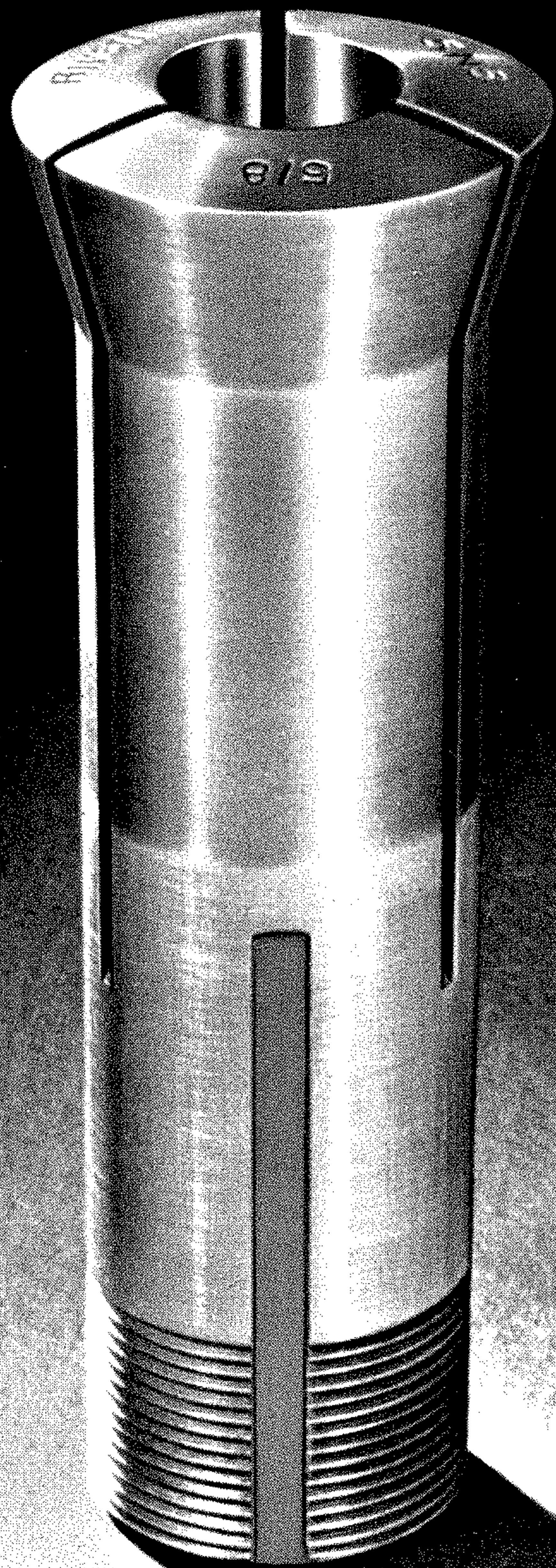


RIVETT



**COLLETS
AND
CHUCKS**

RIVETT
Rudel, Carey & Briggs, Inc.

435 FOURTH AVE. :: NEW YORK 16, N. Y.

Sales Engineers — Distributors

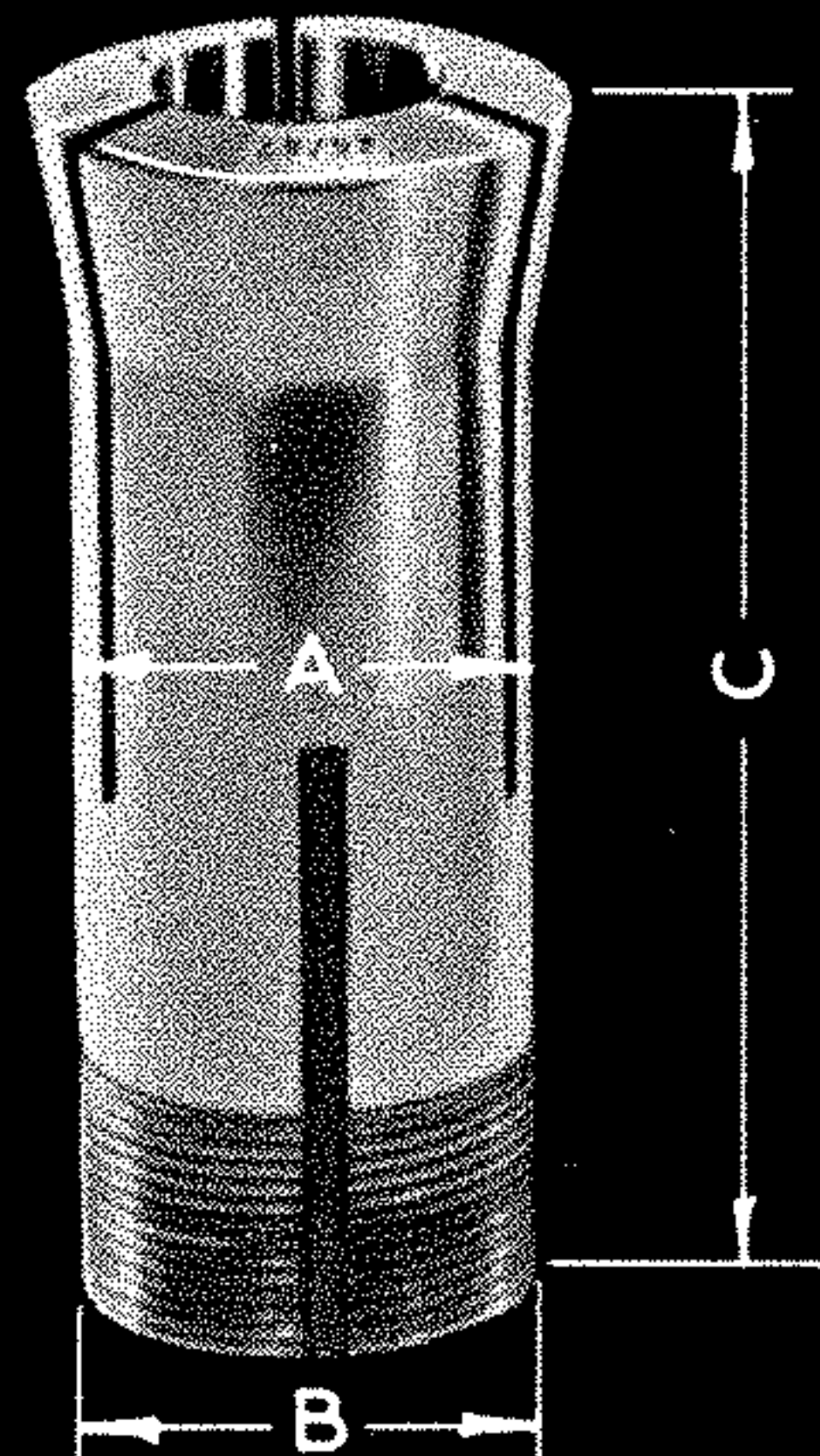


Fig. 1—Collet

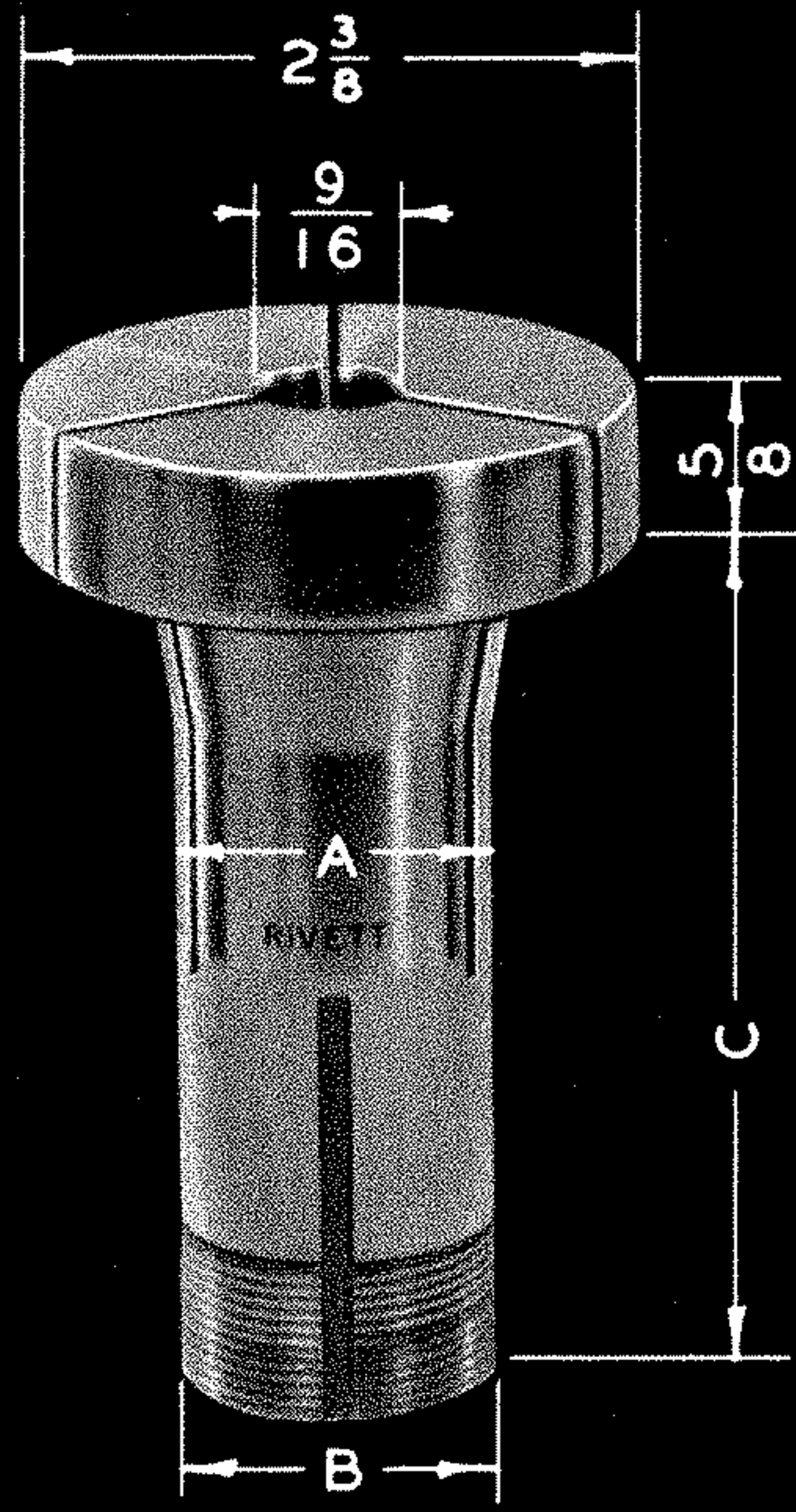


Fig. 2—2" Step Chuck

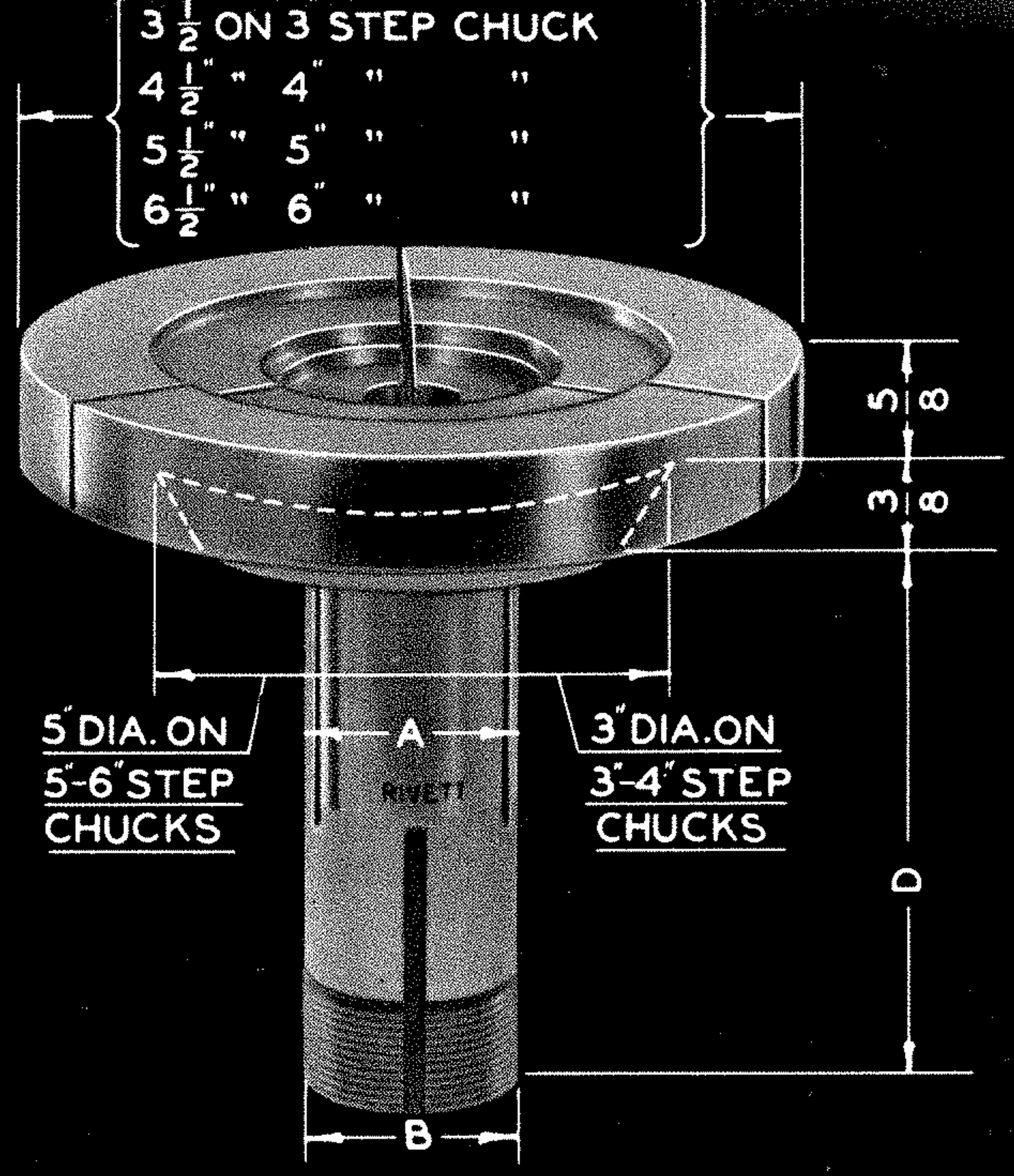


Fig. 3—3", 4", 5", 6" Step Chuck

INSTRUCTIONS FOR ORDERING

To determine "Mark" of Rivett collet or step chuck used on your machine, see table on page 3 or, if sample is available, check with dimensions listed below. If your collet or step chuck is not listed, forward sample or give all dimensions indicated by letters in Figs. 1, 2 or 3. On collets specify size of round, square

or hexagon hole—this should closely approximate work to be held. On step chucks specify if blank or stepped chuck is desired. If stepped, give number of steps and their diameters and depths. Round hole collets in sizes $\frac{1}{64}$ " to capacity by 64ths and blank step chucks are carried in stock for immediate delivery.

STYLE OF COLLET	RIVETT MARK	MAX. COLLET CAP.*	COLLET AND STEP CHUCK DIMENSIONS						
			ROUND	SQUARE	HEX.	"A" BODY	"B" THREAD	"C" LENGTH	"D" LENGTH
Atlas No. 3AT	3AT RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.687	.642—26NS-3	$2\frac{5}{16}$...
Becker No. 1	1B RIVETT	$\frac{5}{16}$	$\frac{7}{32}$	$\frac{17}{64}$.437	$\frac{5}{16}$ (Int.)—30NS-3	$1\frac{3}{4}$...
Becker No. 2	2B RIVETT	$\frac{7}{16}$	$\frac{5}{16}$	$\frac{3}{8}$.590	$\frac{7}{16}$ (Int.)—26NS-3	$2\frac{1}{32}$...
Becker No. 2A	2AB RIVETT	$\frac{9}{16}$	$\frac{25}{64}$	$\frac{31}{64}$.750	$\frac{1}{2}$ (Int.)—20NS-3	$2\frac{9}{16}$...
Becker No. 3	3B RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$.875	$\frac{5}{8}$ (Int.)—16NS-3	$3\frac{7}{16}$...
Cataract No. 3	3C RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.650	.642—26NS-3	$2\frac{11}{16}$	$2\frac{3}{4}$
Cataract No. 4	4C RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$.950	.939—20NS-3	3	$3\frac{1}{16}$
Cataract No. 5	5C RIVETT	1	$\frac{23}{32}$	$\frac{7}{8}$		1.250	1.239—20NS-3	$3\frac{3}{32}$	$3\frac{11}{32}$
Cataract No. 6	6C RIVETT	$1\frac{3}{8}$	$\frac{31}{32}$	$1\frac{3}{16}$		1.625	1.613—20NS-3	$4\frac{5}{16}$	$4\frac{3}{8}$
Hendey No. 2	2H RIVETT	$\frac{5}{8}$	$\frac{7}{16}$	$\frac{17}{32}$.826	.801—20NS-3	$4\frac{1}{4}$	$4\frac{5}{16}$
Hendey No. 3	3H RIVETT	$\frac{7}{8}$	$\frac{5}{8}$	$\frac{3}{4}$		1.125	1.051—20NS-3	$4\frac{1}{2}$	$4\frac{9}{16}$
Hendey No. 6	6H RIVETT	$1\frac{1}{8}$	$\frac{51}{64}$	$\frac{31}{32}$		1.375	1.302—20NS-3	$4\frac{3}{4}$	$4\frac{13}{16}$
Hendey No. 8	8H RIVETT	$1\frac{1}{4}$	$\frac{7}{8}$	$1\frac{1}{16}$		1.500	1.427—20NS-3	$4\frac{3}{4}$	$4\frac{13}{16}$
LeBlond No. 2	2L RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$.950	.939—20NS-3	3	$3\frac{1}{16}$
LeBlond No. 6	6L RIVETT	1	$\frac{11}{16}$	$\frac{7}{8}$		1.250	1.177—20NS-3	$4\frac{7}{16}$	$4\frac{1}{2}$
LeBlond No. 10	10L RIVETT	$1\frac{1}{4}$	$\frac{7}{8}$	$1\frac{1}{16}$		1.562	1.488—18NS-3	$5\frac{1}{2}$	$5\frac{9}{16}$
Rivett No. 3OS	3OS RIVETT	$\frac{3}{8}$	$\frac{17}{64}$	$\frac{21}{64}$.590	.517—26NS-3	$2\frac{3}{32}$	$2\frac{5}{32}$
Rivett No. 3NS	3NS RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.687	.650—20NS-3	$2\frac{7}{8}$	$2\frac{15}{16}$
Rivett No. 4OS	4OS RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.750	.659—20NS-3	$2\frac{25}{32}$	$2\frac{27}{32}$
Rivett No. 4NS	4NS RIVETT	$\frac{5}{8}$	$\frac{7}{16}$	$\frac{17}{32}$.826	.801—20NS-3	$3\frac{1}{2}$	$3\frac{9}{16}$
Rivett No. 5OS	5OS RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$		1.062	.938—18NS-3	$3\frac{13}{32}$	$3\frac{15}{32}$
Rivett No. 5NS	5NS RIVETT	$\frac{7}{8}$	$\frac{5}{8}$	$\frac{3}{4}$		1.062	1.050—20NS-3	$4\frac{7}{32}$	$4\frac{9}{32}$
Rivett No. 6NS	6NS RIVETT	1	$\frac{23}{32}$	$\frac{7}{8}$		1.312	1.234—14NS-3	$5\frac{29}{32}$	$5\frac{31}{32}$
Rivett No. 4R	4R RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$.998	.979—20NS-3	$3\frac{1}{4}$	$3\frac{5}{16}$
Rivett No. 5R	5R RIVETT	1	$\frac{23}{32}$	$\frac{7}{8}$		1.250	Push-Out Type	$3\frac{5}{16}$...
Rivett No. 6R	6R RIVETT	$1\frac{1}{8}$	$\frac{25}{32}$	$\frac{31}{32}$		1.375	1.302—20NS-3	$4\frac{15}{16}$	6
Rivett No. 7R	7R RIVETT	$\frac{7}{8}$	$\frac{5}{8}$	$\frac{3}{4}$		1.062	Stationary Type	$3\frac{1}{2}$...
Seneca No. 2	2S RIVETT	$\frac{17}{32}$	$\frac{3}{8}$	$\frac{31}{64}$.750	.750—18NS-3	$3\frac{15}{64}$	$3\frac{19}{64}$
Seneca No. 3	3S RIVETT	$\frac{3}{4}$	$\frac{17}{32}$	$\frac{21}{32}$		1.000	1.000—20NS-3	$4\frac{19}{32}$	$4\frac{21}{32}$
Sjogren No. 1	1J RIVETT	1	$\frac{23}{32}$	$\frac{7}{8}$		1.250	1.239—20NS-3	3	...
Sjogren No. 2	2J RIVETT	$1\frac{3}{8}$	$\frac{31}{32}$	$1\frac{3}{16}$		1.625	1.613—18NS-3	$3\frac{1}{4}$...
Sjogren No. 3	3J RIVETT	$1\frac{3}{4}$	$\frac{17}{32}$	$1\frac{1}{2}$		2.000	1.989—20NS-3	$3\frac{3}{4}$...
South Bend 9W	1A RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.650	.642—26NS-3	$2\frac{9}{16}$	$2\frac{5}{8}$
South Bend 9"	3SB RIVETT	$\frac{1}{2}$	$\frac{11}{32}$	$\frac{7}{16}$.650	.642—26NS-3	$2\frac{11}{16}$	$2\frac{3}{4}$
South Bend 10R & 13"	2A RIVETT	$1\frac{1}{16}$	$\frac{15}{32}$	$\frac{19}{32}$.860	.855—20NS-3	$3\frac{5}{16}$	$3\frac{3}{8}$

*STEP CHUCK CAPACITIES: Rivett step chucks are furnished in five sizes, measured by their maximum step capacities. Any size of step chuck may be purchased as a blank or with one or

more specified steps. The diameter of the largest step is controlled by the maximum capacity of the particular chuck; namely, 2", 3", 4", 5" or 6". The total depth of the step or steps cannot exceed $\frac{3}{8}$ ".

Spring Tempered

RIVETT COLLETS AND STEP CHUCKS USED ON STANDARD MACHINE TOOLS

MAKE OF MACHINE	RIVETT COLLET USED
American 12", 14" and 16" Lathes	3H Rivett
American 18", 20", 22" and 24" Lathes	6H Rivett
American 14" and 16" Pacemaker Lathes	2J Rivett
American 18", 20" and 22" Pacemaker Lathes	3J Rivett
Atlas 9" and 10" Lathes	3AT Rivett
Becker No. 1 Vertical Miller	1B Rivett
Becker No. 2 Vertical Miller	2B Rivett
Becker No. 2A Vertical Miller	2AB Rivett
Becker No. 3 Vertical Miller	3B Rivett
Blount 11" Lathe	4NS Rivett
Boye & Emmes 14" and 16" Lathes	6H Rivett
Boye & Emmes 18", 20" and 22" Lathes	6H or 8H Rivett
Boye & Emmes 24" and 27" Lathes	6C Rivett
Bradford 14" Geared Head Lathe	5NS Rivett
Bradford 16" Cone or Geared Head Lathe	5NS Rivett
Bradford 18" and 20" Heavy Duty Lathe	6NS Rivett
Burke No. 0, 1, 2, 3, 4 and 5 Milling Machines	3C Rivett
Carroll & Jamieson 13", 14", 15" and 16" Lathes	3H Rivett
Chard 16", 18" and 20" Lathes	6H Rivett
Chard 24" and 28" Lathes	8H Rivett
Cincinnati 14" and 16" Lathes	3H Rivett
Cincinnati 18" and 20" Lathes	6H Rivett
Cincinnati 22" and 24" Lathes	6H or 8H Rivett
Cisco 14" Lathe	3H Rivett
Cisco 16", 18" and 20" Lathes	8H Rivett
Dalton B-4 Lathe	3C Rivett
Dalton B-6 Lathe	3C or 4C Rivett
Davis 12" and 14" Lathes	2H Rivett
Davis 16" Lathe	3H Rivett
Davis 18" and 20" Lathes	6H Rivett
Elgin 3/4" Capacity Lathe	4C Rivett
Elgin 1" Capacity Lathe	5C Rivett
Fay & Scott 14", 16", 18" and 20" Lathes	5NS Rivett
Fitchburg Bowgauge Chucking Grinder	5NS Rivett
Flather FMC 7" Lathe	3C Rivett
Flather 13" Lathe	40S Rivett
Flather 14" and 16" Cone Head Lathes	4NS Rivett
Flather 18" and 20" Cone Head Lathes	5NS Rivett
Flather 14", 16" and 20" Geared Head Lathes	5NS Rivett
Greeves-Klusman 16" and 18" Lathes	3H Rivett
Gorton No. 265 and No. 375 Cutter Grinders	4NS Rivett
Hamilton 14", 16" and 18" Lathes	5C Rivett
Hardinge No. 37 Lathe	3C Rivett
Hardinge No. 47 or 49 Lathe	4C Rivett
Hardinge No. 57 or 59 Lathe	5C Rivett
Hardinge No. 3 Miller	3C Rivett
Hardinge No. 4 Miller	4C Rivett
Hardinge TM or UM Miller	5C Rivett
Hardinge No. 3 Open Vertical Bench Miller	3C Rivett
Hardinge 9" Back-Geared Tool Room Lathe	5C Rivett
Hendey 12" Cone Lathe	2H Rivett
Hendey 12" Geared Lathe	2H or 3H Rivett
Hendey 14" Cone or Geared Lathes	2H or 3H Rivett
Hendey 16" Cone or Geared Lathes	3H or 6H Rivett
Hendey 18", 20" and 24" Cone or Geared Lathes	6H or 8H Rivett
Hendey Centering Machine	2H Rivett
LeBlond (Regal) 10" Lathe	3C Rivett
LeBlond (Regal) 12" and 14" Lathes	4NS Rivett
LeBlond (Regal) 13" and 15" Lathes	2L Rivett
LeBlond (Regal) 16", 17", 18" and 19" Lathes	6L Rivett
LeBlond (Regal) 21" and 24" Lathes	10L Rivett
LeBlond 12", 14", 16" and 17" Lathes	2L Rivett
LeBlond No. 3-14", 16", 17" and 18" Lathes	3H Rivett
LeBlond No. 6-16", 17", 18" and 19"	6L Rivett
LeBlond (Heavy Duty) 12" and 14" Lathes	6L Rivett
LeBlond (Heavy Duty) 16", 18", 20" and 22" Lathes	10L Rivett
LeBlond (Rapid Production) 11" and 13" Lathes	6L Rivett
LeBlond (Rapid Production) 16", 17" and 20" Lathes	10L Rivett
LeBlond (Multi-Cut) No. 6 Lathe	6L Rivett
LeBlond (Multi-Cut) No. 9 Lathe	10L Rivett
Lehmann 16" and 18" Lathes	5NS Rivett
Logan 10" and 10 1/2" Lathes	3AT Rivett
Lipe 9" Production Lathe	2H Rivett
Lipe 12" Carbo-Lathe	5C Rivett
Lipe 15" x 30" Carbomatic Lathe	5C Rivett
Monarch 9", 10", 11" and 12" O. S. Lathes	2H Rivett
Monarch 14" and 16" O. S. Lathes	5C Rivett
Monarch 10" Lathe	5C or 2J Rivett
Monarch 12" Lathe	3H Rivett
Monarch 14", 16", 18" and 20" Lathes	6H Rivett
Porter-Cable 9" Production Lathe	2H Rivett
Porter-Cable 12" Carbo-Lathe	5C Rivett

MAKE OF MACHINE	RIVETT COLLET USED
Porter-Cable (Mulliner) 12" and 14" Lathes	2H Rivett
Potter No. 3 Bench Lathe	3C Rivett
Potter No. 4 Bench Lathe	4C Rivett
Rahn-Larmon 16" and 18" Lathes Series "LN"	3H or 8H Rivett
Rahn-Larmon 18" and 20" Lathes Series "AA"	8H Rivett
Rahn-Larmon 20" and 24" Lathes Series "B" and "D"	8H Rivett
Reed-Prentice 18" and 20" Lathes	6L Rivett
Rivett No. 505-3NS Lathe	3NS Rivett
Rivett No. 505-4NS Lathe	4NS Rivett
Rivett No. 505-4R Lathe	4R Rivett
Rivett No. 505-5NS Lathe	5NS Rivett
Rivett No. 505-5C Lathe	5C Rivett
Rivett No. 505-6H Lathe	6H Rivett
Rivett No. 507 Lathe	4R Rivett
Rivett No. 715 Lathe	4C Rivett
Rivett No. 918 Lathe, Draw-in collet	5C Rivett
Rivett No. 918 Lathe, Push-out collet	5R Rivett
Rivett No. 918-S Lathe, Draw-in collet	6R Rivett
Rivett No. 918-S Turret Lathe, Stationary Collet	7R Rivett
Rivett No. 608-4NS Lathe	4NS Rivett
Rivett No. 608-5C Lathe	5C Rivett
Rivett No. 1020 Lathe	6R Rivett
Rivett No. 103 Grinder	4NS Rivett
Rivett No. 104 Grinder	5NS Rivett
Rivett No. 6 Grinder	5NS Rivett
Rivett No. 106 Grinder	6NS Rivett
Rivett No. 112 Grinder	6NS Rivett
Rivett No. 1024 Grinder	6R Rivett
Rockford (Sunstrand) 9", 15" and 16" Lathes	3H Rivett
Rockford (Economy) 12" Lathe	2H Rivett
Rockford (Economy) 14" and 16" Lathes	3H Rivett
Rockford (Economy) 22" Lathe	8H Rivett
Schauer 1" Capacity Speed Lathe	5C Rivett
Schaffner 11" Lathe (Model "A")	2H Rivett
Sebastian 11" Lathe (Old Model)	2S Rivett
Sebastian (Type "H") 12" to 16" Lathes	5C Rivett
Sebastian (Viking) 12", 14", 16" and 18" Lathes	3H Rivett
Sebastian (Viking) 20" Lathe	6H Rivett
Sebastian (Gold Seal) 12", 14", 16" and 18" Lathes	3A Rivett
Sebastian (Gold Seal) 18" and 20" Lathes	6H Rivett
Seneca or Star 9", 10" and 12" Lathes	2S Rivett
Seneca or Star 14" Lathe	3S Rivett
Sheldon 3/4" Collet Capacity Lathe	4C Rivett
Sheldon 1" Collet Capacity Lathe	5C Rivett
Shephard Lathe	2H, 3H or 4NS Rivett
Sidney Standard Pattern Lathes	
12" Cone or Geared	2H Rivett
14" and 16" Cone or Geared	3H Rivett
18" and 20"	6H Rivett
Sidney Monotrol and Tritrol Lathes	
12", 14", 16" and 18"	6H Rivett
18" and 20" (Heavy Pattern)	8H Rivett
Sjogren Collet Chuck for Engine Lathes	
1" Capacity	1J Rivett
1 3/8" Capacity	2J Rivett
1 3/4" Capacity	3J Rivett
South Bend Lathes — Current Series	
9W	1A Rivett
10R and 13"	2A Rivett
14 1/2"	4C Rivett
10L and 16"	5C Rivett
South Bend Lathes — Prior Series	
9"	3SB Rivett
11"	2S Rivett
13"	4NS Rivett
15"	4C Rivett
16"	5NS Rivett
18"	5C Rivett
24"	6C Rivett
Springfield 14" and 16" Lathes	3H or 6H Rivett
Springfield 18" and 20" Lathes	6H Rivett
Springfield 24" and 26" Lathes	8H Rivett
Stark No. 4 Lathe	4R Rivett
Stark Miller	4R Rivett
Walcott 14" Lathe	2H Rivett
Walcott 16", 18" and 20" Lathes	6H Rivett
Whitcomb Blaisdell 14" Lathe	4C Rivett
Whitcomb Blaisdell 16" and 18" Lathes	3H Rivett
Whitcomb Blaisdell 20" Lathe	6H Rivett
Willard 13" Lathe	3H Rivett
Worcester 12" Lathe	2H Rivett
Worcester 14" Lathe	3H Rivett

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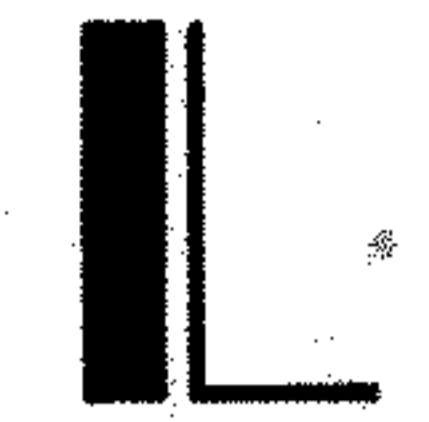
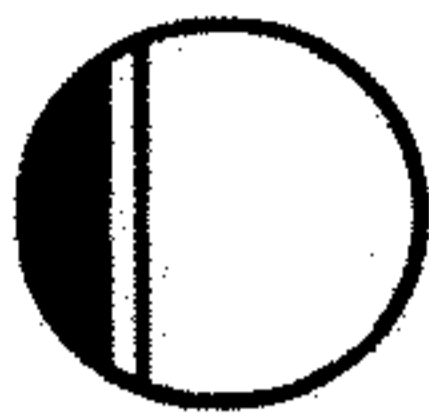
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Spring Tempered



"RIVETT MARK" COLLETS AND CHUCKS

Over fifty-five years ago, Rivett undertook the manufacture of collets and step chucks. As pioneers in the development and manufacture of America-made bench lathes, it was soon learned that precision depended not only on the design and workmanship of the machine, but equally on the method of mounting and holding the work. The self-centering collet and step chuck so successfully introduced on the watchmakers lathe were adopted by Rivett.

Today, "Rivett Mark" collets and step chucks are known throughout the machine tool world where the ultimate in precision is required. While establishing an enviable reputation for quality, service has not been neglected. Many hundreds of manufacturers order their new and replacement collets for immediate shipment from stock.

COLLETS

Rivett collets are identified by the Rivett name, style and size stamped on the nose of each. Made from selected alloy steel and scientifically heat-treated, "Rivett Mark" collets retain their spring forever. Every operation in manufacture from rough turning through thread milling and grinding is checked against master gauges. As a result, the hole of every collet is guaranteed to run dead true at its mouth.

Standard Collets have clearance through body and are furnished with round holes from $1/64$ " , square holes from $1/8$ " or hexagon holes from $1/8$ " to maximum capacities as tabulated on page 2. Oversize round hole collets may be specified up to $1/16$ " above these maximum capacities by $1\frac{1}{4}$ " deep but do not have clearance through body.

Taper Collets are furnished hardened and unsplit in hole sizes limited by their head and body diameters.

Step Collets used for holding pieces of greater diameter than capacity of standard collet or where a shoulder is required for locating work are made to specification. Diameter and depth of step are limited by diameter and taper of collet head.

STEP CHUCKS

Rivett step chucks are made from steel forgings and are machined at every operation to master gauges for "Rivett Mark" accuracy. Step chucks operate on the same principle of radial compression as draw-in collets for quick and accurate chucking of circular or irregular parts requiring only a short grip. Step chucks are furnished soft and split with $9/16$ " hole through body. They may be ordered blank or with one or more bored, milled or threaded steps up to maximum capacity of chuck and $3/8$ " aggregate depth.

1" Step Chucks are furnished only in those styles which have less than 1" maximum collet capacity. Being hardened, spring tempered and ground, they differ from standard step chucks. Maximum capacity of step is 1" diameter $3/4$ " deep.

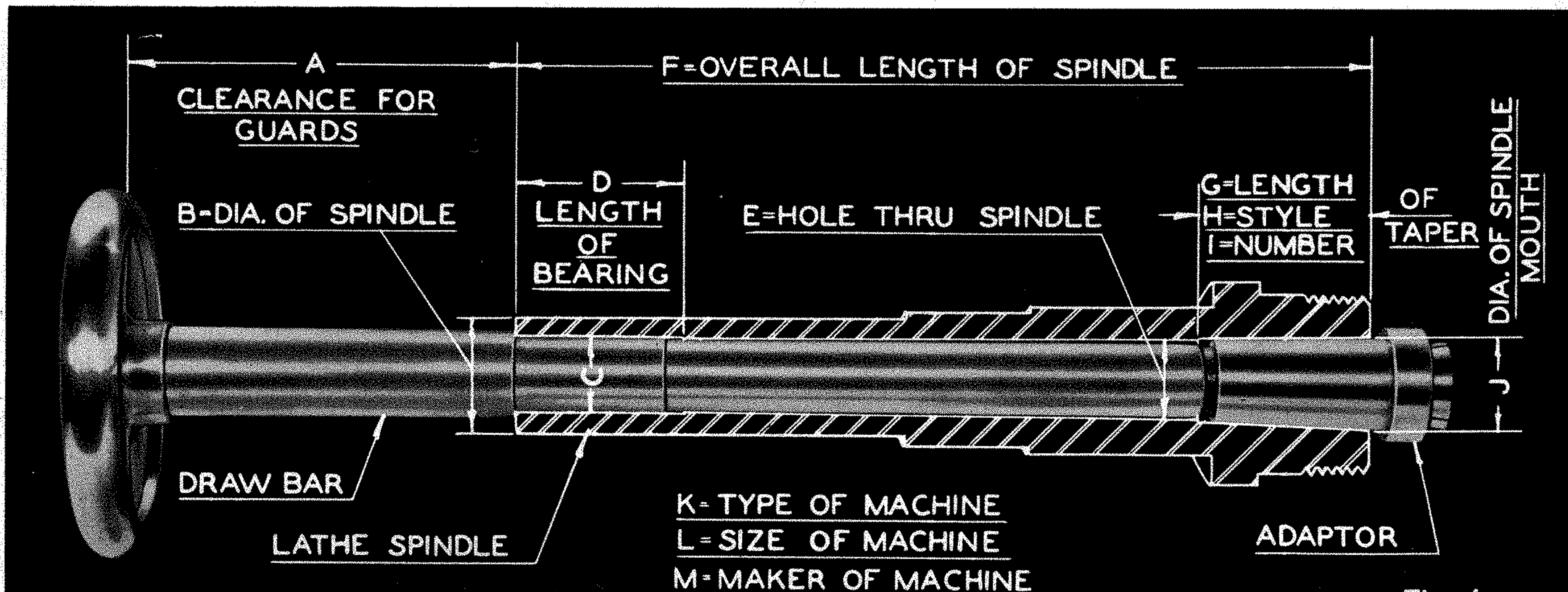
2" Step Chucks are closed by the taper of spindle mouth, Fig. 2, and may be stepped up to 2" diameter.

3", 4", 5" and 6" Step Chucks are closed by closing ring which mounts on spindle nose and presents a tapered seat into which the chuck is drawn. The closing force is exerted on the outer area of the chuck. The diameter of the closing taper is 3" on the 3" and 4" sizes and 5" on the 5" and 6" sizes, see Fig. 3. Each of these chucks may be stepped up to its named diameter.

DRAW-BAR AND ADAPTOR FOR RIVETT COLLETS

Lathes, milling machines and other tools can readily be equipped to use draw-in collets and step chucks. A collet adaptor and draw-bar with handwheel are the only additional parts needed. This convenient method of chucking reduces time and increases precision on tool-room and production work. Hardened and ground adaptor fits taper in mouth of machine spindle and has hole and tapered seat for draw-in collet and step chuck. The draw-bar engages collet thread through spindle. Send measurements and information per letters indicated in Fig. 4, and we will submit price on adaptor, draw-bar and recommended style of "Rivett Mark" collet or step chuck. Unless otherwise specified, we will offer style of collet having largest possible hole capacity.

7-47 Printed in U.S.A.





RIVETT DRAW-IN COLLETS

SEE RIVETT BULLETIN 100-C

RIVETT LATHE & GRINDER INC.

BRIGHTON, BOSTON, MASS., U.S.A.

Supersedes Pages Dated May 1, 1937

Prices include packing for domestic shipment.

STYLE OF COLLET	RIVETT MARK	Round Fractional Holes 1/16" to Standard max. dia.	Round Fractional Holes, Undersize less than 1/16" dia. and oversize up to 1/16" over Standard max. dia.	Decimal Wire Gage Metric and Odd Sizes 1/16" to Standard max. dia.	Decimal Wire Gage Metric and Odd Sizes less than 1/16" dia. and oversize up to 1/16" over Standard max. dia.	Square and Hexagon Holes 1/8" to Capacity	Blanks, Soft	Standard Taper Holes Unsplit Hardened and Ground	Round Step or Pot Split Hardened and Ground
		Price Each	Price Each	Price Each	Price Each	Price Each	Price Each	Price Each	Price Each
Column 1	Column 2	Column 3	Column 4	Column 5	Column 6	Column 7	Column 8	Column 9	Column 10
Atlas No. 3AT	3AT RIVETT	\$4.25	\$4.75	\$4.50	\$5.00	\$7.25	\$3.50	\$9.25	\$5.25
Becker No. 1	1B RIVETT	3.50	4.00	3.75	4.25	6.50	2.75	8.50	4.50
Becker No. 2	2B RIVETT	4.00	4.50	4.25	4.75	7.00	3.25	9.00	5.00
Becker No. 2A	2AB RIVETT	4.50	5.00	4.75	5.25	7.50	3.75	9.50	5.50
Becker No. 3	3B RIVETT	5.25	5.75	5.50	6.00	8.25	4.50	10.25	6.25
Cataract No. 3	3C RIVETT	3.75	4.25	4.00	4.50	6.75	3.00	8.75	4.75
Cataract No. 4	4C RIVETT	4.25	4.75	4.50	5.00	7.25	3.50	9.25	5.25
Cataract No. 5	5C RIVETT	4.75	5.25	5.00	5.50	7.75	4.00	9.75	5.75
Cataract No. 6	6C RIVETT	9.50	10.00	9.75	10.25	12.50	8.75	14.50	10.50
Hendey No. 2	2H RIVETT	5.25	5.75	5.50	6.00	8.25	4.50	10.25	6.25
Hendey No. 3	3H RIVETT	6.25	6.75	6.50	7.00	9.25	5.50	11.25	7.25
Hendey No. 6	6H RIVETT	7.50	8.00	7.75	8.25	10.50	6.75	12.50	8.50
Hendey No. 8	8H RIVETT	9.25	9.75	9.50	10.00	12.25	8.50	14.25	10.25
LeBlond No. 2	2L RIVETT	4.75	5.25	5.00	5.50	7.75	4.00	9.75	5.75
LeBlond No. 6	6L RIVETT	8.00	8.50	8.25	8.75	11.00	7.25	13.00	9.00
LeBlond No. 10	10L RIVETT	10.50	11.00	10.75	11.25	13.50	9.75	15.50	11.50
Rivett No. 3NS	3NS RIVETT	4.25	4.75	4.50	5.00	7.25	3.50	9.25	5.25
Rivett No. 4OS	4OS RIVETT	4.25	4.75	4.50	5.00	7.25	3.50	9.25	5.25
Rivett No. 4NS	4NS RIVETT	4.50	5.00	4.75	5.25	7.50	3.75	9.50	5.50
Rivett No. 5NS	5NS RIVETT	5.50	6.00	5.75	6.25	8.50	4.75	10.50	6.50
Rivett No. 6NS	6NS RIVETT	9.25	9.75	9.50	10.00	12.25	8.50	14.25	10.25
Rivett No. 4R	4R RIVETT	4.75	5.25	5.00	5.50	7.75	4.00	9.75	5.75
Rivett No. 5R	5R RIVETT	7.50	8.00	7.75	8.25	10.50	6.75	12.50	8.50
Rivett No. 6R	6R RIVETT	6.50	7.00	6.75	7.25	9.50	5.25	11.50	7.50
Rivett No. 7R	7R RIVETT	7.50	8.00	7.75	8.25	10.50	6.25	12.50	8.50
Seneca No. 2	2S RIVETT	4.25	4.75	4.50	5.00	7.25	3.50	9.25	5.25
Seneca No. 3	3S RIVETT	4.75	5.25	5.00	5.50	7.75	4.00	9.75	5.75
Sjogren No. 1	1J RIVETT	5.00	5.50	5.25	5.75	8.00	4.25	10.00	6.00
Sjogren No. 2	2J RIVETT	8.00	8.50	8.25	8.75	11.00	7.25	13.00	9.00
Sjogren No. 3	3J RIVETT	10.00	10.50	10.25	10.75	13.00	9.25	15.00	11.00
South Bend 9W	1A RIVETT	3.75	4.25	4.00	4.50	6.75	3.00	8.75	4.75
South Bend 9"	3SB RIVETT	3.75	4.25	4.00	4.50	6.75	3.00	8.75	4.75
South Bend 10R & 13"	2A RIVETT	4.00	4.50	4.25	4.75	7.00	3.25	9.00	5.00



RIVETT STEP CHUCKS

SEE RIVETT BULLETIN 100-C

RIVETT LATHE & GRINDER INC.

BRIGHTON, BOSTON, MASS., U.S.A.

Supersedes Pages Dated May 1, 1937

Prices include packing for domestic shipment

		STEP CHUCKS FORGED STEEL SPLIT BLANKS					One-Inch Step Chuck Hole not over 1" Diameter x 3/4" Deep, Split, Spring Tempered and Ground
Style of Collet		2" Capacity Price Each	3" Capacity Price Each	4" Capacity Price Each	5" Capacity Price Each	6" Capacity Price Each	Price Each
Column 1		Column 2	Column 3	Column 4	Column 5	Column 6	Column 7
3C RIVETT		\$9.00	\$10.75	\$12.75			\$9.25
4C RIVETT		10.50	12.25	14.00	\$15.75		10.50
5C RIVETT		11.50	13.50	15.25	16.75	\$19.00	
2H RIVETT		10.50	12.25	14.00			10.50
3H RIVETT		11.00	12.75	14.50	16.25	18.75	11.00
6H RIVETT		12.25	14.00	15.75	17.00	19.75	
3NS RIVETT		8.50	10.50	13.50			9.25
4NS RIVETT		9.25	11.50	14.00			10.50
5NS RIVETT		11.00	12.75	14.50	16.25	18.75	11.00
6NS RIVETT		12.75	15.25	17.50	19.75	22.25	
6R RIVETT		12.00	14.00	15.75	17.25	19.50	
2S RIVETT		9.25	11.50	13.50			10.25
1A RIVETT		9.00	10.75	12.75			9.25
3SB RIVETT		9.00	10.75	12.75			9.25
2A RIVETT		10.50	12.25	14.00	15.75		10.50

Step chucks, stepped: to above prices add for steps bored to customers' specifications (aggregate of steps not to exceed four, each 3/32" deep or equivalent, smallest step not less than 5/8" dia.,

largest step not exceeding capacity of blank), one step \$3.00, two steps \$5.00, three steps \$6.50, four steps \$7.50.

DRAW-BAR AND ADAPTOR FOR RIVETT COLLETS

Lathes, milling machines and other tools can readily be equipped to use draw-in collets and step chucks. A collet adaptor and draw-bar with handwheel are the only additional parts needed. This convenient method of chucking reduces time and increases precision on tool-room and production work. Hardened and ground adaptor fits taper in mouth of machine spindle and has hole and tapered

seat for draw-in collet and step chuck. The draw-bar engages collet thread through spindle. Send measurements and information per letters indicated in Fig. 4, Bulletin 100-C, and we will submit price on adaptor, draw-bar and recommended style of "Rivett Mark" collet or step chuck. Unless otherwise specified, we will offer style of collet having largest possible hole capacity.