

HR Series Electromagnetic Chuck

Magna-Lock USA HR series electromagnetic chucks feature the same top plate pattern as the HL series (Economag) chucks in models less than 12" wide. These chucks offer excellent stability for heavy machining and grinding and are also ideally suited for use with parallels and V-blocks and offer excellent holding for special fixtures and jigs.

Standard HR model sizes range from 5" x 10" to as large as 18" x 60". The maximum recommended length for a magnetic chuck is 60". For larger sizes use combination of standard sizes in tandem or end-to-end mounting. When using chucks in tandem, it is essential that all chucks remain parallel. If one of them needs to be replaced, all of them will need to be re-ground together to achieve a level machining table.

These chucks have lower wattage than other models which will mean less heat when in use. This in turn means closer grinding tolerances due to less expansion of metals in the chuck. Additionally, these chucks would require a less expensive chuck controller because of the lower wattage. Direct current voltage should be specified by customer with 115 or 230 DC being standard and can be altered in the field on units with multi-coils.

The longitudinal laminated top plate design is all steel construction with 1/8" magnetic steel poles and 1/32" non-magnetic stainless-steel separators extending end to end with a total pitch of 5/32" for chucks up to 12" wide. For chucks wider than 12", the longitudinal top plate design is the same materials but with 1/4" magnetic steel poles and 1/8" non-magnetic stainless-steel separators with a total pitch of 3/8". The HR series design provides high holding power at both ends where single workpieces are normally placed.

Top plates are replaceable without replacing the entire unit. The standard thickness size of the replaceable top plates for these models is 1.125" with .625" useable before replacement. Top plates can be made with larger laminations for special applications very easily. All sizes are furnished with adjustable backstops and end stops.

Standard mounting is sometimes referred to as clamping ledge, Chucks will be furnished with extended base plates to provide clamping ledges at each end. Hold down clamps are provided with the chuck. For butting two or more chucks together without an intervening gap, or for other special requirements, chucks can be furnished with flush ends and provided with counterbored clearance holes for mounting bolts.

Magna-Lock USA Flame Hardening Chucks are for positive, distortion-free holding of workpieces during flame hardening. A large selection of sizes is available, with waterproof construction for complete submersion. Their design allows high wattage input for high holding power, and the longitudinal pole pattern is readily adaptable to additional simple fixturing. Contact our sales team for more information on this unusual application which further demonstrates Magna-Lock USA workholding versatility and ruggedness.



Contact Us

5015 28th Avenue

Rockford, IL 61109

815-962-8700

info@obsidianmfg.com

obsidianmfg.com | magnalock.com