Technical Details

Bar-Puller Body Features

- Pull diameters from 6.0 mm to 110.0mm (0.250” to 4.25”)
- Heavy duty springs allow strong grip force for up to 130lbs (60kg) of pull weight
- Available with 25.0mm, 1.0 inch or VDI40 shanks.
- Pull Round, Square, Rectangle or Hex bars

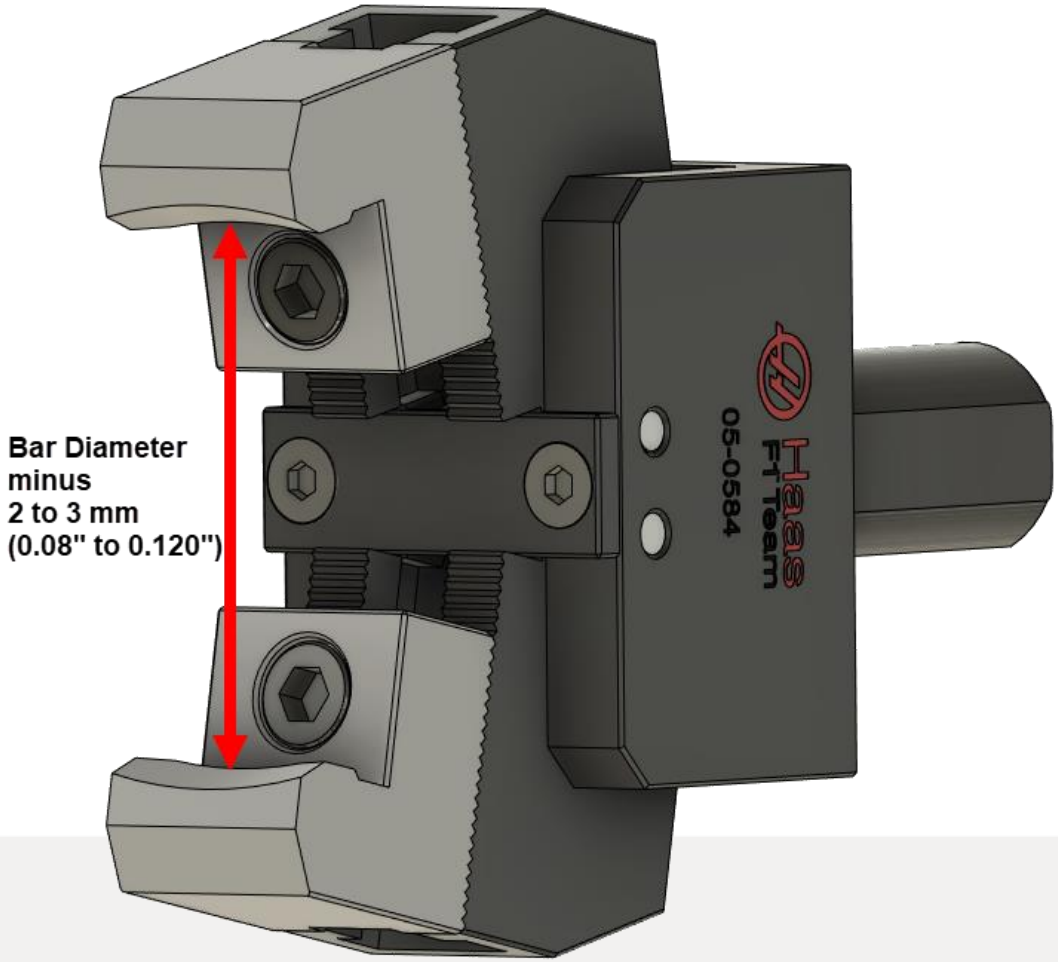
Bar-Puller Jaw Features

- Alloy steel Jaws hardened to 40Rc.
- Tapered at the front to slide over the bar smoothly
- Small Jaws adjustable from 6.0mm to 60.0mm (1/4” to 2 1/4”)
- Large Jaws adjustable from 54.0mm to 110.0mm (2 1/8” to 4 ¼”)

Bar-Puller Jaws

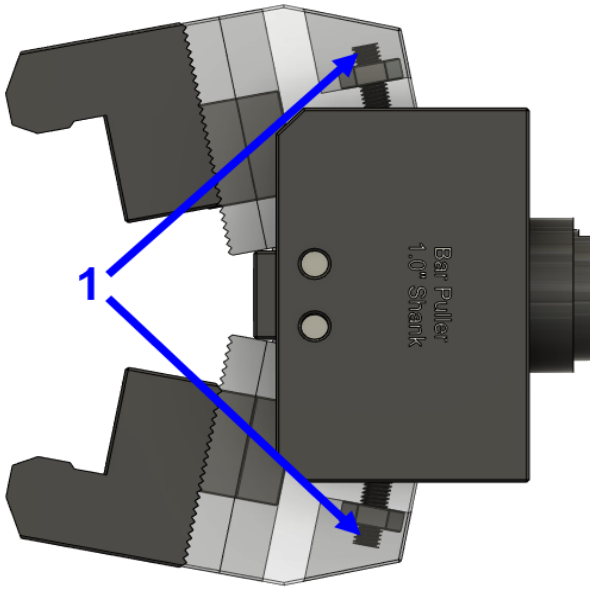
Bar-Puller Jaw Setting

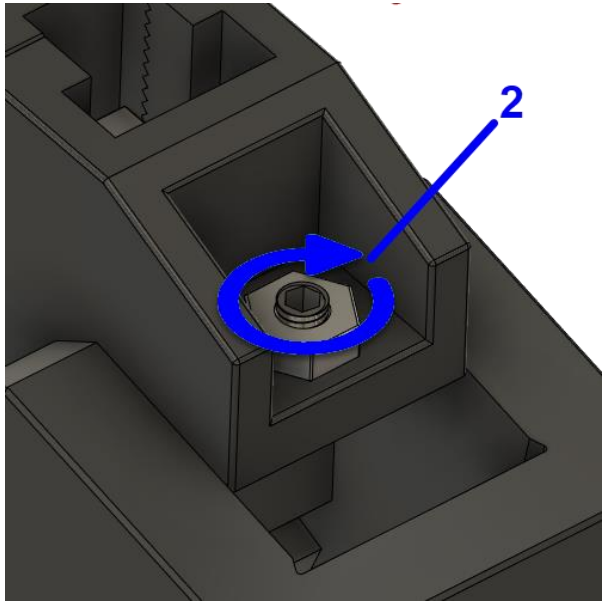
- Set jaw diameter to around 2.0mm to 3.0mm (0.08” to 0.12”) smaller than the bar diameter.
- Small jaws will typically need to be set around 2.0mm to 2.5mm (0.08” 0.1”) smaller than the bar.
- Large jaws will typically need to be set around 2.5mm to 3.0mm (0.1” to 0.12”) smaller than the bar

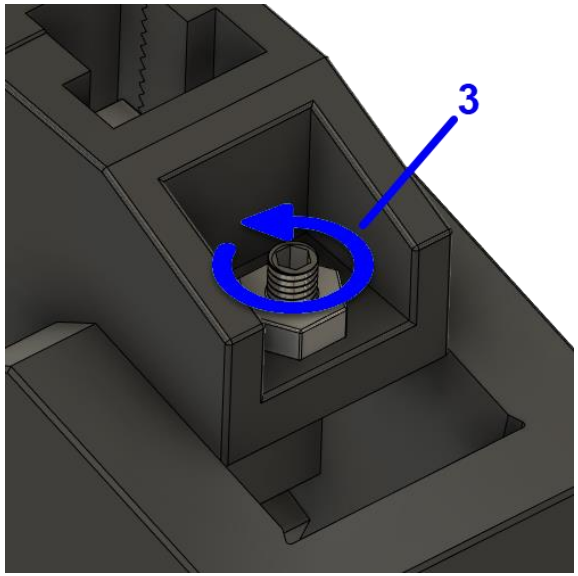


Technical Details

Grip Force Adjustment





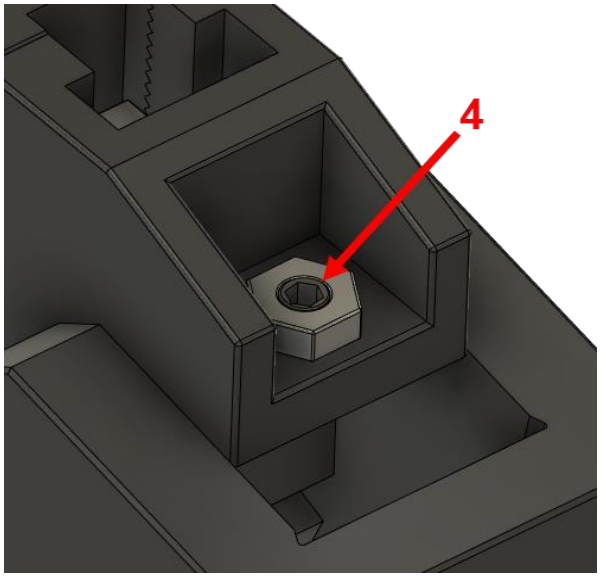


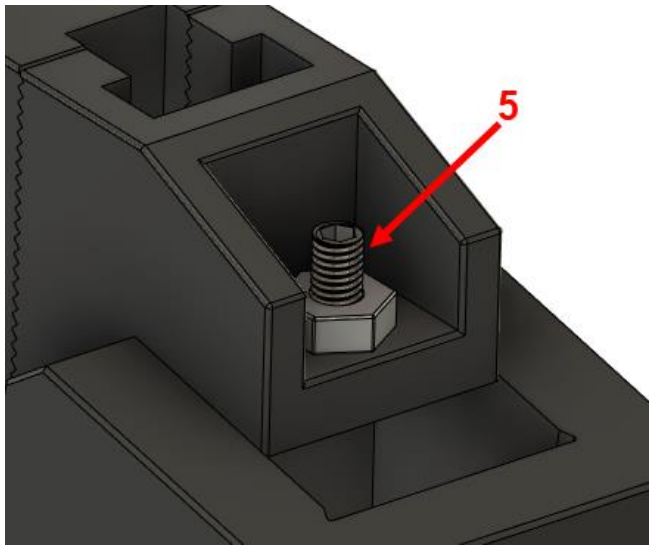
- Change the grip force by adjusting the set screws (1)
- Set each screw height evenly to maintain a balanced grip on each jaw.
- Tighten both screws clockwise to increase the grip force for larger heavier bars. (2)
- Loosen the set screws counterclockwise to decrease the grip force for smaller lighter bars. (3).

Technical Details

Set screw limits

- Set each screw height evenly to maintain a balanced grip on each jaw.
- Do not set the screw at the fully tightened position. Max grip force will be achieved at around half to one turn from fully tightened. (4)
- Check and make sure the master jaw leverage is sufficient by manually pressing the master jaws back.
- Do not keep grip force set at max when its not required. Spring tension life may be unnecessarily reduced.
- Similarly, do not over loosen the set screw (5). Around 3 turns from fully tightened should be sufficient.
- Loosening beyond 3 turns may release the spring from the internal assembly.



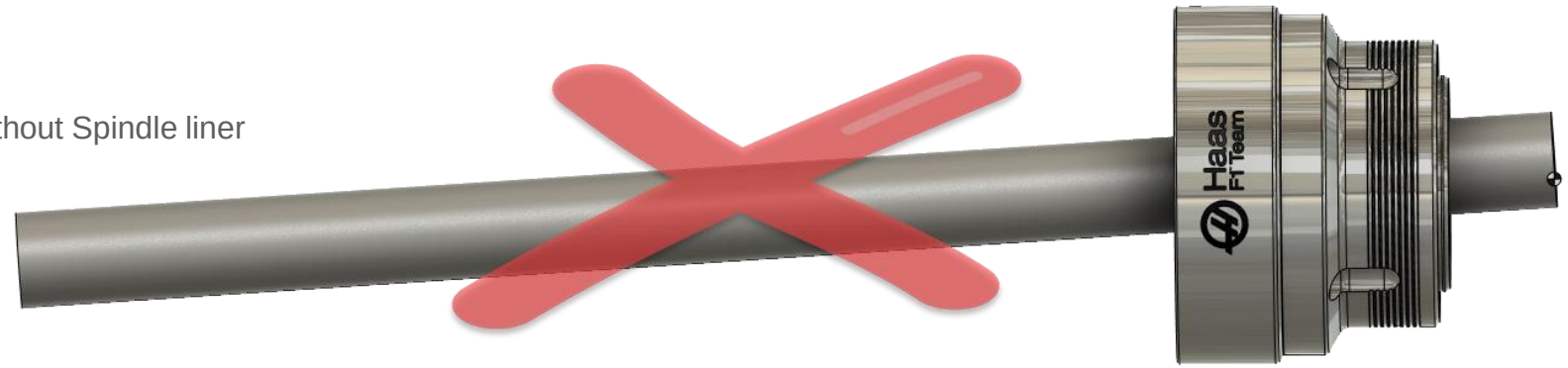


Pull Weight

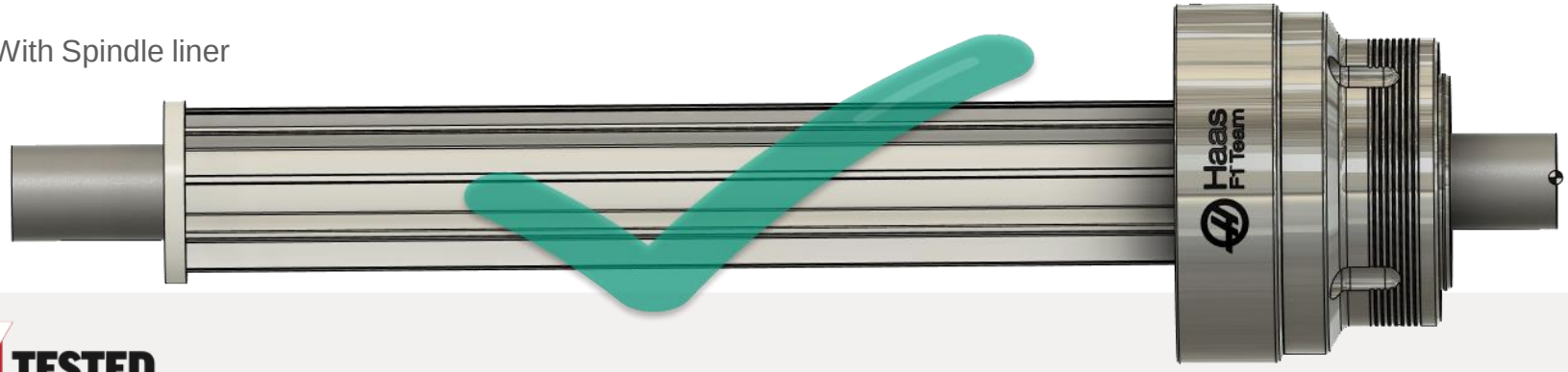
Bar Pulling Friction

- Friction will need to be considered in the bar-pull weight capacity.
- When the work holding is unclamped, an unsupported bar will typically drop in the spindle and hang on the jaws
- Both actions will cause high friction on the jaws and possible damage to the bar puller mechanism.
- Adding a Spindle liner will position your workpiece centrally and perpendicular to the spindle, consequently reducing the friction.
- Irregular or curved bars and rough or serrated jaws will also increase friction to the bar-pull motion.
- Its good practice to manually slide the bar back and forth after its first loaded and observe if there are any other friction issues.

Without Spindle liner



With Spindle liner



Bar-Puller Jaws

Bar-Puller Grip Length

- Do not set the bar grip length to the back face of the jaws.
- Meeting or exceeding this length will likely cause damage to the bar puller mechanism
- A gap between the bar face and the jaw face is required to maintain functionality
- Verify the minimum grip length is beyond the grip surface