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All Hertel Lathe  
Chucks, Adapters  
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ANSI, DIN & ISO  
Standard requirements

# Medium Duty Precision Scroll & Independent Lathe Chucks



Universal, Versatile and Durable Chucks  
designed for a large variety of Turning, Grinding, Milling  
and Drilling medium duty applications.

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## 3 & 6-Jaw Medium Duty Forged Steel Body Scroll Chucks

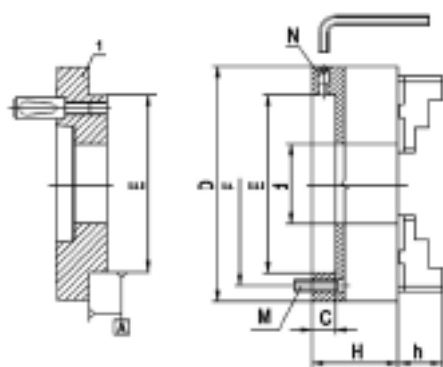
With Fine Adjustment 0.0004" T.I.R.

Hertel Forged Steel Adjustable Body Scroll Chucks can be used for all high speed machining operations where universal chucks are unsuitable. High accuracy, versatility and durability make these chucks invaluable in the modern workshops and indispensable in the tool rooms.

- 3 pinion design
- 4 micro-fine adjustment screws allow 0.0004" T.I.R.
- Two-piece hard top and master jaws are American Standard tongue and groove
- High quality forged steel body construction allows for higher speed and longer life
- Forged and hardened scrolls are precisely ground and balanced
- Jaws and pinions are hardened and precisely ground
- Each assembled chuck is balanced within fine limit for the high speed machining
- Proper chuck maintenance can extend the life of your chuck significantly
- The 6-jaw chucks grip firmly with less pressure and less distortion per jaw

### EACH CHUCK IS PROVIDED WITH:

1 set of hard master jaws | 1 set of hard top reversible jaws | 1 set of adapter mounting bolts | 1 set of fine adjustment screws | 1 Spring loaded chuck T-wrench | 2 hex keys



### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Ø Chuck (Inch)	F (Inch)	E (Inch)	H (Inch)	h (Inch)	C (Inch)	M Mounting Bolts	N Fine Adjustment Screws	d Thru-Hole (Inch)	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Code	Price
5	4.2520	2.1654	2.362	1.575	0.59	M8x1.25 (3)	M12x1 (4)	1.398	3800	0.118-4.92	11	97018683	1031.18
6-1/4	5.5118	3.3858	2.677	1.71	0.67	M10x1.5 (3)	M18x1 (4)	1.654	3500	0.118-6.30	21	97018386	1595.82
8	6.9291	4.3307	3.071	1.77	0.71	M10x1.5 (3)	M18x1 (4)	2.165	3100	0.175-7.87	39	97018931	1566.90
10	8.8189	5.7086	3.504	2.05	0.79	M12x1.75 (3)	M18x1 (4)	2.992	2700	0.197-9.84	69	97018535	2749.64
12-1/2	11.2598	7.0866	3.819	2.24	0.79	M16x2 (3)	M18x1 (4)	4.055	2200	0.394-12.40	123	97018824	2657.14

### 6-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

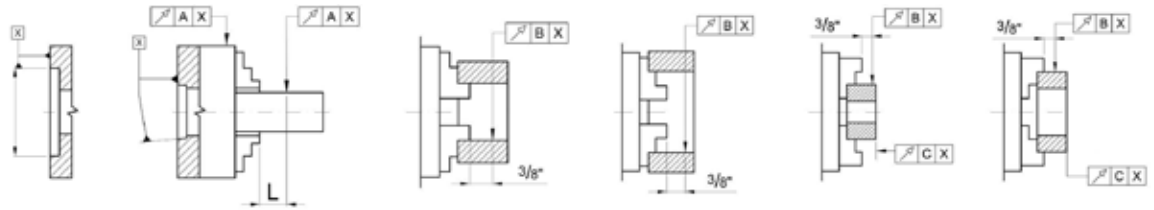
Ø Chuck (Inch)	F (Inch)	E (Inch)	H (Inch)	h (Inch)	C (Inch)	M Mounting Bolts	N Fine Adjustment Screws	d Thru-Hole (Inch)	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Code	Price
6-1/4	5.5118	3.3858	2.677	1.71	0.67	M10x1.5 (3)	M18x1 (4)	1.654	2500	0.315-6.30	27	97018881	1830.08
8	6.9291	4.3307	3.071	1.77	0.71	M10x1.5 (3)	M18x1 (4)	2.165	2200	0.315-7.87	41	97018428	1741.92
10	8.8189	5.7086	3.504	2.05	0.79	M12x1.75 (3)	M18x1 (4)	2.992	1900	0.47-9.84	72	97018790	4205.49
12-1/2	11.2598	7.0866	3.819	2.24	0.79	M16x2 (3)	M18x1 (4)	4.055	1500	0.47-12.40	115	97018600	4560.54

## 3 & 4-Jaw Medium Duty Semi-Steel Body Universal Scroll Chucks

Hertel Universal Scroll Self-Centering Chucks provide high accuracy and durability for tool room and quality control applications. Perfect for use on lathes, grinders, rotary tables, CNC indexers in a variety of turning, milling and drilling medium duty and finishing applications. They are also very useful for inspections and laser markings.

- All Hertel chucks come with either American Standard two-piece tongue and groove jaws, or with two sets of hard solid ID and OD Jaws
- Chuck Body is made of high quality cast iron. All jaw guideways and bearing surfaces are precisely machined
- Scroll plate is drop forged of fine alloy steel, hardened and ground
- Hardened jaws and pinions increase life of the chuck
- Hertel universal chucks are available with Plain Back, Camlock and A Mounts

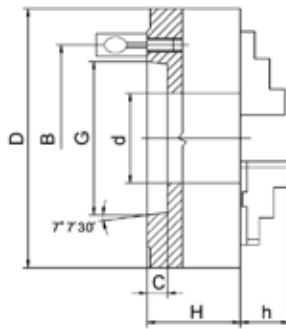
### Chuck Accuracy (T.I.R.)



Chuck Size		3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"
L		1.57"	1.57"	2.36"	2.36"	3.15"	3.15"	4.72"
Radial Runout	A	0.0008"	0.0008"	0.0012"	0.0012"	0.0016"	0.0016"	0.002"
	B	0.001"	0.001"	0.0014"	0.0014"	0.0018"	0.0018"	0.0022"
Axial Runout	C	0.0006"	0.0006"	0.0008"	0.0008"	0.001"	0.001"	0.0012"

## 3-Jaw Scroll Chucks, Semi-Steel Body | Two-Piece Hard Reversible Jaws

### Direct Mount 1



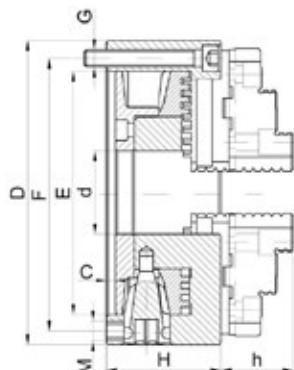
### EACH CHUCK IS PROVIDED WITH:

1 set of hard master jaws | 1 set of hard top reversible jaws | 1 set of Camlock studs and set screws | 1 Spring loaded chuck T-wrench | 2 hex keys | 3 pinion design

## 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Ø Chuck (Inch)	Taper Size	d Ø Hole (Inch)	B (Inch)	G (Inch)	C (Inch)	H (Inch)	h (Inch)	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Ø Camlock Stud (Inch)	Camlock Stud Thread	Code	Price
6-1/4	D1-4	1.6535	3.2520	2.5005	0.5118	3.2087	1.693	3000	0.12-6.30	20	5/8	M10x1 (3)	97018667	1080.65
8	D1-4	2.1653	3.2520	2.5005	0.5118	3.5827	1.8307	2500	0.16-7.87	42	5/8	M10x1 (3)	97018741	1013.61
8	D1-6	2.1653	5.2520	4.1880	0.5905	3.5827	1.8307	2500	0.16-7.87	42	7/8	M16x1.5 (6)	97018758	1222.89
10	D1-6	2.9921	5.2520	4.1880	0.6299	4.0748	2.1457	2000	0.20-9.84	71	7/8	M16x1.5 (6)	97018501	1546.05
10	D1-8	2.9921	6.7480	5.5007	0.7087	4.0748	2.1457	2000	0.20-9.84	71	1	M20x1.5 (6)	97018493	1546.05
12	D1-6	4.06	5.25	4.19	0.63	4.63	2.24	1500	-	112	0.87	M16x1.5 (6)	97018394	2276.79
12	D1-8	4.06	6.75	5.50	0.71	4.63	2.24	1500	-	112	1	M20x1.5 (6)	97018436	2276.79

## 3 & 4-Jaw Scroll Chucks, Semi-Steel Body | Two-Piece Hard Reversible Jaws Plain Back & Front Mount



### EACH CHUCK IS PROVIDED WITH:

1 set of Tongue & Groove hard master jaws | 1 set of Tongue & Groove hard top reversible jaws | 1 set of adapter mounting bolts | 1 Spring loaded chuck T-wrench | 2 hex keys | 3 pinion design

### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws | Plain Back & Front Mount

Ø Chuck (Inch)	F (Inch)	E (H7) (Inch)	C (Inch)	H (Inch)	h (Inch)	d Ø Thru-Hole (Inch)	M Mounting Bolts	G Front Mounting Bolts	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Plain Back Code	Plain Back Price	Front Mount Code	Front Mount Price
5	4.2520	3.7402	0.1575	2.205	1.575	1.2598	M8x1.25 (3)	5/16"-18 (3)	3200	0.12-4.97	11	97018410	655.97	97018907	741.39
6-1/4	5.5118	4.9213	0.1575	2.539	1.693	1.6535	M10x1.5 (3)	3/8"-16 (3)	3000	0.12-6.30	22	97018915	681.07	97018865	721.82
8	6.9291	6.2992	0.1575	2.953	1.8307	2.1654	M10x1.5 (3)	3/8"-16 (3)	2500	0.16-7.87	39	97018451	914.72	97018519	954.47
10	8.8189	7.8740	0.1969	3.347	2.1457	2.9921	M12x1.75 (3)	1/2"-13 (3)	2000	0.20-9.84	55	97018998	1222.89	97018485	1292.51
12-1/2	11.2598	10.2362	0.1969	3.701	2.3622	4.0551	M16x2 (3)	5/8"-11 (3)	1500	0.39-12.40	110	97018972	1814.49	97018477	1903.96

### 4-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws | Plain Back

Ø Chuck (Inch)	F (Inch)	E (H7) (Inch)	C (Inch)	H (Inch)	h (Inch)	d Ø Thru-Hole (Inch)	M Mounting Bolts	G Front Mounting Bolts	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Plain Back Code	Plain Back Price
5	4.2520	3.7402	0.1575	2.205	1.575	1.2598	M8x1.25 (3)	5/16"-18 (3)	3200	0.12-4.97	11	97018550	662.82
6-1/4	5.5118	4.9213	0.1575	2.539	1.693	1.6535	M10x1.5 (3)	3/8"-16 (3)	3000	0.12-6.30	22	97019012	1036.68
8	6.9291	6.2992	0.1575	2.953	1.8307	2.1654	M10x1.5 (3)	3/8"-16 (3)	2500	0.16-7.87	39	97018402	1289.54
10	8.8189	7.8740	0.1969	3.347	2.1457	2.9921	M12x1.75 (3)	1/2"-13 (3)	2000	0.20-9.84	55	97018774	1988.96
12-1/2	11.2598	10.2362	0.1969	3.701	2.3622	4.0551	M16x2 (3)	5/8"-11 (3)	1500	0.39-12.40	110	97018576	2412.60

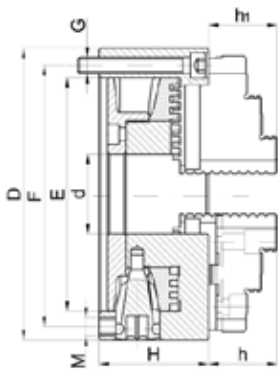


Providing Universal, Versatile and Durable Chucks





## 3-Jaw Scroll Chucks, Semi-Steel Body | Two Sets of Hard Solid Jaws Plain Back & Front Mount



### EACH CHUCK IS PROVIDED WITH:

1 set hard solid ID jaws | 1 set of hard solid OD jaws | 1 set of adapter mounting bolts | 1 Spring loaded chuck T-wrench | 2 hex keys | 3 pinion design

## 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws | Plain Back & Front Mount

Ø Chuck (Inch)	F (Inch)	E (H7) (Inch)	C (Inch)	H (Inch)	h1 (Inch)	d Ø Thru-Hole (Inch)	M Mounting Bolts	G Front Mounting Bolts	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Plain Back Code	Plain Back Price	Front Mount Code	Front Mount Price
3-1/4	2.6378	2.2047	0.1181	1.732	0.512	0.6299	M6x1 (3)	1/4"-20 (3)	4000	0.08-2.80	3.3	97018659	567.39	-	-
4	3.2677	2.7599	0.1181	1.969	0.669	0.7874	M8x1.25 (3)	5/16"-18 (3)	3500	0.12-3.27	6.2	97018691	436.97	97018782	535.17
5	4.2520	3.7402	0.1575	2.205	0.787	1.2598	M8x1.25 (3)	5/16"-18 (3)	3200	0.12-4.97	11	97018808	426.00	-	-
6-1/4	5.5118	4.9213	0.1575	2.539	1.260	1.6535	M10x1.5 (3)	3/8"-16 (3)	3000	0.12-6.30	22	97018675	734.69	-	-
8	6.9291	6.2992	0.1575	2.953	1.142	2.1654	M10x1.5 (3)	3/8"-16 (3)	2500	0.16-7.87	39	-	-	97018642	982.40



**Hertel** provides a wide range of products for your metalworking needs that are designed to deliver consistency, reliability, durability and value with every cut and fit.

For 75 years, **Hertel** has been a brand trusted by machinists for a variety of applications. When customers need reliable tooling and fast results, they know they can count on **Hertel** to deliver no matter what size production run they're working on.

**Hertel** offers more than 24,000 tools across multiple product lines including drills, taps, end mills and indexable inserts.

## 4-Jaw Medium Duty Semi-Steel Body Independent Chucks

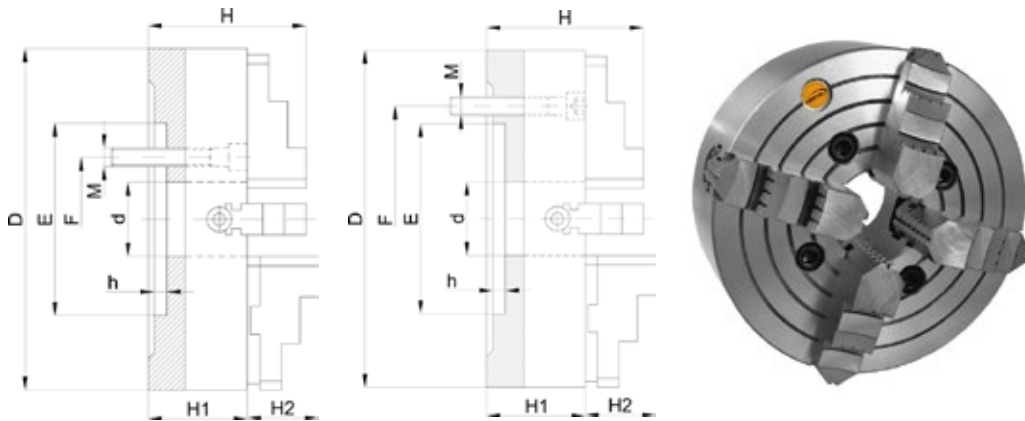
### Plain Back and Direct Mount A & D

Hertel 4-Jaw cast iron body independent chucks can be used for machining operations where scroll chucks are used and for a variety of operations where odd-shaped workpieces have to be machined. High accuracy, high gripping power and durability make them very useful on a variety of medium duty turning, milling drilling or grinding operations. Chucks are provided with Hard Solid Reversible Jaws. High quality cast steel body construction.

- Hertel Independent Chucks are provided with Hard Solid Reversible Jaws
- The high quality cast iron body allows for higher speed and longer life
- The Jaws are made of hard quality steel and hardened
- The thrust bearings and operating screws are made of case hardened steel

## 4-Jaw Independent Medium Duty Semi-Steel Body

### with Hard Solid Reversible Jaws



#### EACH CHUCK IS PROVIDED WITH:

1 set of hard solid reversible jaws | 1 set of adapter mounting bolts | 1 Spring loaded chuck T-wrench | 1 hex key | 10" chucks and larger are provided with T-slots

### 4-Jaw Independent with Hard Solid Reversible Jaws

Ø Chuck (Inch)	E (H7) (Inch)	F (Inch)	d Hole (Inch)	H1 (Inch)	H (Inch)	h (Inch)	M Mounting Bolts	Max. RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Code	Price
6-1/4	2.559	3.74	1.772	2.559	3.799	0.196	M10 (4)	3200	0.315-6.30	16	97018816	646.53
8	2.953	3.74	2.205	2.953	4.331	0.236	M10 (4)	1800	0.394-7.87	22	97018543	681.07
10	5.906	4.126	2.559	3.347	4.7	0.276	M12 (4)	1500	0.394-9.84	55	97018964	909.73



Upgrade to **Hertel** Lathe Chucks Today and Maximize Your Precision



## 4-Jaw Independent Medium Duty Semi-Steel Body with Hard Solid Reversible Jaws

### Direct A1/A2 Mounts



### EACH CHUCK IS PROVIDED WITH:

1 set of hard solid reversible jaws | 1 set of spindle mounting bolts | 1 Spring loaded chuck T-wrench | 1 hex key | 10" chucks and larger are provided with T-slots

### 4-Jaw Independent with Hard Solid Reversible Jaws

D Ø Chuck (Inch)	Taper	E (Inch)	F (Inch)	d (Inch)	Solid Jaws H1 (Inch)	H (Inch)	h (Inch)	L Spindle Mounting Bolts	M Spindle Mounting Bolts	RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Code	Price
10	A2-6	4.188	5.250	2.953	4.700	3.347	0.591	3-1/8"	1/2"-13 (4)	1500	0.394-9.84	55	97018360	1300.53



Engineered for precision and built to last, **Hertel** Lathe Chucks deliver exceptional clamping accuracy and durability.

Made from high-grade steel and cast iron, these chucks minimize runout and vibration, ensuring consistent performance at high speeds.

With versatile jaw configurations and compliance with global machining standards, **Hertel** is the trusted choice for professionals who demand reliable, high-quality work holding.

## 4-Jaw Independent Medium Duty Semi-Steel Body with Hard Solid Reversible Jaws

### Direct D1 Mount



### EACH CHUCK IS PROVIDED WITH:

1 set of hard solid reversible jaws | 1 set of Camlock studs | 1 set of Camlock stud set screws | 1 Spring loaded chuck T-wrench | 1 hex key | 10" chucks and larger are provided with T-slots.

### 4-Jaw Independent with Hard Solid Reversible Jaws

D Ø Chuck (Inch)	Taper	E (Inch)	F (Inch)	d (Inch)	Solid Jaws H1 (Inch)	H (Inch)	h (Inch)	Ø Camlock Stud (Inch)	Camlock Stud Thread	RPM	Clamping Capacity MIN - MAX (Inch)	Weight (lbs)	Code	Price
8	D1-4	2.501	3.252	2.205	4.331	2.953	0.5118	5/8	M10x1 (3)	1800	0.394-7.87	22	97018634	860.04
10	D1-4	2.501	3.252	2.205	4.700	3.347	0.5118	5/8	M10x1 (3)	1500	0.394-9.84	60	97018717	1133.42
10	D1-6	4.188	5.252	2.953	4.700	3.347	0.6299	7/8	M16x1.5 (6)	1500	0.394-9.84	60	97019004	1133.42
12-1/2	D1-6	4.188	5.252	2.953	5.701	3.740	0.6299	7/8	M16x1.5 (6)	1200	0.591-12.40	87	97018923	1680.25
12-1/2	D1-8	5.501	6.748	3.740	5.701	3.740	0.7087	1	M20x1.5 (6)	1200	0.591-12.40	87	97018899	1680.25

Back Plates/Adapters also available | Ask for more details

### D1 & A1/A2 Steel Adapters

Fully Machined

For Adjustable Body 3 & 6-Jaw Chucks

#### D1 Mount

Adjustable Adapters



#### A Mount

Adjustable Adapters



### D1 & A Adapters

Pre-Machined

For Plain Back Scroll Chucks

#### D1 Mount

Plain Back Adapters



#### A Mount

Plain Back Adapters



ALL HERTEL ADAPTER PLATES INTERCHANGEABLE WITH BISON



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