

# HG Series Electromagnetic Chuck

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**Magna-Lock USA HG series** electromagnetic chucks are most commonly used on medium and large grinders and are also recommended for milling and planing operations. These chucks have evenly distributed magnetic holding over the entire surface and have rectangular pole pieces that are properly sized to yield maximum holding for your application. The chucks are low wattage and ideal for both large and small workpieces.

Standard HG model sizes range from 5" x 10" to as large as 48" x 72". The maximum recommended length for a magnetic chuck is 60". For larger sizes use combination of standard sizes in tandem or end-to-end mounting. When using chucks in tandem, it is essential that all chucks remain parallel. If one of them needs to be replaced, all of them will need to be re-ground together to achieve a level machining table.

The controlled magnetic flux pattern of these chucks makes them especially ideal for milling and other heavy machining applications because the lower path of magnetic flux will not magnetize milling cutter and spindle as bad as a higher path of magnetic flux. Additionally, these chucks have a long useful life due to ample grid plate stock for regrinding. The standard thickness size of the replaceable top plates for these models is 1.625" with .625" useable before replacement.

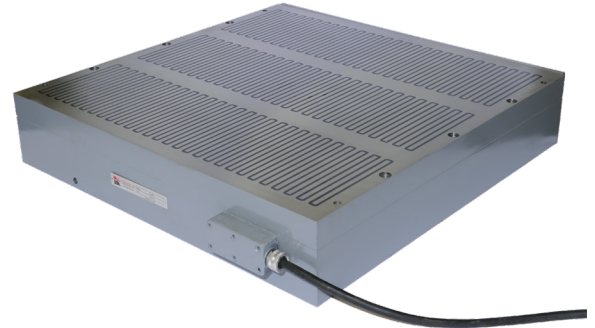
These chucks have lower wattage than other models which will mean less heat when in use. This in turn means closer grinding tolerances due to less expansion of metals in the chuck. Additionally, these chucks would require a less expensive chuck controller because of the lower wattage. Direct current voltage should be specified by customer with 115 or 230 DC being standard and can be altered in the field. Right front terminal box locations are standard, but other locations can be provided on request. All sizes are furnished with adjustable backstops.

All sizes are also available in the grid-to-one edge version with the outermost row of magnetic poles extended all the way to one edge and extending over front or back edge. These models may be used singly for unusually shaped parts or overhanging parts, and may be combined with other standard grid, grid-to-one-edge, or grid-to-two-edge chucks to provide increased magnetic holding area and versatility. These chucks are identified by adding the suffix "E" to the standard grid model number.

All sizes are available with the outermost rows of magnetic pole pieces extended to both outer edges or grid-to-two edge. These chucks may be singly or combined with other models for increased magnetic holding area and versatility. They are identified by adding the suffix "D" to the standard grid model number.

All sizes are available with the magnetic pole pieces extended to all outer edges. These chucks are better used singly. They are identified by adding the suffix "DA" to the standard grid model number.

Standard mounting is sometimes referred to as clamping ledge, Chucks will be furnished with extended base plates to provide clamping ledges at each end. Hold down clamps are provided with the chuck. For butting two or more chucks together without an intervening gap, or for other special requirements, chucks can be furnished with flush ends and provided with counterbored clearance holes for mounting bolts.



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# HG Series Electromagnetic Chuck Specifications

Model	Work surface		Height		Weight		Watts
	in	mm	in	mm	lb	kg	
HG-824G	8 x 24	203 x 610	4	102	215	98	150
HG-836G	8 x 36	203 x 914	4	102	288	131	220
HG-1015G	10 x 15	254 x 381	5	127	160	73	100
HG-1024G	10 x 24	254 x 610	5	127	250	113	160
HG-1030G	10 x 30	254 x 762	5	127	285	129	200
HG-1036G	10 x 36	254 x 914	5	127	385	175	280
HG-1048G	10 x 48	254 x 1219	5	127	485	220	375
HG-1060G	10 x 60	254 x 1524	5	127	750	340	465
HG-1224G	12 x 24	305 x 610	5	127	325	148	200
HG-1230G	12 x 30	305 x 762	5	127	400	181	240
HG-1236G	12 x 36	305 x 914	5	127	480	218	290
HG-1240G	12 x 40	305 x 1016	5	127	525	238	300
HG-1248G	12 x 48	305 x 1219	5	127	615	279	395
HG-1260G	12 x 60	305 x 1524	5	127	750	340	500
HG-1424G	14 x 24	356 x 610	5	127	400	181	200
HG-1436G	14 x 36	356 x 914	5	127	600	272	300
HG-1448G	14 x 48	356 x 1219	5	127	765	347	475
HG-1460G	14 x 60	356 x 1524	5	127	950	431	545
HG-1624G	16 x 24	406 x 610	5.25	133	450	204	290
HG-1636G	16 x 36	406 x 914	5.25	133	700	318	400
HG-1648G	16 x 48	406 x 1219	5.25	133	950	431	535
HG-1660G	16 x 60	406 x 1524	5.25	133	1200	544	730
HG-1824G	18 x 24	457 x 610	5.25	133	530	240	320
HG-1836G	18 x 36	457 x 914	5.25	133	865	392	450

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Model	Work surface		Height		Weight		Watts
	in	mm	in	mm	lb	kg	
HG-1848G	18 x 48	457 x 1219	5.25	133	1200	544	600
HG-1860G	18 x 60	457 x 1524	5.25	133	1525	692	750
HG-2024H	20 x 24	508 x 610	5.25	133	600	272	300
HG-2036H	20 x 36	508 x 914	5.25	133	1000	454	475
HG-2048H	20 x 48	508 x 1219	5.25	133	1400	635	720
HG-2060H	20 x 60	508 x 1524	5.25	133	1700	771	750
HG-2436H	24 x 36	610 x 914	5.25	133	1200	544	500
HG-2448H	24 x 48	610 x 1219	5.25	133	1550	703	780
HG-2460H	24 x 60	610 x 1524	5.25	133	1825	829	1000
HG-3036H	30 x 36	762 x 914	5.5	140	1550	703	750
HG-3048H	30 x 48	762 x 1219	5.5	140	2050	930	1000
HG-3060H	30 x 60	762 x 1524	5.5	140	2600	1179	1225
HG-3636H	36 x 36	914 x 914	5.5	140	1685	764	900
HG-3648H	36 x 48	914 x 1219	5.5	140	2246	1019	1150
HG-3660H	36 x 60	914 x 1524	5.5	140	2700	1225	1500
HG-4248H	42 x 48	1067 x 1219	5.75	146	2620	1188	1400
HG-4260H	42 x 60	1067 x 1524	5.75	146	3270	1483	1650
HG-4848H	48 x 48	1219 x 1219	5.75	146	2995	1359	1500
HG-4860H	48 x 60	1219 x 1524	5.75	146	3744	1698	1875

## HG Series Electromagnetic Chuck Dimensions

	Series	
	G	H
Magnetic Pole Width	.50"	.75"
Non-Magnetic Separator Width	.1875"	.25"
Total Pitch	.6875"	1.00"

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