

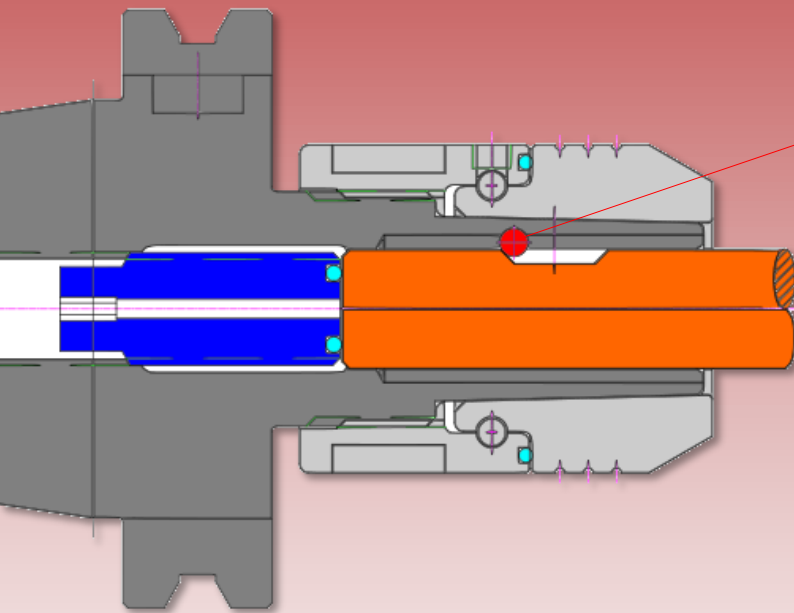
PIONEER Non-Pull Out BC Chuck

The NP Milling System provides a cost effective solution to prevent cutter pull out. Designed to work with any standard Weldon flat the system can be adapted to other flat styles and radial grooves.

Pioneer modifies a standard BC Mill Chuck by EDM, allowing for quick delivery and special configurations in under a week.

The result is a 100% Non-Pull out holder with all the vibration dampening of a Mill Chuck for improved cutter performance.

Combined with the BC Chucks vibration dampening and you have a cost effective performance combination.



How it works...



Requirements:
BC-NP Mill Chuck with
 Preset Screw, Wrench &
 Dowel Pin,
 Weldon End Mill



Insert the
 End mill,
 orientate the flat
 to the cross hole



Insert the
 Hardened
 Dowel Pin



Assemble the
 Lock Nut
 Hand Tight

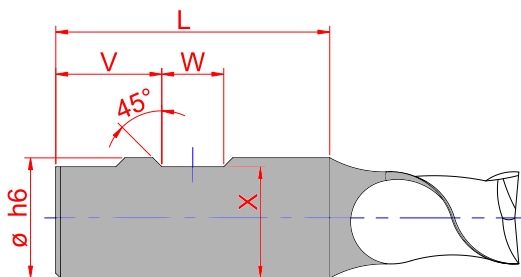


Adjust and Tighten
 the Preset Screw
 until tight against the
 Dowel Pin



Tighten the
 Lock Nut in a
 Locking Fixture

Weldon Flat Information...



Shank		L	V	W		X	
Max ϕ	Min ϕ (ISO h6)			Min	Max	Max	Min
0.3750	0.3746	1.563	0.641	0.125	0.282	0.333	0.325
0.5000	0.4996	1.781	0.616	0.125	0.332	0.458	0.440
0.6250	0.6246	1.906	0.581	0.125	0.402	0.583	0.560
0.7500	0.7495	2.031	0.554	0.125	0.457	0.695	0.675
0.8750	0.8745	2.031	0.554	0.125	0.457	0.820	0.810
1.0000	0.9995	2.281	0.524	0.125	0.517	0.945	0.925
1.2500	1.2494	2.281	0.524	0.125	0.517	1.176	1.156
1.5000	1.4994	2.688	0.524	0.125	0.517	1.426	1.406
2.0000	1.9993	3.250	0.431	0.125	0.702	1.920	1.900

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