ISO 3442-3:2007-02 (E)

Machine tools - Dimensions and geometric tests for self-centring chucks with two-piece jaws - Part 3: Power-op erated chucks with serrated jaws

Contents

Page

Foreword iv

1 Scope 1

2 Normative references 1

3 Preliminary remarks 1
3.1 Measuring units 1
3.2 Geometric tests 1
3.3 Tests to be performed 1

4 Precision classes 1

5 Sizes for interchangeability 2
5.1 90° serrations -- Dimensions 2
5.2 90° serrations -- Permissible cumulative pitch deviation 2
5.3 60° serrations -- Dimensions 3
5.4 60° serrations -- Permissible cumulative pitch deviation 3
5.5 Jaw nuts -- Dimensions 4

6 Geometric tests 5
6.1 Test mandrels 5
6.2 Spindle or face plate accuracy 5
6.3 Chuck body accuracy 5
6.4 Test with test top jaws (hard jaws) 5
6.5 Tests with machined top jaws 6
6.6 Tests off-the-spindle 6
6.7 Chuck accuracy 9