HB Series
Electromagnetic Chuck
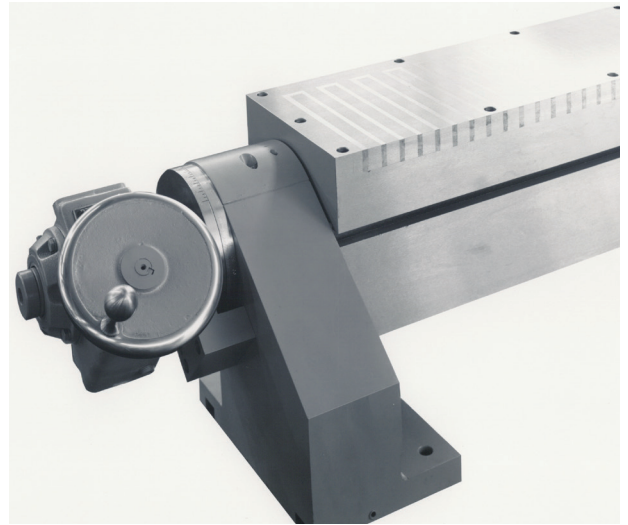
Magna-Lock USA HB series electromagnetic chucks are primarily used for milling, planing, knife grinding and angular machining. Sometimes referred to as swiveling magnetic chucks, or knife bars, they are available in a variety of standard styles and sizes. Other sizes and models can be furnished and will be quoted on request.

The 5" X 10" and 6" X 18" models are provided with brackets only and are intended for lighter grinding and tool room use. These are ideal for resharpening of knives and other angular grinding applications. These smaller models are a laminated type using 1/32" non-magnetic steel separators and 1/8" magnetic steel poles running lengthwise. All other models are supplied with brackets, protractor dial, and an enclosed worm gear box with handwheel (or optional ratchet handle). Means for positive locking at desired angular settings is provided with all models.

The 6" X 32" through 10" X 84" have a square cross section providing greater rigidity for production grinding. These heavy-duty models are well balanced for easy rotation through 360°, and one full-length T-slot for mechanical clamping is included. Position of T-slot can be at option of customer in either of the adjacent faces at 90° to the magnetic surface. Additional T-slots can be provided at extra cost. These models have a special grid style top plate with the magnetic poles extended to the extreme edge to provide magnetic holding where most needed to eliminate chatter.

For some length's models are available in multiple sections for increased support and rigidity. Prices for larger multiple section bars and for units with 90° continuous magnetic surfaces (dual faces) or for magnetic chuck sections only (without brackets or worm gearing) are available on request. For lighter duty models that are one piece knife bar, working surfaces are not to exceed 62" inches in length. For two-piece knife bar, working surfaces should not exceed 123" in length and for three-piece knife bar, working surfaces should not exceed 180" in length. For heavy-duty models that are one piece knife bar, working surface should not exceed 80" in length. For two-piece knife bar, working surfaces should not exceed 160" in length and for three-piece knife bar, working surface should not exceed 240" in length. For longer bar applications, contact our engineers direct.
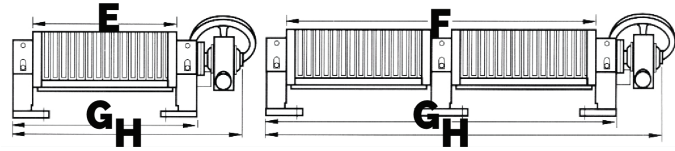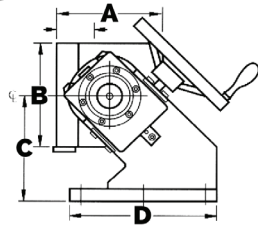
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MAGNA-LOCK USA

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Model	A	B	C	D	E	F	G	H	WEIGHT LBS	WATTS
HB-510C	4	5	4.25	-	10	-	17	-	85	39
HB-618C	4	6	4.25	-	18	-	25	-	135	79
HB-632AG	4.25	6.125	5.25	8.1875	32	-	41.625	-	275	126
HB-638AG	4.25	6.125	5.25	8.1875	38	-	47.625	-	300	138
HB-648AG	4.25	6.125	5.25	8.1875	48.25	48.25	57.875	-	350	200
HB-654AG	4.25	6.125	5.25	8.1875	54.25	54.25	63.875	-	400	220
HB-632G	6.25	6.75	5.25	8.5	32	-	39.125	46.875	375	149
HB-638G	6.25	6.75	5.25	8.5	38	-	45.125	52.875	400	158
HB-644G	6.25	6.75	5.25	8.5	38	-	45.125	52.875	400	158
HB-650G	6.25	6.75	5.25	8.5	50	50	57.125	64.875	450	200
HB-656G	6.25	6.75	5.25	8.5	56	56	63.125	70.875	490	300
HB-662G	6.25	6.75	5.25	8.5	62	62	69.125	76.875	530	300
HB-848G	8.125	8.125	10.25	14.3125	47.875	-	55.875	64.125	980	251
HB-860G	8.125	8.125	10.25	14.3125	60	-	68	76.25	1200	317
HB-872G	8.125	8.125	10.25	14.3125	72	72	80	88.25	1300	377
HB-884G	8.125	8.125	10.25	14.3125	-	84	92	100.25	1450	419
HB-1048H	10.125	10.125	10.25	15.3125	48	-	56	64.25	1510	392
HB-1060H	10.125	10.125	10.25	15.3125	60	-	68	76.25	2050	472
HB-1072	10.125	10.125	10.25	15.3125	72	72	80	88.25	2650	600
HB-1084H	10.125	10.125	10.25	15.3125	84	84	92	100.25	3200	707

NOTE: all dimensions are in inches and are approximates

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OBSIDIAN
Manufacturing Industries, Inc.

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