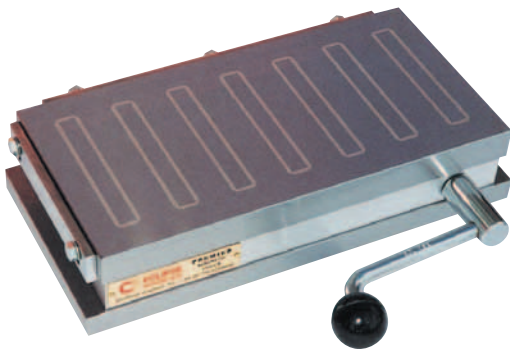


# Premier range magnetic chucks

Eclipse Magnetics invented the first permanent magnet chuck in 1934 and we continue to set the benchmark for quality workholding with today's Premier Range.

Premier range chucks are fully serviceable and can provide many years of service.

## Rectangular



- The all-metal top plate is extra thick to ensure maximum accuracy after frequent re-grinding
- Chrome plated side and end stops for packing and positioning
- The chucks can be partially magnetised to allow part positioning in set up
- Removable, ergonomically designed handles allow easy switching
- Supplied with clamps
- Custom sizes are available. Please call for details

Product No.	Length	Width	Height	Pole pitch
	<i>mm</i>			
AX47/P	203	42	127	17.6
AX510/P	276	53	129	35
AXS612/P	322	63	151	32
AXS614/P	360	63	151	32
AXS618/P	451	63	151	32
AXM824/P	601	63	201	35

dimensions are reference only

See page 14 for service and repair details

## Circular

The unique top plate configuration concentrates the magnetic energy on to the face of the chuck.

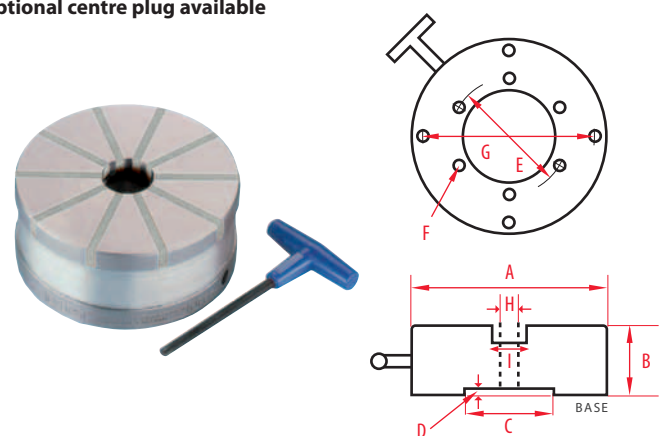
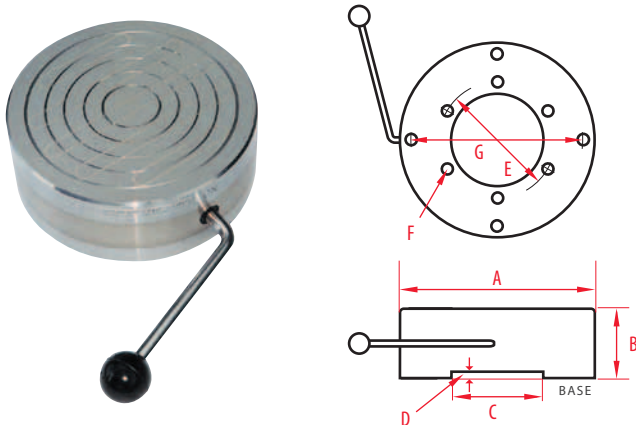
The chucks can be partially magnetised to aid the correct positioning of the workpiece. Grooved rings in the top plate assist in visual positioning to aid quick changeover in set up. Excellent for holding thin ring-shaped components that can be subject to radial distortion. Removable handles allow easy switching.

## Radial pole

Radial pole configuration concentrates the entire magnetism of the chuck into the workpiece – ideal for a wide range of operations from precision grinding to heavy turning.

Dynamically balanced to enable use at high rpm. All metal top plate and a rugged, industrial build ensures accuracy and longevity. Through-bore (except the NR100C) allows through-flushing of coolant during machining.

### Optional centre plug available



Product No.	A*	B	C	D	E	F	G
	<i>mm</i>						
AX475C/P	121	45	50.8	6.5	76.2	M6	101.6
AX651C/P	167	60	76.22	6.5	101.6	M10	139.7
AX91C/P	229	60	85.8	6.5	114.3	M10	190.5
AX12C/P	305	72	152.4	4.75	184.15	M12	254

\*reference diameter only

Product No.	A*	B	C	D	E	F	G	H	I	No. of Poles
	<i>mm</i>									
NR100C	100	48	50.8	6.5	n/a	M6	76	n/a	n/a	6
NR150C	150	69	76.2	4	n/a	M10	102	32	36	10
NR225C	225	71	85.8	5	114.3	M10	190.5	50	54	14
NR300C	300	71	152.4	54.75	184.15	M12	254	62	66	18

\*reference diameter only

# Standard range magnetic chucks

Standard Range chucks provide high performance at a competitive price.

- Clamping force: 80N/cm<sup>2</sup> on test piece (steel ring 52mmØ outer, 38mmØ inner, 10mm thick)
- Brass and steel top plates
- Removable hexagon key handles ensure ease of operation through a 180 degree arc
- All chucks are supplied with side and end stops
- All chucks are supplied with clamps

Standard chucks are available with a choice of 2 pole spacings:



## Standard Pole

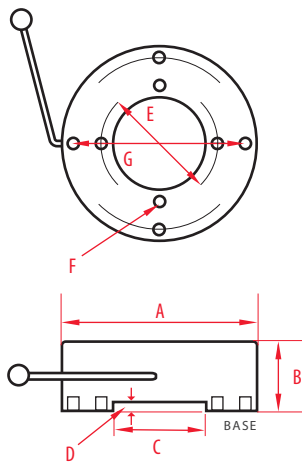
Pole spacing:  
**4.0mm steel – 2.0mm brass**  
 Effectively clamps all workpiece thicknesses down to 3mm.



## Fine Pole

Pole spacing:  
**1.5mm steel – 0.5mm brass**  
 Ideal for small or workpieces less than 3mm in height.

## Circular



Product No.		A*	B	C	D	E	F	G
STD POLE	FINE POLE	mm						
ECSP100	ECFP100	100	50	50.8	6.35	76.2	M6	n/a
ECSP125	ECFP125	125	50	50.8	6.35	76.2	M6	101.6
ECSP160	ECFP160	160	50	76.2	6.35	101.6	M10	139.7
ECSP195	ECFP195	195	50	76.2	6.35	101.6	M10	139.7
ECSP255	ECFP255	255	50	85.73	6.35	114.3	M10	190.5
ECSP310	ECFP310	310	50	152.4	6.35	184.15	M12	254
ECSP350	ECFP350	350	50	196.85	6.35	196.85	M12	n/a

## Rectangular



Product No.		Length	Width	Height
STD POLE	FINE POLE	mm		
ERSP1018	ERFP1018	175	100	50
ERSP1325	ERFP1325	255	130	50
ERSP1530	ERFP1530	300	150	50
ERSP1535	ERFP1535	350	150	50
ERSP1545	ERFP1545	450	150	50
ERSP2060	ERFP2060	600	200	50

## 'V' blocks

'V' blocks are ideal for holding cylindrical and complex workpieces for marking, spark erosion, grinding and measurement operations.



Can be used on its base, side or end.

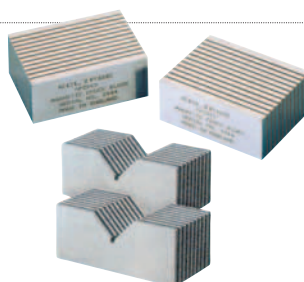
Product No.	Width	Length	Height	Max. dia. of workpiece		Weight
				Top 'V'	Bottom 'V'	
mm						
<b>10 micron accuracy</b>						
E934	70	101.6	95.5	65	22	1.98
E934MP	70	101.6	95.5	65	22	3.96
E935	70	80	95.5	65	22	3.12
E935MP	70	80	95.5	65	22	6.24
<b>25 micron accuracy</b>						
E933H	70	120	95	65	22	4.4
E933MPH	70	120	95	65	22	8.8
E935H	70	80	95	65	22	2.95
E935MPH	70	80	95	65	22	5.9

MP and MPH= Matched Pair

## Chuck blocks

Use to extend the flux paths of a magnetic chuck with parallel poles.

May be used horizontally or vertically. Can be machined to accommodate awkward workpieces.



Product No.	Length	Width	Height	Pole direction
mm				
950	60	75	30	longitudinal*
950v	50	100	40	longitudinal*

\*along width

Supplied in matched and numbered pairs.