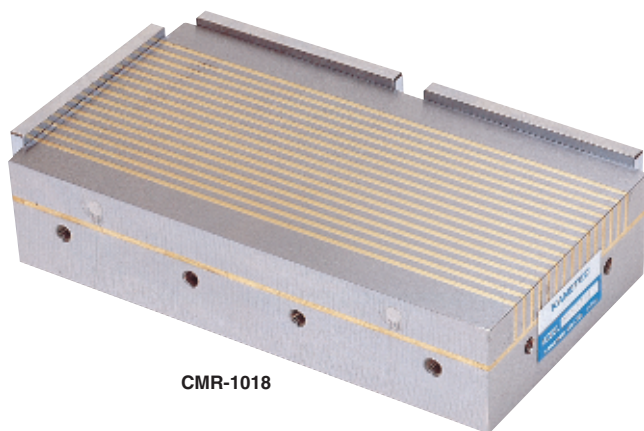


# PERMANENT MAGNETIC CHUCKS

## Model **CMR** NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE

ELECTROMAGNETIC CHUCK CONTROLLERS  
 PERMANENT MAGNETIC CHUCKS  
 PERMANENT ELECTROMAGNETIC CHUCKS  
 BLOCKS FOR MC  
 VACUUM CHUCKS  
 PROMELTA\*  
 SINE BAR CHUCKS  
 BLOCKS, HOLDERS, MINI CHUCKS  
 HOLDING TOOLS  
 MEASURING TOOL HOLDERS  
 MAGNETIC HOLDERS  
 MAGNETIC TOOLS



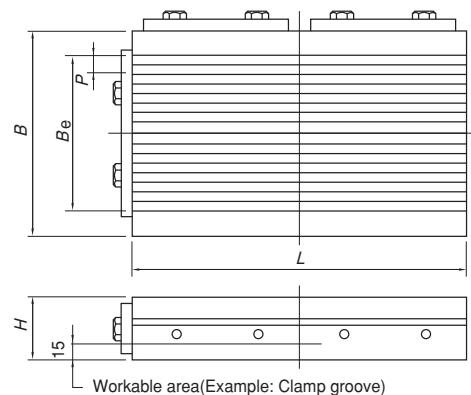
CMR-1018

### [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	Nominal Size	Work Face			Pole Pitch	Height	Holding Power	Mass
		B	L	Be	P	H		
CMR-1010	100 (3.93) × 100 (3.93)	100 (3.93)	100 (3.93)	72 (2.83)	5 (2+3)	40 (1.57)	210N (21kgf) on □50 × 125 carbide test piece	3 kg / 6.6 lb
CMR-1018	100 (3.93) × 180 (7.08)		180 (7.08)		0.19 (0.07+0.11)			

## Model **CMR-H** NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE



CMR-H0709 <Standard pitch type>

### [Application]

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

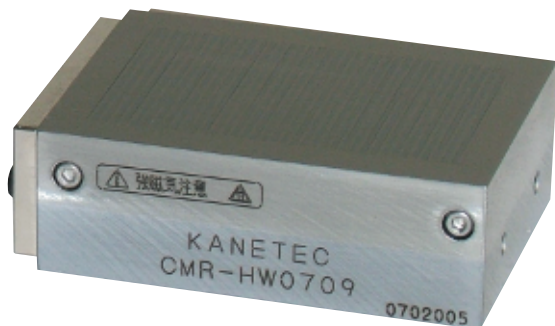
### [Features]

#### CMR-H

- 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.

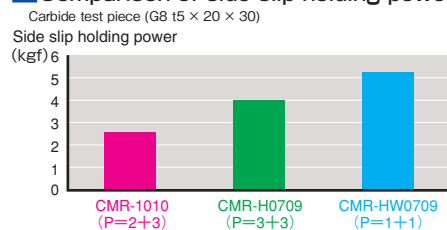


CMR-HW0709 <Fine pitch type>



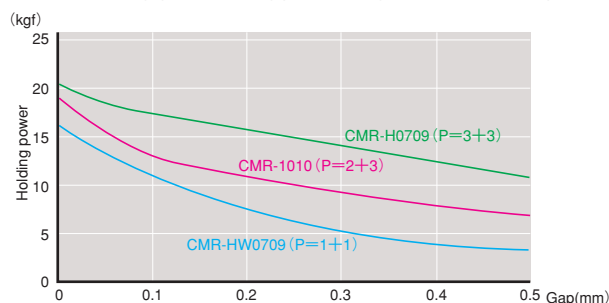
Side slip measuring direction

### Comparison of side slip holding power



### CMR-H type holding power characteristics

- Relation between gap and holding power using □50 carbide test piece



Model	Nominal Size	Height	Pole Pitch		Mass
			B	L	
CMR-H0709	65 (2.55) × 90 (3.54)	30 (1.18)	6 (3+3)	0.23 (0.11+0.11)	1.3kg/2.8 lb
CMR-HW0709			2 (1+1)	0.07 (0.03+0.03)	
CMR-H1215	120 (4.72) × 150 (5.90)	33 (1.29)	6 (3+3)	0.23 (0.11+0.11)	3.6kg/7.9 lb
CMR-HW1215			2 (1+1)	0.07 (0.03+0.03)	