Precision Diaphragm Chucks

NORTHFIELD
NORTHFIELD… THE WORLD LEADER IN PRECISION DIAPHRAGM AIR CHUCKS

GUARANTEED ACCURACY
- Radial - .000020 inch T.I.R
- Axial - .000010 inch T.I.R.

Advantages of a diaphragm chuck:
- Completely sealed from harsh environments
- Jaw motion provides pullback feature
- No metal-to-metal moving parts
- Counterbalanced for higher operating speeds
- No lubrication required, maintenance free
- Uniform, adjustable clamping pressures

Applications:
- Grinding, turning, boring, milling, measuring, inspection, material handling, robotics, CNC, EDM
- All Machines: Rotating, stationary, vertical, horizontal
- Universal workholding: external, thin-wall, rigid

Productivity
- Simple loading and unloading. No indicating or adjusting.
- Automatic self centering
- Uniform, adjustable holding pressure
- Automatic or manual operation

Reliability
- No metal-to-metal moving parts for extremely long life.
- Counterbalanced to operate at high speeds
- Built-in, self contained air cylinder
- Built-in safety features.

The Precision Workholding source
- Workholding leader in accuracy, reliability, repeatability, concentricity and productivity.
- Standard chuck sizes from 3-inch to 10-inch
- Specials up to 18-inch
- Coolant thru or air thru models available
- Custom designed tooling. Special jaws and back stops, engineered and manufactured to adhere to your work piece tolerance.
- One competitive price for a complete workholding solution.

AIR FILTER / LUBRICATOR (OPTIONAL)
AIR INLET
ROTARY UNION
FLEXIBLE HOSES
'CLAMP' PRESSURE REGULATOR WITH GAUGE & QUICK-DUMP VALVE (OPTIONAL)
DIAPHRAGM CHUCK
TOP TOOLING
MANUAL CLAMP / UNCLAMP VALVE
'UNCLAMP' PRESSURE REGULATOR WITH GAUGE & QUICK-DUMP VALVE (OPTIONAL)
CUSTOM DESIGNED WORKHOLDING JAWS
Top jaws are a critical part of a precision workholding system. The same attention must be paid to jaw design and manufacture as to chuck machine performance if maximum accuracy is to be achieved at the workpiece. Northfield’s experienced workholding engineers and specialized manufacturing facilities provide a unique capability for the design and manufacture of custom jaws. Based on customer drawings or workpieces, we design jaws to hold the most intricate or fragile parts. The appropriate material is used — from hardened and ground tool steel through aluminum to Delrin plastic and serrated diamond points. Jaws are created for external, thin-wall/rigid, over-the-shoulder, and hundreds of other unique solutions to exactly meet each workholding requirement to bring gauge block accuracy to your production pieces.

SPECIAL DEVICES FOR INCREASED PRODUCTIVITY
Quality and productivity are improved by specialized tooling produced by Northfield. Among the workholding products we design and manufacture are devices for parts ejection, coolant direction, chip blow-off, robotic loading/unloading, locating tooling, stand-offs and chuck redesign for special applications. In most cases, quotations for these engineering services are free.

U.S. and METRIC
All dimensions and weights listed in this catalog are in U.S. (Imperial) and metric equivalents.

ORDERING INFORMATION
To fit the custom-made air tube to your machine, we need:
(1) I.D. of the spindle’s rear. Within .002” (.051mm).
(2) Overall length of the spindle.
(3) I.D. of the spindle’s bore at midpoint for spindles over 25 inches (635mm) in length.

The basic Northfield Precision workholding package includes: one chuck, custom made air tube, rotary joint, operating valve, hoses, rear split bushing, lubricant, mounting wrench, loading pins, mounting screws and operating instructions. Non-rotating chucks come with a non-rotating air joint.

TERMS: Net 30 days, F.O.B. Island Park, NY

ACCESSORIES AVAILABLE
- Adapter plate — machined to your spindle nose configuration.
- Stationary fixture plates.
- Air pressure regulator, filter, lubricator.
- Side-mounted air ports for lower stationary chuck profile.
- Replacement top jaws.
- Quick disconnects.
MODEL DPH-300W
3 INCH COOLANT-THROUGH DIAPHRAGM CHUCK

MODEL DPH-300I
3 INCH NON-ROTATING AIR TUBE DIAPHRAGM CHUCK

Also Available: DPH-300 DIAPHRAGM CHUCK

SPECIFICATIONS

• Actuation – Air Open/Close, with or without Diaphragm Clamping
• Radial Accuracy – 0.000020" TIR
• Axial Accuracy – 0.000010" TIR
• Jaw Stroke – 0.020" with Pull-Down Action
   (1" Top Jaws) @ 100 PSI
• Speed – 15,000 RPM Max. with Proper Top Jaws
• Weight – 3.4 lbs.
• Standard Chucking Range – 0" to 2.5"
• Totally Sealed with No Metal-to-Metal Moving Parts
• Coolant-Through or Air Blast-Through (DPH 300W)

MATERIALS

• Diaphragm – Special Multi-Treated High Alloy Steel
• Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

NORTHFIELD
PRECISION INSTRUMENT CORPORATION

4400 Austin Blvd., P.O. Box 550, Island Park, NY 11558-0550
(T) (516) 431-1112 (F) (516) 431-1928 (E) sales@northfield.com (W) www.northfield.com
Call Toll Free 1 (800) 810-2482
MODEL DPH-400CBW
4 INCH COOLANT-THROUGH
5/8" COUNTER BORE DIAPHRAGM CHUCK

Also Available: DPH-400CB 5/8" COUNTER BORE DIAPHRAGM CHUCK

MODEL DPH-400W
4 INCH COOLANT-THROUGH
DIAPHRAGM CHUCK

Also Available: DPH-400 DIAPHRAGM CHUCK

SPECIFICATIONS

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.048" with Pull-Down Action
  (1" Top Jaws) @ 100 PSI
- Speed – 12,000 RPM Max. with Proper Top Jaws
- Weight – 5.6 lbs.
- Standard Chucking Range – 0" to 3.0"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

MATERIALS

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

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Call Toll Free 1 (800) 810-2482
MODEL DPH-400I
4 INCH NON-ROTATING AIR TUBE
DIAPHRAGM CHUCK

MODEL DPH-500W
5 INCH COOLANT-THROUGH
DIAPHRAGM CHUCK

SPECIFICATIONS
SPECIFICATIONS SUBJECT TO CHANGE

- Actuation — Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy — 0.000020" TIR
- Axial Accuracy — 0.000010" TIR
- Jaw Stroke — 0.048" with Pull-Down Action
  (1" Top Jaws) @ 100 PSI
- Speed — 12,000 RPM Max. with Proper Top Jaws
- Weight — 5.6 lbs.
- Standard Chucking Range — 0" to 3.0"
- Totally Sealed with No Metal-to-Metal Moving Parts

- Actuation — Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy — 0.000020" TIR
- Axial Accuracy — 0.000010" TIR
- Jaw Stroke — 0.050" with Pull-Down Action
  (1.5" Top Jaws) @ 100 PSI
- Speed — 12,000 RPM Max. with Proper Top Jaws
- Weight — 9.8 lbs.
- Standard Chucking Range — 0" to 4.1"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

MATERIALS

- Diaphragm — Special Multi-Treated High Alloy Steel
- Air Cylinder Components — Heat Treated Stainless Steel

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**SPECIAL FEATURES**

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.050" with Pull-Down Action (1.5" Top Jaws) @ 100 PSI
- Speed – 12,000 RPM Max. with Proper Top Jaws
- Weight – 9.8 lbs.
- Standard Chucking Range – 0" to 4.1"
- Totally Sealed with No Metal-to-Metal Moving Parts

**SPECIFICATIONS**

**SPECIFICATIONS SUBJECT TO CHANGE**

**MATERIALS**

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

**DIMENSIONS**

**MODEL DPH-500I**

- 5 INCH NON-ROTATING AIR FEED TUBE DIAPHRAGM CHUCK

**MODEL DPH-600W**

- 6 INCH COOLANT-THROUGH DIAPHRAGM CHUCK

**CALL TOLL FREE 1 (800) 810-2482**
MODEL DPH-600I
6 INCH NON-ROTATING AIR FEED TUBE
DIAPHRAGM CHUCK

MODEL DPH-600LW
6 INCH LOW PROFILE COOLANT-THROUGH
DIAPHRAGM CHUCK

SPECIFICATIONS

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- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.060" with Pull-Down Action (1.5" Top Jaws)
- Speed – 10,000 RPM Max. with Proper Top Jaws
- Weight – 16.3 lbs.
- Standard Chucking Range – 0" to 4.8"
- Totally Sealed with No Metal-to-Metal Moving Parts

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.060" with Pull-Down Action (1.5" Top Jaws)
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 13.0 lbs.
- Standard Chucking Range – 0" to 4.8"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

MATERIALS

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

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- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

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Call Toll Free 1 (800) 810-2482
MODEL DPH-600LI
6 INCH LOW PROFILE NON-ROTATING AIR FEED TUBE DIAPHRAGM CHUCK

SPECIFICATIONS

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.060" with Pull-Down Action (1.5" Top Jaws)
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 13.0 lbs.
- Standard Chucking Range – 0" to 4.8"
- Totally Sealed with No Metal-to-Metal Moving Parts

MATERIALS

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

Also Available: DPH-700 DIAPHRAGM CHUCK

MODEL DPH-700W
7 INCH COOLANT-THROUGH DIAPHRAGM CHUCK

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Call Toll Free 1 (800) 810-2482
MODEL DPH-700LW
7 INCH LOW PROFILE COOLANT-THROUGH DIAPHRAGM CHUCK

SPECIFICATIONS

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
- Axial Accuracy – 0.000010" TIR
- Jaw Stroke – 0.065" with Pull-Down Action (1.5" Top Jaws) @ 100 PSI
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 23.2 lbs.
- Standard Chucking Range – 0" to 5.5"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

MATERIALS

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

Also Available: DPH-700L LOW PROFILE DIAPHRAGM CHUCK

MODEL DPH-700LIW
7 INCH LOW PROFILE NON-ROTATING AIR FEED TUBE DIAPHRAGM CHUCK

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000020" TIR
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- Jaw Stroke – 0.065" with Pull-Down Action (1.5" Top Jaws) @ 100 PSI
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 23.2 lbs.
- Standard Chucking Range – 0" to 5.5"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

Also Available: DPH-700LI LOW PROFILE DIAPHRAGM CHUCK

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

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- Diaphragm – Special Multi-Treated High Alloy Steel
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- Diaphragm – Special Multi-Treated High Alloy Steel
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- Jaw Stroke – 0.065" with Pull-Down Action (1.5" Top Jaws) @ 100 PSI
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 23.2 lbs.
- Standard Chucking Range – 0" to 5.5"
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- Coolant through or Air Blast-Through

Also Available: DPH-700LI LOW PROFILE DIAPHRAGM CHUCK

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

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- Jaw Stroke – 0.065" with Pull-Down Action (1.5" Top Jaws) @ 100 PSI
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 23.2 lbs.
- Standard Chucking Range – 0" to 5.5"
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

Also Available: DPH-700LI LOW PROFILE DIAPHRAGM CHUCK

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS
MODEL DPH-800W
8 INCH COOLANT-THROUGH
DIAPHRAGM CHUCK

Also Available: DPH-800 DIAPHRAGM CHUCK

SPECIFICATIONS
SPECIFICATIONS SUBJECT TO CHANGE

- **Actuation** – Air Open/Close, with or without Diaphragm Clamping
- **Radial Accuracy** – 0.000050" TIR
- **Axial Accuracy** – 0.000050" TIR
- **Jaw Stroke** – 0.060" with Pull-Down Action (2" Top Jaws) @ 100 PSI
- **Speed** – 8,000 RPM Max. with Proper Top Jaws
- **Weight** – 40.8 lbs.
- **Standard Chucking Range** – 0" to 6.5"
- **Totally Sealed with No Metal-to-Metal Moving Parts**
- **Coolant through or Air Blast-Through**

MATERIALS

- **Diaphragm** – Special Multi-Treated High Alloy Steel
- **Air Cylinder Components** – Heat Treated Stainless Steel

DIMENSIONS

- 6.600 PILOT
- 5.2000 Pilot
- 3.125 MACHINABLE AREA
- CENTER SLUG CAN BE MACHINED FOR TOOLING

Also Available: DPH-800L LOW PROFILE DIAPHRAGM CHUCK

MODEL DPH-800LW
8 INCH LOW PROFILE COOLANT-THROUGH
DIAPHRAGM CHUCK

- **Actuation** – Air Open/Close, with or without Diaphragm Clamping
- **Radial Accuracy** – 0.000050" TIR
- **Axial Accuracy** – 0.000050" TIR
- **Jaw Stroke** – 0.060" with Pull-Down Action (2" Top Jaws) @ 100 PSI
- **Speed** – 3,000 RPM Max. with Proper Top Jaws
- **Weight** – 30.1 lbs.
- **Standard Chucking Range** – 0" to 6.5"
- **Totally Sealed with No Metal-to-Metal Moving Parts**
- **Coolant through or Air Blast-Through**

- **Diaphragm** – Special Multi-Treated High Alloy Steel
- **Air Cylinder Components** – Heat Treated Stainless Steel

- 3.000 PILOT
- 3.125 MACHINABLE AREA
- CENTER SLUG CAN BE MACHINED FOR TOOLING

Also Available: DPH-800 DIAPHRAGM CHUCK

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(T) (516) 431-1112 (F) (516) 431-1928 (E) sales@northfield.com (W) www.northfield.com
Call Toll Free 1 (800) 810-2482
**MODEL DPH-800LIW**

8 INCH LOW PROFILE COOLANT-THROUGH NON-ROTATING AIR FEED TUBE DIAPHRAGM CHUCK

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000050" TIR
- Axial Accuracy – 0.000050" TIR
- Jaw Stroke – 0.060" with Pull-Down Action (2" Top Jaws) @ 100 PSI
- Speed – 3,000 RPM Max. with Proper Top Jaws
- Weight – 30.1 lbs.
- Standard Chucking Range – 0” to 6.5”
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

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**MODEL DPH-1000W**

10 INCH COOLANT-THROUGH DIAPHRAGM CHUCK

Also Available: DPH-1000 DIAPHRAGM CHUCK

- Actuation – Air Open/Close, with or without Diaphragm Clamping
- Radial Accuracy – 0.000050" TIR
- Axial Accuracy – 0.000050" TIR
- Jaw Stroke – 0.120" with Pull-Down Action (2.5" Top Jaws) @ 100 PSI
- Speed – 8,000 RPM Max. with Proper Top Jaws
- Weight – 92.9 lbs.
- Standard Chucking Range – 0” to 8.3”
- Totally Sealed with No Metal-to-Metal Moving Parts
- Coolant through or Air Blast-Through

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**SPECIFICATIONS**

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

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**DIMENSIONS**

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

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**MATERIALS**

- Diaphragm – Special Multi-Treated High Alloy Steel
- Air Cylinder Components – Heat Treated Stainless Steel

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Call Toll Free 1 (800) 810-2482
MODEL DPH-1000LW
10 INCH LOW PROFILE COOLANT-THROUGH DIAPHRAGM CHUCK

Also Available: DPH-1000L LOW PROFILE DIAPHRAGM CHUCK

SPECIFICATIONS

• Actuation – Air Open/Close, with or without Diaphragm Clamping
• Radial Accuracy – 0.000050" TIR
• Axial Accuracy – 0.000050" TIR
• Jaw Stroke – 0.120" with Pull-Down Action (2.5" Top Jaws) @ 100 PSI
• Speed – 3,000 RPM Max. with Proper Top Jaws
• Weight – 68.7 lbs.
• Standard Chucking Range – 0" to 8.3"
• Totally Sealed with No Metal-to-Metal Moving Parts

MATERIALS

• Diaphragm – Special Multi-Treated High Alloy Steel
• Air Cylinder Components – Heat Treated Stainless Steel

DIMENSIONS

Also Available:

MODEL DPH-1000LIW
10 INCH LOW PROFILE NON-ROTATING AIR FEED TUBE DIAPHRAGM CHUCK

• Actuation – Air Open/Close, with or without Diaphragm Clamping
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• Diaphragm – Special Multi-Treated High Alloy Steel
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DIMENSIONS
12 IN. SLIDING JAW CHUCK WITH QUICK CHANGE SUB JAW

HOT DOG CHUCK

7 IN. COMPENSATING DIAPHRAGM CHUCK
3 IN. DIA. CHUCK WITH OUTER RING ROTARY UNION

3 IN. STATIONARY DIAPHRAGM CHUCK

SPECIAL 5 IN. DIAPHRAGM CHUCK WITH COUNTER BORE

7 IN. DIAPHRAGM CHUCK WITH FACE CLAMPS

4 IN. DIA. DIAPHRAGM CHUCK TO GRIP CIRCULATOR PUMP BEARING HOUSE
Precision Air Chucks

Northfield Precision works closely with a world-wide network of representatives and distributors to provide sales and service for the most accurate line of air chucks in the world. This network is supported by factory engineers, full documentation and a national advertising program.

In addition, Northfield is continually developing new products, custom designed to solve the most difficult workholding problems. Northfield supplies precision products to the international automotive, aerospace, electrical/electronic, medical/optical, machine tool, plastics/ceramics and appliance industries.

Northfield provides special accessories such as: automatic lubrication; air or spring ejectors; parts locators; coolant redirection; rubber covers; multiple chuck pallets; all metric chucks; quick-change top jaws. Northfield engineers provide custom workholding solutions for any part that may seem to be impossible to hold.