PRECISION SPECIALTY TOOLING

THE DRILL CHUCK GUIDE

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A PRECISION GUIDE IN FINDING THE RIGHT CHUCK, ARBOR, OR KEY

DRILL CHUCKS

IDENTIFYING THE RIGHT CHUCK: Questions to Ask

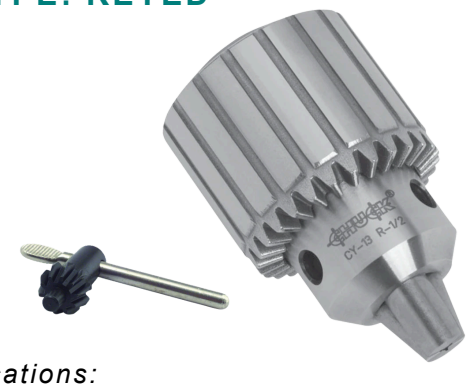
(all of our keyed chucks come with keys)

A. Is the chuck keyed or keyless

B. What is the capacity of your chuck?

C. What mount do you require?

A. TYPE: KEYED



TYPE: KEYLESS

Applications:
Portable power or air tools, stationary equipment, lathes, bench or pedestal drills.

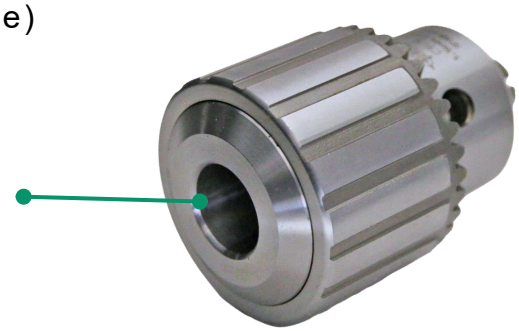
B. CAPACITY

The capacity references how large the jaws open. Most good quality chucks have an engraved number on the chuck itself (13, or 16mm being the most common).

C. MOUNT

The chuck mount will be determined on the drill. commonly a J3 or J6 mount, if the drill chuck is used on a bench or pedestal drill, an arbor will be required (next page)

J =
JACOB'S
MOUNT



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CHUCK ARBORS

Identifying the correct arbor:

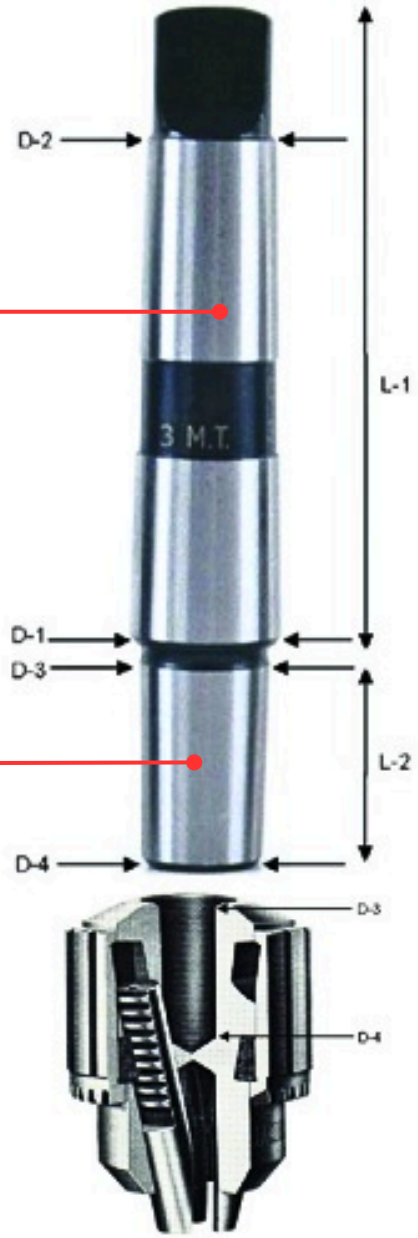
To connect a chuck with a different taper to your machine's spindle, you will need an arbor with a matching taper on each end

Measuring Morse and Jacobs tapers:

1. Use a caliper to measure the large end of the taper.
2. Measure the small end of the taper.
3. Compare your measurements with the charts below:
   - If it fits a spindle or tailstock → check the Morse Taper chart.
   - If it fits a drill chuck → check the Jacobs Taper chart.

MT = MORSE TAPER

JT = JACOBS TAPER or 'B' DIN TAPER (LESS COMMON)



MORSE TAPERS			
Taper No.	D-1 mm	D-2 mm	L-1 mm
1	12.065	9.7	65.5
2	17.78	4.9	80
3	23.825	20.2	99
4	31.267	26.5	124
5	44.399	38.2	156
6	63.348	54.6	218

JACOBS TAPERS			
Taper No.	D-3 mm	D-4 mm	L-2 mm
0	6.35	5.802	11.112
1	9.754	8.469	16.669
2 Short	13.94	12.386	19.05
2	14.199	12.386	22.225
33	15.85	14.237	25.4
6	17.17	15.582	25.4
3	20.599	18.951	30.956
4	28.55	26.346	42.069
5	35.89	33.422	47.625

DIN (METRIC) TAPERS			
Taper No.	D-3 mm	D-4 mm	L-2 mm
B10	10.094	9.4	14.5
B12	12.065	11.1	18.5
B16	15.733	14.5	24
B18	17.78	16.2	32
B22	21.793	19.8	40.5
B24	23.825	21.3	50.5

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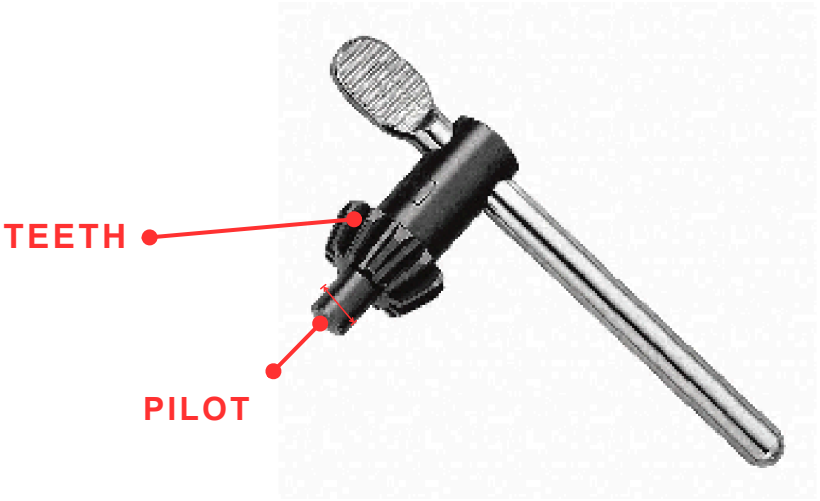
CHUCK KEYS

A chuck key tightens or loosens the jaws to hold a drill bit or tool. The easiest way to find the right key is by checking the chuck's brand and model. In some cases, the chuck itself will have the key size marked on its body.

Indentifying the right chuck key: Questions to Ask

A. What is the pilot/pin size? (Can be metric or imperial).

B. How many teeth does your key have?



Part No.	Description	Pilot (mm)	Pilot (inches)	Teeth
LK0	Chuck Key Suit CY-04 Llambrich & 0 Series Jacobs	3.17	1/8"	11
LK0M	Chuck Key Stainless Suit CSS-04 Llambrich & 0 Series Jacobs	3.17	1/8"	11
LK1M	Chuck Key Stainless Suit CSS-06 Llambrich & 1 Series Jacobs	3.97	5/32"	11
LK2S17	Chuck Key Suit CY-13 & 2 Series Jacobs	6.35	1/4"	11
LK32S9	Chuck Key Suit CBB-10 Llambrich & 33 Series & 11N Jacobs	6.35	1/4"	10
LK3S10	Chuck Key Suit CL-16, CYX-13, CY-16 Llambrich & 3, 34 Series & 14N Jacobs	7.94	5/16"	11
LK4S13	Chuck Key Suit CY-19, CBB-16, CBB-19 Llambrich & 36 Series, 16N, 18N Jacobs	9.52	3/8"	12
LK5	Chuck Key Suit CBB-25 Llambrich & 20N Jacobs	11.11	7/16"	12
LKC4	Chuck Key To Suit CY-06 Series Llambrich	5.42	7/32"	12
LKGS14	Chuck Key Suit CL-10 Llambrich & 10mm Jacobs Multicraft	6.5	9/32"	11
LS1	Chuck Key Suit Rohm Prima Series & LFA 4mm 6mm & 8mm	4	//	10
LS2	Chuck Key Suit CL-13, CY-10 Llambrich & Rohm Prima Series 8mm, 10mm, 13mm	6	//	12
LS3	Chuck Key Din Series S3 8mm Pilot	8	//	12