It's hard to believe that a set of bruised knuckles was the impetus for one of the most significant industrial advancements in the 20th Century.

Arthur Irving Jacobs was never one for leaving things alone. He was always improving them - continually coming up with new ways of working and new gadgets to do the work. Before he was 30, "A.I.", as he was known, had perfected a new bookbinder, a new method of making bicycle spokes, and chains, plus many other manufacturing advancements.

On one particular occasion, he was working with an old style drill press, trying to hold the belt control with one hand, and applying the spanner wrench to the other, the wrench slipped and he badly battered his knuckles. A.I. knew there had to be a better way. In a matter of days, he had developed the first drill chuck with a toothed sleeve and key. A few months later, he founded what would become The Jacobs® Chuck Manufacturing Company. The rest, as they say, is history.

The keyed chuck helped to transform the production process just at the time when industrial manufacturing was about to experience its most significant growth in modern times. Today, the concept of the original keyed chuck is an integral part of all drill chuck technology. It has been applied to a wide range of applications, from the most sophisticated CNC machining to drilling with the smallest cordless portable drill.

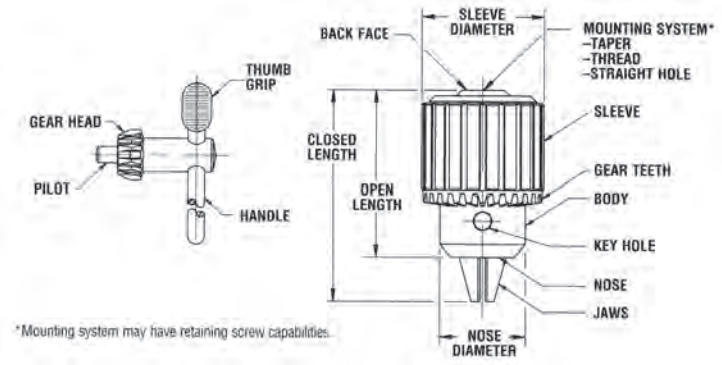
Now a part of the Apex Tool Group family of companies, the Jacobs® Chuck Manufacturing Company maintains a global presence as a recognised leader in the design and manufacture of precision tool and work holding devices for stationary equipment and portable power tools.

Finding a better way through world-class innovation and world-class partnerships - that's the driving force behind our business. It's a tradition that began with A.I. Jacobs a century ago when he set up his first network of distributors for the toothed sleeve and keyed drill chuck. It's a tradition we will carry forward with you.

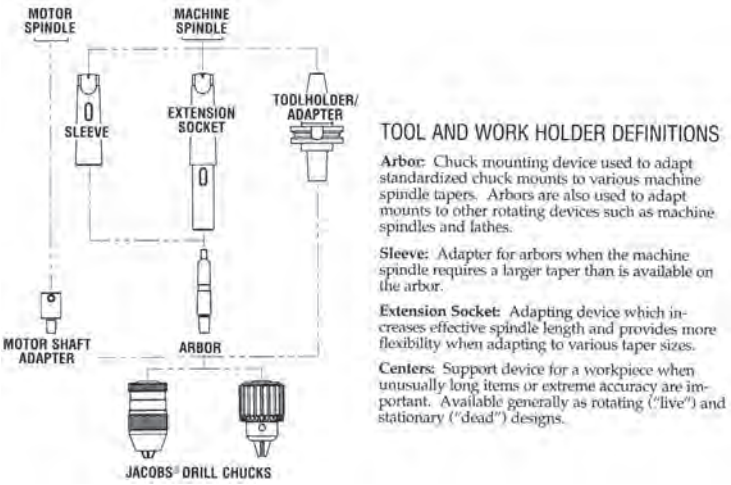
"There must be a better way to build a chuck." **-A.I. Jacobs, 1902**

Terminology

Chucks and Keys



Toolholders



Chuck and Accessory Removal Tools

Ball Bearing Chucks

Super Chuck® Ball Bearing Chucks are designed for close tolerance production drilling on precision equipment.

FEATURES:

- Ball hearing construction maximises gripping force and drilling accuracy.
- Jaws centre-ground for absolute straightness and alignment.
- One-piece sleeve eliminates crack between driving teeth often found in other designs.
- Through-hardened sleeve teeth plus hardened nose and keyholes provide outstanding wear resistance.
- Fluted sleeve standard.
- Each chuck 100% inspected for performance and precision.
- T.I.R. .003" maximum at half capacity.

Taper Mounted

Material Number	Model No.	Capacity Range Minimum in	Minimum mm	Maximum in	Maximum mm	Mount Jacobs	Key No.	Dimensions Closed Length in	Closed Length mm	Open Length in	Open Length mm	Sleeve Dia. in	Sleeve Dia. mm	Wgt Each gm
30209	8-1/2 N	0.040	1	0.250	6.4	2JT	K30	2.41	61.2	1.95	49.5	1.56	39.7	283
30215	11N	0.040	1	0.375	10.0	2JT	K32	2.88	73.2	2.26	57.4	1.93	49.1	538
30221D	14N	0.040	1	0.500	13.0	3JT	K3	3.88	98.6	2.97	75.4	2.44	62.1	1077
30227	16N	0.125	3	0.625	16.0	3JT	K4	4.31	109.5	3.26	82.8	2.63	66.9	1332
30233	18N	0.125	3	0.750	19.0	4JT	K4	5.12	130.0	3.95	100.3	3.01	76.4	1871
30239D	20N	0.375	10	1.000	25.4	5JT	K5	5.5	139.7	4.23	107.4	3.65	92.6	2834

Plain Bearing Chucks

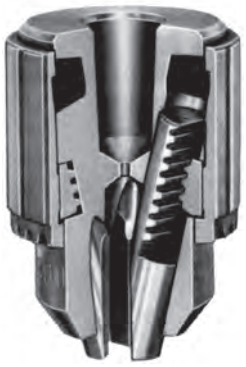
The O.E.M. standard for accuracy and durability on all types of industrial power and machine tools.

FEATURES:

- Heavy and Medium Duty models for threaded or taper mounting.
- Jaws centre-ground for absolute straightness and alignment.
- One-piece sleeve eliminates crack between driving teeth often found in other designs.
- Through-hardened sleeve teeth plus hardened nose and keyholes provide outstanding wear resistance.
- Each chuck 100% inspected for performance and precision.
- T.I.R. .004" maximum at half capacity.

Taper Mounted - Heavy Duty Model

- Fluted sleeve standard except Model 34-33C, which is smooth and ground.



Material Number	Model No.	Capacity Range Minimum in	Minimum mm	Maximum in	Maximum mm	Mount Jacobs	Key No.	Dimensions Closed Length in	Closed Length mm	Open Length in	Open Length mm	Sleeve Dia. in	Sleeve Dia. mm	Wgt Each gm
6223	3A	0.125	3	0.625	16.0	3JT	K3	3.81	96.8	2.87	72.9	2.30	58.4	907
14442	34-02	.040	1	0.500	13.0	2JT	K3	3.52	89.4	2.74	69.6	2.04	51.8	652
6295D	34-06	.040	1	0.500	13.0	6JT	K3	3.52	89.4	2.74	69.6	2.04	51.8	680
14445	34-33	.040	1	0.500	13.0	33JT	K3	3.52	89.4	2.74	69.6	2.04	51.8	652
14451	34-33C(4)	.040	1	0.500	13.0	33JT	K3C	3.71	94.2	2.93	74.4	2.00	50.8	737
6309D	36	0.18	0	0.800	20.3	3JT	K4	4.06	103.1	3.14	79.8	2.54	64.5	1275
14865	36KD(2)	0.18	5	0.800	20.3	3JT	K4	4.25	108.0	3.42	86.9	2.54	64.5	1247

Taper Mounted - Medium Duty Model

- Fluted sleeve standard except Models 0 and 1A, which are smooth and ground.
- All Series 33 Plain Bearing Chucks are hammer capable.

6200	0	.0135	.3	0.156	4.0	0JT	K0	1.404	36.8	1.100	27.9	0.850	21.6	56
6206D	1A	.040	1	0.250	6.5	1JT	K1	1.920	48.8	1.540	39.1	1.180	30.0	141
6214D	2A	.040	1	0.375	10.0	2JT	K2	2.810	71.4	2.170	55.1	1.670	42.4	368
6279D	33	0.08	2	0.500	13.0	33JT	K32	3.210	81.5	2.520	64.0	1.792	45.5	453
6281D	33KD(3)	0.08	2	0.500	13.0	33JT	K32	3.460	87.9	2.770	70.4	1.792	45.5	481

(1) Model 0 has a minimum capacity of a No. 80 (.0135in/.344mm) drill.
(2) Equipped with positive drive slot.
(3) Equipped with pin type positive drive.
(4) Equipped with locking collar - 1-1/1.6-20 thread, smooth sleeve.

Thread Mounted - Heavy Duty Model

- Fluted sleeve standard on all models.

6232D	3B 5/8	0.125	3	0.625	16.0	5/8-16	K3	3.81	97	2.84	72	2.29	58	907
6255D	7BA 3/8	0 (1)	1	0.250	6.5	3/8-24	K7	2.23	57	1.74	44	1.33	34	198
8859D	32BA 1/2	0 (1)	1	0.375	10.0	1/2-20	K32	3.05	77	2.31	59	1.79	45	396
33351D	35B 1/2	0.156	4	0.625	16.0	1/2-20	K3	3.52	89	2.74	70	2.04	52	708
6316D	36B 3/4	0.188	5	0.800	20.3	3/4-16	K4	4.12	105	3.20	81	2.54	65	1304