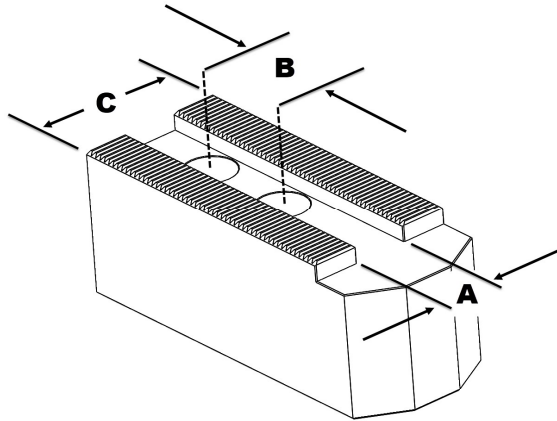
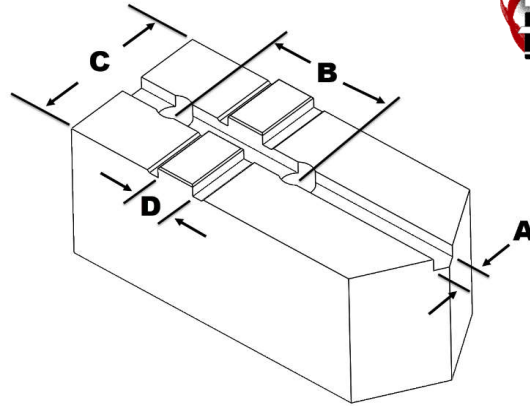


# Haas Automation, Inc. Lathe Chuck Jaw General Specifications



**Haas ST / DS, Hydraulic Chucks**



**Haas TL, Manual Chucks\***

	Chuck Diameter (approx.)		Jaw Serrations mm	A	B	C	D	Socket Head Cap Screw Size	Drive Size (Allen) mm	Jaw Screw Torque	
	Inch	mm		Groove Width mm	Screw Spacing mm	Width (approx.) mm	Tongue Width			Nm	ft-lbs
<b>ST / DS</b>	5	135	1.5 x 60°	10	14	25	-	M8	6	35	26
	6.5	170	1.5 x 60°	12	20	31	-	M10	8	73	54
	8	210	1.5 x 60°	14	25	35	-	M12	10	107	79
	10	254	1.5 x 60°	16	30	40	-	M12	10	107	79
	12	315	1.5 x 60°	21	30	50	-	M16	14	250	185
	15	381	1.5 x 60°	22	43	63.5	-	M20	17	402	298
	18	457	3.0 x 60°	22	50	63.5	-	M20	17	402	298
<b>TL*</b>	8	210	-	.313"	1.750"	1.5"	.500"	M10 (3/8-16)	8 (5/16")	73	54
	10	254	-	.500"	2.125"	1.5"	.750"	M12 (1/2-13)	10 (3/8")	107	79
	12	315	-	.500"	2.500"	2.0"	.750"	M12 (1/2-13)	10 (3/8")	107	79

Chuck Diameter by Model inch								
Main Spindle						Sub-Spindle		
6.5	8	10	12	15	18	5	6.5	8
ST-10						ST-10		
	ST-15					ST-15		
		ST-20**				ST-20		
			ST-25**			ST-25		
				ST-28		ST-28		
				ST-30**			ST-30	
					ST-35**		ST-35	
				DS-30**				DS-30
					ST-40			
						ST-45		
	TL-1/2**							

\* American Standard Tongue and Groove Jaws

\*\* When two Chuck Sizes listed, the smaller diameter is standard, the larger diameter is optional