# JAW CHUCKS FOR POSITIONERS

## Mechanized Automation

*52 in. (1320.8 mm)*
*Jaw Chuck AD2405-5*

*44 in. (1117.6 mm)*
*Jaw Chuck AD2405-3*

*68 in. (1727.2 mm)*
*Jaw Chuck AD2405-4*

*20 in. (508 mm)*
*Jaw Chuck AD2405-1*

*31 in. (787.4 mm)*
*Jaw Chuck AD2405-2*

*Optional Jaws*
*AD2405-6*

Lincoln Electric® jaw chucks for welding positioners are designed and built to include single point cam operation and adjustable quick change reversible jaws that can be positioned for small and large diameter workpieces. A completely enclosed face prevents flux and weld spatter from impairing the operation of the gripper.

The self-centering mechanism makes changing parts quick and easy. The three standard jaws and three ball lock pins ensure quick location of the part.

**Clamp Range »**
1 - 67.5 in (25 mm - 1715 mm)

**Weight Capacity »**
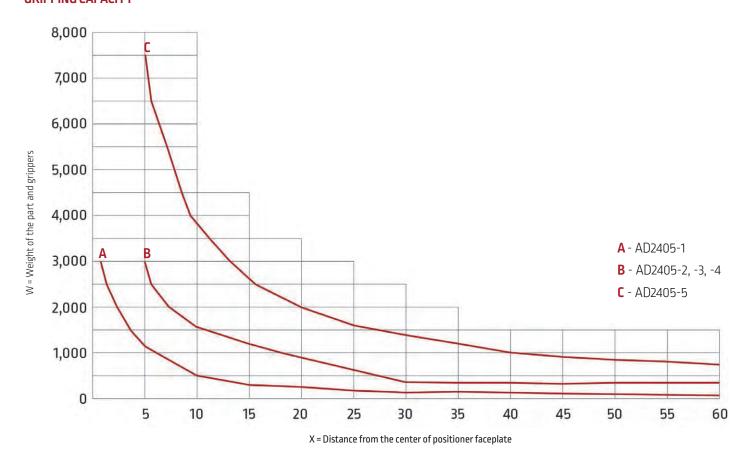1000 lb - 7500 lb (454 kg - 3402 kg)
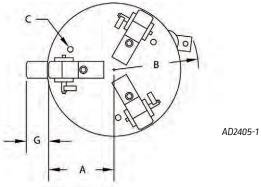
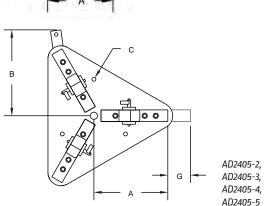**Product Number »**
See back for complete specs

**LINCOLN** ® **ELECTRIC**

## STANDARD SPECIFICATIONS

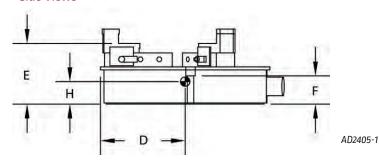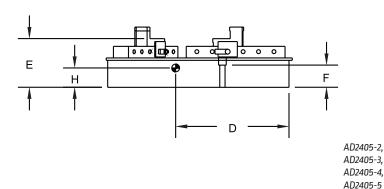| Product Name | Product Number | Overall Clamp Range in (mm) | Clamping Range in (mm) | | Clamp Range with Optional Jaw Chuck (AD2405-6) in (mm) | Chuck Jaws | Chuck Adjustment | Chuck Adjustable Force (Max.) in-lb (Nm) | Jaws Attachment | Mounting Holes in (mm) | Weight lb (kg) | Weight Capacity lb (kg) @ in (mm) |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | I.D | O.D | | | | | | | | |
| Jaw Chuck 20 in (508 mm) | AD2405-1 | 1 - 20 (25.4 - 508) | 6.25 - 20 (159 - 508) | 1 - 16.5 (25 - 419) | 5/8 - 20.87 (15.9 - 530.2) | Self-Centering with three standard jaws | Single point screw with 3 lock ball pins | 1300 (146.8) | Reversible, quickset ball locking pin | 3 holes for 1/2 (12.7) socket head cap screws on 15 3/8 (390.5) B.C.D. | 140 (64) | 1000 (453.6) @ 5 (127) |
| Jaw Chuck 31 in (787.4 mm) | AD2405-2 | 1.5 - 31.25 (38.1 - 794) | 5.5 - 31.25 (140 - 794) | 1.5 - 27.62 (38 - 708) | 5/8 - 32.12 (15.9 - 816) | | | 1380 (155.9) | | 3 holes for 5/8 (15.8) socket head cap screws on 19 1/4 (488.9) B.C.D. | 240 (113) | 3000 (1360.7) @ 5 (127) |
| Jaw Chuck 44 in (1117.6 mm) | AD2405-3 | 1.5 - 44.37 (38.1 - 1127) | 5.5 - 44.37 (140 - 1127) | 1.5 - 40.75 (38 - 1035) | 5/8 - 45.25 (15.9 - 1155.7) | | | 1380 (155.9) | | 3 holes for 5/8 (15.8) socket head cap screws on 19 1/4 (488.9) B.C.D. | 350 (159) | 3000 (1360.7) @ 5 (127) |
| Jaw Chuck 68 in (1727.2 mm) | AD2405-4 | 1.5 - 67.5 (38.1 - 1714.5) | 4.5 - 68 (114 - 1727.2) | 1.5 - 63.5 (38 - 1613) | 5/8 - 68.37 (15.9 - 1736.7) | | | 1380 (155.9) | | 3 holes for 5/8 (15.8) socket head cap screws on 19 1/4 (488.9) B.C.D. | 383 (174) | 3000 (1360.7) @ 5 (127) |
| Jaw Chuck 52 in (1320.8 mm) | AD2405-5 | 3 - 52 (76.2 - 1320.8) | 7 - 52 (179 - 1320.8) | 3 - 48 (76 - 1219) | N/A | Serrated and hardened self-centering with three standard jaws | | 1800 (203.3) | | 3 holes for 3/4 (19) socket head cap screws on 28 7/8 (733.4) B.C.D. | 711 (322) | 7500 (3401.9) @ 5 (127) |
| Optional Jaws | AD2405-6 | - | - | - | N/A | - | - | - | - | - | - | - |

## GRIPPING CAPACITY



A - AD2405-1
B - AD2405-2, -3, -4
C - AD2405-5

W = Weight of the part and grippers

X = Distance from the center of positioner faceplate

*Top Views*

*Side Views*

AD2405-1

AD2405-1

AD2405-2,
AD2405-3,
AD2405-4,
AD2405-5

AD2405-2,
AD2405-3,
AD2405-4,
AD2405-5

## QUICKSET SPECIFICATIONS

| Product Name | Product Number | A | B | C | D | E | F | G | H |
|---|---|---|---|---|---|---|---|---|---|
| | | Jaw Bar Clearance in (mm) | Crank Handle Clearance (Max. Swing) in (mm) | Bolt Center Spacing in (mm) | Frame Swing Clearance in (mm) | Jaw Face Offset in (mm) | Bolt Hole Length in (mm) | Jaw Stroke in (mm) | C.G. Location in (mm) |
| Jaw Chuck 20 in (508 mm) | AD2405-1 | 15.5 (394) | 12.37 (314) | 15.375 (391) | 9 (229) | 6.43 (164) | 3.37 (86) | 2 (51) | 3 (76) |
| Jaw Chuck 31 in (787.4 mm) | AD2405-2 | 15.5 (394) | 18 (457) | 19.25 (489) | 15.125 (384) | 7.18 (183) | 3.87 (98) | 2.25 (57) | 3.37 (86) |
| Jaw Chuck 44 in (1117.6 mm) | AD2405-3 | 22 (559) | 23.5 (597) | 19.25 (489) | 20.43 (519) | 7.18 (183) | 3.87 (98) | 2.37 (60) | 3.56 (90) |
| Jaw Chuck 68 in (1727.2 mm) | AD2405-4 | 33.56 (863) | 23.5 (597) | 19.25 (489) | 20.43 (519) | 7.18 (183) | 3.87 (98) | 2.37 (60) | 3.75 (95) |
| Jaw Chuck 52 in (1320.8 mm) | AD2405-5 | 24.37 (619) | 29.75 (756) | 28.875 (733) | 24.87 (632) | 9.5 (241) | 5.62 (143) | 2.37 (60) | 5.87 (149) |
| Optional Jaws | AD2405-6 | - | - | - | - | - | - | - | - |

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