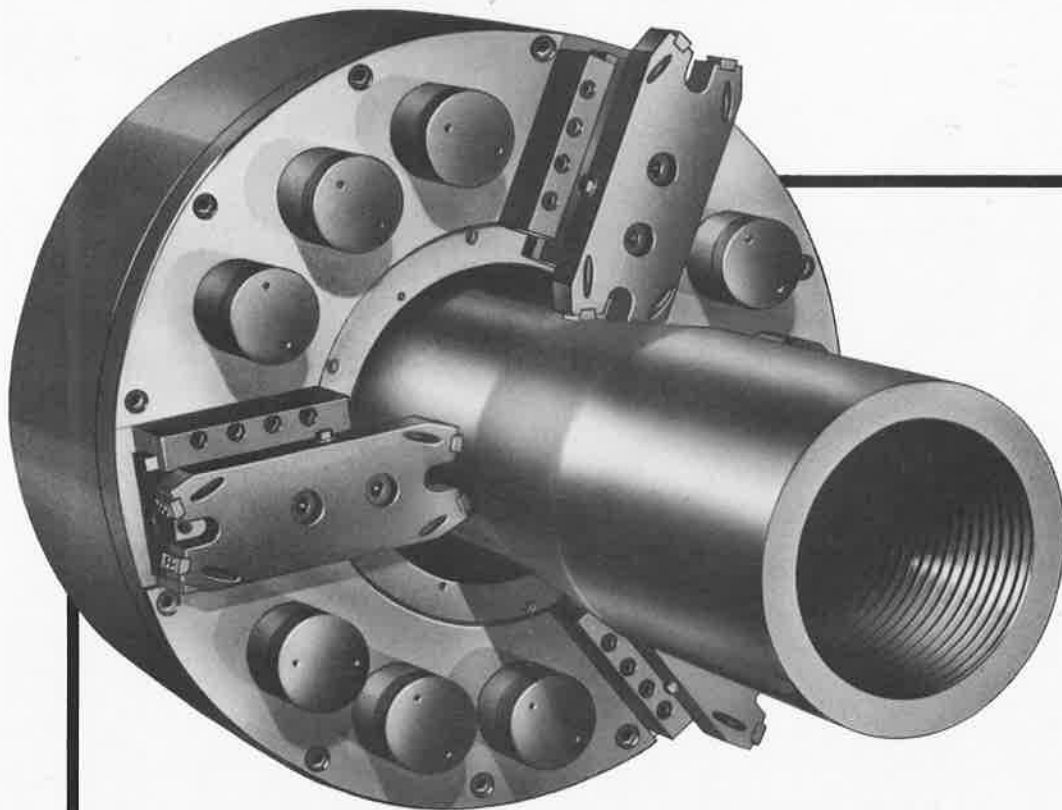
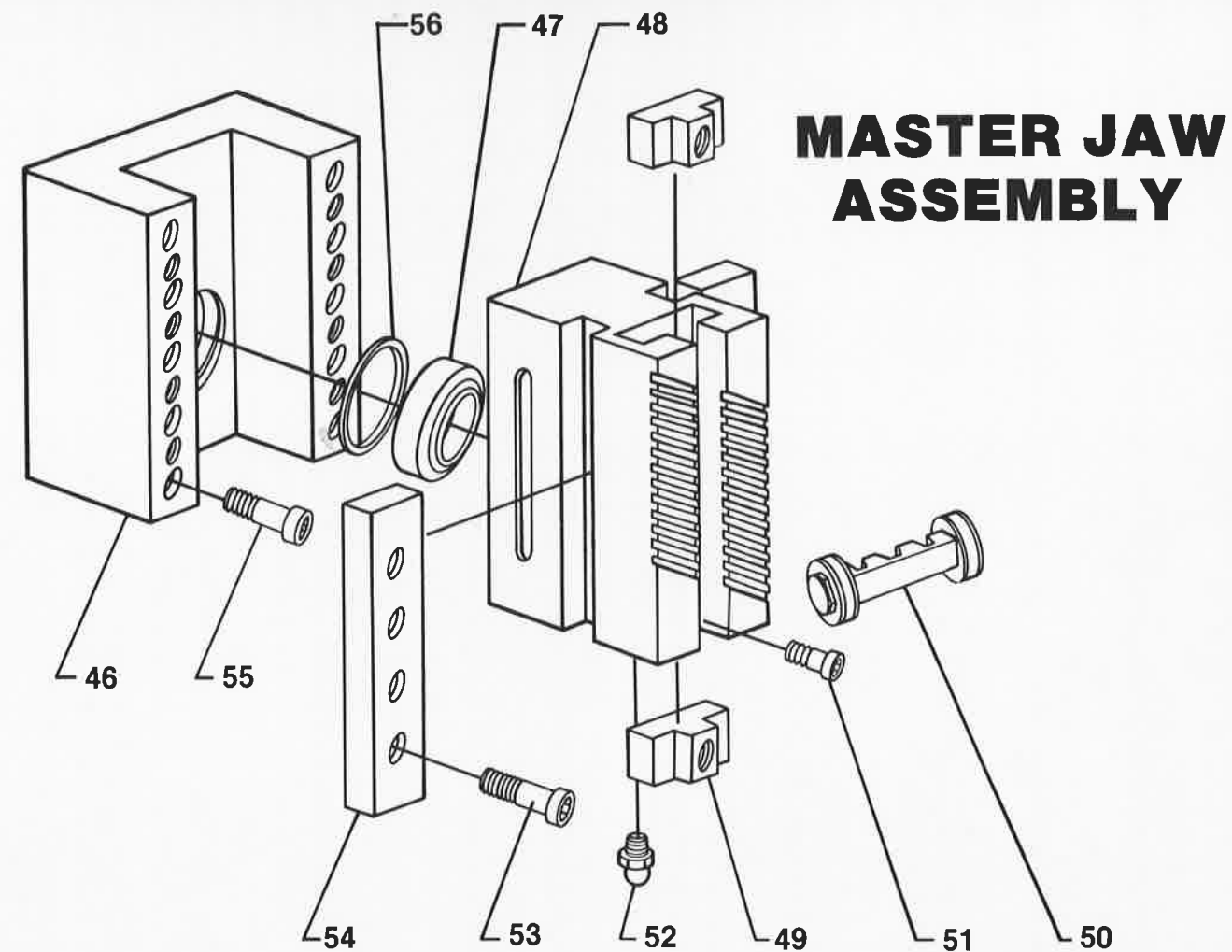




WOODWORTH
CENTRALIZING
THRU-HOLE CHUCK
and JAW ASSEMBLIES



MASTER JAW ASSEMBLY

MASTER JAW ASSEMBLY

NO.	DESCRIPTION	PART NO.	QUANTITY
46.	Jaw Guide	THC-24854	3
47.	Bearing	THC-24855	3
48.	Master Jaw	THC-24852	3
49.	T-Nut	THC-24856	6
50.	Adjusting Screw Assembly	UBL-30844	3
51.	Soc. Hd. Cap Scr.	5/16-18 x .38 lg.	3
52.	Grease Fitting	#5010 Lincoln	6
53.	Soc. Hd. Cap Scr.	1/2-20 x 1.25	24
54.	Top Rail	THC-24853	6
55.	Soc. Hd. Cap Scr.	3/8-24 x 2.25 lg.	30
56.	Retaining Ring	#RRN-281 SPIR-O-LOK	3

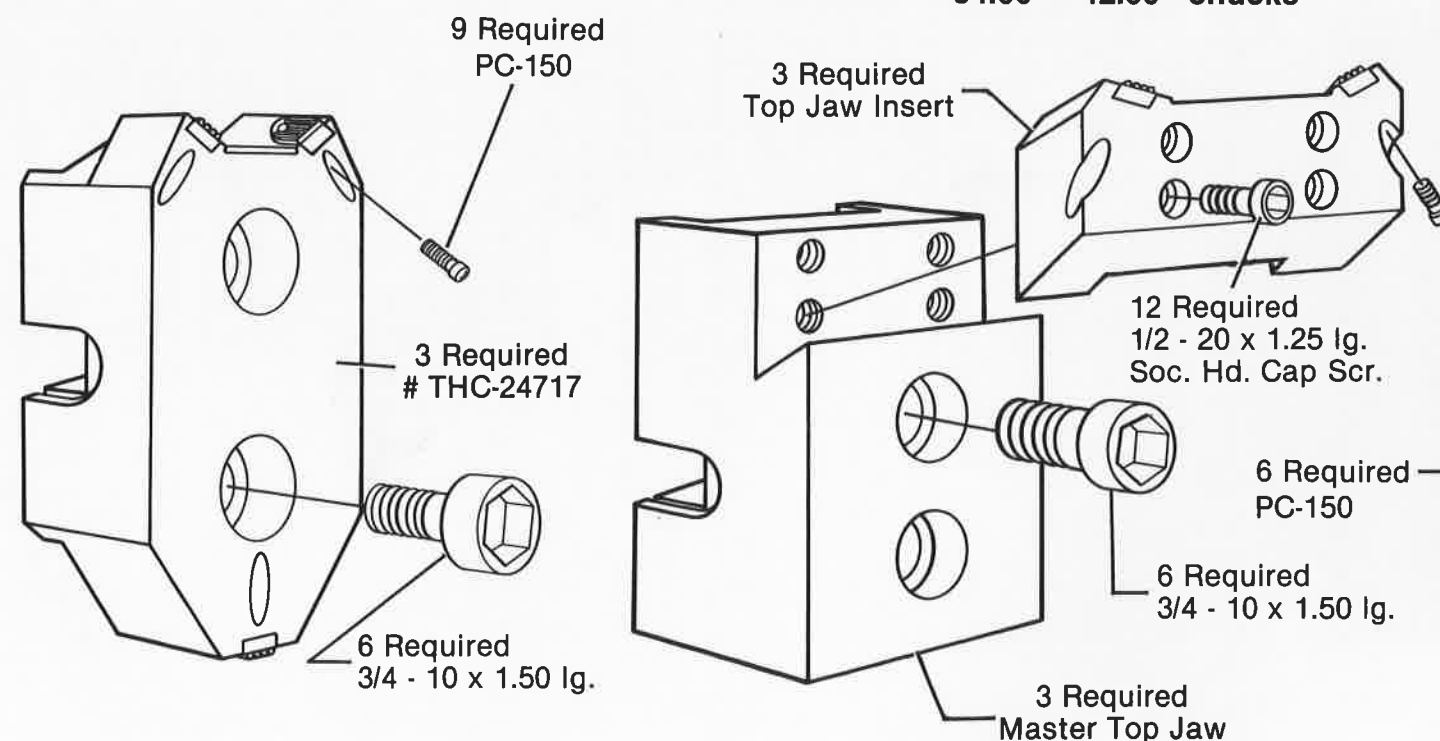
TOP JAW ASSEMBLIES

24.00" CHUCK	REVERSIBLE TOP JAW ASSEMBLY NO.		
FOR CHUCKING API CASING & DRILL PIPE SIZES 1.25 (1.66 ACT.) 2.38 • 2.88 • 3.50 • 4.00 • 4.50 • 5.00 • 5.50	THC-24717		
27.00" CHUCK	TOP JAW ASSEMBLY NO.	MASTER TOP JAW	TOP JAW INSERT
FOR CHUCKING API CASING & DRILL PIPE SIZES 4.50 • 5.00 • 5.50 • 6.62	THC-27711	THC-24722	THC-24736
7.00 • 7.62 • 8.62	THC-27712	THC-24722	THC-28734
28.00" CHUCK	TOP JAW ASSEMBLY NO.	MASTER TOP JAW	TOP JAW INSERTS
FOR CHUCKING API CASING & DRILL PIPE SIZES 4.50 • 5.00 • 5.50 • 6.62	THC-28713	THC-24722	THC-24736
7.00 • 7.62 • 8.62 • 9.62	THC-28714	THC-24722	THC-28734
30.00" CHUCK	TOP JAW ASSEMBLY NO.	MASTER TOP JAW	TOP JAW INSERT
FOR CHUCKING API CASING & DRILL PIPE SIZES 4.50 • 5.00 • 5.50 • 6.62	THC-30711	THC-24722	THC-30731
7.00 • 7.62 • 8.62 • 9.62	THC-30712	THC-24722	THC-28734
10.75 • 11.75	THC-30713	THC-24722	THC-35734
34.00" CHUCK	TOP JAW ASSEMBLY NO.	MASTER TOP JAW	TOP JAW INSERT
FOR CHUCKING API CASING & DRILL PIPE SIZES 4.50 • 5.00 • 5.50 • 6.62	THC-34711	THC-24723	THC-34731
7.00 • 7.62 • 8.62 • 9.62	THC-34712	THC-24723	THC-28734
10.75 • 11.75 • 13.38	THC-34713	THC-24722	THC-35734
42.00" CHUCK	TOP JAW ASSEMBLY NO.	MASTER TOP JAW	TOP JAW INSERT
FOR CHUCKING API CASING SIZES 10.75 • 11.75 • 13.38	THC-42713	THC-24723	THC-42733
16.00 • 18.62 • 20.00	THC-42715	THC-24722	THC-42735

TOP JAW ASSEMBLY

Top Jaw For: 24.00" chuck

Top Jaw For: 27.00" - 28.00" - 30.00" -
34.00" - 42.00" chucks



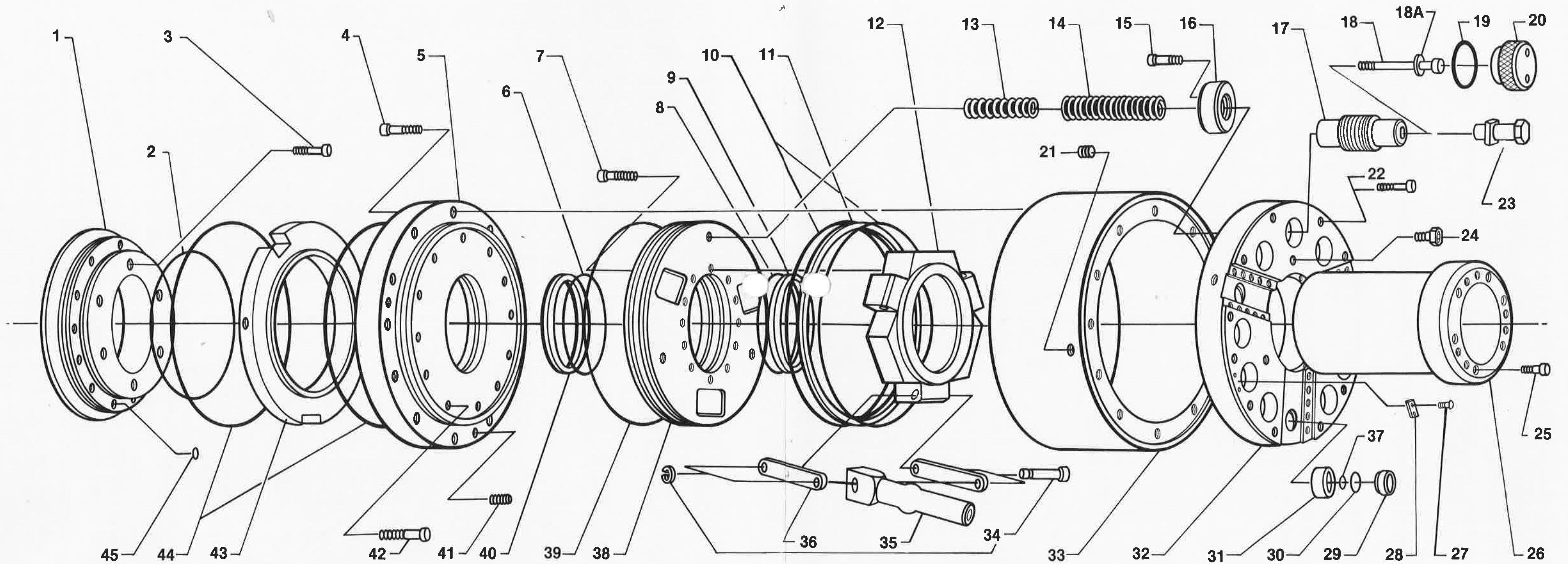
N. A. WOODWORTH COMPANY

1300 EAST NINE MILE RD. • DETROIT, MI 48220 • (313) 541-7500

PRINTED IN U.S.A.

BULLETIN #H-482

THRU-HOLE CHUCK ASSEMBLY



NO. DESCRIPTION

PART NUMBERS AND QUANTITIES

	THC-24000 (24'')	THC-27000 (27'')	THC-28000 (28'')	THC-30000 (30'')	THC-34000 (34'')	THC-42000 (42'')	
1. Sub-Adaptor	THC-24405	(1) THC-27405	(1) THC-28405	(1) THC-28405	(1) THC-28405	(1) THC-42405	(1)
2. Seal	AS-568-283	(1) AS-568-283	(1) THC-28221	(1) THC-28221	(1) THC-28221	(1) THC-42221	(1)
3. Soc. Hd. Cap Scr.	See print	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(12)
4. Soc. Hd. Cap Scr.	5/8-11x1.50	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(15)
5. Back Plate	THC-24401	(1) THC-27401	(1) THC-28401	(1) THC-30401	(1) THC-34401	(1) THC-42401	(1)
6. O-Ring Seal	AS-568-443	(1) AS-568-450	(1) AS-568-452	(1) AS-568-456	(1) AS-568-461	(1) AS-568-472	(1)
7. Soc. Hd. Cap Scr.	1/2-13x1.25 lg.	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(15) —————>	
8. O-Ring Seal	AS-568-443	(1) AS-568-450	(1) AS-568-452	(1) AS-568-456	(1) AS-568-461	(1) AS-568-472	(1)
9. Seal Backing	THC-24228	(1) THC-27228	(1) THC-28228	(1) THC-30228	(1) THC-34228	(1) THC-42228	(1)
10. Piston Seal	THC-24225	(2) THC-27225	(2) THC-28225	(2) THC-30225	(2) THC-34225	(2) THC-42225	(2)
11. Piston Seal Backing	THC-24226	(1) THC-27226	(1) THC-28226	(1) THC-30226	(1) THC-34226	(1) THC-42226	(1)
12. Actuator	THC-24620	(1) THC-27620	(1) THC-28620	(1) THC-30620	(1) THC-34620	(1) THC-42620	(1)
13. Inner Spring	THC-24167	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
14. Outer Spring	THC-24165	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
15. Soc. Hd. Cap Scr.	10-32x1.00 lg.	(27) —————>	(27) —————>	(27) —————>	(27) —————>	(36) —————>	(36)
16. Nut	THC-24150	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
17. Spring Adj. Cup Retainer	THC-24160	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
18. Soc. Hd. Cap Scr. (Spec.)	THC-24162	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
18A. Flat Washer	THC-24163	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
19. Seal	THC-24227	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
20. Cap	THC-24155	(9) —————>	(9) —————>	(9) —————>	(9) —————>	(12) —————>	(12)
21. Pipe Pressure Plug	1.00"-11 1/2	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1)
21A. Pipe Pressure Plug	1/2" - 14	(2) —————>	(2) —————>	(2) —————>	(2) —————>	(2) —————>	(2)
22. Soc. Hd. Cap Scr.	5/8"-11x3.00 lg.	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(15)
23. Wrench	THC-24010	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1)
24. Breather Vent	THC-24051	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
25. Soc. Hd. Cap Scr.	3/8-16x1.25 lg.	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(9)
26. Center Sleeve	THC-24625	(1) THC-27625	(1) THC-28625	(1) THC-30625	(1) THC-34625	(1) THC-42625	(1)
27. Button Hd. Cap Scr.	8-32 x .25 lg.	(2) —————>	(2) —————>	(2) —————>	(2) —————>	(2) —————>	(2)
28. Tag	THC-24056	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1)
29. Bearing Retainer	THC-24202	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
30. O-Ring Seal	AS-568-236	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
31. Bearing	THC-24201	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
32. Top Plate	THC-24101	(1) THC-27101	(1) THC-28101	(1) THC-30101	(1) THC-34101	(1) THC-42101	(1)
33. Cylinder	THC-24420	(1) THC-27420	(1) THC-28420	(1) THC-30420	(1) THC-34420	(1) THC-42420	(1)
34. Clevis Pin & Retainer Assembly	THC-24861	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6)
35. Actuator Arm	THC-24851	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
36. Toggle	THC-24871	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6) —————>	(6)
37. O-Ring Seal	AS-568-334	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
38. Piston	THC-24610	(1) THC-27610	(1) THC-28610	(1) THC-30610	(1) THC-34610	(1) THC-42610	(1)
39. Seal	THC-24222	(1) THC-27222	(1) THC-28222	(1) THC-30222	(1) THC-34222	(1) THC-42222	(1)
40. Seal Backing	THC-24228	(1) THC-27228	(1) THC-28228	(1) THC-30228	(1) THC-34228	(1) THC-42228	(1)
41. Flat Pt. Soc. Set Scr.	1/2-13 x 1.00 lg.	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3) —————>	(3)
42. Soc. Hd. Cap Scr.	3/4-10x2.00 lg.	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(12) —————>	(15)
43. Idler Coupling	THC-24950	(1) THC-27950	(1) —————>	(1) —————>	(1) —————>	(1) THC-42950	(1)
	THC-24951	(1) THC-27951	(1) —————>	(1) —————>	(1) —————>		
44. Idler Coupling Seal	THC-24955	(2) —————>	(2) —————>	(2) —————>	(2) —————>	(2) THC-42955	(2)
45. O-Ring Seal	AS-568-112	(1) —————>	(1) —————>	(1) —————>	(1) —————>	(1) AS-568-113	(1)