The best in your hands

ALBRECHT

Precision Drill Chucks

Okay:

The best “drill chuck” in your hands …
those are pretty strong words. However, we are sure of this.
When we invented the self-tightening drill chuck in 1932
we were the only one. And the following decades were
marked by the intention to get better and better.

On the following pages we would like to show you
what to look out for, because a lot in your everyday life
starts with a good drill chuck.

ALBRECHT
Germany

The truth: 90% of all drill chucks are not running true.

100% of all drill chucks are drilling. However, when checking the pin with a dial gauge you will see how accurate they do it. A drill with 13 mm becomes one with 13.2 mm. Your eyes cannot see this and those who don't mind and who do not need such a high precision will prefer the cheaper one. Good deal? No, because there is another disadvantage – the cheaper drill chuck won't last long. How could it – with such a bad run-out.

One does.

An Albrecht drill chuck does have a run-out of 0.04 mm. This precision is tested and confirmed for every Albrecht drill chuck before delivery. By this, we are one of the very very small number of manufacturers who offer real precision.
And the best part is that each Albrecht drill chuck will last very long. Presumably a whole life.

But perfect centering and reaming need a perfect run-out

Yes!

Crash – damage – stop. The centering drill is broken.
No, this was not the person operating the machine.
With a drill chuck not running true nobody is able to center safely.
A little too much pressure, stop, 10.– € broken, work stop, get a new one.
The worst, however, is the part of the centering drill itself which is stuck in the work piece.
Whatever happens needs time and additional cost.
Yes, cheap drill chucks cause indirect cost.

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And 90% of all drill chucks do not have self-tightening features. They just let go.

Everybody has this experience. The drill gets stuck in the work piece and the resistance is higher than the tension of the drill chuck. The chuck slightly opens and the drill stops.
And machine and chuck go on turning empty. So now you have to stop your work, stop the machine and retighten. Only after doing that work can go on.

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One stays tight.

An Albrecht drill chuck here keeps true to its patent 588386. On its own without you having to do anything the drill chuck is forced by the momentum of the drill to close the jaws more and more. This can only work when spindle, jaws and all ground surfaces are tuned perfectly to each other.
For more details see page 26.

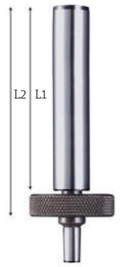
Contents:

Sensitive-Drill-Feed

0.2 up to 1.5 mm

Finally being able to work on smaller and more delicate drills.
The Albrecht Sensitive-Drill-Feed and the according drill chuck for the range of 0.2 up to 1.5 mm enable precise working for everybody. Putting the drill exactly where it should be and a delicate power adjustment of the feed can now be controlled manually. Thus, even the smallest drills now have a long life.
All those who saw problems here before will see them no longer. With the feed on the big knurled wheel you can do the most delicate work in the future.

Sensitive-Drill-Feed, shank precisely ground,
guide ring with ball bearing, spring return, Product group 20.



Form	Option	Part.No.	L1	L2	D	Balanced	kg
MK1 DIN 228		200 MK01 000 0	82	96		20.000	0.10
ø13 Zylinderschaft		200 Z130 000 0	66	80	13	20.000	0.10

Self-tightening drill chuck suitable for the above mentioned Sensitive-Drill-Feed. 0.2 - 1.5 mm

Usable in your machine, with inner taper and marking for pre-setting, Product group 10.

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B06 / J0 ISO 239		100 0015 B06 0	35	37	19	20.000	0.05
B06 / J0 ISO 239	1.8 mm through hole	100 0015 B06 A	35	37	19	20.000	0.05

Self-tightening drill chuck, for clockwise operation, with inner taper, Product group 10 1.5 - 3.0 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B06/J0 ISO 239		100 1015 B06 0	35	37	19	20.000	0.05
B06/J0 ISO 239	1.8 mm through hole	100 1015 B06 A	35	37	19	20.000	0.05

0.2 - 3.0 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B06/J0 ISO 239		100 0030 B06 0	44	48	24		0.10
B06/J0 ISO 239	3.0 mm through hole	100 0030 B06 A	44	48	24		0.10
B10 ISO 239		100 0030 B10 0	44	48	24		0.10
B10 ISO 239	3.0 mm through hole	100 0030 B10 A	44	48	24		0.10
J1 ISO 239		100 0030 J01 0	44	48	24		0.10
J1 ISO 239	3.0 mm through hole	100 0030 J01 A	44	48	24		0.10

0.5 - 6.5 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B10 ISO 239		100 0065 B10 0	62	68	34		0.30
B12 ISO 239		100 0065 B12 0	62	68	34		0.30
J1 ISO 239		100 0065 J01 0	62	68	34		0.30

The real drill chuck

Whoever invents a technical product and then works on improving it for more than 80 years finally will reach the best possible technical standard of today. The truth itself. An Albrecht drill chuck will adhere to this truth. Self-tightening features based on practical experiences.
Built with the best steel and with all essential parts hardened. This results in a drill chuck all other manufacturers worldwide have to live up to. Diamond coated jaws for clamping as per your request, 6 sizes in different range, for clockwise operation, ISO 239 or UNF.

Self-tightening drill chuck for highest quality.
With inner taper or thread, Product group 10

0.5 - 10 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B12 ISO 239		100 0100 B12 0	80	92	43		0.60
B16 ISO 239		100 0100 B16 0	80	92	43		0.60
5/8“-16 UNF		100 0100 G04 0	80	92	43		0.60
J2 ISO 239		100 0100 J02 0	80	92	43		0.60
J33 ISO 239		100 0100 J33 0	80	92	43		0.60

1.0 - 13 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B12 ISO 239		100 0130 B12 0	91	103	50		0.95
B16 ISO 239		100 0130 B16 0	91	103	50		0.95
B16 ISO 239	Diamond coated jaws	1D0 0130 B16 0	91	103	50		0.95
J2 ISO 239		100 0130 J02 0	91	103	50		0.95
5/8“-16 UNF		100 0130 G04 0	91	103	50		0.95
J33 ISO 239		100 0130 J33 0	91	103	50		0.95
J6 ISO 239		100 0130 J06 0	91	103	50		0.95
J6 ISO 239	Diamond coated jaws	1D0 0130 J06 0	91	103	50		0.95

3.0 - 16 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
B16 ISO 239		100 0160 B16 0	96	109	56		1.25
B16 ISO 239	Diamond coated jaws	1D0 0160 B16 0	96	109	56		1.25
B18 ISO 239		100 0160 B18 0	96	109	56		1.25
B18 ISO 239	Diamond coated jaws	1D0 0160 B18 0	96	109	56		1.25
J6 ISO 239		100 0160 J06 0	96	109	56		1.25

Chuck-Removal-Tool. With this tool you immediately get the drill chuck out of the shank. Prevents damage to chuck, spindle and taper, Product group 20

Form	Part.No.	kg
B6 / J0	295 0600 001 0	0.10
B10 / J1 / B12	295 1012 002 0	0.30
B16 / J2 / J33 / B18 / J6	295 1618 003 0	0.60

THE BEST EVER

Finally in a new league. Those who need absolute precision should use this drill chuck. The concentricity of an Albrecht drill chuck with integrated morse taper cannot be beat world wide – at least that is what we see. Whoever has experienced this ease will never want to do without Albrecht. Besides this the integrated design offers an addition in height at the workstation of 21 mm.

Details: for clockwise operation, precision jaws ground on all surfaces. Quick and immediate change. 100% concentricity along the whole clamping range according to standard DIN ISO 10888. Welcome 100%.

The self-tightening drill chucks with integrated morse taper are built for all who need absolute precision for their work. The best for your drilling machine or your tailstock, Product group 10.

0.5 - 6.5 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
MK2 DIN 228		100 0065 MK2 0	62	68	34	10.000	1.03

1 - 13 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
MK2 DIN 228		100 0130 MK2 0	85	97	50	7.000	1.00
MK2 DIN 228	Diamond coated jaws	1D0 0130 MK2 0	85	97	50	7.000	1.00
MK3 DIN 228		100 0130 MK3 0	85	97	50	7.000	1.20
MK3 DIN 228	Diamond coated jaws	1D0 0130 MK3 0	85	97	50	7.000	1.20
MK4 DIN 228		100 0130 MK4 0	87	99	50	7.000	1.50
MK4 DIN 228	Diamond coated jaws	1D0 0130 MK4 0	87	99	50	7.000	1.50

3 - 16 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
MK2 DIN 228		100 0160 MK2 0	89	103	56	4.500	1.30
MK2 DIN 228	Diamond coated jaws	1D0 0160 MK2 0	89	103	56	4.500	1.30
MK3 DIN 228		100 0160 MK3 0	89	103	56	4.500	1.50
MK3 DIN 228	Diamond coated jaws	1D0 0160 MK3 0	89	103	56	4.500	1.50
MK4 DIN 228		100 0160 MK4 0	90	104	56	4.500	1.80
MK4 DIN 228	Diamond coated jaws	1D0 0160 MK4 0	90	104	56	4.500	1.80

Support and Precision Cylindrical shank Bridgeport

An Albrecht cylindrical precision drill chuck is the flexible and optimum support for all your straight shanks in your turning machine.
From 1 up to 13 mm they give your work support and perfection.

Also in your Bridgeport machine an Albrecht drill chuck with integrated R8 shank guarantees a matchless ease and outstanding precision.

Details: precision jaws ground on all surfaces. Quick and easy change. For Clockwise operation. 100% concentricity from 1 to 16 mm according to standard DIN ISO 10888.

Self-tightening drill chuck with integrated cylindrical shank.
Ideal for your turning machines, Product group 10

1 - 13 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
ø 16x60	cylindrical shank	100 0130 Z16 0	79	91	50	-	1.00
ø 32x60	cylindrical shank	100 0130 Z32 0	70	82	50	-	1.20
ø 5/8“x60	cylindrical shank	100 0130 Z58 0	79	91	50	-	1.00

Self-tightening drill chuck with integrated R8 shank.
Ideal for your Bridgeport machine, Product group 10

1 - 13 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
R8 Bridgeport		100 0130 R08 0	84	96	50	7.000	1.25

3 - 16 mm

Form	Option	Part.No.	L1	L2	D	Balanced	kg
R8 Bridgeport		100 0160 R08 0	87	101	56	4.500	1.55

Reverse Lock Clockwise as well as anti-clockwise

This line offers the excellent features of all Albrecht drill chucks and in addition does have a reverse lock which can be adjusted directly on the chuck. This prevents any unintentional opening of this tool. Even with a very quick spindle stop the chuck stays closed. Because “closed” means locked. The Albrecht self-tightening feature will, of course, be still effective during clockwise operation, and you can get diamond coated jaws on request.

Self-tightening drill chuck with reverse lock to prevent unintentional opening. Ideal for **clockwise and anti-clockwise operation.** Inner taper, Product group 10

1 - 13 mm

Form		Option	Part.No.	L1	L2	D	Balanced	kg
B16	ISO 239		100 2130 B16 0	91	103	50		1.10
B16	ISO 239	Diamond coated jaws	1D0 2130 B16 0	91	103	50		1.10
J6	ISO 239		100 2130 J06 0	91	103	50		1.10

3 - 16 mm

Form		Option	Part.No.	L1	L2	D	Balanced	kg
B16	ISO 239		100 2160 B16 0	96	110	56		1.40
B16	ISO 239	Diamond coated jaws	1D0 2160 B16 0	96	110	56		1.40
B18	ISO 239		100 2160 B18 0	96	110	56		1.40
B18	ISO 239	Diamond coated jaws	1D0 2160 B18 0	96	110	56		1.40
J6	ISO 239		100 2160 J06 0	96	110	56		1.40

Chuck-Removal-Tool. With this tool you immediately get the drill chuck out of the shank. Prevents damage to chuck, spindle and taper, Product group 20

Form	Part.No.	kg
B6 / J0	295 0600 001 0	0.10
B10 / J1 / B12	295 1012 002 0	0.30
B16 / J2 / J33 / B18 / J6	295 1618 003 0	0.60

The Best for semi-automatic machines

These Albrecht drill chucks were designed solely for semi-automatic machines. They are ideal for a quick tool change for single-part production up to whole series production. And all drill chucks convince with 100% precision, self tightening features, manual operation or use of key for intensifying the clamping force. And built for clockwise operation.

The self-tightening drill chuck for semi-automatic machines. Quick tool change. 1 - 13 mm

With integrated taper shank and key for additional clamping force. Product group 10.

Form	Option	Part.No.	L1	L2	D	Balanced	kg
A40 DIN 2080		100 4130 140 0	82	94	50		1.70
A40 DIN 69871		100 4130 240 0	86	98	50		1.70
BT40 JIS 6339		100 4130 440 0	92	104	50		1.85
corresponding	ISO 73 88-1 (DIN 69 871) ISO 73 88-2 (JIS B 6339)						

The self-tightening drill chuck for semi-automatic machines. Quick tool change. 1.5 - 16 mm

With integrated taper shank and key for additional clamping force. Product group 10.

Form	Option	Part.No.	L1	L2	D	Balanced	kg
A40 DIN 2080		100 4160 140 0	84	98	56		1.90
A40 DIN 69871		100 4160 240 0	89	103	56		1.90
A50 DIN 69871		100 4160 250 0	87	101	56		3.70
corresponding	ISO 73 99-1 (DIN 69 871) ISO 73 88-2 (JIS B 6339)						

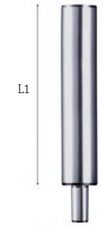
Precision link

As is well known a chain is only as strong as its weakest link. Therefore, we recommend to use our cylindrical shanks. They will reliably connect the capability of your Albrecht drill chuck with that of your machine. With a run-out of < 2 µm they will join quality offered by Albrecht drill chuck with the technical standard of your work shop.

Please do choose your cylindrical shank according to the ø and type of your drill chuck from the table on the right.

Cylindrical shanks, Product group 20.

Form	Part.No.	L1	D	kg
B6	220 0635 B06 0	35	6	0.01
B6	220 0660 B06 0	60	6	0.02
B10	220 0835 B10 0	35	8	0.03
B10	220 1050 B10 0	50	10	0.04
B12	220 1050 B12 0	50	10	0.05
B16	220 1260 B16 0	60	12	0.09
B16	220 1650 B16 0	50	16	0.12
B16	220 2060 B16 0	60	20	0.20
J0	226 3821 J00 0	2 1/2“	3/8“	0.04
J0	226 1221 J00 0	2 1/2“	1/2“	0.07
J1	226 3821 J01 0	2 1/2“	3/8“	0.05
J1	226 1221 J01 0	2 1/2“	1/2“	0.07
J1	226 5821 J01 0	2 1/2“	5/8“	0.11
J2	226 1221 J02 0	2 1/2“	1/2“	0.09
J2	226 3403 J02 0	3“	3/4“	0.20
J33	226 1221 J33 0	2 1/2“	1/2“	0,10
J33	226 5821 J33 0	2 1/2“	5/8“	0.14
J33	226 0103 J33 0	3“	1“	0.35
J6	226 1221 J06 0	2 1/2“	1/2“	0.11
J6	226 3403 J06 0	3“	3/4“	0.22
J6	226 5821 J06 0	2 1/2“	5/8“	0.14



World record.

For example:
An Albrecht MT2.
Clamping range: 0.5 to 6.5 mm.
Speed: 10.000 rpm. Balanced.

In order to produce the taper for your drill chuck we take time, a lot of time.
And the more precise we do our job the more precise your results will be later.
Gauge tolerance: AT3, DIN 228 B – and even better.

21 mm more space.
An Albrecht drill chuck needs less space than the usual two-piece chuck-taper connection.

Only an integrated morse taper guarantees highest rigidity and prevents the frequent loosening of a chuck from the taper. Thus, we do reduce a part that causes run-out problems.

The bigger the torque – the more the best chuck tightens. Patent no. 588386 from the year 1933. So far unbeaten.

Max. clamping when operated clockwise. Keyless opening anti-clockwise. The optimum inclination of the spindle can only be mastered after years of experience.

We will never part. Specifically hardened and ground to this purpose. And all functional surfaces are perfectly tuned to one another.

Hardness: 64 HRC. A must for our jaws.
Forget all else. For this is the only way to reliably clamp tool shafts.
An Albrecht drill chuck has to pass 28 inspection stations.
Then, we pass it on to you – so your work will make a difference.

Thank you

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