NEW GENERATION

The sealed quick jaw change manual chuck

HG-B-2G

► ALL EXISTING TOP JAWS CAN BE USED

Customer benefits

	HG-NB	HG-B-2G
Minimized set up times due to the quick jaw change system	■	■
Highest accuracy of the jaw change	■	■
Universal applicable	■	■
Case hardened parts	■	■
Wedge bar drive	■	■
Jaw safety interlock	■	■
Ideal for vertical mounting of chuck		■
Sealed wedge bars and base jaws		■
Optimized lubrication in the jaw guides		■
Low maintenance		■

Economic and efficiency

Example: Maintenance costs at high accumulation of dirt / coolant

		HG-NB	HG-B-2G
Lubrication interval		every shift	every 3rd shift
Required time for lubricating		10 Min.	10 Min.
Working days / year		230	230
Required time / year		2.300 Min.	767 Min.
Machine costs / hour		$ 60.–	$ 60.–
Total costs / year		$ 2.300.–	$ 767.–
Profit / year *	**at 1-shift operation**		**$ 1.533.–**
	at 2-shift operation		**$ 3.066.–**
	at 3-shift operation		**$ 4.599.–**

* Additionally the profit is increased by reducing the down time of the machine, as the 2G-chucks also need less disassembling for cleaning.

Clamping glossary

HG-B-2G: **Evolution** of the quick jaw change power chuck HG-NB. The HG-B-2G features additional seals and an improved lubrication system for low maintenance. **The chuck still offers all the same advantages as the HG-NB.**

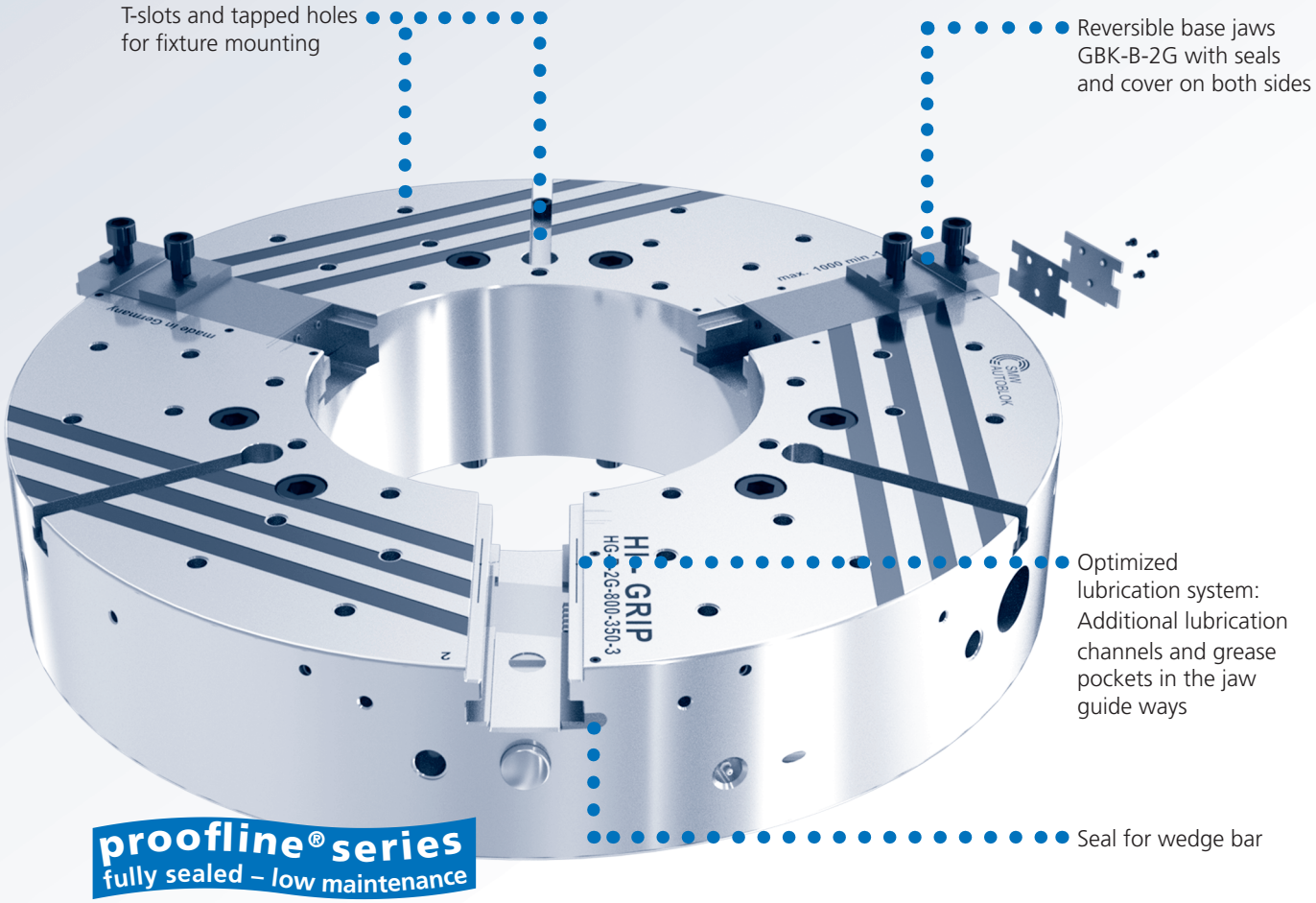
The proven wedge bar drive guarantees unmatched accuracy and rigidity. A low loss of grip force due to centrifugal force makes the chuck ideal for high speed applications.

Sealing: The HG-B-2G is sealed by seals attached to both faces of the base jaws. Also the wedge bars are protected by mechanical seals. The seals **protect the chuck** against penetration of dirt and swarf.

Low Maintenance: **The lubrication system of the HG-B-2G is optimized.** Additional lubrication channels and grease pockets integrated in the jaw guide ways ensure constant clamping force. The lubrication intervals are significantly longer reducing down times and cost for maintenance.

Mass production: The sealing and the new lubrication system make the HG-B-2G also suitable for use on machining centers or turning and milling centers in vertical operation.

Compatibility: The HG-B-2G is interchangeable with the standard series of quick jaw change chucks HG-NB. Existing master jaws still can be used without sealing. A small modification made to the master jaws and a **mounting kit** can upgrade existing master jaws to become 2G master jaws.



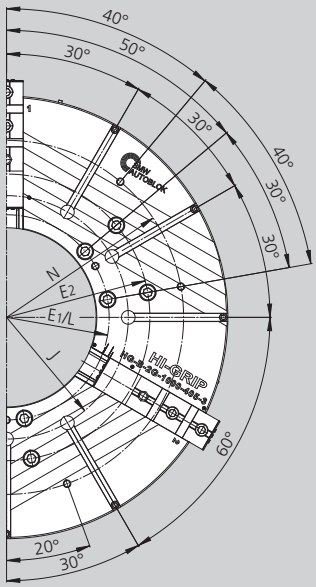
HG-B-2G

QUICK JAW CHANGE
Jaw system original SMW

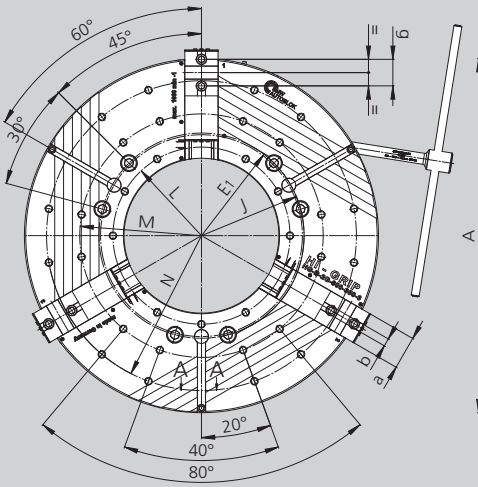
Manual chuck

■ Main dimensions and technical data

HG-B-2G 1000-405

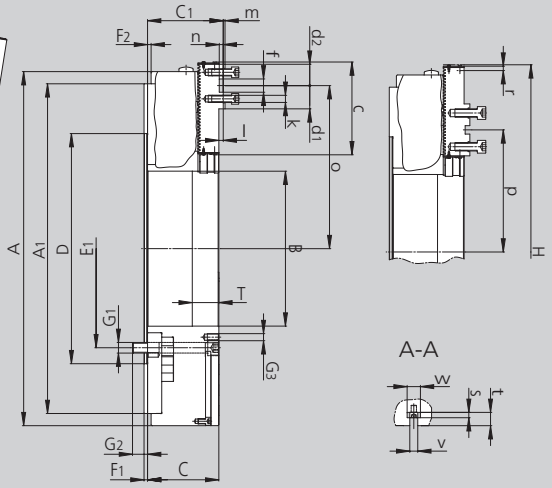


HG-B-2G 800-350



Jaw position: open position for external clamping

Base jaw position »o« **Base jaw position »p«**



Subject to technical changes.
For more detailed information please ask our customer service.

Base jaw position with GBK-B-2G

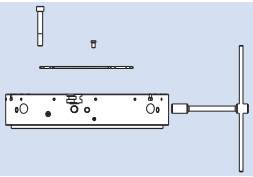
SMW-AUTOBLOK Type		HG-B-2G 800-350	HG-B-2G 1000-405
Mounting	**Size**	**Z520**	**Z720**
	A	800	1000
	A1	745	880
	B	350	405
	C	161	161
	C1	171	171
	D	520	720
	E1	463.6	463.6
	E2	-	647.6
	F1	8	8
	F2	8	8
	G1	M24 (6x)	M24 (12x)
	G2	34	34
Threads front face	**G3**	M16 (33x) / 26	M16 (9x) / 25
Swing dia.	**H**	845	1076
	J	456	550
	L	400	463.6
	M	550	-
	N	700	800
	T	60	60
Base jaw	**-**	GBK-B-2G 630	GBK-B-2G 800
	a	75	75
	b	18	18
	c	209.7	293.4
	d1	52.5	113
	d2	48.25	49
	f	30	30
	g	60	60
	k	M16	M16
	l	10	10
	m	4	4
	n	9	9
Max. / min.	**o**	368.4 / 277.4	478 / 303
Max. / min.	**p**	265.4 / 174.4	353 / 178
Base jaw tooth pitch	**-**	7	7
Base jaw offset	**r**	91	175
Base jaw offset	teeth	13	25
	s	12	12
	t	30	30
H8	**v**	18	18
	w	30	30
Usable jaw stroke	mm	13	13.2
Max. total gripping force	kN	250	250
At max. torque Md	Nm	350	350
Speed	r.p.m.	1000	900
Weight without jaws	kg	475	745
Moment of inertia	kg·m²	45.5	109

Manual chuck

■ Ordering review

HG-B-2G

QUICK JAW CHANGE
Wide master jaws



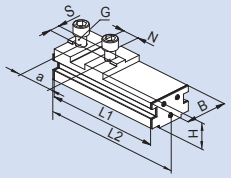
Spindle mounting \ Size	HG-B-2G 800-350	HG-B-2G 1000-405
Centering rim	Z520 162300	Z720 162340

Supply range
Chuck + actuation wrench + mounting bolts + set of coverplates without base jaws

Base jaw type

GBK-B-2G

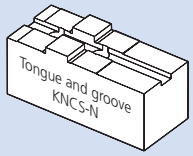
TONGUE & GROOVE KNCS-N standard



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Id. No.	162316	162319
B	75	75
H	57	57
L1	199.5	283.2
L2 *	209.7	293.4
N	30	30 (2x)
S	18	18
G (metric)	M16	M16
a	60	2 x 60

* Dimensions incl. seals, covers and mounting screws

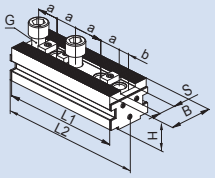
Existing top jaw



Base jaw type

GBK-BD-2G

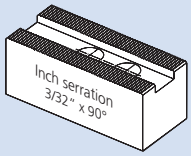
INCH SERRATED (for SMW-AUTOBLOK standard jaws)



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Id. No.	162462	162463
B	75	75
H	61	61
L1	199.5	283.5
L2 *	209.7	293.7
N	3/32" x 90°	3/32" x 90°
S (ridge)	25.5	25.5
G	M20	M20
a	38 / 38 / 52 / 38	38 / 38 / 38 / 60.7 / 38 / 38
b	16.75	16.25

* Dimensions incl. seals, covers and mounting screws

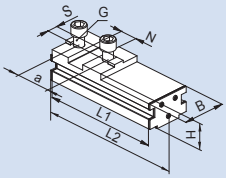
Existing top jaw



Base jaw type

GBK-BA-2G

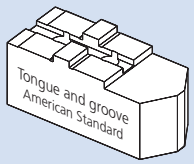
TONGUE & GROOVE American standard



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Id. No.	162315	162349
B	75	75
H	57	57
L1	199.5	283.2
L2 *	209.7	293.4
N	19.02	19.02 (2x)
S	12.7	12.7
G (inch)	3/4 - 10	3/4 - 10
a	76.2	2 x 76.2

* Dimensions incl. seals, covers and mounting screws

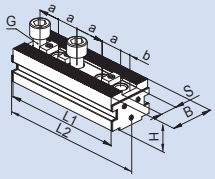
Existing top jaw



Base jaw type

GBK-BM-2G

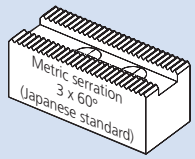
METRIC SERRATION



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Id. No.	162464	162465
B	75	75
H	61	61
L1	199.5	283.5
L2 *	209.7	283.7
N	3 x 60°	3 x 60°
S	25	25
G (metric)	M20	M20
a	60 / 60	60 / 60 / 70.5 / 60
b	16.75	16.75

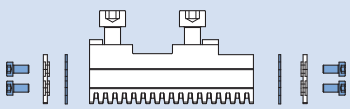
* Dimensions incl. seals, covers and mounting screws

Existing top jaw



Seal Kit

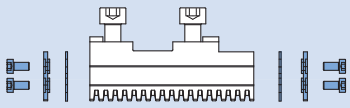
for hardened base jaws GBK-B-2G / GBK-BD-2G / GBK-BA-2G / GBK-BM-2G
Consisting of seals (6 pcs.) and mounting screws (12 pcs.)



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Seal Kit Type	GBK-B-2G 630	GBK-B-2G 800
Id. No.	207673	207673

Mounting Kit

for hardened base jaws GBK-B-2G / GBK-BD-2G / GBK-BA-2G / GBK-BM-2G
Consisting of seals (6 pcs.), covers (6 pcs.) and mounting screws (12 pcs.)



Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Mounting Kit Type	GBK-B-2G 630	GBK-B-2G 800
Id. No.	207674	207674

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 2G master jaws (instruction for the rework on request).