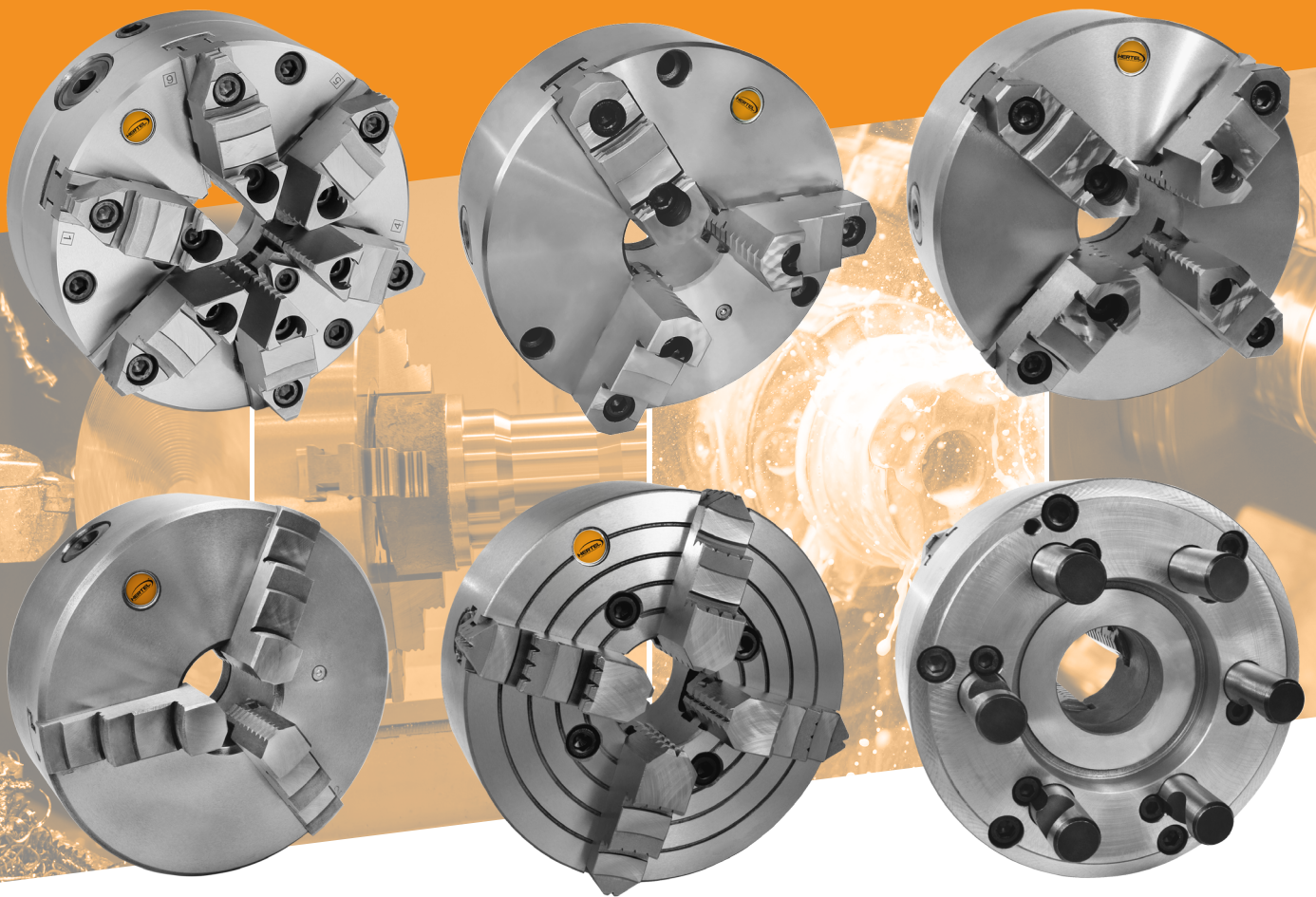


# Medium Duty Precision Scroll & Independent Lathe Chucks & Adapters



These **universal, versatile and durable chucks** are designed for a large variety of **turning, grinding, milling and drilling** medium duty applications.

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MSC Item #	Chuck Dia.	Item Description	Page #
<b>3 &amp; 6-Jaw Steel Scroll Chucks with Adjustable Body</b>			
97018683	5"	3-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018386	6-1/4"	3-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018931	8"	3-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018535	10"	3-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018824	12-1/2"	3-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018881	6-1/4"	6-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018428	8"	6-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018790	10"	6-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
97018600	12-1/2"	6-Jaw 2Pc. Adjust., Steel, Self-Centering Lathe Chucks	3
<b>3 &amp; 4-Jaw Semi-Steel Scroll Chucks with Plain Back &amp; Direct Mounts</b>			
97018667	6-1/4"	3-Jaw 2Pc. D-1 Direct Mnt., Semi-Steel, Self-Centering Lathe Chucks	4
97018741	8"	3-Jaw 2Pc. D1-4 Direct Mnt., Semi-Steel, Self-Centering Lathe Chucks	4
97018758	8"	3-Jaw 2Pc. D1-6 Direct Mnt., Semi-Steel, Self-Centering Lathe Chucks	4
97018501	10"	3-Jaw 2Pc. D1-6 Direct Mnt., Semi-Steel, Self-Centering Lathe Chucks	4
97018493	10"	3-Jaw 2Pc. D1-8 Direct Mnt., Semi-Steel, Self-Centering Lathe Chucks	4
97018410	5"	3-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018907	5"	3-Jaw 2Pc. Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018915	6-1/4"	3-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018865	6-1/4"	3-Jaw 2Pc. Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018451	8"	3-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018519	8"	3-Jaw 2Pc. Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018998	10"	3-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018485	10"	3-Jaw 2Pc. Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018972	12-1/2"	3-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018477	12-1/2"	3-Jaw 2Pc. Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018659	3-1/4"	3-Jaw SLD Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018691	4"	3-Jaw SLD Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018782	4"	3-Jaw SLD Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018808	5"	3-Jaw SLD Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018675	6-1/4"	3-Jaw SLD Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018642	8"	3-Jaw SLD Front Mount, Semi-Steel, Self-Centering Lathe Chucks	5
97018550	5"	4-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97019012	6-1/4"	4-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018402	8"	4-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018774	10"	4-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
97018576	12-1/2"	4-Jaw 2Pc. Plain Back, Semi-Steel, Self-Centering Lathe Chucks	5
<b>4-Jaw Semi-Steel Independent Chucks with Plain Back &amp; Direct Mounts</b>			
97018816	6-1/4"	4-Jaw SLD Plain Back, Semi-Steel, Independent Lathe Chucks	6
97018543	8"	4-Jaw SLD Plain Back, Semi-Steel, Independent Lathe Chucks	6
97018964	10"	4-Jaw SLD Plain Back, Semi-Steel, Independent Lathe Chucks	6
97018360	10"	4-Jaw SLD A2-6 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
97018634	8"	4-Jaw SLD D1-4 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
97018717	10"	4-Jaw SLD D1-4 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
97019004	10"	4-Jaw SLD D1-6 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
97018923	12-1/2"	4-Jaw SLD D1-6 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
97018899	12-1/2"	4-Jaw SLD D1-8 Direct Mnt., Semi-Steel, Independent Lathe Chucks	7
<b>Adapter Plates</b>			
12819199	8"	D1-6 Fully Finished, Steel Adjustable, Lathe Chuck Adapter Plates	8
12819132	10"	A-6 Fully Finished, Steel Adjustable, Lathe Chuck Adapter Plates	8
12819272	10"	D1-6 Fully Finished, Steel Adjustable Lathe Chuck Adapter Plates	8
12819231	8"	A-6 Pre-Machined, Steel Plain Back, Lathe Chuck Adapter Plates	8
12819041	8"	D1-6 Pre-Machined, Steel Plain Back, Lathe Chuck Adapter Plates	8

## 3 & 6-Jaw Medium Duty Forged Steel Body Scroll Chucks, With Fine Adjustment 0.0004" T.I.R.

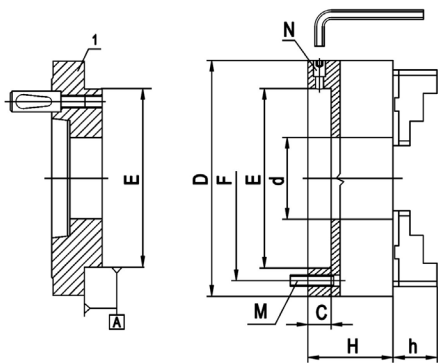
page  
3

Hertel Forged Steel Adjustable Body Scroll Chucks can be used for all high speed machining operations where universal chucks are unsuitable. High accuracy, versatility and durability make these chucks invaluable in the modern workshops and indispensable in the tool rooms.

- 3 Pinion design.
- 4 micro-fine adjustment screws allow 0.0004" T.I.R.
- Two-piece hard top and master jaws are American Standard tongue and groove.
- High quality forged steel body construction allows for higher speed and longer life.
- Forged and hardened scrolls are precisely ground and balanced.
- Jaws and pinions are hardened and precisely ground.
- Each assembled chuck is balanced within fine limit for the high speed machining.
- Proper chuck maintenance can extend the life of your chuck significantly.
- The 6-jaw chucks grip firmly with less pressure and less distortion per jaw.

### EACH CHUCK IS PROVIDED WITH:

**1 set** of hard master jaws, **1 set** of hard top reversible jaws, **1 set** of adapter mounting bolts,  
**1 set** of fine adjustment screws, **1** Spring loaded chuck T-wrench, **2** hex keys



### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Chuck Dia.	F	E	H	h	C	Mounting Bolts M	Fine Adjustment Screws N	Thru Hole Dia. d	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Order #
5"	4,2520	2,1654	2,362	1,575	0,59	M8x1.25 3	M12x1 4	1,398	3800	.118 - 4.92	11	97018683
6-1/4"	5,5118	3,3858	2,677	1,71	0,67	M10x1.5 3	M18x1 4	1,654	3500	.118 - 6.30	21	97018386
8"	6,9291	4,3307	3,071	1,77	0,71	M10x1.5 3	M18x1 4	2,165	3100	.175 - 7.87	39	97018931
10"	8,8189	5,7086	3,504	2,05	0,79	M12x1.75 3	M18x1 4	2,992	2700	.197 - 9.84	69	97018535
12-1/2"	11,2598	7,0866	3,819	2,24	0,79	M16x2 3	M18x1 4	4,055	2200	.394 - 12.40	123	97018824

See page 8 for Adapter Plates. Note: All Hertel Adjustable Adapter Plates are interchangeable with the Bison SET-TRUE ones

### 6-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

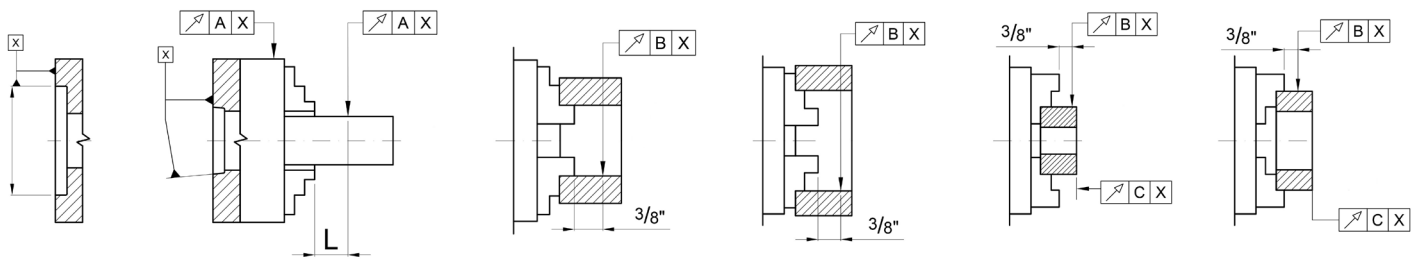
Chuck Dia.	F	E	H	h	C	Mounting Bolts M	Fine Adjustment Screws N	Thru Hole Dia. d	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Order #
6-1/4"	5,5118	3,3858	2,677	1,71	0,67	M10x1.5 3	M18x1 4	1,654	2500	.315 - 6.30	27	97018881
8"	6,9291	4,3307	3,071	1,77	0,71	M10x1.5 3	M18x1 4	2,165	2200	.315 - 7.87	41	97018428
10"	8,8189	5,7086	3,504	2,05	0,79	M12x1.75 3	M18x1 4	2,992	1900	.47 - 9.84	72	97018790
12-1/2"	11,2598	7,0866	3,819	2,24	0,79	M16x2 3	M18x1 4	4,055	1500	.47 - 12.40	115	97018600

See page 8 for Adapter Plates. Note: All Hertel Adjustable Adapter Plates are interchangeable with the Bison SET-TRUE ones

Hertel Universal Scroll Self-Centering Chucks provide high accuracy and durability for tool room and quality control applications. Perfect for use on lathes, grinders, rotary tables, CNC indexers in a variety of turning, milling and drilling medium duty and finishing applications. They are also very useful for inspections and laser markings.

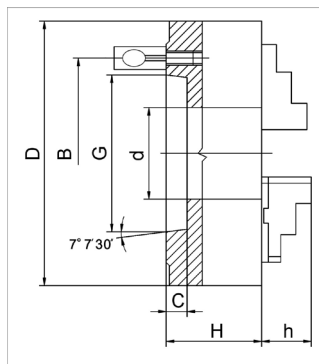
- All Hertel chucks come with either American Standard two-piece tongue and groove jaws, or with two sets of hard solid ID and OD Jaws.
- Chuck Body is made of high quality cast iron. All jaw guideways and bearing surfaces are precisely machined.
- Scroll plate is drop forged of fine alloy steel, hardened and ground.
- Hardened jaws and pinions increase life of the chuck.
- Hertel universal chucks are available with Plain Back, Camlock and A Mounts.

## Chuck Accuracy (T.I.R.)



Chuck Size		3-1/4"	4"	5"	6-1/4"	8"	10"	12-1/2"
Radial Runout	L	1,57	1,57	2,36	2,36	3,15	3,15	4,72
	A	0,0008	0,0008	0,0012	0,0012	0,0016	0,0016	0,002
	B	0,001	0,001	0,0014	0,0014	0,0018	0,0018	0,0022
Axial Runout		C	0,0006	0,0006	0,0008	0,0008	0,001	0,0012

## 3-Jaw Scroll Chucks, Semi-Steel Body with Two-Piece Hard Reversible Jaws Direct Mount 1



### EACH CHUCK IS PROVIDED WITH:

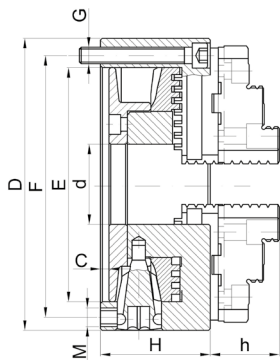
- 1 set** of hard master jaws, **1 set** of hard top reversible jaws, **1 set** of Camlock studs and set screws,  
**1** Spring loaded chuck T-wrench, **2** hex keys, **3** pinion design

## 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Chuck Dia.	Taper Size	Hole Dia. d	B	G	C	H	h	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Camlock Studs			Order #
											Dia.	Thread	Qty.	
6-1/4"	D1-4	1,6535	3,2520	2,5005	,5118	3,2087	1,693	3000	0.12 - 6.30	20	5/8	M10x1	3	97018667
8"	D1-4	2,1653	3,2520	2,5005	,5118	3,5827	1,8307	2500	0.16 - 7.87	42	5/8	M10x1	3	97018741
8"	D1-6	2,1653	5,2520	4,1880	,5905	3,5827	1,8307	2500	0.16 - 7.87	42	7/8	M16x1.5	6	97018758
10"	D1-6	2,9921	5,2520	4,1880	,6299	4,0748	2,1457	2000	0.20 - 9.84	71	7/8	M16x1.5	6	97018501
10"	D1-8	2,9921	6,7480	5,5007	,7087	4,0748	2,1457	2000	0.20 - 9.84	71	1	M20x1.5	6	97018493



## 3 & 4-Jaw Plain Back Scroll Chucks, Semi-Steel Body with Two-Piece Hard Reversible Jaws



### EACH CHUCK IS PROVIDED WITH:

**1 set** of Tongue & Groove hard master jaws, **1 set** of Tongue & Groove hard top reversible jaws, **1 set** of adapter mounting bolts, **1** Spring loaded chuck T-wrench, **2** hex keys, **3** pinion design

### 3-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Chuck Dia.	F	E (H7)	C	H	h	Thru Hole Dia. d	Mounting Bolts M	Front Mounting Bolts G	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Order # Plain Back	Order # Front Mount
5"	4,2520	3,7402	,1575	2,205	1,575	1,2598	M8x1.25 3	5/16"-18 3	3200	0.12 - 4.97	11	97018410	97018907
6-1/4"	5,5118	4,9213	,1575	2,539	1,693	1,6535	M10x1.5 3	3/8"-16 3	3000	0.12 - 6.30	22	97018915	97018865
8"	6,9291	6,2992	,1575	2,953	1,8307	2,1654	M10x1.5 3	3/8"-16 3	2500	0.16 - 7.87	39	97018451	97018519
10"	8,8189	7,8740	,1969	3,347	2,1457	2,9921	M12x1.75 3	1/2"-13 3	2000	0.20 - 9.84	55	97018998	97018485
12-1/2"	11,2598	10,2362	,1969	3,701	2,3622	4,0551	M16x2 3	5/8"-11 3	1500	0.39 - 12.40	110	97018972	97018477

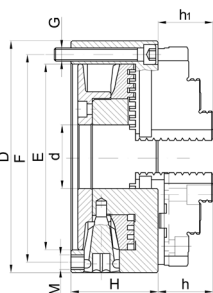
See page 8 for Adapter Plates. Note: All Hertel Adapter Plates are interchangeable with the Bison ones

### 4-Jaw Scroll Chucks with Two-Piece Hard Reversible Jaws

Chuck Dia.	F	E (H7)	C	H	h	Thru Hole Dia. d	Mounting Bolts M	Front Mounting Bolts G	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Order # Plain Back
5"	4,2520	3,7402	,1575	2,205	1,575	1,2598	M8x1.25 3	5/16"-18 3	3200	0.12 - 4.97	11	97018550
6-1/4"	5,5118	4,9213	,1575	2,539	1,693	1,6535	M10x1.5 3	3/8"-16 3	3000	0.12 - 6.30	22	97019012
8"	6,9291	6,2992	,1575	2,953	1,8307	2,1654	M10x1.5 3	3/8"-16 3	2500	0.16 - 7.87	39	97018402
10"	8,8189	7,8740	,1969	3,347	2,1457	2,9921	M12x1.75 3	1/2"-13 3	2000	0.20 - 9.84	55	97018774
12-1/2"	11,2598	10,2362	,1969	3,701	2,3622	4,0551	M16x2 3	5/8"-11 3	1500	0.39 - 12.40	110	97018576

See page 8 for Adapter Plates. Note: All Hertel Adapter Plates are interchangeable with the Bison ones

## 3-Jaw Plain Back Scroll Chucks, Semi-Steel Body with Two Sets of Hard Solid Jaws



### EACH CHUCK IS PROVIDED WITH:

**1 set** of hard solid ID jaws, **1 set** of hard solid OD jaws, **1 set** of adapter mounting bolts, **1** Spring loaded chuck T-wrench, **2** hex keys, **3** pinion design

### 3-Jaw Scroll Chucks with Two Sets of Hard Solid Jaws

Chuck Dia.	F	E (H7)	C	H	h1	Thru Hole Dia. d	Mounting Bolts M	Front Mounting Bolts G	RPM max.	Clamping Capacity Min. - Max.	Weight lbs.	Order # Plain Back	Order # Front Mount
3-1/4"	2,6378	2,2047	,1181	1,732	0.512	,6299	M6x1 3	1/4"-20 3	4000	0.08 - 2.80	3,3	97018659	-
4"	3,2677	2,7599	,1181	1,969	0.669	,7874	M8x1.25 3	5/16"-18 3	3500	0.12 - 3.27	6,2	97018691	-
5"	4,2520	3,7402	,1575	2,205	0,787	1,2598	M8x1.25 3	5/16"-18 3	3200	0.12 - 4.97	11	97018808	-
6-1/4"	5,5118	4,9213	,1575	2,539	1,260	1,6535	M10x1.5 3	3/8"-16 3	3000	0.12 - 6.30	22	97018675	-
8"	6,9291	6,2992	,1575	2,953	1,142	2,1654	M10x1.5 3	3/8"-16 3	2500	0.16 - 7.87	39	-	97018642

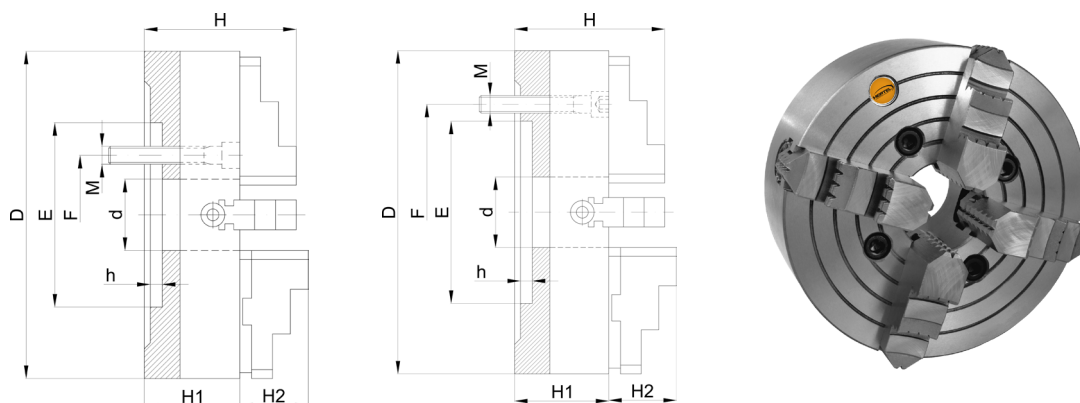
See page 8 for Adapter Plates. Note: All Hertel Adapter Plates are interchangeable with the Bison ones

## 4-Jaw Medium Duty Semi-Steel Body Independent Chucks Plain Back and Direct Mount A & D

Hertel 4-Jaw cast iron body independent chucks can be used for machining operations where scroll chucks are used and for variety operations where odd-shaped workpieces have to be machined. High accuracy, high gripping power and durability make them very useful on a variety of medium duty turning, milling, drilling or grinding operations. Chucks are provided with Hard Solid Reversible Jaws. High quality cast steel body construction.

- Hertel Independent Chucks are provided with Hard Solid Reversible Jaws.
- The high quality cast iron body allows for higher speed and longer life.
- The Jaws are made of hard quality steel and hardened.
- The thrust bearings and operating screws are made of case hardened steel.

## 4-Jaw Independent Medium Duty Semi-Steel Body with Hard Solid Reversible Jaws



### EACH CHUCK IS PROVIDED WITH:

1 set of hard solid reversible jaws, 1 set of adapter mounting bolts, 1 Spring loaded chuck T-wrench, 1 hex key, 10" chucks & larger are provided with T-Slots

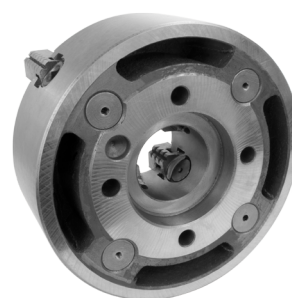
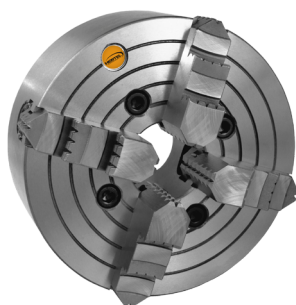
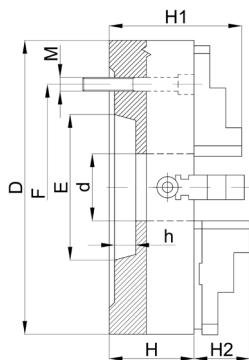
### 4-Jaw Independent with Hard Solid Reversible Jaws

Chuck Dia.	E (H7)	F	Hole d	H1	H	h	Chuck Mounting Bolts M		Clamping Capacity Min. - Max.	RPM max.	Weight lbs.	Order # Plain Back
							Thread M	Qty.				
6-1/4"	2,559	3,74	1,772	2,559	3,799	0,196	M10	4	0.315 - 6.30	3200	16	97018816
8"	2,953	3,74	2,205	2,953	4,331	0,236	M10	4	0.394 - 7.87	1800	22	97018543
10"	5,906	4,126	2,559	3,347	4,7	0,276	M12	4	0.394 - 9.84	1500	55	97018964

For above listed chucks, use BISON Semi-Finished Adapters.

## 4-Jaw Independent Medium Duty Semi-Steel Body with Hard Solid Reversible Jaws

### Direct A1/A2 Mounts



#### EACH CHUCK IS PROVIDED WITH:

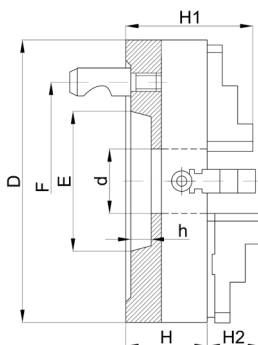
1 set of hard solid reversible jaws, 1 set of spindle mounting bolts, 1 Spring loaded chuck T-wrench, 1 hex key,  
10" chucks & larger are provided with T-Slots

### 4-Jaw Independent with Hard Solid Reversible Jaws

Chuck	Taper	E	F	d	Solid Jaws H1	H	h	Spindle Mounting Bolts			Clamping Capacity Min. - Max.	Weight lbs.	RPM*	Order # A Mount
Dia. D	No.							Thread M	L	Qty.				
10"	A2-6	4,188	5,250	2,953	4,700	3,347	0,591	1/2"-13	3-1/8	4	0.394 - 9.84	55	1500	97018360

Note: Above listed chucks can be mounted either on A1 or A2 spindle noses.

### Direct D1 Mount



#### EACH CHUCK IS PROVIDED WITH:

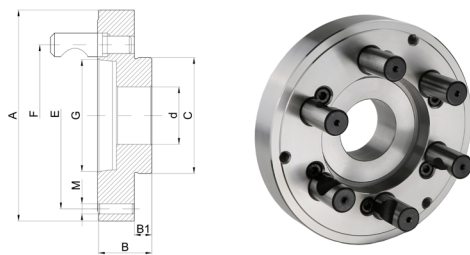
1 set of hard solid reversible jaws, 1 set of Camlock Studs, 1 Set of Camlock Stud Set Screws, 1 Spring loaded chuck T-wrench, 1 hex key,  
10" chucks & larger are provided with T-Slots

### 4-Jaw Independent with Hard Solid Reversible Jaws

Chuck	Taper	E	F	d	H	Solid Jaws H1	h	Camlock Studs			Clamping Capacity Min. - Max.	Weight lbs.	RPM*	Order # D1 Mount
Dia. D	No.							Dia.	Thread	Qty.				
8"	D1-4	2,501	3,252	2,205	2,953	4,331	0,5118	5 / 8	M10X1	3	0.394 - 7.87	22	1800	97018634
10"	D1-4	2,501	3,252	2,205	3,347	4,700	0,5118	5 / 8	M10X1	3	0.394 - 9.84	60	1500	97018717
10"	D1-6	4,188	5,252	2,953	3,347	4,700	0,6299	7 / 8	M16X1.5	6	0.394 - 9.84	60	1500	97019004
12-1/2"	D1-6	4,188	5,252	2,953	3,740	5,701	0,6299	7 / 8	M16X1.5	6	0.591 - 12.40	87	1200	97018923
12-1/2"	D1-8	5,501	6,748	3,740	3,740	5,701	0,7087	1	M20X1.5	6	0.591 - 12.40	87	1200	97018899

## D1 & A1/A2 Steel Adapters, Fully Machined for Adjustable Body 3 & 6-jaw Chucks

- D adapters come with the spindle mounting Camlock studs and set screws.
- All adapters do not require any additional machining.

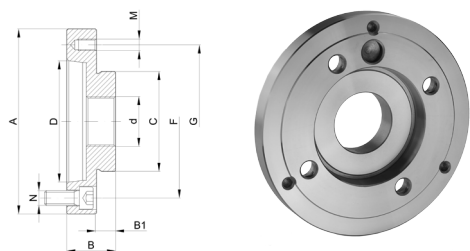


### D1 Mount, Adjustable Adapters

Chuck Dia.	Taper Size	OD A	D	Thru Hole d	F	C	E	Chuck Mounting Bolts M	B1	B	Camlock Studs		Weight lbs.	Order #
											OD	QTY		
8"	D1-6	7.87	4.1880	2.165	5.252	4.330	6.929	M10x1.50	.67	2.01	7/8"	6	17.64	12819199
10"	D1-6	9.84	4.1880	2.992	5.252	5.708	8.819	M12x1.75	.75	2.09	7/8"	6	28.44	12819272

See page 3 for Adjustable Body Chucks

- A adapters come with the spindle mounting bolts and hex key.
- All adapters do not require any additional machining.
- Below listed adapters can be mounted either on A1 or A2 spindle noses.



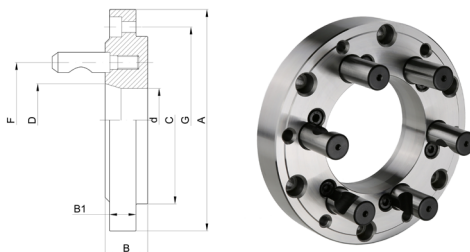
### A Mount, Adjustable Adapters

Chuck Dia.	Taper Size	OD A	D	Thru Hole d	F	C	G	Chuck Mounting Bolts M	B1	B	Spindle Mounting Bolts		Weight lbs.	Order #
											N	QTY		
10"	A6	9.84	4.1880	2.992	5.252	5.708	8.819	M12x1.75	.75	1.49	1/2-13	4	17.3	12819132

See page 3 for Adjustable Body Chucks

## D1 & A Pre-Machined Adapters for Plain Back Scroll Chucks

- Skim cut on the face of the adapter flange and boss is required to make a press fit between adapter boss (size C) and chuck counterbore.
- D1 adapters come with the Camlock Studs, set screws and hex key.
- A adapters come with the spindle mounting bolts and hex key.
- All adapters are made of steel.

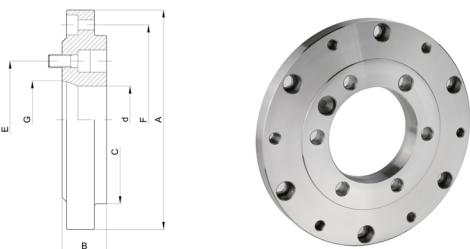


### D1 Mount, Plain Back Adapters

Chuck Dia.	Taper Size	Stud Dia.	No. of Studs	Hole Dia d	F	A	B	B1	D	C	G	Weight lbs.	Order #
8"	D1-6	7/8	6	4.06	5,252	7.87	1.44	1.3200	4,1880	6,378	6.9291	16,7	12819041

See page 5 for Plain Back Chucks

Below listed adapters can be mounted either on A1 or A2 spindle noses.



### A Mount, Plain Back Adapters

Chuck Dia.	Taper Size	A	B	Hole Dia d	E	F	D	C	G	Spindle Mounting Bolts	No. of Bolts	Weight lbs.	Order #
8"	A-6	7.87	.83	4.06	5.250	5,252	4,1880	6,378	6.9291	1/2-13	6	9,6	12819231

See page 5 for Plain Back Chucks

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