



Special 5 inch diameter diaphragm chuck, air open diaphragm clamp. Chuck has 8 sets of jaws that repeat to 1/10,000 when removed & replaced. 6 different stops mount to center of chuck for positive axial location. Jaws are alloy steel hardened to 58/63 Rockwell "C". Chuck is mounted to a special balance machine that finds the center of gravity of the cast turbine blades and drills a centering hole in that position. The part is now rotated about this center instead of machining weight off different areas for balance.

- T.I.R. = 50 millionths
- Axial = 0
- Cycle time 30 seconds.

NORTHEIELD
MODEL DPH-5S