

ULTRA-LOCK™ MILLING CHUCKS

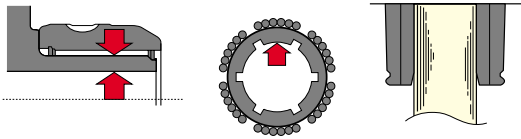
BULL'S-EYE™ CHUCK

LSK™ COLLET CHUCK

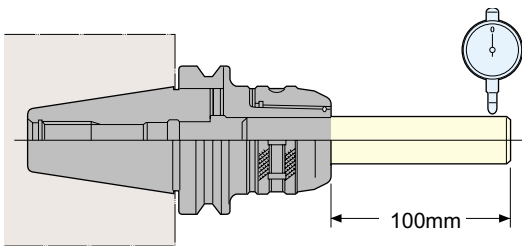
INSIDER™ COLLET CHUCK

ULTRA LOCK™ MILLING

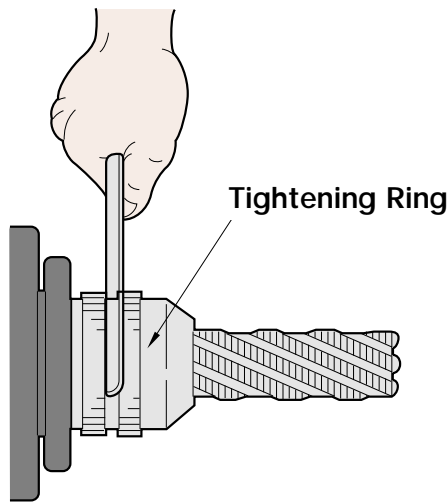




A thick wall and internal slots create strong chucking torque and rigidity. Our unique chucking mechanism makes the Ultra-Lock™ the only Milling Chuck that clamps the cutting tool evenly up to 3mm from the chuck's nose.



The finest run-out accuracy of any Milling Chuck (5µm at 100mm from nose)



Instructions: Tighten the Tightening Ring with the spanner (sold separately) completely to the collar for maximum grip. For finish milling, or when higher run-out accuracy is required, return Tightening Ring slightly (less than 3 degrees).

Ultra-Rigidity, Ultra-Grip, Ultra-Precision

The Ultra-Lock™ Milling Chuck has the highest accuracy and strongest grip of any Milling Chuck available today. Our latest generation of Milling Chuck will meet or exceed the high precision and heavy duty machining standards of today's most demanding high-performance applications.

Ultra-Lock™ Milling Chuck Sizes:

- UMC0750: 0.750" bore
- UMC1000: 1.000" bore
- UMC1250: 1.250" bore
- UMC2000: 2.000" bore
- Collets available (see page 28)

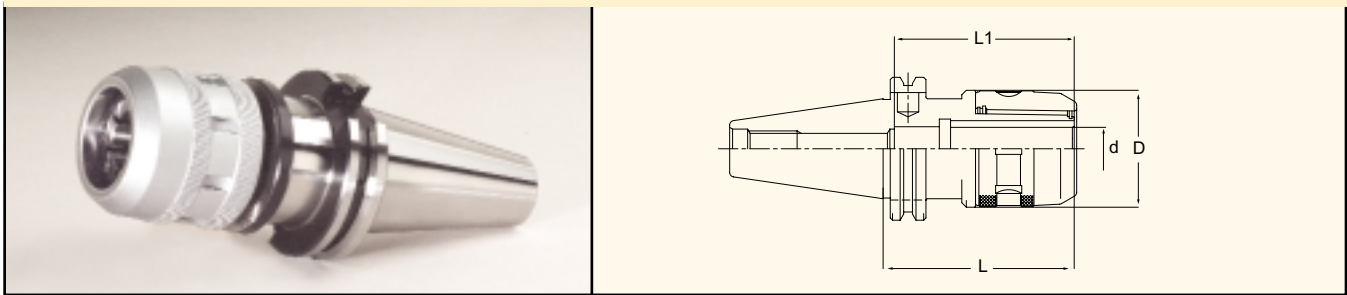
Features:

- Accuracy: run-out accuracy is less than 5µm at 100mm from the nose.
- Cutting Tools: cylindrical shank cutting tools with a tolerance of H7 or better (H6 or better for high-speed applications) are strongly recommended.
- Chucking Length: cutting tools must be inserted to a minimum depth. Please refer to the operation manual.
- Thick wall construction: ensures strong rigidity and high clamping force.

Coolant Capacity:

- Coolant-Thru the Tool: Maximum 1,000 PSI when utilizing the Coolant Collet and Coolant-Thru Nut (see page 28)
- Coolant Along the Tool: Maximum 1,000 PSI when utilizing the Coolant Collet and Slotted Nut or Nozzle Nut (see page 28)

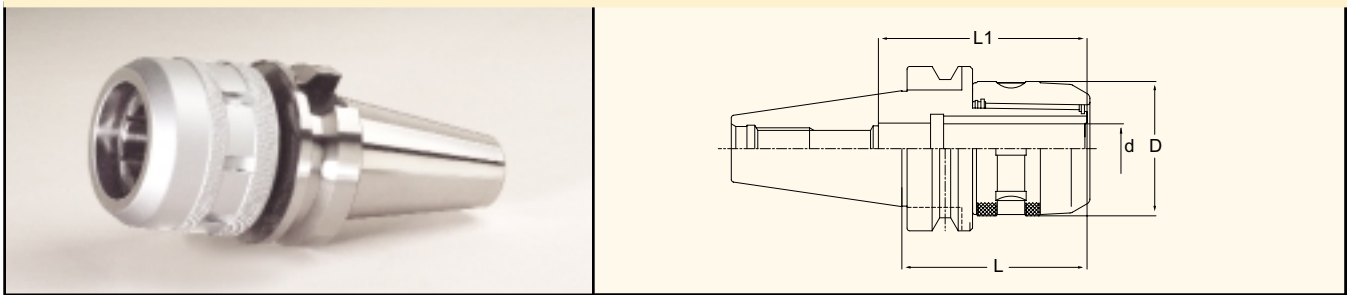
CT TAPER ULTRA-LOCK™ MILLING CHUCKS



Part Number	Taper	Collet Series	Clamping Range	d	L	L1	D
C40UMC-0750	CT40	UMC0750	0.125-0.750"	0.750"	3.346"	3.150"	2.047"
C40UMC-0750L	CT40	UMC0750	0.125-0.750"	0.750"	4.134"	3.150"	2.047"
C40UMC-1000	CT40	UMC1000	0.125-1.000"	1.000"	3.346"	3.150"	2.362"
C40UMC-1000L	CT40	UMC1000	0.125-1.000"	1.000"	4.134"	3.150"	2.362"
C40UMC-1250	CT40	UMC1250	0.187-1.250"	1.250"	3.346"	3.031"	2.520"
C40UMC-1250L	CT40	UMC1250	0.187-1.250"	1.250"	4.724"	3.031"	2.520"
C45UMC-0750	CT45	UMC0750	0.125-0.750"	0.750"	3.543"	3.150"	2.047"
C45UMC-1000	CT45	UMC1000	0.125-1.000"	1.000"	4.134"	3.150"	2.362"
C45UMC-1250	CT45	UMC1250	0.187-1.250"	1.250"	4.134"	4.134"	2.717"
C50UMC-0750	CT50	UMC0750	0.125-0.750"	0.750"	4.134"	3.150"	2.047"
C50UMC-0750L	CT50	UMC0750	0.125-0.750"	0.750"	5.315"	3.150"	2.047"
C50UMC-1000	CT50	UMC1000	0.125-1.000"	1.000"	4.134"	3.150"	2.362"
C50UMC-1000L	CT50	UMC1000	0.125-1.000"	1.000"	5.315"	3.150"	2.362"
C50UMC-1250	CT50	UMC1250	0.187-1.250"	1.250"	4.134"	4.134"	2.717"
C50UMC-1250L	CT50	UMC1250	0.187-1.250"	1.250"	5.315"	4.134"	2.717"
C50UMC-2000	CT50	UMC2000	1.000-2.000"	2.000"	4.921"	3.228"	4.134"

Note: Balanceable Milling Chucks are available upon request.

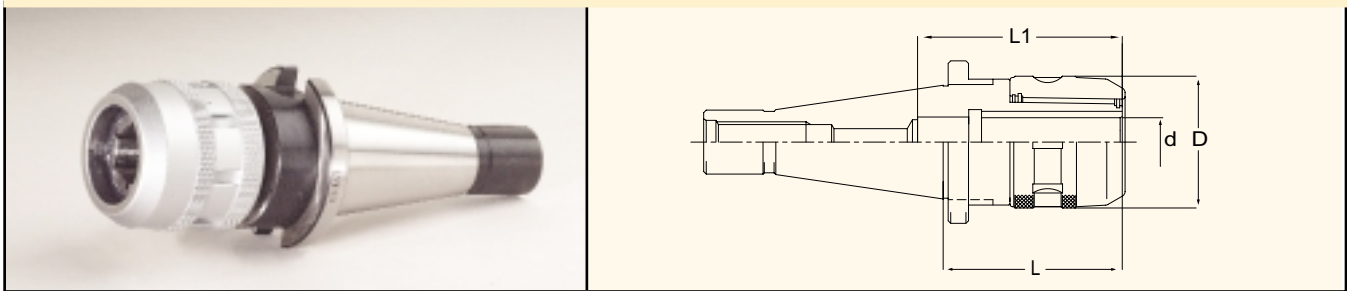
BT TAPER ULTRA-LOCK™ MILLING CHUCKS



Part Number	Taper	Collet Series	Clamping Range	d	L	L1	D
B30UMC-0750	BT30	UMC0750	0.125-0.750"	0.750"	2.953"	3.150"	2.047"
B35UMC-0750	BT35	UMC0750	0.125-0.750"	0.750"	2.756"	3.150"	2.047"
B40UMC-0750	BT40	UMC0750	0.125-0.750"	0.750"	2.756"	3.150"	2.047"
B40UMC-0750L	BT40	UMC0750	0.125-0.750"	0.750"	4.134"	3.150"	2.047"
B40UMC-1000	BT40	UMC1000	0.125-1.000"	1.000"	2.756"	3.150"	2.362"
B40UMC-1000L	BT40	UMC1000	0.125-1.000"	1.000"	3.543"	3.150"	2.362"
B40UMC-1250	BT40	UMC1250	0.187-1.250"	1.250"	3.346"	3.031"	2.717"
B40UMC-1250L	BT40	UMC1250	0.187-1.250"	1.250"	4.724"	4.134"	2.717"
B45UMC-1250	BT45	UMC1250	0.187-1.250"	1.250"	3.346"	4.134"	2.717"
B50UMC-0750	BT50	UMC0750	0.125-0.750"	0.750"	4.134"	3.150"	2.047"
B50UMC-0750L	BT50	UMC0750	0.125-0.750"	0.750"	5.315"	3.150"	2.047"
B50UMC-1000	BT50	UMC1000	0.125-1.000"	1.000"	4.134"	3.150"	2.362"
B50UMC-1000L	BT50	UMC1000	0.125-1.000"	1.000"	5.315"	3.150"	2.362"
B50UMC-1250	BT50	UMC1250	0.187-1.250"	1.250"	3.543"	4.134"	2.717"
B50UMC-1250L	BT50	UMC1250	0.187-1.250"	1.250"	5.315"	4.134"	2.717"
B50UMC-2000	BT50	UMC2000	1.000-2.000"	2.000"	4.134"	3.543"	4.134"

Note: Balanceable Milling Chucks are available upon request.

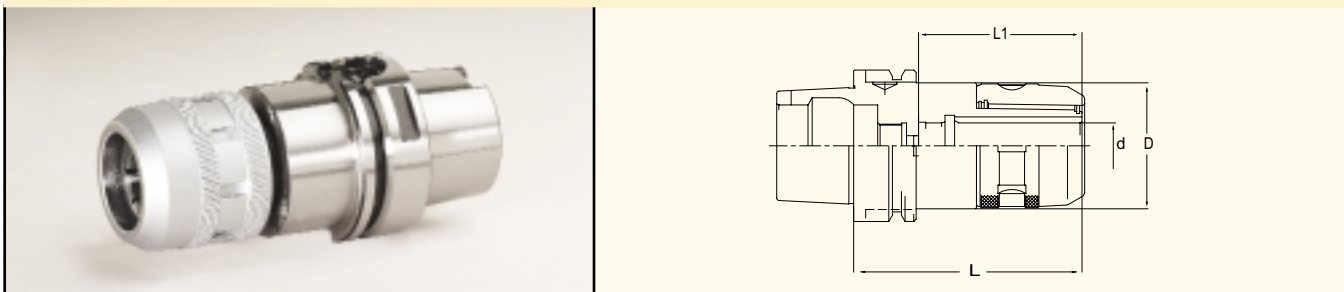
NMTB TAPER ULTRA-LOCK™ MILLING CHUCKS



Part Number	Taper	Collet Series	Clamping Range	d	L	L1	D
N40UMC-0750	NMTB40	UMC0750	0.125-0.750"	0.750"	2.756"	3.150"	2.047"
N40UMC-1250	NMTB40	UMC1250	0.187-1.250"	1.250"	4.134"	3.150"	2.717"
N50UMC-0750	NMTB50	UMC0750	0.125-0.750"	0.750"	2.559"	3.150"	2.047"
N50UMC-1250	NMTB50	UMC1250	0.187-1.250"	1.250"	3.543"	4.134"	2.717"
N50UMC-2000	NMTB50	UMC2000	1.000-2.000"	2.000"	4.134"	3.543"	4.134"

Note: All NMTB toolholder flanges are qualified for use with Erickson QC spindles.

HSK ULTRA-LOCK™ MILLING CHUCKS



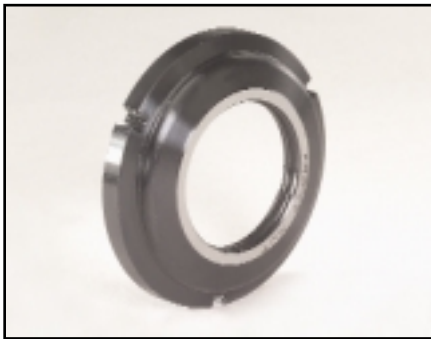
Part Number	Taper	Collet Series	Clamping Range	d	L	L1	D
HSK63A-UMC0750-95	HSK63A	UMC0750	0.125-0.750"	0.750"	3.740"	2.480"	2.047"
HSK63A-UMC0750-110	HSK63A	UMC0750	0.125-0.750"	0.750"	4.331"	3.150"	2.047"
HSK63A-UMC1000-100	HSK63A	UMC1000	0.125-1.000"	1.000"	3.937"	2.972"	2.362"
HSK63A-UMC1000-130	HSK63A	UMC1000	0.125-1.000"	1.000"	5.118"	3.150"	2.362"
HSK63A-UMC1250-110	HSK63A	UMC1250	0.187-1.250"	1.250"	4.331"	3.268"	2.717"
HSK63A-UMC1250-130	HSK63A	UMC1250	0.187-1.250"	1.250"	5.118"	3.189"	2.717"
HSK100A-UMC0750-115	HSK100A	UMC0750	0.125-0.750"	0.750"	4.528"	3.150"	2.047"
HSK100A-UMC0750-135	HSK100A	UMC0750	0.125-0.750"	0.750"	5.315"	3.150"	2.047"
HSK100A-UMC1000-115	HSK100A	UMC1000	0.125-1.000"	1.000"	4.528"	3.150"	2.362"
HSK100A-UMC1000-135	HSK100A	UMC1000	0.125-1.000"	1.000"	5.315"	3.150"	2.362"
HSK100A-UMC1250-115	HSK100A	UMC1250	0.187-1.250"	1.250"	4.528"	3.268"	2.717"
HSK100A-UMC1250-165	HSK100A	UMC1250	0.187-1.250"	1.250"	6.496"	3.189"	2.717"
HSK100A-UMC2000-125	HSK100A	UMC2000	1.000-2.000"	2.000"	4.921"	3.543"	4.134"

Note: Balanceable Milling Chucks are available upon request.



Ultra-Lock™ Milling Chuck Collets

The Ultra-Lock™ Milling Chuck Collets are designed to insure uniform collapsing around the cutting tool shank. This provides maximum gripping power as well as concentric positioning of the cutting tool. Collets are available for all sizes of Ultra-Lock Milling Chucks (see page 29 for sizes and part numbers).



Coolant-Thru Nut

When paired with the Ultra-Lock™ Milling Chuck Coolant Collet (not shown), the Coolant-Thru Nut forms a complete seal around the cutting tool. This combination is well suited for coolant-thru cutting tools. Both the Coolant Collet and the Coolant-Thru Nut must be ordered on size for each cutting tool (see page 30 for sizes and part numbers).



Slotted Nut

When paired with the Ultra-Lock™ Milling Chuck Coolant Collet (not shown), the Slotted Nut allows coolant to travel down the shank of the cutting tool to the cutting edge. This combination is well suited for non-coolant-thru cutting tools. Both the Coolant Collet and the Slotted Nut must be ordered on size for each cutting tool (see page 30 for sizes and part numbers).



Nozzle Nut

When paired with the Ultra Lock™ Milling Chuck Coolant Collet (not shown), the Nozzle Nut allows the operator to direct the coolant to the cutting edge via three nozzles. This combination is well suited for non-coolant-thru cutting tools, particularly tools where the cutting tool shank diameter is smaller than the actual cutting edge diameter. Both the Coolant Collet and the Nozzle Nut must be ordered on size for each cutting tool (see page 30 for sizes and part numbers).

0750 ULTRA-LOCK™ INCH COLLETS

Part Number	Size
UMC0750-008	1/8"
UMC0750-012	3/16"
UMC0750-016	1/4"
UMC0750-020	5/16"
UMC0750-024	3/8"
UMC0750-028	7/16"
UMC0750-032	1/2"
UMC0750-036	9/16"
UMC0750-040	5/8"

0750 ULTRA-LOCK™ METRIC COLLETS

Part Number	Size
UMC0750-6	6mm
UMC0750-7	7mm
UMC0750-8	8mm
UMC0750-10	10mm
UMC0750-12	12mm
UMC0750-14	14mm
UMC0750-16	16mm

1000 ULTRA-LOCK™ INCH COLLETS

Part Number	Size
UMC1000-008	1/8"
UMC1000-012	3/16"
UMC1000-016	1/4"
UMC1000-020	5/16"
UMC1000-024	3/8"
UMC1000-028	7/16"
UMC1000-032	1/2"
UMC1000-040	5/8"
UMC1000-048	3/4"
UMC1000-056	7/8"

1000 ULTRA-LOCK™ METRIC COLLETS

Part Number	Size
UMC1000-6	6mm
UMC1000-8	8mm
UMC1000-10	10mm
UMC1000-12	12mm
UMC1000-14	14mm
UMC1000-16	16mm
UMC1000-18	18mm
UMC1000-20	20mm

1250 ULTRA-LOCK™ INCH COLLETS

Part Number	Size
UMC1250-012	3/16"
UMC1250-016	1/4"
UMC1250-020	5/16"
UMC1250-024	3/8"
UMC1250-028	7/16"
UMC1250-032	1/2"
UMC1250-036	9/16"
UMC1250-040	5/8"
UMC1250-048	3/4"
UMC1250-056	7/8"
UMC1250-064	1"

1250 ULTRA-LOCK™ METRIC COLLETS

Part Number	Size
UMC1250-6	6mm
UMC1250-8	8mm
UMC1250-10	10mm
UMC1250-12	12mm
UMC1250-14	14mm
UMC1250-16	16mm
UMC1250-20	20mm
UMC1250-25	25mm

Note: Ultra-Lock™ Milling Chuck Collets are available with a depth-adjustment mechanism upon request

2000 ULTRA-LOCK™ INCH COLLETS

Part Number	Size
UMC2000-064	1"
UMC2000-080	1 1/4"
UMC2000-096	1 1/2"



UMC0750 ULTRA-LOCK™ COOLANT SYSTEM

Size	COOLANT COLLET	COOLANT-THRU NUT	SLOTTED NUT	NOZZLE NUT
1/8"	UMC0750-008(C)	UMC0750N-008(C)	UMC0750N-008(S)	UMC0750N-008(N)
3/16"	UMC0750-012(C)	UMC0750N-012(C)	UMC0750N-012(S)	UMC0750N-012(N)
1/4"	UMC0750-016(C)	UMC0750N-016(C)	UMC0750N-016(S)	UMC0750N-016(N)
5/16"	UMC0750-020(C)	UMC0750N-020(C)	UMC0750N-020(S)	UMC0750N-020(N)
3/8"	UMC0750-024(C)	UMC0750N-024(C)	UMC0750N-024(S)	UMC0750N-024(N)
7/16"	UMC0750-028(C)	UMC0750N-028(C)	UMC0750N-028(S)	UMC0750N-028(N)
1/2"	UMC0750-032(C)	UMC0750N-032(C)	UMC0750N-032(S)	UMC0750N-032(N)
9/16"	UMC0750-036(C)	UMC0750N-036(C)	UMC0750N-036(S)	UMC0750N-036(N)
5/8"	UMC0750-040(C)	UMC0750N-040(C)	UMC0750N-040(S)	UMC0750N-040(N)
6mm	UMC0750-6(C)	UMC0750N-6(C)	UMC0750N-6(S)	UMC0750N-6(N)
7mm	UMC0750-7(C)	UMC0750N-7(C)	UMC0750N-7(S)	UMC0750N-7(N)
8mm	UMC0750-8(C)	UMC0750N-8(C)	UMC0750N-8(S)	UMC0750N-8(N)
10mm	UMC0750-10(C)	UMC0750N-10(C)	UMC0750N-10(S)	UMC0750N-10(N)
12mm	UMC0750-12(C)	UMC0750N-12(C)	UMC0750N-12(S)	UMC0750N-12(N)
14mm	UMC0750-14(C)	UMC0750N-14(C)	UMC0750N-14(S)	UMC0750N-14(N)
16mm	UMC0750-16(C)	UMC0750N-16(C)	UMC0750N-16(S)	UMC0750N-16(N)

UMC1000 ULTRA-LOCK™ COOLANT SYSTEM

Size	COOLANT COLLET	COOLANT-THRU NUT	SLOTTED NUT	NOZZLE NUT
1/8"	UMC1000-008(C)	UMC1000N-008(C)	UMC1000N-008(S)	UMC1000N-008(N)
3/16"	UMC1000-012(C)	UMC1000N-012(C)	UMC1000N-012(S)	UMC1000N-012(N)
1/4"	UMC1000-016(C)	UMC1000N-016(C)	UMC1000N-016(S)	UMC1000N-016(N)
5/16"	UMC1000-020(C)	UMC1000N-020(C)	UMC1000N-020(S)	UMC1000N-020(N)
3/8"	UMC1000-024(C)	UMC1000N-024(C)	UMC1000N-024(S)	UMC1000N-024(N)
7/16"	UMC1000-028(C)	UMC1000N-028(C)	UMC1000N-028(S)	UMC1000N-028(N)
1/2"	UMC1000-032(C)	UMC1000N-032(C)	UMC1000N-032(S)	UMC1000N-032(N)
5/8"	UMC1000-040(C)	UMC1000N-040(C)	UMC1000N-040(S)	UMC1000N-040(N)
3/4"	UMC1000-048(C)	UMC1000N-048(C)	UMC1000N-048(S)	UMC1000N-048(N)
7/8"	UMC1000-056(C)	UMC1000N-056(C)	UMC1000N-056(S)	UMC1000N-056(N)
6mm	UMC1000-6(C)	UMC1000N-6(C)	UMC1000N-6(S)	UMC1000N-6(N)
8mm	UMC1000-8(C)	UMC1000N-8(C)	UMC1000N-8(S)	UMC1000N-8(N)
10mm	UMC1000-10(C)	UMC1000N-10(C)	UMC1000N-10(S)	UMC1000N-10(N)
12mm	UMC1000-12(C)	UMC1000N-12(C)	UMC1000N-12(S)	UMC1000N-12(N)
14mm	UMC1000-14(C)	UMC1000N-14(C)	UMC1000N-14(S)	UMC1000N-14(N)
16mm	UMC1000-16(C)	UMC1000N-16(C)	UMC1000N-16(S)	UMC1000N-16(N)
18mm	UMC1000-18(C)	UMC1000N-18(C)	UMC1000N-18(S)	UMC1000N-18(N)
20mm	UMC1000-20(C)	UMC1000N-20(C)	UMC1000N-20(S)	UMC1000N-20(N)



UMC1250 ULTRA-LOCK™ COOLANT SYSTEM

Size	COOLANT COLLET	COOLANT-THRU NUT	SLOTTED NUT	NOZZLE NUT
3/16"	UMC1250-012(C)	UMC1250N-012(C)	UMC1250N-012(S)	UMC1250N-012(N)
1/4"	UMC1250-016(C)	UMC1250N-016(C)	UMC1250N-016(S)	UMC1250N-016(N)
5/16"	UMC1250-020(C)	UMC1250N-020(C)	UMC1250N-020(S)	UMC1250N-020(N)
3/8"	UMC1250-024(C)	UMC1250N-024(C)	UMC1250N-024(S)	UMC1250N-024(N)
7/16"	UMC1250-028(C)	UMC1250N-028(C)	UMC1250N-028(S)	UMC1250N-028(N)
1/2"	UMC1250-032(C)	UMC1250N-032(C)	UMC1250N-032(S)	UMC1250N-032(N)
9/16"	UMC1250-036(C)	UMC1250N-036(C)	UMC1250N-036(S)	UMC1250N-036(N)
5/8"	UMC1250-040(C)	UMC1250N-040(C)	UMC1250N-040(S)	UMC1250N-040(N)
3/4"	UMC1250-048(C)	UMC1250N-048(C)	UMC1250N-048(S)	UMC1250N-048(N)
7/8"	UMC1250-056(C)	UMC1250N-056(C)	UMC1250N-056(S)	UMC1250N-056(N)
1"	UMC1250-064(C)	UMC1250N-064(C)	UMC1250N-064(S)	UMC1250N-064(N)
6mm	UMC1250-6(C)	UMC1250N-6(C)	UMC1250N-6(S)	UMC1250N-6(N)
8mm	UMC1250-8(C)	UMC1250N-8(C)	UMC1250N-8(S)	UMC1250N-8(N)
10mm	UMC1250-10(C)	UMC1250N-10(C)	UMC1250N-10(S)	UMC1250N-10(N)
12mm	UMC1250-12(C)	UMC1250N-12(C)	UMC1250N-12(S)	UMC1250N-12(N)
14mm	UMC1250-14(C)	UMC1250N-14(C)	UMC1250N-14(S)	UMC1250N-14(N)
16mm	UMC1250-16(C)	UMC1250N-16(C)	UMC1250N-16(S)	UMC1250N-16(N)
20mm	UMC1250-20(C)	UMC1250N-20(C)	UMC1250N-20(S)	UMC1250N-20(N)
25mm	UMC1250-25(C)	UMC1250N-25(C)	UMC1250N-25(S)	UMC1250N-25(N)

UMC2000 ULTRA-LOCK™ COOLANT SYSTEM

Size	COOLANT COLLET	COOLANT-THRU NUT	SLOTTED NUT	NOZZLE NUT
1"	UMC2000-064(C)	UMC2000N-064(C)	UMC2000N-064(S)	UMC2000N-064(N)
1 1/4"	UMC2000-080(C)	UMC2000N-080(C)	UMC2000N-080(S)	UMC2000N-080(N)
1 1/2"	UMC2000-096(C)	UMC2000N-096(C)	UMC2000N-096(S)	UMC2000N-096(N)



BULL'S-EYE™ CHUCK

ISK™ COLLET CHUCK

INSIDER™ COLLET CHUCK

ULTRA LOCK™ MILLING

UMC Spanners

Part Number	Size
UMC0750-SPAN	UMC0750 Series Spanner
UMC1000-SPAN	UMC1000 Series Spanner
UMC1250-SPAN	UMC1250 Series Spanner
UMC2000-SPAN	UMC2000 Series Spanner

