The standard has evolved.
BR series
The jaw-reforming at setup change is eliminated. (BR-Plus)
BR series

Next generation standard chuck

1. **Gripping accuracy of 0.01 mm T.I.R. or less, transforming standard machining methods**
   This chuck can be also used for finishing process.

   ![Existing chuck](image1)
   ![BR chuck](image2)

   - Chuck body
   - Jaw
   - Test bar
   - \(\phi 0.02\)
   - \(\phi 0.01\)

2. **Reduced jaw-lift**
   Stable gripping accuracy
   Good for workpiece transfer in sub-spindle lathes

   ![Existing chuck](image3)
   ![BR chuck](image4)

   - Jaw-lift: large
   - Jaw-lift: small

3. **Interchangeable with Kitagawa B-200 & BB200**
   Existing cylinder can be used.

4. **Modern appearance**
   Body with rounded corner edge

   ![Dedicated QR code](image5)
With the optional special T-nuts it will become more accurate
BR-Plus

Maintaining a repeatability of 0.01 mm T.I.R. or less after changing jaws
The BR-Plus jaw mounting design enables unrivalled top jaw exchange accuracy.

1 Eliminating jaw-reforming at setup change

Significant reduction of setup time
3 setup changes per day, 30 minutes jaw forming per setup change
450 hours per year = 1.35 million Yen

Please watch the video from the QR code on the right.

2 Parent-child jaws can be replaced with monoblock jaws.

Due to high repeatability at jaw changing, it is not necessary to use parent-child jaws.

The chuck can rotate at higher speed so that the surface roughness is improved as well as reducing cycle time.

3 Kitagawa soft jaws on your shelves can be used.

※High repeatability can be realized only with Kitagawa genuine soft jaws. Use of jaws manufactured by a third party may cause deterioration of repeatability, sliding surface seizure or damage to parts.

Note 1) The gripping accuracy is the Total Indicator Reading of the test bar right after forming jaws.
Note 2) The repeatability is the amount of the test bar runout measured by detaching the formed jaws from the chuck and mounting them again in the same position.
Note 3) Both the gripping accuracy and repeatability are the amounts of test bar runout measured 10 mm apart from the top end of Kitagawa standard soft jaw. The above criteria are based on our internal regulations.
### Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>A</th>
<th>B</th>
<th>C (mm)</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G (mm)</th>
<th>H (mm)</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
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<td>170</td>
<td>81</td>
<td>140</td>
<td>104.8</td>
<td>3-M10</td>
<td>53</td>
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<td>81</td>
<td>8.5 (-10.5)</td>
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<tr>
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<td>108</td>
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<td>235</td>
<td>3-M20</td>
<td>106</td>
<td>8 (-15)</td>
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<td>0</td>
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</tr>
</tbody>
</table>

### Specifications

- The specifications and outside appearance are subject to change without notice due to ongoing research and development.
- The color of the actual product may be different from the catalog's due to printing matters.
- Catalogue contents as of 2018.10
- The products herein are under Japanese Foreign Exchange and Foreign Trade Control Act.
- In the event of importing and/or exporting the products, you are obliged to consult KITAGAWA as well as your government for the related regulation prior to any transaction.

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