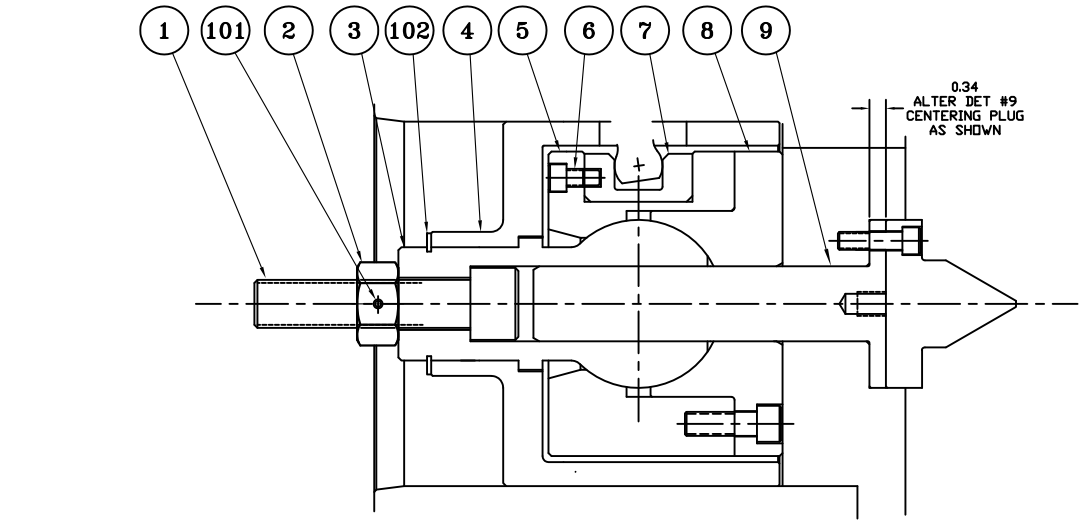
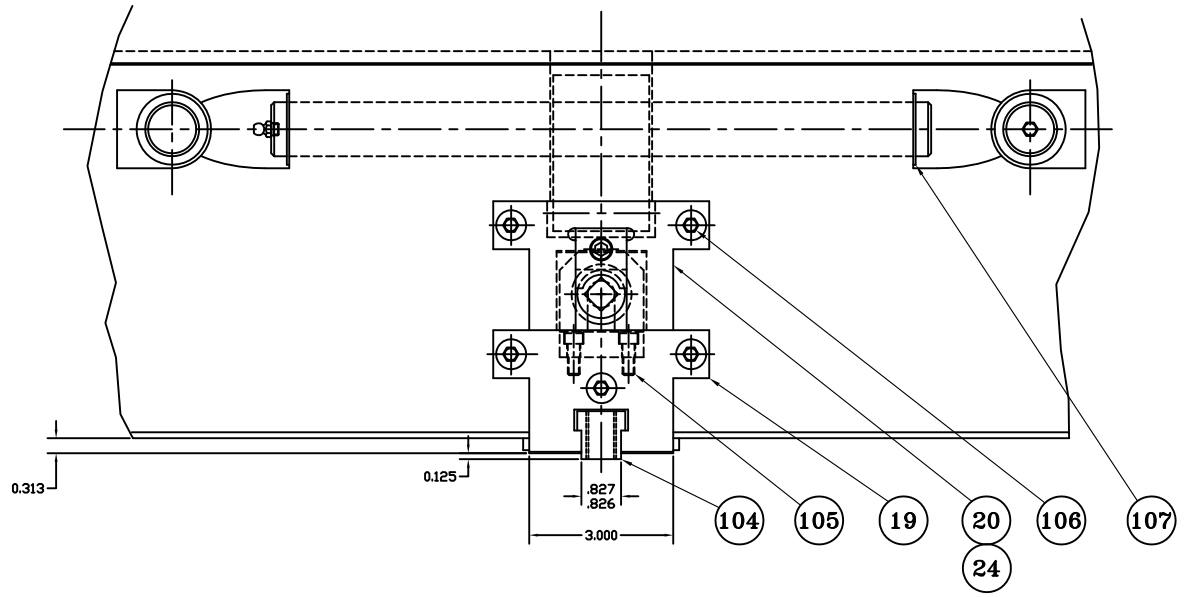
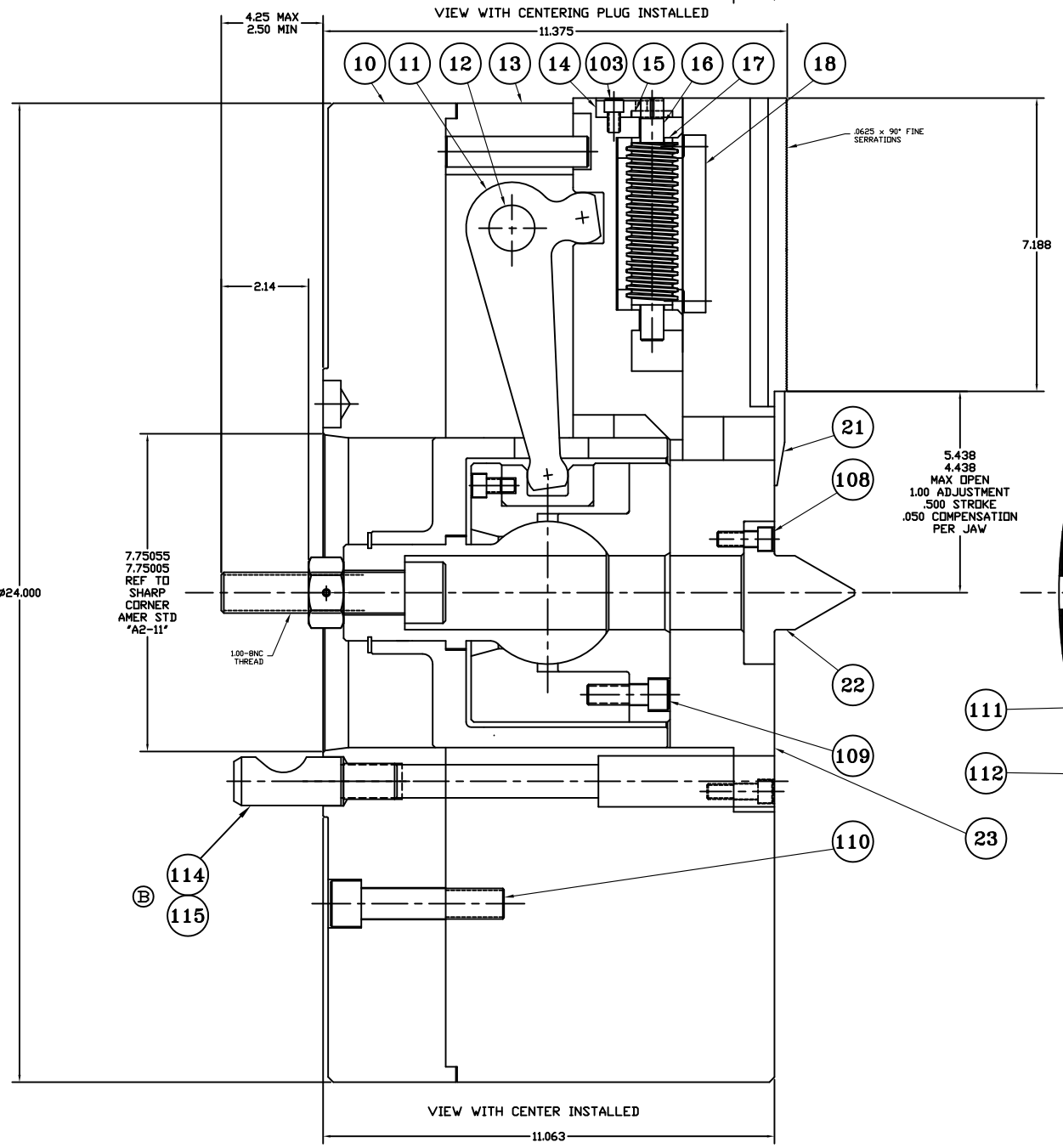
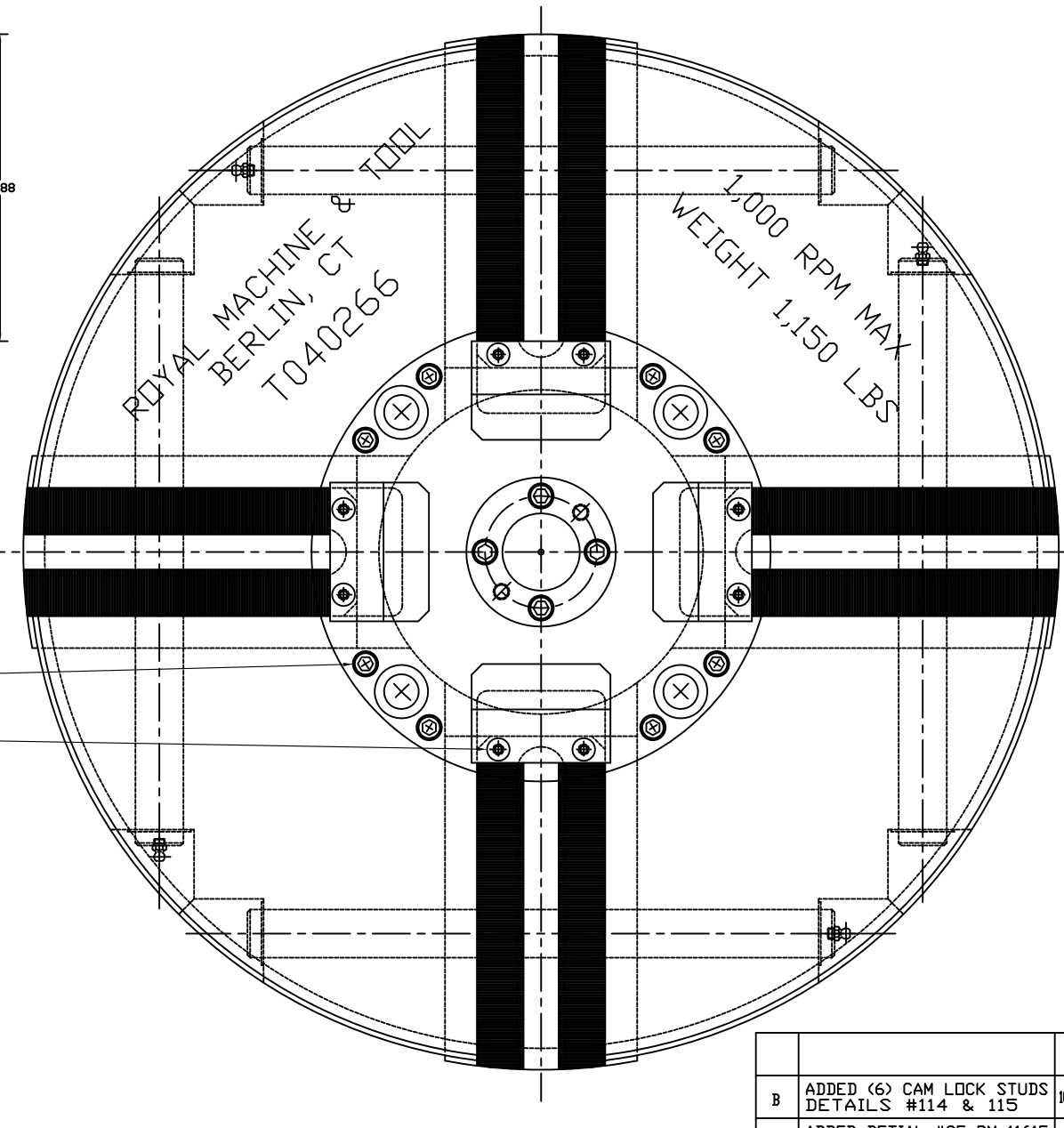








B	115	6	SHCS	STD	5/16-18 x 3/4 LG	
B	114	6	CAMLOCK STUD	MSC	#84392679	
	113	4	SHCS	STD	3/4-10NC X 7.50 LG	
	112	8	FLAT HEAD SHCS	STD	1/4-20NC X .63 LG	
	111	8	SHCS	STD	3/8-16NC X 1.25 LG	
	110	8	SHCS	STD	3/4-10NC X 3.50 LG	
	109	8	SHCS	STD	1/2-13NC X 1.50 LG	
	108	4	SHCS	STD	3/8-16NC X 1.00 LG	
	107	8	RETAINING RING	PURCH	WALDES #5100-112	
	106	24	GREASE FITTING	PURCH	ALEMITE #1792-B	
	105	16	SHCS	STD	1/4-20NC X .63 LG	
	104	12	JAW NUT	PURCH	DILLON #PH15T	
	103	4	SHCS	STD	5/16-18NC X .50 LG	
	102	1	RETAINING RING	PURCH	WALDES #5100-237	
	101	1	ROLL PIN	STD	.188 DIAM X 1.50 LG	
A	~~25~~	~~4~~	~~CAM LOCK NUT~~	~~R-STK~~	~~RM-11615~~	
	24	4	SHIM PLATE	A-2	.063 X1.875 X 4.25	
	23	1	CENTER COVER	4150HT STK	10.750 DIAM X 2.563	
	22	1	CENTER	S-7	3.500 DIAM X 2.720	
	21	4	CHIP COVER	C1018	.250 X 2.313 X 3.250	
	20	4	OPERATING JAW	8620	2.688 X 4.500 X 8.375	
	19	4	MASTER JAW	8620	2.563 X 4.500 X 7.813	
	18	4	ADJUSTING INSERT	C95400 AL BRZ	1.750 X 2.188 X 4.344	
	17	8	THRUST WASHER	R-STK	RM-12459	
	16	4	ADJUSTING SCREW	4150HT STK	1.250 DIAM X 6.00	
	15	4	LOCK PLATE	R-STK	RM-12395	
	14	4	LOCK CLAMP	R-STK	RM-12394	
	13	1	BODY	A-36	24.000 DIAM X 8.063	
	12	4	LEVER PIN	8620	1.125 DIAM X 13.750	
	11	4	LEVER	8620	2.000 X 3.250 X 7.563	
	10	1	REAR COVER	A-36	24.000 DIAM X 3.250	
	9	1	CENTERING PLUG	8620	3.500 DIAM X 7.750	
	8	1	COMPENSATOR CAP	8620	6.344 DIAM X 2.750	
	7	4	SWIVEL INSERT	8620	2.250 DIAM X 1.000	
	6	4	SWIVEL INSERT RETAINER	ALTER	SHCS 3/8-16NC X .75 LG	
	5	1	COMPENSATOR	8620	6.344 DIAM X 3.875	
	4	1	ACTUATOR SLEEVE	8620	7.594 DIAM X 7.250	
	3	1	ACTUATOR	8620	3.500 DIAM X 6.44	
	2	1	DRAW BOLT NUT	ALTER	HEX NUT 1.00-8NC X 4.50 LG	
	1	1	DRAW BOLT	ALTER	SHCS 1.00-8NC X 4.50 LG	

DET NO	NO REQ'D	NAME	MATERIAL	FIN STK SIZE	SHEET NO

SYM	REVISION	DATE	BY
B	ADDED (6) CAM LOCK STUDS DETAILS #114 & 115	10/7/14	AT
A	ADDED DETIAL #25 RM-11615 CAM LOCK NUT	7/7/14	JSD

TOLERANCES UNLESS OTHERWISE SPECIFIED
XX DIMS ±.010
XXX DIMS ±.005
ANG DIMS ±2°
CORNER RADII .020
SURFACE FINISH 125µ
REMOVE ALL BURRS AND SHARP EDGES
DO NOT SCALE DRAWING

TITLE: 24" DIAMETER 4 JAW SELF CENTERING/ COMPENSATING LEVER OPERATED CHUCK WITH ADJUSTABLE .0625 X 90 DEG SERRATED MASTER JAWS "A2-11" OR "D2-11" MOUNTING

-ROYAL- MACHINE & TOOL CORPORATION BERLIN, CONNECTICUT

CUSTOMER: TECHNICAL EQUIPMENT SALES

MACHINE USED ON	DES BY	DATE	SCALE	JOB NO	SHEET	SHEETS	TOOL NO.	REV
MONARCH 91 LATHE	JSD	2-7-14	HALF	#040266	1	16	12-038A	B