PERMANENT MAGNETIC CHUCKS

Model RMA SUPER POWERFUL PERMANENT MAGNETIC CHUCK FOR CUTTING

Greatest holding power in KANETEC permanent magnetic chuck series. New design of ON-OFF switch provides improved durability.

[Application]
Usable for a wide range of applications from heavy duty cutting to heavy-duty grinding. Also suitable for certain small workpieces and thin workpieces.

[Features]
- Super powerful permanent magnetic chucks developed with special design for heavy duty cutting.
- Relatively fine pole pitches make the magnetism work effectively on certain small workpieces and thin workpieces.
- A drop in magnetic force due to air gaps is small, enabling heavy duty cutting of mill scale steel.
- The holding power is very strong, yet the operation of the select ratchet handle is light and safe. The handle is detachable for space saving.
- Usable in wet conditions.

RMA type holding power characteristics
- Relation between gaps and holding power by use of [116 test piece

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Mounting Face</th>
<th>Height</th>
<th>No. of Stoppers</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-1530A</td>
<td>150 (5.90) x 300 (11.8)</td>
<td>150 (5.90)</td>
<td>300 (11.8)</td>
<td>229 (9.0)</td>
<td>2 pcs</td>
<td>24 kg / 54 lb</td>
</tr>
<tr>
<td>RMA-1545A</td>
<td>150 (5.90) x 450 (17.7)</td>
<td>450 (17.7)</td>
<td>379 (14.9)</td>
<td>196 (7.7)</td>
<td>4 pcs</td>
<td>56 kg / 123 lb</td>
</tr>
<tr>
<td>RMA-2055A</td>
<td>200 (7.87) x 500 (19.6)</td>
<td>200 (7.87)</td>
<td>500 (19.6)</td>
<td>424 (16.6)</td>
<td>4 pcs</td>
<td>71 kg / 158 lb</td>
</tr>
<tr>
<td>RMA-3050A</td>
<td>300 (11.8) x 600 (23.6)</td>
<td>300 (11.8)</td>
<td>600 (23.6)</td>
<td>544 (21.4)</td>
<td>3 pcs</td>
<td>103 kg / 226 lb</td>
</tr>
<tr>
<td>RMA-4050A</td>
<td>400 (15.7) x 600 (23.6)</td>
<td>400 (15.7)</td>
<td>600 (23.6)</td>
<td>544 (21.4)</td>
<td>4 pcs</td>
<td>136 kg / 299 lb</td>
</tr>
</tbody>
</table>

* The ratchet handle (with socket) is included.

Model RMA-U TILT TYPE POWERFUL PERMANENT MAGNETIC CHUCK

Greatest holding power in KANETEC tilt type permanent magnetic chucks!

[Application]
Suitable for heavy duty grinding of inclined surfaces and light duty cutting.

[Features]
- The strong holding power enables inclined cutting.
- A drop in magnetic force due to air gaps is minimal to make this type suitable for cutting of mill scale steel.
- The tilting angle can be set as desired in a range of 90° forward and 90° backward.
- A 200-mm wide type is also available.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-1535U</td>
<td>150 (5.90) x 300 (11.8)</td>
<td>150 (5.90)</td>
<td>300 (11.8)</td>
<td>429 (16.8)</td>
<td>30 mm (.12)</td>
<td>61 kg / 133 lb</td>
</tr>
<tr>
<td>RMA-1545U</td>
<td>150 (5.90) x 450 (17.7)</td>
<td>450 (17.7)</td>
<td>379 (14.9)</td>
<td>424 (16.6)</td>
<td>30 mm (.12)</td>
<td>79 kg / 174 lb</td>
</tr>
<tr>
<td>RMA-2050U</td>
<td>200 (7.87) x 500 (19.6)</td>
<td>200 (7.87)</td>
<td>500 (19.6)</td>
<td>529 (20.8)</td>
<td>30 mm (.12)</td>
<td>108 kg / 236 lb</td>
</tr>
<tr>
<td>RMA-2055U</td>
<td>200 (7.87) x 600 (23.6)</td>
<td>200 (7.87)</td>
<td>600 (23.6)</td>
<td>529 (20.8)</td>
<td>30 mm (.12)</td>
<td>125 kg / 275 lb</td>
</tr>
</tbody>
</table>

* The ratchet handle (with socket) is included.
* The scaled ring can be used to set an angle roughly. When it is necessary to set the angle accurately, use a sine bar or other suitable device. Note that, when it is tilted forward, ON-OFF operation will become difficult.
Model **RMA-C**

**POWERFUL ROUND PERMANENT MAGNETIC CHUCK**

- **Features**
  - Strong holding power for various cutting applications.
  - The magnetic force adjust feature ensures efficient positioning of workpieces for machining by a lathe.
  - An easy-to-operate ratchet handle is employed for ON-OFF operation.
  - Holding power 1.5 times greater than that of conventional models.

- **Relation between handle turning angle and holding power**
  - (in the center of the attractive face)

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Mounting Face</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-C15</td>
<td>160 (6.29)</td>
<td>160 (6.29)</td>
<td>125 (4.92)</td>
<td>140 (5.51)</td>
</tr>
<tr>
<td>RMA-C20</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>125 (4.92)</td>
<td>180 (7.88)</td>
</tr>
<tr>
<td>RMA-C25</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>200 (7.87)</td>
<td>224 (8.81)</td>
</tr>
<tr>
<td>RMA-C32</td>
<td>315 (12.4)</td>
<td>315 (12.4)</td>
<td>250 (9.84)</td>
<td>280 (11.0)</td>
</tr>
<tr>
<td>RMA-C40</td>
<td>400 (15.7)</td>
<td>400 (15.7)</td>
<td>315 (12.4)</td>
<td>355 (13.9)</td>
</tr>
</tbody>
</table>

*The ratchet handle (with socket) is included.*

---

Model **RMA-V**

**VICE CLAMP TYPE PERMANENT MAGNETIC CHUCK FOR CUTTING**

- **Heavy duty application**

**A new construction and finer pole pitch to generate strongest holding power on small workpieces!**

- **Features**
  - Direct clamping in a vice by use of a block for easy removal of the chuck.
  - By securing a workpiece overhanging, 5 faces can be machined in one chucking.
  - The setup work is done more efficiently than when setting a workpiece in a vice.

![RMA-V1530 Diagram]

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Holding Power</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-V1325</td>
<td>125 (4.92)</td>
<td>150 (5.90)</td>
<td>10kN</td>
</tr>
<tr>
<td>RMA-V1530</td>
<td>150 (5.90)</td>
<td>200 (7.87)</td>
<td>15kN</td>
</tr>
</tbody>
</table>

*The ratchet handle (with socket) is included. For higher accuracy, the work face needs to be re-ground.*

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Model **RMAW**

**FINE PITCH POWERFUL RECTANGULAR PERMANENT MAGNETIC CHUCK**

- **Features**
  - Suitable for grinding small and thin workpieces.
  - Holds small and thin (thinner than 3 mm) workpieces effectively.
  - Holding performance greater than conventional models on hardened parts around molds.
  - Gap performance improved over conventional models.

**Comparison of holding power on weak magnetic materials**

Center - holding power

| 50 x 25 (SKH2, HRC60 hardened test piece) |
| RMAW-1018 | 650 (23.6) |
| RMAW-1015 | 900 (35.4) |

**Relation between holding power and thickness**

Center - thickness

| 25 x | 515 (20.3) |
| RMAW-1018 | 350 (13.8) |
| RMAW-1015 | 500 (19.7) |

*As for the handle, a hex wrench key is included.*

![RMAW-1018 Diagram]
PERMANENT MAGNETIC CHUCKS

Model RMT
POWERFUL RECTANGULAR PERMANENT MAGNETIC CHUCK

[Application]
Powerful permanent magnetic chucks for a wide range of applications from heavy duty grinding to light duty cutting. Usable in liquid also.

[Features]
- Light weight and thin, yet robust construction. Highly precise chucks minimizing influence of handle operation on accuracy.
- Usable for a wide range of workpieces, from thick to thin.

Special sizes available.

Model RMT-U
TILT TYPE PERMANENT MAGNETIC CHUCK

[Application]
Suitable for angle grinding on grinders. The strong holding power enables angle grinding of various workpieces regardless of whether they are thin, small or thick.

[Features]
- The rotary shaft with scale facilitates angle setting. (An angle can be set as desired between 90° forward and 90° backward)
- Easy installation and highly precise operations.

Model RMT-V
VICE CLAMP TYPE PERMANENT MAGNETIC CHUCK

Light duty cutting

[Application]
Most suitable for holding thin workpieces that cannot be secured by a machine vice directly.

[Features]
- Direct clamping in a vice by use of a block for easy removal of the chuck.
**Model RMWH**

RECTANGULAR PERMANENT MAGNETIC MICROPITCH CHUCK

![RMWH-2040C](Image)

**Features**
- Suitable for grinding thin, thick and small workpieces.

**Application**
- Suitable for grinding thin workpieces. Usable for dielectric discharge machining also.

**Model RMWH-X**

RECTANGULAR PERMANENT MAGNETIC SUPER MICROPITCH CHUCK

![RMWH-X713](Image)

**Features**
- Impossible to microchip 1.2 (0.2+1).
- Thin sheet holding performance superior to that of Model RMWH-A-H and Model RMWH-C.

**Model RMWH-A-H**

RECTANGULAR PERMANENT MAGNETIC MICROPITCH CHUCK

![RMWH-1018A-H](Image)

**Features**
- Compared with Model RMWH-C, these chucks are capable of holding thinner and smaller workpieces.

**Application**
- These chucks can be used for a wide range of applications such as securing very small workpieces and securing workpieces during grinding and dielectric discharge machining. They can be used in liquid also.

---

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-713C</td>
<td>75 (2.95) x 130 (5.11)</td>
<td>B, L, t</td>
<td>P</td>
<td>h, E</td>
<td>18 (0.70)</td>
<td>0.2+1 (0.04)</td>
<td>10 (0.39)</td>
</tr>
<tr>
<td>RMWH-1025C</td>
<td>105 (4.13) x 175 (6.89)</td>
<td>B, L, t</td>
<td>P</td>
<td>h, E</td>
<td>18 (0.70)</td>
<td>0.2+1 (0.04)</td>
<td>10 (0.39)</td>
</tr>
<tr>
<td>RMWH-1325C</td>
<td>130 (5.11) x 250 (9.84)</td>
<td>B, L, t</td>
<td>P</td>
<td>h, E</td>
<td>18 (0.70)</td>
<td>0.2+1 (0.04)</td>
<td>10 (0.39)</td>
</tr>
<tr>
<td>RMWH-1515C</td>
<td>150 (5.90) x 300 (11.8)</td>
<td>B, L, t</td>
<td>P</td>
<td>h, E</td>
<td>18 (0.70)</td>
<td>0.2+1 (0.04)</td>
<td>10 (0.39)</td>
</tr>
<tr>
<td>RMWH-1805C</td>
<td>180 (7.08) x 400 (15.7)</td>
<td>B, L, t</td>
<td>P</td>
<td>h, E</td>
<td>18 (0.70)</td>
<td>0.2+1 (0.04)</td>
<td>10 (0.39)</td>
</tr>
</tbody>
</table>

**Application**
- Suitable for grinding thin, thick and small workpieces.

**Features**
- Extremely low profile, 45 mm for small to medium sizes and 50 mm for large sizes and light weight.
- A wide attractive area on the chuck work face, allowing the corners to be utilized.
- The magnetic force ON-OFF handle can be operated lightly thanks to a special slide design. The side insert type used allows the handle to be detached when it is not used.
- A micropitch type having very fine pole-to-pole pitches. This design provides effective power holding not only on thick workpieces but also on thin and small workpieces.
- Portable specification.
**PERMANENT MAGNETIC CHUCKS**

**Model RMWH-2F**

**DOUBLE-FACE HOLDING PERMANENT MAGNETIC CHUCK**

*Features*
- Suitable for grinding and electric discharge machining of workpieces of various thicknesses and sizes.
- A micro pole-to-pole pitch on the chuck work face generates effective holding power on thin and small workpieces.
- A powerful permanent magnetic attractive force having a chuck mounting face that can also be turned on and off. Thus, no mechanical clamping is required for installation.
- Can be used in liquid.
- The changeover handle is of side insert type and can be kept detached when it is not used after ON/OFF operation.

**Model RTH**

**SUPER THIN RECTANGULAR PERMANENT MAGNETIC CHUCK**

*Application*
- Suitable for securing workpieces for high speed and light duty grinding. (To use these chucks in liquid or in wet conditions, use machining fluid of rust-preventive type.) The light weight design makes these chucks suitable for setup change (pallet change) operations by workers also.

*Features*
- Very thin (only 20 mm high) and light weight permanent magnetic chucks.

**Model RMC-X**

**STAR-POLE ROUND PERMANENT MAGNETIC CHUCK**

*Application*
- Permanent magnetic chucks for securing ring-shaped workpieces on lathes and vertical combined grinding machines.

*Features*
- The star-pole construction generates a strong magnetic force that works well on ring-shaped workpieces such as bearings.
- The permanent magnetic chucks that do not require electricity can be mounted easily without troublesome wiring. They also contribute to energy saving.
- Usable in wet conditions.
- Model RMC-X-B chucks are equipped with a magnetic force adjust function. (The ON-OFF operating angle is about 630 degrees and the magnetic force is adjusted according to the handle turning angles.)

---

**Model RMWH-2F**

**DOUBLE-FACE HOLDING PERMANENT MAGNETIC CHUCK**

![Image of RMWH-2F](image-url)

Both sides are magnetic.

**Model RTH**

**SUPER THIN RECTANGULAR PERMANENT MAGNETIC CHUCK**

![Image of RTH](image-url)

20 mm

**Model RMC-X**

**STAR-POLE ROUND PERMANENT MAGNETIC CHUCK**

![Image of RMC-X](image-url)
**Model RMC**

**POWERFUL ROUND PERMANENT MAGNETIC CHUCK**

"B" is magnetic force adjust type.

![Diagram of RMC-32](image)

[Application]
Permanent magnetic chucks using a high-performance magnet for grinding operations on rotary grinders, cylindrical grinders, internal grinders and cutting operations on lathes.

[Features]
- The "B" type can be used in such a way that it first holds a workpiece by a weak magnetic force and after finely adjusting its holding position, it is changed to a strong magnetic force to secure the workpiece firmly.
- Can be used for both grinding and cutting operations.
- Work well on thin workpieces to thick workpieces.
- Highly precise chucks with little accuracy change.

<table>
<thead>
<tr>
<th>Model</th>
<th>Figure</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMC-13</td>
<td>1 2</td>
<td>125 (4.92) 125 (4.92) 88 100 (3.93)</td>
<td>112 (4.40) 125 (4.92) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 125 (4.92)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
<tr>
<td>RMC-16</td>
<td>1 2</td>
<td>160 (6.30) 160 (6.30) 118 125 (4.92) 15.2 (0.59)</td>
<td>112 (4.40) 58 (2.28) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 58 (2.28)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
<tr>
<td>RMC-20</td>
<td>1 2</td>
<td>200 (7.87) 200 (7.87) 149 94 (3.70) 0.59 (0.02+0.035+0.045+0.12)</td>
<td>112 (4.40) 78 (3.07) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 78 (3.07)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
<tr>
<td>RMC-25</td>
<td>1 2</td>
<td>250 (9.84) 250 (9.84) 194 94 (3.70) 0.59 (0.02+0.035+0.045+0.12)</td>
<td>112 (4.40) 78 (3.07) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 78 (3.07)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
<tr>
<td>RMC-32</td>
<td>1 2</td>
<td>315 (12.4) 315 (12.4) 355 94 (3.70) 15.2 (0.59)</td>
<td>112 (4.40) 81 (3.22) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 81 (3.22)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
<tr>
<td>RMC-40</td>
<td>1 2</td>
<td>400 (15.7) 400 (15.7) 531 94 (3.70) 15.2 (0.59)</td>
<td>112 (4.40) 81 (3.22) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 81 (3.22)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included with Models RMC-13 to 20, and a dedicated handle is included with Models RMC-25 and above.

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**Model RMCB**

**ROUND PERMANENT MAGNETIC CHUCK WITH TAPPED HOLE IN CENTER OF FACE PLATE**

Round permanent magnetic chucks with a tapped hole for easy mounting of various jigs/fixtures introduced!

[Application]
Permanent magnetic chucks to hold workpieces during grinding operations on rotary grinders, cylindrical grinders, internal grinders and cutting operations on lathes.

[Features]
- Two types; standard type and magnetic force adjust type are available.
- As a standard feature, a tapped hole is provided in the center of the attractive face. This facilitates mounting of jigs/fixtures for workpiece alignment.
- The tapped hole in the center is allowed to be M10 max. for the chuck size φ160 and M12 max. for φ200 or over. (For the φ125 size only, a tapped hole must not be worked on.)
- There is a 9-mm additional work allowance from the attractive face, which allows additional work according to jigs/fixtures.
- The permanent magnetic chucks that do not require electricity can be mounted easily without troublesome wiring. They also contribute to energy saving.

<table>
<thead>
<tr>
<th>Model</th>
<th>Fig</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Tapped Hole</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMCB-13</td>
<td>1 2</td>
<td>125 (4.92) 125 (4.92) 88 100 (3.93)</td>
<td>112 (4.40) 125 (4.92)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 125 (4.92)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
<tr>
<td>RMCB-16</td>
<td>1 2</td>
<td>160 (6.30) 160 (6.30) 118 125 (4.92) 15.2 (0.59)</td>
<td>112 (4.40) 58 (2.28) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 58 (2.28)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
<tr>
<td>RMCB-20</td>
<td>1 2</td>
<td>200 (7.87) 200 (7.87) 149 94 (3.70) 0.59 (0.02+0.035+0.045+0.12)</td>
<td>112 (4.40) 78 (3.07) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 78 (3.07)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
<tr>
<td>RMCB-25</td>
<td>1 2</td>
<td>250 (9.84) 250 (9.84) 194 94 (3.70) 0.59 (0.02+0.035+0.045+0.12)</td>
<td>112 (4.40) 78 (3.07) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 78 (3.07)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
<tr>
<td>RMCB-32</td>
<td>1 2</td>
<td>315 (12.4) 315 (12.4) 355 94 (3.70) 15.2 (0.59)</td>
<td>112 (4.40) 81 (3.22) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 81 (3.22)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
<tr>
<td>RMCB-40</td>
<td>1 2</td>
<td>400 (15.7) 400 (15.7) 531 94 (3.70) 15.2 (0.59)</td>
<td>112 (4.40) 81 (3.22) 100 (3.93)</td>
<td>4 (0.16)</td>
<td>112 (4.40) 81 (3.22)</td>
<td>100 (3.93)</td>
<td>56</td>
<td>0.31</td>
<td>1.45 kg/ 10 lbs</td>
<td></td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included with Standard Models RMCB-13 to 20, and a special changeover handle is included with Models RMCB-25 and above. A T-handle is included with the magnetic force adjust types.

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RMWH-2F / RTH / RMC-X / RMC / RMCB
PERMANENT MAGNETIC CHUCKS

Model RMCW
ROUND PERMANENT MAGNETIC MICROPITCH CHUCK

[RMCW-50B]

[Application]
Suitable for grinding a wide range of workpieces, small and large, thin and thick on grinders. Since these chucks are thin, they can be used in a wide range of applications including securing workpieces temporarily.

[Features]
- Thin; 43 mm to 60 mm.
- Micro pole pitch; can be used with any sizes of workpieces, small and large and thin and thick.
- The handle is a hex wrench key. It can be operated lightly. A half turn turns on and off the magnetic force.
- The changeover handle can be set at an angle to generate a weak magnetic force for easy temporary positioning of workpieces.

Model SKM
VERTICAL PERMANENT MAGNETIC CHUCK

[Application]
These chucks are suitable for applications where when securing a workpiece on the table of a machine, it needs to be held vertically due to its shape or it needs to be secured from sides additionally when it cannot be held sufficiently horizontally.

[Features]
- The permanent magnetic chuck used in Model SKM is our powerful RMT.
- Holds various sizes of workpieces, thin, small, and thick.

Model SKAW
VERTICAL PERMANENT MAGNETIC CHUCK

A new powerful model added to permanent magnetic chucks for securing workpieces in vertical direction!

[Application]
This chuck is suitable for applications where when securing a workpiece on the table of a machine, it needs to be held vertically due to its shape or it needs to be secured from sides additionally when it cannot be held sufficiently horizontally.

[Features]
- Compared with Model SKM, this model can hold smaller and thinner (3 mm) workpieces.
- The rigid construction facilitates maintenance such as recovering the original accuracy.

The standard material of the angle plate is SS400, but it may be made of SKD-11 (HRC60).
### Model RMT-ED
RECTANGULAR PERMANENT MAGNETIC CHUCK WITH JET HOLE

**[Application]**
Suitable for securing workpieces during electric discharge machining.

**[Features]**
- Can be used in liquid.
- With extra powerful holding, these chucks are suitable for applications that require strong holding power.
- A jet hole is provided for jet-stream machining.
- The bottom face is made flat to allow providing tapped holes for clamp fixtures.
- Counter boring around the jet hole on the attractive face is possible.
- The water-tightness performance has been improved over the standard type.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-ED20</td>
<td>200 (7.87) × 200 (7.87)</td>
<td>15.2 (1.5+9+1.5+3.2)</td>
<td>220 (8.66)</td>
<td>Hex. B</td>
<td>15 (3.99)</td>
<td>55 (2.16)</td>
<td>25 (1.96)</td>
</tr>
<tr>
<td>RMT-ED25</td>
<td>250 (9.84) × 250 (9.84)</td>
<td>14.9 (1.5+9+1.5+3.2)</td>
<td>220 (8.66)</td>
<td>Hex. B</td>
<td>15 (3.99)</td>
<td>55 (2.16)</td>
<td>25 (1.96)</td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included. An electromagnetic type (special specification) is also available.

### Model RMWH-ED
RECTANGULAR PERMANENT MAGNETIC CHUCK FOR ELECTRIC DISCHARGE MACHINING

**[Application]**
Suitable for securing workpieces during electric discharge machining.

**[Features]**
- Can be used in liquid.
- A fine pole pitch ensures securing thin and small workpieces firmly.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-ED20</td>
<td>200 (7.87) × 200 (7.87)</td>
<td>15.2 (1.5+9+1.5+3.2)</td>
<td>220 (8.66)</td>
<td>Hex. B</td>
<td>15 (3.99)</td>
<td>55 (2.16)</td>
<td>25 (1.96)</td>
</tr>
<tr>
<td>RMWH-ED25</td>
<td>250 (9.84) × 250 (9.84)</td>
<td>14.9 (1.5+9+1.5+3.2)</td>
<td>220 (8.66)</td>
<td>Hex. B</td>
<td>15 (3.99)</td>
<td>55 (2.16)</td>
<td>25 (1.96)</td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included.

### Model RMC-ED
ROUND PERMANENT MAGNETIC CHUCK WITH JET HOLE

**[Application]**
Suitable for securing workpieces during electric discharge machining.

**[Features]**
- Can be used in liquid.
- With extra powerful holding, these chucks are suitable for applications that require strong holding power.
- A jet hole is provided for jet-stream machining.
- The bottom face is made flat to allow providing tapped holes for clamp fixtures.
- Counter boring around the jet hole on the attractive face is possible.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMC-ED20</td>
<td>200 (7.87)</td>
<td>14.9 (1.5+9+1.5+3.2)</td>
<td>29 (1.14)</td>
<td>60 (2.36)</td>
<td>Hex. B</td>
<td>14 (0.31)</td>
<td>14 (0.31)</td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included.
**Model CMR**

**NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE**

**CMR-1018**

[Application]
These permanent magnetic chucks are designed for securing workpieces of materials having a relatively weak magnetic properties such as cemented carbide during grinding. They are normally mounted on and held by other chuck for use.

**Features**
- The use of a powerful rare earth magnet ensures a sufficient holding power even on cemented carbide materials.

**Model CMR-H**

**NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE**

**CMR-H0709** (Standard pitch type)

**CMR-HW0709**

[Application]
Permanent magnetic chucks for grinding operations to hold materials such as cemented carbide that cannot be secured fully.

**Features**
- Suitable mainly for relatively large and thick workpieces. The gap characteristic is excellent.
- The holding power has been increased 1.5 times max. from the conventional chucks.
- The separator part is made of stainless steel to enhance accuracy stability.

**CMR-HW**
- Works well on small and thin workpieces that cannot be held by conventional pitches.
- The holding power is 2 times max. (depending on materials) the conventional chucks.
- The separator part is made of stainless steel to enhance accuracy stability.

**Comparison of side slip holding power**

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Height</th>
<th>Pole Pitch</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>CMR-H0709</td>
<td>(65.50) x (90.54)</td>
<td>30</td>
<td>6/3+3</td>
<td>1.3kg/2.8 lb</td>
</tr>
<tr>
<td>CMR-HW0709</td>
<td>(65.50) x (90.54)</td>
<td>30</td>
<td>2/3+1</td>
<td>0.57kg/1.2 lb</td>
</tr>
<tr>
<td>CMR-H1215</td>
<td>(120.72) x (150.90)</td>
<td>33</td>
<td>6/3+3</td>
<td>3.6kg/7.9 lb</td>
</tr>
<tr>
<td>CMR-HW1215</td>
<td>(120.72) x (150.90)</td>
<td>33</td>
<td>2/3+1</td>
<td>0.73kg/1.6 lb</td>
</tr>
</tbody>
</table>
**Model CMR-DL** CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE

**Long-awaited compact type!**

[Application]
These chucks are designed for grinding workpieces of materials having relatively weak magnetic properties such as cemented carbide on small grinders.

[Features]
- The ON-OFF handle turning angle has been reduced to improve the handle operability significantly.
- The holding performance has been enhanced by improving the pole pitch.
- Residual magnetism has been reduced by employing a unique construction. (CMR-DL1319B)
- The effective attractive face area relative to the external dimensions has been increased 30% over the conventional model. (CMR-DL0915B)

![CMR-DL0915B](image)

![CMR-DL1319B](image)

![CMR-DW1319](image)

**Comparison of magnetic poles with conventional model**

Conventional

New type

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Height</th>
<th>Pole Pitch</th>
<th>Effective Pole Width</th>
<th>Holding Power</th>
<th>Handle Select Angle</th>
<th>Mass</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>CMR-DL0915B</td>
<td>85 (3.34) x 145 (5.70)</td>
<td>55 (2.16)</td>
<td>0 (0) 0.23 (0.11) + 0.11</td>
<td>105 (4.13)</td>
<td>162N</td>
<td>90°</td>
<td>4.5kg/9.92 lbf</td>
<td>Compact</td>
</tr>
<tr>
<td>CMR-DL1319B</td>
<td>132 (5.16) x 190 (7.48)</td>
<td>48 (1.89)</td>
<td>0 (0) 0.15 (0.07) + 0.07</td>
<td>105 (4.13)</td>
<td>175N</td>
<td>60°</td>
<td>9kg/19.8 lbf</td>
<td>Standard</td>
</tr>
<tr>
<td>CMR-DW1319</td>
<td>4 (0.16) x 150 (5.90)</td>
<td>4 (0.15)</td>
<td>0 (0) 0.31 (0.12) + 0.15</td>
<td>100 (3.94)</td>
<td>200N</td>
<td>120°</td>
<td>Fine</td>
<td>Powerful</td>
</tr>
</tbody>
</table>

The holding power is based on a test piece of 50 x 25 carbide (G5). ♦ As for the handle, a dedicated handle is included.

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**Magnetic Chuck Accessory Products**

**Model YS** WORK SUPPORTER*

**Nonmagnetic workpiece supporter**

[Application]
These supporters can hold materials having weak magnetic properties such as carbide and materials such as aluminum, brass and stainless steel which cannot be held by magnetic chucks. They are held by a strong spring force on both sides and secured to the magnetic chuck.

[Features]
- These supporters are thin and therefore can be used for relatively thin workpieces.
- One set consists of two supporters.

![YS-10](image)

![YS-15A](image)

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>YS-10</td>
<td>Length: 100 (3.93) Width: 45 (1.77) Thickness: 4 (0.15)</td>
<td>100g/0.22 lb x 2</td>
</tr>
<tr>
<td>YS-15A</td>
<td>Length: 150 (5.90) Width: 45 (1.77) Thickness: 4 (0.15)</td>
<td>166g/0.36 lb x 2</td>
</tr>
</tbody>
</table>

*For all models, two pieces make one set.