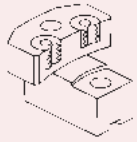


Thame Specialist Jaws & Services

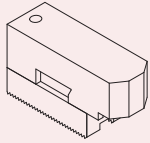
Page



Multi-Point Rocker Jaws

- Hard jaws with grip inserts
- For clamping thin walled workpieces

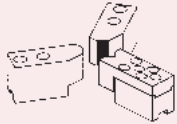
148



Quick Change Top Jaw System

- Convert your serrated power chuck to quick change

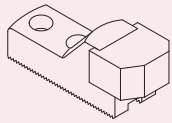
149



Tri Square Hard Jaws

- For clamping bar and square section on 3 jaw chucks

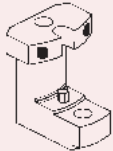
150



Insert System

- Plastic or aluminium inserts for gentle clamping

150



Design and Manufacture of Special Jaws

- Application Service

151



Replacement Chucks and Special Chucks

- Including cylinders, draw-tubes, etc.

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THAME WORKHOLDING

Field End, Thame Road, Long Crendon, Aylesbury, Bucks, HP18 9EJ England
Telephone: + 44 (0)1844 208050 Fax: + 44 (0)1844 201699
E-mail: sales@thameworkholding.com Web: www.thameworkholding.com

Multi-Point Rocker Jaws

Multi-Point Rocker Jaws are designed for clamping thin walled workpieces that are often deformed when clamped with conventional width jaws on a power chuck. They lower the deformation of the workpiece by spreading the clamping force equally to six or twelve clamping points on its perimeter. The floating rocker arms allow the part to self centre thus overcoming irregularity in castings and forgings as the part is clamped.



Thame Workholding's standard design of Rocker Jaws covers many applications and each assembly comes complete with a Master Base Jaw, Pivot Bolt, Rocker Arm and Serrated Grip Inserts.

A set of Multi-Point Rocker Jaws will cover a specific range of clamping diameters whilst the depth of grip can be varied by using our standard height pins.

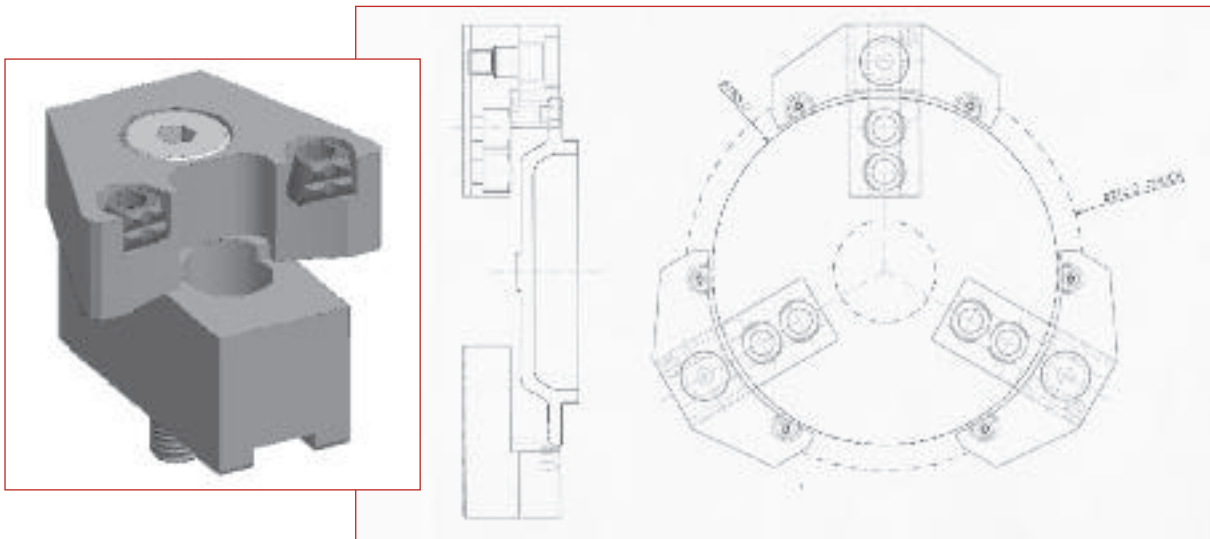
Using Multi-Point Rocker Jaws will assist in obtaining the best possible machined roundness on diameters and bores improving any out round to an acceptable level.

Multi-Point Rocker Jaws can improve deformation from hundreds of microns down to a single figure digit in some cases. Soft inserts or segments can also be used to allow second operation work with the rocking arms fixed.

We manufacture and design Multi-Point Rocker Jaws to suit all types of chucks including large vertical chucks up to 3 metres.

Standard Design

Available to suit a wide range of chucks contact our sales office for more information.



Special Design

We will design Multi-Point Rocker Jaws to suit your workpiece they could be six or twelve point contact jaws with all the necessary stops and location needed to clamp your part and reduce the out of roundness to an acceptable level. These are usually first operation jaws but provision for a second operation could also be possible.

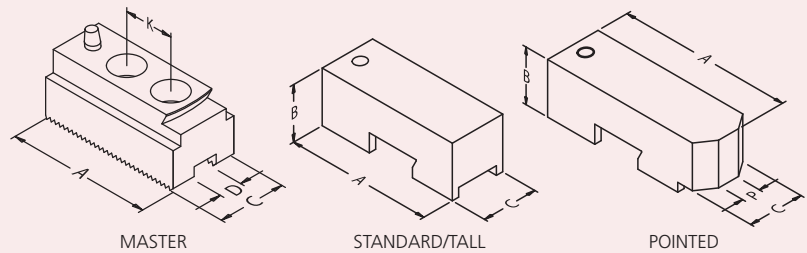


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Quick Change Soft Top Jaw System

- High Repeatability (0.020mm)
- Stable & Secure System
- Low profile Master Jaw
- Large Clamping Range Possible
- Changed in Seconds
- Other types available to order



To suit • 1.5mm x 60° Metric Serrated Power Chucks

The TEC Quick Change Jaw system consists of a hardened intermediate jaw, which is mounted to and normally stays on the chuck base jaws. This intermediate jaw has a unique mounting for inexpensive top jaws. A set of top jaws can be exchanged for a different set in a few seconds with only the simple push of a button. Jaws can be quickly interchanged with high levels of repeatability so providing all the advantages of a quick-change chuck but at a fraction of the cost.

Master Jaws

THAME PART No.	A	B	C	D	K	SERRATIONS	CHUCK Ø
QK 06	57.0	23.0	30.0	12.0	20.0	1.5mm x 60°	165mm
QK 08	67.5	27.5	31.8	14.0	25.0		200mm
QK 10	79.5	34.5	40.0	16.0	30.0		250mm
QK 12	85.5	34.5	50.0	18.0	30.0		315mm
QK 13	85.5	34.5	50.0	21.0	30.0		315mm
QK 15	116.0	45.0	63.5	22.0	43.0		380mm

Soft Top Jaws

THAME PART No.	JAW TYPE	A	B	C	P	FITS MASTER JAWS
QS 06	STANDARD	72	35	30		QK06
QT 06	TALL	72	50	30		QK06
QL 06	POINTED	80	35	30	6	QK06
QS 08	STANDARD	90	40	35		QK08
QT 08	TALL	90	60	35		QK08
QL 08	POINTED	105	40	35	6	QK08
QS 10	STANDARD	100	40	40		QK10
QT 10	TALL	100	60	40		QK10
QL 10	POINTED	120	40	40	8	QK10
QS 12	STANDARD	110	50	50		QK12, QK13
QT 12	TALL	110	80	50		QK12, QK13
QL 12	POINTED	135	50	50	10	QK12, QK13
QS 15	STANDARD	130	80	60		QK15



THAME WORKHOLDING

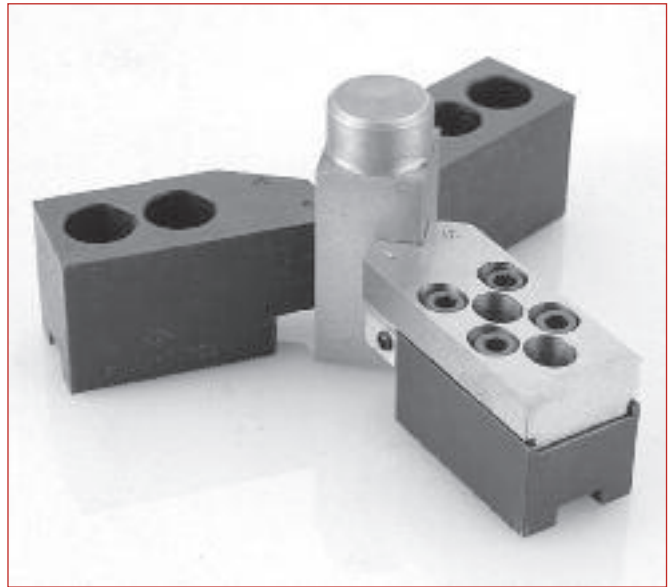
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Tri Square Top Jaws

For clamping square section on a 3 Jaw Chuck

Tri Square top jaws are adjustable hard top jaws used on three jaw chucks to clamp a range of square section. This simple but clever top jaw system removes the need in many instances to use 2 or 4 jaw chucks for the clamping of square section. Tri Square top jaws are ideal for clamping a series of square parts of different size because of the quick and easy adjustment from one size to another. Tri Square top jaws allow more universal use of three jaw chucks allowing the clamping of square and round section - when using chucks as fixtures horizontally on machining centres this can save costs on special fixtures.

Tri Square jaws are made to order to suit your chuck type and range of section size. Special shaped jaws can also be designed to suit irregular, rectangular and polygonal shapes.



Insert Systems

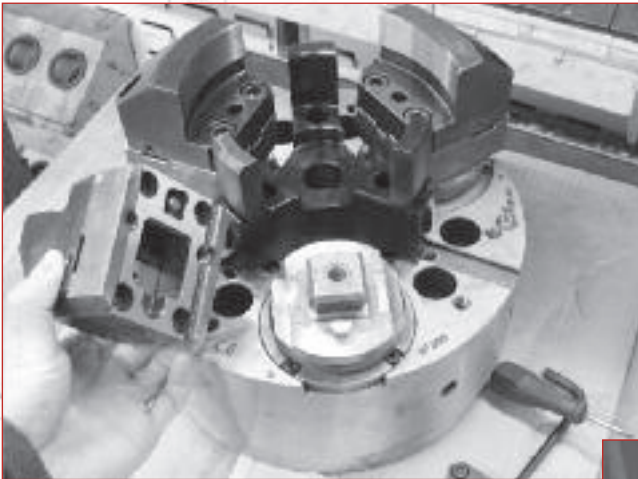
Plastic or aluminium inserts for gentle clamping



The use of inserts in a softer material can be an advantage when you need to clamp machined diameters during finishing operations. In this instance we offer to supply a range of plastic or aluminium inserts either standard width or wide to leave no marks when you clamp the workpiece.

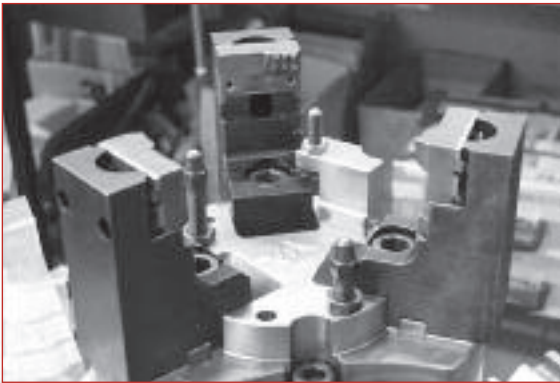
The support jaws can be steel or aluminium depending on the application and can be for serrated or slot and tenon style chucks. This method of clamping is often used to hold fragile parts that would be marked or distorted in steel jaws.

Design and Manufacture of Special Jaws



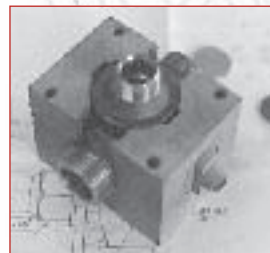
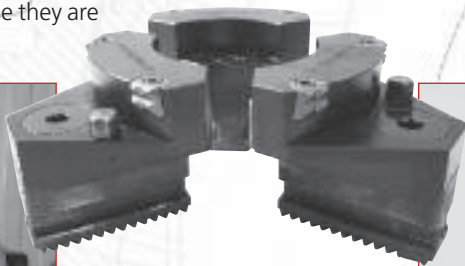
In house Design

In a perfect situation all applications would be covered by standard chucks and jaws, in reality to get the best performance or because it is technically impossible to hold the workpiece with standard products it is often necessary to use specifically designed chucks and jaws. This is where Thame ask you to let our specialist design engineers look at your problem and offer the optimum chuck and jaw solution. We will analyse your equipment and manufacturing operations to develop a specific recommendation to suit your workpiece.



Special Jaws

We have over thirty years experience and know-how in the design and manufacture of special jaws. Every year we design and produce hundreds of innovative solutions to help our customers increase their productivity. This specialist knowledge is at your disposal, please try our service and join the large number of our customers who return time and time again because they are satisfied with the end result.



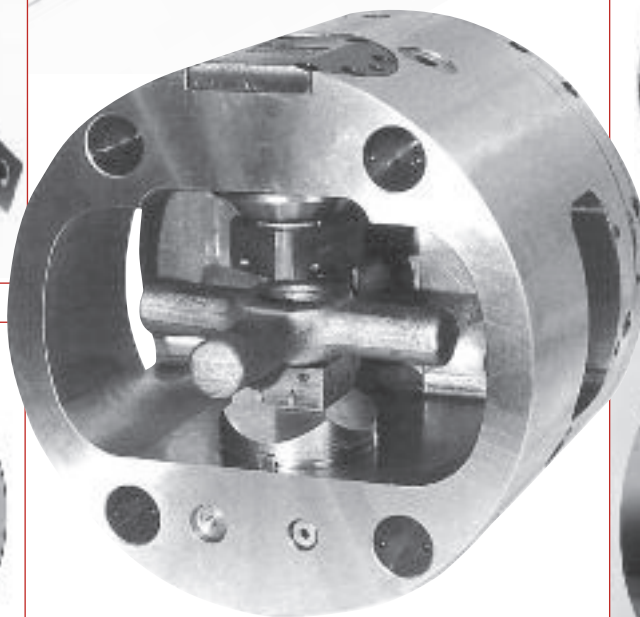
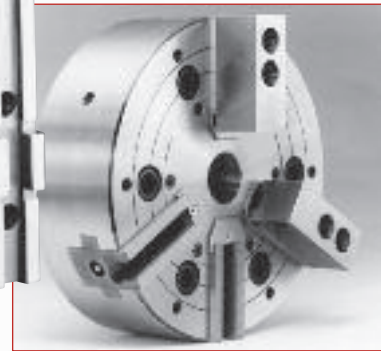
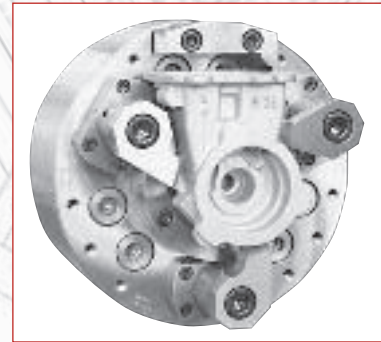
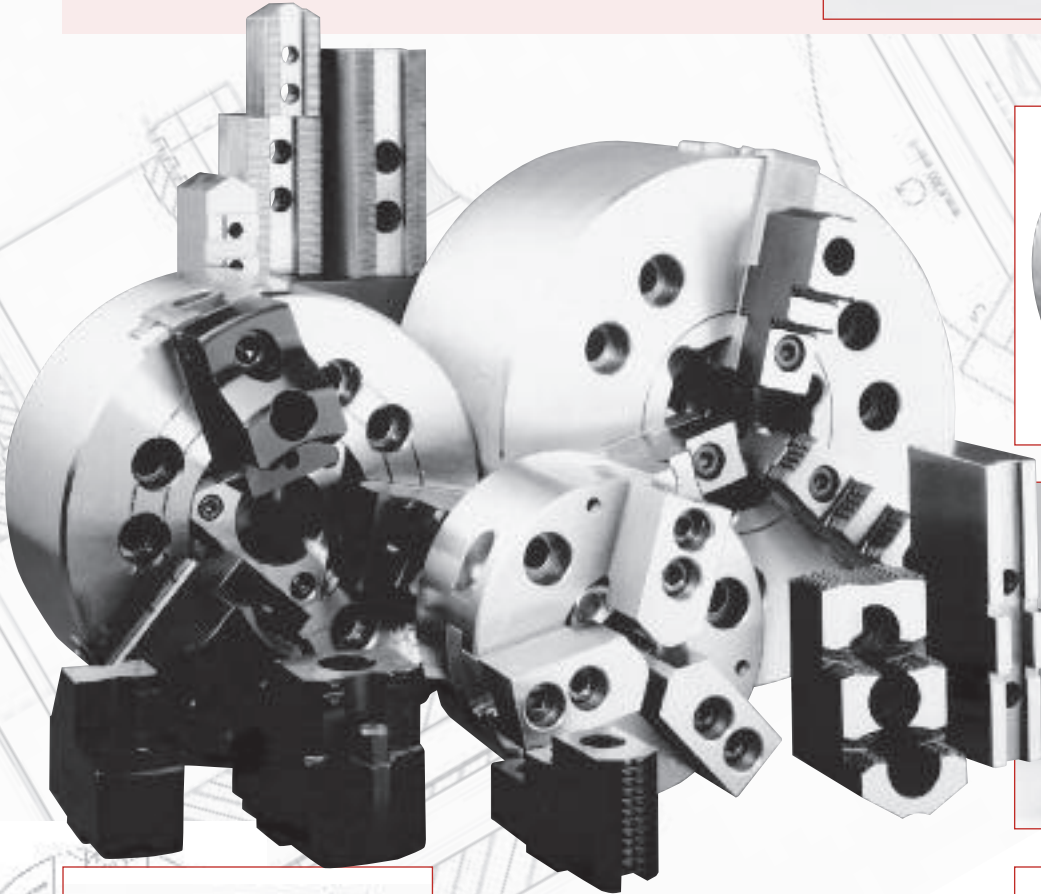
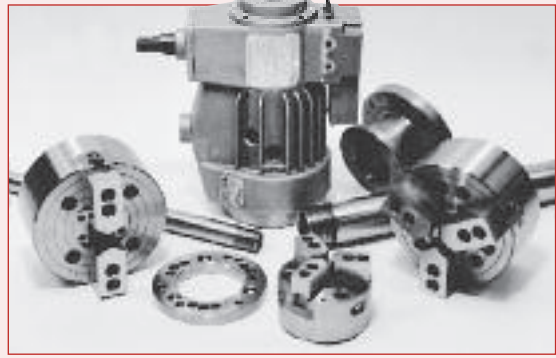
Thame Specialist
Jaws & Services

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Replacement Chucks and Special Chucks

Manual and Power Chucks, including retro-fit systems to suit most applications. We will design, supply and fit complete packages –top tooling, chuck, adaptors, draw-tube/bar, connectors, cylinders and all ancillary products. We also design Special Chucks for customers to suit their application including Pull Back, Indexing and Eccentric Chucks.



Thame Specialist
Jaws & Services

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