

SERRATED JAW SELF-CENTERING POWER CHUCKS

Type A American Standard Spindles

(Specifications on page 3)

All power chucks are carefully designed and are built to provide accurate repetitive workholding. Bodies are of steel with all moving surfaces precision ground and all wearing surfaces flame-hardened and ground. Internal parts are protected by dust plates carefully fitted to the chuck face, thereby preventing the entry of chips and dirt. Reliability combined with heavy duty type performance enables these chucks to be used for most types of workholding over a long, rugged, trouble-free service life. Note: Chucks listed below do not include top jaws. All chucks in sizes 12" and larger are furnished with T-slots. To order chucks with Draw Tubes, change the reference number as shown above each listing. (Example: to order chuck number 20-670-12-A06 with a draw tube, change the reference number to 20-673-12-A06.) Most of the chucks listed in this catalog are for direct mounting on Type A American Standard Spindles. Other chuck sizes and spindle seats are available on request.

Chucks with serrated master jaws are especially recommended for production and chucking operations where it is necessary to provide a wide range of jaw capacity, and is achieved by "stepping" the top jaw along the master jaw. One set of master jaw keys are furnished with each chuck; top jaws are not included. Balanced to eliminate vibration and chatter at high RPM.

Chucks are priced on application.

SERIES 20-670 - 3-Jaw Chucks

American Standard Serrated Master Jaws*

(For Draw Tube type, change number to 20-673)†



Series:
• 20-670
• 20-673

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
10	20-670-10-A06Z	12	20-670-12-A08Z	18	20-670-18-A11Z	21	20-670-21-A15Z
10	20-670-10-A08Z	15	20-670-15-A08Z	18	20-670-18-A15Z	24	20-670-24-A15Z
12	20-670-12-A06Z	15	20-670-15-A11Z	21	20-670-21-A11Z		

SERIES 20-671 - 2-Jaw Chucks

American Standard Serrated Master Jaws*

(For Draw Tube type, change number to 20-674)†



Series:
• 20-671
• 20-674

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
10	20-671-10-A06Z	12	20-671-12-A08Z	18	20-671-18-A11Z	21	20-671-21-A15Z
10	20-671-10-A08Z	15	20-671-15-A08Z	18	20-671-18-A15Z	24	20-671-24-A15Z
12	20-671-12-A06Z	15	20-671-15-A11Z	21	20-671-21-A11Z		

SERIES 20-672 - 2 & 3-Jaw Chucks

American Standard Serrated Master Jaws*

(For Draw Tube type, change number to 20-675)†



Series:
• 20-672
• 20-675

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
10	20-672-10-A06Z	15	20-672-15-A08Z**	18	20-672-18-A15Z	21	20-672-21-A15Z
10	20-672-10-A08Z	15	20-672-15-A11Z	21	20-672-21-A11Z	24	20-672-24-A15Z
12	20-672-12-A08Z	18	20-672-18-A11Z				

*Accralock Angular Serrated Master Jaws can be furnished at slight extra cost.

**Adapter for mounting included.

†See statement at top of page.

NON-ADJUSTABLE JAW SELF-CENTERING POWER CHUCKS

Type A American Standard Spindles

(Specifications on page 3)

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Recommended for general manufacturing service where adjustability of individual jaws is not required. Particularly suited for repetitive operations, especially heavy workpieces. Provides a simple and economical method of workholding, eliminating costly special devices. Balanced to eliminate vibration and chatter at high RPM.

All chucks are priced on application.

SERIES 20-620 - 3-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-623)†

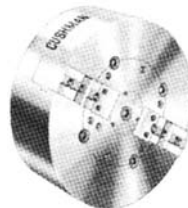


Series:
• 20-620
• 20-623

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
6	20-620-06-A05Z	10	20-620-10-A06Z	15	20-620-15-A08Z	21	20-620-21-A11Z
6	20-620-06-A06Z	10	20-620-10-A08Z	15	20-620-15-A11Z	21	20-620-21-A15Z
8	20-620-08-A06Z	12	20-620-12-A06Z	18	20-620-18-A11Z	24	20-620-24-A15Z
8	20-620-08-A08Z	12	20-620-12-A08Z	18	20-620-18-A15Z		

SERIES 20-621 - 2-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-624)†



Series:
• 20-621
• 20-624

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
6	20-621-06-A05Z	10	20-621-10-A06Z	15	20-621-15-A08Z	21	20-621-21-A11Z
6	20-621-06-A06Z	10	20-621-10-A08Z	15	20-621-15-A11Z	21	20-621-21-A15Z
8	20-621-08-A06Z	12	20-621-12-A06Z	18	20-621-18-A11Z	24	20-621-24-A15Z
8	20-621-08-A08Z	12	20-621-12-A08Z	18	20-621-18-A15Z		

SERIES 20-622 - 2 & 3-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-625)†



Series:
• 20-622
• 20-625

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
8	20-622-08-A06Z	10	20-622-10-A08Z	15	20-622-15-A11Z	21	20-622-21-A11Z
8	20-622-08-A08Z	12	20-622-12-A08Z	18	20-622-18-A11Z	21	20-622-21-A15Z
10	20-622-10-A06Z	15	20-622-15-A08Z**	18	20-622-18-A15Z	24	20-622-24-A15Z

**Adapter for mounting included.

†See statement at top of page.

ADJUSTABLE JAW SELF-CENTERING POWER CHUCKS

Type A American Standard Spindles

(Specifications on page 3)

All power chucks are carefully designed and are built to provide accurate repetitive workholding. Bodies are of steel with all moving surfaces precision ground and all wearing surfaces flame-hardened and ground. Internal parts are protected by dust plates carefully fitted to the chuck face, thereby preventing the entry of chips and dirt. Reliability combined with heavy duty type performance enables these chucks to be used for most types of workholding over a long, rugged, trouble-free service life. Note: Chucks listed below do not include top jaws. All chucks in sizes 12" and larger are furnished with T-slots. To order chucks with Draw Tubes, change the reference number as shown above each listing. (Example: to order chuck number 20-640-12-A06 with a draw tube, change the reference number to 20-643-12-A06.) Most of the chucks listed in this catalog are for direct mounting on Type A American Standard Spindles. Other chuck sizes and spindle seats are available on request.

Self-centering Power Chucks with American Standard Master Jaws providing independent jaw action are simple and quick to adjust. This series of chucks is designed for accurate, expeditious holding of irregularly shaped workpieces. Initial accuracy maintained on repetitive chucking operations.

All chucks are priced on application.

SERIES 20-640 - 3-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-643)†

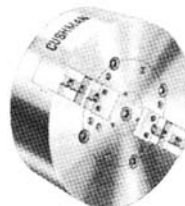


Series:
• 20-640
• 20-643

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
8	20-640-08-A06Z	12	20-640-12-A06Z	18	20-640-18-A11Z	21	20-640-21-A15Z
8	20-640-08-A08Z	12	20-640-12-A08Z	18	20-640-18-A15Z	24	20-640-24-A11Z
10	20-640-10-A06Z	15	20-640-15-A08Z	21	20-640-21-A11Z	24	20-640-24-A15Z
10	20-640-10-A08Z	15	20-640-15-A11Z				

SERIES 20-641 - 2-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-644)†



Series:
• 20-641
• 20-644

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
8	20-641-08-A06Z	12	20-641-12-A06Z	15	20-641-15-A11Z	21	20-641-21-A11Z
8	20-641-08-A08Z	12	20-641-12-A08Z	18	20-641-18-A11Z	21	20-641-21-A15Z
10	20-641-10-A06Z	15	20-641-15-A08Z	18	20-641-18-A15Z	24	20-641-24-A11Z
10	20-641-10-A08Z						

SERIES 20-642 - 2 & 3-Jaw Chucks

American Standard Tongue & Groove Master Jaws
(For Draw Tube type, change number to 20-645)†



Series:
• 20-642
• 20-645

SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER	SIZE	PART NUMBER
8	20-642-08-A06Z	12	20-642-12-A08Z	18	20-642-18-A11Z	21	20-642-21-A15Z
8	20-642-08-A08Z	15	20-642-15-A08Z**	18	20-642-18-A15Z	24	20-642-24-A11Z
10	20-642-10-A06Z	15	20-642-15-A11Z	21	20-642-21-A11Z	24	20-642-24-A15Z
10	20-642-10-A08Z						

**Adapter for mounting included.

†See statement at top of page.

SELF-CENTERING POWER CHUCKS COMPONENT PARTS LIST

Serrated/Adjustable/Non-Adjustable Jaw Types

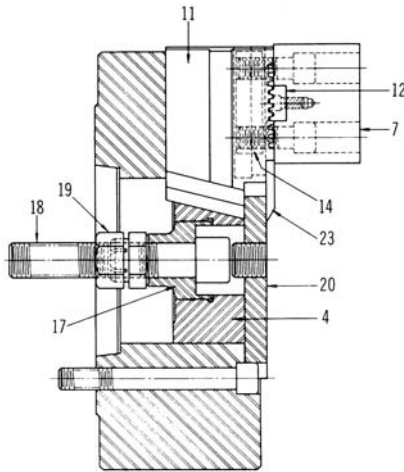
All parts are priced on application.

Series: 20-620; 20-621; 20-622; 20-623; 20-624; 20-625

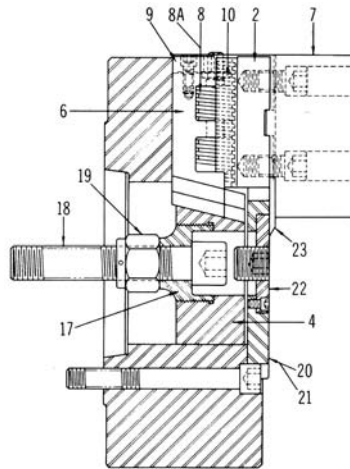
Series: 20-670; 20-671; 20-672; 20-673; 20-674; 20-675

Series: 20-640; 20-641; 20-642; 20-643; 20-644; 20-645

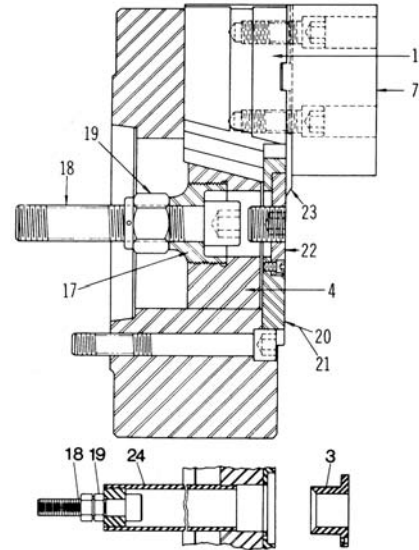
Serrated Jaw Type



Adjustable Jaw Type



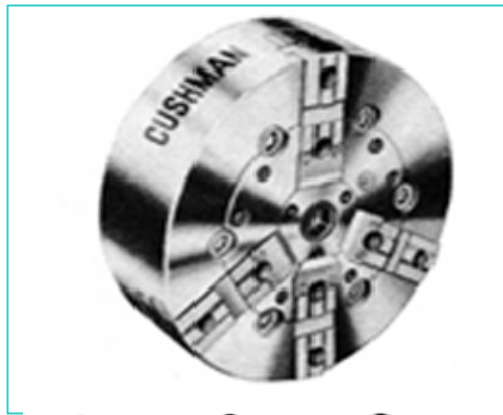
Non-Adjustable Jaw Type



Draw Tube Assembly

Chuck Size (Inches)	1 Master Jaws Non-Adjustable Tongue & Groove	2 Master Jaws Adjustable Tongue & Groove	3 Center Hole Bushing	4 Wedge	6 Screw Carrier	8 Adjusting Screw	9 Screw Locking Plate	10 Screw Locking Washer	11 Master Jaw Acme Serrated	12 Acme Serrated Jaw Key	14 Jaw Nut
6	03200269F0	---	2500389300	2400389000	---	---	---	---	--	---	---
8	24009673F0	25009552F0	2500427000	2400426800	04207492F0	3500487400	3500487500	3500487600	--	---	---
10	23009782F0	23009675F0	3500593700	2400431400	0420749300	2500847500	2500847600	3500486000	23010917F0	2501091200	2501091800
12" A-6 Spindle	23009632F0	23009681F0	3500593700	2400431400	04207495F0	3500486400	2500847600	3500486000	23013875F0	2501091200	2501091100
12" A-8 Spindle	23009685F0	23009681F0	2500430400	2400429900	04207495F0	3500486400	2500836600	3500486000	23010909F0	2501091200	2501091100
15	24011821F0	23009710F0	2501239300	2401223100	04207496F0	3500488600	2500836600	3500488700	23010906F0	2501090700	2501091600
18	23009718F0	23009715F0	2500447400	2400447200	04214857F0	3500567400	2500836600	3500488700	23010914F0	2501090700	2501091600
21	03204131F0	03204138F0	0520329800	2301778900	0421496100	3500497900	3500741800	3500488700	03204613F0	2501119900	2501120000
24	03205889F0	03203276	0520329800	2301778900	0421541900	3500497900	3500741800	3500488700	03205381F0	2501119900	2501120000

Chuck Size (Inches)	15 Hard Stepped Top Jaw	16 Wrench	17 Wedge Plug	18 Draw Rod Stud	19 Draw Rod Lock Nut	20 Protector Plate	21 Protector Plate with Cover Plate Recess	22 Cover Plate	23 Chip Plates	24 Draw Tube Assembly
6" A5	---	---	2500448100	9820645100	9823806400	---	2400929900	2500520400	0520027000	2601302300
6" A6	---	---	2500448100	9820645100	9823806400	---	2400389200	2500520400	0520027000	2601302300
8" A6	---	2601252300	2500448200	9820645100	9823806400	---	3400447200	2500520500	2500955500	2601302400
8" A8	---	2601252300	2500448200	9820645100	9823806400	---	3400831300	2500520500	2500955500	2601302400
10" A6	---	2601250400	2500448300	9820644700	9820644500	---	3400318500	2500520600	2500967700	2601302500
10" A8	---	2601250400	2500448300	9820644700	9820644500	---	3400451000	2500520600	2500967700	2601302500
12" A6	24010957F0	2601250400	2500448300	9820644700	9820644500	---	3400318500	2500520600	2500967700	2601302500
12" A8	24010957F0	2601250400	2500448400	9820644900	9820644500	---	3400447700	2500524400	2500967700	2601302600
15" A8	24011058F0	2601405300	3500238200	9820644900	9820645000	---	2401144100	2500520800	2501143900	2601302700
15" A11	24011058F0	2601405300	3500238200	9820644900	9820645000	---	2401225200	2500520800	2501143900	2601302700
18"	24011058F0	2601405300	3500447500	9820644900	9820645000	---	2401180300	2500520800	2500971900	2601302800
21" A11	24011205F0	2601405300	2500448600	9820644900	9820645000	0420298100	---	---	0520449300	2620330200
21" A15	24011205F0	2601405300	2500448600	9820644900	9820645000	0420426800	---	---	0520449300	2620330200
24" A11	24011205F0	2601405300	2500448600	9820644900	9820645000	0420298100	---	---	0520449300	2620330200
24" A15	24011205F0	2601405300	2500448600	9820644900	9820645000	0420426800	---	---	---	2620330200



Series **10-6****

Cushman® Wedge Style Power Chucks

High Quality, Steel Body Power Chuck



[Chuck Nomenclature](#)
[Manual](#)
[Spindle Nomenclature](#)

- Steel Body
- Various Jaw Mounts Available

- Sizes 6" through 36"
- Various Spindle Mounts Available

How To Order

