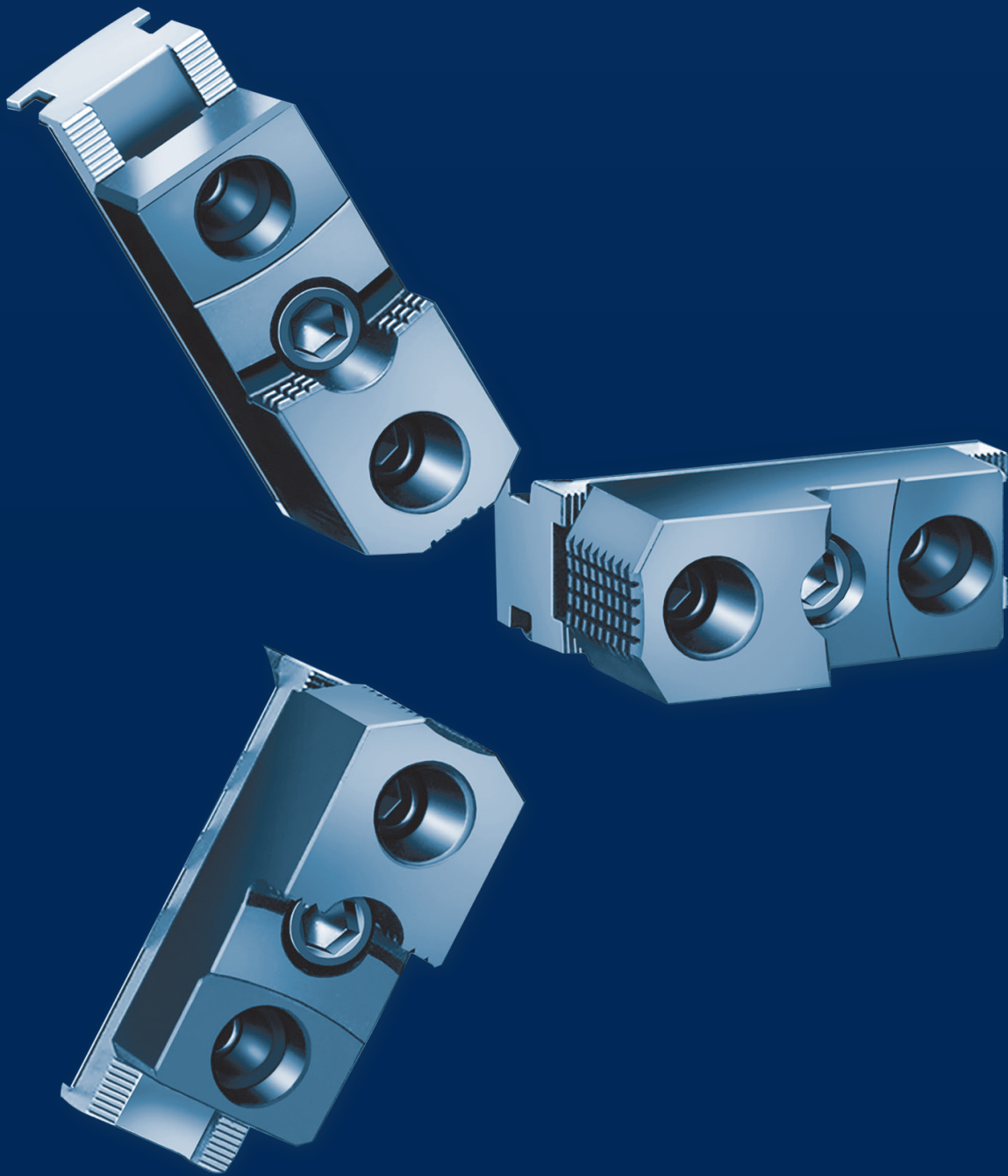
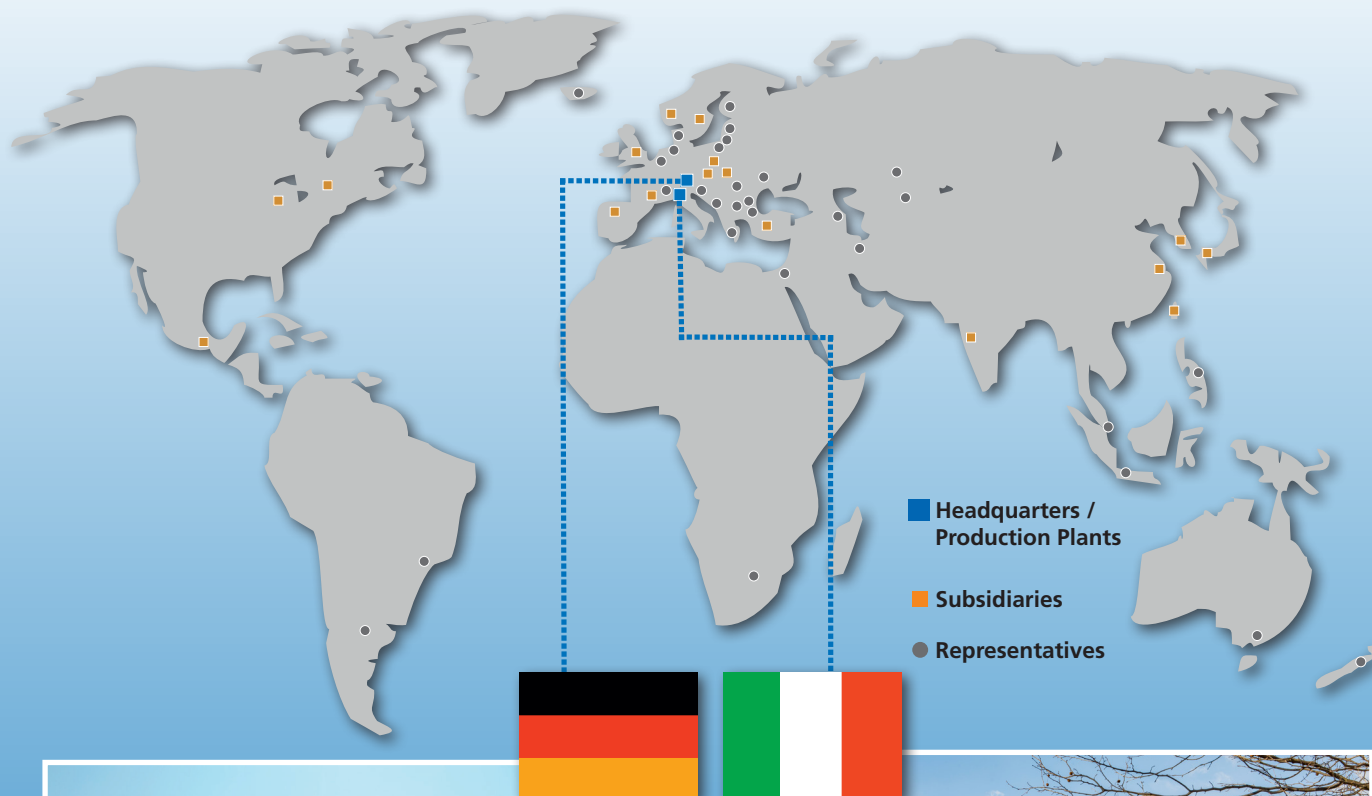




JAWS

SMW-AUTOBLOK worldwide



SMW-AUTOBLOK manufacturing plant Meckenbeuren
Development | Manufacturing | Sales | Service | Support



AUTOBLOK manufacturing plant Caprie-Torino



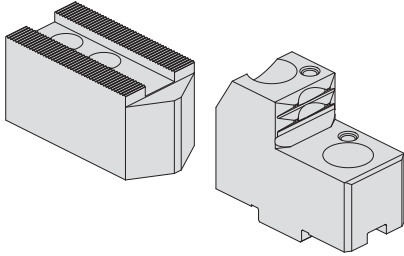
Visit our website: www.smw-autoblok.de

Latest product catalogues | Product innovations | Worldwide contact data | Tutor: Customer section

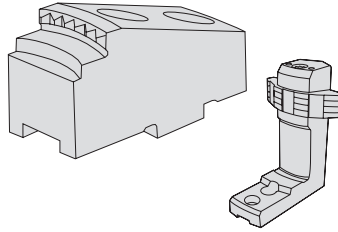
Free web applications: Jaw Finder | D-Vario Configurator | Update GFT-X 4.0

Top jaws from SMW-AUTOBLOK

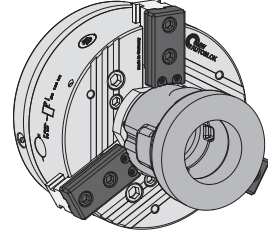
Top jaws for all standard manual and power chucks



■ Standard jaws serrated or tongue and groove



■ Special top jaws to customer specification



■ Turn key – i. e. complete engineering and production of top tooling

Customer benefit

Consulting

SMW-AUTOBLOK can call on many years of experience. This ensures best consulting for customer applications.

Engineering

The specialized SMW-AUTOBLOK Team can provide prompt and optimized solutions, that match the customer request.

Quality made in Germany

All SMW-AUTOBLOK top jaws are made in Germany from high quality steel.

They fulfill highest standards in quality, engineering, production and testing.

Delivery

All standard jaws are usually available from stock. Same day deliveries are possible on request.

Service

The worldwide SMW-AUTOBLOK sales network in more than 50 countries ensures best availability and competent consulting on site

Material

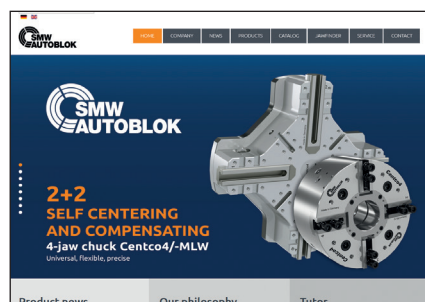
Material 16MnCr5
= Case hardening steel,
Material C45
= Quenching steel
Aluminum

>> Contact of our specialists

Telefon: +49 (0) 75 42 405-0
Fax: +49 (0) 75 42 405-181
E-Mail: sales@smw-autoblok.de

Further information

>> www.smw-autoblok.de



>> JAW FINDER

You are here: Start > JawFinder				
SMW-AUTOBLOK		KNCS-N		225
TYPE	ID.-NO.	JAW MODEL	SIZE	L X B X H
GGK 2001	012469	hard roughing jaws	2001	87 x 28 x 45
GGK 2002	012470	hard roughing jaws	2002	66 x 28 x 45
GGK 2003	012471	hard roughing jaws	2003	66 x 28 x 45

- Free application to easily pick your top jaw
- For all established makers
- 3D Modelle models available for download

Easy and quick choice of top jaw

>> www.smw-autoblok.de

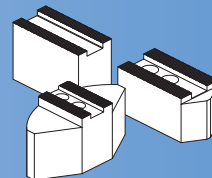
0

Soft top jaws

Steel | Aluminum

Inch serration

1/16" x 90° or 3/32" x 90°



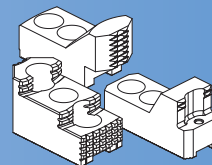
Page 9

1

Hard top jaws

Inch serration

1/16" x 90° or 3/32" x 90°



Page 29

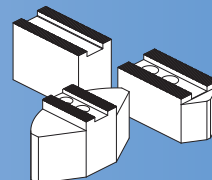
2

Soft top jaws

Steel | Aluminum

Metric serration

1.5 x 60° or 3 x 60°



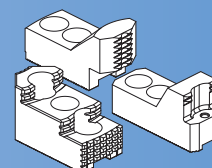
Page 41

3

Hard top jaws

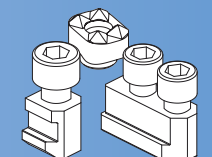
Metric serration

1.5 x 60° or 3 x 60°



Page 57

4

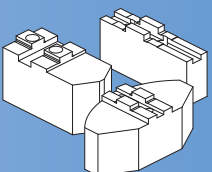
T-Nuts**Grippers**

Page 69

5

Soft top jaws

Tongue & groove

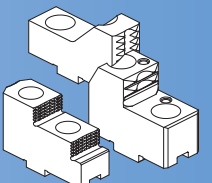


Page 87

6

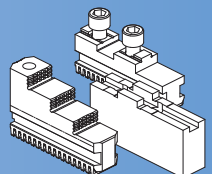
Hard top jaws

Tongue & groove



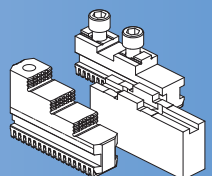
Page 101

7

Quick jaw changeFor manual and power chucks
straight modular serration
system SMW-AUTOBLOK

Page 109

8

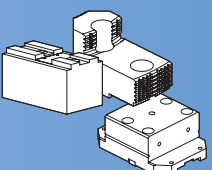
Quick jaw changeFor manual and power chucks
helix modular serration System Forkardt

Page 137

9

Jaws

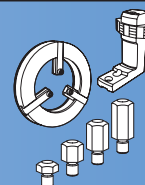
For application chucks



Page 147

10

Special jaws | Boring rings
Cleaning plate | Gripping force tester
Calculations

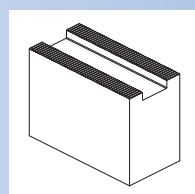


Page 157

Soft top jaws – Inch serration

SMW-AUTOBLOK | Forkardt | Röhme | Schunk

0



MAB-D

Without holes
16MnCr5

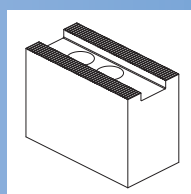
Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 11

MAB-DL

Without holes
16MnCr5
Long version



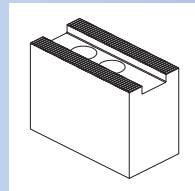
MAB-D

With holes for 2-jaw chucks
16MnCr5 / C45

Soft top jaws for 2-jaw chucks

- Inch serration
1/16" x 90°

Page 24



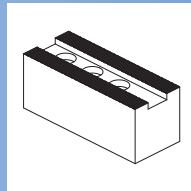
MAB-D

With holes
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°
- Bolt pattern to customer request

Page 11



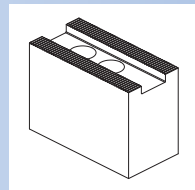
WBSA-D

for SMW-AUTOBLOK power chucks
C45 (flame hardenable)

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 25



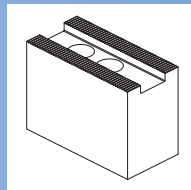
MWB-D

Tall version
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 12



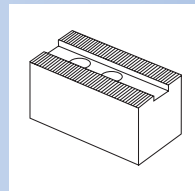
WBB-D

for Berg power chucks type KH
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° serration ground

Page 26



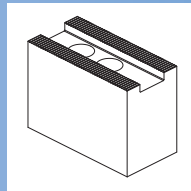
MWB-DA

Light version
Aluminum F50

Soft top jaws aluminum

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 14



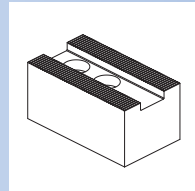
WBR-D

for Röhme power chucks type KFD-HS
for Schunk power chucks type HSG
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° serration ground

Page 26



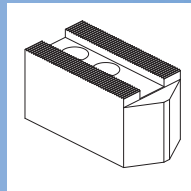
LWB-D

Low version
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 16



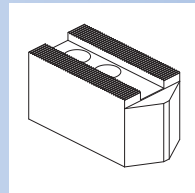
Soft top jaws

for front end power chucks
16MnCr5 / C45 (flame / induction hardening)

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 27



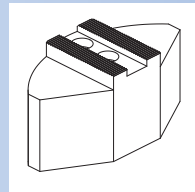
AWB-D

Low / pointed version
16MnCr5

Soft top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 18



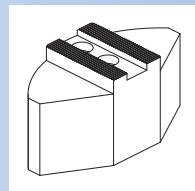
SBS-D

16MnCr5

Soft pie jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 20



SBA-D

Aluminum F50

Soft pie jaws aluminum

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 22

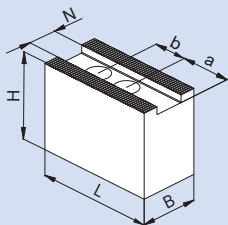
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

MAB-D



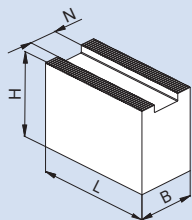
Soft top jaws blanks without holes and with holes drilled

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5 , Serration ground

Type	Id. No. without holes	Id. No. with holes*	B	H	L	N	Serration	a + b	ISO 4762	kg / piece without holes
MAB-D 1002	081562	032932	35	50	60	10	1/16" x 90°	*	M 6	0.55
MAB-D 1202	081564	032934	35	50	70	12	1/16" x 90°	*	M 8	0.92
MAB-D 1401	090717	091315	40	40	90	14	1/16" x 90°	*	M 10	1.07
MAB-D 1402	090718	091316	40	60	90					1.63
MAB-D 1710	081566	032936	40	40	70	17	1/16" x 90°	*	M12	0.82
MAB-D 1711	081567	032937	40	40	90					1.06
MAB-D 1712	081568	032938	40	40	105					1.24
MAB-D 1713	081569	032939	40	60	70					1.26
MAB-D 1714	081571	032940	40	60	90					1.62
MAB-D 1715	081572	032941	40	60	120					2.16
MAB-D 1716	081573	032942	40	80	90					2.18
MAB-D 1718	081575	032944	40	120	90					3.31
MAB-D 1730	081576	032945	50	80	90					2.74
MAB-D 1751	081579	032948	60	60	90					2.46
MAB-D 1760	081583	032952	80	60	90					3.30
MAB-D 2101	081584	032953	45	60	90	21	1/16" x 90°	*	M16	1.82
MAB-D 2111	081588	032956	50	50	120					2.24
MAB-D 2112	081589	032957	50	80	90					2.73
MAB-D 2113	081590	032958	50	80	120					3.64
MAB-D 2114	035239	091317	50	100	120					4.58
MAB-D 2115	090721	091318	50	80	150					4.55
MAB-D 2120	081591	032959	60	60	90					2.45
MAB-D 2125	081596	032964	60	100	120					5.51
MAB-D 2126	081597	032965	60	120	120					6.63
MAB-D 2141	233366	233367	80	80	120					5.88
MAB-D 2501	081599	032967	60	60	140	25.5	3/32" x 90°	*	M 20	3.77
MAB-D 2502	081600	032968	60	80	140					5.08
MAB-D 2503	081601	032969	60	100	155					7.07
MAB-D 2504	081602	032970	60	120	155					8.52
MAB-D 2505	081603	032971	60	150	155					10.70
MAB-D 2506	090720	091319	60	100	200					9.13
MAB-D 2511	081605	032973	80	80	155					7.55

* Indicate when ordering the version with holes drilled.

MAB-DL



Soft top jaws blanks Long version without holes

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5 , Serration ground

Type	Id. No. without holes	B	H	L	N	Serration	kg / piece
MAB-DL 120	233363	35	60	420	12	1/16" x 90°	6.70
MAB-DL 140	233364	35	60	420	14	1/16" x 90°	6.70
MAB-DL 170	233365	40	60	420	17	1/16" x 90°	7.60
MAB-DL 171	233310	40	100	420	17	1/16" x 90°	12.80
MAB-DL 210	233316	50	60	420	21	1/16" x 90°	9.40
MAB-DL 211	233368	50	120	420	21	1/16" x 90°	19.30
MAB-DL 250	233369	60	100	420	25.5	3/32" x 90°	19.20

Other dimensions on request.

Please use the data sheet on page 28 for ordering.



SMW-AUTOBLOK
28, 158, 160

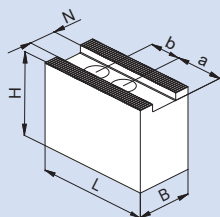


SMW-AUTOBLOK
69



SMW-AUTOBLOK
80

MWB-D



Soft top jaws Tall version

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5, Serration ground

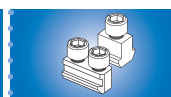
Type	Id. No.	B	H	L	N	Serration	a + b f. ISO 4762	kg / Set
MWB-D 111	007094	20	30	52	8	1/16" x 90°	26.5 + 12 M6	0.56
MWB-D 130	013488	30	40	55	12	1/16" x 90°	29 + 16 M8	1.25
MWB-D 165	233372	35	60	70	14	1/16" x 90°	33 + 16.5 M10	2.78
MWB-D 165/4	5318607**	35	60	70	14	1/16" x 90°	33 + 16.5 M10	2.78
MWB-D 160	013489	40	60	70	17	1/16" x 90°	33 + 22 M12	3.02
MWB-D 200	013490	40	60	90	17	1/16" x 90°	43 + 22 M12	4.09
MWB-D 200/4	5318837**	40	60	90	17	1/16" x 90°	43 + 22 M12	4.09
MWB-D 250	013491	50	80	120	21	1/16" x 90°	62 + 28 M16	9.16
MWB-D 250/4	5319680**	50	80	120	21	1/16" x 90°	62 + 28 M16	9.16
MWB-D 400	013492	60	90	155	25.5	3/32" x 90°	90 + 35 M20	16.21
MWB-D 400	5319831	60	90	155	25.5	3/32" x 90°	90 + 35 M20	21.6

* With single T-nuts only

** 1 Set = 4 pieces



• SMW-AUTOBLOK
• 28, 158, 160



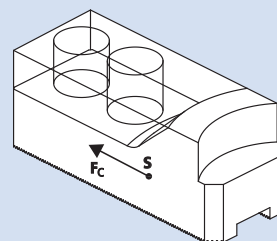
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

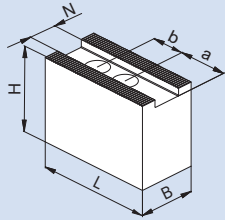


**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.**
Always lighten the top jaws when using them at high speeds!



SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D110			
AN/AL-D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125 HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165 BHD-FC 165 PB/PBI/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180 Centco4-D 210	KTH 130/140	KFD 130 • KFH 140 KFD-HS 160/175 KFD-HE 170 LVE 125/160	HSG 160 ROTA NCD 165
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226 BP-D 220/260	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226 BP-D 220/260	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200 KFL 250	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NC plus 215 ROTA NCK plus 210/250 ROTA NCF plus 215 ROTA 2B 160 ROTA TP 200
Centco4-D 260/315			
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400 BP-D 320	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NC plus 260/315 ROTA NCK plus 315 ROTA NCF plus 315 ROTA TP 250/315/350 TP 250/315 ROTA EP 500
Centco4-D 400			
HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYDL-S 500/630/800 Centco4-D 500/630	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500/630 ROTA NCF/ROTA NCO 400/500/630 ROTA EP 380/460 ROTA EP-LH 460 ROTA TB 400/470/500/600 ROTA TB-LH TB 400/470/500/600 ROTA NCO 800

MWB-DA



Soft top jaws aluminum Light version

- Less jaw mass (3 x lighter than steel jaws)
- Higher chip removal at higher speeds
- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: aluminum (tensile strength = 500 N/mm²)

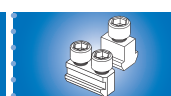
Type	Id. No.	B	H	L	N	Serration	a + b f. ISO 4762	kg / Set
MWB-DA 165	036011	40	60	70	14	1/16" x 90°	36 + 22 M10	1.17
MWB-DA 200	081645	40	60	90	17	1/16" x 90°	43 + 22 M12	1.50
MWB-DA 250	081646	50	80	120	21	1/16" x 90°	62 + 28 M16	3.26
MWB-DA 400	081647	60	100	155	25.5	3/32" x 90°	90 + 35 M20	6.38

* With single T-nuts only



• SMW-AUTOBLOK
• 28, 158, 160

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• SMW-AUTOBLOK
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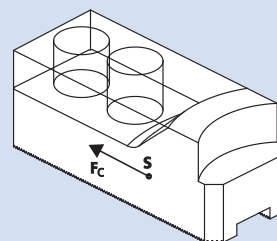


• SMW-AUTOBLOK
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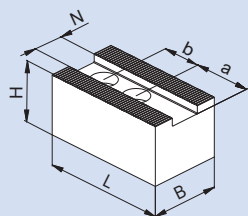


Aluminum jaws are subject to centrifugal force.
Also lighten these jaws for less loss of grip force!



SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180* HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KS 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TP 160 Rota TP 160 TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400 HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYDL-S 500/630/800	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315 QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315 KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315 TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

LWB-D



Soft top jaws low version

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5, Serration ground

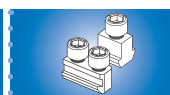
Type	Id. No.	B	H	L	N	Serration	a + b f. ISO 4762	kg / Set
LWB-D 160	081613	40	40	80	17	1/16" x 90°	43 + 22 M12	2.38
LWB-D 200	081615	40	40	90	17	1/16" x 90°	53 + 22 M12	2.73
LWB-D 250	081617	50	50	120	21	1/16" x 90°	70 + 28 M16	5.73
LWB-D 400	081620	60	60	140	25.5	3/32" x 90°	80 + 35 M20	9.56

* With single T-nuts only



• SMW-AUTOBLOK
• 28, 158, 160

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• SMW-AUTOBLOK
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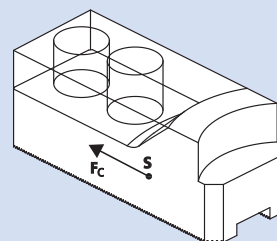


• SMW-AUTOBLOK
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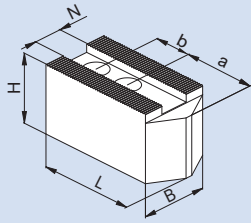


**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.**
Always lighten the top jaws when using them at high speeds!



SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYDL-S 500/630/800	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

AWB-D



Soft top jaws low / pointed version

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5, Serration ground

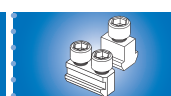
Type	Id. No.	B	H	L	N	Serration	a + b f. ISO 4762	kg / Set
AWB-D 110	038258	20	30	55	8	1/16" x 90°	30 + 12 M6	0.59
AWB-D 165	035954	40	40	80	14	1/16" x 90°	43 + 22 M10	2.32
AWB-D 165/4	5318608**	40	40	100	14	1/16" x 90°	43 + 22 M12	2.4
AWB-D 160	081614	40	40	80	17	1/16" x 90°	43 + 22 M12	2.19
AWB-D 200	081616	40	40	90	17	1/16" x 90°	53 + 22 M12	2.61
AWB-D 200/4	5318838**	40	40	110	17	1/16" x 90°	53 + 22 M12	2.7
AWB-D 250	081618	50	50	120	21	1/16" x 90°	70 + 28 M16	5.37
AWB-D 250/4	5319681**	50	50	120	21	1/16" x 90°	70 + 28 M16	5.4
AWB-D 315	081619	50	50	140	21	1/16" x 90°	90 + 28 M16	6.48
AWB-D 400	5319834**	60	60	170	25.5	3/32" x 90°	115 + 35 M20	14.5

* With single T-nuts only

** 1 Set = 4 pieces



• SMW-AUTOBLOK
• 28, 158, 160



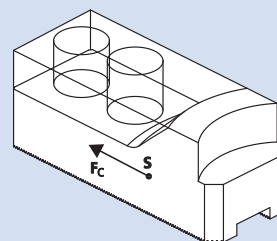
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

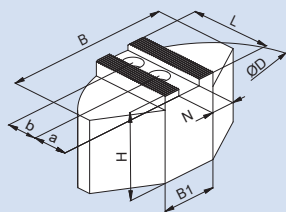


**Reduced jaw mass =
Reduced loss of grip force on the chuck under rotation.**
Always lighten the top jaws when using them at high speeds!



SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D 110			
HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180* HFKS-2G-D 165 Centco4-D 210			TP 160 ROTA TP 160
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/ PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226 HFKS-2G-D 210 Centco4-D 260/315	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400 HFKS-2G-D 255/320 Centco4-D 400	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 315 BHD-FC 315 RC-D 305/400 CC 350Z HB/PB/PBI-D 315 AP/APL/NT-D 315 HYND-S 250/315/400* Centco4-D 500/630	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTGF 315 KLNC/NH/NHF 315 KS 315/400 KSPS 300 KSH/KSHF 315/400 HF315 UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/ROTA NCD/ROTA NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315

SBS-D



Soft pie jaws

- Less deformation of easily deformed parts with wrap around jaws
- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5, Serration ground

Type	Id. No.	B	B1	H	L	D	N	Serration	a + b f. ISO 4762	kg / Set
SBS-D 165	035154	120	40	60	60	165	14	1/16" x 90°	25 + 22 M10	6.11
SBS-D 165	5318610**	120	40	60	60	165	14	1/16" x 90°	25 + 22 M12	7.10
SBS-D 160	081639	120	40	60	60	160	17	1/16" x 90°	25 + 22 M12	5.88
SBS-D 200/4	5318839**	120	60	60	70	200	17	1/16" x 90°	35 + 22 M12	10.22
SBS-D 200	081640	140	64	60	70	200	17	1/16" x 90°	35 + 22 M12	8.83
SBS-D 250/21	081642	180	104	70	80	250	21	1/16" x 90°	30 + 29*** M16	14.49
SBS-D 250/4	5319684**	180	104	70	80	250	21	1/16" x 90°	30 + 29*** M16	18.27
SBS-D 600/4	5322250**	330	160	85	140	660	21	1/16" x 90°	75 + 29*** M20	56.30
SBS-D 400	133459	330	150	85	155	440	25.5	3/32" x 90°	85 + 35 M20	53.49
SBS-D 400/4	5319832**	330	190	85	155	440	25.5	3/32" x 90°	85 + 35 M20	53.20
SBS-D 1200/4	5322251**	500	360	85	155	1200	25.5	3/32" x 90°	85 + 35 M20	85.56

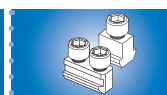
* With single T-nuts only

** 1 Set = 4 pieces

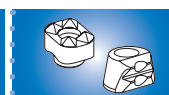
*** Can be used with double T-nuts hole spacing 28 mm and 30 mm



• SMW-AUTOBLOK
• 28, 158, 160



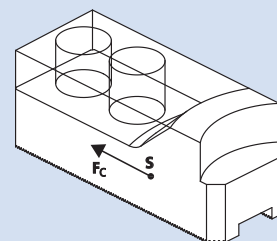
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

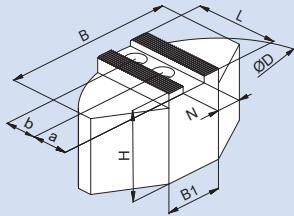


Pie jaws are heavy!
High jaw mass = high loss of grip force under rotation.
 Lighten the jaws for high speeds!



SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PBI/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180* Centco4-D 210			TP 160 ROTA TP 160
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
Centco4-D 260/315 Centco4-MLW-D 400			
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 200 QLK/QLC-KS 200/250 QLK/QLC-LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 KSF 200 KGH/KGHF/KTH 200 KG/KP 200 UVE 200/250	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210/250 ROTA 2B ROTA TP 200 TP 200
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PBI-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400 Centco4-D 400 Centco4-MLW-D 600/750	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYDL-S 500/630/800	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500
Centco4-D 500/630 Centco4-MLW-D 1000/1200/1400			

SBA-D



Soft pie jaws aluminum light version

- Less deformation of easily deformed parts with wrap around jaws
- Less jaw mass (3 x lighter than steel jaws)
- Higher chip removal at higher speeds
- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: aluminum (tensile strength = 500 N/mm²)

Type	Id. No.	B	B1	H	L	D	N	Serration	a + b f. ISO 4762	kg / Set
SBA-D 165	5318609**	110	40	58	58	165	14	1/16" x 90°	25 + 20 M10	2.40
SBA-D 165	035155	120	40	58	59.5	165	14	1/16" x 90°	25 + 20 M10	2.06
SBA-D 160	081648	120	40	58	59.5	165	17	1/16" x 90°	22 + 22 M12	2.00
SBA-D 200	5318840**	120	50	58	75	200	17	1/16" x 90°	35 + 22 M12	3.64
SBA-D 200	081649	140	50	58	72.5	200	17	1/16" x 90°	35 + 22 M12	3.02
SBA-D 250/21/4	5319685**	160	70	78	90	250	21	1/16" x 90°	40 + 29*** M16	7.17
SBA-D 600/4	5322254**	330	160	85	140	660	21	1/16" x 90°	25 + 29*** M16	20.07
SBA-D 250/21	081651	180	70	78	87.5	250	21	1/16" x 90°	40 + 29*** M16	6.09
SBA-D 315	081652	240	80	78	117	320	21	1/16" x 90°	70 + 29*** M16	10.90
SBA-D 400	231072	330	150	98	160	440	25.5	3/32" x 90°	85 + 35 M20	23.98
SBA-D 400/4	5319833**	330	190	98	160	440	25.5	3/32" x 90°	85 + 35 M20	32
SBA-D 1200/4	5322255	500	360	85	155	1200	25.5	3/32" x 90°	85 + 35 M20	30.30

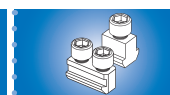
* With single T-nuts only

** 1 Set = 4 pieces

*** Can be used with double T-nuts hole spacing 28 mm and 30 mm



• SMW-AUTOBLOK
• 28, 158, 160



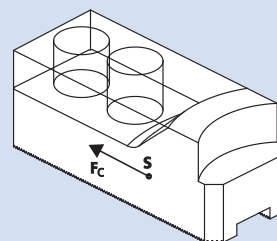
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

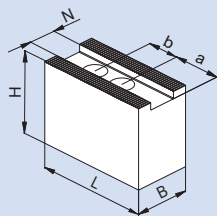


Aluminum jaws are subject to centrifugal force.
Also lighten these jaws for less loss of grip force!



SMW-AUTOBLOK	Forkardt	Röhnm	Schunk
Centco4-D 210-52			
HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165* BHD-FC 165* PB/PB/RC-D 165* AP/NT-D 170* BB-D 175* HYND-S 180* HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PB/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TP 160 ROTA TP 160 TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
Centco4-D 260/315 Centco4-MLW-D 400			
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PB/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226	QLK/QLC 200 QLK/QLC-KS 200/250 QLK/QLC-LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 KSF 200 KGH/KGHF/KTH 200 KG/KP 200, UVE 200/250	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ NCF/ NCO 210 ROTA NCK plus 210/250 ROTA TP 200 TP 200
Centco4-D 400 Centco4-MLW-D 600/750			
HFKN-D 260/315 SP/STP 280 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PB-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTG 250/315 KLNC/NH/ NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
HFKN-D 315 HB/PB/PB-D 315 SP/SP-L 350 BHD-FC 315 AN/AL/BH/BB-D 315 CC 350Z RC-D 305/400 HYND-S 250/315/400 AP/APL/NT-D 315	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTG 315 KLNC/NH/NHF 315 KS 315/400 KSPS 300 KSH/KSHF 315/400 HF315 UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/NCD/NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315
HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/L-D 500/630/800 HYDL-S 500/630/800 Centco4-D 500/630 Centco4-MLW-D 1000/1200/1400	QLK/QLC 400 NH/NHF 400/500/630 KT/KTG 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ NCD 400/500 ROTA NCF/ NCO 400/500

MAB-D



Soft top jaws for 2-jaw power chucks

- Inch serration 1/16" x 90°
- Material: 16MnCr5/ C45

Type	Id. No.	B	H	L	N	Serration	a + b f. ISO4762	kg	SMW- AUTOBLOK	Forkardt	Röhm	Schunk
MAB-D3	013750*	70	70	95	21	1/16" x 90°	45 + 28 M16	6.37 *	2 CLD 200 US-2 CLD 200	2 BLE 200 2 BLE 250 Mo 2 BLN 200	KFA 200	ROTA 2B 200
MAB-D4 ¹	90072500**	60	60	120	25.5	1/16" x 90°	64 + 34 M20	5.20 **	2 CLD 250 US-2 CLD 250 2 CLD 315 US-2 CLD 315	2 BLE 250 2 BLE/PS 250 2 BLN 250 2 BLE/PS 300 2 BLE 315 2 BLE/PS 315 2 BLN 315 2 BLN 400	KFA 250 KFA 315	ROTA 2B 250 ROTA 2B 315 ROTA 2B 400

* Jaws / Set

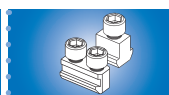
** Jaw / Piece

¹ Material: C45



• SMW-AUTOBLOK
• 28, 158, 160

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•
•



• SMW-AUTOBLOK
• 69

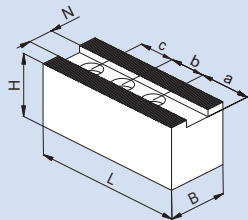
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• SMW-AUTOBLOK
• 80

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WBSA-D



Soft top jaws for SMW-AUTOBLOK power chucks

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: C45

Type	Id. No.	B	H	L	N	Serration	a + b + c f. ISO 4762	kg / Set	SMW-AUTOBLOK
WBSA-D 125*	12071300	30	30	60	12	1/16" x 90°	29 + 16 M8	0.32	AN/AL-D 125 • BH/HB/PB-D 130 BB-D 140 • SP/STP 125
WBSA-D 165*	12071680	30	35	70	14	1/16" x 90°	37.5 + 16.5 M10	0.42	HFKN-D 165 • PB/PBI/RC-D 165 SP/STP160 • AP/NT-D 170 AN/AL/BH/HB-D 165 BB-D 175 • BHD-FC 165 HYND-S 180
WBSA-D 210*	12072130	35	40	90	17	1/16" x 90°	47 + 23 M12	0.73	HFKN-D 210 • HB/PB/PBI/RC-D 210 SP/STP 200/240 • AP/APL/NT-D 215 AN/AL/BH/BB-D 210 HYND-S 210/226 BHD-FC 210 • CC 240Z
WBSA-D 250*	12072500	45	45	110	21	1/16" x 90°	60 + 30 M16	1.25	HFKN-D 260/315 RC-D 250/305/400 SP/STP 280 • SP/SP-L 350 CC 350Z • HB/ PB/ PBI-D 250/315 AN/AL/BH/BB-D 250 AP/APL/NT-D 315 AN/AL/BH/BB-D 315 HYND-S 250/315 BHD-FC 250/315
WBSA-D 260*	12072620	40	45	110	17	1/16" x 90°	60 + 30 M12	1.23	AP/APL/NT-260
WBSA-D 315	12073000	50	50	125	21	1/16" x 90°	43 + 30 + 30 M16	1.85	HFKN-D 315 RC-D 305/400 SP/SP-L 350 • HYND-S 315 AN/AL/BH/BB-D 315 AP/APL/NT-D 315 BHD-FC 315 • CC 350Z
WBSA-D 400	12074040	60	60	140	25.5	3/32" x 90°	75 + 38 M20	3.18	HFKN-D 400/500 BHD-FC 400/500/630 BB-N 400/470/500/600 IN/IL-D 500/630/800 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 HYDL-S 500/630/800 AN/AL/BB-D 400 BH-D 400/450/500/630/800 AP/APL/NT-D 400
WBSA-D 401	12074030	60	60	140	21	1/16" x 90°	25 + 34 + 34 M16	3.20	RC-D 400 GH-D 400
WBSA-D 500	12075050	59.5	60	170	25.5	3/32" x 90°	69 + 38 + 38 M20	3.62	HFKN-D 400/500 BHD-FC 400/500/630 BB-N 400/470/500/600 IN/IL-D 500/630/800 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 HYDL-S 500/630/800 AN/AL/BB-D 400 BH-D 400/450/500/630/800 AP/APL/NT-D 400
WBSA-D 610	12075040	75	75	160	25.5	3/32" x 90°	59 + 38 + 38 M20	5.69	HFKN-D 400/500 BHD-FC 400/500/630 BB-N 400/470/500/600 IN/IL-D 500/630/800 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 HYDL-S 500/630/800 AN/AL/BB-D 400 BH-D 400/450/500/630/800 AP/APL/NT-D 400

* Jaws pointed



SMW-AUTOBLOK
28, 158, 160

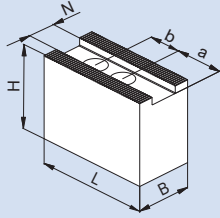


SMW-AUTOBLOK
69



SMW-AUTOBLOK
80

WBB-D



Soft top jaws for Berg power chucks

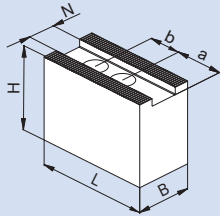
- Inch serration 1/16" x 90°
- Material: 16MnCr5 , Serration ground

Type	Id. No.	B	H	L	N	Serration	a + b für ISO 4762	kg / Set	Berg
WBB-D 211	034241	20	40	55	8	1/16" x 90°	30 + 14 M8	0.77	KH 110-30
WBB-D 232*	081621	30	45	70	10	1/16" x 90°	38 + 19 M10	1.63	KH 140-36 KH 160-45
WBB-D 235	081622	30	55	84	12	1/16" x 90°	45 + 21 M12	2.50	KH 175-56 KH 200-68
WBB-D 237	081623	35	60	90	12	1/16" x 90°	55 + 21 M12	3.60	KH 175-56 KH 200-68
WBB-D 240	081624	40	60	110	16	1/16" x 90°	63 + 29** M16	4.79	KH 250-91 KH 315-117

* Jaws pointed

** Can be used with double T-nuts hole spacing 28 mm and 30 mm

WBR-D



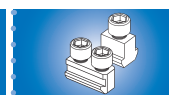
Soft top jaws

- Inch serration 1/16" x 90°
- Material: 16MnCr5 , Serration ground

Type	Id. No.	B	H	L	N	Serration	a + b for ISO 4762	kg / Set	Röhm	Schunk
WBR-D 012	081630	30	55	55	12	1/16" x 90°	31 + 15 M8	1.72	KFD-HS 160/175 KFD 130 KFD-HE 170 KFH 140	HSG 160 ROTA NCD 165
WBR-D 017	081631	40	60	70	17	1/16" x 90°	39 + 19 M12	3.04	KFD-HS 200 KFD 200 KFD-HE 210	HSG 200
WBR-D 117	081632	40	60	90	17	1/16" x 90°	59 + 19 M12	4.12	KFD-HS 250 KFD 200 KFD-HE 210	HSG 250
WBR-D 021	081633	50	60	105	21	1/16" x 90°	65 + 25 M16	5.86	KFD-HS 315 KFD 250 KFD-HE 254/315	HSG 315 ROTA NCD 250/315



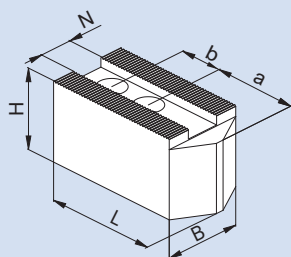
• SMW-AUTOBLOK
• 28, 158, 160



• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80



Soft top jaws for front end power chucks

- Inch serration 1/16" x 90° or 3/32" x 90°
- Material: 16MnCr5, C45¹

Type	Id. No.	B	H	L	N	Serration	a + b for ISO 4762	kg	SMW-AUTOBLOK	Röhm	Schunk
WBC-D 125*	013795**	30	40	74	11	1/16" x 90°	35 + 18 M8	1.62 **		LVE 125	TP 125-26 ROTA TP 125
MWB-D 130	013488**	30	40	55	12	1/16" x 90°	29 + 16 M8	1.2 **	SP 125 ab Bj. 98 STP 125		
WBSA-D 125 ¹ *	12071300***	30	30	60	12	1/16" x 90°	29 + 16 M8	0.96 ***	SP 125 ab Bj. 98 STP 125		
AWB-D 165*	035954**	40	40	80	14	1/16" x 90°	43 + 22 M10	2.32 **	SP 160 ab Bj. 98 STP 160	LVE 160	TP 160-38 ROTA TP 160
AWB-D 200*	081616**	40	40	90	17	1/16" x 90°	53 + 22 M12	2.61 **	SP 200/240 STP 200/240 CC 240 Z	LVE 200	TP 200-52 ROTA TP 200
AWB-D 250*	081618**	50	50	120	21	1/16" x 90°	70 + 28 M16	5.37 **	SP 250/280/350 SP 280 STP 280	LVE 250 LVE 315	TP 250/315 ROTA TP 250 ROTA TP 315/350
AWB-D 315*	081619**	50	50	140	21	1/16" x 90°	90 + 28 M16	6.48 **	SP 350 SP-L 350 CC 350 Z		TP 315 ROTA TP 315/350
WBSA-D 500 ¹	12075050***	59.5	60	170	25.5	3/32" x 90°	69 + 38 + 38 M20	3.62 ***	BB-N 400/470 BB-N 500/600 BB-N ES 400/470 BB-N ES 500/600 BB-EXL(SC)2G 510 BB-EXL(SC)2G 660	LVE 400/500 LVE 630/800 LVE 1000	TB 400 ROTA EP 380 ROTA TB 400 TB 500 ROTA EP 460 ROTA TB 500/610 ROTA TB 630-265LH
WBC-D 502 ¹	12075140***	60	60	205	25.5	3/32" x 90°	104 + 38 + 38 M20	4.50 ***	BB-N 400/470 BB-N 500 BB-N ES 400/470 BB-N ES 500/600 BB-EXL(SC)2G 510 BB-EXL(SC)2G 660	LVE 400/500 LVE 630/800 LVE 1000	TB 400 ROTA EP 380 ROTA TB 400 TB 500 ROTA EP 460 ROTA TB 500/610 ROTA TB 630-265LH
WBC-D 630 ¹	12076440***	80	80	240	30	3/32" x 90°	110 + 50 + 50 M24	9.65 ***	BB-N 630 BB-N ES 630 BB-AZ2G 685 BB-AZ2G 740 BB-AZ2G 1000 BB-EXL(SC)2G 900		ROTA TB 630 TB 800/1000/1200 ROTA TB 800/850 ROTA TB 100/1200
WBC-D 800 ¹	12078040***	80	80	320	30	3/32" x 90°	165 + 60 + 60 M24	13.29 ***	BB-N 800/ 1000 BB-N ES 850 BB-N ES 1000 BB-AZ2G 685 BB-AZ2G 740 BB-AZ2G 1000 BB-EXL(SC)2G 900		TB 800/1000/1200 ROTA TB 800/850 ROTA TB 100/1200
WBCL-D 800 ¹	12079040***	80	80	390	30	3/32" x 90°	230 + 60 + 60 M24	16.55 ***	BB-N 800/ 1000 BB-N ES 850 BB-N ES 1000 BB-AZ2G 685 BB-AZ2G 740 BB-AZ2G 1000 BB-EXL(SC)2G 900		TB 800/1000/1200 ROTA TB 800/850 ROTA TB 100/1200

* Jaws pointed

** Jaws / Set

*** Jaw / Piece

¹ Material C45



SMW-AUTOBLOK
28, 158, 160



SMW-AUTOBLOK
69



SMW-AUTOBLOK
80

Modified standard jaw-blanks according to your specifications

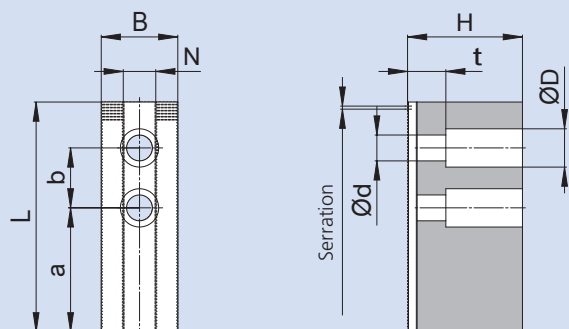
Reduced weight and / or pointed for small clamping diameters

Your benefits:

- You will quickly receive the right offer
- The jaws are made from blanks, which makes them inexpensive and available in shorter time
- Economical alternative to special jaws
- No machining is required on the clamping jaws by the customer
- Clamping diameter can be turned out by the customer on the machine under clamping pressure = best concentricity
- Clamping of small workpiece diameters due to tapered clamping surface
- If you have any questions in advance, please contact sales@smw-autoblok.de

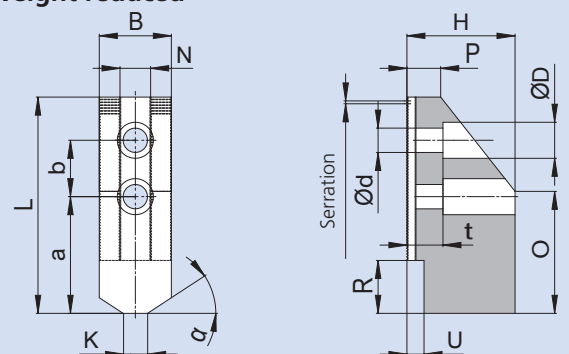
interactive PDF available
at www.smw-autoblok.de

Soft top jaw-blanks



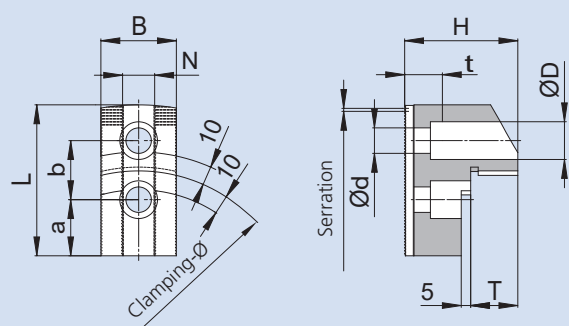
Dimensions					
a		mm	H		mm
b		mm	L		mm
B		mm	N		mm
d		mm	t		mm
D		mm			
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Soft top jaw-blanks weight reduced



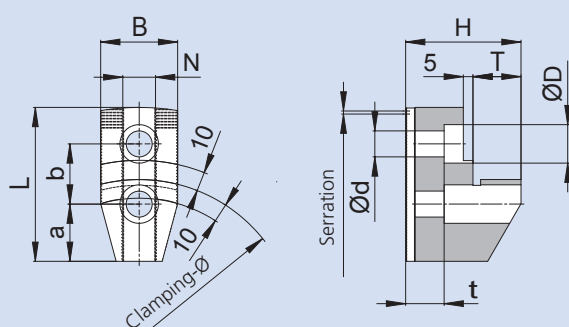
Dimensions					
a		mm	K		mm
b		mm	O		mm
B		mm	P		mm
d		mm	R		mm
D		mm	t		mm
H		mm	U		mm
L		mm	α		Grad
N		mm			
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Soft top jaws for OD clamping



Dimensions					
a		mm	L		mm
b		mm	N		mm
B		mm	t		mm
d		mm	T		mm
D		mm	Clamping-Ø		mm
H		mm	Workpiece-Ø		mm
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

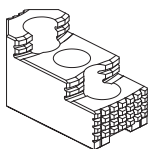
Soft top jaws for ID clamping



Dimensions					
a		mm	L		mm
b		mm	N		mm
B		mm	t		mm
d		mm	T		mm
D		mm	Clamping-Ø Workpiece-Ø		mm
H		mm			mm
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Hard top jaws – Inch serration

SMW-AUTOBLOK | Forkardt | Röhm | Schunk



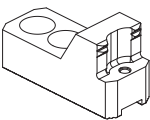
MHB-D

Reversible

Hard top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 32



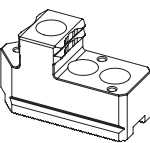
GG-D

For internal and external clamping

Hard roughing jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 34



GG-D

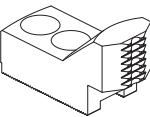
For Centco4 and Centco4-MLW

For internal and external clamping

Hard roughing jaws

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 36

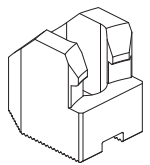


GSG-D

Hard roughing jaws for bar work

- Inch serration
1/16" x 90° or 3/32" x 90°

Page 38



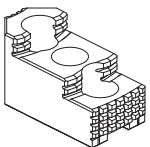
GFB-D

For bar pulling chucks

Hard top jaws

- Inch serration
1/16" x 90°
- For bar pulling chucks GF 80
SMW-AUTOBLOK
Röhm

Page 40



MHB-D

For pneumatic front-end chucks

Hard top jaws

- Inch serration
1/16" x 90° or 3/32" x 90°
- For pneumatic front-end chucks
SMW-AUTOBLOK
Röhm, Schunk

Page 40

Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

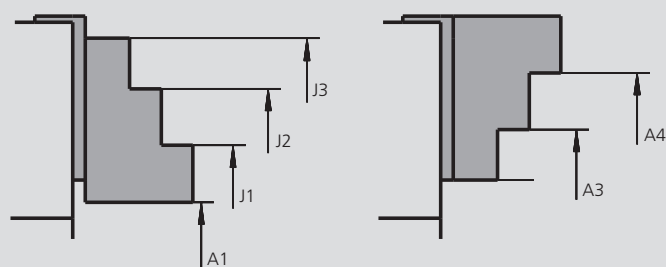
Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

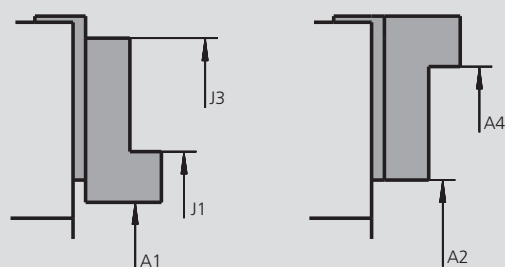
Clamping ranges with standard hard, reversible stepped top jaws

■ Standard chucks Ø 125 - 800 mm

2 step top jaws



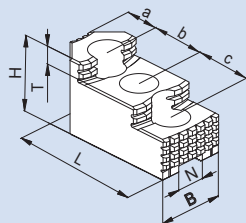
1 step top jaws*



Chuck diameter	Chuck type	Top jaws Id. No. Serr. "D"	A1 mm	A2 mm	A3 mm	A4 mm	J1 mm	J2 mm	J3 mm
125	AN-, AL-	12081306	10-54	-	54-92	90-120	56-100	90-135	125-170
165-170	AN-, AL-, AP-, NT-	12081636	14-80	-	62-125	110-155	65-125	115-175	145-210
210-215	AN-, AL-, AP-, NT-	12082036	20-100	-	72-150	150-200	75-150	145-230	190-265
250	AN-, AL-	12083036	20-115	-	105-205	190-235	80-165	155-250	230-325
260	AP-, NT-	12082626	20-130	-	105-215	180-245	80-180	155-260	220-330
315	AN-, AL-, AP-, NT-	12083036	30-170	-	120-265	205-300	95-225	165-310	240-380
400	AN-, AL-	12084546	52-205	-	180-330	280-370	140-285	240-385	330-480
400	AP-, NT-	12084546	35-200	-	165-325	260-370	125-280	220-380	315-480
500	IN-D, IL-D	12086346*	80-320	125-365	-	320-475	180-420	-	370-610
630	IN-D, IL-D	12086346*	80-440	125-485	-	320-600	180-540	-	370-730
800	IN-D, IL-D	12086346*	80-610	125-655	-	320-760	180-710	-	370-900
500	APLD	12084546	60-310	-	185-440	285-470	145-390	245-490	340-590
630	APLD	12084546	60-440	-	185-570	285-600	145-520	245-620	340-720
800	APLD	12084546	60-610	-	185-740	285-760	145-690	245-790	340-890
500	IEPD	12084546	85-320	-	210-450	310-480	170-400	270-500	370-600
630	IEPD	12084546	85-440	-	210-570	310-600	170-520	270-620	370-720
800	IEPD	12084546	85-610	-	210-740	310-760	170-690	270-790	370-890
130	BH-, BH-	12081306	10-58	-	55-97	90-120	58-105	90-140	125-175
140	BB-, BB-	12081306	16-65	-	55-105	90-130	65-110	98-148	132-182
165	BH-, BH-FC, RC-	12081636	12-80	-	62-125	110-155	62-125	105-170	145-210
175	BB-D, BB-M	12081636	25-92	-	74-138	120-165	74-138	118-185	155-220
180	HYND-S	12081636	27-95	-	77-140	125-170	77-140	120-185	160-225
210	BH-, BH-FC, RC-, HYND-S	12082036	14-100	-	65-150	140-200	65-150	135-230	180-265
210	BB-D, BB-M	12082036	25-100	-	80-150	155-200	80-150	150-230	195-265
226	HYND-S	12082036	24-110	-	75-160	150-215	75-160	145-240	190-275
250	BH-D, BHD-FC, RC-, HYND-S	12083036	20-115	-	105-205	190-235	80-165	155-250	230-325
250	BH-M, BHM-FC	12082626	20-115	-	105-205	190-235	80-165	155-250	230-325
250	BB-D, BB-M	12083036	25-115	-	115-205	200-235	85-165	165-250	240-325
305	RC-D, RC-M	12083036	25-160	-	120-250	205-290	85-215	165-300	240-370
315	BH-, BH-FC, HYND-S	12083036	40-170	-	135-265	220-300	100-225	180-310	250-380
315	BB-D, BB-M	12083036	75-170	-	165-265	250-300	130-225	210-310	320-415
400	RC-	12084006	90-250	-	195-355	285-380	155-315	240-400	330-490
400	BH-, BH-FC, HYND-S	12084546	52-205	-	180-330	280-370	140-285	240-385	330-480
450	BH	12084546	52-265	-	180-390	280-430	140-345	240-445	330-540
500	BH	12084546	115-325	-	240-450	340-480	200-410	300-510	395-610
500	BH-FC	12084546	90-320	-	220-445	320-480	175-400	275-500	370-600
500	HYDL-S	12084546	150-320	-	275-445	375-480	230-400	330-500	430-600
550	HYDL-S	12084546	200-370	-	330-500	430-535	285-455	385-555	485-655
630	BH	12086346	195-420	240-465	-	440-600	295-520	-	490-715
630	BH-FC	12084546	135-440	-	260-565	360-600	220-520	315-620	415-720
630	HYDL-S	12084546	230-450	-	360-575	460-600	315-530	415-630	515-730
800	BH	12086346	195-590	240-635	-	440-760	295-690	-	490-880
800	HYDL-S	12086346	245-595	295-640	-	490-760	345-695	-	540-890

* Note: AN means AND, ANM; AL means ALD, ALM; AP means APD, APM; NT means NTD, NTM; BH means BHD, BHM; BH-FC means BHD-FC, BHM-FC; RC means RCD, RCM.

MHB-D



Hard, reversible top jaws

- Inch serration 1/16" x 90° or 3/32" x 90°
- Serration ground

Type	Id. No.	B	H	L	T	N	Serration	a + b + c for ISO 4762	kg / Set	Number of jaws
MHB-D 110	007076	20	31	48.2	7	8	1/16" x 90°	14.5 + 12 + 12 M6	0.35	3
MHB-D 130	12081306	29.7	34	58.1	8.5	12	1/16" x 90°	13 + 16 + 16 M8	0.60	3
MHB-D 160	12081636	34	39	65.2	10	14	1/16" x 90°	18 + 16.5 + 16.5 M10	0.89	3
MHB-D 160	12081638**	34	39	65.2	10	14	1/16" x 90°	18 + 16.5 + 16.5 M10	0.90	4
MHB-D 200	12082036	40	45	82.7	10.5	17	1/16" x 90°	19 + 23 + 23 M12	1.68	3
MHB-D 200	12082038**	40	45	82	10.5	17	1/16" x 90°	19 + 23 + 23 M12	2.30	4
MHB-D 260	12082626	45	56	101.1	13.5	17	1/16" x 90°	23 + 30 + 30 M12	3.08	3
MHB-D 251	12083038**	45	56	106.2	13.5	21	1/16" x 90°	26 + 30 + 30 M16	2.90	4
MHB-D 251	12083036	45	56	106.2	13.5	21	1/16" x 90°	26 + 30 + 30 M16	2.87	3
MHB-D 315	12083186	45	56	123.6	13.5	21	1/16" x 90°	43 + 30 + 30 M16	3.72	3
MHB-D 401	12084506	60	75	141.1	19	21	1/16" x 90°	38 + 38 + 38 M16	5.10	3
MHB-D 500	12084546	60	75	140.8	19	25.5	3/32" x 90°	38 + 38 + 38 M20	7.10	3
MHB-D 500	12084548**	60	75	140.8	19	25.5	3/32" x 90°	38 + 38 + 38 M20	9.50	4
MHB-D 610 ¹	12086346	74	74	146.8	32	25.5	3/32" x 90°	46 + 38 + 38 M20	9.61	3

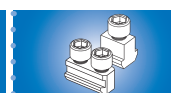
¹ 1 step only

* With single T-nuts only

** 1 Set = 4 pieces



SMW-AUTOBLOK
158, 160



SMW-AUTOBLOK
69

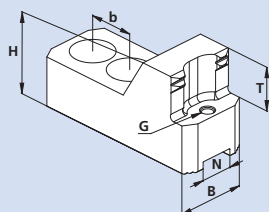


For highest accuracy we recommend grinding the jaws on the chuck under clamping conditions.

1

SMW-AUTOBLOK	Forkardt	Röhm	Schunk
HFKN-D 110			
AN/AL-D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125	KTH 130/140	KFD 130 KFH 140 KFD-HS 160/175 KFD-HE 170 LVE 125/160	HSG 160 ROTA NCD 165
HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165 BHD-FC 165 PB/PB/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180 HFKS-2G-D 165 Centco4-D 210			
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PB/RC-D 210 AP/APL/NT-D 215 AP/APL/NT-D 260* HYND-S 210/226 HFKS-2G-D 210/255	QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 NH/NHF 160/175/200 KL/KT/KTG/KTN/KS-PS 160/200 KS 160/200/250 KSF 175/200 KGH/KGHF/KTH 160/175/200 KG/KP 200 UVE 160/200/250	KFD/KFD-HF 160/200 KFH/KFH-F/KFH-G/KFH-NC 160/200 KFD-AF 160/200 KFD-HE 210 SPD/SPO 160/215 LVE 200	TH/THF/HSL 165/210 ROTA NCD 185/210 ROTA NC/ROTA NCF 165/210 ROTA NCO 165/210 ROTA NCK plus 210/250 ROTA 2B 160 ROTA TP 200 TP 200
Centco4-D 260/315			
AP/APL/NT-D 260			
Centco4-D 400			
HFKN-D 260/315 SP/STP 280 HFKS-2G-D 320 SP/SP-L 350 AN/AL/BH/BB-D 250 AN/AL/BH/BB-D 315 BHD-FC 250/315 RC-D 250/305/400 CC 350Z HB/PB/PB/RC-D 250/315 AP/APL/NT-D 315 HYND-S 250/315/400 RC-D 400	QLK/QLC 250/315 QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 QLC-AG 250/315 KG/KT/KP/KTG/KTN/KTGF 250/315 KLNC/NH/NHF 250/315 KS 315/400 KSPS 250/300 KSH/KSHF 250/315/400 HF315 UVE315	KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 SPD/SPO 300 LVE 250/305/315	TH/THF/HSL 250/315 ROTA NC/ROTA NCD 250/315 ROTA NCF 250/315 ROTA NCO 260/315 ROTA NCK plus 315 ROTA TP 250/315 TP 250/315
HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/470/500/600 BB-N ES 400/470/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/IL-D 500/630/800 HYDL-S 500/630/800 Centco4-D 500/630	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500
BH-D 630/800 IN/IL-D 630/800 HYDL-S 500/630/800	NH/NHF 630 KT/KTGF 630 KS 630 KSHF 630 KSL 630 UVE 630/800	KFD 630/800 LVE 630/800/1000	

GG-D



Hard roughing jaws for external and internal clamping

- Inch serration 1/16" x 90° or 3/32" x 90°
- Serration ground

Type	Id. No.	External clamping	Internal clamping	B	H	T	G	N	Serration	b	kg / Set
GG-D 001	081047	25-40	-	35	40	20	M6	12	1/16" x 90°	16	1.36
GG-D 002	081048	40-60	-								1.24
GG-D 003	081049	60-80	-								1.13
GG-D 004	081050	80-100	-								0.91
GG-D 005	081051	100-120	127-146								0.83
GG-D 006	090803	120-140	109-127								0.89
GG-D 004-1	081050	47-68	110-128	35	40	20	M6	12	1/16" x 90°	16	0.91
GG-D 005-1	081051	67-88	92-111								0.83
GG-D 006-1	090803	87-102	74-93								0.89
GG-D 010	090732	25-50	-	35	45	20	M6	14	1/16" x 90°	16.5	1.77
GG-D 011	090733	49-80	145-185								1.26
GG-D 012	090734	80-120	115-145								1.13
GG-D 013	090735	119-150	80-115								1.08
											1.16
GG-D 020	081052	40-60	-	35	50	25	M6	17	1/16" x 90°	22	1.43
GG-D 021	081053	60-80	168-188								1.29
GG-D 022	081054	80-100	144-164								1.05
GG-D 023	081055	100-120	125-145								1.02
GG-D 024	081056	120-140	105-125			20					1.14
GG-D 030	081057	30-60	-	35	50	25	M6	17	1/16" x 90°	22	1.87
GG-D 031	081058	60-90	210-240								1.55
GG-D 032	081059	90-120	180-210	40	45	20					1.24
GG-D 033	081060	120-150	150-180	40	45	20					1.29
GG-D 034	090811	150-190	120-150	40	50	25					1.73
GG-D 035	090812	-	90-120	40	50	25					2.06
GG-D 030	081057	40-80	-	35	50	25	M6	17	1/16" x 90°	22	1.87
GG-D 031	081058	80-120	210-290	40	45	20					1.55
GG-D 032	081059	120-160	175-250	40	45	20					1.24
GG-D 033	081060	160-200	140-210	40	45	20					1.29
GG-D 034	090811	-	120-160	40	50	25					1.73
GG-D 035	090812	-	90-130	40	50	25					2.06
GG-D 050	081065	40-80	-	45	59	28	M8	21	1/16" x 90°	29**	3.38
GG-D 051	081066	80-120	250-300	45							2.57
GG-D 052	081067	120-160	220-260	60							3.14
GG-D 053	081068	160-210	180-225	60							2.75
GG-D 054	090817	200-250	140-180	60							3.85
GG-D 055	090818	-	100-150	60							4.74
GG-D 056	090819	-	80-120	45	46	15					3.06
GG-D 060	081069	50-110	-	45	59	28	M8	21	1/16" x 90°	29**	3.76
GG-D 061	081070	100-170	280-350	60							4.61
GG-D 062	080552	150-220	240-290	60							3.65
GG-D 063	081071	210-290	175-250	60							3.80
GG-D 064	090820	280-350	120-180	60	51	20					4.48
GG-D 080 ¹	081076	60-160	-	60	80	40	M8	25.5	3/32" x 90°	35	8.67
GG-D 081 ¹	019355	160-240	-								7.30
GG-D 082 ¹	081077	240-320	270-380								4.88
GG-D 083 ¹	081078	320-400	190-290								6.26
GG-D 084 ¹	081079	350-460	140-230								8.47
GG-D 085 ¹	081080	-	100-160	60	20						8.18

Note: The specified clamping range is valid for the BH-D chuck series. It may differ for other chucks.

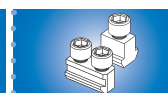
¹ Clamping range valid for chuck Ø 400

* With single T-nuts only

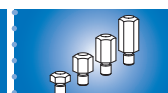
** Can be used with double T-nuts hole spacing 28 mm and 30 mm



• SMW-AUTOBLOK
• 158, 160



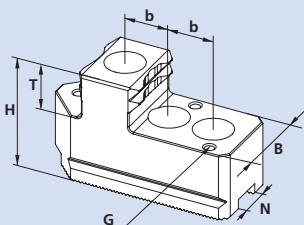
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 147

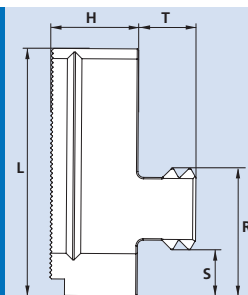
SMW-AUTOBLOK	Forkardt	Röhm	Schunk
		KFD-HS 160/175 KFD-HE 170 LVE 160	HSG 160 ROTA NCD 165
AN/AL-D 125 BH/HB/PB-D 130 BB-D 140 SP/STP 125 HFKN-D 165 SP/STP 160 AN/AL/BH/HB-D 165 BHD-FC 165 PB/PBI/RC-D 165 AP/NT-D 170 BB-D 175 HYND-S 180 HFKS-2G-D 165	KTH 130/140	KFD 130 KFH 140 LVE 125	
	QLK/QLC 160/175 • QLK/QLC-LS 160 NH/NHF 160/175 KL/KT/KTG/KTN/KS-PS 160 KS 160 • KSF 175 KGH/KGHF/KTH 160/175 • UVE 160	KFD/KFD-HF 160 KFH/KFH-F/KFH-G/KFH-NC 160 KFD-AF 160 SPD/SPO 160	TH/THF/HSL 165 ROTA NCD 185 ROTA NC/ROTA NCF/ROTA NCO 165 ROTA 2B 160
HFKN-D 210 SP/STP 200/240 AN/AL/BH/BB-D 210 BHD-FC 210 CC 240Z HB/PB/PBI/RC-D 210 AP/APL/NT-D 215 HYND-S 210/226 HFKS-2G-D 210	QLK/QLC 200 QLK/QLC-KS/LS 200 QLC-AG 200 NH/NHF 200 KL/KT/KTG/KTN/KS-PS 200 KS 200/250 KSF 200 KGH/KGHF/KTH 200 KG/KP 200 UVE 200	KFD/KFD-HF 200 KFH/KFH-F/KFH-G/KFH-NC 200 KFD-AF 200 KFD-HE 210 SPD/SPO 215 LVE 200	TH/THF/HSL 210 ROTA NCD 210 ROTA NC/ROTA NCF/ROTA NCO 210 ROTA NCK plus 210 ROTA TP 200 TP 200
AP/APL/NT-D 260*	KL 250 KS 250 UVE 250 NHF 250-65 (Index) QLK/QLC-KS 250	KFL 250 KFD-HS 250	ROTA NCK plus 250
HFKN-D 260 SP/STP 280 AN/AL/BH/BB-D 250 BHD-FC 250 RC-D 250 HB/PB/PBI-D 250 HYND-S 250 HFKS-2G-D 255 HFKN-D 315 HB/PB/PBI-D 315 SP/SP-L 350 BHD-FC 315 AN/AL/BH/BB-D 315 CC 350Z RC-D 305/400 HYND-S 315/400 AP/APL/NT-D 315 HFKS-2G-D 320	QLK/QLC 250 QLK/QLC-LS 250 QLC-AG 250 KG/KT/KP/KTG/KTN/KTGF 250 KLNC/NH/NHF 250 KSPS 250 KSH/KSHF 250	KFD/KFD-HF 250 KFH/KFH-F/KFH-G/KFH-NC 250 KFD-AF 250 KFD-HE 254 LVE 250	TH/THF/HSL 250 ROTA NC/ROTA NCD/ROTA NCF 250 ROTA NCO 260 ROTA TP 250 TP 250
	QLK/QLC 315 QLK/QLC-KS 315/400 QLK/QLC-LS 315 QLC-AG 315 KG/KT/KP/KTG/KTN/KTGF 315 KLNC/NH/NHF 315 KS 315/400 KSPS 300 KSH/KSHF 315/400 HF315 UVE315	KFD/KFD-HF 315 KFH/KFH-F/KFH-G/KFH-NC 315 KFD-AF 315 KFD-HE 315 KFL 315/400 SPD/SPO 300 LVE 305/315	TH/THF/HSL 315 ROTA NC/ROTA NCD 315 ROTA NCF 315 ROTA NCO 315 ROTA NCK plus 315 ROTA TP 315 TP 315
HFKN-D 400/500 AP/AP-L/NT-D 400* BB-N 400/460/500/600 BB-N ES 400/460/500/600 BB-EXL(SC)2G 510/660 AN/AL/BB-D 400 BH-D 400/450/500/630/800 BHD-FC 400/500/630 IN/L-D 500/630/800 HYDL-S 500/630/800	QLK/QLC 400 NH/NHF 400/500/630 KT/KTGF 400/500/630 KS 500/630 KG/KL/KP/KLNC 400/500 KSHF 630 KSH 500 KSL 630 KSPS 400 UVE 400/500/630/800	KFD 400/500/630/800 KFD-HF 400/500/630 KFD-HS 400/500 KFD-HE 400 KFH/KFH-F/KFH-G/KFH-NC 400/500 KFL 500/600 KFD-HE 400 LVE 400/500/630/800/1000	TH/THF 400/500 HSL 400 HSG 400/500 ROTA NC/ROTA NCD 400/500 ROTA NCF/ROTA NCO 400/500

GG-D



Hard roughing jaws for Centco4 and Centco4-MLW for external and internal clamping

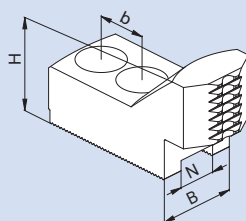
- Inch serration 1/16" x 90° or 3/32" x 90°
- Serration ground



Type	Id. No.	External clamping*	Internal clamping*	B	H	L	R	S	T	G	N	b	Serration	kg / Set	SMW-AUTOBLOK
GG-D 210	5325558	48-205	104-210	35	50	85	44	16	20	M5	14	20	1/16"x90°	2.25	Centco4 D210
GG-D 260	5325560	49-256	128-260	36	55	100	52	11	20	M5	17	25	1/16"x90°	3.36	Centco4 D260
GG-D 315	5325562	50-309	146-315	40	55	110	65	17	20	M8	17	25	1/16"x90°	4.18	Centco4 D315
GG-D 400	5325564	72-394	171-400	50	60	130	64	13	22	M8	21	32.5	1/16"x90°	6.85	Centco4 D400
GG-D 500	5325565	127-495	242-500	60	60	150	73	14.5	22	M8	25.5	40	3/32"	9.04	Centco4 D500
GG-D 630	5325566	105-630	242-630	60	60	180	83	13	22	M8	25.5	50	3/32"	11.49	Centco4 D630
GG-D 260	5325560	76 - 314	128 - 315	36	55	100	52	11	20	M5	17	25	1/16"x90°	3.36	Centco4-MLW 315-4
GG-D 315	5325562	59 - 391	155 - 400	40	55	110	65	17	20	M8	17	25	1/16"x90°	4.18	Centco4-MLW 400-4
GG-D 400	5325564	94 - 582	194 - 600	50	60	130	64	13	22	M8	21	32.5	1/16"x90°	6.85	Centco4-MLW 600-4
GG-D 400	5325564	100 - 731	200 - 750	50	60	130	64	13	22	M8	21	32.5	1/16"x90°	6.85	Centco4-MLW 750-4
GG-D 500	5325565	124 - 986	239 - 1000	60	60	150	73	14.5	22	M8	25.5	40	3/32"	9.04	Centco4-MLW 1000-4
GG-D 630	5325566	95 - 1190	231 - 1200	60	60	180	83	13	22	M8	25.5	50	3/32"	11.49	Centco4-MLW 1200-4
GG-D 630	5325566	95 - 1390	231 - 1400	60	60	180	83	13	22	M8	25.5	50	3/32"	11.49	Centco4-MLW 1400-4

* Attention: SMW-AUTOBLOK is recommending not to clamp any diameters, that are larger than the chuck O.D.
If you have any questions, please do not hesitate to contact our customer service.

GSG-D



Hard roughing jaws for bar work

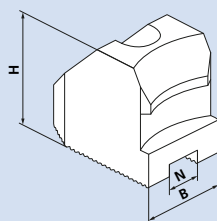
- Inch serration 1/16" x 90° or 3/32" x 90°
- Serration ground

Type	Id. No.	Clamping range Ø	B	H	N	Serration	b for ISO 4762	kg / Set
GSG-D 165	091343	15-40	30	40	14	1/16" x 90°	20 M10	1.06
GSG-D 200	091344	15-50	35	45	17	1/16" x 90°	22 M12	1.50
GSG-D 250	091345	20-70	45	50	21	1/16" x 90°	28 M16	2.69
GSG-D 400 ¹	091346	40-100	55	60	25.5	3/32" x 90°	35 M20	7.78

Note: The specified clamping range is valid for the BH-D chuck series. It may differ for other chucks.

¹ Clamping range valid for chuck Ø 400

GFB-D



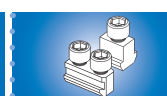
Hard top jaws for GF-80

- Inch serration 1/16" x 90°
- Serration ground

Type	Id. No.	Clamping range Ø	B	H	N	Serration	b for ISO 4762	kg / Set
GFB-D 1	016348	5-25	25	39	10	1/16" x 90°	M8	0.64
GFB-D 2	016349	25-45	30	39	10	1/16" x 90°	M8	0.62
GFB-D 3	016350	45-65	30	39	10	1/16" x 90°	M8	0.53
GFB-D 4	016351	65-80	30	39	10	1/16" x 90°	M8	0.47
GFB-D 5	016352	80-100	30	39	10	1/16" x 90°	M8	0.51



• SMW-AUTOBLOK
• 158, 160

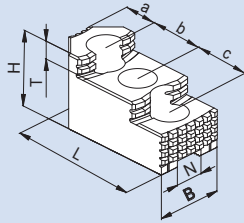


• SMW-AUTOBLOK
• 69

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GF 80
GF 80

MHB-D



Hard, reversible stepped top jaws for pneumatic front end power chucks

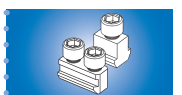
- Inch serration 1/16" x 90° or 3/32" x 90°
- Serration ground

Type	Id. No.	B	H	L	T	N	Serration	a + b + c f. ISO 4762	kg / Set	SMW- AUTOBLOK	Röhm	Schunk
MHB-D 125	013817	24	40	57.7	9	11	1/16" x 90°	9.5 + 18 + 18 M8	0.68		LV 125	TP 125-26 ROTA TP 125
MHB-D 130	12081306	29.7	34	58.1	8.5	12	1/16" x 90°	13 + 16 + 16 M10	0.60	SP 125-26 ab Bj. 98 STP 125 ab Bj. 98		
MHB-D 160	12081636	34	39	65.2	10	14	1/16" x 90°	18 + 16.5 + 16.5 M10	0.89	SP 160-38 STP 160	LVE 160	TP 160-38 ROTA TP 160
MHB-D 200	12082036	40	45	82.7	10.5	17	1/16" x 90°	19 + 23 + 23 M12	1.68	SP 200/240 STP 200/240	LVE 200	TP 200-52 ROTA TP 200
MHB-D 251	12083036	45	56	106.2	13.5	21	1/16" x 90°	26 + 30 + 30 M16	2.87	SP 250/280/350 STP 280	LVE 305 LVE 250	TP 250/315 ROTA TP 250/315 ROTA TP 350
MHB-D 315	12083186	50	56	123.6	13.5	21	1/16" x 90°	43 + 30 + 30 M16	3.72	SP 350 SP-L 350	LVE 315	TP 315 ROTA TP 315/350
MHB-D 500	12084546	60	75	140.8	19	25.5	3/32" x 90°	38 + 38 + 38 M20	7.10	BB-N 400/470 BB-N 500/600 BB-N ES 400/470 BB-N ES 500/600 BB-EXL(SC)2G 510 BB-EXL(SC)2G 660	LVE 400/500 LVE 630/800 LVE 1000	TB 400/500 ROTA EP 380/46 ROTA TB 400/500 ROTA TB 610 ROTA TB 630-265 LH
MHB-D 630¹	12086446	75	85	161.8	30	30	3/32" x 90°	30 + 50 + 50 M24	13.50	BB-N 630-310 BB-N ES 630 BB-AZ2G 685 BB-AZ2G 740 BB-AZ2G 1000 BB-EXL(SC)2G 900		ROTA TB 630
MHB-D 800¹	12088046	75	85	220	30	30	3/32" x 90°	51 + 62 + 62 M24	19.50	BB-N 800-410 BB-N ES 850 BB-N ES 1000 BB-AZ2G 685 BB-AZ2G 740 BB-AZ2G 1000 BB-EXL(SC)2G 900		TB 800/1000/1200 ROTA TB 800/850 ROTA TB 1000/1200

¹ 1 step only



• SMW-AUTOBLOK
• 158, 160

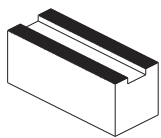


• SMW-AUTOBLOK
• 69

Soft top jaws – Metric serration

SMW-AUTOBLOK | Howa | Samchully | Kitagawa | Schunk

2



MAB-M

Without holes
16MnCr5

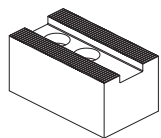
Soft top jaws

- Metric serration
1.5 x 60°

Page 42

MAB-ML

Without holes,
16MnCr5
Long version



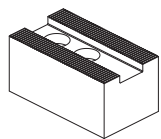
MAB-M

With holes
16MnCr5

Soft top jaws

- Metric serration
1.5 x 60°
- Hole pattern according
to customer specifications

Page 42



WBJ-M

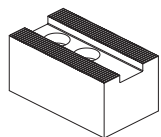
Tall version
16MnCr5/ C45 (induction/ flame hardenable)

Soft top jaws

- Metric serration
1.5 x 60° bzw. 3 x 60°
- Partly pointed version

Page 44

WBSA-M



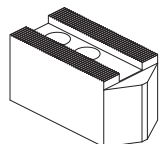
WBJ-MA

Light version
Aluminum F50

Soft top jaws aluminum

- Metric serration
1.5 x 60°

Page 46



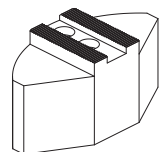
AWB-M

Long, pointed version
16MnCr5

Soft top jaws

- Metric serration
1.5 x 60° bzw. 3 x 60°

Page 48



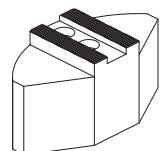
SBJ-M

16MnCr5

Soft pie jaws

- Metric serration
1.5 x 60°

Page 50



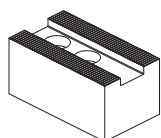
SBJ-MA

Light version
Aluminum F50

Soft pie jaws aluminum

- Metric serration
1.5 x 60°

Page 52



WBSA-M

C45 (flame hardenable)

Soft top jaws

- Metric serration
1.5 x 60°

Page 54

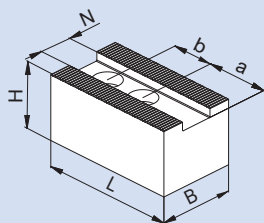
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

MAB-M



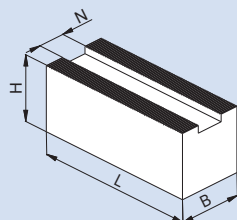
Soft top jaw-blanks without holes and with holes drilled

- Metric serration, 1.5 x 60°
- Material: 16MnCr5 , Serration ground

Type	Id. No. without holes	Id. No. with holes*	B	H	L	N	Serration	a + b	ISO 4762	kg / piece without holes
MAB-M 1001	091320	091321	25	50	60	10	1.5 x 60°	*	M8	0.57
MAB-M 1201	091322	091323	35	60	80	12	1.5 x 60°	*	M10	1.28
MAB-M 1401	091324	091325	40	60	95	14	1.5 x 60°	*	M12	1.72
MAB-M 1601	091326	091327	40	80	110	16	1.5 x 60°	*	M12	2.68
MAB-M 2101	091330	091331	50	120	130	21	1.5 x 60°	*	M16	5.99

* Indicate dimensions a+b when ordering the version with holes drilled

MAB-ML



Soft top jaw-blanks long, without holes drilled

- Metric serration, 1.5 x 60°
- Material: 16MnCr5 , Serration ground

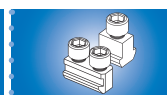
Type	Id. No. without holes	B	H	L	N	Serration	kg / piece
MAB-ML 1201	233340	35	60	420	12	1.5 x 60°	6.69
MAB-ML 1401	236498	40	80	420	14	1.5 x 60°	10.26
MAB-ML 1402	236500	60	60	420	14	1.5 x 60°	11.55
MAB-ML 1601	231039	40	80	420	16	1.5 x 60°	10.23
MAB-ML 1602	236499	60	60	420	16	1.5 x 60°	11.52
MAB-ML 2101	233344	50	80	420	21	1.5 x 60°	12.77
MAB-ML 2102	233383	60	120	420	21	1.5 x 60°	23.30

Other dimensions or serrations on request.

Please use the data sheet on page 55 for ordering.



• SMW-AUTOBLOK
• 55, 68, 158, 160

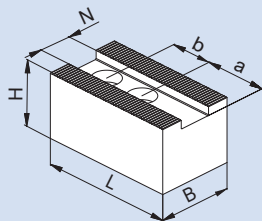


• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

WBJ/WBSA-M



Soft top jaws for SMW-AUTOBLOK power chucks

- Metric serration 1.5 x 60° or 3 x 60°
- Material: 16MnCr5/ C45
- Serration ground

Type	Id. No.	B	H	L	N	Serration	a + b for ISO 4762	kg	SMW-AUTOBLOK
WBJ-M 1001	081682*	25	25	55	10	1.5 x 60°	32 + 14 M8	0.60*	
WBJ-M 1002	081683*	30	40	55				1.22*	
WBSA-M 165 ²	12071621**	30	35	70	12	1.5 x 60°	34 + 20 M10	1.26**	HFKN-M 165 AN/AL/BH-M 165
WBJ-M 1201	081688*	30	40	72			37 + 20 M10	1.55*	BHM-FC 165 RC-M 165
WBJ-M 1202	081689*	35	50	72				2.36*	AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
WBSA-M 210 ²	12072121**	35	40	90	14	1.5 x 60°	45 + 25 M12	2.21**	HFKN-M 210 AN/AL/BH-M 210
WBJ-M 1401	081690*	35	50	90				2.96*	BB-M 210 BHM-FC 210
WBJ-M 1402	081691*	40	40	90				2.77*	RC-M 210
WBJ-M 1403	081692*	40	60	90				4.17*	AP/APL/NT-M 215 HB/PB/PBI-M 210
WBJ-M 1403/4	5311479	40	60	90				5.56*	BP-M 220 Centco4-M 210/260/315
WBJ-M 1404	081693*	40	80	90				5.57*	
WBJ-M 1405	081694*	40	100	90				6.97*	
WBJ-M 1601	081696*	40	40	85	16	1.5 x 60°	40 + 25 M12	2.57*	
WBJ-M 1603	081698*	40	60	110				5.23*	
WBJ-M 1604	081699*	40	80	90				5.55*	
WBSA-M 250 ²	12072621**	45	45	110	16	1.5 x 60°	60 + 30 M12	4.19**	HFKN-M 260 AN/AL/BH-M 250
WBJ-M 1611	081700*	40	40	110			50 + 30 M12	3.46*	BB-M 250 BHM-FC 250
WBJ-M 1612	081701*	40	60	110				5.23*	RC-M 250
WBJ-M 1613	081702*	50	80	90			45 + 30 M12	7.24*	AP/APL/NT-M 260 HB/PB/PBI-M 250
WBJ-M 1614	081703*	50	100	90				9.06*	BP-M 260
WBJ-M 1802	081706*	50	50	120	18	1.5 x 60°	60 + 30 M14	5.98*	
WBJ-M 1803	081707*	50	80	130				10.49*	
WBJ-M 1805	081709*	50	120	130			70 + 30 M14	15.77*	
WBSA-M 315 ¹	12073001**	50	50	125	21	1.5 x 60°	22+30+30 M16	5.54**	HFKN-M 315 BHM-FC 315
WBJ-M 2111	081712*	60	80	126			72 + 30 M16	12.15*	AN/AL/BH-M 315 BB-M 315
WBJ-M 2112	236505*	50	60	129			60 + 30 M16	7.52*	RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315 BP-M 320
WBJ-M 2201	081714*	60	80	156	22	1.5 x 60°	87 + 43 M20	14.39*	
WBJ-M 2501	530711*	80	80	195	25	3 x 60°	85 + 60 M20	25.70*	

* Jaws / Set

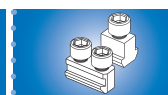
** Jaw / Piece

¹ Material: C45

² Material: C45 and jaws pointed



• SMW-AUTOBLOK
• 55, 68, 158, 160



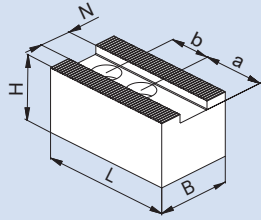
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Howa	Samchully	Kitagawa	Schunk
HO1MA4 HO24M5	HC 04 HCL 04 HCT 04 HC 05 • HS 05	AS 110 B-204/-205 N-04 NJ-04 • NL-04	
HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	HC 06 HCH 06 HCL 06 HCLT 06 HCT 06 MH 206 HS 06 HSL 06 MHT 206	AS165 B-06/-106/-160/-206 BB-06/-206 • BL-206 B-07 • BR06 • HJA 5-6 HOB-6 • HO-6 HOH-06/-106 HOH-160/-206 HOS 6 • N-06/-160 NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC/NCF 165
HO7MA8 HO15MA8 HO23MA8	HC 08 HCH 08 HCL 08 HCLT 08 HCT 08 MH 208 HS 08 HSF 08 HSL 08 MHT 208	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 • BR08 • HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 • N-08/-200 NL-08	HSL 210 ROTA NC/ NCD 210 ROTA NCF/NCK 210 ROTA NCK plus 210 ROTA NC plus 210 ROTA NCF plus 210
HO7MA10 H15MA10 H23MA10 HO22MA8 HO24MA8 HO27MA8 HO73MA8 HO47MA8			
	HC 10 HCH 10 HCL 10 HCLT 10 HCT 10 MH 210 HS 10 HSF 10 HSL 10	AS250 B-10/-110/-210 B-210X/-250 BB-10/-210 BL-210 • BR10 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC/NCD 250 ROTA NCF/NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	HC 12 HCH 12 HCL 12	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 • HOB-12 HOH-12/300 HOS-12 N-12/-300 NL-12	HSL 315 ROTA NC/NCF 315
	MH 212 HS 12 HSF 12 HSL 12	B-212 BB-212 BL-212 BR12	HSL 315 ROTA NCD 315 ROTA NCK 315 ROTA NC plus 315 ROTA NCK plus 315 ROTA NCF plus 315
	HC 15 HCH 15 HC 18 HCH 18	B-15/-18 B-380/-450 HOH-15 • HOH-15K HOH-380	HSL 400 ROTA NC/NCF 400
	HC 21 • HCH 21 MH 221 HC24 • HCH 24 MH 224	B-21/24 HJ-18/21/24 HOB-21/24 N-21/24	

WBJ-MA



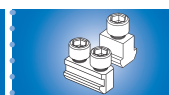
Soft top jaws aluminum light version

- Metric serration 1.5 x 60°
- Material: Aluminum (tensile strength = 500 N/mm²)

Type	Id. No.	B	H	L	N	Serration	a + b for ISO 4762	kg / Set	SMW-AUTOBLOK
WBJ-MA 120	036017	35	50	72	12	1.5 x 60°	37 + 20 M10	0.84	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
WBJ-MA 140	081728	40	60	90	14	1.5 x 60°	45 + 25 M12	1.49	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
WBJ-MA 165	081730	40	60	110	16	1.5 x 60°	55 + 30 M12	1.88	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
WBJ-MA 180	081731	50	80	130	18	1.5 x 60°	60 + 30 M14	3.76	
WBJ-MA 210	039511	50	80	130	21	1.5 x 60°	60 + 30 M16	3.63	HFKN-M 315 BHM-FC 315 AN/AL/BH-M 315 BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315



• SMW-AUTOBLOK
• 55, 68, 158, 160



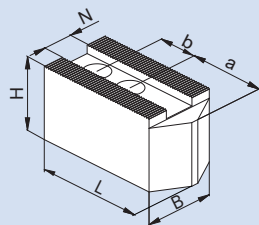
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Howa	Samchully	Kitagawa	Schunk
HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	HC 06 HCH 06 HCL 06 HCLT 06 HCT 06 MH 206 HS 06 HSL 06 MHT 206	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 • BR06 HJA 5-6 • HOB-6 HO-6 • HOS-6 HOH-06/-106 HOH-160/-206 N-06/-160 • NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC 165 ROTA NCF 165
HO7MA8 HO15M8 HO23M8	HC 08 HCH 08 HCL 08 HCLT 08 HCT 08 MH 208 HS 08 HSF 08 HSL 08 MHT 208	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 • BR08 • HJA 6-8 HO 8 • HOB 8 HOH-8/-108 HOH-200/-208 HOS 8 N-08/-200 • NL-08	HSL 210 ROTA NCD 210 ROTA NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC plus 215 ROTA NCF plus 215
	HC 10 HCH 10 HCL 10 HCLT 10 HCT 10 MH 210 HS 10 HSF 10 HSL 10	AS250 B-10/-110/-210 B-210X/-250 BB-10/-210 BL-210 • BR10 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110 HOH-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC ROTA NCD 250 ROTA NCF 250 ROTA NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	HC 12 HCH 12 HCL 12	B-12 • B-300 N-12 • N-300 HO-12 • HOH 300 HOB/HOS/HOH-12 HJA6-12/8-12 HLA 6-12/5-18/8-15 N 12 • N 300	HSL 315 ROTA NC 315 ROTA NCF 315
	MH 212 HS 12 HSF 12 HSL 12	B-212 BB-212 BL-212 BR12	HSL 315 ROTA NCD 315 ROTA NCK 315 ROTA NC plus 315 ROTA NCK plus 315 ROTA NCF plus 315

AWB-M



Soft top jaws long, pointed version

- Metric serration 1.5 x 60° or 3 x 60°
- Material 16MnCr5, Serration ground

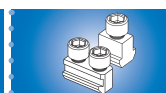
Type	Id. No.	B	H	L	N	Serration	a + b for ISO 4762	kg / Set	SMW-AUTOBLOK
AWB-M 1201	081719	32	32	82	12	1.5 x 60°	47 + 20 M10	1.49	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165 HFKS-2G-M 165
AWB-M 1401	081720	35	40	102	14	1.5 x 60°	57 + 25 M12	2.60	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210 HFKS-2G-M 210
AWB-M 1401/4	5311476**	35	40	102	14	1.5 x 60°	57 + 25 M12	3.50	Centco4-M 210/260/315
AWB-M 1611	081722	40	42	125	16	1.5 x 60°	65 + 30 M12	4.00	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250 HFKS-2G-M 255
AWB-M 1802	081723	50	50	145	18	1.5 x 60°	85 + 30 M14	7.01	
AWB-M 2101	236517	50	50	145	21	1.5 x 60°	85 + 30 M16	6.83	HFKN-M 315 BHM-FC 315 AN/AL/BH-M 315 BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315 HFKS-2G-M 320
AWB-M 400*	036791	60	60	140	25.5	3 x 60°	80 + 35 M20	9.42	HFKN-M 400 HFKN-M 500

* Not pointed

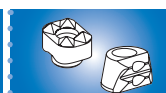
** 1 Set = 4 pieces



• SMW-AUTOBLOK
• 55, 68, 158, 160



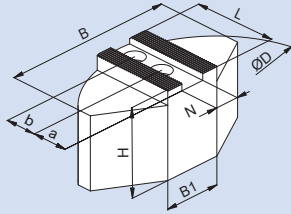
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Howa	Samchully	Kitagawa	Schunk
HO7MA6	HC 06	AS165	HSL 165
HO15M6	HCH 06	B-06/-106/-160/-206	ROTA NC plus 185
HO22M6	HCL 06	BB-06/-206	ROTA NCF plus 185
HO24M6	HCLT 06	BL-206 • B-07 • BR06	ROTA NCK 165
HO27M6	HCT 06	HJA 5-6	ROTA NCK plus 165
HO37M6	MH 206	HOB-6 • HO-6	ROTA NC/NCF 165
HO47M6	HS 06	HOH-06/-106	
	HSL 06	HOH-160/-206	
	MHT 206	HOS 6	
		N-06/-160 • NL-06	
HO7MA8	HC 08	AS210	HSL 210
HO15MA8	HCH 08	B-08/-108/-200/-208	ROTA NCD 210
HO23MA8	HCL 08	BB-08/-208	ROTA NCK 210
	HCLT 08	BL-208 • BR08 • HJA 6-8	ROTA NCK plus 210
	HCT 08	HO 8 • HOB 8	ROTA NC plus 215
	MH 208	HOH-8/-108	ROTA NCF plus 215
	HS 08	HOH-200/-208	
	HSF 08	HOS 8	
	HSL 08	N-08/-200 • NL-08	
	MHT 208		
	HC 10	AS250	HSL 250
	HCH 10	B-10/-110/-210	ROTA NC/NCD 250
	HCL 10	B-210X/-250	ROTA NCF/NCK 250
	HCLT 10	BB-10/-210 • BL-210 • BR08	ROTA NCK plus 250
	HCT 10	HJA 6-10/ 8-10	ROTA NC plus 260
	MH 210	HO-10 • HOB-10	ROTA NCF plus 260
	HS 10	HOH-10/-110	
	HSF 10	HOH-210/-250	
	HSL 10	HOS-10	
		N-10/-250 • NL-10	
HO7MA12	HC 12	B-12/-300	HSL 315
HO15M12	HCH 12	HJA 6-12/8-12	ROTA NC/NCF 315
H23M12	HCL 12	HLA 6-15/8-15	
HO22M10		HO-12 • HOB-12	
HO24M10		HOH-12/300	
HO27M10		HOS-12	
HO37M10		N-12/-300 • NL-12	
HO47M10			
	MH 212	B-212	HSL 315
	HS 12	BB-212	ROTA NCD 315
	HSF 12	BL-212	ROTA NCK 315
	HSL 12	BR12	ROTA NC plus 315
			ROTA NCKplus 315
			ROTA NCF plus 315

SBJ-M



Soft pie jaws

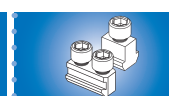
- Metric serration 1.5 x 60°
- Material: 16MnCr5, Serration ground

Type	Id. No.	B	B ₁	H	L	D	N	Serration	a + b for ISO 4762	kg / Set	SMW-AUTOBLOK
SBJ-M 160	036016	120	50	50	60	160	12	1.5 x 60°	25 + 20 M10	5.15	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
SBJ-M 200	081724	140	70	60	70	200	14	1.5 x 60°	30 + 25 M12	9.02	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
SBJ-M 200/4	5311478*	140	70	60	70	200	14	1.5 x 60°	30 + 25 M12	12.00	Centco4-M 210/260/315
SBJ-M 250	081726	180	100	60	80	250	16	1.5 x 60°	30 + 30 M12	12.24	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
SBJ-M 315	231104	240	120	70	110	300	21	1.5 x 60°	45 + 30 M16	26.03	HFKN-M 315 BHM-FC 315 AN/AL/BH-M 315 BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315

* 1 Set = 4 pieces



• SMW-AUTOBLOK
• 55, 68, 158, 160



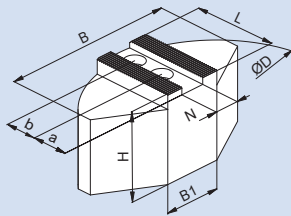
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Howa	Samchully	Kitagawa	Schunk
HO7MA6	HC 06	AS165	HSL 165
HO15M6	HCH 06	B-06/-106/-160-206	ROTA NC plus185
HO22M6	HCL 06	BB-06/-206	ROTA NCF plus185
HO24M6	HCLT 06	BL-206 • B-07 • BR06	ROTA NCD 165-185
HO27M6	HCT 06	HJA 5-6	ROTA NCK 165
HO37M6	MH 206	HOB-6 • HO-6	ROTA NCK plus 165
HO47M6	HS 06	HOH-06/-106	ROTA NC/NCF 165
	HSL 06	HOH-160/-206	
	MHT 206	HOS 6	
		N-06/-160 • NL-06	
HO7MA8	HC 08	AS210	HSL 210
HO15MA8	HCH 08	B-08/-108/-200/-208	ROTA NCD 210
HO23MA8	HCL 08	BB-08/-208	ROTA NCK 210
	HCLT 08	BL-208 • BR08	ROTA NC 210
	HCT 08	HJA 6-8	ROTA NCF 210
	MH 208	HO 8 • HOB 8	ROTA NCK plus 210
	HS 08	HOH-8/-108/-200	ROTA NC 215
	HSF 08	HOH-208 • HOS 8	ROTA NCF plus 215
	HSL 08	N-08/-200 • NL-08	
	MHT 208		
	HC 10	AS250	HSL 250
	HCH 10	B-10/-110/-210	ROTA NC/NCD 250
	HCL 10	B-210X/-250	ROTA NCF 250
	HCLT 10	BB-10/-210	ROTA NCK 250
	HCT 10	BL-210 • BR10	ROTA NCK plus 250
	MH 210	HJA 6-10/8-10	ROTA NC 260
	HS 10	HO-10 • HOB-10	ROTA NCF plus 260
	HSF 10	HOH-10/-110	
	HSL 10	HOH-210/-250	
		HOS-10	
		N-10/-250 • NL-10	
	MH 212	B-212	HSL 315
	HS 12	BB-212	ROTA NCD 315
	HSF 12	BL-212	ROTA NCK 315
	HSL 12	BR12	ROTA NC plus 315
			ROTA NCK plus 315
			ROTA NCF plus 315

SBJ-MA



Soft pie jaws aluminum light version

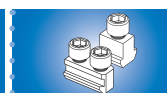
- Metric serration 1.5 x 60°
- Material: Aluminum (tensile strength = 500 N/mm²)

Type	Id. No.	B	B ₁	H	L	D	N	Serration	a + b for ISO 4762	kg / Set	SMW-AUTOBLOK
SBJ-MA 160	036018	120	40	58	59.5	165	12	1.5 x 60°	25 + 20 M10	2.06	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
SBJ-MA200	081732	140	50	58	75	200	14	1.5 x 60°	35 + 25 M12	3.04	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
SBJ-MA200/4	5311477*	140	50	58	75	200	14	1.5 x 60°	35 + 25 M12	4.10	Centco4-M 210/260/315
SBJ-MA250	081734	180	70	58	87.5	250	16	1.5 x 60°	40 + 30 M12	4.42	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
SBJ-MA 315	236520	240	80	78	117	320	21	1.5 x 60°	45 + 30 M16	10.85	HFKN-M 315 BHM-FC 315 AN/AL/BH-M 315 BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315

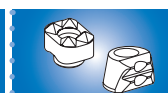
* 1 Set = 4 pieces



• SMW-AUTOBLOK
• 55, 68, 158, 160



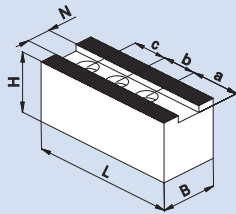
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Howa	Samchully	Kitagawa	Schunk
HO7MA6	HC 06	AS165	HSL 165
HO15M6	HCH 06	B-06/-106/-160/-206	ROTA NC 185
HO22M6	HCL 06	BB-06/-206	ROTA NCF plus 185
HO24M6	HCLT 06	BL-206 • B-07 • BR06	ROTA NCD 165-185
HO27M6	HCT 06	HJA 5-6	ROTA NCK 165
HO37M6	MH 206	HOB-6 • HO-6	ROTA NCK plus 165
HO47M6	HS 06	HOH-06/-106	ROTA NC 165
	HSL 06	HOH-160/-206	ROTA NCF 165
	MHT 206	HOS 6	
		N-06/-160 • NL-06	
HO7MA8	HC 08	AS210	HSL 210
HO15MA8	HCH 08	B-08/-108/-200/-208	ROTA NCD 210
HO23MA8	HCL 08	BB-08/-208	ROTA NCK 210
	HCLT 08	BL-208 • BR08	ROTA NC 210
	HCT 08	HJA 6-8	ROTA NCF 210
	MH 208	HO 8 • HOB 8	ROTA NCK plus 210
	HS 08	HOH-8/-108	ROTA NC 215
	HSF 08	HOH-200/-208	ROTA NCF plus 215
	HSL 08	HOS 8	
	MHT 208	N-08/-200 • NL-08	
	HC 10	AS250	HSL 250
	HCH 10	B-10/-110/-210	ROTA NC/NCD 250
	HCL 10	B-210X/-250	ROTA NCF 250
	HCLT 10	BB-10/-210	ROTA NCK 250
	HCT 10	BL-210 • BR10	ROTA NCK plus 250
	MH 210	HJA 6-10/8-10	ROTA NC 260
	HS 10	HO-10 • HOB-10	ROTA NCF plus 260
	HSF 10	HOH-10/-110	
	HSL 10	HOH-210/-250	
		HOS-10	
		N-10/-250 • NL-10	
	MH 212	B-212	HSL 315
	HS 12	BB-212	ROTA NCD 315
	HSF 12	BL-212	ROTA NCK 315
	HSL 12	BR12	ROTA NC plus 315
			ROTA NCK plus 315
			ROTA NCF plus 315

WBSA-M



Soft top jaws

- Metric serration 1.5 x 60°
- Material: C45

Type	Id. No.	B	H	L	N	Serration	a + b + c f. ISO 4762	kg / piece	SMW-AUTOBLOK
WBSA-M 125*	12071301	30	30	60	12	1.5 x 60°	29 + 16 M8	0.32	AN-/AL-M 125 BH-M 130 BB-M 140 HB/PB-M130
WBSA-M 165*	12071621	30	35	70	12	1.5 x 60°	34 + 20 M10	0.42	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
WBSA-M 210*	12072121	35	40	90	14	1.5 x 60°	45 + 20 M12	0.74	HFKN-M 210 AN/AL/BH/BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
WBSA-M 250*	12072621	45	45	110	16	1.5 x 60°	60 + 30 M12	1.40	HFKN-M 260 AN/AL/BH/BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
WBSA-M 315	12073001	50	50	125	21	1.5 x 60°	22 + 30 + 30 M16	1.85	HFKN-M 315 BHM-FC 315 AN/AL/BH/BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315
WBSA-M 400	12074031	60	60	140	21	1.5 x 60°	25 + 34 + 34 M16	3.21	RC-M 400 GH-M 400
WBSA-M 401	12074021	60	60	140	22	1.5 x 60°	75 + 38 M20	3.20	AP/AP-L/NT-M 400 AN/AL-M 400 BH-M 400/450 BHM-FC 400

* Jaws pointed



• SMW-AUTOBLOK
• 55, 68, 158, 160



• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 80

Modified standard jaw-blanks according to your specifications

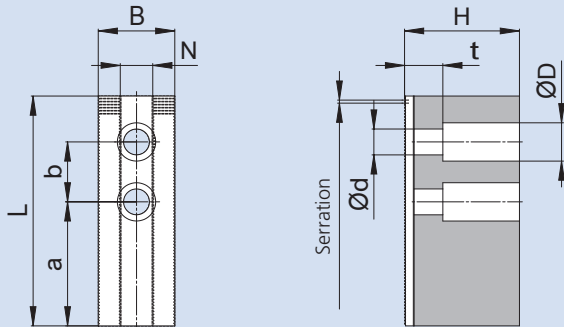
Reduced weight and / or pointed for small clamping diameters

Your benefits:

- You will quickly receive the right offer
- The jaws are made from blanks, which makes them inexpensive and available in shorter time
- Economical alternative to special jaws
- No machining is required on the clamping jaws by the customer
- Clamping diameter can be turned out by the customer on the machine under clamping pressure = best concentricity
- Clamping of small workpiece diameters due to tapered clamping surface
- If you have any questions in advance, please contact sales@smw-autoblok.de

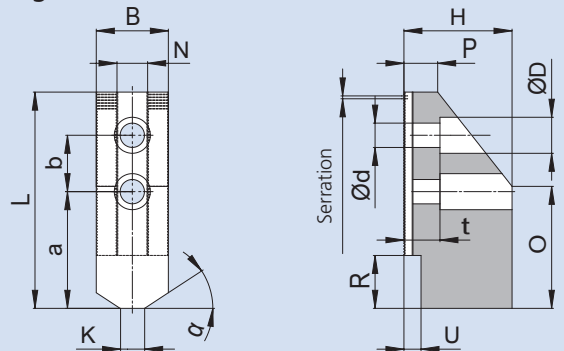
interactive PDF available
at www.smw-autoblok.de

Soft top jaw-blanks



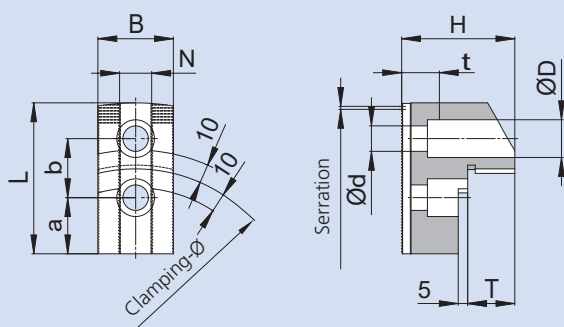
Dimensions					
a		mm	H		mm
b		mm	L		mm
B		mm	N		mm
d		mm	t		mm
D		mm			
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Soft top jaw-blanks weight reduced



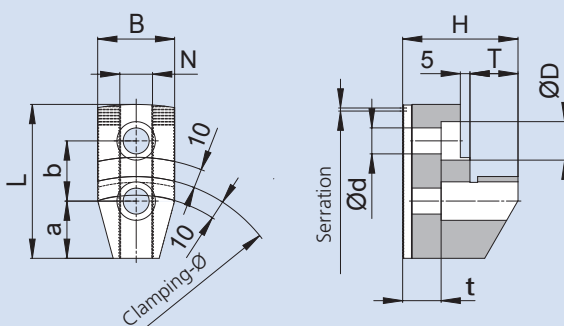
Dimensions					
a		mm	K		mm
b		mm	O		mm
B		mm	P		mm
d		mm	R		mm
D		mm	t		mm
H		mm	U		mm
L		mm	α		Grad
N		mm			
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Soft top jaws for OD clamping



Dimensions					
a		mm	L		mm
b		mm	N		mm
B		mm	t		mm
d		mm	T		mm
D		mm	Clamping-Ø		mm
H		mm	Workpiece-Ø		mm
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

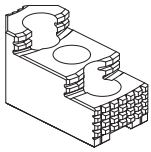
Soft top jaws for ID clamping



Dimensions					
a		mm	L		mm
b		mm	N		mm
B		mm	t		mm
d		mm	T		mm
D		mm	Clamping-Ø		mm
H		mm	Workpiece-Ø		mm
Jaw serration / material (please mark)					
		1/16" x 90°			1.5 x 60°
		3/32" x 90°			3 x 60°
Material		Steel		Alu	
Quantity in pieces					
Chuck manufacturer					
Chuck type + size					

Hard top jaws – Metric serration

SMW-AUTOBLOK | Howa | Samchully | Kitagawa | Schunk



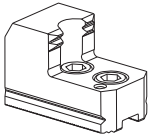
MHB-M

Reversible

Hard top jaws

- Metric serration
1.5 x 60° or 3 x 60°

Page 60



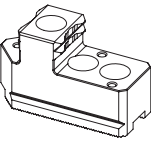
GG-M

For internal and external clamping

Hard roughing jaws

- Metric serration
1.5 x 60°

Page 62



GG-M

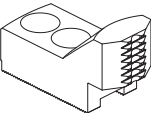
For Centco4

For internal and external clamping

Hard roughing jaws

- Metric serration
1.5 x 60°

Page 64



GSG-M

Hard bar roughing jaws

- Metric serration
1.5 x 60°

Page 66

Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

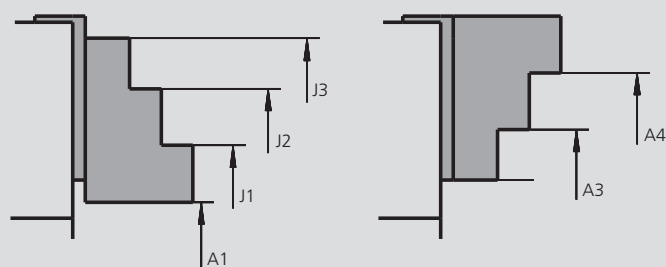
Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

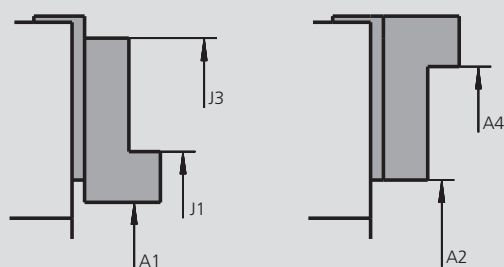
Clamping ranges with standard stepped hard top jaws

■ Standard chucks Ø 125 - 800 mm

2 step top jaws



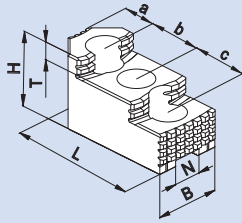
1 step top jaws*



Chuck diameter	Chuck type	Top jaws Id. No. Serr. "M"	A1 mm	A2 mm	A3 mm	A4 mm	J1 mm	J2 mm	J3 mm
125	AN-, AL-	12081307	10-54	-	54-92	90-120	56-100	90-135	125-170
165-170	AN-, AL-, AP-, NT-	12081627	14-80	-	62-125	110-155	65-125	115-175	145-210
210-215	AN-, AL-, AP-, NT-	12082127	20-100	-	72-150	150-200	75-150	145-230	190-265
250	AN-, AL-	12082627	20-115	-	105-205	190-235	80-165	155-250	230-325
260	AP-, NT-	12082627	20-130	-	105-215	180-245	80-180	155-260	220-330
315	AN-, AL-, AP-, NT-	12083037	30-170	-	120-265	205-300	95-225	165-310	240-380
400	AN-, AL-	12084527	52-205	-	180-330	280-370	140-285	240-385	330-480
400	AP-, NT-	12084527	35-200	-	165-325	260-370	125-280	220-380	315-480
500	IN-D, IL-D	-	80-320	125-365	-	320-475	180-420	-	370-610
630	IN-D, IL-D	-	80-440	125-485	-	320-600	180-540	-	370-730
800	IN-D, IL-D	-	80-610	125-655	-	320-760	180-710	-	370-900
500	APLD	-	60-310	-	185-440	285-470	145-390	245-490	340-590
630	APLD	-	60-440	-	185-570	285-600	145-520	245-620	340-720
800	APLD	-	60-610	-	185-740	285-760	145-690	245-790	340-890
500	IEPD	-	85-320	-	210-450	310-480	170-400	270-500	370-600
630	IEPD	-	85-440	-	210-570	310-600	170-520	270-620	370-720
800	IEPD	-	85-610	-	210-740	310-760	170-690	270-790	370-890
130	BH-, BH-	12081307	10-58	-	55-97	90-120	58-105	90-140	125-175
140	BB-, BB-	12081307	16-65	-	55-105	90-130	65-110	98-148	132-182
165	BH-, BH-FC, RC-	12081627	12-80	-	62-125	110-155	62-125	105-170	145-210
175	BB-D, BB-M	12081627	25-92	-	74-138	120-165	74-138	118-185	155-220
180	HYND-S	12081627	27-95	-	77-140	125-170	77-140	120-185	160-225
210	BH-, BH-FC, RC-, HYND-S	12082127	14-100	-	65-150	140-200	65-150	135-230	180-265
210	BB-D, BB-M	12082127	25-100	-	80-150	155-200	80-150	150-230	195-265
226	HYND-S	12082127	24-110	-	75-160	150-215	75-160	145-240	190-275
250	BH-D, BHD-FC, RC-, HYND-S	12083037	20-115	-	105-205	190-235	80-165	155-250	230-325
250	BH-M, BHM-FC	12082627	20-115	-	105-205	190-235	80-165	155-250	230-325
250	BB-D, BB-M	12083037	25-115	-	115-205	200-235	85-165	165-250	240-325
305	RC-D, RC-M	12083037	25-160	-	120-250	205-290	85-215	165-300	240-370
315	BH-, BH-FC, HYND-S	12083037	40-170	-	135-265	220-300	100-225	180-310	250-380
315	BB-D, BB-M	12083037	75-170	-	165-265	250-300	130-225	210-310	320-415
400	RC-	12084007	90-250	-	195-355	285-380	155-315	240-400	330-490
400	BH-, BH-FC, HYND-S	12084527	52-205	-	180-330	280-370	140-285	240-385	330-480
450	BH	12084527	52-265	-	180-390	280-430	140-345	240-445	330-540
500	BH	-	115-325	-	240-450	340-480	200-410	300-510	395-610
500	BH-FC	-	90-320	-	220-445	320-480	175-400	275-500	370-600
500	HYDL-S	-	150-320	-	275-445	375-480	230-400	330-500	430-600
550	HYDL-S	-	200-370	-	330-500	430-535	285-455	385-555	485-655
630	BH	-	195-420	240-465	-	440-600	295-520	-	490-715
630	BH-FC	-	135-440	-	260-565	360-600	220-520	315-620	415-720
630	HYDL-S	-	230-450	-	360-575	460-600	315-530	415-630	515-730
800	BH	-	195-590	240-635	-	440-760	295-690	-	490-880
800	HYDL-S	-	245-595	295-640	-	490-760	345-695	-	540-890

* Note: AN means AND, ANM; AL means ALD, ALM; AP means APD, APM; NT means NTD, NTM; BH means BHD, BHM; BH-FC means BHD-FC, BHM-FC; RC means RCD, RCM.

MHB-M



Hard, reversible top jaws

- Metric serration 1.5 x 60° or 3 x 60°
- Serration ground

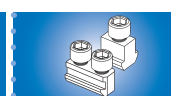
Type	Id. No.	B	H	L	T	N	Serration	a + b + c for ISO 4762	kg / Set	SMW-AUTOBLOK
MHB-M 120	081032	35	44	80	10	12	1.5 x 60°	24 + 20 + 20 M10	1.60	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165
MHB-M 121	12081627	34	39	67.3	10	12	1.5 x 60°	14 + 20 + 20 M10	0.93	RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165 HFKS-2G-M 165
MHB-M 122	12081307	30	34	58	9	12	1.5 x 60°	13 + 16 + 16 M8	0.60	AN/AL-M 125 BH-M 130 BB-M 140 HB/PB-M 130
MHB-M 140	12082127	40	45	86	10.5	14	1.5 x 60°	19 + 25 + 25 M12	1.80	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210 HFKS-2G-M 210
MHB-M 140/4	12082129**	40	45	86	10.5	14	1.5 x 60°	19 + 25 + 25 M12	2.40	Centco4-M 210/260/315
MHB-M 160 ¹	081045	40	42	83	15	16	1.5 x 60°	17 + 25 + 25 M12	1.50	
MHB-M 161	12082627	45	56	100.1	13.5	16	1.5 x 60°	23 + 30 + 30 M12	2.55	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250 HFKS-2G-M 255
MHB-M 180	081038	50	60	109.2	15	18	1.5 x 60°	23.5 + 30 + 30 M14	5.10	
MHB-M 211	12083037	45	56	105	13.5	21	1.5 x 60°	26 + 30 + 30 M16	2.85	HFKN-M 315 BHM-FC 315 AN/AL/BH-M 315 BB-M 315 RC-M 305 AP/APL/NT-M 315 HB/PB/PBI-M 315 HFKS-2G-M 320
MHB-M 400	12084007	55	73	120	22	21	1.5 x 60°	30 + 34 + 34 M16	5.10	GH-M 400 RC-M 400
MHB-M 401	12084527	60	75	140	19	22	1.5 x 60°	38 + 38 M20	7.50	AP/AP-L/NT-M 400 AN/AL-M 400 BH-M 400/450 BHM-FC 400
MHB-M 402	231032	60	86	143	20	22	1.5 x 60°	33 + 43 + 43 M20	9.00	
MHB-M 500 ¹	037126	55	73	145	32	25.5	3 x 60°	46 + 38 + 38 M20	6.70	HFKN-M 400 HKFN-M 500

¹ 1 step only

** 1 Set = 4 pieces



• SMW-AUTOBLOK
• 68, 158, 160



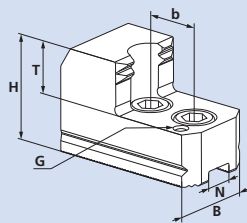
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 147

Howa	Samchully	Kitagawa	Schunk
HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	HC 06 HCH 06 HCL 06 HCLT 06 HCT 06 MH 206 HS 06 HSL 06 MHT 206	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 • BR06 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC 165 ROTA NCF 165
HO7MA8 HO15MA8 HO23MA8	HC 08 HCH 08 HCL 08 HCLT 08 HCT 08 MH 208 • HS 08 HSF 08 • HSL 08 MHT 208	AS210 B-08/-108/-200/-208 BB-08/-208 • BL-208 • BR08 HJA 6-8 • HO 8 HOB 8 HOH-8/-108/-200/-208 HOS 8 • N-08/-200 NL-08	HSL 210 ROTA NCD 210 ROTA NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC 215 ROTA NCF plus 215
HO7MA10 H15MA10 H23MA10 HO22MA8 HO24MA8 HO27MA8 HO73MA8 HO47MA8			
	HC 10 HCH 10 HCL 10 HCLT 10 HCT 10 MH 210 HS 10 HSF 10 HSL 10	AS 250 B-10/-110/-210 B-210X/-250 BB-10/-210 • BL-210 • BR10 HJA 6-10/8-10 HO-10 • HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC 250 ROTA NCD 250 ROTA NCF 250 ROTA NCK 250 ROTA NCK plus 250 ROTA NC 260 ROTA NCF plus 260
HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	HC 12 HCH 12 HCL 12	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 • HOB-12 HOH-12/300 HOS-12 N-12/-300 NL-12	HSL 315 ROTA NC 315 ROTA NCF 315
	MH 212 HS 12 HSF 12 HSL 12	B 212 BB-212 BL-212 BR12	HSL 315 ROTA NCD 315 ROTA NCK 315 ROTA NC plus 315 ROTA NCF plus 315
	HC 15 HCH 15 HC 18 • HCH 18	B15/18 • B-350/450 HOH 15 • HOH 15K HOH 380	HSL 400 ROTA NC 400 ROTA NCF 400

GG-M



Hard roughing jaws for internal and external clamping

- Metric serration 1.5 x 60°
- Serration ground

Type	Id. No.	Internal clamping	External clamping	B	H	T	G	N	Serration	b	kg / Set	SMW-AUTOBLOK
GG-M 010	5311500	-	26-48	35	45	20	M5	12	1.5 x 60°	20	1.63	BH-M 165
GG-M 020	5311501	-	48-71				M6				1.39	HFKN-M 165
GG-M 030	5317820	143-167	71-91				M6				1.28	AN/AL/BH-M 165
GG-M 040	5317821	120-143	97-120				M6				1.41	BHM-FC 165
GG-M 050	5317822	97-120	120-144				M6				1.29	RC-M 165
GG-M 060	5318113	75-97	144-167				M6				1.23	AP/NT-M 170
GG-M 070	5317971	58-80	-	40	42		M6				1.34	BB-M 175
												HB/PB/PBI-M 165
												HFKS-2G-M 165
GG-M 080	5311502	-	30-70	35	50	25	M5	14	1.5 x 60°	25	2.00	BH-M 210
GG-M 090	5317465	179-218	70-111	40			M6				1.86	HFKN-M 210
GG-M 100	5317466	138-179	109-148	40			M6				1.74	AN/AL/BH/BB-M 210
GG-M 110	5317467	101-139	148-190	40			M6				2.31	BHM-FC 210
GG-M 120	5317468	79-101	188-209	40			M6				2.31	RC-M 210
												AP/APL/NT-M 215
												HB/PB/PBI-M 210
												HFKS-2G-M 210
GG-M 130	5317469	-	38-71	45	59	28	M8	16	1.5 x 60°	30	4.02	BH-M 250
GG-M 140	5317470	-	71-105								3.27	HFKN-M 260
GG-M 150	5317471	213-243	105-140	60							2.48	AN/AL/BH/BB-M 250
GG-M 160	5317472	180-215	140-175	60							2.28	BHM-FC 250
GG-M 170	5317473	146-181	175-208	50							3.61	RC-M 250
GG-M 180	5317474	114-149	208-243	50							4.11	AP/APL/NT-M 260
GG-M 190	5317475	81-115	243-263	50							4.10	HB/PB/PBI-M 250
												HFKS-2G-M 255
GG-M 200	5311504	-	40-98	45	59	28	M5	21	1.5 x 60°	30	4.16	BH-M 315
GG-M 210	5317477	280-346	98-166				M8				3.13	HFKN-M 315
GG-M 220	5317478	215-280	163-232				M8				3.28	AN/AL/BH/BB-M 315
GG-M 230	5317479	148-215	230-284	50		20	M8				4.75	BHM-FC 315
GG-M 240	5317480	99-162	284-346	50		22	M8				4.68	RC-M 305
GG-M 250	5318115	88-155	-	55	60	20	M8				5.48	AP/APL/NT-M 315
												HB/PB/PBI-M 315
												HFKS-2G-M 320
GG-M 260 ¹	5317481	-	57-123	62	80	40	M6	22	1.5 x 60°	38	11.42	BH-M 400
GG-M 270 ¹	5317482	372-416	123-193				M8				8.36	BH-M 450
GG-M 280 ¹	5317483	301-372	193-264				M6				6.38	
GG-M 290 ¹	5317484	230-301	263-335		60	20	M8				5.88	
GG-M 300 ¹	5317485	163-233	335-406			30	M8				9.56	

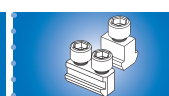
Note: The specified clamping range is valid for the BH-M chuck series. It may differ for other chucks.

* with single T-Nuts only

¹ Clamping range valid for chuck Ø 400



• SMW-AUTOBLOK
• 68, 158, 160



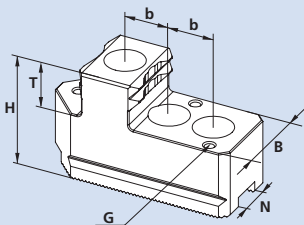
• SMW-AUTOBLOK
• 69



• SMW-AUTOBLOK
• 147

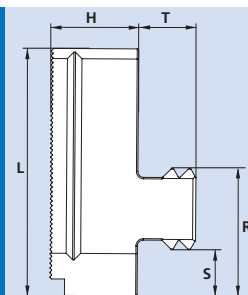
Howa	Samchully	Kitagawa	Schunk
HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	HC 06 HCH 06 HCL 06 HCLT 06 HCT 06 MH 206 HS 06 HSL 06 MHT 206	AS 165 B-06/-106/-160/-206 BB-06/-206 ▪ BL-206 B-07 ▪ BR06 ▪ HJA 5-6 HOB-6 ▪ HO-6 HOH-06/-106 HOH-160/-206 HOS 6 N-06/-160 ▪ NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC 165 ROTA NCF 165
HO7MA8 HO15MA8 HO23MA8	HC 08 HCH 08 HCL 08 HCLT 08 HCT 08 MH 208 HS 08 ▪ HSF 08 HSL 08 ▪ MHT 208	AS 210 B-08/-108/-200/-208 BB-08/-208 ▪ BL-208 ▪ BR08 HJA 6-8 ▪ HO-8 HOB-8 ▪ HOS-8 HOH-8/-108/-200/-208 N-08/-200 NL08	HSL 210 ROTA NCD 210 ROTA NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC plus 215 ROTA NCF plus 215
	HC 10 HCH 10 HCL 10 HCLT 10 HCT 10 MH 210 HS 10 HSF 10 HSL 10	AS 250 B-10/-110/-210/-210X/-250 BB-10/-210 ▪ BL-210 ▪ BR10 HJA 6-10/8-10 HO-10 ▪ HOB-10 HOH-10/-110/-210 HOH-250 ▪ HOS-10 N-10/-250 NL10	HSL 250 ROTA NC 250 ROTA NCD 250 ROTA NCF 250 ROTA NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
	MH 212 HS 12 HSF 12 HSL 12	B 212 BB-212 BL-212 BR12	HSL 315 ROTA NCD 315 ROTA NCK 315 ROTA NC plus 315 ROTA NCK plus 315 ROTA NCF plus 315
	HC 15* HCH 15* HC 18* HCH 18*	B-15/-18* B-380/-450* HOH-15* HOH-15K* HOH-380*	HSL 400 ROTA NC 400 ROTA NCF 400

GG-M



Hard roughing jaws for Centco4 for internal and external clamping

- Metric serration 1.5 x 60°
- Serration ground

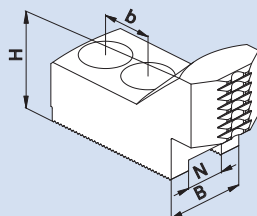


Type	Id. No.	Internal clamping*	External clamping*	B	H	L	R	S	T	G	N	b	Serration	kg / Set	SMW-AUTOBLOK
GG-M 210	5325559	113-210	46-201	35	50	85	49	15	20	M5	14	21.5	1.5x60°	2.27	Centco4 M210
GG-M 260	5325561	141-260	65-258	36	55	100	51	13.5	20	M5	14	23	1.5x60°	3.22	Centco4 M260
GG-M 315	5325563	147-315	51-308	40	55	110	65	17	20	M8	14	25	1.5x60°	4.22	Centco4 M315

* Attention: SMW-AUTOBLOK is recommending not to clamp any diameters, that are larger than the chuck O.D.
If you have any questions, please do not hesitate to contact our customer service.

Notes

GSG-M



Hard bar roughing jaws

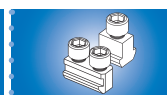
- Metric serration 1.5 x 60°
- Serration ground

Type	Id. No.	Clamping range Ø	B	H	N	Serration	b for ISO 4762	kg / Set	SMW-AUTOBLOK
GSG-M 120	091347	15-30	30	40	12	1.5 x 60°	20 M10	1.04	HFKN-M 165 AN/AL/BH-M 165 BHM-FC 165 RC-M 165 AP/NT-M 170 BB-M 175 HB/PB/PBI-M 165
GSG-M 140	091348	20-50	35	45	14	1.5 x 60°	25 M12	1.73	HFKN-M 210 AN/AL/BH-M 210 BB-M 210 BHM-FC 210 RC-M 210 AP/APL/NT-M 215 HB/PB/PBI-M 210
GSG-M 160	091349	20-60	40	50	16	1.5 x 60°	30 M12	2.60	HFKN-M 260 AN/AL/BH-M 250 BB-M 250 BHM-FC 250 RC-M 250 AP/APL/NT-M 260 HB/PB/PBI-M 250
GSG-M 180	091350	30-80	50	50	18	1.5 x 60°	30 M14	3.84	
GSG-M 210	091351	30-80	50	50	21	1.5 x 60°	30 M16	3.92	AN/AL-M 315 BH/BB-M 315 PB/PBI/HB-M 315 HFKN-M 315 AP/NT-M 315

Note: The specified clamping range is valid for the BH-M chuck series. It may differ for other chucks.



• SMW-AUTOBLOK
• 68, 158, 160



• SMW-AUTOBLOK
• 69

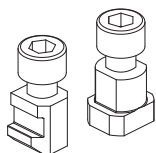


• SMW-AUTOBLOK
• 147

Howa	Samchully	Kitagawa	Schunk
HO7MA6 HO15M6 HO22M6 HO24M6 HO27M6 HO37M6 HO47M6	HC 06 HCH 06 HCL 06 HCLT 06 HCT 06 MH 206 HS 06 HSL 06 MHT 206	AS165 B-06/-106/-160/-206 BB-06/-206 BL-206 • B-07 • BR06 HJA 5-6 HOB-6 • HO-6 HOH-06/-106/-160/-206 HOS 6 N-06/-160 • NL-06	HSL 165 ROTA NC plus 185 ROTA NCF plus 185 ROTA NCD 165-185 ROTA NCK 165 ROTA NCK plus 165 ROTA NC 165 ROTA NCF 165
HO7MA8 HO15MA8 HO23MA8	HC 08 HCH 08 HCL 08 HCLT 08 HCT 08 MH 208 HS 08 HSF 08 HSL 08 MHT 208	AS210 B-08/-108/-200/-208 BB-08/-208 BL-208 • BR08 • HJA 6-8 HO 8 • HOB 8 HOH-8/-108/-200/-208 HOS 8 N-08/-200 NL-08	HSL 210 ROTA NCD 210 ROTA NCK 210 ROTA NC 210 ROTA NCF 210 ROTA NCK plus 210 ROTA NC plus 215 ROTA NCF plus 215
	HC 10 HCH 10 HCL 10 HCLT 10 HCT 10 MH 210 HS 10 HSF 10 HSL 10	AS250 B-10/-110/-210/-210X/-250 BB-10/-210 BL-210 • BR10 HJA 6-10/8-10 HO-10 HOB-10 HOH-10/-110/-210/-250 HOS-10 N-10/-250 • NL-10	HSL 250 ROTA NC 250 ROTA NCD 250 ROTA NCF 250 ROTA NCK 250 ROTA NCK plus 250 ROTA NC plus 260 ROTA NCF plus 260
HO7MA12 HO15M12 H23M12 HO22M10 HO24M10 HO27M10 HO37M10 HO47M10	HC 12 HCH 12 HCL 12	B-12/-300 HJA 6-12/8-12 HLA 6-15/8-15 HO-12 • HOB-12 HOH-12/300 HOS-12 N-12/-300 NL-12	HSL 315 ROTA NC 315 ROTA NCF 315
	MH 212 HS 12 HSF 12 HSL 12	B-212 BB-212 BL-212 BR12	HSL 315 ROTA NCD 315 ROTA NCK 315 ROTA NC plus 315 ROTA NCK plus 315 ROTA NCF plus 315

T-nuts | Grippers

SMW-AUTOBLOK | Forkardt | Howa | Samchully | Kitagawa | Röhm | Schunk



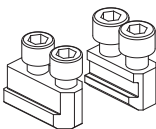
Page 70

NST

Quenched and ground

T-nuts

- For chucks with INCH SERRATION
1/16" x 90° or 3/32" x 90°



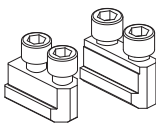
Page 74

NSTE

Quenched and ground

Double T-nuts

- For chucks with INCH SERRATION
1/16" x 90° or 3/32" x 90°



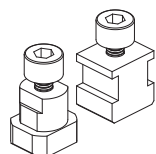
Page 76

NSTE-M

Quenched and ground

Double T-nuts

- For chucks with METRIC SERRATION
1.5 x 60°



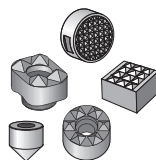
Page 78

NSO

Quenched and ground

Special T-nuts

- Order form



Page 80

Grippers UGE, FGH + HDS, Clamping points MGH

- Grippers special steel hardened
- Grippers solid carbide
- Clamping points



Page 83

Precision gripper inserts G14 + G25 - G15 + G30

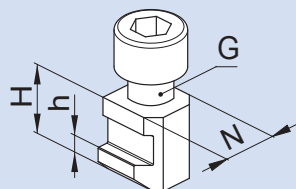
- Precision grippers inserts
- G14 light duty version
- G25 heavy duty version
- G15 light duty version
- G30 heavy duty version

Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

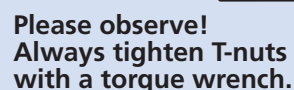


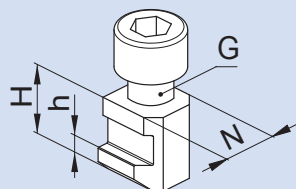
Version 1

T-nuts

- Quenched and ground
- Incl. screw ISO 4762 – 12.9

Type	Id. No.	Version	N	H	h	G	Screw ISO 4762	Torque Md max. (Nm)
NST 11	013862	2	11	21.5	7.5	M8	M8 x 30	30
NST 12	081966	2	12	17	7	M8	M8 x 20	30
NST 12-1	089810	2	12	21.5	7.5	M8	M8 x 25	30
NST 14	013863	2	14	26.5	9.5	M10	M10 x 35	50
NST 14-1	12062000	2	14	20	7.5	M10	M10 x 25	50
NST 14-2	035958	1	14	18.5	6.5	M10	M10 x 20	50
NST 14-3	163134	2	14	20	7.5	M10	M10 x 25	50
NST 17	016021	2	17	23	9	M12	M12 x 30	70
NST 17-1	085877	2	17	22.3	8.3	M12	M12 x 30	70
NST 17-2	034245	1	17	20.5	7.5	M12	M12 x 25	70
NST 17/14	036976	1	17	20.5	7.5	M12	M12 x 25	70
NST 17-3	081825	2	17	21.5	9	M12	M12 x 25	70
NST 17-4	013864	2	17	26.5	9.5	M12	M12 x 30	70
NST 17-5	064921	1	17	18.5	6.5	M12	M12 x 25	70
NST 21	014788	2	21	27	11	M16	M16 x 35	150
NST 21/17	081812	3	17/21	27	11	M12	M12 x 35	70
NST 21/16	162744	1	16	26.5	10	M12	M12 x 30	70

4

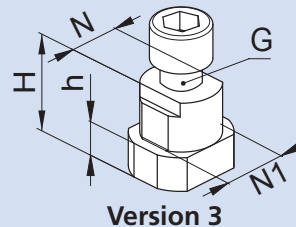
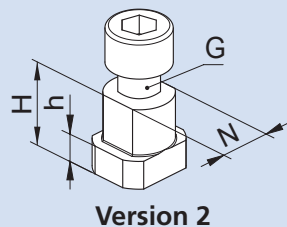


Version 1

T-nuts

- Quenched and ground
- Incl. screw ISO 4762 – 12.9

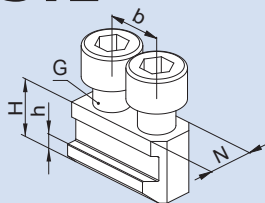
Type	Id. No.	Version	N	H	h	G	Screw ISO 4762	Torque Md max. (Nm)
NST 21-3	081826	2	21	25.5	11	M16	M16 x 35	150
NST 21-5	033429	2	21	30	11	M16	M16 x 35	150
NST 21-6	034197	1	21	26.5	10	M16	M16 x 35	150
NST 21/17-1	034208	3	17 / 21	26.5	10	M12	M12 x 30	70
NSTE-M 22	12064020	3	22 / 25.5	34.5	15	M20	M20 x 40	300
NSTE-M/22-1	5320432	2	22/24	45.5	16.5	M20	M20 x 60	300
NST 25	014812	2	25.5	29	11	M20	M20 x 40	300
NST 25-2	12065082	3	25.5	34	15	M20	M20 x 40	300
NST 25-3	12065020	2	25.5	34.5	15	M20	M20 x 40	300
NST 25-4	12065002	3	25.5 / 28	40	15.5	M20	M20 x 50	300
NST 25-5	199908	2	25.5	40.5	15	M20	M20 x 50	300
NST 30	081811	2	30	41	15	M24	M24 x 50	450
NST 30-1	014827	2	30	36	15	M24	M24 x 50	450
NST 30-2	013868	2	30	41	15	M24	M24 x 70	450
NST 30-3	13063900	2	30	44	18	M24	M24 x 60	450



Please observe!
Always tighten T-nuts
with a torque wrench.

SMW-AUTOBLOK	Forkardt	Röhm	Schunk
GH-D 400 GH-M 400 RC-D 400 RC-M 400		KFD/KFD-HF 250/315 KFH/KFH-F/KFH-G/KFH-NC 250/315 KFD-AF 250/315 KFD-HE 254/315 KFL 315/400 KFA 200 LVE 250/305/315	
SP 250/98 SP 350 STP 250/98 • STP 280 SP 280/350 HFKN-D 260/315 AN-D 250/315 HFKS-2G-M 320 AL-D 250/315 AN-M 315 • AL-M 315 HB-D 250/315 NT-D 315 • NT-M 315 AP-D 315 • AP-M 315 APL-D 315 • APL-M 315 BH-D 250/315 BHD-FC 250/315 BH-M 315 • BB-M 315 PB-D 250/315 BB-D 250/315 RC-D 250/305 BHM-FC 315 • RC-M 305 PBI-D 250/315 HYDN-S 250/315 AN-M 400 • AL-M 400 BH-M 400/450 AP/APL/NT-M 400 • BHM-FC 400			TP 205/315 ROTA TP 250/315 ROTA NCO 260/315 ROTA NC 250 ROTA NCF 250 ROTA 2B 200 ROTA NC Plus 260/315 ROTA NCK Plus 315 ROTA NCF Plus 260/315
			ROTA NCK 315 • ROTA NCK Plus 315 ROTA NCD 315 ROTA NC/NCF Plus 315
HFKN-D 400 HFKN-D 500 Centco4-D-MLW 1000/1200/1400 Centco4-D 500/630	3 NH 400/500/630 • QLC 400 QLK 400 • 3 NHF 400/500/630 3 KTGF 400/500 UVE 400/500/630/800 • KT 400/500 KG 400/500 • KL 400/500 KLNC 400/500 • KP 400 • KS 500/630 KSH 500 • KSL 630 KSHF 630 • KL 300 • KSHF 560 2 BLE 250 • 2 BLE 315 2 BLE-PS 300 • 2 BLE-PS 315 2 BLE 400 • 2 BLE 500 2 BLE-PS 400/500 2 BLN 250/315/400		HSL 400 ROTA NC-D 400/600 ROTA NC 400 ROTA NCF 400 TH 400 THF 400 TH 500 THF 500 ROTA 2B 250/315/400
AN/AL-D 400 BB-N 400/460/500/600 BB-N ES 400/460/500/600 BH-D 400/450/500/630/800 BHD-FC 400/450/500/630/800 CL-D 250/315		KFH 400 • KFD 400 • LVE 400 KFH 500 • KFD 500 • LVE 500 KFD-HE 400 • KFD-HF 400 KFD 630 • LVE 630 KFD-HF 500 • KFD 800 LVE 1000 • KFD-HS 400 KFL 500 • KFA 250 • KFD-HS 500 KFL 600 • KFA 315 • KFH-F 400/500 KFH-G 400/500 • KFH-NC 400/500	HSG 400 HSG 500 ROTA NCO 400/500 TB 400 TB 500 ROTA TB 400/500/610 ROTA EP 380/460 ROTA TB-LH 400/500/610
GHDN 610/640/800 HYDL-S 800 IN-D 500/630/800 IL-D 500/630/800 BB-SC 600			
	KS 800/1000 • KSF 1000	KFD 1000/1250	ROTA NCD 1000 • ROTA NC 1000
			ROTA TB 800/850/1000/1200 ROTA TB-LH 800/850/1000 ROTA NC 630 • ROTA TB 630 ROTA TB-LH 630 • 630 • TH 630
BB-N 630/800/1000 BB-N ES 630/800/1000 IN-D 1000/1250			

NSTE

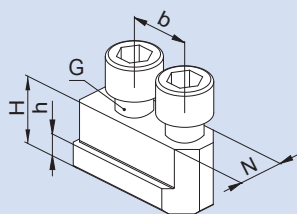


Version 1

Double T-nuts

- Quenched and ground
- Incl. screw ISO 4762 – 12.9

Type	Id. No.	Version	N	H	h	b	G	Screw ISO 4762	Torque Md max. (Nm)
NSTE 08	038265	2	8	13.5	5	12	M6	M6 x 20	16
NSTE 12	12061300	2	12	15	6.5	16	M8	M8 x 20	30
NSTE 12-1	12061200	1	12	15	5.5	16	M8	M8 x 20	30
NSTE 14	73061650	1	14	18.5	6.5	16.4	M10	M10 x 20	50
NSTE 17	081813	2	17	23	9	22	M12	M12 x 30	70
NSTE 17-1	081814	2	17	23	9	19	M12	M12 x 30	70
NSTE 17-2	73062150	1	17	20.5	7.5	23	M12	M12 x 25	70
NSTE 17-3	18062632	1	17	20.5	7	30	M12	M12 x 25	70
NSTE 21	081815	2	21	27	11	28	M16	M16 x 35	150
NSTE 21-2	73063050	1	21	26.5	10	30	M16	M16 x 30	150
NSTE 21-3	034148	1	21	26.5	10	28	M16	M16 x 30	150
NSTE 25.5	081817	2	25.5	29	11	35	M20	M20 x 40	300
NSTE 25.5-1	73065030	1	25.5	33	14.5	38	M20	M20 x 40	300



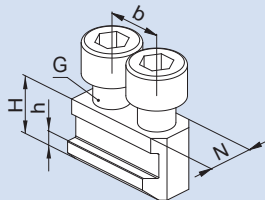
Version 2



Please observe!
Always tighten T-nuts
with a torque wrench.

SMW-AUTOBLOK	Forkardt	Schunk
HFKN-D 110		
BH-D 130		
PB-D 130		
HB-D 130		
BB-D 140		
AN-D 125		
AL-D 125		
HFKN-D 165		
AN/AL/BH/BH-D 165		
BHD-FC 165		
PB/PBI/RC-D 165		
AP/NT-D 170		
BB-D 175		
HYND-S 180		
	2 BLE-PS 160/200 • 2 BLEF 200 KL/KT/KTG/KTN/KS-PS 160/200 KSF 175/200 • KSKL 250 Mo KGH/KGHF/KTH 160/175/200 KS 160/200/250 • KG/KP 200 NH/NHF 160/175/200 QLK/QLC 160/175/200 QLK/QLC-KS 200/250 QLK/QLC-LS 160/200 QLC-AG 200 • UVE 160/200/250	HSL 165/210 TH 165/210 THF 165/210 ROTA NC-D 200 HSG 200 HSG 250 ROTA NC/NCF Plus 165
HFKN-D 210 • AN-D 210		ROTA NC/NCF Plus 215
AL-D 210 • BH-D 210		ROTA NCO 210
BHD-FC 210 • RC-D 210		ROTA NCD 185
BB-D 210 • PB-D 210		ROTA NCK Plus 210/250
PBI-D 210 • HB-D 210		ROTA NCF 165/210
HYDN-S 210/226		ROTA NC 165/210
AP-D 215 • NT-D 215		ROTA 2B 160
AP-D 260		
NT-D 260		
	3 NH 250-315 • 3 NHF 250-315 KT 250-315 • KSH 250-315 KSHF 250-315 • 3 KTGF 250-315 KG 250-315 • KP 250-315 KLNC 250-315 • KL 250 • KSPS 250-300 3 NHF 290 • KS 315-400 • KSH 400 KSHF 400 • UVE 315 • 3 NHD 400 (Index) 2 BLE 200 • 2 BLE 250 Mo QLK/QLC 250/315 • QLK/QLC-KS 315/400 QLK/QLC-LS 250/315 • QLC-AG 250/315	HSL 250/315 ROTA NC-D 250 ROTA NC-O 250 TH 250/315 THF 250/315 HSG 315 ROTA NC-D 315 ROTA NC-O 315 ROTA NCF 315 ROTA NC 315
HFKN-D 260/315 • HFKN-M 315		ROTA NCO 260/315
AN/AL/BH/BB/HB/PB/PBI-D 250/315		ROTA 2B 200
AN/AL/BH/BB/PB/PBI-M 315		ROTA NC 250 • ROTA NCF 250
AP/APL/NT-D 315		ROTA NC Plus 260/315
AP/APL/NT-M 315		ROTA NCK Plus 315
HYND-S 250/315 • RC-D 250/305		ROTA NCF Plus 260/315
RC-M 305 • BHD-FC 250/315		
BHM-FC 315		
HFKN-D 400	3 NH 400-500-630 • 3 NHF 400-500-630	HSL 400
HFKN-M 400	3 KTGF 400-500 • UVE 400-500-630-800	ROTA NC-D 400/500
	KT 400-500 • KG 400-500 • KL 400-500	ROTA NC-F 400/500
	KLNC 400-500 • KP 400 • KS 500-630	TH 400/500
	KSH 500 • KSL 630 • KSHF 630 • KL 300	THF 400/500
	KSHF 560 • 2 BLE 250 • 2 BLE 315	ROTA 2B 250/315/400
	2 BLE-PS 300 • 2 BLE-PS 315 • 2 BLE 400	
	2 BLE 500 • 2 BLE-PS 400-500 • QLC 400 • QLK 400	
RC-D 500		
AP-D 400 • APL-D 400		
NT-D 400		

NSTE-M

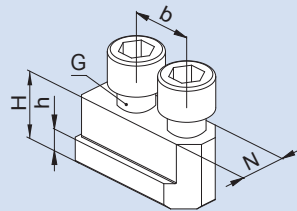


Version 1

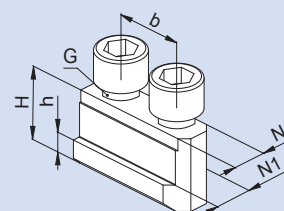
Double T-nuts for base jaws with METRIC SERRATION

- Quenched and ground
- Incl. screw ISO 4762 – 12.9

Type	Id. No.	Version	N	H	h	b	G	Screw ISO 4762	Torque Md max. (Nm)	SMW-AUTOBLOK
NSTE-M 105	091508	2	10	15	5	14	M8	M8 x 20	30	
NSTE 12	12061300	2	12	15	6.5	16	M8	M8 x 20	30	BH-M 130 • BB-M 140 HB/PB-M 130
NSTE 12-1	12061200	1	12	15	5.5	16	M8	M8 x 20	30	AN-M 125 • AL-M 125
NSTE-M 120	73061602	1	12	18.5	6.5	20	M10	M10 x 20	50	AN-M 165 • AL-M 165 BH-M 165 • BHM-FC 165 RC-M 165 • PB-M 165 PBI-M 165 • HB-M 165 BB-M 175 • AP/NT-M 170 HFKS-2G-M 165
NSTE-M 121	081833	2	12	22	7	20	M10	M10 x 25	50	
NSTE-M 125	012534	2	12	18.5	7.5	20	M10	M10 x 25	50	
NSTE-M 140	73062101	1	14	20.5	7.5	25	M12	M12 x 25	70	AN-M 210 • AL-M 210 BH-M 210 • BHM-FC 210 RC-M 210 • PB-M 210 PBI-M 210 • HB-M 210 BB-M 210 • AP/NT-M 215 APL-M 215
NSTE-M 141	081834	2	14	24.5	8.5	25	M12	M12 x 35	70	
NSTE-M 145	012535	2	14	20.5	8.5	25	M12	M12 x 30	70	
NSTE-M 160	73062501	1	16	26.5	10	30	M12	M12 x 30	70	AN-M 250 • AL-M 250 BH-M 250 • BHM-FC 250 RC-M 250 • PB-M 250 PBI-M 250 • HB-M 250 BB-M 250
NSTE-M 160-1	18062633	1	17/16	20.5	7.5	30	M12	M12 x 30	70	AP/APL-M 260 • NT-M 260
NSTE-M 161	080547	2	16	24.5	8.5	30	M12	M12 x 35	70	
NSTE-M 162	081835	2	16	23	8	30	M12	M12 x 30	70	
NSTE-M 165	012546	2	16	21.5	8.5	30	M12	M12 x 30	70	
NSTE-M 167	081836	2	16	26.5	8.5	25	M12	M12 x 35	70	
NSTE-M 181	081837	2	18	33.5	13.5	30	M14	M14 x 45	130	
NSTE-M 187	019359	2	18	27.5	9.5	30	M14	M14 x 40	130	
NSTE 21-2	73063050	1	21	26.5	10	30	M16	M16 x 30	150	AN/AL/AP/APL/NT/BH/BB-M 315 PP/HB/PBI-M 315 BHM-FC 315 • RC-M 305
NSTE-M 212	081839	2	21	28	11.5	30	M16	M16 x 40	150	
NSTE-M/22-1	5320432	2	22/24	45.5	16.5		M20	M20 x 60	300	
NSTE-M 213	236521	2	21	23	11.5	30	M16	M16 x 35	150	
NSTE-M 227	081842	3	22/24	45.5	16.5	43	M20	M20 x 60	300	



Version 2



Version 3



Please observe!
Always tighten T-nuts
with a torque wrench.

Howa	Samchully	Kitagawa	Schunk
		B204 • B205	
HO 1 MA 6 • HO 7 MA 6 HO 24 M 6 • HO 27 M 6 HO 15 M 6 • HO 22 M 6 HO 47 M 6 • HO 37 M 6		HJA 5-6 • HO 6 • N-160 • HOS 6 HOH 06 • N 160 • B 06 • N 06 B-160 • HOB 6 • AS 165 • HOH-160	HSL 165 (1.5 x 60°) ROTA NC/NCF 165
		B-206 • B 06 • B 106 • B 07 HOH 106 • HOH 06 • BB 06 BB 206 • HOH 206	ROTA NCK 165 ROTA NCK Plus 165
HO 1 MA 8 • HO 2 MA 8 HO 23 M 8 • HO 7 M 8 • HO 15 M 8	HCH 08	HJA 6-8 • HO 8 • HOH 08 • N-200 HOS 8 • B 08 • B-200 • HOB 8 AS 210 • HOH-200 • N 08 • N 200	HSL 210 (1.5 x 60°) ROTA NC/NCF 210
	MH208	B-208 • B 108 • HOH 108 • HOH 208 B 208 • BB 208 • BB 08	
	HC 10 HCH 10	B-250 • AS 250 • HOS 10 • B 10 AS 250 • HOB-10 • HO-10 HJA 8-10 • HOH 250 • N 10 • N 250	HSL 250 (1.5 x 60°) ROTA NC/NF 250
HO 1 MA 10 • HO 2 M 10	MH 208 • HS 08 MH 210 • HS 10	B-110 • HOH 110 • B-210 • HOH 210 BB 210 • BB 10	ROTA NCK 250 ROTA NCK Plus 250
HO 7 MA 10 • HO 15 M 10 HO 22 M 8 • HO 47 M 8 HO 23 M 10 • HO 27 M 8 HO 24 M 8 • HO 37 M 8 HO 1 MA 12 • HO 2 M 12	HC 12 • HS 12	B-300 • HO-12 • HOH-300 • HOS 12 B 12 • N 12 • HOH 12 • N-300 HOB 12 • HLA 6-12 • HLA 6-15 HLA 8-12 • HJA 8-15	ROTA NC/NCF 315
HO 7 MA 12 • HO 22 M 10 HO 23 M 12 • HO 37 M 10 HO 27 M 10 • HO 24 M 10 HO 15 M 12 • HO 47 M 10			HSL 315
	MH 212 HS 12	B 212 • HOH 212 • B-112 • HOH 112	ROTA NCK 315 • ROTA NCK Plus 315 ROTA NCD 315 ROTA NC/NCF Plus 315
		BB 212 B-380 • B-15 • B-18 • B-450 HOH 380 • HOH-18 • HOB-15 HOB 18 • HOH 15	HSL 400 ROTA NC/NCF 400

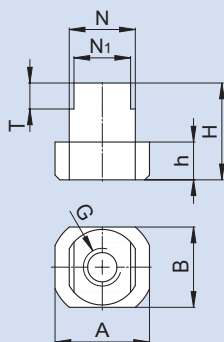
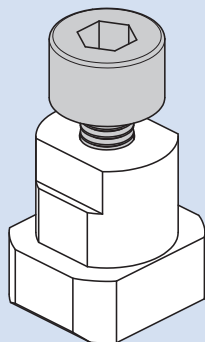
Modified standard T-nuts according to your specifications

Your benefits:

- You will quickly receive the right offer
- The T-nuts are made from blanks, which makes them inexpensive and available at short term
- Economical alternative to special T-nuts
- Existing top jaws can be adapted to different chucks by using stepped T-nuts
- If you have any questions in advance, please contact sales@smw-autoblok.de

 interactive PDF available
at www.smw-autoblok.de

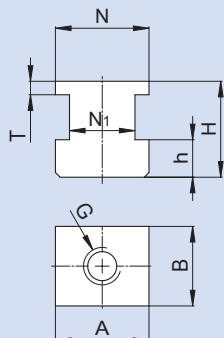
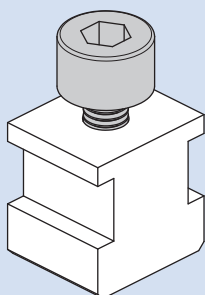
T-nuts type NSO 10



Dimensions

A		mm	H		mm
B		mm	N		mm
G (thread)			N1		mm
h		mm	T		mm

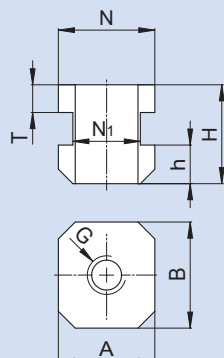
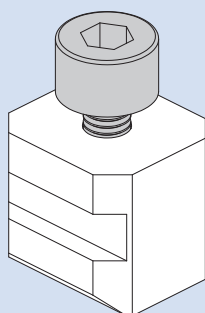
T-nuts type NSO 20



Dimensions

A		mm	H		mm
B		mm	N		mm
G (thread)			N1		mm
h		mm	T		mm

T-nuts type NSO 30



Dimensions

A		mm	H		mm
B		mm	N		mm
G (thread)			N1		mm
h		mm	T		mm

The economical solution:

Roughing jaws with exchangeable grippers

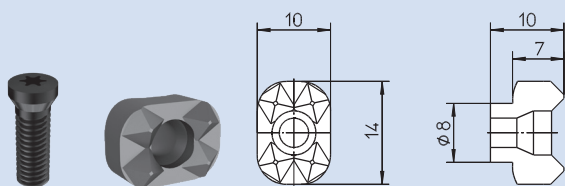
- Made from standard SMW-AUTOBLOK jaws.
- Economical, because only the worn out gripper is changed in seconds.
- Extended life compared to standard roughing jaws.

Features:

- Safe gripping of raw material / forgings / castings made from standard or high tensile strength material.
- Better gripping allows heavier cuts.
- Fast and easy change of worn out grippers.

UGE 10

Id. No. 081845F, hardened steel



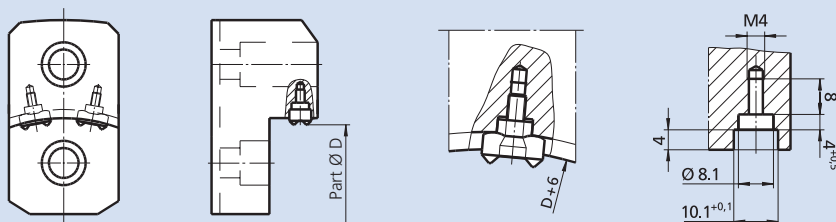
Parts included: Gripper with Torx screw

The universal gripper with unique feature:

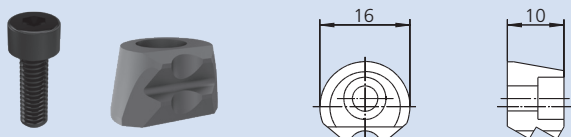
- For flat and round clamping surfaces.
- For external and internal gripping.
- Front mounting of bolts.
- Gripper seat, round or flat, and thread is easy to produce.
- Hardening of gripper seat necessary.
- **Torx screw driver Id. No. 085961**
- **Torx screw M4 x 13.5 Id. No. 033010**

Mounting instruction:

1. Part $\varnothing D + 6 \text{ mm}$ (0.23 inch) + location + slot has to be turned or milled. Please note corrected dimensions according to sketch.
2. Drill and tap.
3. Insert and harden jaws.

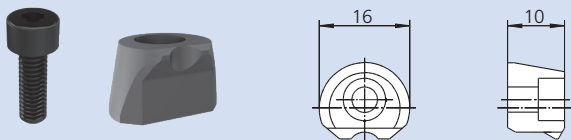
**UGE 20**

Id. No. 087414, Hardened Steel



UGE 21

Id. No. 233348 (Gripper with 1 tooth row)



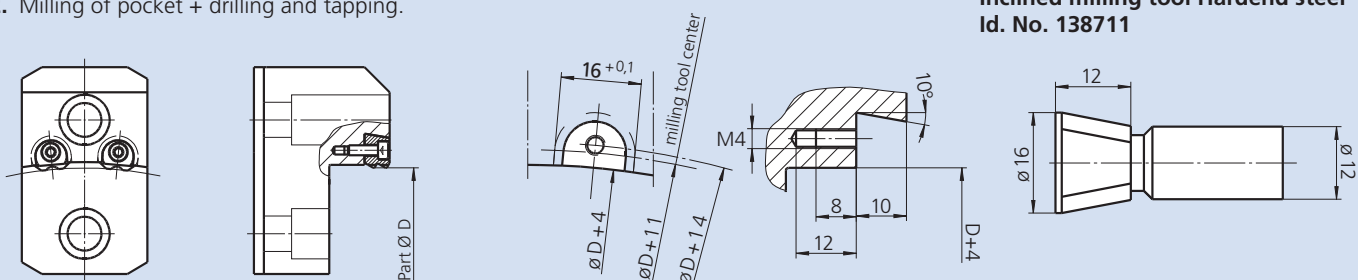
Parts included: Gripper with head socket screw M4 x 12 ISO 4762

The gripper with the unique shape:

- Top mounting of bolt.
- Pull-down effect by wedge shape design.
- Can be used fixed or swivelling.
- Gripper seat: Milling, drilling and tapping can easily be machined with the inclined milling tool (033611).
- No hardening of jaws necessary.
- For external or internal clamping.
- Head socket screw M4 x 12 ISO 4762, Id. No. 010145.

Mounting instruction:

1. Part Ø D + 4 mm (0.16 inch) + location turning or milling.
2. Milling of pocket + drilling and tapping.

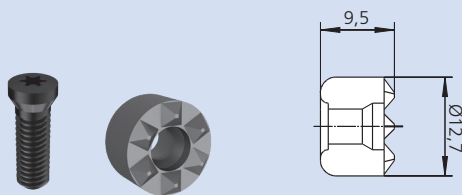


Inclined milling tool HSS
Id. No. 033611

Inclined milling tool Hardend steel
Id. No. 138711

UGE 30

Id. No. 089822, solid carbide



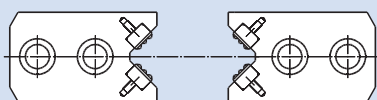
Parts included: Gripper with Torx screw

Gripper for prism jaws and fixtures:

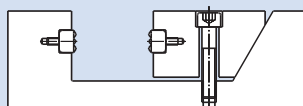
- For external and internal gripping of rectangular parts.
- For chuck jaws, fixture jaws and fixtures.
- Front mounting of bolt.
- Gripper seat: drilling and tapping can easily be done
Bottom of seat can be either 120° (standard drill tool) or flat.
- For high production hardening of gripper pocket is recommended.
- **Torx screw driver Id. No. 085961**

Mounting instruction:

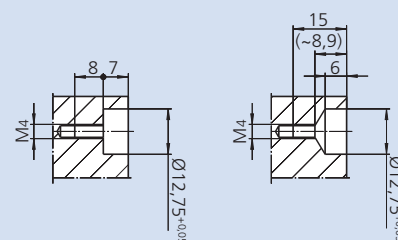
1. Drilling 12.7 Ø bottom of seat 120° or flat
2. Tapping of thread



prism jaws



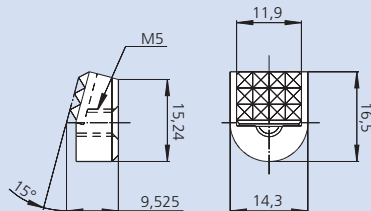
vise



optional

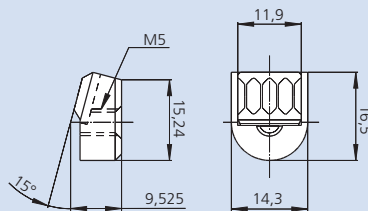
FGH 33

Id. No. 71400133
Carbide Tipped
with 12 points



FGH 34

Id. No. 71400134
Carbide Tipped
with 4 blades



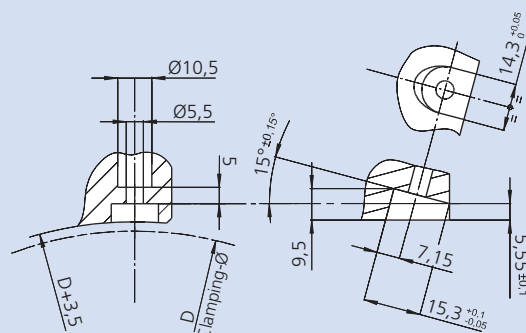
Inclined grippers with pull-down effect:

- For external clamping.
- Very short and forward-positioned clamping area.
- Rear mounting of bolts.
- Inclined gripper seat are easy to be machined.
- For high production hardening of gripper seat is recommended.

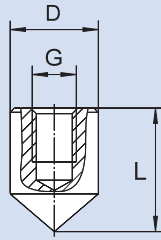
Parts included: Gripper without screw

Mounting instruction for FGH grippers:

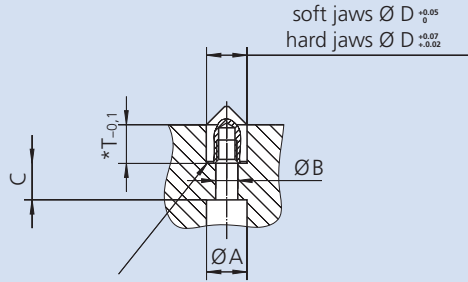
1. With 15° inclined top-jaw, mill the Ø 14.3 gripper seat
2. Drill Ø 5.5 as shown on the drawing.
3. Drill Ø 10.5 for the screw's head.



MGH Hardened steel



Parts included: Hardened tip without screw



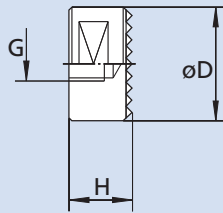
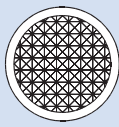
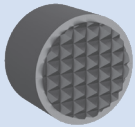
*equal per set within 0.1 mm

Clamping tips for jaws

- For external and internal gripping.
- Increasing gripping allows for heavier cuts.
- Rear mounting of bolts.
- Point seat can easily be machined: drilling only.

Type	MGH 6	MGH 8	MGH 10	MGH 12
Id. No.	081851	087805	081852	081853
D mm	6	8	10	12
L mm	10	12	14	16
G mm	M3	M4	M5	M6
A mm	6	8	10	11
B mm	3.4	4.5	5.5	6.6
C mm	9	9	9	11
T mm	7.5	8.5	9.5	10.5
R mm	0.3	0.5	0.5	0.5
Torx Screw ISO 4762	M3 x 14	M4 x 14	M5 x 14	M6 x 16

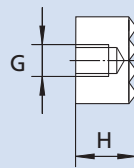
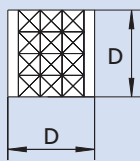
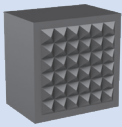
HDS-R Carbide soldered



Grippers for jaws, fixtures

- For O.D. gripping.
- Increase of the transmittable torque on raw or machined work pieces.
- Rear mounting threads or side gages for locking.
- The pocket can easily be machined.

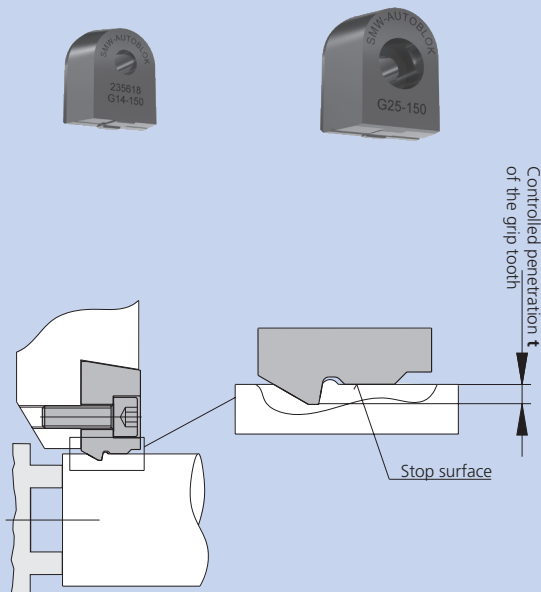
HDS-Q Carbide soldered



Type	Id. No.	D	H	G	max. load force F ¹⁾ (daN)	rec. mounting	
						bore-Ø + 0.05	bore depth
HDS-R 10	081846	10	10	M5	800	10	9.0
HDS-R 11	081847	12.7	9.5	M5	1100	12.7	8.5
HDS-R 12	081848	12.7	12.7	M6	1100	12.7	11.5
HDS-R 13	081849	15.8	9.5	M6	2000	15.8	8.5
HDS-R 14	081850	19	9.5	M6	3000	19	8.5
HDS-Q 15	033058	12.7	9.5	M6	2000	—	—

■ With pull down effect

G14 + G25



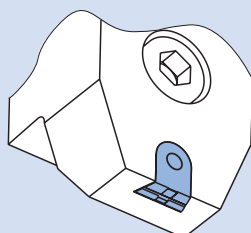
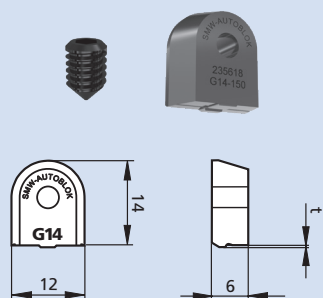
G-gripper characteristics

- Type G grippers have a stop surface for a **controlled penetration** of the grip tooth.
- **The workpiece is clamped concentric on the stop surface**, so that the clamping dia. and the machining dia. are concentric.
- The **high precision** of the gripper guarantees concentricity even after replacing worn out grippers.
- Highest torque transmission is guaranteed with the **combination of friction and positive drive**.
- The geometry of the gripper creates a **pull down effect** on the workpiece.
- **TIN coated high speed steel** for long life.
- You can **select the corresponding gripper** for all applications according to the grind stock allowance.
- Gripper with **controlled penetration** 0.07 - 0.30 mm are standard.
- **Special grippers are available** on request.

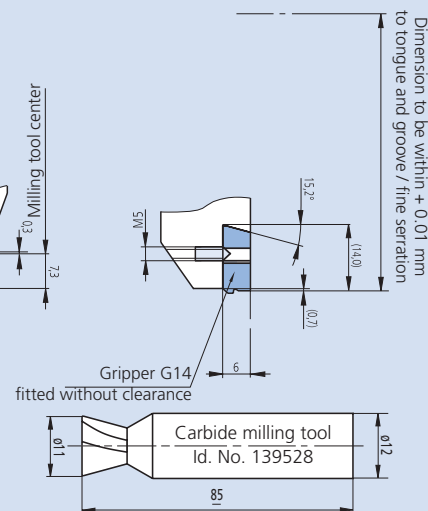
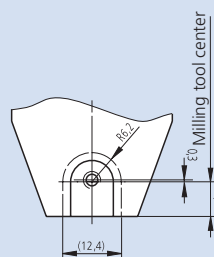
G14

(Light duty version)
Material: HSS

Mounting dimension



Measured into sharp corner

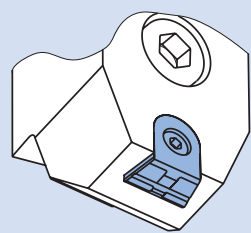
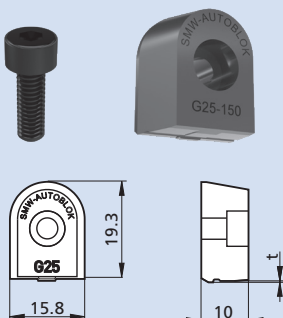


SMW-AUTOBLOK Type	G14-070	G14-100	G14-125	G14-150	G14-175	G14-200
Controlled penetration t	0.070	0.100	0.125	0.150	0.175	0.200
Id. No.	235615	235616	235617	235618	235619	235620

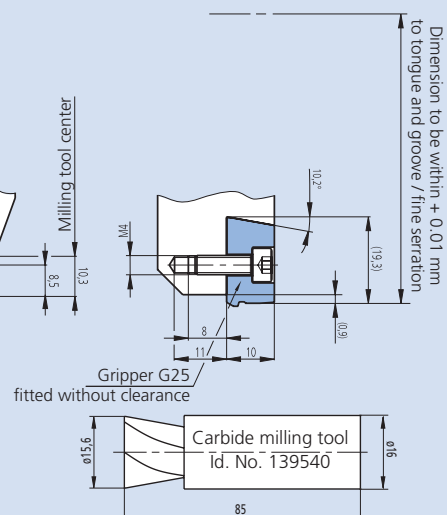
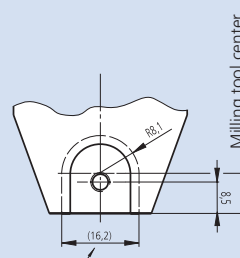
G25

(Heavy duty version)
Material: HSS

Mounting dimension

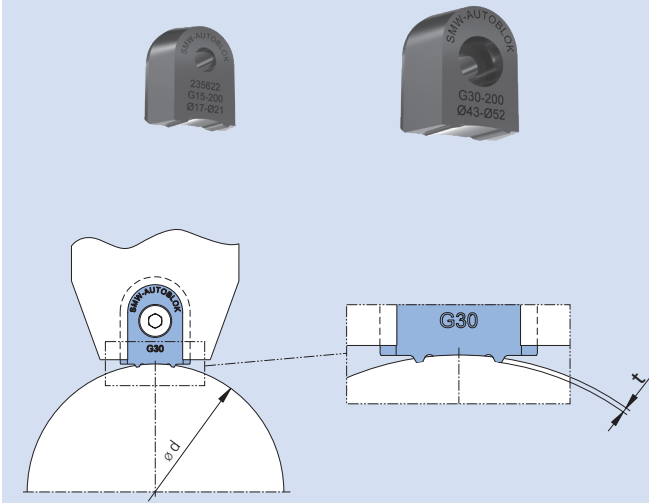


Measured into sharp corner



SMW-AUTOBLOK Type	G25-100	G25-150	G25-200	G25-250	G25-300
Controlled penetration t	0.10	0.15	0.20	0.25	0.30
Id. No.	232704	231275	231276	231277	231278

G15 + G30

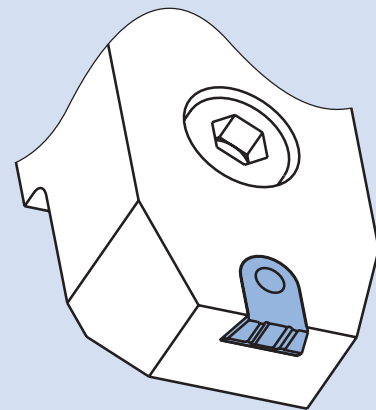
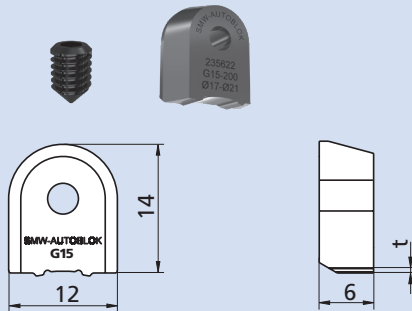


G-gripper characteristics

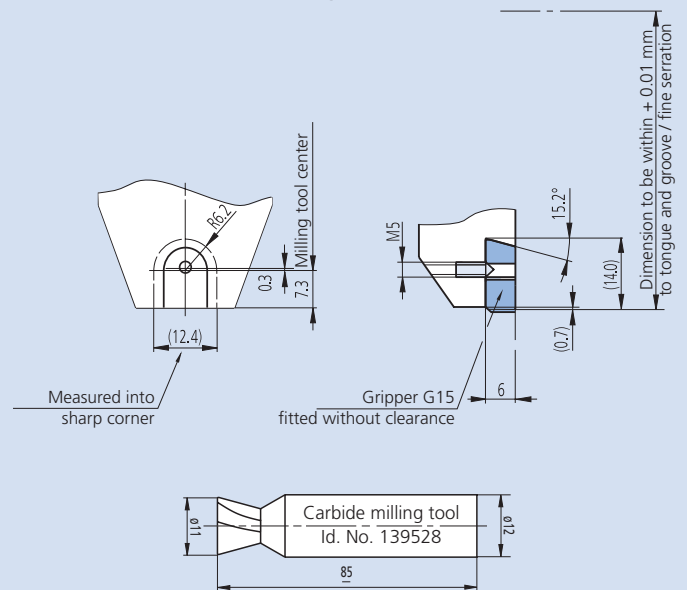
- Type G grippers have a stop surface for a **controlled penetration** of the grip tooth.
- **The workpiece is clamped concentric on the stop surface**, so that the clamping dia. and the machining dia. are concentric.
- The **high precision** of the gripper guarantees concentricity even after replacing worn out grippers.
- Highest torque transmission is guaranteed with the **combination of friction and positive drive**.
- **TIN coated high speed steel** for long life.
- You can **select the corresponding gripper** for all applications according to the grind stock allowance.
- Gripper with **controlled penetration** 0.15 - 0.30 mm are standard.
- **Special grippers are available** on request.

G15

(Light duty version)
Material: HSS



Mounting dimension

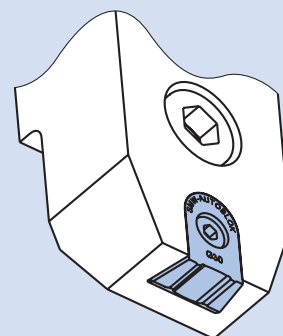
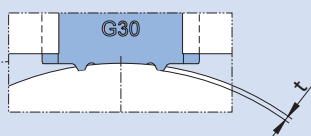
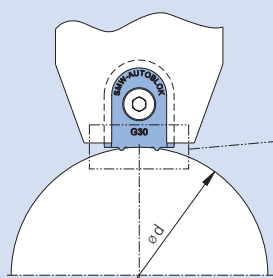
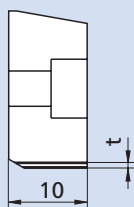
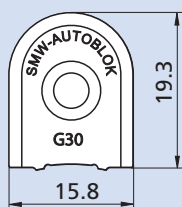


SMW-AUTOBLOK Type	G15-150	G15-200	G15-250
Work piece-Ø		17-21	
Controlled penetration t	0.15	0.20	0.25
Id. No.	235621	235622	235623
Work piece-Ø		22-27	
Controlled penetration t	0.15	0.20	0.25
Id. No.	237762	237763	237764
Work piece-Ø		28-34	
Controlled penetration t	0.15	0.20	0.25
Id. No.	235624	235625	235626
Work piece-Ø		35-42	
Controlled penetration t	0.15	0.20	0.25
Id. No.	237765	237766	237767
Work piece-Ø		43-53	
Controlled penetration t	0.15	0.20	0.25
Id. No.	235627	235628	235629
Work piece-Ø		54-78	
Controlled penetration t	0.15	0.20	0.25
Id. No.	237400	237401	237402
Work piece-Ø		79-175	
Controlled penetration t	0.15	0.20	0.25
Id. No.	237409	237410	237411

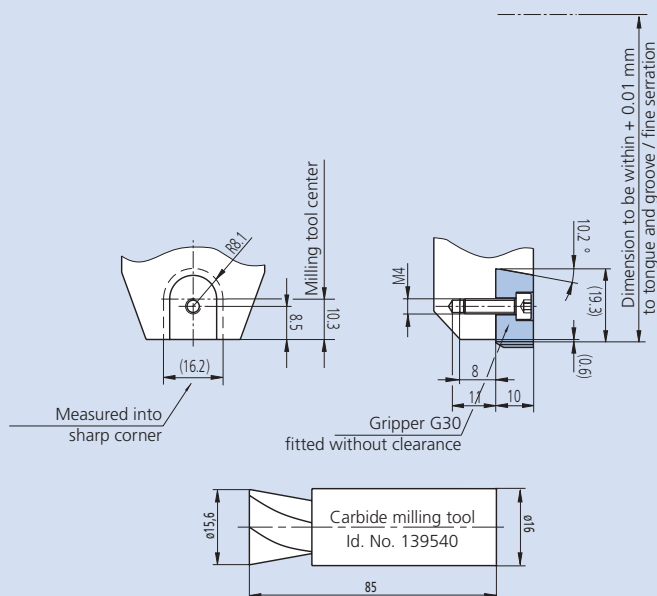
■ For highest torque transmission

G30

(Heavy duty version)
Material: HSS



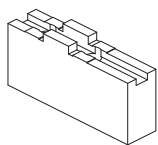
Mounting dimension



SMW-AUTOBLOK Type	G30-200	G30-250	G30-300
Work piece-Ø		24-32	
Controlled penetration t	0.20	0.25	0.30
Id. No.	237841	237842	237843
Work piece-Ø		33-42	
Controlled penetration t	0.20	0.25	0.30
Id. No.	233481	233482	233483
Work piece-Ø		43-52	
Controlled penetration t	0.20	0.25	0.30
Id. No.	233421	233422	233423
Work piece-Ø		53-64	
Controlled penetration t	0.20	0.25	0.30
Id. No.	233485	233486	233487
Work piece-Ø		65-84	
Controlled penetration t	0.20	0.25	0.30
Id. No.	234811	234812	234813
Work piece-Ø		85-119	
Controlled penetration t	0.20	0.25	0.30
Id. No.	237291	237292	237293
Work piece-Ø		120-174	
Controlled penetration t	0.20	0.25	0.30
Id. No.	237299	237300	237301
Work piece-Ø		175-335	
Controlled penetration t	0.20	0.25	0.30
Id. No.	237422	237423	237424

Soft top jaws – TONGUE & GROOVE

SMW-AUTOBLOK | Forkardt | Samchully | Kitagawa | Röhm | Schunk



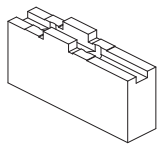
WAK

Standard version
16MnCr5

Soft top jaws

- TONGUE & GROOVE
- For quick jaw change

Page 88



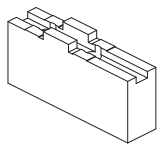
WAKS

Wide version
16MnCr5

Soft top jaws

- TONGUE & GROOVE
- For quick jaw change

Page 90



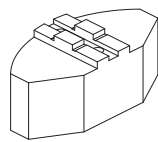
WAK-A

Light version
Aluminum F50

Soft top jaws aluminum

- TONGUE & GROOVE
- For quick jaw change

Page 92



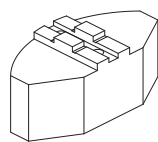
SBK

16MnCr5

Soft pie jaws

- TONGUE & GROOVE
- For quick jaw change

Page 94



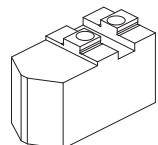
SBK-A

Light version
Aluminum F50

Soft pie jaws aluminum

- TONGUE & GROOVE
- For quick jaw change

Page 96



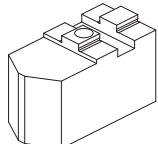
WBR

16MnCr5

Soft top jaws

- TONGUE & GROOVE
- For 3-jaw power chuck

Page 98



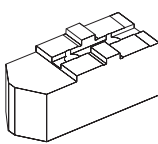
WBK

16MnCr5/C45

Soft top jaws

- TONGUE & GROOVE
- For 2- and 3-jaw power chuck

Page 98



WAKA

C45

American Standard

Soft top jaws

- TONGUE & GROOVE
- For 2-, 3- and 4-jaw power chuck
- For all chucks:
American Standard

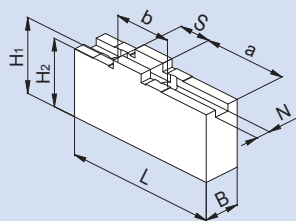
Page 99

Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.



Soft top jaws for quick jaw change

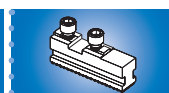
- Tongue & groove
- Material: 16MnCr5

Type	Id. No.	B	H ₁	H ₂	L	N	S	a	b	kg / Set	SMW-AUTOBLOK
WAK 140-10	012490	20	40	36	69	8	18	26	32	0.89	KNCS-N 140
WAK 160-10	012491	20	40	36	85	8	18	42	32	1.15	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
WAK 200-10	012492	22	46	42	105	10	20	50	40	1.91	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
WAK 200-10	012492-2*	22	46	42	105	10	20	50	40	1.30	KNCS-N 210
WAK 250-10	012493	30	55.5	50.5	125	12	20	70	40	3.72	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
WAK 250-10	012493-2*	30	55.5	50	125	12	20	70	40	2.50	KNCS-N 260/325
WAK 400-10	012494	35	60	54	145	12	26	74	54	5.70	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400
WAK 500-10	012495	50	80	73	180	18	30	100	60	13.65	HG-N 500 HG-N 630 HG-2G 500 HG-2G 630 HG-F 400/ 500 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800 KNCS-2G 500 KNCS-2G 630
WAK 630-10	080930	65	118	110	260	24	40	150	82	39.48	HG-F 630

* For 2-jaw-chucks
Other dimensions on request.
Use the data sheet on page 100 for ordering.



• SMW-AUTOBLOK
• 100, 158



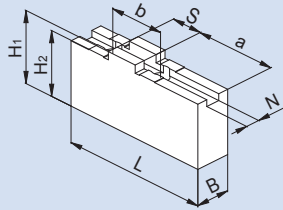
• SMW-AUTOBLOK
• 112, 138



• SMW-AUTOBLOK
• 80

Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro-NC 140 Duro-NC 168 Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 • THW165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200 ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	
F 250 UNC 250/315 KTNC 250/265 KTNC 280/315 KTNCV 250 KTNCV 250 KTNCV 315 FNC 250 FNC 315 F+250	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW315-F
F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500L	QJC-220	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500 THW 630-R
F 630 F+ 630		Duro 630 Duro-NC 630	ROTA-S plus 630/800/1000 ROTA-S 630/800/1000 ROTA-G 630

WAKS



Soft top jaws wide version, for quick jaw change

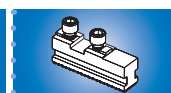
- Tongue & groove
- Material: 16MnCr5

Type	Id. No.	B	H ₁	H ₂	L	N	S	a	b	kg / Set	SMW-AUTOBLOK
WAKS 140-10	012496	35	40	36	63	8	18	26	32	1.62	KNCS-N 140
WAKS 160-10	080931	25	50	46	85	8	18	42	32	1.94	HG-N 160
WAKS 160-20	080932	30	55.5	51.5	85			48	32	2.69	HG-F 160
WAKS 160-30	080933	40	80	76	70			26	32	4.43	KNCS-N 170 KNCS-2G 170
WAKS 200-10	080934	30	55.5	51.5	100	10	20	57	40	3.21	HG-N 210
WAKS 200-20	080935	30	70	66	100			45	40	4.09	HG-F 210
WAKS 200-30	012497	40	40	36	70			27	40	2.11	KNCS-N 210
WAKS 200-31	080936	40	60	56	85			42	40	4.02	KNCS-N 225
WAKS 200-32	036733	40	80	76	95			52	40	6.19	KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
WAKS 250-10	080937	40	60	55	125	12	20	70	40	5.70	HG-N 260
WAKS 250-11	080938	40	80	75	125			70	40	7.71	HG-N 315
WAKS 250-12	080939	40	100	95	125			70	40	9.75	HG-F 260
WAKS 250-13	080940	40	120	115	125			70	40	11.80	KNCS-N 260/275
WAKS 250-20	012498	60	60	55	90			44	40	6.30	KNCS-N 325/340
WAKS 250-21	080942	60	60	55	110			60	40	7.78	KNCS-NB 260
WAKS 250-22	080943	60	80	75	90			44	40	8.50	KNCS-NB 325
WAKS 250-23	080944	60	80	75	110			60	40	10.58	KNCS-NB 340
WAKS 250-30	012499	80	60	55	90			44	40	8.68	KNCS-2G 260
WAKS 250-31	080945	80	80	75	110			60	40	14.48	KNCS-2G 325
WAKS 400-10	080946	40	60	54	110	12	26	54	54	4.88	HG-N 400
WAKS 400-11	080947	40	60	54	145			89	54	6.60	HG-2G 400
WAKS 400-12	080948	40	100	94	145			89	54	11.44	HG-F 315
WAKS 400-13	080949	40	120	114	145			89	54	13.86	KNCS-N 400
WAKS 400-14	080950	40	150	144	145			89	54	17.49	KNCS-NB 400
WAKS 400-20	080951	60	60	54	110			54	54	7.73	KNCS-2G 400
WAKS 400-21	080952	60	80	74	110			54	54	10.52	
WAKS 400-22	080953	60	100	94	110			54	54	13.32	
WAKS 400-30	012500	80	70	64	100			44	54	11.38	
WAKS 500-10	080954	60	80	73	155	18	30	90	60	14.17	HG-N 500
WAKS 500-12	080956	60	120	113	155			90	60	21.91	HG-N 630
WAKS 500-20	080957	80	80	73	155			90	60	19.70	HG-2G 500
WAKS 500-21	080958	80	100	93	155			90	60	25.04	HG-2G 630
WAKS 500-30	012501	90	80	73	130			65	60	18.50	HG-F 400/500
WAKS 500-31	012502	100	80	73	150			85	60	24.28	KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800 KNCS-2G 500 KNCS-2G 630
WAKS 200-10	080934-2*	30			100			57		2.10	KNCS-N 210
WAKS 200-20	080935-2*	30			100			45		2.70	
WAKS 200-30	012497-2*	40			70			27		1.40	
WAKS 200-31	080936-2*	40			85			43		2.70	
WAKS 200-32	036733-2*	40			95			52		4.10	
WAKS 250-10	080937-2*	40			125			70		3.80	KNCS-N 260
WAKS 250-11	080938-2*	40			125			70		5.10	KNCS-N325
WAKS 250-12	080939-2*	40			125			70		6.50	
WAKS 250-13	080940-2*	40			125			70		7.90	
WAKS 250-20	012498-2*	60			90			44		4.20	
WAKS 250-21	080942-2*	60			110			60		3.20	
WAKS 250-22	080943-2*	60			90			44		5.70	
WAKS 250-23	080944-2*	60			110			60		7.00	
WAKS 250-30	012499-2*	80			90			44		5.80	
WAKS 250-31	080945-2*	80			110			60		9.70	

* For 2-jaw-chuck



• SMW-AUTOBLOK
• 100, 158



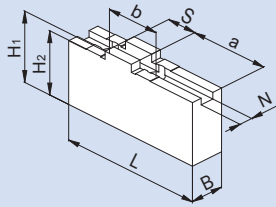
• SMW-AUTOBLOK
• 112, 138



• SMW-AUTOBLOK
• 80

Forkardt	Samchully	Röhm	Schunk
		Duro-NC 140 Duro-NC 168	
F 160	QJC-206	Duro 160	ROTA-S plus 160
KTNC 160		Duro-NC 160	ROTA THW 165
KTNCV 160		Duro-NC 175	ROTA THW plus 165/185
KTNCV 175		Duro-NCE 160	ROTA-G 160
FNC 175		Duro-NCE 175	THW165
F+160		Duro-NCES 175	ROTA-S 160
			ROTA NCW 185
			ROTA-NCR 200
F 200	QJC-208	Duro 200	ROTA-S plus 200
KTNC 200		Duro-NC 200	ROTA THW 210
KTNCV 200		Duro-NC 225	ROTA THW plus 215
FNC 200		Duro-NCE 200	ROTA-G 200
F+200		Duro-NCES 200	THW 210R/F
			ROTA NCW 225
			ROTA-S 200
			ROTA NCWF 210
			ROTA THWB 210
			ROTA THW vario 215
F 250	QJC-210	Duro 250	ROTA-S plus 250
UNC 250/315	QJC-212	Duro-NC 250	ROTA-THW 250/315
KTNC 250/265		Duro-NCE 250	ROTA THW plus 260/315
KTNC 280		Duro-NCE 315	ROTA-G 250/315
KTNC 315		Duro-NCES 250	THW 250/265-R/F
KTNCV 250		Duro-NCES 315	ROTA NCW 265/315
KTNCV 315			ROTA-S 250
FNC 250			ROTA-NCWF 250/315
FNC 315			ROTA THWB 265
F+250			THW 315-R
F 315	QJC-215	Duro 315	ROTA-S plus 315
UNC 400		Duro-NC 315	ROTA THW 400
KTNC 360		Duro-NCE 400	THW 400-R/F
KTNC 400		Duro-NCES 400	ROTA-G 400
KTNCV 400			ROTA-S 315
FNC 400			ROTA THWB 315
F+315			THW 315-F
F 400/500 L	QJC-220	Duro 400/500	ROTA-S plus 400/500
UNC 500		Duro-NC 400/500	ROTA THW 500/630/800
KTNC 500/630		Duro-NCE 500	ROTA-G 500
KTNCV 500/630			THW 630-R
FNC 500/630			ROTA-S 400/500
F+400			THW 500-R/F
F+500			ROTA THWB 400/500

WAK-A



Soft top jaws aluminum light version, for quick jaw change

■ Tongue & groove

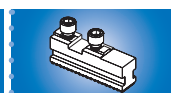
■ Material: Aluminum (tensile strength ca. 500 N/mm²)

Type	Id. No.	B	H ₁	H ₂	L	N	S	a	b	kg / Set	SMW-AUTOBLOK
WAK-A 160	080959	25	50	46	85	8	18	42	32	0.69	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
WAK-A 200	080960	25	50	46	105	10	20	50	40	0.88	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
WAK-A 210	035222	40	60	56	90	10	20	43	40	1.54	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
WAK-A 250	080961	40	60	55	125	12	20	70	40	2.04	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
WAK-A 400	080962	40	60	54	145	12	26	74	54	2.38	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400
WAK-A 500	035142	50	80	73	180	18	30	100	60	4.89	HG-N 500 HG-N 630 HG-2G 500 HG-2G 630 HG-F 400/500 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800 KNCS-2G 500 KNCS-2G 630



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• SMW-AUTOBLOK
• 112, 138

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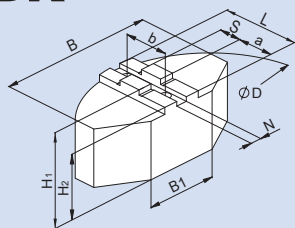


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Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200 ROTA-S plus 200
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 250 UNC 250/315 KTNC 250/265 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 FNC 250 FNC 315 F+250	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500	QJC-220	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500

SBK



Soft pie jaws for quick jaw change

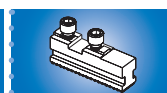
- Tongue & groove
- Material: 16MnCr5

Type	Id. No.	B	B ₁	H ₁	H ₂	L	N	S	a	b	D	kg / Set	SMW-AUTOBLOK
SBK 160	080963	120	40	50	46	60	8	18	23	32	160	4.89	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
SBK 200	080964	140	64	60	56	70	10	20	27	40	200	9.01	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
SBK 250	080965	180	70	60	55	90	12	20	44	40	250	13.05	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
SBK 400	080966	240	120	75	69	110	12	26	54	54	320	28.89	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400



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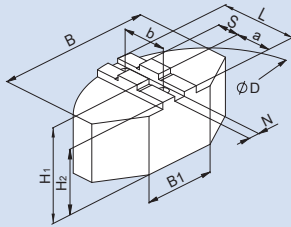


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Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 250 UNC 250/315 KTNC 250/265 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 FNC 250 FNC 315 F+250	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F

SBK-A



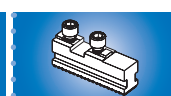
Soft pie jaws Aluminum light version, for quick jaw change

- Tongue & groove
- Material: Aluminum (tensile strength appr. 500 N/mm²)

Type	Id. No.	B	B ₁	H ₁	H ₂	L	N	S	a	b	D	kg / Set	SMW-AUTOBLOK
SBK-A 160	080967	120	40	50	46	59.5	8	18	23	32	165	1.74	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
SBK-A 200	080968	140	50	58	54	72.5	10	20	32	40	200	3.11	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
SBK-A 250	080969	180	70	58	53	87.5	12	20	44	40	250	4.31	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
SBK-A 400	080970	240	80	75	69	117	12	26	54	54	320	10.40	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400
SBK-A 500	085193	330	150	90	82	160	18	30	95	60	440	21.63	HG-N 500 HG-N 630 HG-2G 500 HG-2G 630 HG-F 400 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800 KNCS-2G 500 KNCS-2G 630



• SMW-AUTOBLOK
• 100, 158



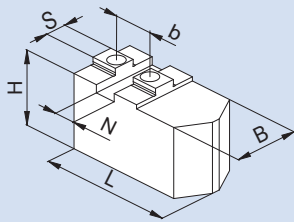
• SMW-AUTOBLOK
• 112, 138



• SMW-AUTOBLOK
• 80

Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro 160 Duro-NC 160 Duro-NC 175 Duro-NCE 160 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 250 UNC 250/315 KTNC 250/265 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500	QJC-220	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW500-R/F ROTA THWB 400/500

WBR

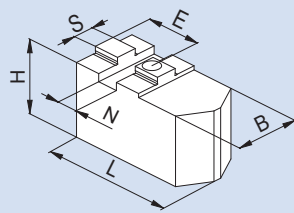


Soft top jaws for 3-jaw power chuck

- Tongue & groove
- Material: 16MnCr5

Type	Id. No.	B	H	L	S	N	b	kg / Set	SMW-AUTOBLOK	Röhm
WBR 1101	013843	25	30	51	8	8	15	0.65	HFKN-C 110	KFD 110 KFD 125

WBK



Soft top jaws for 2- and 3-jaw power chuck

- Tongue & groove
- Material: 16MnCr5/ *C45

Type	Id. No.	B	H	L	S	N	E	kg	SMW-AUTOBLOK	Forkardt	Röhm	Schunk
WBK 0801*	90040800	30	30	38	8	8	14	0.18	CL-C 80			
WBK 0851**	080983	22	30	40	8	8	-	0.48			KFD 85	
WBK 0951**	080984	22	40	44.5	8	8	-	0.75			KFD 95	
WBK 1001*	90041000	30	30	48	8	8	20	0.23	CL-C 100			
WBK 1201*	90041300	35	35	57	14	16	27	0.40	CL-C 125 US 2 CL-C 125	2 BLE 125 2 BLN 125	KFA 125 KFD-G 125	ROTA 2 B 125
WBK 1602*	90041600	40	40	75	18	18	34	0.72	CL-C 160 US 2 CL-C 160	2 BLE 160 2 BLE PK 160 2 BLN 160	KFA 160 KFD-G 160	ROTA 2 B 160

* Material: C45 / Id. No. per piece (Weight per piece)

** Jaws pointed / Id. No. per set (Weight per set / 3 pieces)

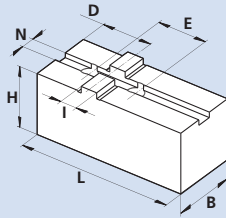


• SMW-AUTOBLOK
• 100, 158



• SMW-AUTOBLOK
• 80

WAKA



Soft top jaws 2, 3 and 4 jaw versions for power chucks

- American Standard tongue and groove
- Material: C45

Type	Id. No.	B	H ₂	L	N	D	E	I	ISO 4762	kg / piece	SMW-AUTOBLOK
WAKA 165*	12041660	30	32	80	7.94	30	38	12.68	M10	0.47	RAN 160 AN-C 165 HB-C 165 PB-C 165 PBI-C 165 AP-C 170 NT-C 170
WAKA 210*	12042060	35	37	100	7.94	35	44.4	12.68	M12	0.81	RAN 200 AN-C 210 HB-C 210 PB-C 210 PBI-C 210 AP-C 215 APL-C 215 NT-C 215
WAKA 250*	12042560	45	42	120	12.7	42	54	19.03	M16	1.40	AN-C 250 HB-C 250 PB-C 250 PBI-C 250 RAN 250 AP-C 260 APL-C 260 NT-C 260
WAKA 315*	12043060	50	47	140	12.7	50	63.5	19.03	M16	2.14	AN-C 315 HB-C 315 PB-C 315 PBI-C 315 RAN 315 AP-C 315 APL-C 315 NT-C 315
WAKA 400	12044050	60	55	165	12.7	60	76.2	19.03	M20	3.53	AN-C 400 AP-C 400 APL-C 315 NT-C 400 RAN 400
WAKA 500	12045050	75	70	165	12.7	60	76.2	19.03	M20	5.83	IL-C 500 IL-C 630 IL-C 800 IN-C 500 IN-C 630 IN-C 800

* Jaws pointed



SMW-AUTOBLOK
100, 158



SMW-AUTOBLOK
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Modified standard jaw-blanks according to your specifications

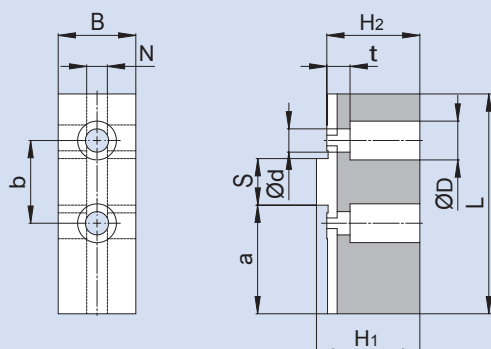
Reduced weight and / or tapering for small clamping diameters

Your benefits:

- You will quickly receive the right offer
- The jaws are made from blanks, which makes them inexpensive and available at short term
- Economical alternative to special jaws
- No machining is required on the clamping jaws by the customer
- Clamping diameter can be turned out by the customer on the machine under clamping pressure = best concentricity
- Clamping of small workpiece diameters due to tapered clamping surface
- If you have any questions in advance, please contact sales@smw-autoblok.de

interactive PDF available
at www.smw-autoblok.de

Soft top jaw-blanks



Dimensions

a	mm	H2	mm
b	mm	L	mm
B	mm	N	mm
d	mm	S	mm
D	mm	t	mm
H1	mm		

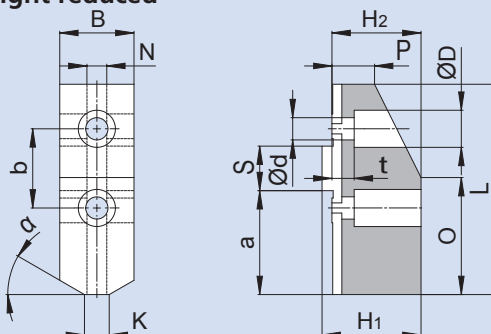
Material

Quantity in pieces

Chuck manufacturer

Chuck type + size

Soft top jaw-blanks weight reduced



Dimensions

a	mm	N	mm
b	mm	S	mm
B	mm	t	mm
d	mm	K	mm
D	mm	O	mm
H1	mm	P	mm
H2	mm	α	Grad
L	mm		

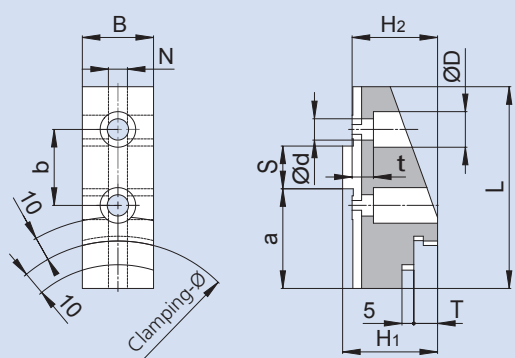
Material

Quantity in pieces

Chuck manufacturer

Chuck type + size

Soft top jaws for external clamping



Dimensions

a	mm	L	mm
b	mm	N	mm
B	mm	S	mm
d	mm	t	mm
D	mm	T	mm
H1	mm	Clamping-Ø	mm
H2	mm	Workpiece-Ø	mm

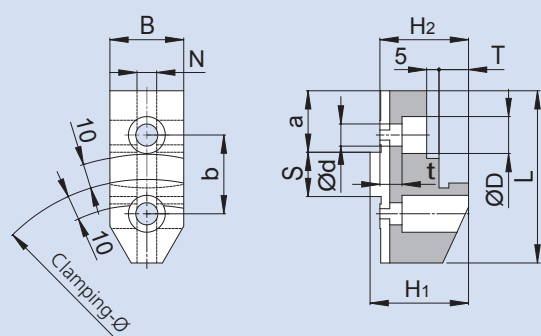
Material

Quantity in pieces

Chuck manufacturer

Chuck type + size

Soft top jaws for internal clamping



Dimensions

a	mm	L	mm
b	mm	N	mm
B	mm	S	mm
d	mm	t	mm
D	mm	T	mm
H1	mm	Clamping-Ø	mm
H2	mm	Workpiece-Ø	mm

Material

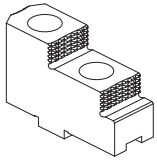
Quantity in pieces

Chuck manufacturer

Chuck type + size

Hard top jaws – Tongue & groove

SMW-AUTOBLOK | Forkardt | Samchully | Röhme | Schunk



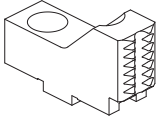
GUA

Reversible

Hard top jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

Page 102

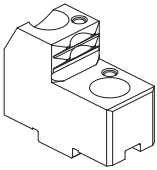


GSK

Hard bar roughing jaws

- Tongue & groove
- For quick jaw change
- For external clamping

Page 104



GGK

Hard roughing jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

Page 106

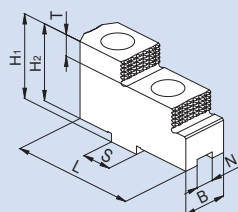
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

GUA



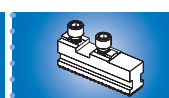
Hard, reversible top jaws for quick jaw change

- Tongue & groove
- For internal and external clamping

Type	Id. No.	B	H ₁	H ₂	L	T	N	S	kg / Set	SMW-AUTOBLOK
GUA 160	012484	20	36.5	32.5	63.60	7.5	8	18	0.59	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
GUA 200	012485	22	43	39	74.95	10	10	20	0.92	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-NB 225 KNCS-2G 210 KNCS-2G 225
GUA 250	012486	30	55	50	89.50	14	12	20	1.95	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
GUA 400	012487	35	62	56	105.5	15	12	26	3.25	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400
GUA 500	012488	45	80.5	73	130	20	18	30	6.57	HG-N 500 HG-N 630 HG-2G 500 HG-2G 630 HG-F 400/500 KNCS-N 500 KNCS-N 630 KNCS-NB 500 KNCS-NB 630 KNCS-NB 800 KNCS-2G 500 KNCS-2G 630
GUA 631	035959	65	105	97	185	30	24	40	18.71	HG-F 630



• SMW-AUTOBLOK
• 158

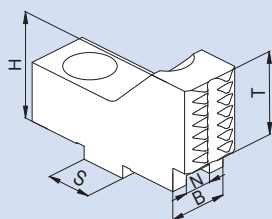


• SMW-AUTOBLOK
• 112, 138



Only jaws that are ground on the chuck under clamping condition guarantee highest repeatability.

Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210 R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 250 UNC 250/315 KTNC 250/265 KTNC 280 KTNC 315 KTNCV 250 KTNCV 315 FNC 250 FNC 315 F+250 F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
F 400/500 L UNC 500 KTNC 500/630 KTNCV 500/630 FNC 500/630 F+400 F+500	QJC-220	Duro 400/500 Duro-NC 400/500 Duro-NCE 500	ROTA-S plus 400/500 ROTA THW 500/630/800 ROTA-G 500 THW 630-R ROTA-S 400/500 THW 500-R/F ROTA THWB 400/500
F 630 F+ 630		Duro 630 Duro-NC 630	ROTA-S plus 630/800/1000 ROTA-S 630/800/1000 ROTA-G 630

GSK

Hard bar roughing jaws for quick jaw change

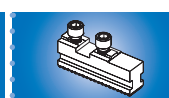
- Tongue and groove
- For external clamping

Type	Id. No.	Clamping ranges Ø	B	H	T	N	S	kg / Set	SMW-AUTOBLOK
GSK 160	091359	12-40	22	40	30	8	18	0.68	HG-N 160 HG-F 160 KNCS-N 170 KNCS-2G 170
GSK 200	091360	15-50	22	45	37	10	20	0.85	HG-N 210 HG-F 210 KNCS-N 210 KNCS-N 225 KNCS-NB 210 KNCS-2G 210 KNCS-2G 225
GSK 250	091361	15-60	26	45	35	12	20	1.13	HG-N 260 HG-N 315 HG-F 260 KNCS-N 260/275 KNCS-N 325/340 KNCS-NB 260 KNCS-NB 325 KNCS-NB 340 KNCS-2G 260 KNCS-2G 325
GSK 400	091362	30-90	32	50	40	12	26	2.15	HG-N 400 HG-2G 400 HG-F 315 KNCS-N 400 KNCS-NB 400 KNCS-2G 400

Note: The specified clamping range is valid for the KNCS-N chuck series. It may differ for other chucks.

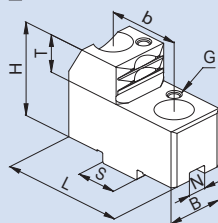


• SMW-AUTOBLOK
• 158



• SMW-AUTOBLOK
• 112, 138

Forkardt	Samchully	Röhm	Schunk
F 160 KTNC 160 KTNCV 160 KTNCV 175 FNC 175 F+160	QJC-206	Duro 160 Duro-NC 160 Duro-NCE 160 Duro-NC 175 Duro-NCE 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165/185 ROTA-G 160 THW 165 ROTA-S 160 ROTA NCW 185 ROTA-NCR 200
F 200 KTNC 200 KTNCV 200 FNC 200 F+200	QJC-208	Duro 200 Duro-NC 200 Duro-NC 225 Duro-NCE 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA NCW 225 ROTA-S 200 ROTA NCWF 210 ROTA THWB 210 ROTA THW vario 215
F 250 UNC 250/315 KTNC 250/265 KTNCV 250 KTNC 280 KTNC 315 KTNCV 315 FNC 250 FNC 315 F+250 F 315 UNC 400 KTNC 360 KTNC 400 KTNCV 400 FNC 400 F+315	QJC-210 QJC-212	Duro 250 Duro-NC 250 Duro-NCE 250 Duro-NCE 315 Duro-NCES 250 Duro-NCES 315	ROTA-S plus 250 ROTA-THW 250/315 ROTA THW plus 260/315 ROTA-G 250/315 THW 250/265-R/F ROTA NCW 265/315 ROTA-S 250 ROTA-NCWF 250/315 ROTA THWB 265 THW 315-R
	QJC-215	Duro 315 Duro-NC 315 Duro-NCE 400 Duro-NCES 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F



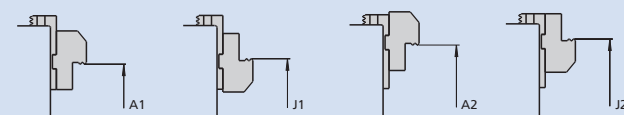
Hard roughing jaws with quick jaw change

- Tongue & groove
- For internal and external clamping

Type	Id. No.	Clamping ranges Ø*		Clamping ranges Ø*		B	H	T	G	N	S	b	L	kg / Set
		External-A ₁	Internal-J ₁	External-A ₂	Internal-J ₂									
GGK 1751	012464	25-53	125-162	-	-	25	40	16	M5	8	18	32	64	0.91
GGK 1752	012465	36-56	128-168	-	-								68	0.92
GGK 1753	012466	55-81	101-135	-	-								60	0.88
GGK 1754	012467	80-105	75-109	-	-								56	0.80
GGK 1751	012464	25-62	133-171	33-80	155-190	25	40	16	M5	8	18	32	64	0.91
GGK 1753	012466	52-89	107-145	70-107	125-163								60	0.88
GGK 1754	012467	77-115	81-118	95-133	99-137								56	0.80
GGK 2001	012469	29-59	187-252	36-87	-	28	45	20	M5	10	20	40	88	1.52
GGK 2002	012470	57-122	121-186	94-150	158-215								66	1.28
GGK 2003	012471	93-149	85-140	131-187	122-178								66	1.19
GGK 2004	012472	152-208	62-100	189-246	72-137		40	15					87	1.39
GGK 2001	012469	30-69	-	45-106	-	28	45	20	M5	10	20	40	88	1.52
GGK 2002	012470	67-132	131-197	105-170	169-235								66	1.28
GGK 2003	012471	104-169	95-160	141-207	134-199								66	1.19
GGK 2004	012472	-	68-110	-	74-148		40	15					87	1.39
GGK 2501	012473	35-66	192-258	64-130	256-322	40	50	22	M6	12	20	40	94	2.38
GGK 2502	012474	70-136	122-188	134-200	186-252								72	2.08
		78-154	132-208	141-218	195-272									
GGK 2503	012475	100-166	92-158	164-230	156-222								78	2.19
		107-184	109-175	159-247	152-238									
GGK 2504	012476	-	-	-	70-134								110	2.88
		-	-	-	80-156									
GGK 2501	012473	40-82	197-274	69-146	261-338	40	50	22	M6	12	20	40	94	2.38
GGK 2502	012474	75-152	127-204	139-216	191-268								72	2.08
GGK 2503	012475	105-182	97-174	169-246	161-238								78	2.19
GGK 2504	012476	-	-	-	74-150								110	2.88
GGK 2501	012473	40-126	207-320	104-214	295-406	40	50	22	M6	12	20	40	94	2.38
GGK 2502	012474	86-196	138-248	173-284	225-336								72	2.08
GGK 2503	012475	115-226	109-218	203-314	196-306								78	2.19
GGK 2505	012477	197-285	78-164	261-371	139-249		43	15					98	2.49
GGK 2501	012473	60-126	236-326	-	326-396	40	50	22	M6	12	20	40	94	2.38
GGK 2502	012474	116-201	-	196-288	-								72	2.08
GGK 2503	012475	-	136-236	232-318	-								78	2.19
GGK 2504	012476	-	108-186	-	-								110	2.88
GGK 4001	012478	78-188	258-378	143-263	333-453	50	55	25	M8	12	26	54	104	4.01
GGK 4002	012479	-	140-263	258-378	-								91	3.58
GGK 4003	012480	-	118-243	-	-								147	5.50
GGK 5001	012481	100-210	280-420	210-350	415-560	60	74	35	M8	18	30	60	125	7.58
GGK 5002	012482	-	155-295	330-470	-								108	6.67
GGK 5003	012483	-	100-240	-	-	50	56	25	M8	18	30	60	136	4.96
GGK 5001	012481	80-240	265-450	240-440	460-650	60	74	35	M8	18	30	60	125	7.58
GGK 5002	012482	-	140-320	380-560	-								108	6.67
GGK 5003	012483	-	100-240	-	-	50	56	25	M8	18	30	60	136	4.96

Note: Clamping range valid for chuck type KNCS-N.
It may differ for other chucks.

Clamping ranges



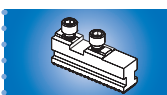
Base jaw position "P"

Base jaw position "O"

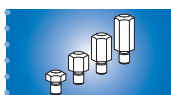
SMW-AUTOBLOK	Forkardt	Samchully	Röhm	Schunk
KNCS-N 140	3 KTNC 160 KTNCV 160 F 160 F+160 KTNCV 175 FNC 175	QJC-206	Duro-NC 160 Duro-NCE 160 Duro 160 Duro-NC 175 Duro-NCES 175	ROTA-S plus 160 ROTA THW 165 ROTA THW plus 165 ROTA-G 160 THW 165 ROTA-S 160
KNCS-N 170 KNCS-2G 170 HG-N 160 HG-F 160				
KNCS-N 210 KNCS-NB 210 KNCS-2G 210 HG-N 210 HG-F 210	3 KTNC 200 F 200 F+200 KTNCV 200 FNC 200	QJC-208	Duro-NC 200 Duro-NCE 200 Duro 200 Duro-NCES 200	ROTA-S plus 200 ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R/F ROTA-S 200 ROTA NCWF 210 ROTA THWB 210
KNCS-N 225 KNCS-NB 225 KNCS-2G 225				
KNCS-N 260 KNCS-N 260 KNCS-NB 260 KNCS-N 260 KNCS-2G 260 KNCS-N 260 HG-N 260 HG-F 260	3 KTNC 250 F 250 F+250 KTNCV 250 FNC 250	QJC-210	Duro-NC 250 Duro-NCE 250 Duro 250 Duro-NCES 250	ROTA-S plus 250 ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R/F ROTA NCW 265 ROTA-S 250 ROTA-NCWF 250 ROTA THWB 265
KNCS-N 275			Duro-NCE 315 Duro-NCES 315	
KNCS-N 325 KNCS-NB 325 KNCS-2G 325 HG-N 315	3 KTNC 280 KTNC 315 KTNCV 315 FNC 315	QJC-212		ROTA THW 315 ROTA THW plus 315 ROTA-G 315 ROTA-NCW 315 ROTA- NCWF 315 THW 315-R
KNCS-N 340				
KNCS-N 400 KNCS-NB 400 KNCS-2G 400 HG-N 400 HG-2G 400 HG-F 315	3 KTNC 360 F 315 F+315 KTNC 400 KTNCV 400 FNC 400	QJC-215	Duro-NC 315 Duro 315 Duro-NCE 400	ROTA-S plus 315 ROTA THW 400 THW 400-R/F ROTA-G 400 ROTA-S 315 ROTA THWB 315 THW 315-F
KNCS-N 500 KNCS-2G 500 KNCS-NB 500 HG-N 500 HG-2G 500 HG-F 400	3 KTNC 500 F+400 F 500 L F+500 L KTNCV 500 FNC 500	QJC-220	Duro-NC 400 Duro 400 Duro-NCE 500 Duro-NC 500 Duro 500	ROTA-S plus 400 ROTA-S plus 500 ROTA THW 500 ROTA-G 500 ROTA-S 400/500 THW 500-R/F ROTA THWB 400 ROTA THWB 500 ROTA THW 630 THW 630-R
KNCS-N 630 KNCS-NB 630 KNCS-2G 630 HG-N 630 HG-2G 630	3 KTNC 630 KTNCV 630 FNC 630			



SMW-AUTOBLOK
158



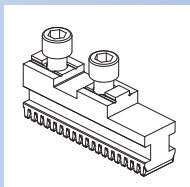
SMW-AUTOBLOK
112, 138



SMW-AUTOBLOK
147

Jaws for quick jaw change chucks – System SMW-AUTOBLOK

SMW-AUTOBLOK | Forkardt | Samchully | Kitagawa | Röhm | Schunk (Page 1 / 2)

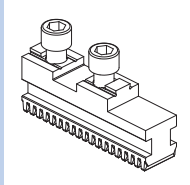


GBK

Hard base jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 112



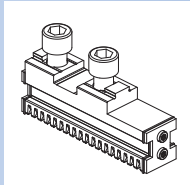
GBKS

With 1/2 tooth pitch offset

Hard base jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 114

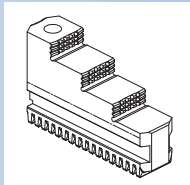


GBK-2G

Hard base jaws with sealing

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 116

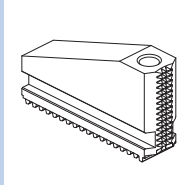


GST

Hard stepped monoblock jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 118

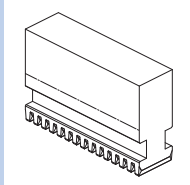


GES

Hard monoblock roughing jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 120



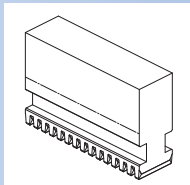
UVB

Quenched
15CrNi6

Soft monoblock jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 122



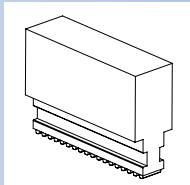
UVB-H

Quenched
15CrNi6

Soft, high monoblock jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 124



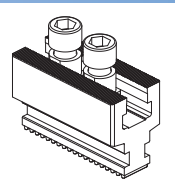
UVB-U

Quenched
15CrNi6

Soft, wide monoblock jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 126

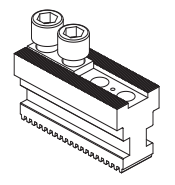


KOB

Kombi base jaws

- Modular serration straight System SMW-AUTOBLOK for INCH SERRATION
- For quick jaw change

Page 128



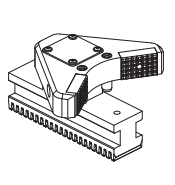
KLGD

KLM

Kombi base jaws

- Modular serration straight System SMW-AUTOBLOK for INCH / METRIC SERRATION
- For quick jaw change

Page 130



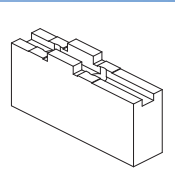
PJC

For 6-point clamping

Pendulum jaw complete

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change
- Modular system
- Sealed against contamination

Page 132



WAK

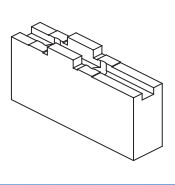
Standard
16MnCr5

Soft top jaw

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 88



WAKS

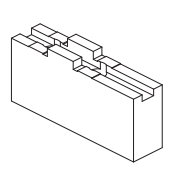
Wide version
16MnCr5

Soft top jaw

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 90



WAK-A

Light version
Aluminum F50

Soft top jaw aluminum

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 92

Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

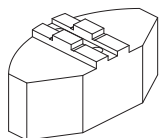
Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

Continuation
on the next page

Jaws for quick jaw change chucks – System SMW-AUTOBLOK

SMW-AUTOBLOK | Forkardt | Samchully | Kitagawa | Röhm | Schunk (Page 2 / 2)



SBK

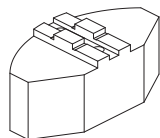
16MnCr5

Soft pie jaws

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 94



SBK-A

Light version

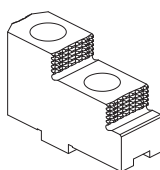
Aluminum F50

Soft pie jaws aluminum

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 96



GUA

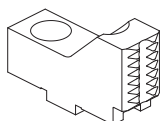
Reversible

Hard, reversible jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

>> Jaw data sheet see chapter 6

Page 102



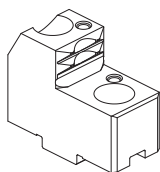
GSK

Hard bar roughing jaws

- Tongue & groove
- For quick jaw change
- For external clamping

>> Jaw data sheet see chapter 6

Page 104



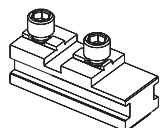
GSK

Hard roughing jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

>> Jaw data sheet see chapter 6

Page 106



GBK-B

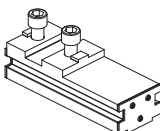
Wide version

For SMW-AUTOBLOK KNCS-NB(X), HG-NB

Hard base jaws

- Tongue & groove
- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 134



GBK-B-2G

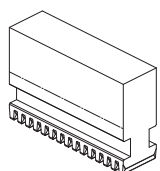
Wide version

For SMW-AUTOBLOK HG-B-2G

Hard base jaws with sealing

- Tongue & groove
- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 135



UVB-B

Wide version

For SMW-AUTOBLOK KNCS-NB(X), HG-NB

Monoblock jaws

- Modular serration straight System SMW-AUTOBLOK
- For quick jaw change

Page 134

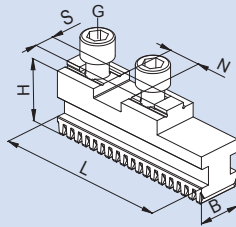
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

GBK



Hard base jaws for quick jaw change

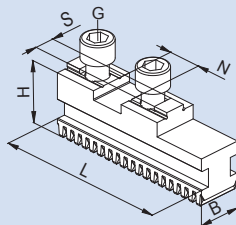
- Modular serration straight System SMW-AUTOBLOK
- Incl. jaw mounting bolts ISO 4762 – 12.9

Type	Id. No.	B	H	L	N	S	G x tapped hole	kg / Set	SMW-AUTOBLOK
GBK 140	012438	20	27.5	56	18	8	M8 x 13	0.60	KNCS-N 140
GBK 160	012439	20	27.5	65	18	8	M8 x 13	0.67	KNCS-N 170 HG-N 160
GBK 200	012440	22	29.5	85	20	10	M8 x 13	1.03	KNCS-N 210 KNCS-N 225 HG-N 210
GBK 200	012440-2*	22	29.5	85	20	10	M8 x 13	0.70	KNCS-N 210
GBK 250	012441	26	37	104	20	12	M12 x 17	1.89	KNCS-N 260 HG-N 260 KNCS-N 275
GBK 250	012441-2*	26	37	104	20	12	M12 x 17	1.30	KNCS-N 260
GBK 315	012442	32	43	115	20	12	M12 x 17	2.79	KNCS-N 325 HG-N 315 KNCS-N 340
GBK 315	012442-2*	32	43	115	20	12	M12 x 17	1.90	KNCS-N 325
GBK 400	012443	32	43	125	26	12	M12 x 17	3.06	KNCS-N 400 HG-N 400
GBK 500	012444	45	57	160	30	18	M16 x 34	7.69	KNCS-N 500 HG-N 500
GBK 630	012445	45	57	200	30	18	M16 x 34	9.31	KNCS-N 630 HG-N 630

* For 2-jaw-chuck

Samchully	Kitagawa	Röhm	Schunk
		DURO-NCES 175 DURO-A RC 180 DURO-NCSE 180	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
		DURO-NCES 200 DURO-A RC 215 DURO-NCSE 215	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
		DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
		DURO-NCES 315 DURO-A RC 315 DURO-NCSE 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
		DURO-NCES 400 DURO-A RC 400 DURO-NCSE 400 DURO-NCSE 500	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THW 500 THW 500-R ROTA-G 500
		DURO-NCSE 630	ROTA THW 630 THW 630-R ROTA THW 800

GBKS



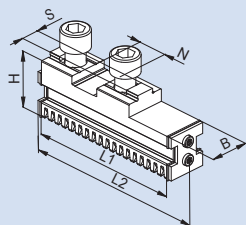
Hard base jaws for quick jaw change

- Modular serration straight with 1/2 tooth pitch offset
- System SMW-AUTOBLOK
- Incl. jaw mounting bolts ISO 4762 – 12.9

Type	Id. No.	B	H	L	N	S	G x tapped hole	kg / Set	SMW-AUTOBLOK
GBKS 140	013733	20	27.5	56	18	8	M8 x 13	0.62	KNCS-N 140
GBKS 160	013735	20	27.5	65	18	8	M8 x 13	0.66	KNCS-N 170 HG-N 160
GBKS 200	013737	22	29.5	85	20	10	M8 x 13	1.01	KNCS-N 210 KNCS-N 225 HG-N 210
GBKS 250	013739	26	37	104	20	12	M12 x 17	1.87	KNCS-N 260 HG-N 260 KNCS-N 275
GBKS 315	013741	32	43	115	20	12	M12 x 17	2.77	KNCS-N 325 HG-N 315 KNCS-N 340
GBKS 400	013743	32	43	125	26	12	M12 x 17	3.04	KNCS-N 400 HG-N 400

Samchully	Kitagawa	Röhm	Schunk
		DURO-NCES 175	ROTA THW 165
		DURO-A RC 180	ROTA THW plus 165/185
		DURO-NCSE 180	ROTA NCW 185
			ROTA-G 160
			THW 165
		DURO-NCES 200	ROTA THW 210
		DURO-A RC 215	ROTA THW plus 215
		DURO-NCSE 215	ROTA-G 200
			THW 210R
			ROTA NCW 225
			ROTA THW vario 215
		DURO-NCES 250	ROTA-THW 250
		DURO-A RC 260	ROTA THW plus 260
		DURO-NCSE 260	ROTA-G 250
			THW 250/265-R
			ROTA NCW 265
		DURO-NCES 315	ROTA-THW 315
		DURO-A RC 315	ROTA THW plus 315
		DURO-NCSE 315	ROTA-G 315
			ROTA NCW 315
			THW 315-R
		DURO-NCES 400	ROTA THW 400
		DURO-A RC 400	THW 400-R
		DURO-NCSE 400	ROTA-G 400

GBK-2G

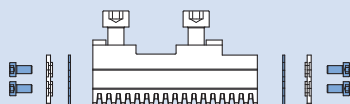


Hardened base jaws for quick jaw change

- Consisting of 1 set (3 pieces) base jaws GBK-2G with seals and mounting screws for top jaws (6 pieces)

Type	Id. No.	B	H	L1	L2*	N	S	kg / Set	SMW-AUTOBLOK
GBK-2G 170	162390	20	27.5	63.5	73.6	20	10	0.7	KNCS-2G 170
GBK-2G 200	161520	22	29.5	82	92.2	20	10	1.0	KNCS-2G 210 KNCS-2G 225
GBK-2G 250	161540	26	37	101	111.2	20	12	1.8	KNCS-2G 260
GBK-2G 315	161329	32	43	112	122.2	20	12	2.7	KNCS-2G 325
GBK-2G 400	161605	32	43	123	133.2	26	12	3.0	HG-2G 400 KNCS-2G 400
GBK-2G 500	161843	45	57	157.5	167.1	30	18	7.7	HG-2G 500 KNCS-2G 500
GBK-2G 630	161846	45	57	199.5	209.7	30	18	9.5	HG-2G 630 KNCS-2G 630

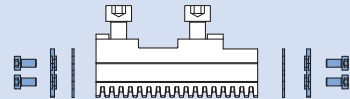
* Dimensions incl. seals, cover and screws



Seal kit for hardened base jaws GBK-2G

- Consisting of seals (6 piece) and mounting screws (12 pieces)

Type	Id. No.	SMW-AUTOBLOK
GBK-2G 170	207495	KNCS-2G 170
GBK-2G 200	205382	KNCS-2G 210 KNCS-2G 225
GBK-2G 250	205383	KNCS-2G 260
GBK-2G 315	205384	KNCS-2G 325
GBK-2G 400	205384	HG-2G 400 KNCS-2G 400
GBK-2G 500	206915	HG-2G 500 KNCS-2G 500
GBK-2G 630	206915	HG-2G 630 KNCS-2G 630



Mounting kit for hardened base jaw GBK-2G

- Consisting of seals (6 pieces), covers (6 pieces) and mounting screws (12 pieces)

Type	Id. No.	SMW-AUTOBLOK
GBK-2G 170	207496	KNCS-2G 170
GBK-2G 200	205386	KNCS-2G 210 KNCS-2G 225
GBK-2G 250	205387	KNCS-2G 260
GBK-2G 315	205388	KNCS-2G 325
GBK-2G 400	205388	HG-2G 400 KNCS-2G 400
GBK-2G 500	206916	HG-2G 500 KNCS-2G 500
GBK-2G 630	206916	HG-2G 630 KNCS-2G 630

Important for maintenance and safe operation, to be ordered with the chuck

Grease K05®

Special grease for
manual and power chucks



Cartridge 14 Oz. (DIN 1284)
Grease content 500 g
Id. No. 016440

Can 1000 g
Id. No. 011881

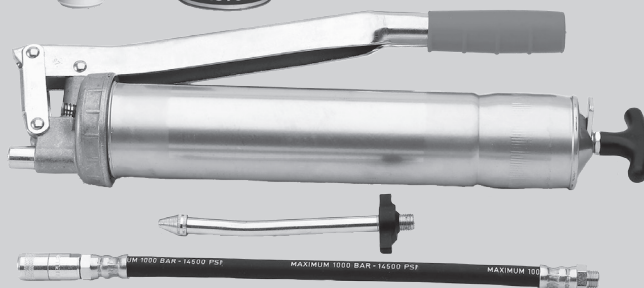


- High adhesion
- High resistance against coolant
- High load bearing capacity
- Low friction coefficient
- Avoids tribocorrosion

Grease gun

Grease gun (DIN 1283) for
cartridges 14 Oz. (DIN 1284).

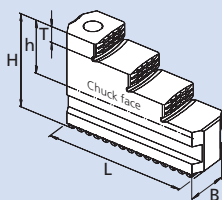
- Also refillable from grease can 1000 g.



Lubrication set Id. No. 083726

Supply range

- Grease gun
- 1 Adapter flexible for high pressure grease nipple
- 1 Adapter for cone grease nipple



Hard stepped monoblock jaws for quick jaw change

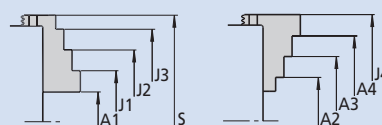
■ Modular serration straight System SMW-AUTOBLOK

Type	Id. No.	B	H	h	L	T	kg / set
GST 160-1*	014046	20	43.5	22	58	7	0.72
GST 160-2*	012454	20	43.5	22	58	7	0.71
GST 170	035867	20	43.5	22	67	7	0.82
GST 210	035863	22	51	26	84	8	1.40
GST 260	037623	26	60	31.3	100	10	2.23
GST 315	012457	32	66	32	116.2	10	3.48
GST 400	012458	32	70	36	136.4	11	4.40
GST 500	012459	45	93	46	175	20	11.47

* To cover the whole range 2 sets of stepped jaws are needed.

Hardened stepped monoblock jaws

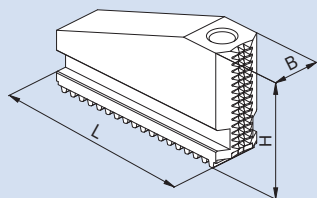
Gripping ranges



KNCS-N	140	170	210	225	260	275	325	340	400	500	630
Jaw type	GST 160-2	GST 170	GST 210	GST 210	GST 260	GST 260	GST 315	GST 315	GST 400	GST 500	GST 500
Id. No.	012454	035867	035863	035863	037623	037623	012457	012457	012458	012459	012459
A1	5-40	6-59	10-85	12-96	10-98	14-113	37-148	46-141	48-173	70-225	38-220
A2	35-70	42-89	56-121	57-132	62-150	66-165	104-215	111-206	116-238	170-320	133-328
A3	66-101	73-120	96-161	97-172	111-200	115-215	160-271	166-261	184-308	315-470	276-458
A4	97-132	104-151	136-201	137-212	161-250	165-265	217-328	221-316	252-378	-	-
J1	39-72	44-78	60-134	62-144	63-149	67-164	91-202	106-196	118-243	-	-
J2	69-103	74-110	100-174	101-185	112-199	116-214	148-259	161-251	186-310	180-330	149-342
J3	99-134	105-141	140-214	141-225	161-249	165-264	205-316	216-308	253-378	325-475	297-492
J4	131-163	135-182	185-250	186-261	212-300	216-315	272-383	281-376	328-448	425-560	385-581
S	166	198	255	266	303	318	385	376	456	585	-

SMW-AUTOBLOK	Röhm	Schunk
KNCS-N 140 HG-N 160		ROTA NCW 185 THW 165 ROTA THW plus 165 ROTA THW 165 ROTA NCW 185
KNCS-N 140 HG-N 160		THW 165 ROTA THW plus 165 ROTA THW 165
KNCS-N 170	DURO-NCES 175 DURO-A RC 180 DURO-NCSE 180	ROTA THW plus 185 ROTA-G 160
KNCS-N 210 KNCS-N 225 HG-N 210	DURO-NCES 200 DURO-A RC 215 DURO-NCSE 215	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
KNCS-N 260 KNCS-N 275 HG-N 260	DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
KNCS-N 325 KNCS-N 340 HG-N 315	DURO-NCES 315 DURO-A RC 315 DURO-NCSE 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
KNCS-N 400 HG-N 400	DURO-NCES 400 DURO-A RC 400 DURO-NCSE 400	ROTA THW 400 THW 400-R ROTA-G 400
KNCS-N 500 KNCS-N 630 HG-N 500 HG-N 630	DURO-A RC 500/630 DURO-NCSE 500/630	ROTA THW 500/630 THW 500/630-R ROTA-G 500

GES



Hard, monoblok roughing jaws for quick jaw change

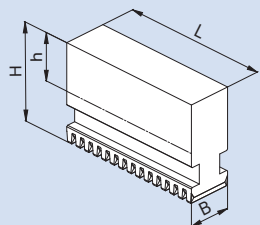
■ Modular serration straight System SMW-AUTOBLOK

Type	Id. No.	B	H	L	kg / Set	SMW-AUTOBLOK
GES 175	012460	20	43.5	69	0.90	KNCS-N 170 HG-N 160
GES 200	012461	22	51	90	1.58	KNCS-N 210 KNCS-N 225 HG-N 210
GES 250	012462	26	60	90	2.34	KNCS-N 260 KNCS-N 275 HG-N 260
GES 315	012463	32	66	132	4.31	KNCS-N 325 KNCS-N 340 KNCS-N 400 HG-N 315 HG-N 400

Note: Clamping range valid for chuck type KNCS-N.
It may differ for other chucks.

Samchully	Kitagawa	Röhm	Schunk
	QJ 306	DURO-NCES 175 DURO-A RC 180 DURO-NCSE 180	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
	QJ 308	DURO-NCES 200 DURO-A RC 215 DURO-NCSE 215	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
	QJ 310	DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
	QJ 312 QJ 15	DURO-NCES 315/400 DURO-A RC 315/400 DURO-NCSE 315/400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA-THW 400 THW 400-R ROTA-G 400

UVB

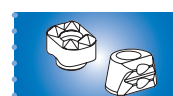


Soft monoblock jaws for quick jaw change

- Modular serration straight System SMW-AUTOBLOK
- Material: 15CrNi6, quenched 800 N/mm²

Type	Id. No.	B	H	h	L	kg / Set	SMW-AUTOBLOK
UVB 140	012446	20	60	39.4	59.5	1.52	KNCS-N 140
UVB 160/170	012447	20	60	39.4	69	1.77	KNCS-N 170 HG-N 160
UVB 200	012448	22 40	70	45	83	2.76	KNCS-N 210 KNCS-N 225 HG-N 210
UVB 200	012448-2*	22	70	45	83	1.8	KNCS-N 210
UVB 250	012449	26 46	90	61	108	5.51	KNCS-N 260 HG-N 260 KNCS-N 275
UVB 250	012449-2*	26	90	61	108	3.7	KNCS-N 260
UVB 315	012450	32 46	100	66	119	8.20	KNCS-N 325 HG-N 315 KNCS-N 340
UVB 315	012450-2*	32	100	66	119	5.5	KNCS-N 325
UVB 400	012451	32	100	66	146.5	10.10	KNCS-N 400 HG-N 400
UVB 500	012452	45	134	87	175	23.12	KNCS-N 500 HG-N 500
UVB 630	012453	45	134	87	230	30.38	KNCS-N 630 HG-N 630

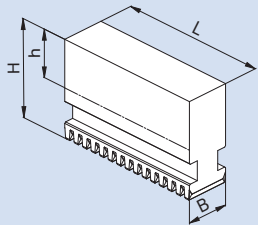
* For 2-jaw-chuck



SMW-AUTOBLOK
80

Samchully	Röhm	Schunk
	DURO-NCES 175 DURO-A RC 180 DURO-NCSE 180	ROTA THW 165 ROTA THW plus 165/185 ROTA NCW 185 ROTA-G 160 THW 165
	DURO-NCES 200 DURO-A RC 215 DURO-NCSE 215	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
	DURO-NCES 250 DURO-A RC 250 DURO-NCSE 250	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
	DURO-NCES 315 DURO-A RC 315 DURO-NCSE 315	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R
	DURO-NCES 400 DURO-A RC 400 DURO-NCSE 400 DURO-A RC 500 DURO-NCSE 500	ROTA THW 400 THW 400-R ROTA-G 400 ROTA THW 500 THW 500-R ROTA-G 500
	DURO-A RC 630 DURO-NCSE 630	ROTA THW 630 THW 630-R ROTA THW 800

UVB-H



**Soft, high monoblock jaws
for quick jaw change**

- Modular serration straight System SMW-AUTOBLOK
- Material: 15CrNi6, quenched 800 N/mm²

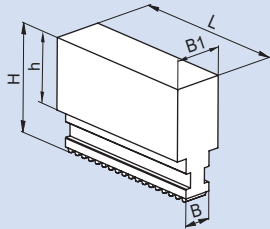
Type	Id. No.	B	H	h	L	kg / Set	SMW-AUTOBLOK
UVB-H 200	5321839	22	85	60	84	1.15	KNCS-N 210 KNCS-N 225 HG-N 210
UVB-H 250	5322137	26	115	86	99	2.19	KNCS-N 260 HG-N 260 KNCS-N 275
UVB-H 315	5322138	32	135	101	121	3.84	KNCS-N 325 HG-N 315 KNCS-N 340



SMW-AUTOBLOK
80

Samchully	Röhm	Schunk
	DURO-NCES 200	ROTA THW 210
	DURO-A RC 215	ROTA THW plus 215
	DURO-NCSE 215	ROTA-G 200
		THW 210R
		ROTA NCW 225
		ROTA THW vario 215
	DURO-NCES 250	ROTA-THW 250
	DURO-A RC 250	ROTA THW plus 260
	DURO-NCSE 250	ROTA-G 250
		THW 250/265-R
		ROTA NCW 265
	DURO-NCES 315	ROTA-THW 315
	DURO-A RC 315	ROTA THW plus 315
	DURO-NCSE 315	ROTA-G 315
		ROTA NCW 315
		THW 315-R

UVB-U



**Soft, wide monoblock jaws
for quick jaw change**

- Modular serration straight System SMW-AUTOBLOK
- Material: 15CrNi6, quenched 800 N/mm²

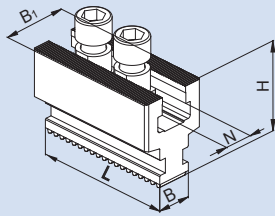
Type	Id. No.	B	B1	H	h	L	kg / Set	SMW-AUTOBLOK
UVB-U 200	5322135	22	40	65	38	84	1.31	KNCS-N 210 KNCS-N 225 HG-N 210
UVB-U 250	5322136	26	46	84	52	99	2.37	KNCS-N 260 HG-N 260 KNCS-N 275
UVB-U 315	5322139	32	46	90	52	121	3.17	KNCS-N 325 HG-N 315 KNCS-N 340



SMW-AUTOBLOK
80

Samchully	Röhm	Schunk
	DURO-NCES 200	ROTA THW 210
	DURO-A RC 215	ROTA THW plus 215
	DURO-NCSE 215	ROTA-G 200
		THW 210R
		ROTA NCW 225
		ROTA THW vario 215
	DURO-NCES 250	ROTA-THW 250
	DURO-A RC 250	ROTA THW plus 260
	DURO-NCSE 250	ROTA-G 250
		THW 250/265-R
		ROTA NCW 265
	DURO-NCES 315	ROTA-THW 315
	DURO-A RC 315	ROTA THW plus 315
	DURO-NCSE 315	ROTA-G 315
		ROTA NCW 315
		THW 315-R

KOB



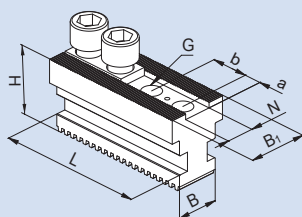
Kombi base jaws for quick jaw change

- Modular serration straight System SMW-AUTOBLOK for inch serration
- Incl. T-nuts and screw ISO 4762 – 12.9

Type	Id. No.	B	B ₁	H	L	N	Serration	kg / Set	SMW-AUTOBLOK
KOB 200-1	081323	22	45	56	85	17	1/16" x 90°	2.67	KNCS-N 210 KNCS-N 225 HG-N 210
KOB 250-1	081324	26	45	59.5	104	17	1/16" x 90°	3.63	KNCS-N 260 HG-N 260 KNCS-N 275
KOB 250-2	081325	26	50	67	104	21	1/16" x 90°	4.36	KNCS-N 260 HG-N 260 KNCS-N 275
KOB 315-2	081327	32	50	72	115	21	1/16" x 90°	5.46	KNCS-N 325 HG-N 315 KNCS-N 340
KOB 400-2	081329	32	60	76	125	25.5	3/32" x 90°	7.04	KNCS-N 400 HG-N 400 KNCS-N 315 HG-N 315
KOB 500-2	006474	45	64	84	160	25.5	3/32" x 90°	11.90	KNCS-N 500 HG-N 500 KNCS-N 630

Samchully	Röhm	Schunk
	DURO-NCES 200	ROTA THW 210
	DURO-A RC 215	ROTA THW plus 215
	DURO-NCSE 215	ROTA-G 200
		THW 210R
		ROTA NCW 225
		ROTA THW vario 215
	DURO-NCES 250	ROTA-THW 250
	DURO-A RC 260	ROTA THW plus 260
	DURO-NCSE 260	ROTA-G 250
		THW 250/265-R
		ROTA NCW 265
	DURO-NCES 250	ROTA-THW 250
	DURO-A RC 260	ROTA THW plus 260
	DURO-NCSE 260	ROTA-G 250
		THW 250/265-R
		ROTA NCW 265
	DURO-NCES 315	ROTA-THW 315
	DURO-A RC 315	ROTA THW plus 315
	DURO-NCSE 315	ROTA-G 315
		ROTA NCW 315
		THW 315-R
	DURO-NCES 400	ROTA THW 400
	DURO-A RC 400	THW 400-R
	DURO-NCSE 400	ROTA-G 400
	DURO-A RC 500/630	ROTA THW 500
	DURO-NCSE 500/630	THW 500-R
		ROTA-G 500
		ROTA THW 630
		THW 630-R
		ROTA THW 800

KLG-D



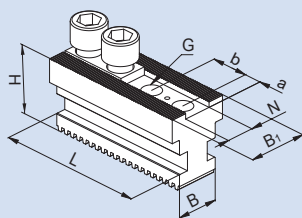
Kombi base jaws for quick jaw change

- Modular serration straight System SMW-AUTOBLOK for inch serration
- Incl. jaw mounting bolts ISO 4762 – 12.9 and guide rail

Type	Id. No.	B	B ₁	H	L	N	Serration	G	a	b*	kg / Set	SMW-AUTOBLOK
KLG-D 250-1	081311	26	40	46	86	17	1/16" x 90°	M12	10	22	2.7	KNCS-N 260 HG-N 260 KNCS-N 275
KLG-D 250-2	081312	26	45	50	110	21	1/16" x 90°	M16	13	28	4.2	KNCS-N 260 HG-N 260 KNCS-N 275
KLG-D 315-2	081314	32	45	55	110	21	1/16" x 90°	M16	13	28	4.5	KNCS-N 325 HG-N 315 KNCS-N 400 HG-N 400 KNCS-N 340

* 3 x (4 holes)

KLG-M



Kombi base jaws for quick jaw change

- Modular serration straight System SMW-AUTOBLOK for metric serration
- Incl. jaw mounting bolts ISO 4762 – 12.9 and guide rail

Type	Id. No.	B	B ₁	H	L	N	Serration	G	a	b*	kg / Set	SMW-AUTOBLOK
KLG-M 200	091378	22	40	47	95	14	1.5 x 60°	M12	10	25	2.7	KNCS-N 210 KNCS-N 225 HG-N 210
KLG-M 250	091379	26	40	47	110	16	1.5 x 60°	M12	10	30	4.2	KNCS-N 260 HG-N 260 KNCS-N 275
KLG-M 315	091380	32	50	54	120	18	1.5 x 60°	M14	15	30	4.5	KNCS-N 325 HG-N 315 KNCS-N 400 HG-N 400 KNCS-N 340
KLG-M 315-1**	236526	32	50	57	125	21	1.5 x 60°	M16	17.5	30	4.8	KNCS-N 325 HG-N 315 KNCS-N 400 HG-N 400 KNCS-N 340

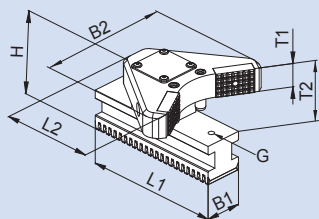
* 3 x (4 holes)

** on request

Samchully	Kitagawa	Röhm	Schunk
		DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
		DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
		DURO-NCES 315/400 DURO-A RC 315/400 DURO-NCSE 315/400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA THW 400 THW 400-R ROTA-G 400

Samchully	Kitagawa	Röhm	Schunk
		DURO-NCES 200 DURO-A RC 215 DURO-NCSE 215	ROTA THW 210 ROTA THW plus 215 ROTA-G 200 THW 210R ROTA NCW 225 ROTA THW vario 215
		DURO-NCES 250 DURO-A RC 260 DURO-NCSE 260	ROTA-THW 250 ROTA THW plus 260 ROTA-G 250 THW 250/265-R ROTA NCW 265
		DURO-NCES 315/400 DURO-A RC 315/400 DURO-NCSE 315/400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA THW 400 THW 400-R ROTA-G 400
		DURO-NCES 315/400 DURO-A RC 315/400 DURO-NCSE 315/400	ROTA-THW 315 ROTA THW plus 315 ROTA-G 315 ROTA NCW 315 THW 315-R ROTA THW 400 THW 400-R ROTA-G 400

PJC



Pendulum jaws complete for 6-point clamping for quick jaw change

■ Modular serration straight System SMW-AUTOBLOK

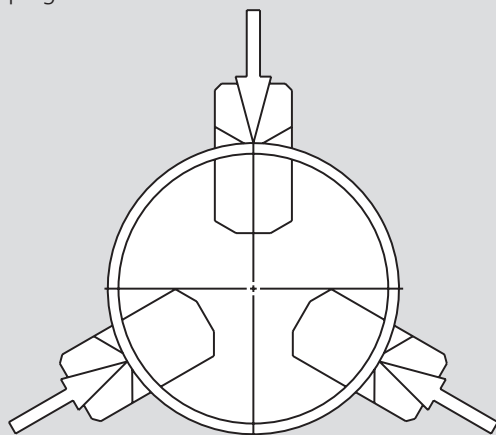
Pendulum jaws set (1 set = 3 pieces)

Type	Id. No./ Set (1 Set = 3 pieces)	Clamping range	L1	L2	B1	B2	H	T1	T2	G	kg / Set	SMW-AUTOBLOK
PJC 200	5306638	50-90	78	67.9	22	85.1	62	20	37.5	M6	3.33	KNCS-N 210
	5306639	85-140	86.5	64.3	22	107.9	62	20	37.5	M6	3.58	
	5306640	135-170	86.5	61.3	22	134.8	62	20	37.5	M6	3.64	
PJC 200	5306638	50-90	78	67.9	22	85.1	62	20	37.5	M6	3.33	KNCS-N 225
	5306639	85-155	86.5	64.3	22	107.9	62	20	37.5	M6	3.58	
	5306640	120-175	86.5	61.3	22	134.8	62	20	37.5	M6	3.64	
PJC 250	5306641	60-100	93	70.5	26	83.9	68	20	39.5	M6	3.99	KNCS-N 260
	5306642	95-140	93	75.7	26	112.3	68	20	39.5	M6	4.65	
	5306643	135-170	100	84.2	26	150.6	68	20	39.5	M6	5.41	
PJC 250	5306641	65-115	93	70.5	26	83.9	68	20	39.5	M6	3.99	KNCS-N 275
	5306642	100-155	93	75.7	26	112.3	68	20	39.4	M6	4.65	
	5306643	140-185	100	84.2	26	150.6	68	20	39.5	M6	5.41	
PJC 315	5306644	75-115	119	83.0	32	91.3	70	20	36.5	M6	5.18	KNCS-N 325
	5306645	100-160	119	83.7	32	115.6	70	20	36.5	M6	5.26	
	5306646	145-215	119	92.0	32	140.3	70	20	36.5	M6	5.97	
	5306647	180-248	119	83.0	32	163.7	70	20	36.5	M6	6.01	
PJC 200	5306638	50-90	78	67.9	22	85.1	62	20	37.5	M6	3.33	HG-N 210
	5306639	85-135	86.5	64.3	22	107.9	62	20	37.5	M6	3.58	
	5306640	128-160	86.5	61.3	22	134.8	62	20	37.5	M6	3.64	
PJC 250	5306641	60-100	93	70.5	26	83.9	68	20	39.5	M6	3.99	HG-N 260
	5306642	85-126	93	75.7	26	112.3	68	20	39.4	M6	4.65	
	5306643	122-151	100	84.2	26	150.6	68	20	39.5	M6	5.41	
PJC 315	5306644	80-120	119	83.0	32	91.3	70	20	36.5	M6	5.18	HG-N 315
	5306645	115-164	119	83.7	32	115.6	70	20	36.5	M6	5.26	
	5306646	160-207	119	92.0	32	140.3	70	20	36.5	M6	5.97	
	5306647	200-242	119	83.0	32	163.7	70	20	36.5	M6	6.01	

- For thin walled or deformation sensitive components
- Cost-efficient solution
- Short set up times: From 3-point to 6-point clamping
- Modular design: All parts interchangeable

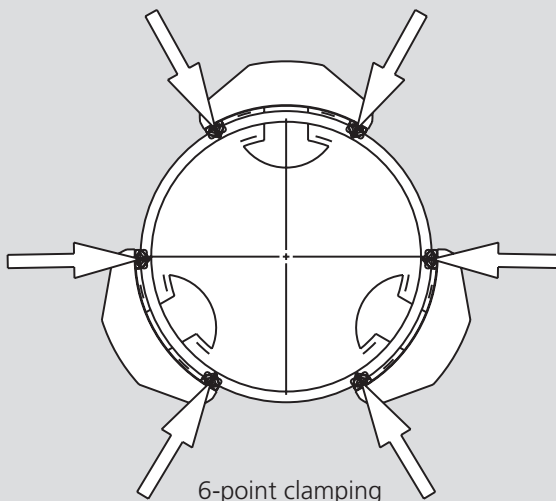
Example: Deformation of the workpiece at 3-point and 6-point clamping

Workpiece: Pipe section, 30 mm length, Outside diameter 100 mm, Inside diameter 90 mm
 Material: 16MnCr5
 Clamping force: 50 kN



3-point clamping

Deformation 1,097 mm



6-point clamping

Deformation 0,063 mm

Improvement of factor 17

Setup pendulum jaw

Type	Pendulum jaw cpl. (1 piece)		A: Base jaw cpl. ¹	B: Pendulum segment cpl. ¹	C: Clamping insert hard cpl. ²	C: Clamping insert soft cpl. ²	SMW-AUTOBLOK
	Id. No./ piece	kg/ piece	Id. No./ piece	Id. No./ piece	Id. No./ piece	Id. No./ piece	
PJC 200	5306271	1.11	5306368	5306370	5306373	5306374	KNCS-N 210
	5306272	1.19	5306369	5306371	5305807	5306421	
	5306273	1.21	5306969	5306372	5305807	5306421	
PJC 200	5306271	1.11	5306368	5306370	5306373	5306374	KNCS-N 225
	5306272	1.19	5306369	5306371	5305807	5306421	
	5306273	1.21	5306969	5306372	5305807	5306421	
PJC 250	5302901	1.33	5305802	5305803	5305804	5306420	KNCS-N 260
	5302902	1.55	5305802	5305806	5305807	5306421	
	5302903	1.80	5305808	5305809	5305807	5306421	
PJC 250	5302901	1.33	5305802	5305803	5305804	5306420	KNCS-N 275
	5302902	1.55	5305802	5305806	5305807	5306421	
	5302903	1.80	5305808	5305809	5305807	5306421	
PJC 315	5303962	1.73	5305810	5305811	5305804	5306420	KNCS-N 325
	5303963	1.75	5305810	5305813	5305807	5306421	
	5303964	1.99	5305815	5305816	5305807	5306421	
	5303970	2.00	5305815	5305817	5305807	5306421	
PJC 200	5306271	1.11	5306368	5306370	5306373	5306374	HG-N 210
	5306272	1.19	5306369	5306371	5305807	5306421	
	5306273	1.21	5306969	5306372	5305807	5306421	
PJC 250	5302901	1.33	5305802	5305803	5305804	5306420	HG-N 260
	5302902	1.55	5305802	5305806	5305807	5306421	
	5302903	1.80	5305808	5305809	5305807	5306421	
PJC 315	5303962	1.73	5305810	5305811	5305804	5306420	HG-N 315
	5303963	1.75	5305810	5305813	5305807	5306421	
	5303964	1.99	5305815	5305816	5305807	5306421	
	5303970	2.00	5305815	5305817	5305807	5306421	

¹ 1 piece per jaw = 3 pieces per set

² 2 pieces per jaw = 6 pieces per set

Pendulum jaw cpl. (1 piece) consists of:

A Base jaw

B Pendulum segment

C Clamping insert (hard)

B Protection cover incl. mounting screws

A Mounting bolt

A O-Ring

A Bushing

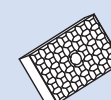
B Pendulum segment

A Swivel return

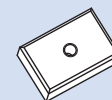
B O-Ring for swivel return

B Swivel limitation bolt

A Base jaw



Clamping insert hard (standard)

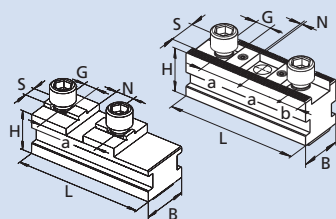


Clamping insert soft (optional)

C Clamping inserts including mounting screws (standard are hard clamping inserts)

B Pins to clamp a boring ring

GBK-B



**Hard base jaws
for SMW-AUTOBLOK KNCS-NB(X) and HG-NB
quick jaw change chucks**

■ Modular straight serration System SMW-AUTOBLOK

GBK-B Tongue & groove

Type	Id. No.	B	H	L	N	S	G	a	kg / Set
GBK-B 210	138494	28	32	85	20	10	M8	40	1.34
GBK-B 260	039624	35	40	104	20	12	M12	40	2.49
GBK-B 315	039626	50	45.8	115	20	12	M12	40	4.53
GBK-B 400	039629	50	45.8	125	26	12	M12	54	5.01
GBK-B 500	035565	62	57	160	30	18	M16	60	9.88
GBK-B 630	035902	75	57	202	30	18	M16	60	15.08
GBK-B 800	064604	75	57	286	30	18	M16	60	21.41
GBK-B 1000	069806	75	61	384	30	18	M16	60	28.60

GBK-BD Inch serration

Type	Id. No.	B	H	L	N	S	G	a	b	kg/ Set
GBK-BD 210	036292	28	32	85	1/16" x 90°	17	M12	2x23	11	1.54
GBK-BD 260	035704	35	40	104	1/16" x 90°	21	M16	1x30 / 1x28	14	2.98
GBK-BD 315	036167	50	46	115	1/16" x 90°	21	M16	1x30 / 1x28	14	5.45
GBK-BD 400	036293	50	46	125	3/32" x 90°	25.5	M20	2x38	17	6.17
GBK-BD 500	036294	62	61	160	3/32" x 90°	25.5	M20	38+49+38	17	12.20
GBK-BD 630	036295	75	61	202	3/32" x 90°	25.5	M20	38+38+52+38	18	18.55
GBK-BD 800	036296	75	61	286	3/32" x 90°	25.5	M20	38+38+38+60.7+38+38	17.5	25.74

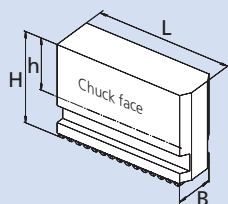
GBK-BA Tongue & groove American Standard

Type	Id. No.	B	H	L	N	S	G	a	kg / Set
GBK-BA 210	-	-	-	-	-	-	-	-	-
GBK-BA 260	-	-	-	-	-	-	-	-	-
GBK-BA 315	039628	50	45.8	120	19.02	12.7	5/8-11	63.5	4.83
GBK-BA 400	039631	50	45.8	146	19.02	12.7	3/4-10	76.2	5.89
GBK-BA 500	060561	62	57	168	19.02	12.7	3/4-10	76.2	10.53
GBK-BA 630	060562	75	57	202	19.02	12.7	3/4-10	76.2	15.45
GBK-BA 800	064590	75	57	286	19.02	12.7	3/4-10	76.2	22.34
GBK-BA 1000	069807	75	60	384	19.02	12.7	3/4-10	76.2	30.00

GBK-BM Metric serration

Type	Id. No.	B	H	L	N	S	G	a	b	kg / Set
GBK-BM 210	035566	28	32	85	1.5 x 60°	14	M12	2x25	11	1.53
GBK-BM 260	035567	35	40	104	1.5 x 60°	16	M12	2x30	11	2.87
GBK-BM 315	035568	50	45.8	115	1.5 x 60°	21	M16	2x30	14	5.44
GBK-BM 400	035569	50	45.8	125	1.5 x 60°	22	M20	2x43	17	6.29
GBK-BM 500	035570	62	61	160	3 x 60°	25	M20	1x50 / 1x60	17	12.54
GBK-BM 630	035917	75	61	202	3 x 60°	25	M20	2x60	18	19.04
GBK-BM 800	036708	75	61	286	3 x 60°	25	M20	60+60+70.5+60	17.5	26.30

UVB-B

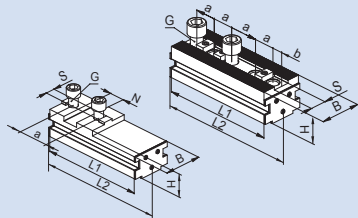


**Wide monoblock jaws
for SMW-AUTOBLOK KNCS-NB(X) and HG-NB
quick jaw change chucks**

Modular straight serration System SMW-AUTOBLOK

Type	Id. No.	B	H	h	L	kg / Set
UVB-B 210	534337	28	80	55	85	4.2
UVB-B 250	238910	35	110	81	109.5	9.4
UVB-B 315	238911	50	115	60	120.5	18.5
UVB-B 400	238740	50	125	60	148	20.7
UVB-B 500	238912	62	160	105	175	38.8
UVB-B 630	5301060	75	160	105	230	61.5

GBK-B-2G



**Hard base jaws with sealing
for SMW-AUTOBLOK HG-B-2G
quick jaw change chucks**

■ Modular straight serration System SMW-AUTOBLOK

GBK-B-2G Tongue & groove

Type	Id. No.	B	H	L1	L2*	N	S	G	a	kg / Set
GBK-B-2G 630	162316	75	57	199.5	209.7	30	18	M16	60	15.89
GBK-B-2G 800	162319	75	57	283.2	293.4	30 (2x)	18	M16	2 x 60	22.20

GBK-BD-2G Inch serration

Type	Id. No.	B	H	L1	L2*	N	S	G	a	b	kg / Set
GBK-BD-2G 630	162462	75	61	199.5	209.7	3/32" x 90°	25.5	M20	38+38+52+38	16.75	18.66
GBK-BD-2G 800	162463	75	61	283.5	293.7	3/32" x 90°	25.5	M20	38+38+38+60.7+38+38	16.25	25.85

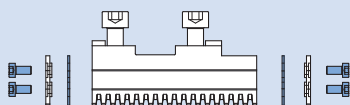
GBK-BA-2G Tongue & groove American Standard

Type	Id. No.	B	H	L1	L2*	N	S	G	a	kg / Satz
GBK-BA-2G 630	162315	75	57	199.5	209.7	19.02	12.7	3/4-10	76.2	16.74
GBK-BA-2G 800	162349	75	57	283.2	293.4	19.02 (2x)	12.7	3/4-10	2 x 76.2	23.60

GBK-BM-2G Metric serration

Typ	Id.-Nr.	B	H	L1	L2*	N	S	G	a	b	kg / Satz
GBK-BD-2G 630	162464	75	61	199.5	209.7	3x60°	25	M20	60+60	16.75	19.16
GBK-BD-2G 800	162465	75	61	283.5	283.7	3x60°	25	M20	60+60+70.5+60	16.75	26.41

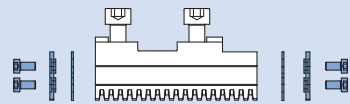
* Dimension incl. seals, cover and screws



**Seal kit
for hard base jaws
GBK-B-2G | GBK-BD-2G | GBK-BA-2G | GBK-BM-2G**

■ Consisting of seals (6 pieces)
and mounting screws (12 pieces)

Type	Id. No.	SMW-AUTOBLOK
GBK-B-2G 630	207673	HG-B-2G 800
GBK-B-2G 800	207673	HG-B-2G 1000



**Mounting kit
for hard base jaws
GBK-B-2G | GBK-BD-2G | GBK-BA-2G | GBK-BM-2G**

■ Consisting of seals (6 pieces), covers (6 pieces)
and mounting screws (12 pieces)

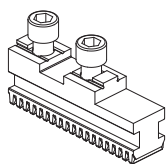
Type	Id. No.	SMW-AUTOBLOK
GBK-B-2G 630	207674	HG-B-2G 800
GBK-B-2G 800	207674	HG-B-2G 1000

Advice:

Existing master jaws still can be used without seals. A small modification made to the master jaws and a mounting kit can upgrade existing master jaws to become 2 G master jaws (instruction for the rework on request).

Jaws for quick jaw change chucks – System Forkardt

SMW-AUTOBLOK | Forkardt | Samchully | Kitagawa | Röhm | Schunk

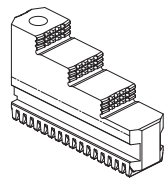


MFG

Hard base jaws

- Modular serration inclined System Forkardt
- For quick jaw change

Page 138

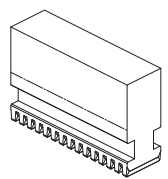


FST

Hard stepped monoblock jaws

- Modular serration inclined System Forkardt
- For quick jaw change

Page 140



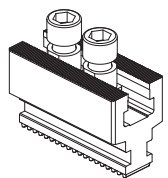
BFR

Quenched C45

Monoblock jaws

- Modular serration inclined System Forkardt
- For quick jaw change

Page 142

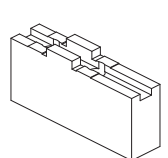


KFR

Hard kombi base jaws with T-nuts

- Modular serration inclined System Forkardt and inch serration
- For quick jaw change

Page 144



WAK

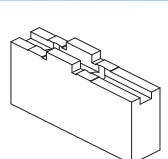
Standard 16MnCr5

Soft top jaws

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 88



WAKS

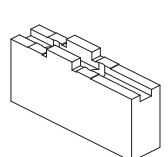
Wide version 16MnCr5

Soft top jaws

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 90



WAK-A

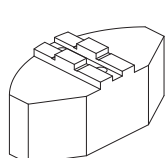
Light version Aluminum F50

Soft top jaws aluminum

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 92



SBK

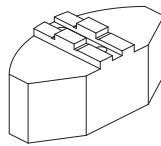
16MnCr5

Soft pie jaws

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 94



SBK-A

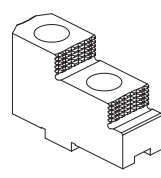
Light version Aluminum F50

Soft pie jaws aluminum

- Tongue & groove
- For quick jaw change

>> Jaw data sheet see chapter 5

Page 96



GUA

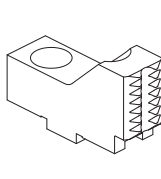
Reversible

Hard, reversible base jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

>> Jaw data sheet see chapter 6

Page 102



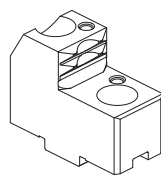
GSK

Hard bar roughing jaws

- Tongue & groove
- For quick jaw change
- For external clamping

>> Jaw data sheet see chapter 6

Page 104



GGK

Hard roughing jaws

- Tongue & groove
- For quick jaw change
- For internal and external clamping

>> Jaw data sheet see chapter 6

Page 106

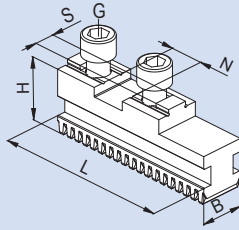
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

MFG



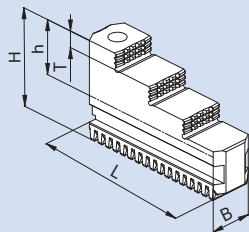
Hard base jaws for quick jaw change

- Modular serration inclined System Forkardt
- Inclusive jaw mounting bolts ISO 4762 – 12.9

Type	Id. No.	B	H	L	N	S	G x Length (tapped hole)	kg / Set	SMW-AUTOBLOK
MFG 160	081303	20	29.5	74	18	8	M8 x 1.0 x 16	0.68	HG-F 160
MFG 200	081304	22	35	90	20	10	M8 x 1.0 x 16	1.14	HG-F 210
MFG 250	081305	26	40	110	20	12	M12 x 1.5 x 20	1.82	HG-F 260
MFG 315	081306	32	46	125	26	12	M12 x 1.5 x 25	2.90	HG-F 315
MFG 400	081307	45	55	160	30	18	M16 x 1.5 x 30	6.43	HG-F 400 HG-F 500
MFG 630	034266	65	62	230	40	24	M20 x 33	16.13	HG-F 630

Forkardt	Samchully	Kitagawa	Röhm	Schunk
F 160			Duro 160	ROTA-S 160
F+160			Duro-NC 160	ROTA-S PLUS 160
KTNC 160			Duro-NC 175	
FNC 175			Duro-NCE 160	
KTNCV 160/175				
F 200			Duro 200	ROTA-S 200
F+200			Duro-NC 200	THW 210 F
KTNC 200			Duro-NCE 200	ROTA-S PLUS 200
FNC 200			Duro-NC 225	ROTA NC-WF 210
KTNCV 200				
F 250			Duro 250	ROTA-S 250
F+250			Duro-NC 250	THW 250 F
UNC 250/315			Duro-NCE 250/315	THW 265 F
FNC 250/315				ROTA NC-WF 250
KTNC 250/280/315				ROTA NC-WF 315
KTNCV 250/315				ROTA-S PLUS 250
F 315			Duro 315	ROTA-S 315
F+315			Duro-NC 315	THW 315 F
UNC 400			Duro-NCE 400	THW 400 F
FNC 400				ROTA-S PLUS 315
KTNC 360/400				
KTNCV 400				
F 400/500-L			Duro 400/500	ROTA-S 400
F+400/500			Duro-NC 400/500	ROTA-S 500
UNC 500			Duro-NCE 500	THW 500 F
KTNC 500/630				ROTA-S PLUS 400
FNC 500/630				ROTA-S PLUS 500
KTNCV 500/630				
F 630			Duro 630	ROTA-S 630
F+630			Duro-NC 630	ROTA-S plus 630

FST



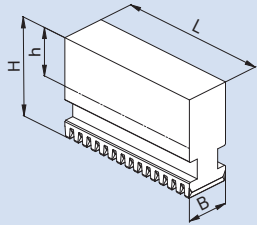
Hard stepped monoblock jaws for quick jaw change

■ Modular serration inclined System Forkardt

Type	Id. No.	B	H	h	L	T	kg / Set	SMW-AUTOBLOK
FST 160	081282	20	45	24	79	7.5	1.07	HG-F 160
FST 200	081283	22	60	35	94	10	1.84	HG-F 210
FST 250	081284	26	70	40	115	14	3.31	HG-F 260
FST 315	081285	32	81	46	129	15	5.33	HG-F 315
FST 400	081286	45	93	52	167	20	10.86	HG-F 400 HG-F 500

Forkardt	Samchully	Kitagawa	Röhm	Schunk
F 160			Duro 160	ROTA-S 160
F+160			Duro-NC 160/175	ROTA-S PLUS 160
KTNC 160			Duro-NCE 160	
FNC 175				
KTNCV 160/175				
F 200			Duro 200	ROTA-S 200
F+200			Duro-NC 200/225	THW 210 F
KTNC 200			Duro-NCE 200	ROTA-S PLUS 200
FNC 200				ROTA NC-WF 210
KTNCV 200				
F 250			Duro 250	ROTA-S 250
UNC250/315			Duro-NC 250	THW 250/265 F
F+250			Duro-NCE 250/315	ROTA NC-WF 250/315
FNC 250/ 315				ROTA-S PLUS 250
KTNC 250/280/315				
KTNCV 250/315				
F 315			Duro 315	ROTA-S 315
F+315			Duro-NC 315	THW 315 F
UNC 400			Duro-NCE 300	THW 400 F
FNC 400				ROTA-S PLUS 315
KTNC 360/400				
KTNCV 400				
F 400/500-L			Duro 400/500	ROTA-S 400/500
F+400/500			Duro-NC 400/500	THW 500 F
UNC 500			Duro-NCE 500	ROTA-S PLUS 400
KTNC 500/630				ROTA-S PLUS 500
FNC 500/630				
KTNCV 500/630				

BFR



Soft monoblock jaws for quick jaw change

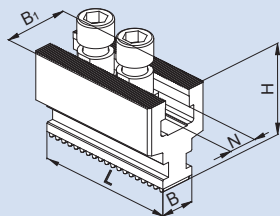
- Modular serration inclined System Forkardt
- Material: C45, serration and guide ways are induction hardened and ground

Type	Id. No.	B	H	h	L	kg / Set	SMW-AUTOBLOK
BFR 160	081272	20	45	24	79	1.48	HG-F 160
BFR 200	081273	22	60	35	94	2.00	HG-F 210
BFR 250	081274	26	70	40	115	4.33	HG-F 260
BFR 315	081275	32	81	46	140	7.43	HG-F 315
BFR 400	081276	45	93	45	176	15.39	HG-F 400 HG-F 500



SMW-AUTOBLOK
80

Forkardt	Samchully	Kitagawa	Röhm	Schunk
F 160			Duro 160	ROTA-S 160
F+160			DURO-NC 160	ROTA-S plus 160
KTNC 160			Duro-NC 175	
KTNCV 160			Duro-NCE 160	
FNC 175				
KTNCV 175				
F 200			Duro 200	ROTA-S 200
F+200			Duro-NC 200	ROTA-S plus 200
FNC 200			Duro-NCE 200	ROTA NC-WF 210
KTNC 200			Duro-NC 225	THW 210-F
KTNCV 200				
F 250			Duro 250	ROTA-S 250
F+250			Duro-NC 250	ROTA-S plus 250
FNC 250			Duro-NCE 250/315	ROTA NC-WF 250
KTNC 250				ROTA NC-WF 315
KTNCV 250				THW 250 F
UNC 250				THW 265 F
KTNC 280				
FNC 315				
KTNC 315				
KTNCV 315				
UNC 315				
F 315			Duro 315	ROTA-S 315
F+315			Duro-NC 315	ROTA-S plus 315
KTNC 360			Duro-NCE 400	THW 315 F
FNC 400				THW 400 F
KTNC 400				
KTNCV 400				
UNC 400				
F 400			Duro 400/500	ROTA-S 400
F+400			Duro-NC 400/500	ROTA-S plus 400
F 500 L			Duro-NCE 500	ROTA-S 500
F+500 L				ROTA-S plus 500
FNC 500				THW 500 F
KTNC 500				
KTNCV 500				
UNC 500				
FNC 630				
KTNC 630				
KTNCV 630				

KFR

Kombi base jaws for quick jaw change

- Modular serration inclined System Forkardt and inch serration
- Inclusive T-nuts and screws ISO 4762 – 12.9

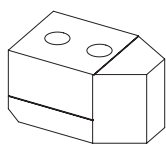
Type	Id. No.	B	B ₁	H	L	N	Serration	kg / Set	SMW-AUTOBLOK
KFR 200-1	236528	22	45	61	80	17	1/16" x 90°	3.26	HG-F 210
KFR 250-1	081330	26	45	65	110	17	1/16" x 90°	4.65	HG-F 260
KFR 250-2	081331	26	50	70	110	21	1/16" x 90°	5.75	HG-F 260
KFR 315-2	081333	32	50	75	125	21	1/16" x 90°	7.18	HG-F 315
KFR 400-1	236529	45	50	80	160	21	1/16" x 90°	11.06	HG-F 400 HG-F 500
KFR 400-2	081335	45	64	82	160	25.5	3/32" x 90°	12.92	HG-F 400 HG-F 500

Forkardt	Samchully	Kitagawa	Röhm	Schunk
F 200			Duro 200	ROTA-S 200
F+200			Duro-NC 200	THW 210 F
KTNC 200			Duro-NCE 200	ROTA-S PLUS 200
FNC 200			Duro-NC 225	ROTA NC-WF 210
KTNCV 200				
F 250			Duro 250	ROTA-S 250
UNC 250/315			Duro-NC 250	THW 250 F
F+250			Duro-NCE 250/315	ROTA-S PLUS 250
FNC 250/315				ROTA NC-WF 250/315
KTNC 250/280/315				THW 265 F
KTNCV 250/315				
F 250			Duro 250	ROTA-S 250
UNC 250/315			Duro-NC 250	THW 250 F
F+250			Duro-NCE 250/315	ROTA-S PLUS 250
FNC 250/315				ROTA NC-WF 250/315
KTNC 250/280/315				THW 265 F
KTNCV 250/315				
F 315			Duro 315	ROTA-S 315
UNC 400			Duro-NC 315	THW 315 F
F+315			Duro-NCE 400	THW 400 F
FNC 400				ROTA-S PLUS 315
KTNC 360/400				
KTNCV 400				
F 400/500 L			Duro 400/500	ROTA-S 400/500
UNC 500			Duro-NC 400/500	THW 500 F
F+400/500			Duro-NCE 500	ROTA-S PLUS 400/500
KTNC 500/630				
FNC 500/630				
KTNCV 500/630				
F 400/500 L			Duro 400/500	ROTA-S 400/500
UNC 500			Duro-NC 400/500	THW 500 F
F+400/500			Duro-NCE 500	ROTA-S PLUS 400/500
KTNC 500/630				
FNC 500/630				
KTNCV 500/630				

Jaws for application chucks

SMW-AUTOBLOK

High precision equalising chuck SJL



WAC-SJL

Tongue & groove

WAM-SJL

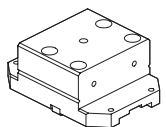
Metric serration

Top Jaws
for high precision equalising chuck SJL

- Tongue & groove
- Metric serration 1.5 x 60°

Page 148

4 jaws manual chuck Centco4-MLW-D



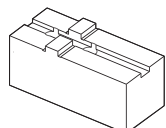
Fixed jaws

Fixed jaws
for 4 jaws manual chuck Centco4-MLW-D
only for stationary use

- Console clamping

Page 150

4 jaws independent manual chucks PTF 3, 4 and 6 jaw versions for power chucks IR-C



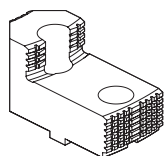
WAKA

Tongue & groove

Soft top jaws
for jaws independent manual chucks PTF
for 3, 4 and 6 jaw versions for
power chucks IR-C

- Tongue & groove (American Standard)
- Material: C45

Page 152



GUA

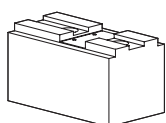
Tongue & groove

Hard, reversible top jaws
for jaws independent manual chucks PTF
for 3, 4 and 6 jaw versions for
power chucks IR-C

- Tongue & groove
- Material: C45

Page 152

3, 4 and 6 jaw versions for power chucks IN-D and IL-D



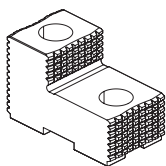
BWK

Modul 2 serration

Soft top jaws
for 3, 4 and 6 jaw versions for
power chucks IN-D und IL-D

- Modul 2 serration

Page 153



BHK

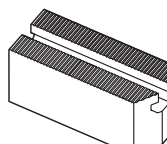
Modul 2 serration

Hard top jaws
for 3, 4 and 6 jaw versions for
power chucks IN-D und IL-D

- Modul 2 serration

Page 153

Quick jaw change power chucks AP-RD and AP-RC Quick jaw change power chucks NT-RD and NT-RC



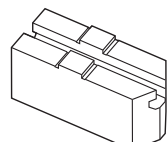
WBSA-D

Serration 2.5 x 60°

Soft top jaws
for quick jaw change power chucks
AP-RD and NT-RD

- Serration 2.5 x 60°
- Material: C45

Page 154



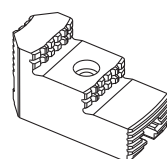
WAK-A

Tongue & groove

Soft top jaws
for quick jaw change power chucks
AP-RC and NT-RC

- Tongue & groove
- Material: C45

Page 154



MHB-D

Serration 2.5 x 60°

Hard top jaws
for quick jaw change power chucks
AP-RD and NT-RD

- Serration 2.5 x 60°
- Material: C45

Page 155

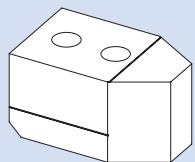
Safety advice:

Top jaws are safety components, which can be under high load depending on their use.

Max grip forces and speeds must not be exceeded at any time.

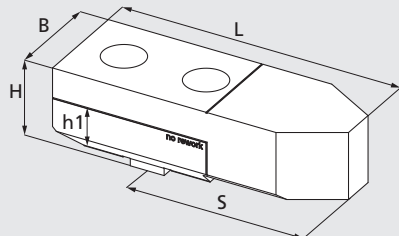
For safety reasons all jaws as well as all T-nuts and bolts must be checked regularly for damage and cracks.

WAC-SJL WAM-SJL

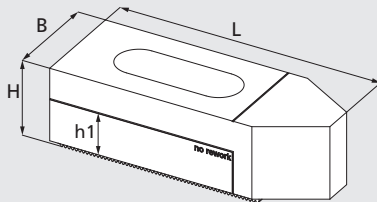


Top Jaws for high precision equalising chuck SJL

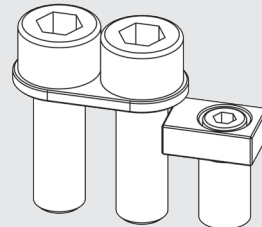
- Tongue & groove
- Metric serration 1.5 x 60°
- Material: 16MnCr5 , Serration ground



Top jaw WAC-SJL (Tongue and groove)

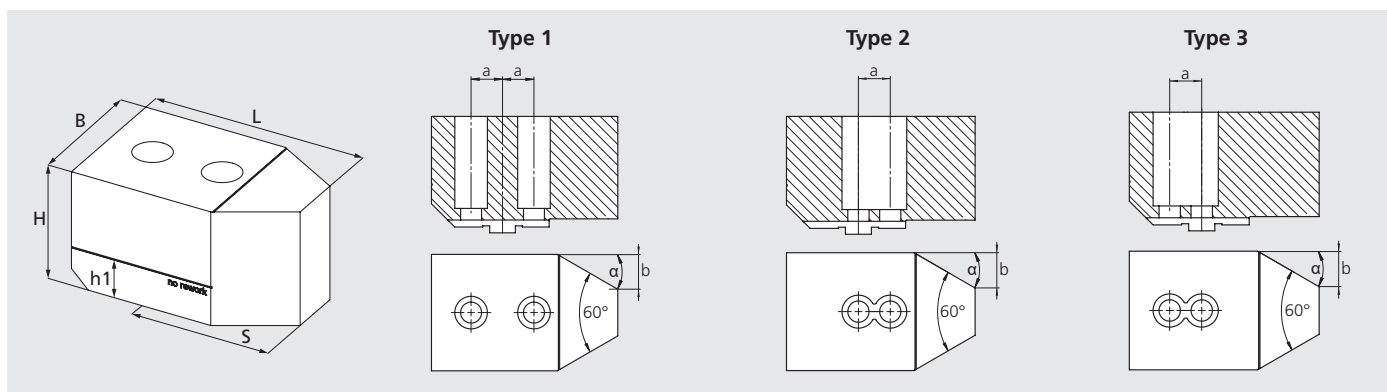


Top Jaw WAM-SJL (Metric serration)



Mounting Kit WAM-SJL

Type	Id. No.	Mounting Kit	L	B	H	h1*	S	kg / Set	SMW-AUTOBLOK
WAC-SJL-225	5300950	-	94	20	32	16.5	63.5	2.2	SJL-C 225 SJLS-C 225
WAC-SJL-290	5300955	-	115	40	36	21	80	5.4	SJL-C 290 SJLS-C 290
WAC-SJL-400	5301053	-	150	52	46	25	105.5	12.5	SJL-C 400 SJLS-C 400
WAC-SJL-500	5315987	-	150	52	46	25	105.5	12.6	SJL-C 500
WAC-SJL-630	5315988	-	200	60	50	30.5	154.5	21.6	SJL-C 630 SJL-C 800
WAM-SJL-225	539053	203572	84	20	32	20	-	1.8	SJL-M 225 SJLS-M 225
WAM-SJL-290	539055	203573	108	40	35	22	-	4.9	SJL-M 290 SJLS-M 290
WAM-SJL-400	5301052	204115	153	52	46	26.5	-	12.5	SJL-M 400 SJLS-M 400

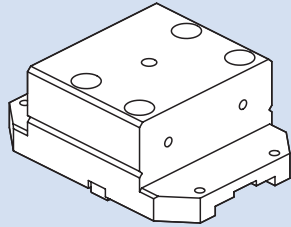


Type	Id. No.	Thread	L	B	H	h1*	S	a	b x α	kg / Set	SMW-AUTOBLOK
WAC-SJL-225 - Type 1	5316471	M8	80	50	50	18.5	49.5	13.5	15 x 30°	7	SJL-C 225 SJLS-C 225
WAC-SJL-225 - Type 2	5316472										
WAC-SJL-225 - Type 3	5316473										
WAC-SJL-290 - Type 1	5316468	M10	100	60	65	21	65	17	20 x 30°	13.5	SJL-C 290 SJLS-C 290
WAC-SJL-290 - Type 2	5316469										
WAC-SJL-290 - Type 3	5316470										
WAC-SJL-400 - Type 1	5316465	M12	140	80	65	25	95.5	22.5	28 x 30°	25.2	SJL-C 400 SJLS-C 400
WAC-SJL-400 - Type 2	5316467										
WAC-SJL-400 - Type 3	5316466										

* No rework.

Notes

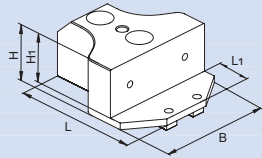
FIXED JAWS



Fixed jaws for 4 jaws manual chucks Centco4-MLW-D only for stationary application

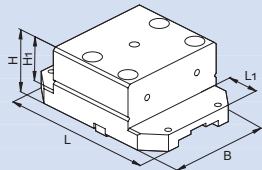
- Capture clamping | Clamping against fixed jaw
- Vise-clamping
- Very large clamping range for maximum flexibility
- Ideal for OP10 and OP20
- Inch serration 1/16" x 90° / 3/32" x 90° at movable top jaw

Movable top jaw



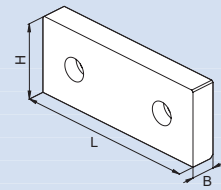
Id. No.	B	H	H1	L	L1	kg / Set	SMW-AUTOBLOK
5325943	100	57	50	110	37	2.9	Centco4-MLW-D 400-4
5325923	120	57	50	147	37	3.8	Centco4-MLW-D 600-4
5325955	160	57	50	167	37	6.7	Centco4-MLW-D 750-4
							Centco4-MLW-D 1000-4
							Centco4-MLW-D 1200-4
							Centco4-MLW-D 1400-4

Fixed top jaw



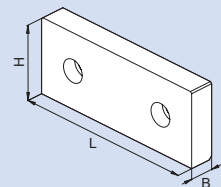
Id. No.	B	H	H1	L	L1	kg / Set	SMW-AUTOBLOK
5325947	100	69	50	142	37	5.3	Centco4-MLW-D 400-4
5325927	120	69	50	179	37	7.6	Centco4-MLW-D 600-4
5325957	160	69	50	199	37	11.7	Centco4-MLW-D 750-4
							Centco4-MLW-D 1000-4
							Centco4-MLW-D 1200-4
							Centco4-MLW-D 1400-4

Clamping insert hard



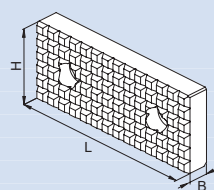
Id. No.	B	H	L	kg / Set	SMW-AUTOBLOK
5325952	16	50	100	0.7	Centco4-MLW-D 400-4
5325932	16	50	120	0.8	Centco4-MLW-D 600-4
5325877	16	50	160	1.0	Centco4-MLW-D 750-4
					Centco4-MLW-D 1000-4
					Centco4-MLW-D 1200-4
					Centco4-MLW-D 1400-4

Clamping insert soft



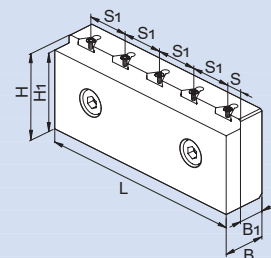
Id. No.	B	H	L	kg / Set	SMW-AUTOBLOK
5325953	30	50	100	1.2	Centco4-MLW-D 400-4
5325933	30	50	120	1.4	Centco4-MLW-D 600-4
5325878	30	50	160	1.9	Centco4-MLW-D 750-4
					Centco4-MLW-D 1000-4
					Centco4-MLW-D 1200-4
					Centco4-MLW-D 1400-4

Clamping insert with serrations



Id. No.	B	H	L	kg / Set	SMW-AUTOBLOK
5325951	16	50	100	0.6	Centco4-MLW-D 400-4
5325931	16	50	120	0.7	Centco4-MLW-D 600-4
5325959	16	50	160	1.0	Centco4-MLW-D 750-4
					Centco4-MLW-D 1000-4
					Centco4-MLW-D 1200-4
					Centco4-MLW-D 1400-4

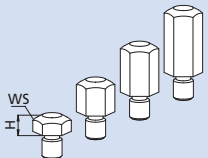
Clamping insert for SinterGrip

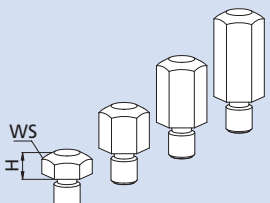


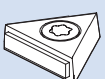
Id. No.	B	B1	H	H1	L	S	S1	kg / Set	SMW-AUTOBLOK
5326058	25	15	50	45	100	10	20	1.0	Centco4-MLW-D 400-4
5326060	25	15	50	45	120	25	15	1.2	Centco4-MLW-D 600-4
5326054	25	15	50	45	160	35	10	1.5	Centco4-MLW-D 750-4
									Centco4-MLW-D 1000-4
									Centco4-MLW-D 1200-4
									Centco4-MLW-D 1400-4

* SMW-AUTOBLOK is recommending not to clamp any diameters, that are larger than the chuck O.D.
For more detailed information please ask our customer service.

Stop pin ALB

ALB-jaw	H [mm]	WS13 / M8
	5	017603
	10	016514
	15	016515
	20	016516
	25	081191

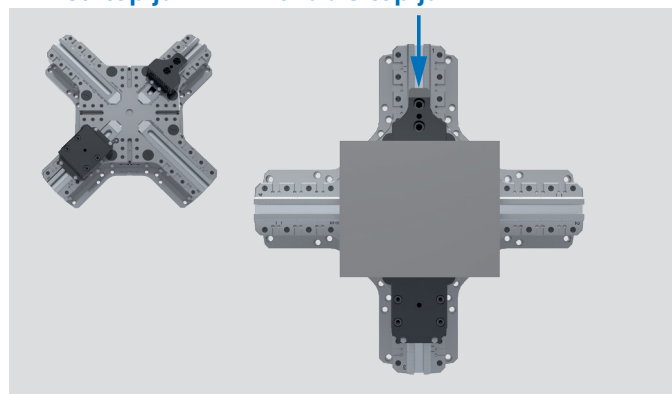
ALB-chuck		Centco4-MLW-D 400	Centco4-MLW-D 600 / 750	Centco4-MLW-D 1000 / 1200 / 1400
	H [mm]	WS19 / M10	WS24 / M12	WS27 / M16
	20	5326290	5326296	5326063
	25	5326291	5326297	5326064
	30	5326292	5326298	5326065
	35	5326293	5326299	5326066
	40	5326294	5326300	5326067
	45	5326295	5326301	5326068

SinterGrip		SinterGrip STD	SinterGrip HRC	SinterGrip ALU
	1 set	58450119	58450129	58450139

Function / Application examples

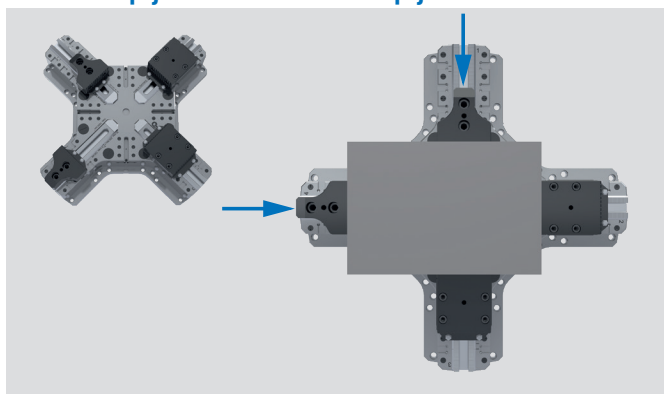
Capture clamping:

1 fixed top jaw + 1 movable top jaw



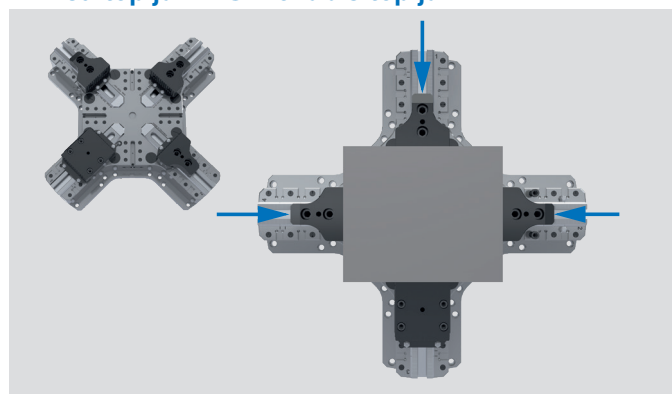
Capture clamping:

2 fixed top jaw + 2 movable top jaw



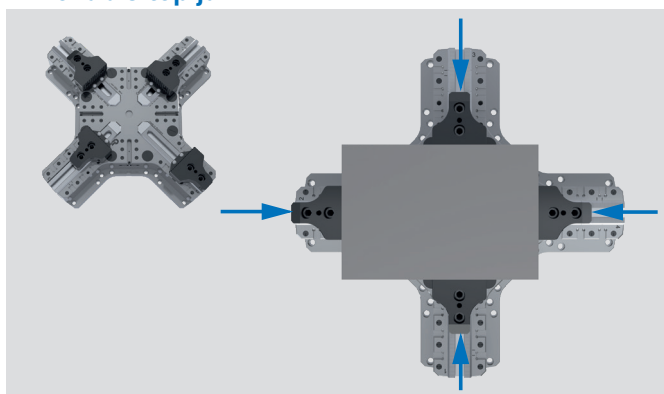
Capture clamping:

1 fixed top jaw + 3 movable top jaw

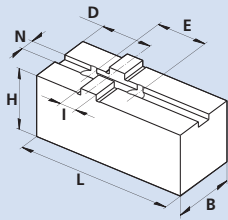


Chuck clamping:

4 movable top jaw



WAKA

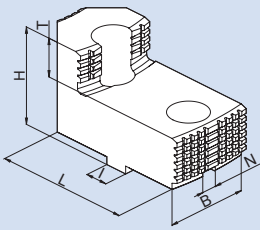


Soft top jaws
for 4 jaws independent manual chucks PTF
for 3, 4 and 6 jaw versions for power chucks IR-C

- American Standard tongue and groove
- Material: C45

Type	Id. No.	B	H	L	N	D	E	I	ISO 4762	kg / piece	SMW-AUTOBLOK
WAKA 500	12045050	75	70	165	12.7	50.5	76.2	19.03	M20	5.83	IR-C 600 IR-C 800
WAKA 1000	13046310	116	110	270	30	115.5	76.2 + 76.2	19.03	M24	22.67	IR-C 1000 IR-C 1250 IR-C 1400 IR-C 1600 IR-C 2000 IR-C 2500 PTF 1000 PTF 1250 PTF 1400 PTF 1600 PTF 2000

GUA

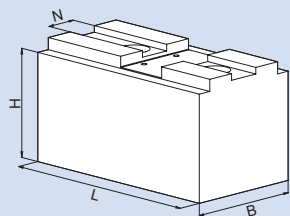


Hard, reversible top jaws
for 4 jaws independent manual chucks PTF
for 3, 4 and 6 jaw versions for power chucks IR-C

- American Standard tongue & groove
- Material: 16MnCr5

Type	Id. No.	B	H	L	T	N	I	ISO 4762	Number of jaws	kg / piece	SMW-AUTOBLOK
GUA 300	12087111	70	75	146	32	12.7	19.03	76.2 M20	1	3.39	IR-C 600 IR-C 800 JBX 300 JBX-2G 300 JBX-2G 400
GUA 1000	13086310	110	117	223	55	12.7	19.03	114.3 M24	1	29.4	IR-C 1000 IR-C 1250 IR-C 1400 IR-C 1600 IR-C 2000 IR-C 2500 PTF 1000 PTF 1250 PTF 1400 PTF 1600 PTF 2000

BWK

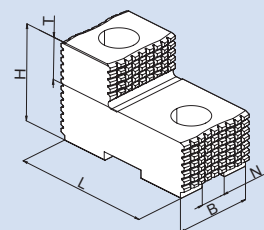


Soft top jaws for 3, 4 and 6 jaw versions for power chucks IN-D | IL-D

■ Modul 2 serration

Type	Id. No.	B	H	L	N	ISO 4762	Number of jaws	kg / piece	SMW-AUTOBLOK
BWK 305 ¹	13043910	100	110	200	30	100 M24	1	15.85	IN-D 1000 IN-D 1250 IL-D 1400 IL-D 1600

BHK



Hard top jaws for 3, 4 and 6 jaw versions for power chucks IN-D | IL-D

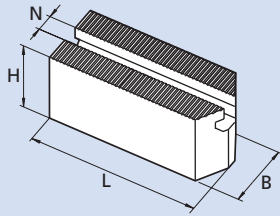
■ Modul 2 serration

Type	Id. No.	B	H	L	T	N	ISO 4762	Number of jaws	kg / piece	SMW-AUTOBLOK
BHK 305 ¹	13083910*	85	110	175	47	30	100 M24	1	7.78	IN-D 1000 IN-D 1250 IL-D 1400 IL-D 1600

* only 1 clamping level

1) only usable with cross key Id. No. 13114910

WBSA-D

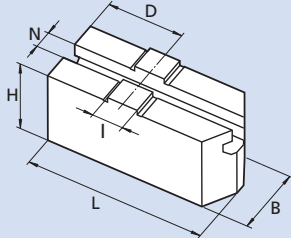


**Soft top jaws
for quick jaw change power chucks AP-RD
for quick jaw change power chucks NT-RD**

- Serration 2.5 x 60°
- Material: C45

Type	Id. No.	Serration	B	H	L	N	kg / piece	SMW-AUTOBLOK
WBSA-D 170	18071730	2.5 x 60°	30	40	70	10	0.48	AP-RD 170 NT-RD 170
WBSA-D 215	18072130	2.5 x 60°	35	45	90	10	0.87	AP-RD 215 NT-RD 215
WBSA-D 260	18072630	2.5 x 60°	45	60	100	12	1.70	AP-RD 260 NT-RD 260
WBSA-D 315	18073130	2.5 x 60°	45	60	120	14	2.05	AP-RD 315 NT-RD 315
WBSA-D 400	18074030	2.5 x 60°	55	75	140	18	3.87	AP-RD 400 NT-RD 400

WAK-A

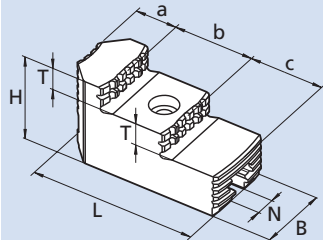


**Soft top jaws
for quick jaw change power chucks AP-RC
for quick jaw change power chucks NT-RC**

- Tongue and groove
- Material: C45

Type	Id. No.	B	H	L	N	D	I	kg / piece	SMW-AUTOBLOK
WAK-A 170	18041730	30	37	80	10	30	12.70	0.52	AP-RC 170 NT-RC 170
WAK-A 215	18042130	35	44	100	10	35	12.70	0.97	AP-RC 215 NT-RC 215
WAK-A 260	18042630	45	57	120	12	42	19.03	2.02	AP-RC 260 NT-RC 260
WAK-A 315	18043130	45	57	140	14	50	19.03	2.30	AP-RC 315 NT-RC 315
WAK-A 400	18044030	55	70	165	18	60	19.03	4.20	AP-RC 400 NT-RC 400

MHB-D



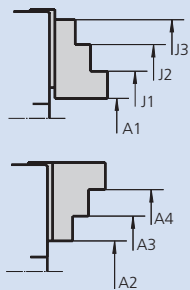
Hard top jaws for quick jaw change power chucks AP-RD for quick jaw change power chucks NT-RD

- Serration 2.5 x 60°
- Material: C45

Type	Id. No.*	Serration	B	H	L	N	T	a	b	c	kg / piece	SMW-AUTOBLOK
MHB-D 170	18081736	2.5 x 60°	30	45	65	10	10	23	24	18	0.36	AP-RD 170 NT-RD 170
MHB-D 215	18082136	2.5 x 60°	35	46	82	10	10.5	24	36	22	0.57	AP-RD 215 NT-RD 215
MHB-D 260	18082636	2.5 x 60°	45	56	100	12	14.5	27	39	34	1.04	AP-RD 260 NT-RD 260
MHB-D 315	18083136	2.5 x 60°	45	57	105	14	14	27	42	36	1.09	AP-RD 315 NT-RD 315
MHB-D 400	18084036	2.5 x 60°	55	73	140	18	18.5	42	49	49	2.27	AP-RD 400 NT-RD 400

First operation jaws, if high concentricity is required jaws have to be ground on chuck.

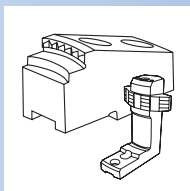
* The number refers to a set of 3 jaws



Clamping ranges for hard top jaws for quick jaw change power chucks AP-RD for quick jaw change power chucks NT-RD

Type	Id. No.	A1	A2	A3	A4	J1	J2	J3	SMW-AUTOBLOK
MHB-D 170	18081736	15-75	-	55-115	105-155	65-120	110-170	145-205	AP-RD 170 NT-RD 170
MHB-D 215	18082136	20-95	-	65-145	140-200	75-150	140-215	185-260	AP-RD 215 NT-RD 215
MHB-D 260	18082636	20-105	-	95-175	170-245	80-160	150-235	220-305	AP-RD 260 NT-RD 260
MHB-D 315	18083136	35-130	-	105-205	190-290	110-195	190-280	265-350	AP-RD 315 NT-RD 315
MHB-D 400	18084036	45-170	-	145-275	245-370	135-255	230-350	325-450	AP-RD 400 NT-RD 400

Accessories

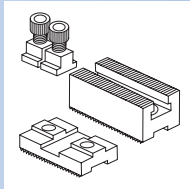


Page 158

SPECIAL

Special jaws

- To customer request

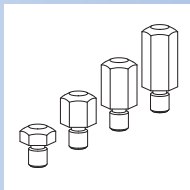


Page 160

AD

Conversion jaws

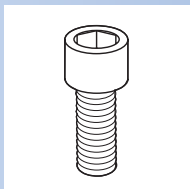
- Serration
- Tongue & groove



Page 161

ALB

Stop pins



Page 161

Mounting bolts

Jaw mounting bolts

- ISO 4762, Class 12.9
- For base jaws type GBK, GBK-2G, GBKS, GBK-B, GBK-B-2G, MFG



Page 162

ROTORI

Jaw boring set

- To bore jaws on the chuck



Page 163

ADS

Boring rings

- To bore jaws on the chuck



Page 163

RPS

Dress and cleaning plate

- Inch and metric serration
- To clean and dress top jaws

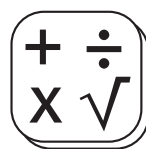


Page 164

Gripping force tester GFT®-X 4.0

Multi Device Tablet with expert apps

- Wireless handheld with rechargeable battery
- Dynamic or static gripping force measuring
- Speed measuring
- Display Software



Page 168

Calculation service

- Grip force
- Deformation

SMW-AUTOBLOK Special jaws

Turnkey solutions for almost every workpiece demand

SMW-AUTOBLOK delivers customized clamping solutions in no time.

All clamping devices are getting calculated through FEM analysis meticulously and are meeting the highest security standards. When designing, particular attention is paid to meet the highest and consistent processing quality. In addition, the economy, especially in minimizing set-up costs, is taken into account.

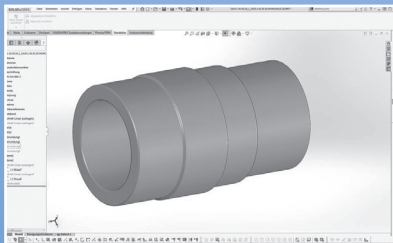
All milestones – from the customer inquiry to the delivery of the complete setup – are based on a certified workflow, which is constantly visible to our customers. All clamping devices are designed and manufactured in a way so that you, the customer, can start machining your workpieces directly.

After delivery of the device, a worldwide service network guarantees support directly at the application site.

We also offer our special jaws for all commercially available chucks from other manufacturers.

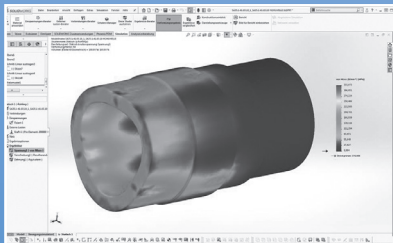
Certified workflow

Real-time simulation in the construction process



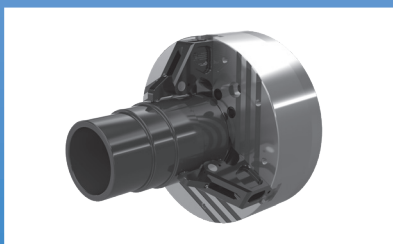
Customized design

Turnkey solutions – workpiece-specific design of clamping devices within a very short time.



FEM calculation

Each design goes through a safety process in the project planning, in which an FEM calculation is carried out.



Ready to use

After production, pre-assembly and testing, the device is delivered ready for use – with customer identification on request.

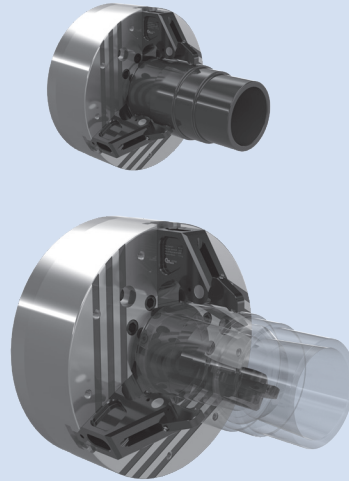
Example:

O.D. Clamping of a hollow shaft without additional support

Customer requirements: O.D. clamping of a hollow shaft, clamping on two different diameters, workpiece should be machined without additional support.

Solution: Pendulum jaws with axial pendulum, interchangeable clamping inserts UGE10.

Customer benefit: The hollow shaft can be securely clamped and processed without additional support, simple and quick replacement of the clamping inserts when worn.



Do you have any concern?

Ask our workholding experts today:

Phone: +49 (0) 7542 405 0

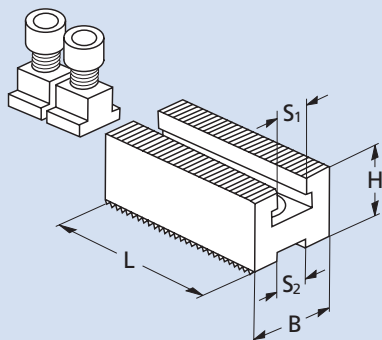
E-mail: sales@smw-autoblok.de

Hardened conversion jaws

- For matching of top jaws to chucks with different jaw interface
- If you have any questions in advance, please contact sales@smw-autoblok.de

 Interactive PDF available at www.smw-autoblok.de

Conversion jaw type AD 10



Dimensions

Serration chuck side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S2		mm		
----	--	----	--	--

Serration jaw side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S1		mm	B		mm
H		mm	L		mm

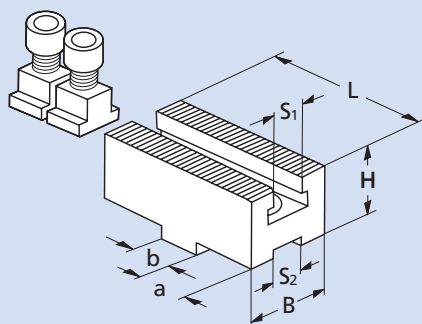
Chuck manufacturer

Chuck type + Size

Fine serration on both sides.

T-nuts and bolts are special according to the existing top jaws.

Conversion jaw type AD 50



Dimensions

Serration jaw side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S1		mm	B		mm
H		mm	L		mm
a		mm	b		mm
S2		mm			

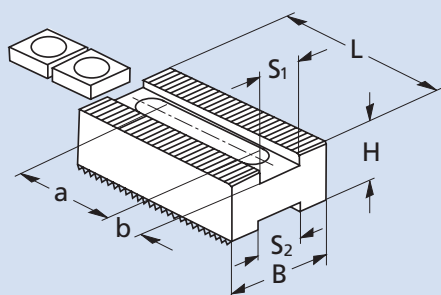
Chuck manufacturer

Chuck type + Size

Tongue and groove on the chuck and fine serration on the jaws.

T-nuts and bolts are special according to the existing top jaws.

Conversion jaw type AD 30



Dimensions

Serration chuck side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S2		mm		
----	--	----	--	--

Serration jaw side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S1		mm	B		mm
H		mm	L		mm
a		mm	b		mm

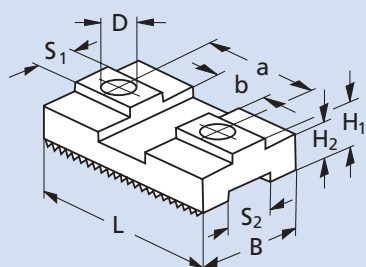
Chuck manufacturer

Chuck type + Size

Fine serration on both sides.

The conversion jaw has a slot so that it can match different bolts patterns.

Conversion jaw type AD 80



Dimensions

Serration chuck side (please mark)

	1/16" x 90°		1.5 x 60°
	3/32" x 90°		3 x 60°

S1		mm	B		mm
H1		mm	L		mm
H2		mm	a		mm
S2		mm	b		mm

Chuck manufacturer

Chuck type + Size

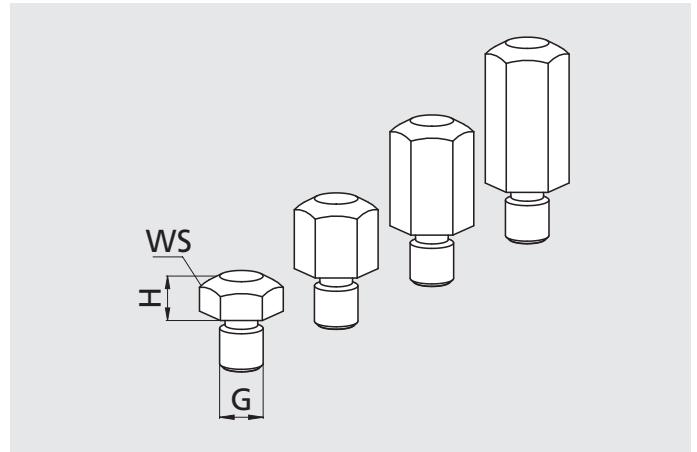
Tongue and groove on the jaw and fine serration the chuck.

The size and position of the holed D are depending on the existing T-nuts.

■ For turning out jaws on the chuck

Stop pins ALB

SMW-AUTOBLOK Type	Id. No.	G	H	WS
ALB 505	016510	M5	5	10
ALB 510	016508	M5	10	10
ALB 515	016509	M5	15	10
ALB 605	016513	M6	5	10
ALB 610	016511	M6	10	10
ALB 615	016512	M6	15	10
ALB 620	017602	M6	20	10
ALB 805	017603	M8	5	13
ALB 810	016514	M8	10	13
ALB 815	016515	M8	15	13
ALB 820	016516	M8	20	13
ALB 825	081191	M8	25	13

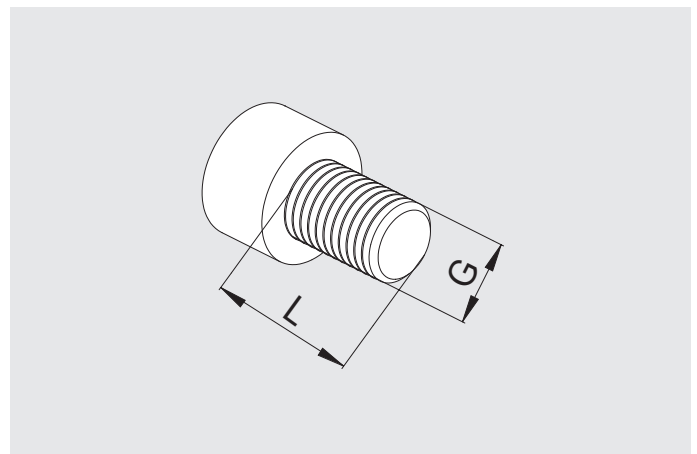


Jaw mounting bolts for base jaws type GBK, GBK-2G, GBKS, GBK-B, GBK-B-2G, MFG

■ Screw ISO 4762, Class 12.9

Jaw mounting bolts

Id. No.	G x Length	ISO	SMW-AUTOBLOK Base jaws
010182	M8 x 20	ISO 4762	GBK 140 GBK 160 GBK 200 GBK-2G 170 GBK-2G 200 GBKS 200 GBKS 210
015524	M12 x 25	ISO 4762	GBK 140 GBK 260 GBK 315 GBK-2G 250 GBK-2G 315 GBKS 250 GBKS 315 GBKB 315
010207	M12 x 30	ISO 4762	GBK 400 GBK-2G 400 GBKS 400 GBKS 400
010448	M16 x 45	ISO 4762	GBK 500 GBK 630 GBK-2G 500 GBK-2G 630 GBKB 500 GBKB 630 GBKB 800 GBK-B-2G 630 GBK-B-2G 800
082498	M20 x 45	ISO 4762	MFG 630
084331	M8 x 1 x 20	ISO 4762	MFG 160 MFG 200
087603	M12 x 1.5 x 30	ISO 4762	MFG 250
087733	M12 x 1.5 x 35	ISO 4762	MFG 315
086405	M16 x 1.5 x 40	ISO 4762	MFG 400



Jaw boring set ROTORI

With the ROTORI boring set, clamping jaws can be turned out with high precision under clamping pressure and hard clamping jaws can be ground out.

The set consists of several rings in different dimensions. The desired clamping diameter can be set continuously via the curve segments. Further readjustment of the clamping point is possible.

Your advantages

- **High flexibility**
 - Internal- and external clamping with 1 ring
 - Infinitely adjustable clamping range
 - Suitable for chuck sizes 80 - 1.600 mm, for 2-, 3-, 4-, and 6-jaw manual- and power chucks
 - Optimal accessibility of the turning tool
- **High precise**
 - 0.1 mm accurate infeed of the clamping diameter
- **Increased profitability**
 - Low set-up costs thanks to Rotofix clamping bolts
 - Fast and flexible handling
 - High cost savings on clamping jaws



Type	Id. No.	Ring (piece)	RotoFix Clamping bolts	Chuck Type	Chuck Size
RotoRi Premium L	5311480	29	M10/M12/M16	3-Jaw Chuck	80-315
RotoRi Premium XL	5311481	10	M16/M20	3-Jaw Chuck	315-630
RotoRi Premium XXL	5311482	13	M16/M20	3-Jaw Chuck	500-1200
RotoRi Premium Master XL	5311483	25	M8/M10/M12/M16	2,3,4 und 6-Jaw Chuck	160-500
RotoRi Premium Six L	5311484	29	M8/M10/M12	6-Jaw Chuck	80-250
RotoRi Premium Six XL	5311485	25	M10/M12/M16	6-Jaw Chuck	200-500
RotoRi Premium Six XXL	5311486	13	M16/M20	6-Jaw Chuck	500-1200
RotoRi Premium Quattro L	5311487	29	M8/M10/M12	4-Jaw Chuck	80-250
RotoRi Premium Quattro XL	5311488	15	M10/M12/M16	4-BJaw Chuck	200-500
RotoRi Premium Quattro XXL	5311489	13	M16/M20	4-Jaw Chuck	500-1200

Clamping bolt ROTORI

Type	Id. No.	Size
RotoriFix Clamping bolt M8	5311490	M8
RotoriFix Clamping bolt M10	5311491	M10
RotoriFix Clamping bolt M12	5311492	M12
RotoriFix Clamping bolt M16	5311493	M16
RotoriFix Clamping bolt M20	5311494	M20

■ To bore jaws on the clamping chuck

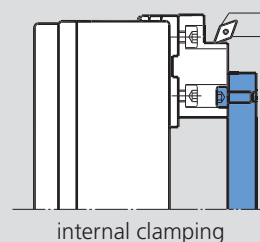
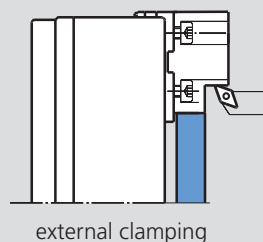
ADS, Id. No. 082689

Parts included:

- Packing box
- Boring rings 36 pieces
- Loading tool



Applications



The advantages of the SMW-AUTOBLOK boring rings for jaws:

- Complete set to bore all dia. from 20 to 150 mm.
- Set consisting of 36 rings Ø 20 - 50 mm each stepped 2 mm. From Ø 50 - 150 mm stepped in 5 mm increments.
- Clearly organized in packing box.
- Rings from Ø 105 mm and up have 3 tapped holes for clamping bolts to machine jaws for internal gripping.
- Rigid design. Rings are 10 mm thick, quenched for greater durability.
- Loading tool is used for the safe insertion of the rings without danger of injuries.

Recommendations:

For highest repeatability and accuracy please follow these instructions:

- Always tighten mounting bolts of the top jaws with a torque wrench.
- Always position boring rings as close as possible to the clamping area.
- Always bore top jaws at machining pressure.

- With 2 different fine serrations to clean and dress top jaws
- With fine serration inch / metric

Dress and cleaning plate RPS

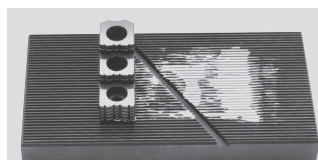


- Dress and cleaning plate, hardened, precision ground serrations.
- 2 different serrations, on the upper and lower side of the plate. Just turn it!
- Rapid cleaning of the top jaws serration. Swarf and dirt is accumulated in the diagonal groove.
- Dressing of light damage on the serration by using the grinding compound.

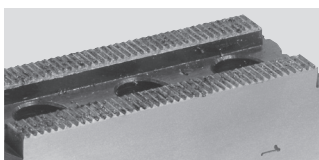
Dressing and cleaning of serration



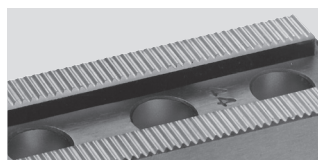
Apply grinding compound (corn 320) near the outer edge.



Put the jaw on the grinding compound and move it back and forth, with a light pressure.



Dirty / damaged serration



Serration after dressing and cleaning

SMW-AUTOBLOK Type	Id. No.	Serration		kg
		upper side	lower side	
RPS-D	081912	1/16" x 90°	3/32" x 90°	7.8
RPS-M	081914	1.5 x 60°	3 x 60°	7.8
RPS-MD	081913	1.5 x 60°	1/16" x 90°	7.8

Parts included:

- Dress and cleaning plate
- 1 tube of grinding paste
- Wooden box

Extra grinding paste:
Id. No. 037133

MULTI DEVICE

Gripping Force Tester GFT-X 4.0

Wireless gripping force and speed measuring of jaw chucks and collet chucks in dynamic or static measuring mode



Measuring heads

M3 / M4

Measuring heads for jaw chucks

Clamping-Ø 72 to 108 mm



Measuring head convertible for 2 and 3 jaws

Measuring head	Range / gripping force	
	2 Jaws	3 Jaws
M3	0 to 180 kN	0 to 270 kN
	Id. No. 207074	
M4	0 to 30 kN	0 to 45 kN
	Id. No. 207259	



Separate measuring head for 2, 3 and 6 jaws

Measuring head	Range / gripping force
	6 Jaws
M3-6	0 to 270 kN on request
M4-6	0 to 45 kN on request

M2

Measuring head for collet chucks

Clamping-Ø 42 mm



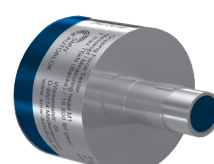
For collets with 3 segments

Measuring head	Range / gripping force
	Collets
M2	0 to 120 kN
	Id. No. 207258

M1

Measuring head for collet chucks

Clamping-Ø 18 mm



For collets with 3 segments

Measuring head	Range / gripping force
	Collets
M1	0 to 75 kN
	Id. No. 207257

Features GFT-X 4.0

- **Wireless data transfer** from measuring head to table via Bluetooth for the measuring of dynamic and static clamping forces and speed (with included bracket)
- **Built-in camera** in tablet
- **Assistance systems:**
Manuals, Jaw Finder, Chuck Finder, Technical calculations
- **Rechargeable battery**, operation time in use: 8h
- **Smart user interface**
- Tablet suitable for **industrial use**
(Protection class IP 67)
- **Display** kN or lbf
- **Languages:**
German, English, Italian, Spanish, Russian, Chinese and Japanese
- **Measured clamping forces can be evaluated**
by the integrated software or by the display software on Laptop / PC
- **4 Measuring heads** for jaw chucks and
2 Measuring heads for collet chucks



Gripping force tester – GFT-X 4.0 with measuring head



GFT-X 4.0

Multifunctional Gripping Force Tester

Wireless gripping force measuring

Ordering overview and technical data

Standard equipment with GFT-X 4.0

Case with:

- Large Multi Device Tablet.
- Measuring head M3 (2 and 3 jaws) for jaw chucks with extensions and loading device.
- Torx-key T15 and spare screws.
- Bracket with magnet for measuring of speed.
- Loading cable with USB port.
- USB cable for Tablet.
- Adapter for USA, UK and Southern Europe.

Ordering data

GFT-X 4.0 case incl. Tablet, Measuring head M3 (2 and 3 jaws) Id. No. 206844

Option:

Measuring head M1 (for collet chucks)	Id. No.	207257
Measuring head M2 (for collet chucks)	Id. No.	207258
Measuring head M3 (2 and 3 jaws)	Id. No.	207074
Measuring head M4 (2 and 3 jaws, high-precision)	Id. No.	207259
Measuring head M3 (6 jaws)	Id. No.	207586
Measuring head M4 (6 jaws, high-precision)	Id. No.	207587



Display software PC / Laptop

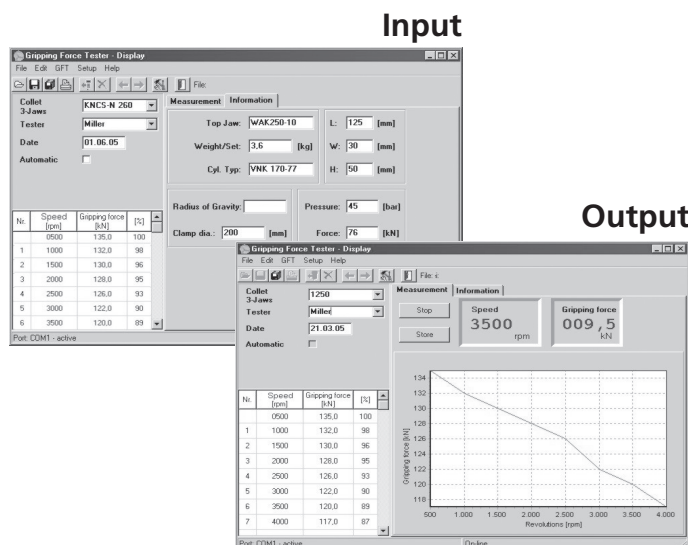
- The data transfer is via an USB interface.
- The software can be run under all standard windows systems.

Input

- Automatic measuring of the data (gripping force - speed).
- The number of measuring steps can be programmed free.

Output

- Table gripping force / speed.
- Diagram gripping force / speed.



Technical data

Tablet	
Display / Grip force F – speed	Display in kN / lbf - r.p.m
Data transfer	Bluetooth 4.0
Power supply / Transformer	100 / 240 V AC, 50 to 60 Hz
Distance Tablet / Measuring head	1-4 m (appr.)
Interface PC / Laptop	USB 2.0
Operating temp.	0 to 40° (32°-100 °F)
Protection class	IP 67

Warning: Machine door must be closed while measuring head is rotating!

Measuring heads				
	Measuring head M1	Measuring head M2	Measuring head M3	Measuring head M4
Application	collet Ø 18	collet Ø 42	chuck 2 / 3 or 2 / 3 / 6 jaws	
Clamping diameter	18 mm	42 mm	72 to 108 mm	72 to 108 mm
No. of jaws	collet 3 x slotted	collet 3 x slotted	2 and 3 jaws / 6 jaws	
Power supply	internal rechargeable capacitor			
Capacity of power supply	ca. 1.5 h at 50 % d.c.			
Data transfer	Bluetooth 4.0			
Range / gripping force F max.	0 to 75 kN	0 to 120 kN	0 to 180 kN (2-jaws) 0 to 270 kN (3 / 6-jaws)	0 to 30 kN (2-jaws) 0 to 45 kN (3 / 6-jaws)
Speed r.p.m	<10.000 r.p.m.	<8.000 r.p.m.	<6.000 r.p.m.	<6.000 r.p.m.
Accuracy (F / r.p.m)	<5% / <1% fsr	<5% / <1% fsr	<3% / <1% fsr	<1.5% / <1% fsr

Notes

Calculation Service

■ We can provide a calculation of deformation for thin walled components when clamping with the chuck

Verform -03.03.02/MR SMW-AUTOBLOK

Kunde: Beispiel 1 Werkstück-Nr:

Werkstück-Daten

Aussendurchmesser AD
100 mm

Innendurchmesser ID
80 mm

Einspanntiefe L1
15 mm

Werkstoff
Stahl

Futter-Spannkraft
7000 daN

Werkstück-Spannung
☒ 3-Punkt Spannung
 ☐ 6-Punkt Spannung

drucken
beenden

berechnen

Berechnung der Verformung 3-Punktspegnung

Werkstückverformung t
0,3265 mm

Please note:

The roundness of the work piece is affected by the clamping, as well as by the accuracy of the machine, the tool and the work piece characteristic.

Verform -03.03.02/MR SMW-AUTOBLOK

Kunde: Beispiel 2 Werkstück-Nr:

Werkstück-Daten

Aussendurchmesser AD
100 mm

Innendurchmesser ID
80 mm

Einspanntiefe L1
15 mm

Werkstoff
Stahl

Futter-Spannkraft
7000 daN

Werkstück-Spannung
☐ 3-Punkt Spannung
 ☒ 6-Punkt Spannung

drucken
beenden

berechnen

Berechnung der Verformung 6-Punktspegnung

Werkstückverformung t
0,0187 mm

Please note:

The roundness of the work piece is affected by the clamping, as well as by the accuracy of the machine, the tool and the work piece characteristic.

Calculation service

■ We can calculate the necessary gripforce for SMW-AUTOBLOK chucks for your machining process.

ESP1.3 SMW-AUTOBLOK

Kunde: Beispiel 1 Werkstück-Nr.:

Bearbeitungs-Daten

Spanndurchmesser dsp: 100 mm

Zerspanndurchmesser dz: 80 mm

Vorschub: 0,2 mm/Umdr.

Schnitttiefe: 2 mm

Einstellwinkel χ_r : 45

Drehzahl: 4500 min⁻¹

Werkstück-Daten

Werkstoff: 16 Mn Cr5

Werkstückoberfläche:

- ☐ geschliffen
- ☐ geschichtet
- ☒ roh

Spann-Verhältnis

$l_z/l_{sp} \leq 3$

Backen-Daten

Backenlänge: 72 mm

Backenbreite: 22 mm

Backenhöhe: 38 mm

Backengewicht / Backe (kg): 0,47

Schwerpunktradius Aufsatzbacke: 94 mm

Backenspannfläche:

- ☐ glatt
- ☐ Pflastersteinverzahnung
- ☒ Spitzverzahnung

Spannfutter-Daten

Spannfutter-Typ: KNCS-N

Spannfutter-Größe: 210

max. zul. Spannkraft: 10000 daN

für die Bearbeitung erforderlichen Kräfte

berechnen

Haupt-schnittkraft: 114 daN

Futterspannkraft bei statischer Anwendung: 405 daN

Futterspannkraft bei dynamischer Anwendung: 5054 daN

drucken

beenden

Die angezeigten Werte sind RICHT-WERTE. Bei der Bearbeitung eventuell auftretende zusätzliche Faktoren wurden nicht berücksichtigt. Die Verantwortung zur Prüfung der angezeigten Werte hat der Anwender zu tragen. Garantieleistungen bzw. Forderungen jeglicher Art können nicht gewährt werden.

Notes

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SMW-AUTOBLOK

Service Benefits

>> **Service hotline**

Hotline +49 (0) 7542 - 405 - 140

>> **Worldwide**

Service and support on site

>> **Rapid task force**

Global reach in less time,
technical problem-solving skills

>> **Repair**

Quick Repair, express service on request

>> **Original spare parts**

Relevant spare parts are available from stock

>> **Training**

Individual training courses

>> **Run-off**

Run-off and support at the point of use

>> **Maintenance**

Scheduled maintenance, at SMW-AUTOBLOK or at the customer

>> **Warranty**

Warranty of 24 month on request

>> **Kontakt**

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