



**ASI Workholding Inc.**

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Face Plates

Riser Bodies

Yoke Plates

Cam Arms

Keepers

Pins

Stop Bolts

Bushings

Jaw Inserts

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# Spare Parts Catalog

ASI Workholding Inc.  
1258 Fendt Dr.  
Howell, MI 48843  
Ph. 517.540.0400  
Fax. 517.540-0375

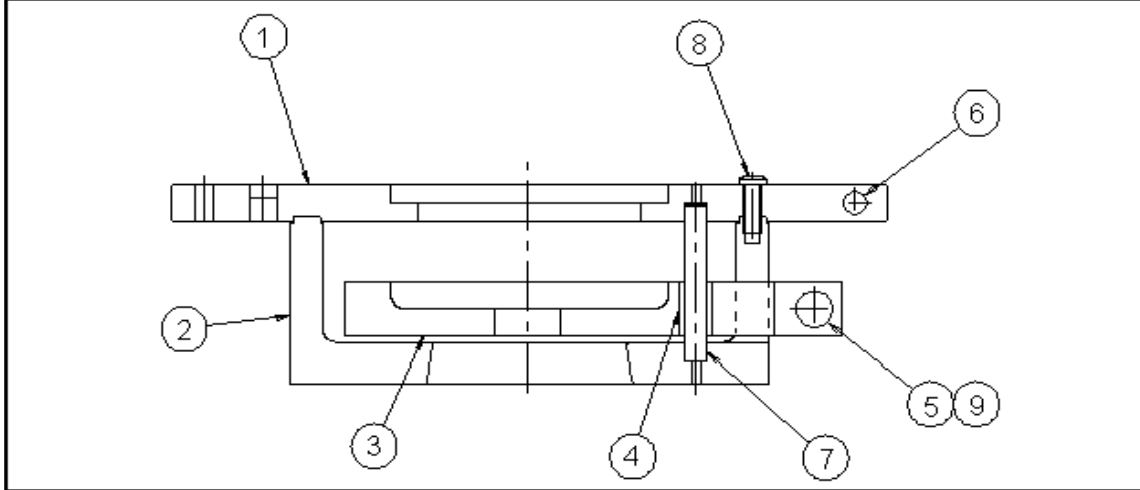
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# MARTECH MTI-30000 SERIES INCH BASE CHUCK PACKAGE

- For Wheel sizes 12" - 18"
- Recommended 2800 RPM maximum



This **INCH** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-30104	Face Plate	1
2	MTI-30239	Riser Body	1
3	MTI-30302	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MTI-30801N	Pivot Pin	3
6	MTI-30802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30814	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-30000

(12"-18") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	30407 SMALL	30405 LARGE	30404 XLARGE	30417 (+.1) X1LARGE	30406 XXLARGE	30411 (+.1) X1XLARGE	30408 XXXLARGE	30416 (+.1) 4XLARGE
306L1	306L2	AAA	10"	11"	12"	12"	13"	13"	14"	16"
306G3	306G4	AA	11"	12"	13"	13"	14"	14"	15"	17"
30601	30606	A	12"	13"	14"	14"	15"	15"	16"	18"
30602	30607	B	13"	14"	15"	15"	16"	16"	17"	19"
30603	30608	C	14"	15"	16"	16"	17"	17"	18"	20"
30604	30609	D	15"	16"	17"	17"	18"	18"	19"	21"

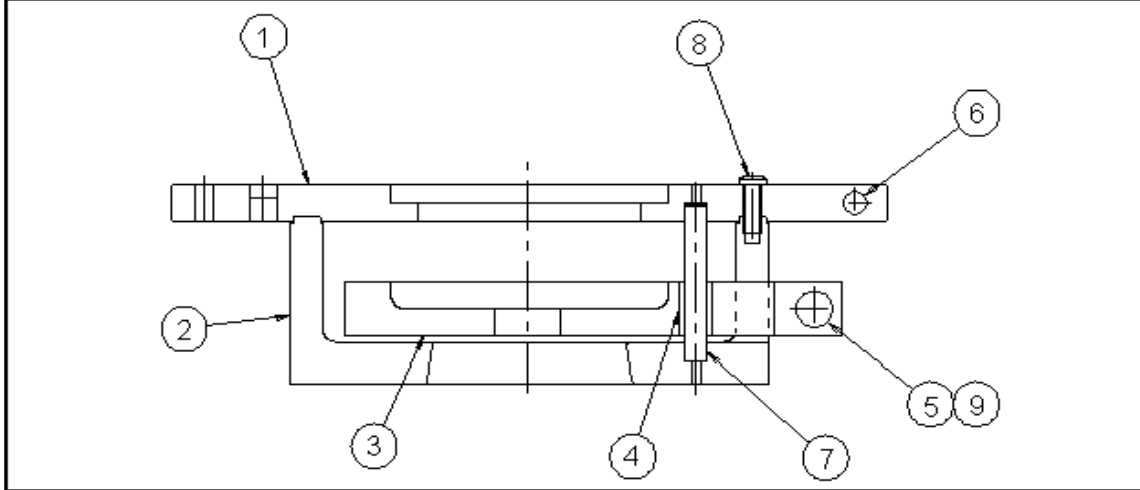
Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

ASI WORKHOLDING, INC.

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# MARTECH MTI-30000 SERIES METRIC BASE CHUCK PACKAGE

- For Wheel sizes 12" - 18"
- Recommended 2800 RPM maximum



This **Metric** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-30105M	Face Plate	1
2	MTI-30242M	Riser Body	1
3	MTI-30303M	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MTI-30801N	Pivot Pin	3
6	MTI-30802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30813	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-30000

(12"-18") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	30407 SMALL	30405 LARGE	30404 XLARGE	30417 (+.1) X1LARGE	30406 XXLARGE	30411 (+.1) X1XLARGE	30408 XXXLARGE	30416 (+.1) 4XLARGE
306L1	306L2	AAA	10"	11"	12"	12"	13"	13"	14"	16"
306G3	306G4	AA	11"	12"	13"	13"	14"	14"	15"	17"
30601	30606	A	12"	13"	14"	14"	15"	15"	16"	18"
30602	30607	B	13"	14"	15"	15"	16"	16"	17"	19"
30603	30608	C	14"	15"	16"	16"	17"	17"	18"	20"
30604	30609	D	15"	16"	17"	17"	18"	18"	19"	21"

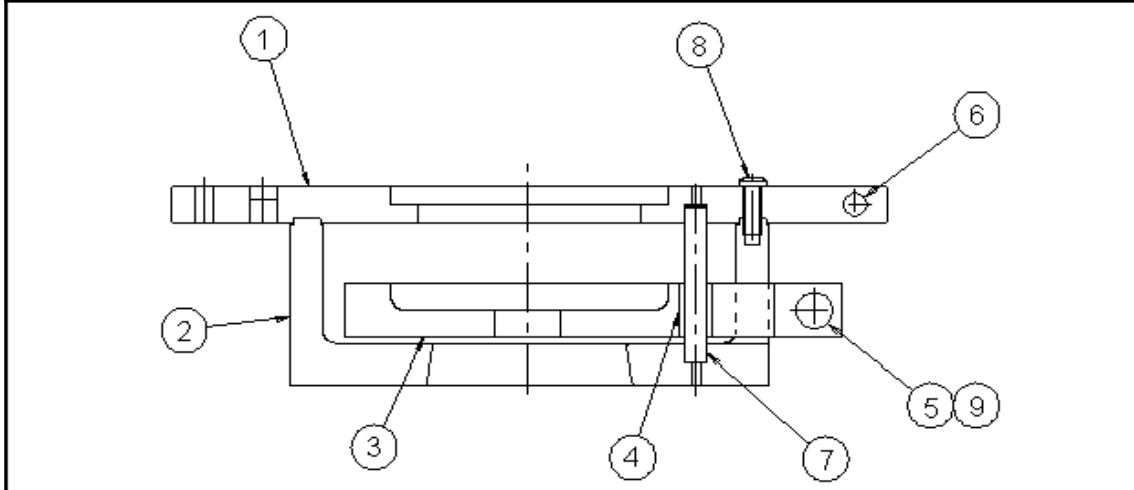
Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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## MARTECH MTI-35000 SERIES INCH BASE CHUCK PACKAGE

- For Wheel sizes 13" - 21"
- Recommended 2800 RPM maximum



This **INCH** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-35105	Face Plate	1
2	MTI-30239	Riser Body	1
3	MTI-35301	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MTI-30801N	Pivot Pin	3
6	MTI-30802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30828	Stop Bolt	3
9	MTI-30901	Keeper	6

### MTI-35000

(13"- 21") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	30407 SMALL	30405 LARGE	30404 XLARGE	30417 (+1) X1LARGE	30406 XXLARGE	30411 (+1) X1XLARGE	30408 XXXLARGE	30416 (+1) 4XLARGE
306L1	306L2	AAA	12"	13"	14"	14"	15"	15"	16"	18"
306G3	306G4	AA	13"	14"	15"	15"	16"	16"	17"	19"
30601	30606	A	14"	15"	16"	16"	17"	17"	18"	20"
30602	30607	B	15"	16"	17"	17"	18"	18"	19"	21"
30603	30608	C	16"	17"	18"	18"	19"	19"	20"	22"
30604	30609	D	17"	18"	19"	19"	20"	20"	21"	23"

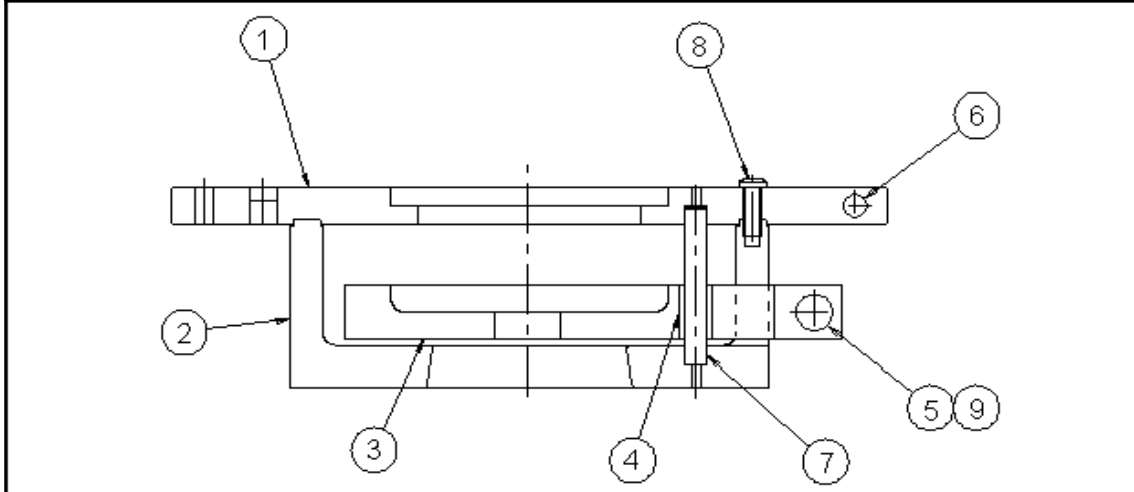
<b>Color Key</b>	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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# MARTECH MTI-35000 SERIES METRIC BASE CHUCK PACKAGE

- For Wheel sizes 13" - 21"
- Recommended 2800 RPM maximum



This **Metric** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-35106M	Face Plate	1
2	MTI-30242M	Riser Body	1
3	MTI-35302M	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MTI-30801N	Pivot Pin	3
6	MTI-30802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30827	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-35000

(13" - 21") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	30407 SMALL	30405 LARGE	30404 XLARGE	(+.1) X1LARGE	30406 XXLARGE	(+.1) X1XLARGE	30408 XXXLARGE	(+.1) 4XLARGE
306L1	306L2	AAA	12"	13"	14"	14"	15"	15"	16"	18"
306G3	306G4	AA	13"	14"	15"	15"	16"	16"	17"	19"
30601	30606	A	14"	15"	16"	16"	17"	17"	18"	20"
30602	30607	B	15"	16"	17"	17"	18"	18"	19"	21"
30603	30608	C	16"	17"	18"	18"	19"	19"	20"	22"
30604	30609	D	17"	18"	19"	19"	20"	20"	21"	23"

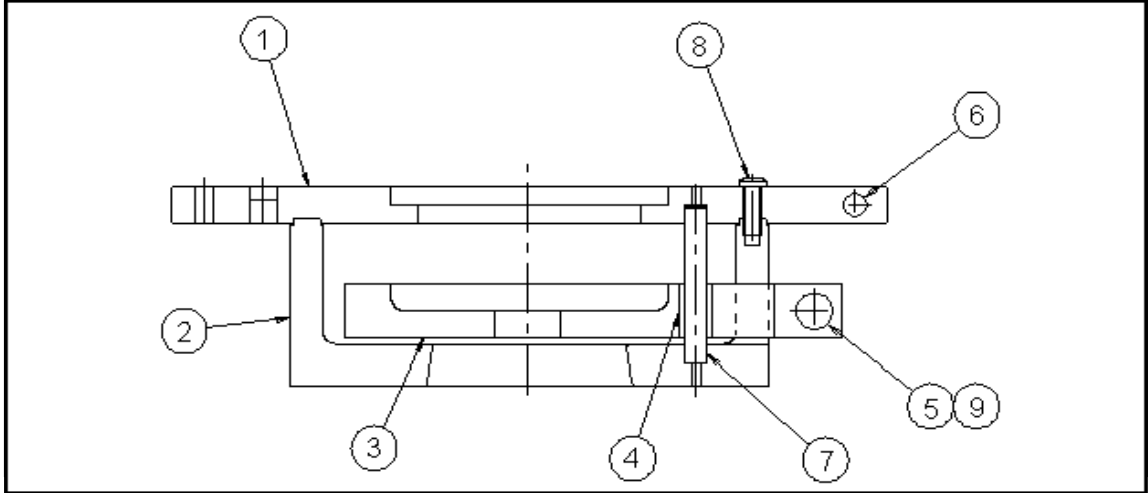
Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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# MARTECH MTI-36000 SERIES INCH BASE CHUCK PACKAGE

■ For Wheel sizes 13" - 21"  
 ■ Recommended 2800 RPM maximum



This **INCH** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-36103	Face Plate	1
2	MTI-30239	Riser Body	1
3	MTI-36301	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MHS-40801	Pivot Pin	3
6	MTI-50802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30828	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-36000

(13" - 21") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	40401 SMALL	40402 LARGE	40407 (+.1) 1LARGE	40403 XLARGE	40404 (+.1) X1XLARGE	40405 (+.1) XXXLARGE	40408 (+.1) 3.5XLARGE	40406 (+.1) 4XLARGE
306L1	306L2	AAA	12"	13"	13"	14"	15"	16"	17"	18"
306G3	306G4	AA	13"	14"	14"	15"	16"	17"	18"	19"
30601	30606	A	14"	15"	15"	16"	17"	18"	19"	20"
30602	30607	B	15"	16"	16"	17"	18"	19"	20"	21"
30603	30608	C	16"	17"	17"	18"	19"	20"	21"	22"
30604	30609	D	17"	18"	18"	19"	20"	21"	22"	23"

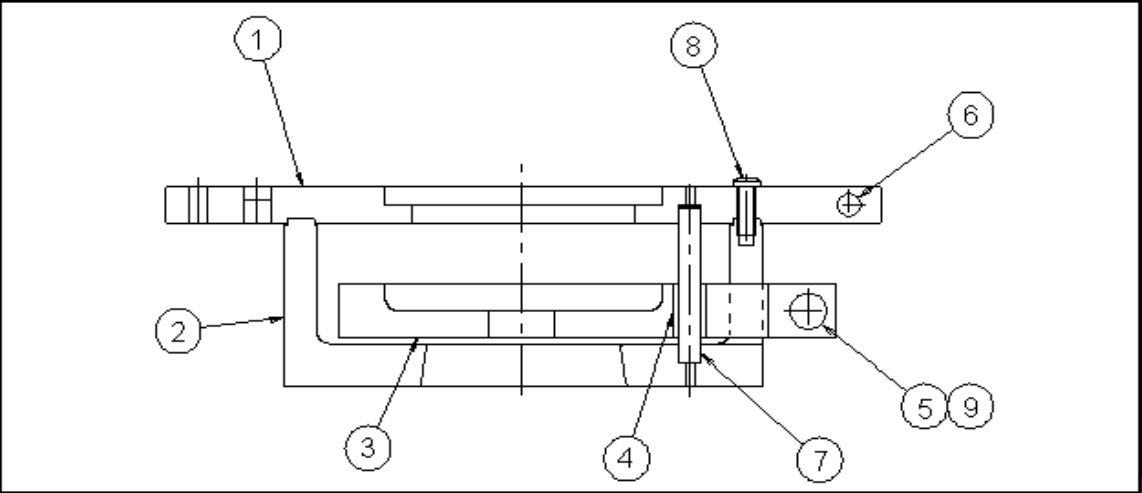
Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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# MARTECH MTI-36000 SERIES METRIC BASE CHUCK PACKAGE

■ For Wheel sizes 13" - 21"  
 ■ Recommended 2800 RPM maximum



This **INCH** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-36104M	Face Plate	1
2	MTI-30242M	Riser Body	1
3	MTI-36302M	Yoke Plate	1
4	MTI-30701	Yoke Bushing	3
5	MHS-40801	Pivot Pin	3
6	MTI-50802JC	Cam Pin	3
7	MTI-30805N	Guide Pin	3
8	MTI-30828	Stop Bolt	3
9	MTI-30901	Keeper	6

**MTI-36000**  
 (13" - 21") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	40401 SMALL	40402 LARGE	(+.1) 1LARGE	40403 XLARGE	(+.1) X1XLARGE	(+.1) XXXLARGE	(+.1) 3.5XLARGE	(+.1) 4XLARGE
306L1	306L2	AAA	12"	13"	13"	14"	15"	16"	17"	18"
306G3	306G4	AA	13"	14"	14"	15"	16"	17"	18"	19"
30601	30606	A	14"	15"	15"	16"	17"	18"	19"	20"
30602	30607	B	15"	16"	16"	17"	18"	19"	20"	21"
30603	30608	C	16"	17"	17"	18"	19"	20"	21"	22"
30604	30609	D	17"	18"	18"	19"	20"	21"	22"	23"

Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
Dark Grey	Not recommended condition	

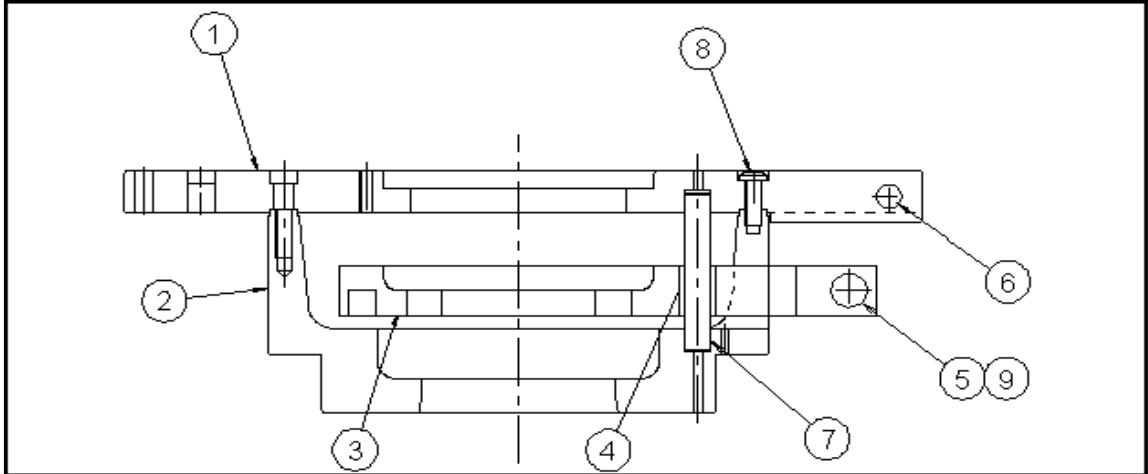
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# MARTECH MTI -50000 SERIES INCH BASE CHUCK PACKAGE

- For Wheel sizes 14" - 24"
- Recommended 3200 RPM maximum



This **Inch** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-50101	Face Plate	1
2	MTI-50201	Riser Body	1
3	MTI-50301	Yoke Plate	1
4	MTI-30702	Yoke Bushing	3
5	MHS-40801	Pivot Pin	3
6	MTI-50802JC	Cam Pin	3
7	MTI-31803	Guide Pin	3
8	MTI-30828	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-50000

(14"- 24") CAPABLE WHEEL RANGE

JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	40401 SMALL	40402 LARGE	40407 (+.1) XLARGE	40403 X1LARGE	40404 (+.1) XXLARGE	40405 (+.1) X1XLARGE	40408 (+.1) XXXLARGE	40406 (+.1) 4XLARGE
306G3	306G4	AAA	13"	14"	14"	15"	16"	17"	18"	19"
306L1	306L2	AA	14"	15"	15"	16"	17"	18"	19"	20"
30601	30606	A	15"	16"	16"	17"	18"	19"	20"	21"
30602	30607	B	16"	17"	17"	18"	19"	20"	21"	22"
30603	30608	C	17"	18"	18"	19"	20"	21"	22"	23"
30604	30609	D	18"	19"	19"	20"	21"	22"	23"	24"

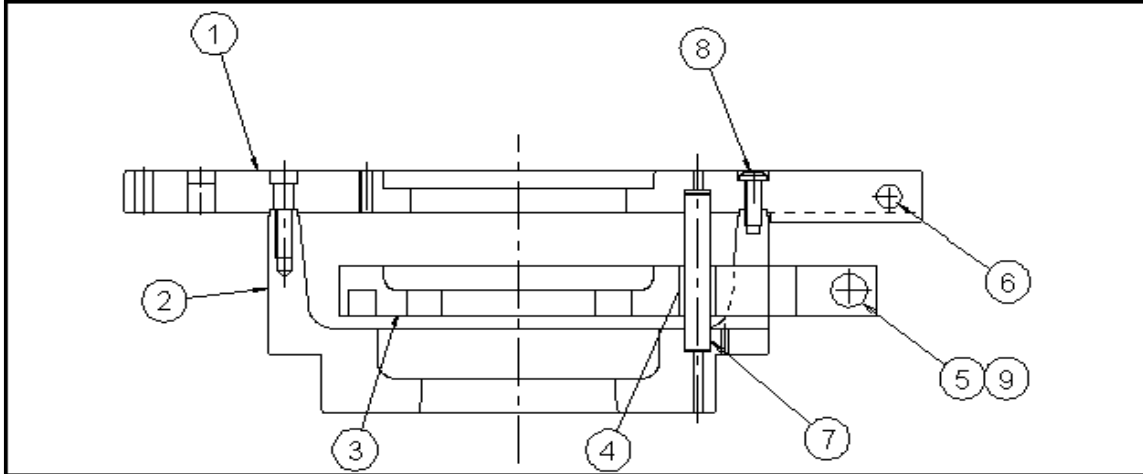
Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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# MARTECH MTI-50000 SERIES METRIC BASE CHUCK PACKAGE

- For Wheel sizes 14" - 24"
- Recommended 3200 RPM maximum



This **Metric** package will include the following

Detail	Part Number	Description	Quantity
1	MTI-50102	Face Plate	1
2	MTI-50202	Riser Body	1
3	MTI-50303	Yoke Plate	1
4	MTI-30702	Yoke Bushing	3
5	MHS-40801	Pivot Pin	3
6	MTI-50802JC	Cam Pin	3
7	MTI-31803	Guide Pin	3
8	MTI-30827	Stop Bolt	3
9	MTI-30901	Keeper	6

## MTI-50000

(14"-24") CAPABLE WHEEL RANGE

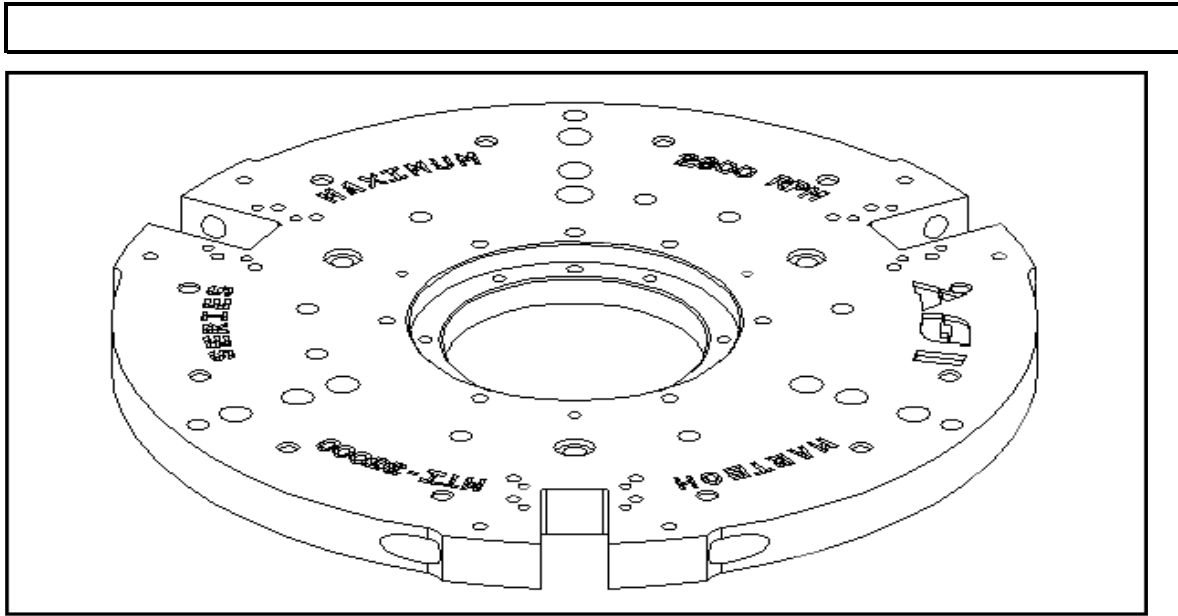
JAW INSERTS			CAM ARMS							
1ST OP	2ND OP	LETTER	40401 SMALL	40402 LARGE	40407 (+.1) XLARGE	40403 X1LARGE	40404 (+.1) XXLARGE	40405 (+.1) X1XLARGE	40408 (+.1) XXXLARGE	40406 (+.1) 4XLARGE
306G3	306G4	AAA	13"	14"	14"	15"	16"	17"	18"	19"
306L1	306L2	AA	14"	15"	15"	16"	17"	18"	19"	20"
30601	30606	A	15"	16"	16"	17"	18"	19"	20"	21"
30602	30607	B	16"	17"	17"	18"	19"	20"	21"	22"
30603	30608	C	17"	18"	18"	19"	20"	21"	22"	23"
30604	30609	D	18"	19"	19"	20"	21"	22"	23"	24"

Color Key	Block Color	Description
	White	Recommended condition
	Light Grey	Does not account for .1 shift
	Dark Grey	Not recommended condition

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## MARTECH SERIES FACE PLATES

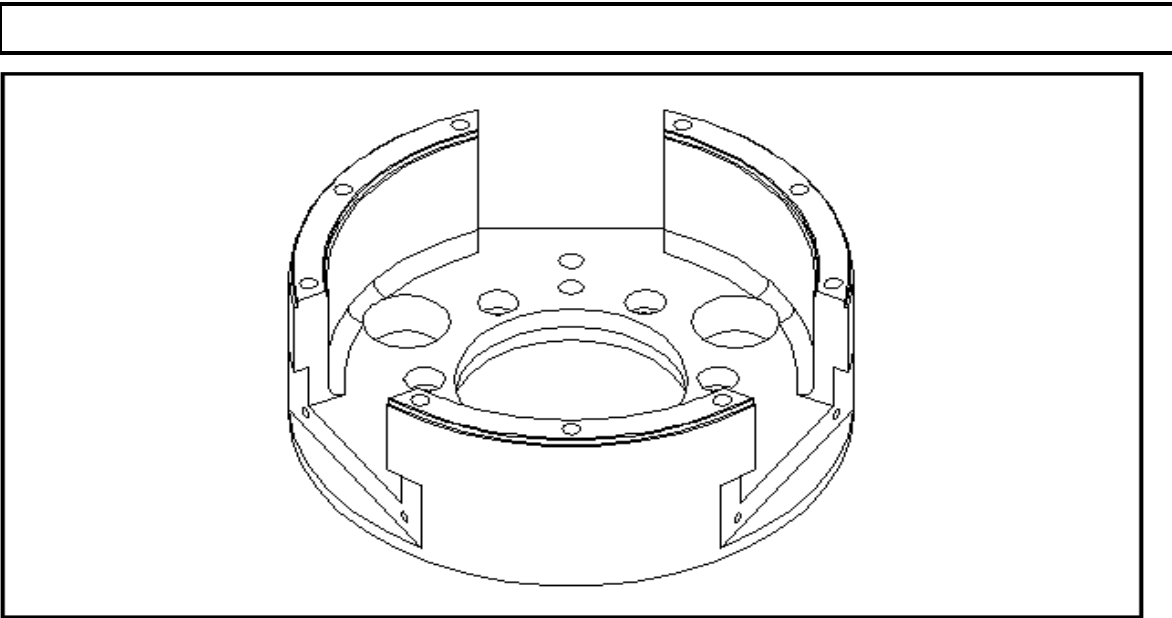


Part Number	Inch/Metric
MTI-30102	Non-Light Weight Inch-30000 series
MTI-30103M	Non-Light Weight Metric - MTI-30000 series
MTI-30104	Inch - MTI-30000 series
MTI-30105M	Metric - MTI-30000 series
MTI-35105	Inch - MTI-35000 series
MTI-35106M	Metric - MTI-35000 series
MTI-36103	Inch - MTI-36000 series
MTI-36104M	Metric - MTI-36000 series
MTI-50101	Inch - MTI-50000 series
MTI-50102M	Metric - MTI-50000 series

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## MARTECH SERIES RISER BODIES

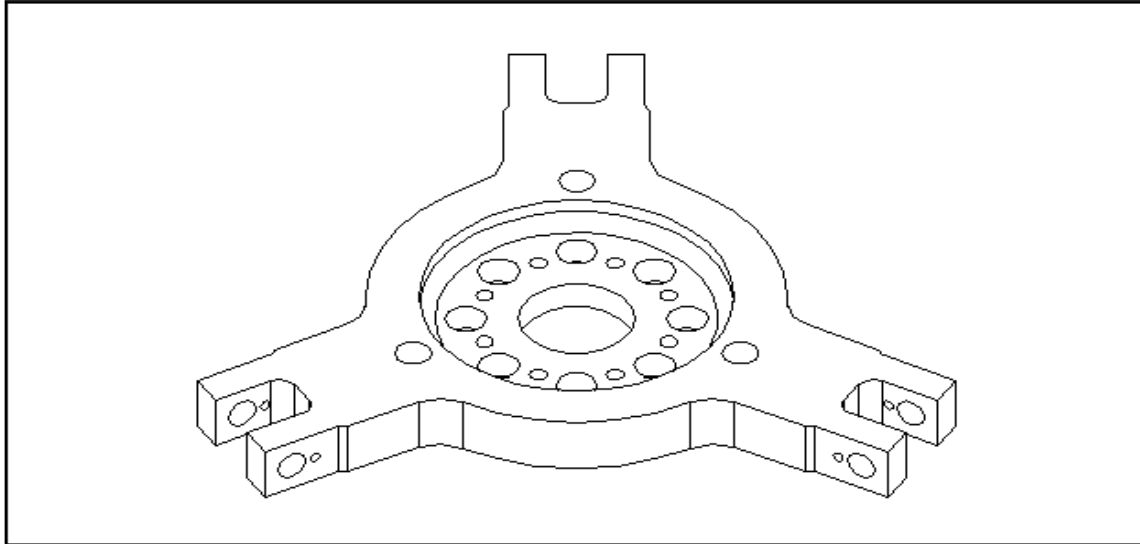


PART NUMBER	DESCRIPTION	SERIES
MTI-30201	INCH - A2/A8 <b>NON</b> ANTI/DEFLECTION	MTI-30000, 35000 & 36000 SERIES
MTI-30202	INCH - A2/A11 <b>NON</b> ANTI/DEFLECTION	MTI-30000, 35000 & 36000 SERIES
MTI-30209M	MERTIC - A2/A8 <b>NON</b> ANTI/DEFLECTION	MTI-30000, 35000 & 36000 SERIES
MTI-30239	INCH - A2/A8 ANTI-DEFLECTION CAPABLE	MTI-30000, 35000 & 36000 SERIES
MTI-30242M	METRIC - A2/A8 ANTI-DEFLECTION CAPABLE	MTI-30000, 35000 & 36000 SERIES
MTI-50201	INCH - A2/A8 ANTI-DEFLECTION CAPABLE	MTI-50000 SERIES
MTI-50202M	METRIC - A2/A8 ANTI-DEFLECTION CAPABLE	MTI-50000 SERIES

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## MARTECH SERIES YOKE PLATES



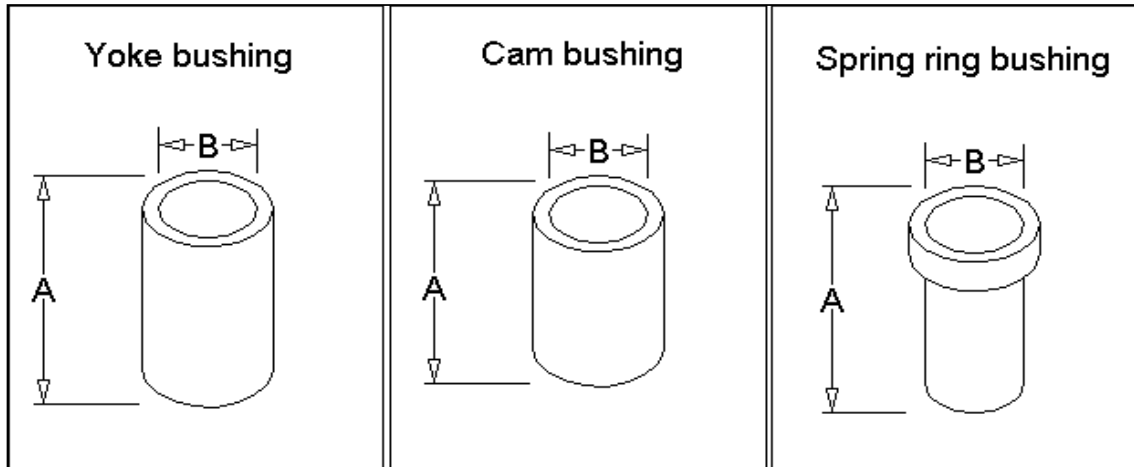
PART NUMBER	DESCRIPTION	SERIES
MTI-30302	INCH	MTI-30000 & MTI-35000
MTI-30303M	METRIC	MTI-30000 & MTI-35000
MTI-35301	INCH	MTI-30000 & MTI-35000
MTI-35306M	METRIC	MTI-30000 & MTI-35000
MTI-36301	INCH	MTI-36000
MTI-36302M	METRIC	MTI-36000
MTI-50301	INCH	MTI-50000
MTI-50303M	METRIC	MTI-50000

**Note:** All yokes shipped with a 3/4" diameter center holes unless otherwise specified. Articulating option available. Please inquire for part number and availability.

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## MARTECH MTI-30000 & MTI-35000 SERIES BUSHINGS



### THE FOLLOWING STANDARD YOKE BUSHINGS ARE AVAILABLE

PART NUMBER	"A" LENGTH	"B" INNER DIAMETER
MTI-30701	1-5/8" (1.625)	5/8" (.625)
MTI-30702	1-1/2" (1.500)	3/4" (.750)

### THE FOLLOWING STANDARD CAM BUSHINGS ARE AVAILABLE

PART NUMBER	"A" LENGTH	"B" INNER DIAMETER
MTI-30702	1-1/2" (1.500)	3/4" (.750)
MHS-40702	1-1/2" (1.500)	3/4" (.765)

### THE FOLLOWING STANDARD SPRING RING BUSHINGS ARE AVAILABLE

PART NUMBER	"A" LENGTH	"B" INNER DIAMETER
MTI-30704	1-3/4" (1.750)	5/8" (.625)
*MTI-30708*	1-3/4" (1.750)	5/8" (.625)

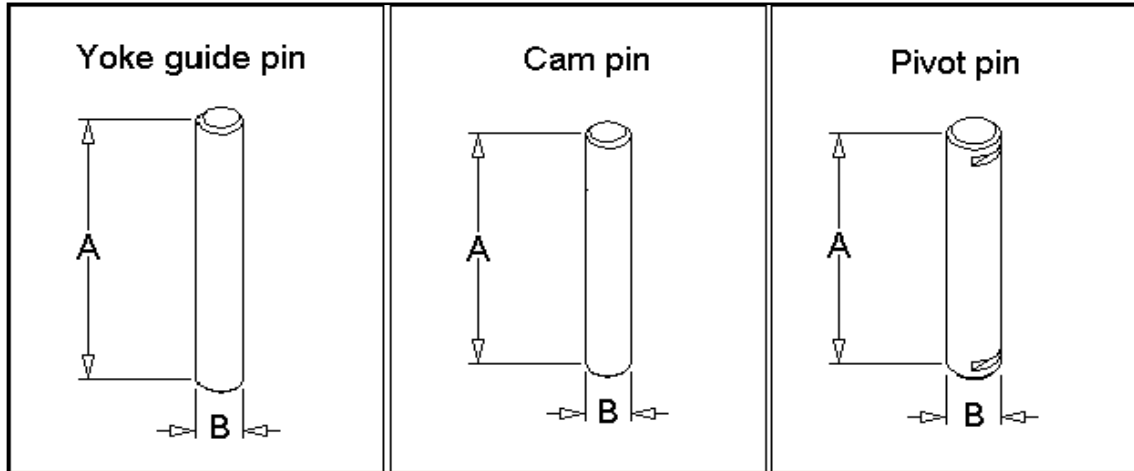
\* THREADED\*

( ) INDICATES NOMINAL DIMENSION

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**MARTECH MTI-30000, MTI-35000 AND MTI-50000 PINS**



**THE FOLLOWING STANDARD YOKE GUIDE PINS ARE AVAILABLE**

<b>PART NUMBER</b>	<b>"A" LENGTH</b>	<b>"B" DIAMETER</b>
MTI-30805N	4-3/8" (4.375)	5/8" (.625")
MTI-31803	4-3/4" (4.750)	3/4" (.750")

**THE FOLLOWING STANDARD CAM PINS ARE AVAILABLE**

<b>PART NUMBER</b>	<b>"A" LENGTH</b>	<b>"B" DIAMETER</b>
MTI-30802JC	3-7/8" (3.875")	5/8" (.625")
MTI-50802JC	3-7/8" (3.875")	(.708")

**THE FOLLOWING STANDARD PIVOT PINS ARE AVAILABLE**

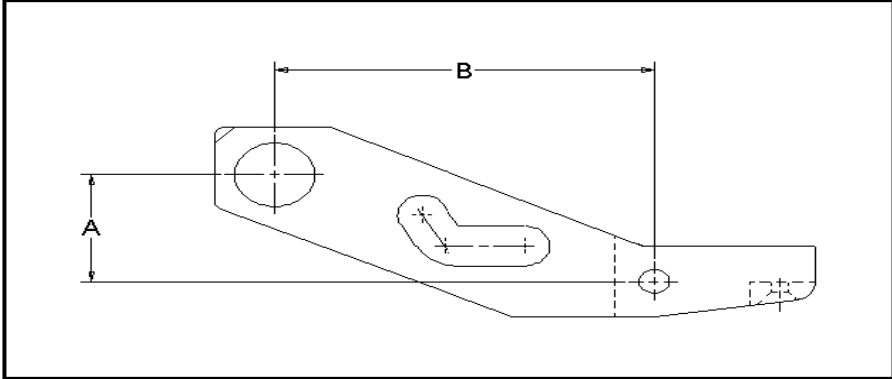
<b>PART NUMBER</b>	<b>"A" LENGTH</b>	<b>"B" DIAMETER</b>
MTI-30801N	3-7/8" (3.875")	3/4" (.749")
MHS-40801N	3-7/8" (3.875")	3/4" (.764")

() INDICATES NOMINAL DIMENSION

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**Martech MTI-30000 and MTI-35000 Series Cam Arms**



This following standard cam arms are available

Part Number	"A"	"B"
MTI-30401	1-3/16 (1.18)	4 (4.00)
MTI-30402	1-11/16 (1.68)	4 (4.00)
MTI-30403	2-3/16 (2.18)	4 (4.00)
MTI-30404	2-3/16 (2.18)	4-3/4 (4.75)
MTI-30405	1-11/16 (1.68)	4-3/4 (4.75)
MTI-30406	2-11/16 (2.68)	4-3/4 (4.75)
MTI-30407	1-3/16 (1.18)	4-3/4 (4.75)
MTI-30408	3-3/16 (3.18)	4-3/4 (4.75)
MTI-30411	2-3/4 (2.78)	4-3/4 (4.75)
MTI-30416	4-1/4 (4.27)	4-3/4 (4.75)
MTI-30417	2-1/4 (2.28)	4-3/4 (4.75)

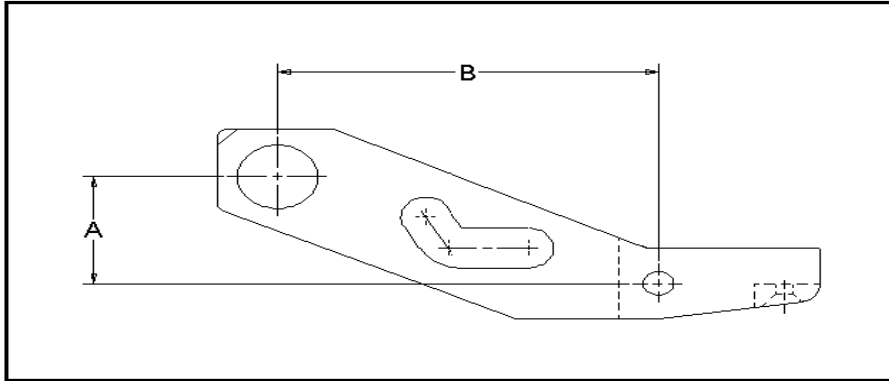
() Indicates nominal dimension

AUTOMATION SPECIALTIES INC.

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## Martech MTI -50000 Series Cam Arms



This following standard cam arms are available

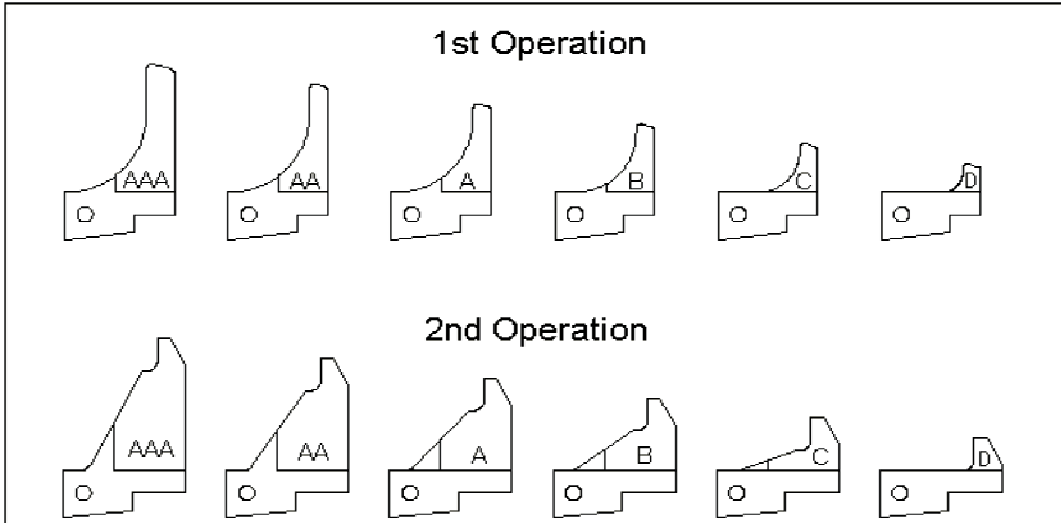
Part Number	"A"	"B"
MHS-40401	1-3/16 (1.18)	5 (5.00)
MHS-40402	1-11/16 (1.68)	5 (5.00)
MHS-40403	2-3/16 (2.18)	5 (5.00)
MHS-40404	2-3/4 (2.78)	5 (5.00)
MHS-40405	3-1/4 (3.28)	5 (5.00)
MHS-40406	4-1/4 (4.28)	5 (5.00)

( ) Indicates nominal dimension

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Martech MTI-30000, MTI-35000 and MTI-50000 Jaw Inserts



This following standard jaw inserts are available

Part Number	Size	Operation
MTI-306L1	AAA	1ST
MTI-306G3	AA	1ST
MTI-30601	A	1ST
MTI-30602	B	1ST
MTI-30603	C	1ST
MTI-30604	D	1ST
MTI-306L2	AAA	2ND
MTI-306G4	AA	2ND
MTI-30606	A	2ND
MTI-30607	B	2ND
MTI-30608	C	2ND
MTI-30609	D	2ND

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