>Sizes for interchangeability .....</b>	<b>5</b>
<b>5.1</b>	<b>90° serrations -- Dimensions .....</b>	<b>5</b>
<b>5.2</b>	<b>90° serrations -- Permissible cumulative pitch deviation .....</b>	<b>5</b>
<b>5.3</b>	<b>60° serrations -- Dimensions .....</b>	<b>6</b>
<b>5.4</b>	<b>60° serrations -- Permissible cumulative pitch deviation .....</b>	<b>6</b>
<b>5.5</b>	<b>Jaw nuts -- Dimensions .....</b>	<b>7</b>
<b>6</b>	<b>Geometric tests .....</b>	<b>8</b>
<b>6.1</b>	<b>Test mandrels .....</b>	<b>8</b>
<b>6.2</b>	<b>Spindle or face plate accuracy .....</b>	<b>8</b>
<b>6.3</b>	<b>Chuck body accuracy .....</b>	<b>8</b>
<b>6.4</b>	<b>Test with test top jaws (hard jaws) .....</b>	<b>8</b>
<b>6.5</b>	<b>Tests with machined top jaws .....</b>	<b>9</b>
<b>6.6</b>	<b>Tests off-the-spindle .....</b>	<b>9</b>
<b>6.7</b>	<b>Chuck accuracy .....</b>	<b>12</b>
<b>S</b>	<b>4 Accuracy classes .....</b>	<b>4</b>