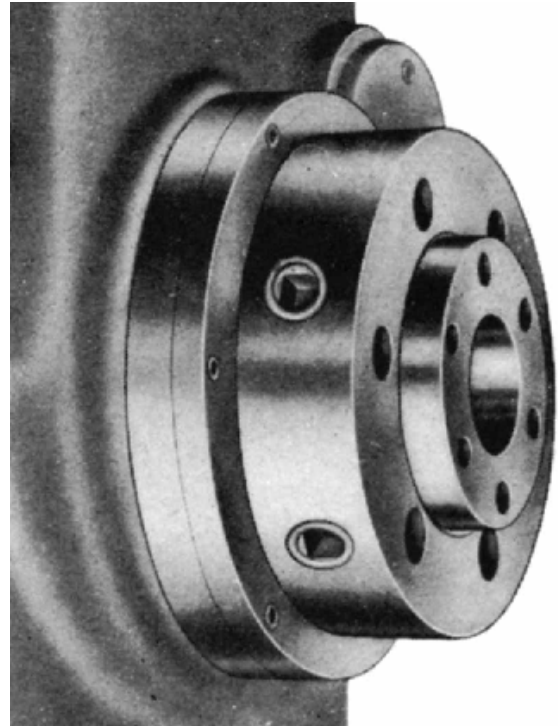
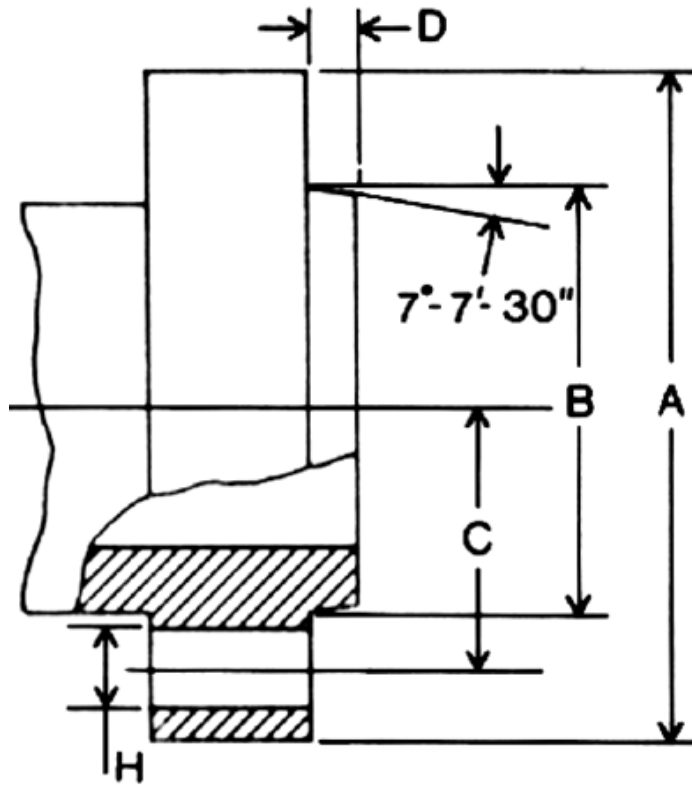


### American Short Taper with Cam-lock Fitting Type D1

A replacement for the original American long-nose taper and widely used on many different sizes of lathe. The different sizes are referred to as D1-3", D1-4", D1-5", etc. although some publications and parts lists have the figures reversed as in 3"-D1 or simply list them, as in the chart below, as 3" (3-inch), 4" (4-inch) etc.

The spindle nose is provided with a short tapered flange of the same dimensions as the American A-1 Type but has in its face either 3 or 6 holes (for light and heavy-duty use respectively) into which the mounting studs on the back of a chuck or backplate can fit. Each stud is cut away in a semi-circle half-way along its length and an eccentric cross pin, turned by a standard chuck key, causes these to be drawn inwards until the pin goes over-centre and locks. The pins, being screwed into the back of the chuck, can be turned until the locking action is positive.



American Short Taper  
with Cam-lock Fitting Type  
D1

| SPINDLE NOSE SIZE   |   |     | 3"     | 4"     | 5"     | 6"      | 8"      | 11"     | 15"     |
|---------------------|---|-----|--------|--------|--------|---------|---------|---------|---------|
| Outside diameter    | A | in. | 3.625  | 4.625  | 5.750  | 7.125   | 8.875   | 11.750  | 15.875  |
|                     |   | mm. | 92.08  | 117.48 | 146.05 | 180.98  | 225.43  | 298.45  | 403.23  |
| Max. taper diameter | B | in. | 2.1250 | 2.5005 | 3.2505 | 4.1880  | 5.50075 | 7.75075 | 11.2510 |
|                     |   | mm. | 53.975 | 63.513 | 82.563 | 106.375 | 139.719 | 196.869 | 285.775 |
| P.C.R. stud holes   | C | in. | 1.391  | 1.625  | 2.063  | 2.625   | 3.375   | 4.625   | 6.500   |
|                     |   | mm. | 35.32  | 41.28  | 52.39  | 66.68   | 85.73   | 117.48  | 165.10  |
| Spigot height       | D | in. | .44    | .44    | .50    | .56     | .63     | .69     | .75     |
|                     |   | mm. | 11.1   | 11.1   | 12.7   | 14.3    | 15.9    | 17.5    | 19.1    |
| Stud hole diameter  | H | in. | .5937  | .6562  | .78125 | .90625  | 1.03125 | 1.21875 | 1.40625 |
|                     |   | mm. | 15.081 | 16.669 | 19.844 | 23.019  | 26.194  | 30.956  | 35.719  |