



US005984321A

# United States Patent [19] Gruttadauria

[11] Patent Number: **5,984,321**

[45] Date of Patent: **Nov. 16, 1999**

[54] UNIVERSAL QUICK JAWS

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[21] Appl. No.: **09/157,912**

[22] Filed: **Sep. 21, 1998**

[51] Int. Cl.<sup>6</sup> ..... **B23B 31/16**

[52] U.S. Cl. .... **279/123; 279/153**

[58] Field of Search ..... 279/123, 152, 279/153

[56] **References Cited**

**U.S. PATENT DOCUMENTS**

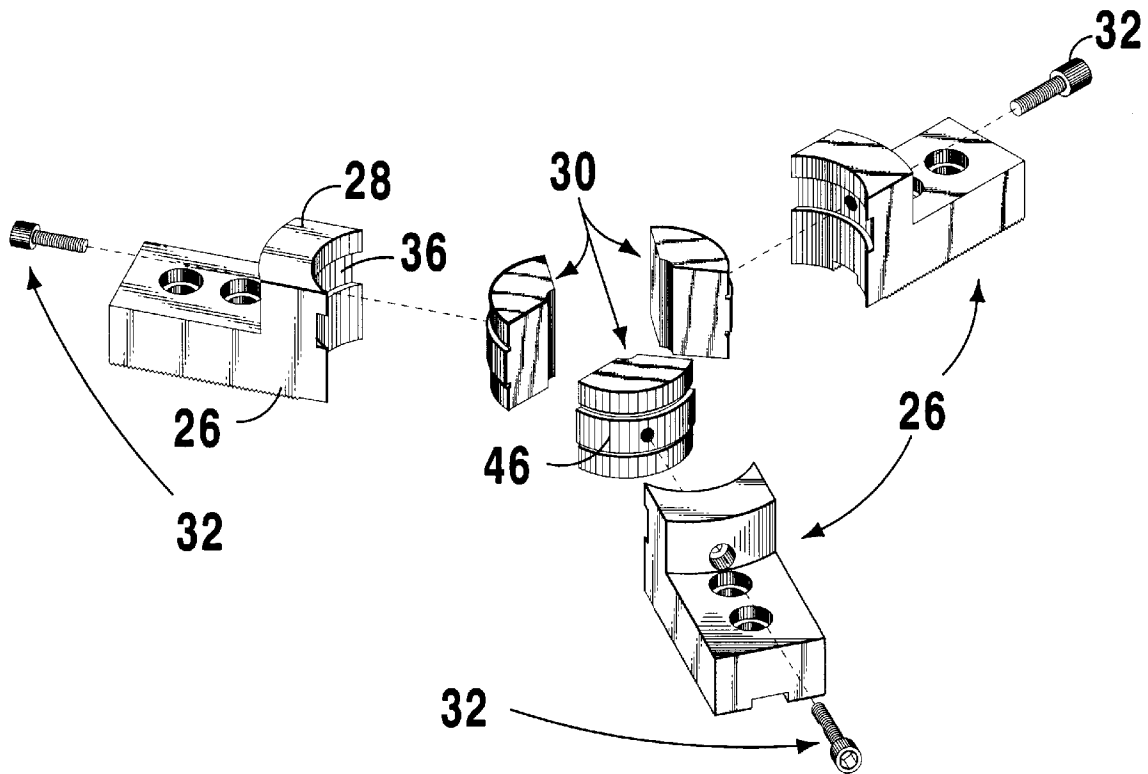
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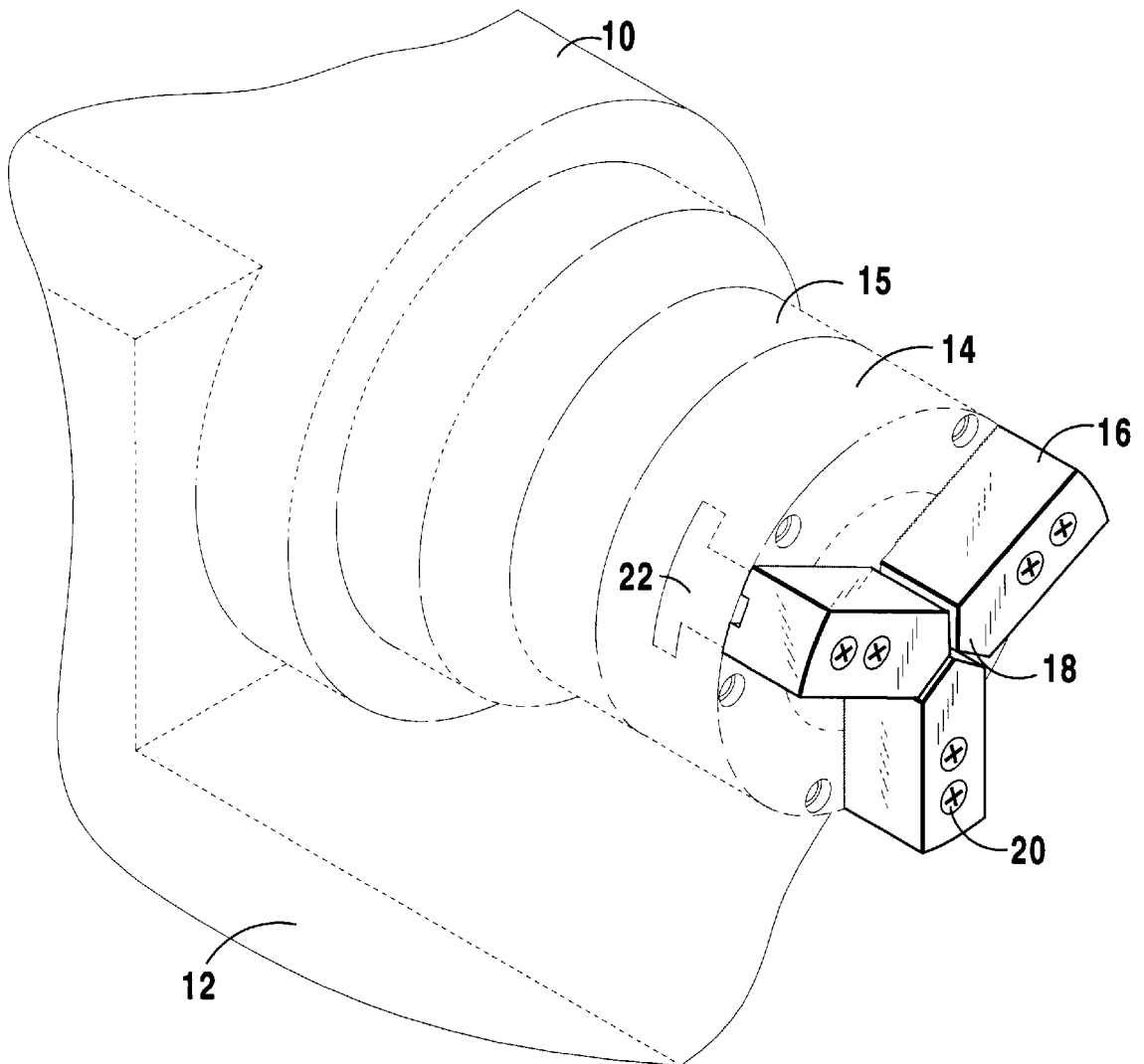
*Primary Examiner*—Steven C. Bishop  
*Attorney, Agent, or Firm*—Michael I. Kroll

[57] **ABSTRACT**

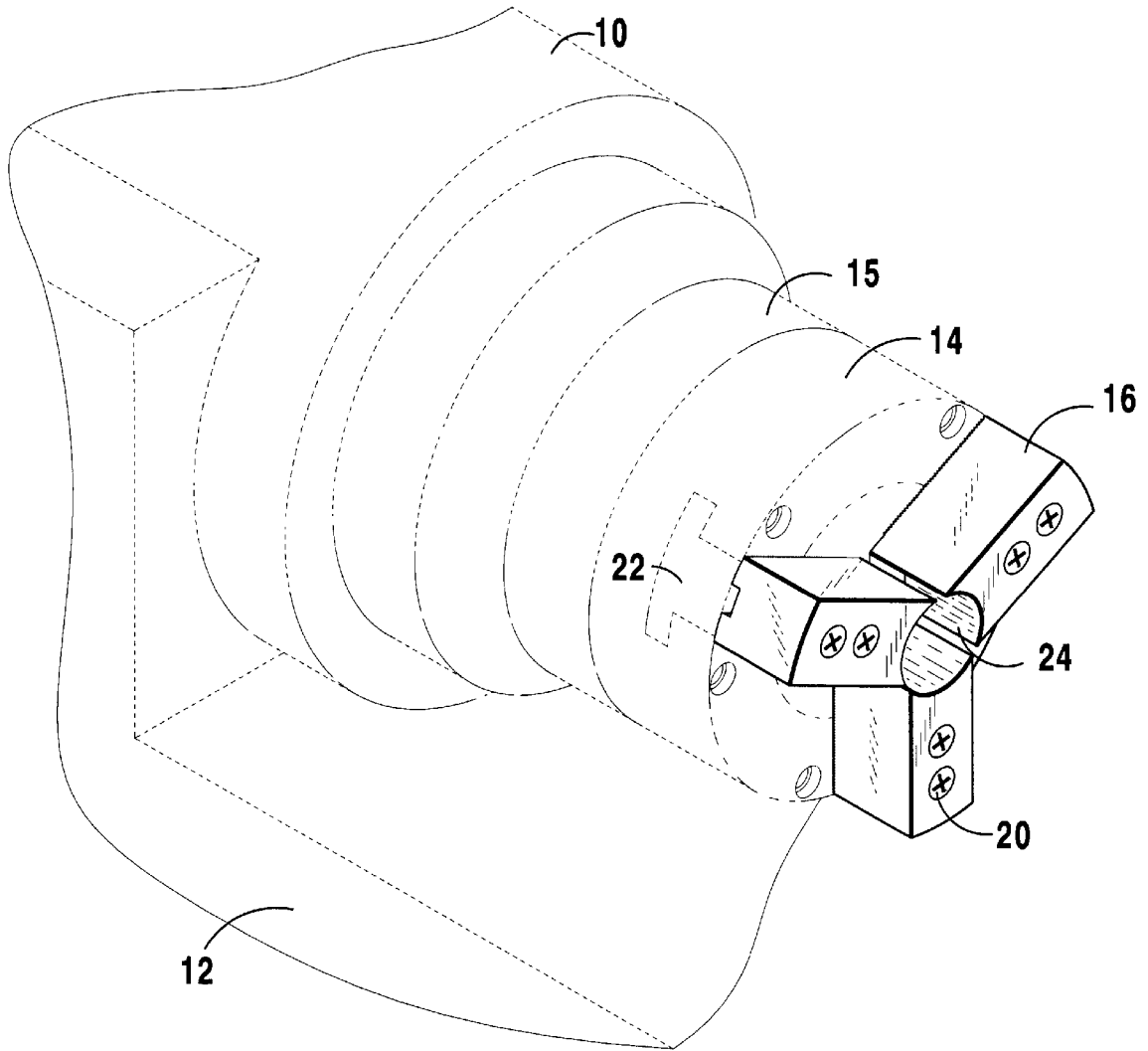
The present invention discloses a set of multiple universal adjustable soft jaws **26** for holding workpieces for being mounted onto a lathe chuck body **14** for mounting onto the spindle **15** of a lathe **10**. The multiple jaws **26** are mounted onto the face of the chuck body **14** in the standard manner. The jaws **26** are further equipped on their inner end with an offset flange foot **28** for having mounted thereon custom sized jaw pads **30** which are attached to the offset flange foot **28** with quick connect/disconnect screws **32** which allow the custom sized jaw pads **30** to be quickly and easily removed from the universal set of jaws **26**. These custom sized jaws **30** are useful for accommodating workpieces of particular sizes and shapes depending on the specific job application.

**1 Claim, 9 Drawing Sheets**

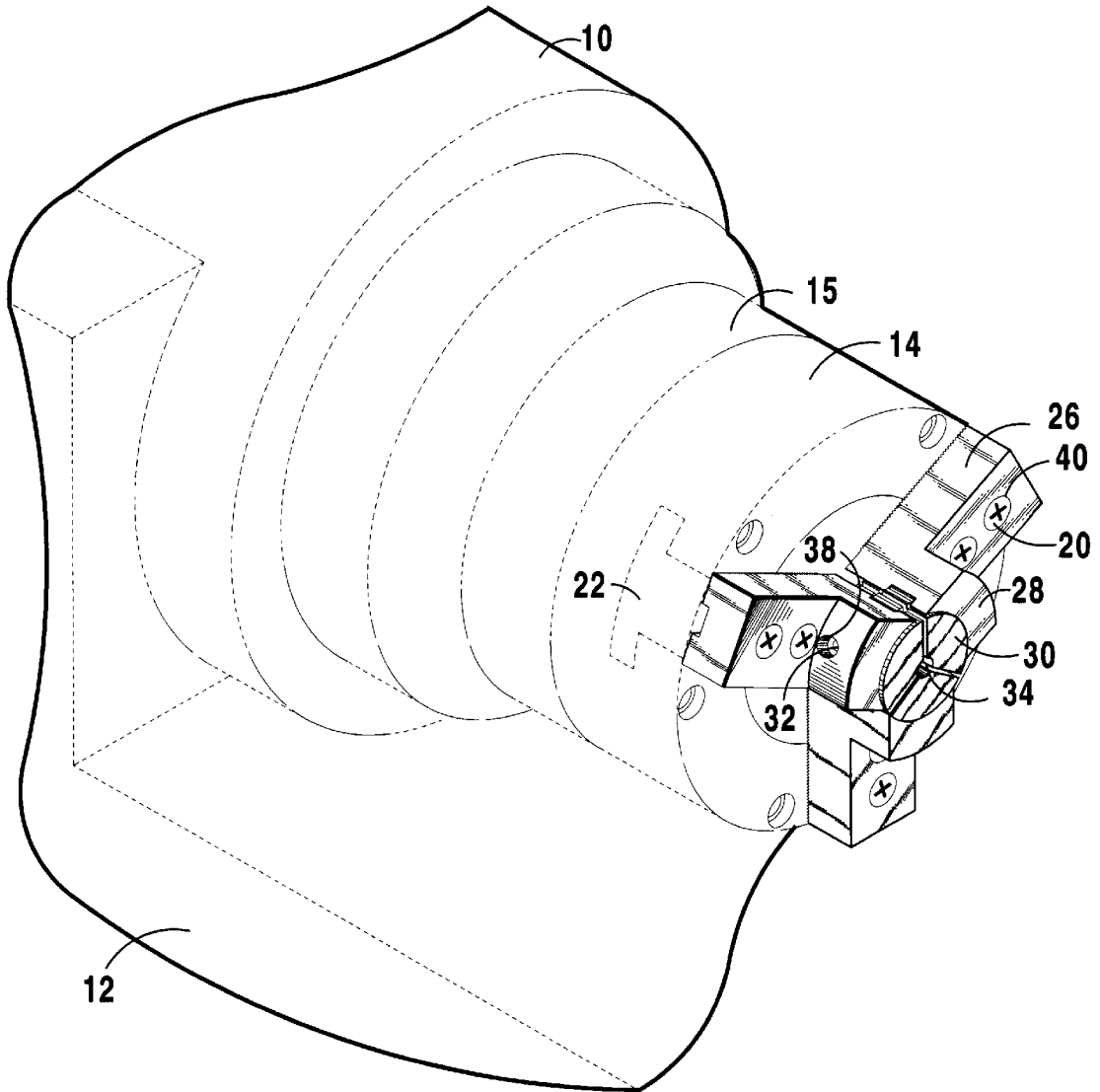




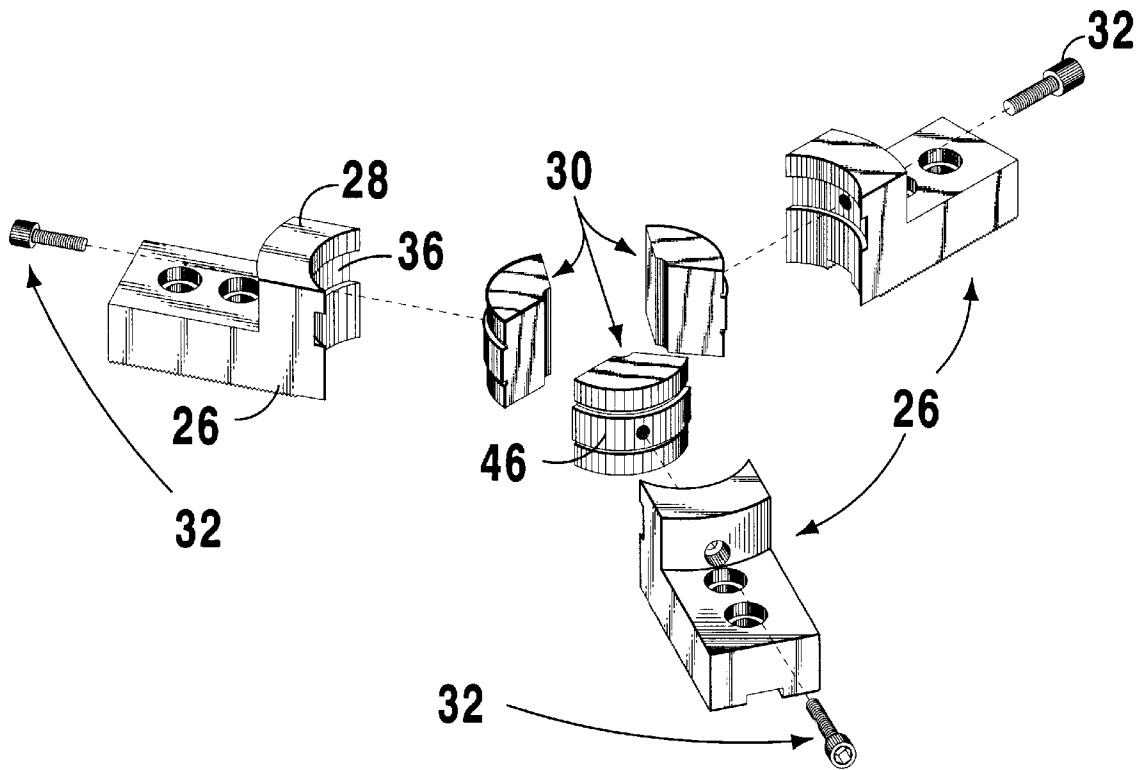
**FIG 1**  
( PRIOR ART )



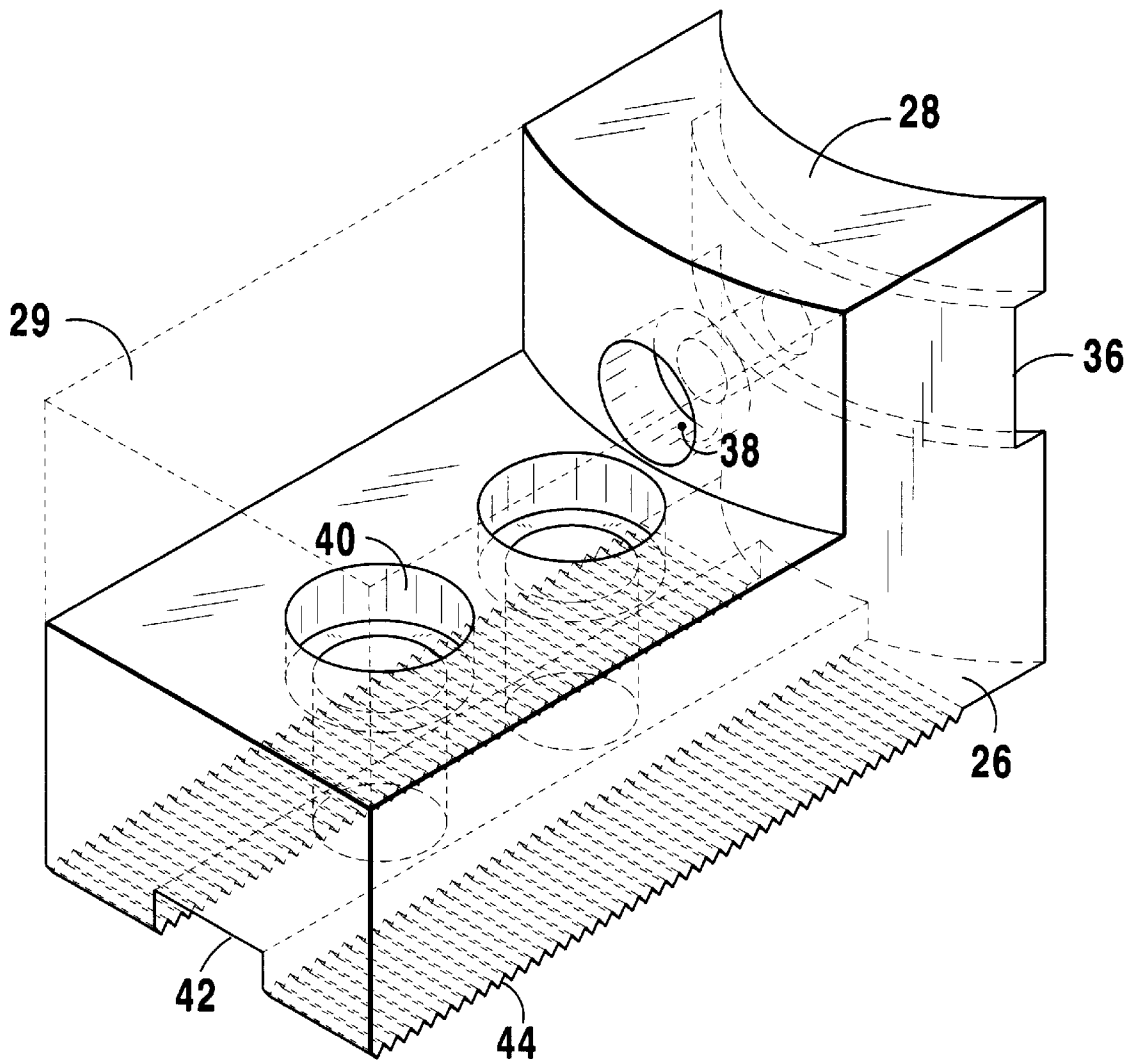
**FIG 1A**  
( PRIOR ART )



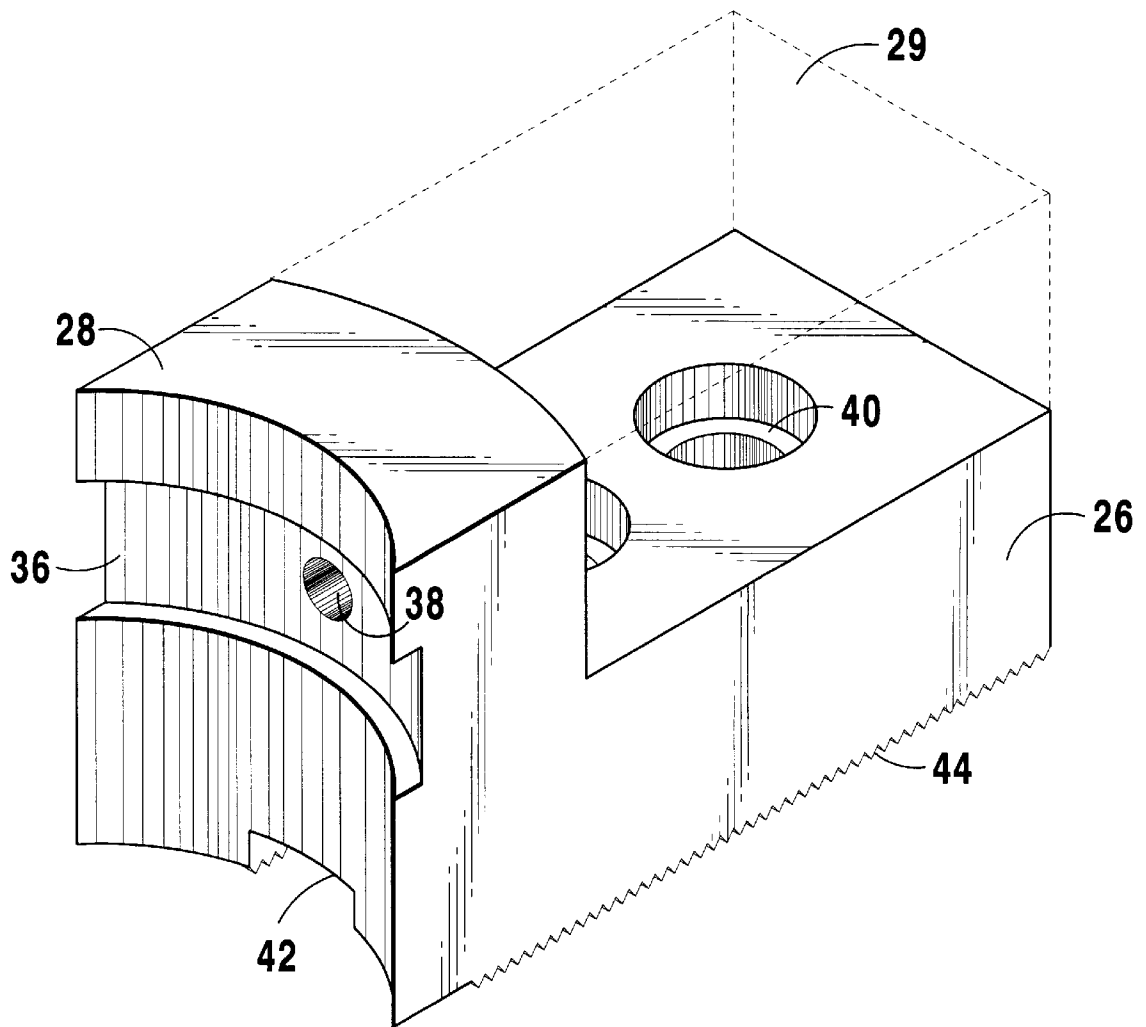
**FIG 2**



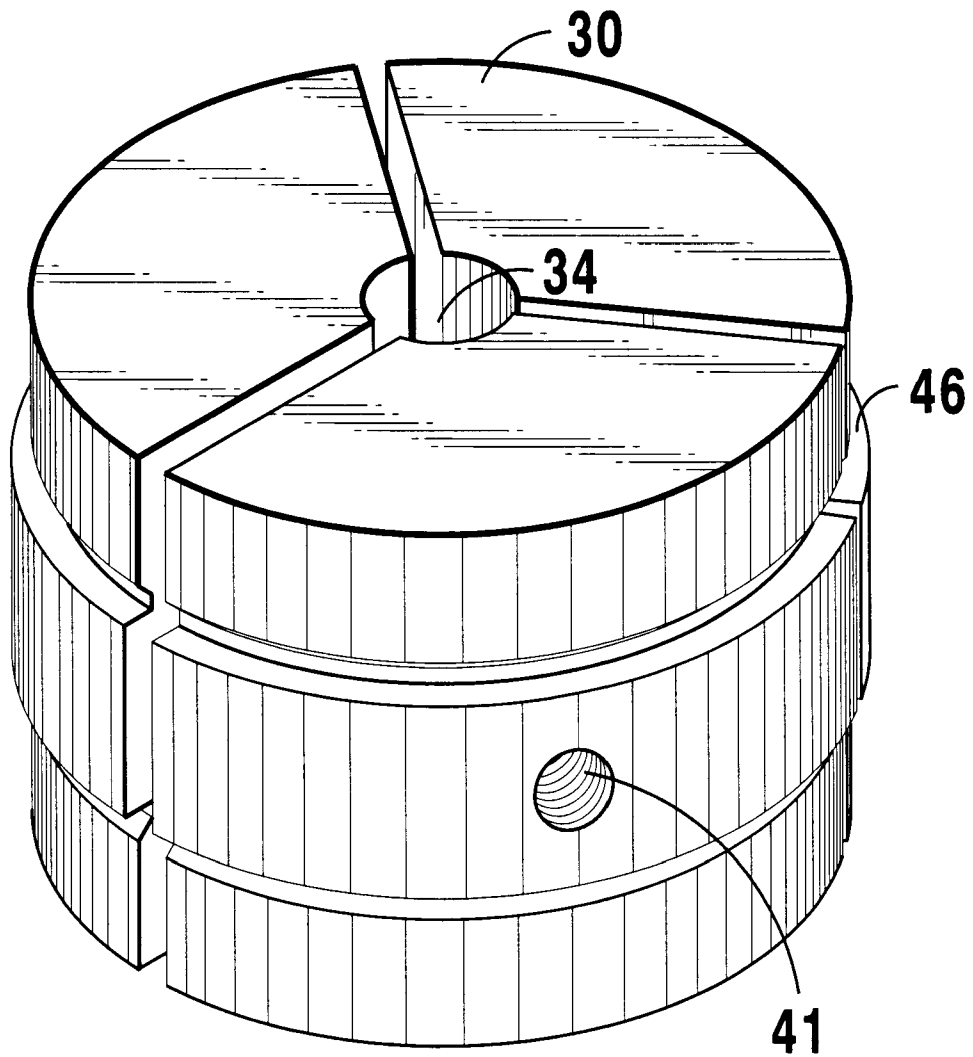
**FIG 2A**



**FIG 3**

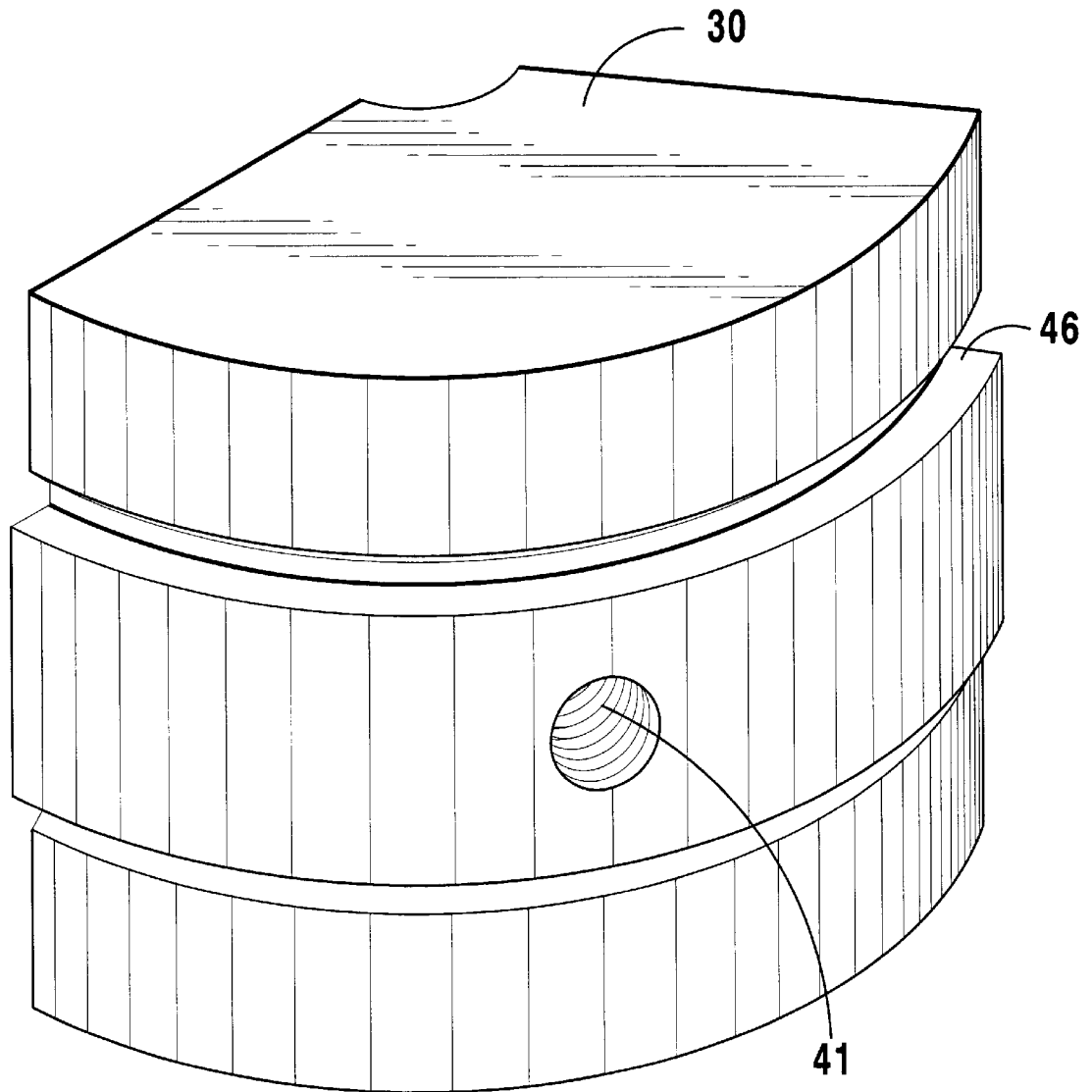


**FIG 3A**

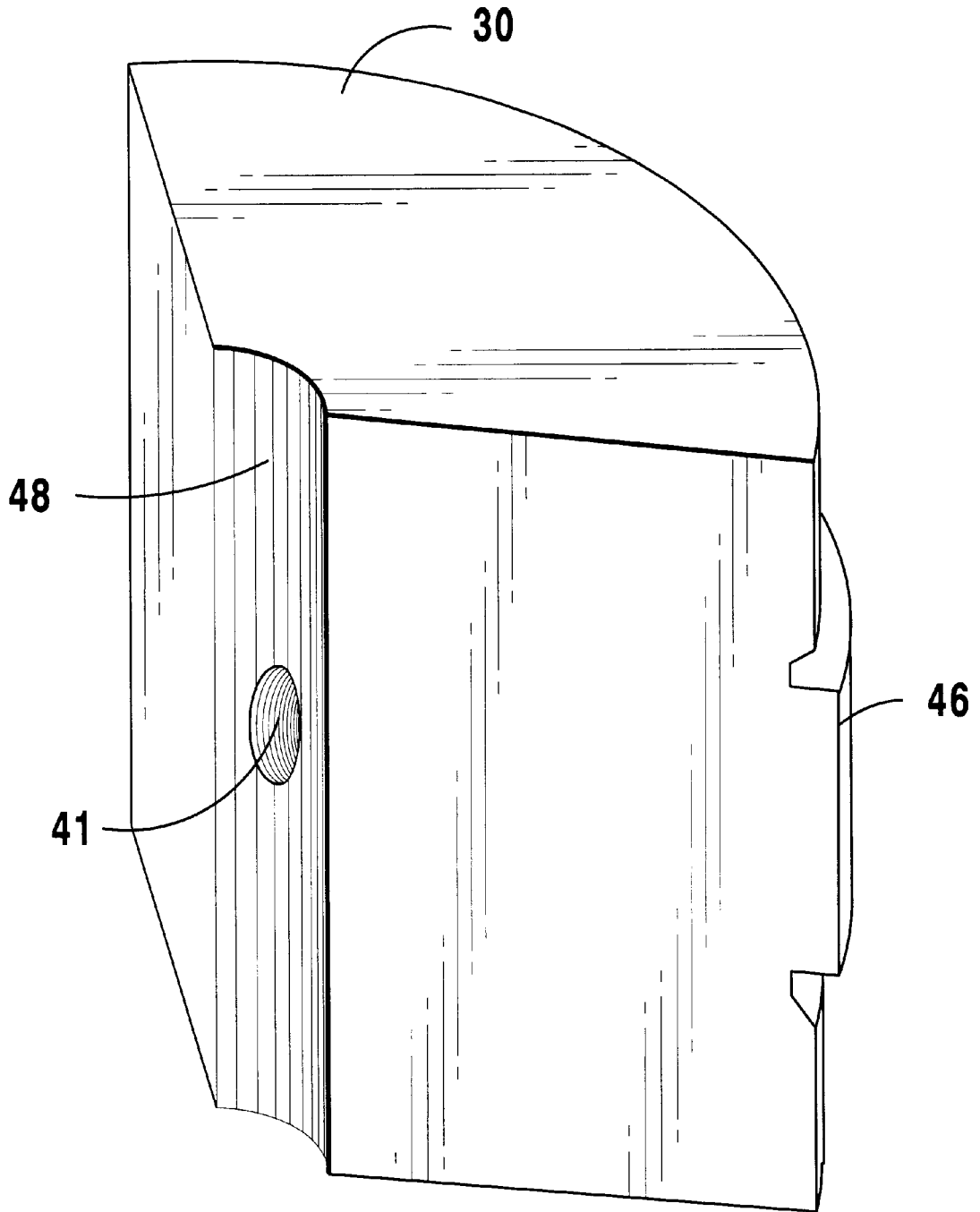


**FIG 4**





**FIG 5**



**FIG 5A**

## UNIVERSAL QUICK JAWS

An expanding collet for machine tools including a tubular body portion having a longitudinal axis and a plurality of slots dividing the tubular body portion into a hub portion and a plurality of fingers extending from the hub portion and having inner and outer surfaces, an adapter member mounted on the outer surface of the free end of each of the fingers, each of the adapter members having an inner surface coincident with the outer surface of the fingers, the adapter members each including a portion beyond the free end of the fingers and extending radially inward toward the longitudinal axis, the adapter members each including an outer surface longer than its respective inner surface.

In an arrangement for coupling a false jaw to a master jaw of a chuck, wherein a positive locking is effected by a radial displacement, the master jaw is provided with an extension having a stop surface and a projection. The false jaw has a recess for receiving the extension and a relief shoulder and is guided in the direction of rotation. Due to this arrangement, the false jaw is well supported and highly stable, so that strong forces can be transmitted, and a highly repetitive accuracy in chucking is obtained.

The soft jaws of a lathe chuck or the like are constructed to be engaged by studs of an adjustable lock ring device for holding the jaws during the machining thereof to fit a workpiece to be held by the jaws.

A universal sleeve-clamp for using interchangeable jaw pieces to clamp a workpiece has a sleeve with a plurality of radially moveable elements. Features are provided for locating and attaching the jaw pieces to the radially moveable elements so that, when a clamping taper is made to bear against the radially moveable elements, the radially moveable elements, and hence the interchangeable jaw pieces, are moved radially to clamp the workpiece. The clamping taper may be externally tapered to form an expanding mandrel, or internally tapered to form a collet chuck. The jaw pieces, which are made of soft metal or other easily machinable material, may be shaped for clamping multiple diameters, clamping thin-walled workpieces or for clamping a workpiece eccentrically. A locator plate is used to give additional support to a workpiece, or to align it in a known rotational position for static fixturing.

While these holding devices may be suitable for the purposes for which they were designed, they would not be as suitable for the purposes of the present invention, as hereinafter described.

## SUMMARY OF THE INVENTION

The present invention discloses a set of three universal adjustable soft jaws for holding workpieces for being mounted onto a chuck body for mounting onto the spindle of a lathe. The three jaws are mounted onto the face of the chuck body using standard screws. The three jaws are further equipped on their inner end with an offset flange foot for having mounted thereon a custom sized jaw pad which is attached to the offset flange foot with quick connect/disconnect screws which allow the custom sized jaw pads to be quickly and easily removed from the universal set of jaws. These custom sized jaws are useful for accommodating workpieces of particular sizes and shapes depending on the specific job application.

A primary object of the present invention is to provide a soft jaw locking device to hold the workpiece.

Another object of the present invention is to provide a universal set of jaws and the jaws are configured to hold custom sized jaw pads.

A still further object of the present invention is to provide a custom sized jaw pad that may quickly be attached to a set of universal jaws.

Yet another object of the present invention is to provide the user with an inexpensive method of holding various sized work pieces.

Additional objects of the present invention will appear as the description proceeds.

The present invention overcomes the shortcomings of the prior art by modifying a standard set of jaws to hold a customized set of jaw pads.

The foregoing and other objects and advantages will appear from the description to follow. In the description reference is made to the accompanying drawings, which form a part hereof, and in which is shown by way of illustration specific embodiments in which the invention may be practiced. These embodiments will be described in sufficient detail to enable those skilled in the art to practice the invention, and it is to be understood that other embodiments may be utilized and that structural changes may be made without departing from the scope of the invention. In the accompanying drawings, like reference characters designate the same or similar parts throughout the several views.

The following detailed description is, therefore, not to be taken in a limiting sense, and the scope of the present invention is best defined by the appended claims.

## BRIEF DESCRIPTION OF THE DRAWINGS

In order that the invention may be more fully understood, it will now be described, by way of example, with reference to the accompanying drawings in which:

FIG. 1 is a perspective view of a typical lathe with a typical set of adjustable jaws;

FIG. 1A is a perspective view of a typical lathe with another typical set of adjustable jaws;

FIG. 2 is a perspective view of the present invention with a set of custom sized jaw pads in place;

FIG. 2A is a broken out perspective view of the individual components of the present invention;

FIG. 3 is a perspective view of one of the universal adjustable jaws of the instant invention and may be fabricated by taking the prior art jaws and removing material so that the rectangular shape of the prior art jaws becomes "L" shaped.

FIG. 3A is a perspective view of another one of the universal jaws of the instant invention and may be fabricated by taking the prior art jaws and removing material so that the rectangular shape of the prior art jaws become "L" shaped;

FIG. 4 is a perspective view of the custom sized jaw pads;

FIG. 5 is a perspective view of one section of the custom sized jaw pads;

FIG. 5A is a perspective view of another section of the custom sized jaw pads.

## DESCRIPTION OF THE PREFERRED EMBODIMENT(S)

Turning now descriptively to the drawings, in which similar reference characters denote similar elements throughout the several views, FIGS. 1 through 5A illustrate the present invention. With regard to the reference numerals used, the following numbering is used throughout the various drawings.

**10** lathe  
**12** bed of lathe  
**14** body of chuck  
**15** spindle  
**16** jaws  
**18** wedged face  
**20** head screw  
**22** master jaw/T-nut  
**24** concave face  
**26** universal jaws  
**28** offset flange foot  
**29** removed material  
**30** custom jaw pads  
**32** quick connect/disconnect screws  
**34** hole of custom sized jaws  
**36** recess  
**38** holes for connecting screws  
**40** holes for head screws  
**41** holes for connecting screw  
**42** groove of jaw  
**44** serrated face of jaw  
**46** tongue  
**48** concave inner face

Turning to FIG. 1, therein is shown a perspective view of a lathe **10** with its support base or bed **12** whereupon the chuck body **14** is attached in the standard manner to the spindle nose **15** of the lathe **10**. Shown therein are the three jaws **16** of the chuck **14** having wedge shaped or pointed inner faces **18** for holding workpieces (not shown). The three jaws **16** are attached to the body **14** by using screws **20** which are typically attached to a T-nut or master jaw **22** which is housed in slotted areas equally circumferentially spaced about the body of the chuck **14**. The wedge shaped faces **18** of the jaws **16** are used for grinding workpieces including round or square shaped pieces.

Turning to Figure 1A, therein is shown a perspective view of a typical prior art lathe **10** with its support base **12** whereupon the chuck body **14** is attached to the spindle **15** of the lathe **10**. Shown therein are the three jaws **16** having concave shaped inner faces **24** for holding mainly round workpieces (not shown). The three jaws **16** are attached to the body **14** by using screws **20** which are attached typically to a T-nut or master jaw **22** which is housed in slotted areas spaced about the body of the chuck **14** and which serve as part of the means for adjusting the jaws in the standard manner.

Turning to FIG. 2, therein is shown a perspective view of the present invention with a plurality or set of custom sized jaw pads **30** in operative connection. Therein is shown the universal adjustable jaws of the present invention **26**, which are attached by means and adjusted inwardly and outwardly about the face of the chuck by means in the standard manner, being attached to the body of the chuck **14** and radially spaced about the chuck face using the screws **20** mounted in recessed holes **40** of the universal jaws **26**. Also shown is the offset flange foot **28** located on the inner end of the jaws **26** and the custom jaw pads **30** attached thereto along with the quick connect/disconnect screws **32** for the custom jaw pads **30** which screws **32** are mounted in recessed holes **38** on the offset flange foot **28** of the universal jaws **26**. In operation it can be seen that the universal adjustable jaws of the present invention **26** attach to the chuck body **14** and are adjustable similarly to the prior art. However, the first set of

universal jaws **26** of the present invention are adapted to have an offset flange foot or base **28** for mounting thereon a second set of the custom sized jaw pads **30** by using the screws **32**. The custom sized jaw pads **30** act as an inner piece of the first set of jaws **26** and serve to extend the first set of jaws **26** inwardly. The offset foot **28** extends transversely from one side of the first set of jaws **26** away from and perpendicular to the chuck body **14** and has a concave face on its inner end for receiving the second set of jaws **30**. Finally shown therein is the inner space or hole **34** wherein the workpiece (not shown) is held by the custom sized jaws **26**. The custom sized jaws **30** are useful for accommodating workpieces of particular sizes or shapes as may be necessary or convenient depending on the specific job purpose or objective and may be a plurality of three, four, or other number as may be desired according to the standard practice of the art.

Turning to FIG. 2A, therein is shown the jaws of the present invention **26**, the offset flange foot **28** of the inner face and the custom sized jaws **30** along with the quick connect/disconnect screws **32** for holding the custom sized jaws **30** onto the body of the universal adjustable jaws **26**. A circumferential tongue **46** is located on the outer periphery of the custom sized jaws **30** for being received by a recess **36** located on the inner face of the flange foot **36**.

Turning to FIG. 3, therein is shown a perspective view of the universal adjustable jaws **26** of the present invention which may be fabricated by taking the prior art jaws and removing material **29** (shown in outline) from them so that the rectangular shape of the prior art jaws becomes "L" shaped which comprises the offset flange foot or base **28** of the inner face of the present invention **26**. Also shown therein is the recessed area **36** on the inner face of the offset flange foot **28** and the recessed hole or aperture **38** for holding the connecting screw (not shown). Also shown therein are the recessed holes **40** for the head screws (not shown) along with the longitudinal groove **42** on the back of the present invention for mating with the master jaw or T-nut (not shown) along with serrations **44** which allow for adjustability on the chuck body and assist in holding the present invention to the face of the chuck body (not shown).

Turning to FIG. 3A, therein is shown a perspective view of the universal adjustable jaws **26** of the present invention which may be fabricated by taking the prior art jaws and removing material **29** (shown in outline) from them so that the rectangular shape of the prior art jaws becomes "L" shaped which comprises the offset flange foot or base **28** of the inner face of the present invention **26**. Also shown therein is the recessed area **36** on the inner face of the offset flange foot **28** and the recessed hole or aperture **38** for accommodating or holding the connecting screw (not shown). Also shown therein are the recessed holes **40** for the head screws (not shown) along with the longitudinal groove **42** on the back of the present invention for mating with the master jaw or T-nut (not shown) along with serrations **44** which allow for adjustability on the chuck body and assist in holding the present invention to the face of the chuck body (not shown).

Turning to FIG. 4, therein is shown a perspective view of the three custom sized jaw pads **30** of the present invention. Also shown is the threaded hole **41** which extends into the jaw pads **30** on a line perpendicular to the central axis of the chuck body **14** (not shown) which hole **41** is for accepting the connecting screws (not shown). Also shown is the inner hole **34** of the custom sized jaws. Also shown is the circumferential tongue area **46** on the periphery of the jaws which secure it in place in and to the recessed area **36** (not shown) of the flange foot **28** (not shown).

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Turning to FIG. 5, therein is shown a perspective view of one section of the custom sized jaw pads **30** of the present invention. Shown therein is the hole **41** for accepting the disconnect screw along with the circumferential tongue **46** on the periphery of the pad **30** which mates to the recessed area on the inner face of the offset flange foot **28** (not shown). 5

Turning to FIG. 5A, therein is shown a perspective view of one section of the custom sized jaw pads **30** of the present invention. Shown therein is the hole **41** for accepting the disconnect screw along with the circumferential tongue **46** on the periphery of the pad **30** which mates to the recessed area on the inner face of the offset flange foot **28** (not shown). Also shown is the concave inner face **48** of the custom sized jaw **30**. 10 15

What is claimed to be new and desired to be protected by Letters Patent is set forth in the appended claims:

1. Apparatus for holding a workpiece on a lathe chuck having a face comprising:

- (a) a plurality of jaws mounted on a flat face of said chuck, each of said jaws being L-shaped with a first leg mounted on said face and a second leg having a 20

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concave shaped edge facing said workpiece, the concave edges of the jaws forming a circle being completely smooth and adapted to hold said workpiece for machining;

- (b) a recess formed in the concave shaped edge of each jaw extending parallel to the face of said chuck;
- (c) a pie-shaped jaw pad nesting against each of said jaws, each jaw pad having an outer circular surface nested in the concave shaped edge of a jaw, said outer circular surface having a circumferential tongue fitted into the recess of a jaw;
- (d) a threaded opening extending into the tongue of each of said pads for receiving and engaging a head screw;
- (e) a circular opening through the recess of each of said jaws aligned with the threaded opening in the nested pad large enough to accommodate said screw without threading; and
- (f) a screw for each of said jaws for attaching the nested pad in a quick connect/disconnect manner.

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