PERMANENT MAGNETIC CHUCKS

Model RMA
SUPER POWERFUL PERMANENT MAGNETIC CHUCK FOR CUTTING

Greatest holding power in KANETEC permanent magnetic chuck series. New design of ON-OFF switch provides improved durability.

[Application]
Usable for a wide range of applications from heavy duty cutting to heavy duty grinding. Also suitable for certain small workpieces and thin workpieces.

[Features]
- Super powerful permanent magnetic chucks developed by special design for heavy duty cutting.
- Relatively fine pole pitches make the magnetism work effectively on certain small workpieces and thin workpieces.
- A drop in magnetic force due to air gaps is little, enabling heavy duty cutting of mill scale steel.
- The holding power is very strong, yet the operation of the select ratchet handle is light and safe. The handle is detachable for space saving.
- Usable in wet conditions.

RMA-1530A and RMA-4060A require two places for ON-OFF ratchet operation.

Model RMA-U
TILT TYPE POWERFUL PERMANENT MAGNETIC CHUCK

Greatest holding power in KANETEC tilt type permanent magnetic chucks!

[Application]
Suitable for heavy duty grinding of inclined surfaces and light duty cutting.

[Features]
- The strong holding power enables inclined cutting.
- A drop in magnetic force due to air gaps is minimal to make this type suitable for cutting of mill scale steel.
- The tilting angle can be set as desired in a range of 90° forward and 90° backward.
- A 200-mm wide type is also available.

* The ratchet handle (with socket) is included.

* The scaled ring can be used to set an angle roughly. When it is necessary to set the angle accurately, use a sine bar or other suitable device. Note that when it is tilted forward, the ON-OFF operation will become difficult.
MODEL RMA-C

POWERFUL ROUND PERMANENT MAGNETIC CHUCK

[Application]
Strong holding power for various cutting applications.

[Features]
- The magnetic force adjust feature ensures efficient positioning of workpieces for machining by a lathe.
- An easy-to-operate ratchet handle is employed for ON-OFF operation.
- Holding power 1.5 times greater than that of conventional models.

### Relation between handle turning angle and holding power
(in the center of the attractive face)

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Mounting Face</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Dc x Dp</td>
<td>Lc x Le</td>
<td>A x B</td>
</tr>
<tr>
<td>RMA-C16</td>
<td>160 x 6.29</td>
<td>160 x 6.29</td>
<td>100 x 4.29</td>
</tr>
<tr>
<td>RMA-C20</td>
<td>200 x 7.87</td>
<td>200 x 7.87</td>
<td>139 x 5.47</td>
</tr>
<tr>
<td>RMA-C25</td>
<td>250 x 9.84</td>
<td>250 x 9.84</td>
<td>184 x 7.24</td>
</tr>
<tr>
<td>RMA-C32</td>
<td>315 x 12.4</td>
<td>315 x 12.4</td>
<td>244 x 9.60</td>
</tr>
<tr>
<td>RMA-C40</td>
<td>400 x 15.7</td>
<td>400 x 15.7</td>
<td>319 x 12.5</td>
</tr>
</tbody>
</table>

---

MODEL RMA-V

VICE CLAMP TYPE PERMANENT MAGNETIC CHUCK FOR CUTTING

[Application]
Strong holding power for various cutting applications.

[Features]
- Direct clamping in a vice by use of a block for easy removal of the chuck.
- By securing a workpiece overhanging, 5 faces can be machined in one chucking.
- The setup work is done more efficiently than when setting a workpiece in a vice.

### Holding Power (lbs)

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions (mm)</th>
<th>Holding Power (lbs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMA-V125</td>
<td>125 x 6.29 x 6.29</td>
<td>190</td>
</tr>
<tr>
<td>RMA-V150</td>
<td>150 x 9.84 x 9.84</td>
<td>220</td>
</tr>
</tbody>
</table>

---

MODEL RMAW

FINE PITCH POWERFUL RECTANGULAR PERMANENT MAGNETIC CHUCK

A new construction and finer pole pitch to generate strongest holding power on small workpieces!

### Comparison of holding power on weak magnetic materials

Center – holding power

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions (mm)</th>
<th>Mass (lbs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMAW-1018</td>
<td>105 x 3.5 x 3.5</td>
<td>3.5</td>
</tr>
<tr>
<td>RMAW-1325</td>
<td>132.5 x 5.3 x 5.3</td>
<td>5.3</td>
</tr>
<tr>
<td>RMAW-1350</td>
<td>135 x 5.8 x 5.8</td>
<td>5.8</td>
</tr>
</tbody>
</table>

### Relation between holding power and thickness

Center – thickness

<table>
<thead>
<tr>
<th>Holding power (lbs)</th>
<th>Thickness (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>350</td>
<td>2.5</td>
</tr>
<tr>
<td>400</td>
<td>3</td>
</tr>
</tbody>
</table>

---

Size is limited to supply

As for the handle, a hex wrench key is included.

The ratchet handle (with socket) is included. For higher accuracy, the work face needs to be re-ground.

The holding power is based on a test piece of SS400,50mm thick, ground surface held on the whole face.
PERMANENT MAGNETIC CHUCKS

**Model RMT**

**POWERFUL RECTANGULAR PERMANENT MAGNETIC CHUCK**

[Application]
Powerful permanent magnetic chucks for a wide range of applications from heavy duty grinding to light duty cutting. Usable in liquid also.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Weight</th>
<th>Height</th>
<th>Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-1018</td>
<td>100 x 300 x 175</td>
<td>175 x 89</td>
<td>137 (1.37)</td>
<td>137 (1.37)</td>
<td>7 kg</td>
<td>15</td>
<td>50</td>
<td>16 lb</td>
</tr>
<tr>
<td>RMT-1025</td>
<td>100 x 300 x 250</td>
<td>250 x 84</td>
<td>212 (2.12)</td>
<td>212 (2.12)</td>
<td>9.5 kg</td>
<td>20</td>
<td>62</td>
<td>31 lb</td>
</tr>
<tr>
<td>RMT-1030</td>
<td>100 x 300 x 300</td>
<td>300 x 84</td>
<td>253 (2.53)</td>
<td>253 (2.53)</td>
<td>11.5 kg</td>
<td>25</td>
<td>70</td>
<td>44 lb</td>
</tr>
<tr>
<td>RMT-1035</td>
<td>100 x 300 x 350</td>
<td>350 x 84</td>
<td>296 (2.96)</td>
<td>296 (2.96)</td>
<td>13 kg</td>
<td>30</td>
<td>80</td>
<td>57 lb</td>
</tr>
<tr>
<td>RMT-1040</td>
<td>100 x 300 x 400</td>
<td>400 x 84</td>
<td>349 (3.49)</td>
<td>349 (3.49)</td>
<td>14.5 kg</td>
<td>35</td>
<td>90</td>
<td>70 lb</td>
</tr>
<tr>
<td>RMT-1045</td>
<td>100 x 300 x 450</td>
<td>450 x 84</td>
<td>402 (4.02)</td>
<td>402 (4.02)</td>
<td>16 kg</td>
<td>40</td>
<td>100</td>
<td>83 lb</td>
</tr>
<tr>
<td>RMT-1050</td>
<td>100 x 300 x 500</td>
<td>500 x 84</td>
<td>455 (4.55)</td>
<td>455 (4.55)</td>
<td>17.5 kg</td>
<td>45</td>
<td>110</td>
<td>96 lb</td>
</tr>
</tbody>
</table>

Special sizes and stainless-steel types are also available.

**Model RMT-U**

**TILT TYPE PERMANENT MAGNETIC CHUCK**

[Application]
Suitable for angle grinding on grinders. The strong holding power enables angle grinding of various workpieces regardless of whether they are thin, small or thick.

[Features]
- The rotary shaft with scale facilitates angle setting. (An angle can be set as desired between 90° forward and 90° backward)
- Easy installation and highly precise operations.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Tilt Base</th>
<th>Length</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-731U</td>
<td>70 x 275 x 130 (5.11)</td>
<td>130 (5.11)</td>
<td>91 (3.6)</td>
<td>66 (2.59)</td>
<td>225 (8.86)</td>
<td>101 (3.97)</td>
<td>18 kg</td>
<td>1 lb</td>
</tr>
<tr>
<td>RMT-1018U</td>
<td>100 x 300 x 175 (1.75)</td>
<td>175 (6.89)</td>
<td>137 (5.37)</td>
<td>137 (5.37)</td>
<td>290 (11.4)</td>
<td>136 (5.35)</td>
<td>22 kg</td>
<td>4 lb</td>
</tr>
<tr>
<td>RMT-1025U</td>
<td>100 x 300 x 250 (2.5)</td>
<td>250 (9.84)</td>
<td>212 (8.28)</td>
<td>212 (8.28)</td>
<td>365 (14.3)</td>
<td>151 (5.94)</td>
<td>25 kg</td>
<td>5 lb</td>
</tr>
<tr>
<td>RMT-1030U</td>
<td>100 x 300 x 300 (3.0)</td>
<td>300 (11.8)</td>
<td>253 (9.95)</td>
<td>253 (9.95)</td>
<td>456 (16.3)</td>
<td>25 kg</td>
<td>6 lb</td>
<td></td>
</tr>
<tr>
<td>RMT-1035U</td>
<td>100 x 300 x 350 (3.5)</td>
<td>350 (13.7)</td>
<td>296 (11.7)</td>
<td>296 (11.7)</td>
<td>565 (22.3)</td>
<td>25 kg</td>
<td>7 lb</td>
<td></td>
</tr>
<tr>
<td>RMT-1040U</td>
<td>100 x 300 x 400 (4.0)</td>
<td>400 (15.7)</td>
<td>349 (13.7)</td>
<td>349 (13.7)</td>
<td>674 (26.3)</td>
<td>25 kg</td>
<td>8 lb</td>
<td></td>
</tr>
</tbody>
</table>

**Model RMT-V**

**VICE CLAMP TYPE PERMANENT MAGNETIC CHUCK**

[Application]
Most suitable for holding thin workpieces that cannot be secured by a machine vice directly.

[Features]
- Direct clamping in a vice by use of a block for easy removal of the chuck.

<table>
<thead>
<tr>
<th>Model</th>
<th>Dimensions</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-V1018</td>
<td>100 x 300 x 175 (6.89)</td>
<td>20.4 kg (45 lb)</td>
</tr>
<tr>
<td>RMT-V1025</td>
<td>100 x 300 x 250 (9.84)</td>
<td>25 kg (55 lb)</td>
</tr>
<tr>
<td>RMT-V1030</td>
<td>100 x 300 x 300 (11.8)</td>
<td>30 kg (66 lb)</td>
</tr>
<tr>
<td>RMT-V1035</td>
<td>100 x 300 x 350 (13.7)</td>
<td>35 kg (77 lb)</td>
</tr>
<tr>
<td>RMT-V1040</td>
<td>100 x 300 x 400 (15.7)</td>
<td>40 kg (88 lb)</td>
</tr>
<tr>
<td>RMT-V1045</td>
<td>100 x 300 x 450 (17.7)</td>
<td>45 kg (99 lb)</td>
</tr>
</tbody>
</table>
**Model RMT-J**

**ADDITIONALLY WORKABLE RECTANGULAR PERMANENT MAGNETIC CHUCK**

Powerful permanent magnetic chucks for a wide range of applications from heavy duty grinding to light duty cutting. Usable in liquid also.

- **Features**
  - By additionally machining the work face, it becomes possible to hold by magnetism such irregular shaped workpieces that cannot be held on a flat surface. Also by additionally making mounting holes on the mounting face, it becomes possible to mount the chuck on pallets, etc.
  - The work face can be machined to a depth of 13 mm max. and the mounting face to a depth of 25 mm max.

---

### Model RMT-J2020

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Additionally Workable Depth</th>
<th>Mounting Face</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-J1515</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>107.7 (4.24)</td>
<td>1.5 (0.055) + 1.5 (0.055) + 0.32 (0.013)</td>
<td>8 (0.31)</td>
<td>19kg / 33.0 lb</td>
</tr>
<tr>
<td>RMT-J2020</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>151.2 (5.95)</td>
<td>3 (0.12)</td>
<td>0.5 (0.020)</td>
<td>27kg / 59.9 lb</td>
<td></td>
</tr>
</tbody>
</table>

*Note: A hex wrench key is included with Model RMT-J1515 and a dedicated handle is included with Model RMT-J2020.*

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**Model RMWH**

**RECTANGULAR PERMANENT MAGNETIC MICROPITCH CHUCK**

Suitable for grinding thin, small and workpieces.

- **Features**
  - Extremely low profile, 45 mm for small to medium sizes and 50 mm for large sizes and light weight.
  - A wide attractive area on the chuck work face, allowing the corners to be utilized.
  - The magnetic force ON-OFF handle can be operated lightly thanks to a special slide design. The side insert type used allows the handle to be detached when it is not used.
  - A micropitch type having very fine pole-to-pole pitches. This design provides effective holding power not only on thick workpieces but also on thin and small workpieces.
  - Dip-proof specification. (Not usable in liquid) *For use in liquid, please use Model RMWH-ED.*

---

### Model RMWH-2040C

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mounting Face</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-713C</td>
<td>75 (2.95)</td>
<td>130 (5.11)</td>
<td>130 (5.11)</td>
<td>105 (4.13)</td>
<td>175 (6.89)</td>
<td>175 (6.89)</td>
<td>3.8kg / 8.4 lb</td>
</tr>
<tr>
<td>RMWH-1018C</td>
<td>105 (4.13)</td>
<td>130 (5.11)</td>
<td>130 (5.11)</td>
<td>150 (5.90)</td>
<td>118 (4.64)</td>
<td>118 (4.64)</td>
<td>7 kg / 15.4 lb</td>
</tr>
<tr>
<td>RMWH-1025C</td>
<td>105 (4.13)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>9.35 kg / 20.5 lb</td>
</tr>
<tr>
<td>RMWH-1030C</td>
<td>105 (4.13)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>150 (5.90)</td>
<td>11.9 kg / 25.1 lb</td>
</tr>
<tr>
<td>RMWH-1325C</td>
<td>130 (5.11)</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>35 kg / 77.1 lb</td>
</tr>
<tr>
<td>RMWH-1515C</td>
<td>150 (5.90)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>46 kg / 101.4 lb</td>
</tr>
<tr>
<td>RMWH-1530C</td>
<td>150 (5.90)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>62 kg / 136.7 lb</td>
</tr>
<tr>
<td>RMWH-1535C</td>
<td>150 (5.90)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>80 kg / 176.4 lb</td>
</tr>
<tr>
<td>RMWH-1545C</td>
<td>150 (5.90)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>250 (9.84)</td>
<td>80 kg / 176.4 lb</td>
</tr>
<tr>
<td>RMWH-2035C</td>
<td>200 (7.87)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>80 kg / 176.4 lb</td>
</tr>
<tr>
<td>RMWH-2040C</td>
<td>200 (7.87)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>300 (11.8)</td>
<td>80 kg / 176.4 lb</td>
</tr>
</tbody>
</table>

*Note: As for the handle, a hex wrench key is included.*

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**Model RMWH-J**

**ADDITIONALLY WORKABLE RECTANGULAR PERMANENT MAGNETIC CHUCK**

Suitable for grinding thin, thick and small workpieces.

- **Features**
  - As with the standard Model RMWH, this is a micropitch type having very fine pole-to-pole pitches. This design provides effective holding power not only on thick workpieces but also on thin and small workpieces.
  - Since the chuck work face can be machined to a depth of 15 mm max., workpieces that do not have a flat attractive face can also be held firmly.
  - By machining holes and slots according to workpiece shapes in advance, the workpiece securing and setting up time can be reduced significantly when compared with the conventional mechanical clamping method.
  - Since the face plate is thicker than the standard Model RMWH by 15 mm, this chuck can be used for a longer period of time in applications that require frequent self-cut.
  - The chuck mounting section is made of iron, which allows the chuck to be held on an existing magnetic chuck.

Sizes up to 130 mm wide x 250 mm long maximum available.
**Model RMWH-X**  
**RECTANGULAR PERMANENT MAGNETIC SUPER MICROPITCH CHUCK**

It's popular to our users processing small or thin work pieces!

[Application]
Suitable for grinding thin workpieces. Usable for electric discharge machining also.

[Features]
- Super micropitch of 1.2 (0.2 +1).
- Thin sheet holding performance superior to that of Model RMWH-A-H and Model RMWH-C.

[Relation between the holding power and the thickness]

![Graph showing the relation between holding power and thickness](image)

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-X 713</td>
<td>75.2 (9.1) x 130 (5.1)</td>
<td>75.2 (9.1)</td>
<td>18</td>
<td>146 (5.74)</td>
<td>3 kg/6.61 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-X1018</td>
<td>105.4 (13) x 175 (6.89)</td>
<td>105.4 (13)</td>
<td>18</td>
<td>191 (7.52)</td>
<td>5.5 kg/12.1 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-X1325</td>
<td>130 (15.1) x 250 (9.84)</td>
<td>130 (15.1)</td>
<td>18</td>
<td>266 (10.41)</td>
<td>7 kg/15.4 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-X1530</td>
<td>150 (19.0) x 300 (11.8)</td>
<td>150 (19.0)</td>
<td>18</td>
<td>316 (12.4)</td>
<td>1.4 kg/30.8 lb</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included.

**Model RMWH-A-H**  
**RECTANGULAR PERMANENT MAGNETIC MICROPITCH CHUCK**

[Application]
These chucks can be used for a wide range of applications such as securing very small workpieces and securing workpieces during grinding and electric discharge machining. They can be used in liquid also.

[Features]
- Compared with Model RMWH-C, these chucks are capable of holding thinner and smaller workpieces.

![Diagram showing Model RMWH-A-H](image)

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-1018A-H</td>
<td>105.4 (13) x 175 (6.89)</td>
<td>105.4 (13)</td>
<td>18</td>
<td>191 (7.52)</td>
<td>6.5 kg/14 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-1325A-H</td>
<td>130 (15.1) x 250 (9.84)</td>
<td>130 (15.1)</td>
<td>18</td>
<td>266 (10.41)</td>
<td>11 kg/24 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-1530A-H</td>
<td>150 (19.0) x 300 (11.8)</td>
<td>150 (19.0)</td>
<td>18</td>
<td>316 (12.4)</td>
<td>14.5 kg/31 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>RMWH-2035A-H</td>
<td>200 (25.7) x 350 (13.7)</td>
<td>200 (25.7)</td>
<td>18</td>
<td>366 (14.41)</td>
<td>22 kg/48 lb</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included.

**Model RMWH-2F**  
**DOUBLE-FACE HOLDING PERMANENT MAGNETIC CHUCK**

[Application]
Suitable for grinding and electric discharge machining of workpieces of various thicknesses and sizes.

[Features]
- A micro pole-pole pitch on the chuck work face generates effective holding power on thin and small workpieces.
- A powerful permanent magnetic attractive face having a chuck mounting face that can also be turned on and off. Thus, no mechanical clamping is required for installation.
- Can be used in liquid.
- The changeover handle is of side insert type and can be kept detached when it is not used after ON/OFF operation.

![Diagram showing Model RMWH-2F](image)

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Face Plate Pole</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-2F1530B</td>
<td>150.9 (19.1) x 300 (11.8)</td>
<td>150</td>
<td>18</td>
<td>222 (8.74)</td>
<td>17.5 kg</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

As for the handle, a hex wrench key is included.
Model RMC-X

STAR-POLE ROUND PERMANENT MAGNETIC CHUCK

This chuck supports strongly bearing process.

Comparison of ring-shaped workpiece holding power

[Application]
Permanent magnetic chucks for securing ring-shaped workpieces on lathes and vertical combined grinding machines.

[Features]
- The star-pole construction generates a strong magnetic force that works well on ring-shaped workpieces such as bearings.
- The permanent magnetic chucks that do not require electricity can be mounted easily without troublesome wiring. They also contribute to energy saving.
- Usable in wet conditions.
- Model RMC-X-B chucks are equipped with a magnetic force adjust function (the ON-OFF operating angle is about 630 degrees and the magnetic force is adjusted according to the handle turning angles).

Model RMC

POWERFUL ROUND PERMANENT MAGNETIC CHUCK

“B” is magnetic force adjust type.

[Application]
Permanent magnetic chucks using a high-performance magnet for grinding operations on rotary grinders, cylindrical grinders, internal grinders and cutting operations on lathes.

[Features]
- The “B” type can be used in such a way that it first holds a workpiece by a weak magnetic force and after finely adjusting its holding position, it is changed to a strong magnetic force to secure the workpiece firmly.
- Can be used for both grinding and cutting operations.
- Work well on thin workpieces to thick workpieces.
- Highly precise chucks with little accuracy change.
## PERMANENT MAGNETIC CHUCKS

### Model RMCB
**ROUND PERMANENT MAGNETIC CHUCK WITH TAPPED HOLE IN CENTER OF FACE PLATE**

Round permanent magnetic chucks with a tapped hole for easy mounting of various jigs/fixtures introduced!

*Features*
- Two types: standard type and magnetic force adjust type are available.
- As a standard feature, a tapped hole is provided in the center of the attractive face. This facilitates mounting of jigs/fixtures for workpiece alignment.
- The tapped hole in the center is allowed to be M10 max. for the chuck size φ160 and M12 max. for φ200 or over. (For the φ125 size only, a tapped hole must not be worked on.)
- There is a 9-mm additional work allowance from the attractive face, which allows additional work according to jigs/fixtures.
- The permanent magnetic chucks that do not require electricity can be mounted easily without troublesome wiring. They also contribute to energy saving.

### Model RMAW-C
**ROUND PERMANENT MAGNETIC CHUCK**

*Application*
- Used for holding small and thin workpieces in grinding operations on grinders.

*Features*
- Theses chucks firmly hold small and thin workpieces of 3 mm in plate thickness or less.
- While the sizes are the same as conventional chucks, these chucks produce holding power that is about twice as powerful.
- These chucks also offer superior holding performance to conventional chucks on hardened parts used in molds.
- The gap performance is also excellent to reduce influence of flatness and roughness of workpiece attractive faces.
- These are of powerful round type to enable them to be used on light-duty cutting on lathes also.

### Model RMCW
**ROUND PERMANENT MAGNETIC MICROPITCH CHUCK**

*Application*
- Suitable for grinding a wide range of workpieces, small and large, and thin on grinders. Since these chucks are thin, they can be used in a wide range of applications including securing workpieces temporarily.

*Features*
- Thin: 43 mm to 60 mm.
- Micro pole pitch; can be used with any sizes of workpieces, small and large and thin and thick.
- The handle is a hex wrench key. It can be operated lightly. A half turn turns on and off the magnetic force.
- The changeover handle can be set at an angle to generate a weak magnetic force for easy temporary positioning of workpieces.

---

### Table: RMCB Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Tapped Hole in Center</th>
<th>Handle Hole</th>
<th>Mass (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMCB-13</td>
<td>125</td>
<td>125</td>
<td>88</td>
<td></td>
<td></td>
<td>6</td>
<td></td>
<td></td>
<td>65g/170</td>
</tr>
<tr>
<td>RMCB-16</td>
<td>140</td>
<td>140</td>
<td>109</td>
<td></td>
<td></td>
<td>6</td>
<td></td>
<td></td>
<td>67g/170</td>
</tr>
<tr>
<td>RMCB-20</td>
<td>159</td>
<td>159</td>
<td>129</td>
<td></td>
<td></td>
<td>6</td>
<td></td>
<td></td>
<td>67g/170</td>
</tr>
<tr>
<td>RMCB-25</td>
<td>195</td>
<td>195</td>
<td>152</td>
<td>(1.5+φ)</td>
<td></td>
<td>6</td>
<td></td>
<td></td>
<td>96g/170</td>
</tr>
<tr>
<td>RMCB-32</td>
<td>230</td>
<td>230</td>
<td>194</td>
<td>(1.5+φ)</td>
<td></td>
<td>6</td>
<td></td>
<td></td>
<td>256g/195</td>
</tr>
<tr>
<td>RMCB-40</td>
<td>299</td>
<td>299</td>
<td>194</td>
<td>(1.5+φ)</td>
<td>(1.5+φ)</td>
<td>6</td>
<td></td>
<td></td>
<td>256g/195</td>
</tr>
</tbody>
</table>

### Table: RMAW-C Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMAW-C13</td>
<td>125</td>
<td>125</td>
<td>90</td>
<td>80</td>
<td>115</td>
<td>6</td>
<td>(0.11)</td>
<td>1.65g/58</td>
</tr>
<tr>
<td>RMAW-C10</td>
<td>140</td>
<td>140</td>
<td>90</td>
<td>90</td>
<td>115</td>
<td>6</td>
<td>(0.11)</td>
<td>1.65g/58</td>
</tr>
<tr>
<td>RMAW-C13</td>
<td>159</td>
<td>159</td>
<td>90</td>
<td>90</td>
<td>115</td>
<td>6</td>
<td>(0.11)</td>
<td>1.65g/58</td>
</tr>
<tr>
<td>RMAW-C15</td>
<td>195</td>
<td>195</td>
<td>90</td>
<td>90</td>
<td>115</td>
<td>6</td>
<td>(0.11)</td>
<td>1.65g/58</td>
</tr>
</tbody>
</table>

### Table: RMCW Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass (mm)</th>
</tr>
</thead>
</table>

---

For more details or the location of mounting holes of 6C, please contact us. As for the handle, a hex wrench key is included.

---

For more details, please contact us.
Model **RTH**

**SUPER THIN RECTANGULAR PERMANENT MAGNETIC CHUCK**

20mm

Chucks made of stainless steel are also available.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RTH-713A</td>
<td>70 (2.76) x 130 (5.11)</td>
<td>70</td>
<td>70</td>
<td>50</td>
<td>97</td>
<td>200</td>
<td>70</td>
</tr>
<tr>
<td>RTH-1118A</td>
<td>110 (4.33) x 180 (7.08)</td>
<td>110</td>
<td>230</td>
<td>90</td>
<td>147</td>
<td>250</td>
<td>110</td>
</tr>
<tr>
<td>RTH-1515A</td>
<td>150 (5.90) x 200 (7.87)</td>
<td>150</td>
<td>200</td>
<td>130</td>
<td>117</td>
<td>220</td>
<td>150</td>
</tr>
</tbody>
</table>

*As for the handle, a hex wrench key is included.

Model **SKM**

**VERTICAL PERMANENT MAGNETIC CHUCK**

An example of mounting

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>SKM-1018</td>
<td>100 (3.94) x 175 (6.89)</td>
<td>100</td>
<td>100</td>
<td>175</td>
<td>5.95</td>
<td>137</td>
<td>5.95</td>
<td>14.5 (15.5+3.2+1.5+8.3)</td>
</tr>
<tr>
<td>SKM-1325</td>
<td>125 (4.92) x 250 (9.84)</td>
<td>125</td>
<td>250</td>
<td>9.84</td>
<td>209 (8.22)</td>
<td>260 (10.2)</td>
<td>259</td>
<td>5.95</td>
</tr>
<tr>
<td>SKM-1530</td>
<td>150 (5.90) x 300 (11.8)</td>
<td>150</td>
<td>300</td>
<td>11.8</td>
<td>253 (9.96)</td>
<td>260 (10.2)</td>
<td>259</td>
<td>5.95</td>
</tr>
</tbody>
</table>

*One set of stoppers is included. As for the handle, a hex wrench key is included.

Model **SKAW**

**VERTICAL PERMANENT MAGNETIC CHUCK**

A new powerful model added to permanent magnetic chucks for securing workpieces in vertical direction!

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Thickness</th>
<th>Height</th>
<th>Mounting Face</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>SKAW-1018</td>
<td>105 (4.13) x 175 (6.89)</td>
<td>105</td>
<td>175</td>
<td>6.89</td>
<td>134.5</td>
<td>277</td>
<td>24 (0.94)</td>
<td>75 (2.95)</td>
</tr>
</tbody>
</table>

*One set of stoppers is included. As for the handle, a hex wrench key is included.

[Application]

Suitable for securing workpieces for high speed and light duty grinding. (To use these chucks in liquid or in wet conditions, use machining fluid of rust-preventive type.) The light weight design makes these chucks suitable for setup change (pallet change) operations by workers also.

[Features]

* Very thin (only 20 mm high) and light weight permanent magnetic chucks.

[Application]

These chucks are suitable for applications where when securing a workpiece on the table of a machine, it needs to be held vertically due to its shape or it needs to be secured from sides additionally when it cannot be held sufficiently horizontally.

[Features]

* The permanent magnetic chuck used in Model SKM is our powerful RMT.
* Hold various sizes of workpieces; thin, small, and thick.

[Application]

This chuck is suitable for applications where when securing a workpiece on the table of a machine, it needs to be held vertically due to its shape or it needs to be secured from sides additionally when it cannot be held sufficiently horizontally.

[Features]

* Compared with Model SKM, this model can hold smaller and thinner (3 mm) workpieces.
* The rigid construction facilitates maintenance such as recovering the original accuracy.

The standard material of the angle plate is SS400, but it may be made of SKD-11 (HRC60).
PERMANENT MAGNETIC CHUCKS

Model RMT-ED
RECTANGULAR PERMANENT MAGNETIC CHUCK WITH JET HOLE

[Application]
Suitable for securing workpieces during electric discharge machining.

[Features]
● Can be used in liquid.
● With extra powerful holding, these chucks are suitable for applications that require strong holding power.
● A jet hole is provided for jet-stream machining.
● The bottom face is made flat to allow providing tapped holes for clamp fixtures.
● Counter boring around the jet hole on the attractive face is possible.
● The water-tightness performance has been improved over the standard type.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMT-ED2000</td>
<td>200 (7.87) × 200 (7.87)</td>
<td>200 (7.87)</td>
<td>149 (5.86)</td>
<td>15.2 (1.59 + 1.5 + 3.2)</td>
<td>(0.99)</td>
<td>200 (7.87)</td>
<td>220 (8.66)</td>
</tr>
<tr>
<td>RMT-ED2255</td>
<td>250 (9.84) × 250 (9.84)</td>
<td>250 (9.84)</td>
<td>210 (8.26)</td>
<td>250 (9.84)</td>
<td>270 (10.6)</td>
<td>15 (0.59)</td>
<td></td>
</tr>
</tbody>
</table>

[As for the handle, a hex wrench key is included. □ An electromagnetic type (special specification) is also available.

Model RMWH-ED
RECTANGULAR PERMANENT MAGNETIC CHUCK FOR ELECTRIC DISCHARGE MACHINING

[Application]
Suitable for securing workpieces during electric discharge machining.

[Features]
● Can be used in liquid.
● A fine pole pitch ensures securing thin and small workpieces firmly.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Mounting Face</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMWH-ED1018</td>
<td>105 (4.13) × 175 (6.88)</td>
<td>105 (4.13)</td>
<td>142 (5.60)</td>
<td>105 (4.13)</td>
<td>191 (7.51)</td>
<td>3 (1.22)</td>
<td>(0.03 + 0.07)</td>
</tr>
<tr>
<td>RMWH-ED1515</td>
<td>150 (5.90) × 150 (5.90)</td>
<td>150 (5.90)</td>
<td>118 (4.64)</td>
<td>150 (5.90)</td>
<td>166 (6.54)</td>
<td>150 (5.90)</td>
<td>316 (12.4)</td>
</tr>
<tr>
<td>RMWH-ED1530</td>
<td>150 (5.90) × 300 (11.8)</td>
<td>150 (5.90)</td>
<td>256 (10.0)</td>
<td>150 (5.90)</td>
<td>316 (12.4)</td>
<td>1kg/2.2 lb</td>
<td></td>
</tr>
<tr>
<td>RMWH-ED2020</td>
<td>200 (7.87) × 200 (7.87)</td>
<td>200 (7.87)</td>
<td>210 (8.26)</td>
<td>200 (7.87)</td>
<td>216 (8.50)</td>
<td>200 (7.87)</td>
<td>416 (16.3)</td>
</tr>
<tr>
<td>RMWH-ED2040</td>
<td>200 (7.87) × 400 (15.7)</td>
<td>200 (7.87)</td>
<td>346 (13.6)</td>
<td>200 (7.87)</td>
<td>416 (16.3)</td>
<td>200 (7.87)</td>
<td>416 (16.3)</td>
</tr>
<tr>
<td>RMWH-ED2525</td>
<td>250 (9.84) × 250 (9.84)</td>
<td>250 (9.84)</td>
<td>208 (8.18)</td>
<td>250 (9.84)</td>
<td>266 (10.4)</td>
<td>250 (9.84)</td>
<td>266 (10.4)</td>
</tr>
<tr>
<td>RMWH-ED3050</td>
<td>300 (11.8) × 500 (19.6)</td>
<td>300 (11.8)</td>
<td>442 (17.4)</td>
<td>300 (11.8)</td>
<td>516 (20.3)</td>
<td>300 (11.8)</td>
<td>516 (20.3)</td>
</tr>
<tr>
<td>RMWH-ED3600</td>
<td>300 (11.8) × 600 (23.0)</td>
<td>300 (11.8)</td>
<td>541 (21.2)</td>
<td>300 (11.8)</td>
<td>616 (24.2)</td>
<td>300 (11.8)</td>
<td>616 (24.2)</td>
</tr>
</tbody>
</table>

[As for the handle, a hex wrench key is included.

Model RMC-ED
ROUND PERMANENT MAGNETIC CHUCK WITH JET HOLE

[Application]
Suitable for securing workpieces during electric discharge machining.

[Features]
● Can be used in liquid.
● With extra powerful holding, these chucks are suitable for applications that require strong holding power.
● A jet hole is provided for jet-stream machining.
● The bottom face is made flat to allow providing tapped holes for clamp fixtures.
● Counter boring around the jet hole on the attractive face is possible.

<table>
<thead>
<tr>
<th>Model</th>
<th>Nominal Size</th>
<th>Work Face</th>
<th>Pole Pitch</th>
<th>Face Plate Thickness</th>
<th>Height</th>
<th>Handle Hole</th>
<th>Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>RMC-ED16</td>
<td>160 (6.29)</td>
<td>160 (6.29)</td>
<td>118 (4.64)</td>
<td>15.2 (1.59 + 1.5 + 3.2)</td>
<td>29 (1.14)</td>
<td>60 (2.36)</td>
<td>Hex. 8 (0.31)</td>
</tr>
<tr>
<td>RMC-ED20</td>
<td>200 (7.87)</td>
<td>200 (7.87)</td>
<td>149 (5.86)</td>
<td>0.59 (0.03 + 0.36 + 0.05 + 0.12)</td>
<td>29 (1.14)</td>
<td>60 (2.36)</td>
<td>Hex. 8 (0.31)</td>
</tr>
</tbody>
</table>

[As for the handle, a hex wrench key is included.
**Model CMR**

**NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE**

RMT-ED / RMWH-ED / RMC-ED / CMR / CMR-H / CMR-DL

---

**CMR-1018**

- **Features**
  - Suitable for relatively large and thick workpieces. The gap characteristic is excellent.
  - The holding power has been increased 1.5 times max. from the conventional chucks.
  - The separator part is made of stainless steel to enhance accuracy stability.
  - Works well on small and thin workpieces that cannot be held by conventional pitches.
  - The holding power is 2 times max. (depending on materials) the conventional chucks.
  - The separator part is made of stainless steel to enhance accuracy stability.

---

**CMR-H type holding power characteristics**

- **Comparison of side slip holding power**
  - Carbide test piece (d=5 x 20 x 30)

---

**Model CMR-H**

**NON-CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE**

---

**CMR-H0709**

- **Standard pitch type**

**CMR-HW0709**

- **Fine pitch type**

---

**CMR-DL**

**CHANGEABLE PERMANENT MAGNETIC CHUCK FOR CEMENTED CARBIDE**

- **Features**
  - The ON-OFF handle turning angle has been reduced to improve the handle operability significantly.
  - The holding performance has been enhanced by improving the pole pitch.
  - Residual magnetism has been reduced by employing a unique construction. (CMR-DL319B)
  - The effective attractive face relative to the external dimensions has been increased 30% over the conventional model. (CMR-DL0915B)

---

**CMR-DL0915B**

- **New type**

---

**Model CMR-DL**

**Model CMR-H**

**Model CMR-DL**

---

**Model CMR-DL1319B**

- **Features**
  - Compact
  - For MC tools
  - Electromagnetic chuck
  - Magnetic chuck
  - Magnetic chuck system
  - Chuck holders
  - Chuck holders
  - Chuck holders

---

**Comparison of magnetic poles with conventional model**

- **Features**
  - Compact
  - Standard
  - Fine
  - Powerful