



STANDARD

MANUAL CHUCKS with quick jaw change

for turning and milling

SEALED

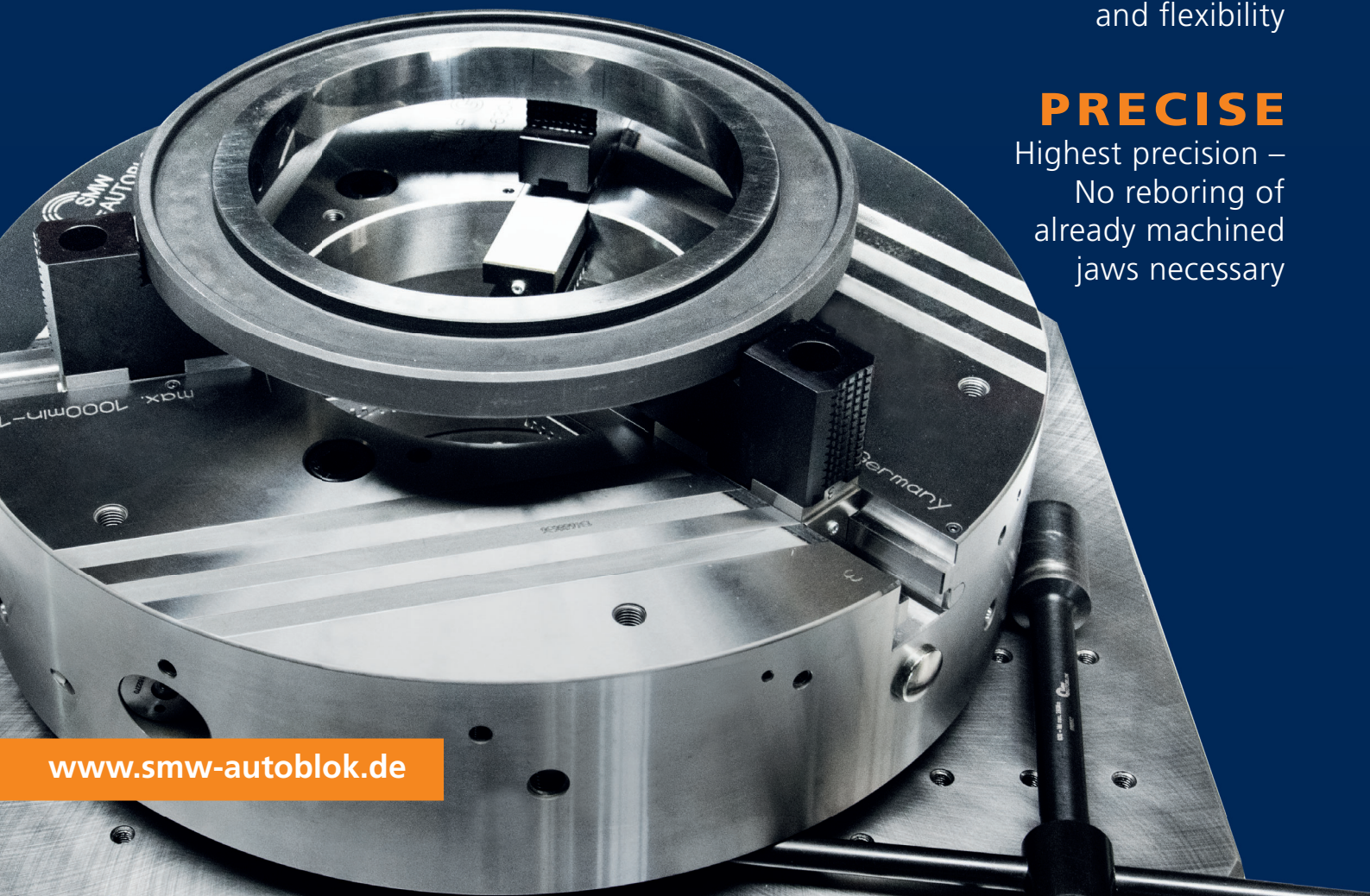
now as 2G-version:
Sealed – low maintenance

EFFICIENT + FLEXIBLE

Minimum set up times
Maximum cost-efficiency
and flexibility

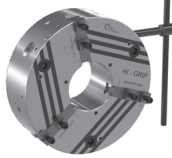
PRECISE

Highest precision –
No re boring of
already machined
jaws necessary



www.smw-autoblok.de

Manual chucks



HG-N

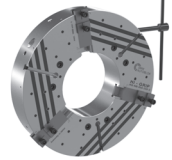
TONGUE & GROOVE
Jaw system original SMW

Manual chucks Ø 160 - 630 mm

- With through-hole – Quick jaw change
- 3 jaws

Page

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HG-NB

TONGUE & GROOVE

Manual chucks Ø 800 - 1000 mm

- With extra large through-hole – Quick jaw change
- All existing top jaws can be used
- 3 jaws

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HG-2G

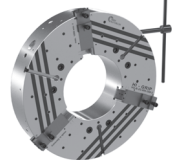
TONGUE & GROOVE

Manual chucks Ø 400 - 630 mm

- With through-hole – Quick jaw change
- 3 jaws
- Lubrication channels in the jaw guide ways
- Mechanic sealed – low maintenance

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HG-B-2G

TONGUE & GROOVE

Manual chucks Ø 800 - 1000 mm

- With extra large through-hole – Quick jaw change
- All existing top jaws can be used
- 3 jaws
- Mechanic sealed – low maintenance

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HG-F

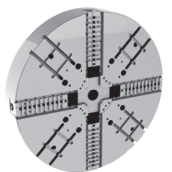
TONGUE & GROOVE
Jaw system FORKARDT

Manual chucks Ø 160 - 400 mm

- With through-hole – Quick jaw change
- 3 jaws

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PTF

TONGUE & GROOVE

Manual clamping and radial setting of jaws

High precision 4 jaws independent manual chucks Ø 1000 - 2000 mm

- Closed center
- 4 jaws

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JBX

Manual jaw box
Standard mounting dimensions

High precision, resistance and power manual jaw box

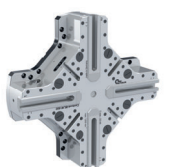
- Accessory for face plates, 4 jaws independent manual or chucks
- Internal or external clamping

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JBX-2G

Manual jaw box
with semi-finished body



Centco4-MLW

INCH
SERRATION

4-jaw chuck
Ø 400 - 1400 mm

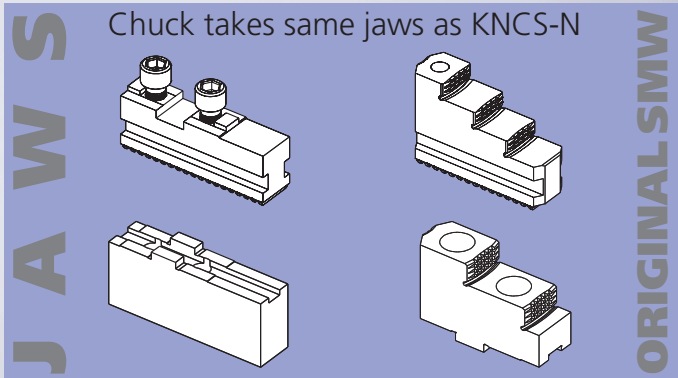
- Independent self centering clamping in 2 axis
- Weight-optimized chuck body
- 4 jaws

Page

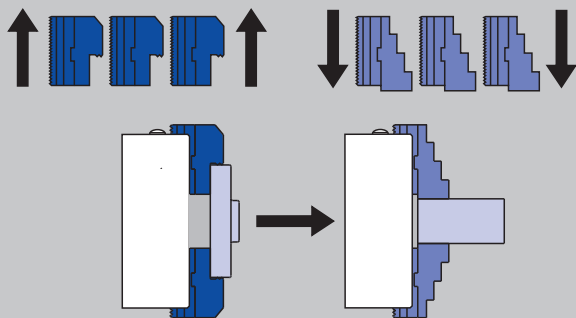
36

Quick jaw change

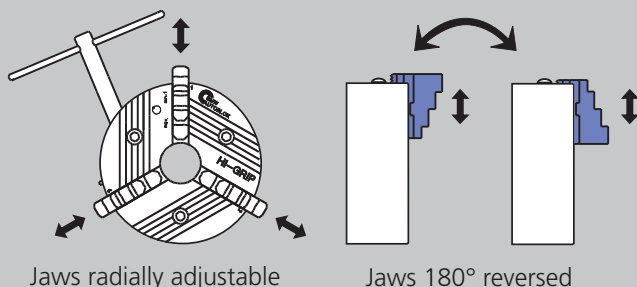
HG-N



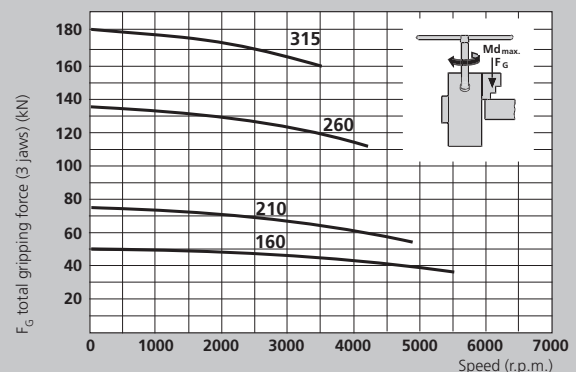
- Jaw change in less than 1 minute



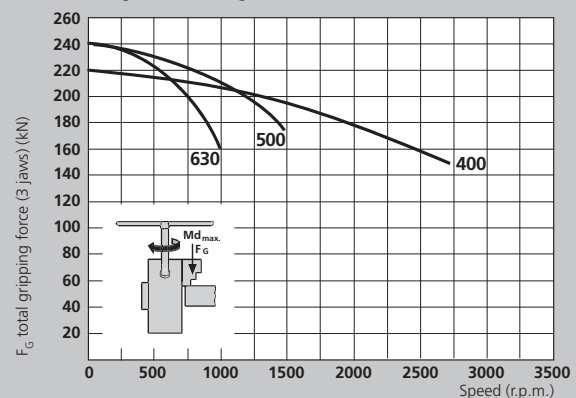
- Universal, because jaws can be radially adjusted and reversed = less jaw sets



Flat gripping force curve for highest speeds



- The max. gripping force is the total, acting on the 3 jaws, obtained by applying to the chuck the max. allowed driving torque. The data refers to a chuck newly maintained accordingly to their service manual, using SMW K05 grease.



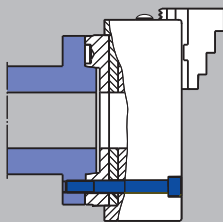
- The dynamic gripping forces have been measured using hardened standard stepped monoblock jaws type GST placed in a position not exceeding the outer diameter of the chuck.

⚠ Safety advice / danger of damage:

When using taller / heavier jaws and / or clamping on a more external position reduce driving torque / rotating speed accordingly.

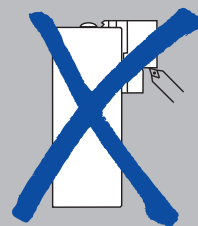
manual chuck HI-GRIP®

Direct mounting



Recess and bolt circle to
DIN 55026 / ISO-A 702/1

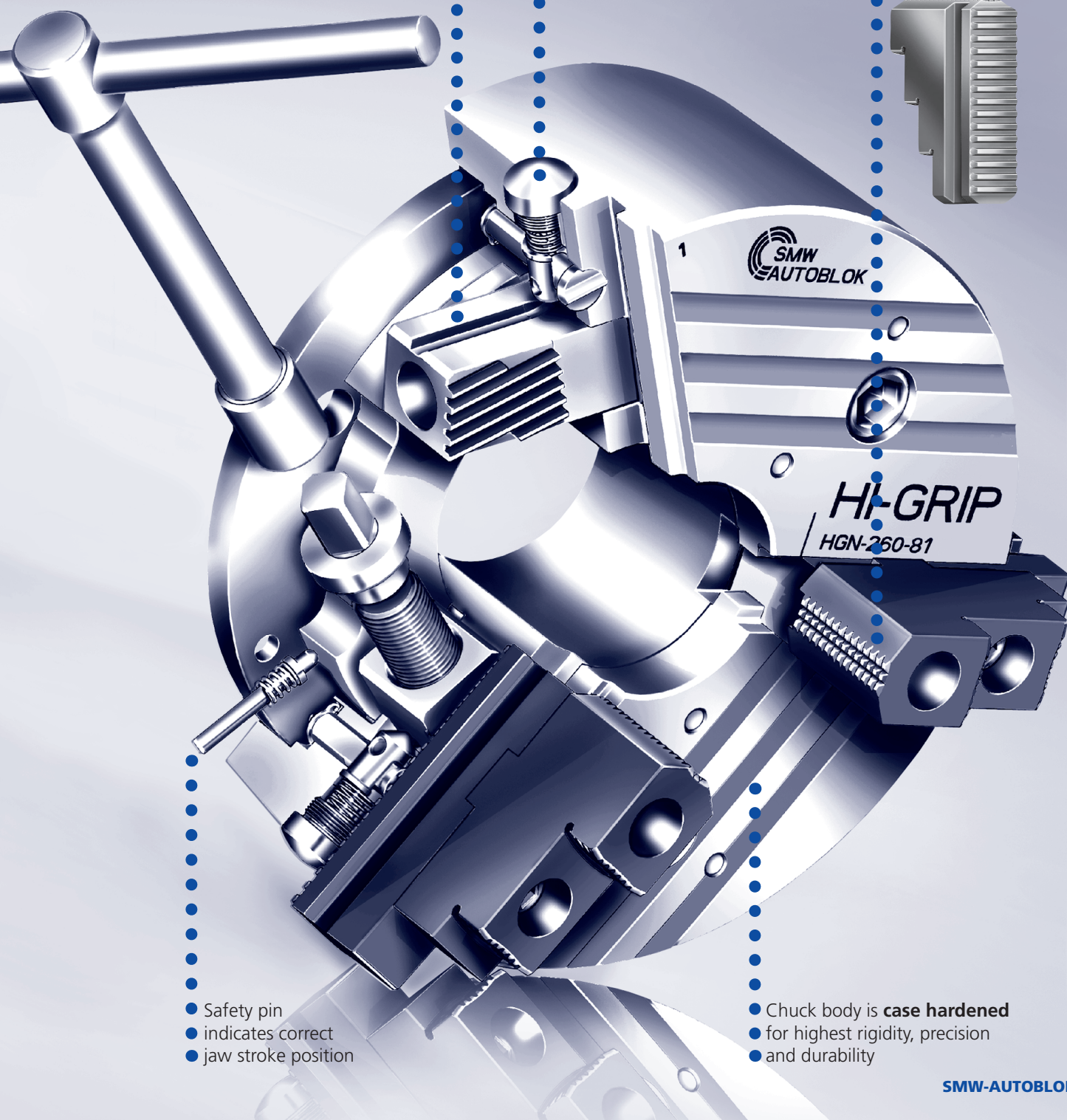
■ No reboring of already machined jaws necessary, because of runout < 0.02 (e.g. HG-N 210)



Wedge bar design
guarantees highest precision,
concentricity and repeatability
as well as highest
gripping forces

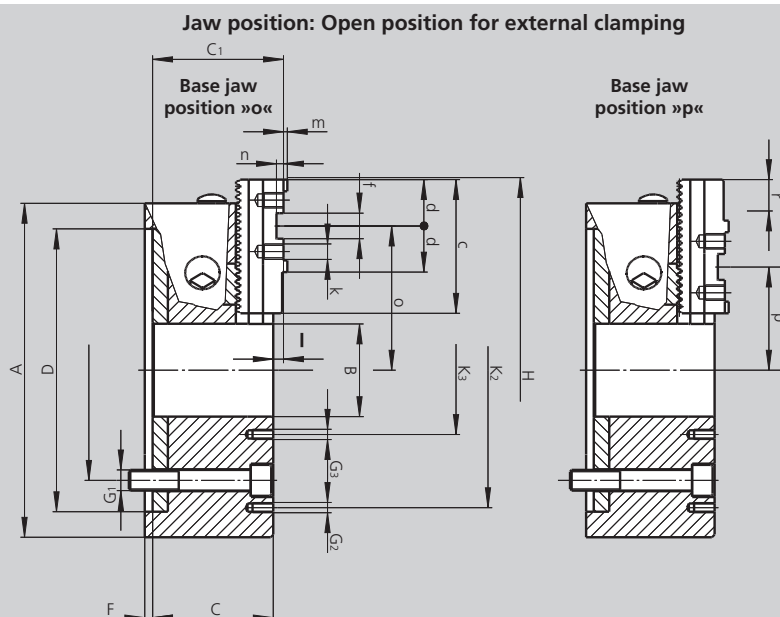
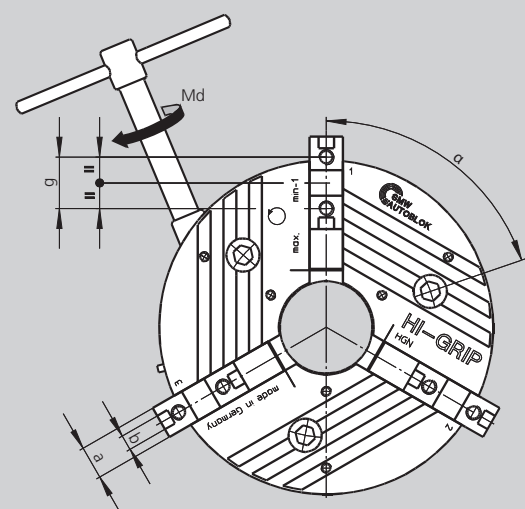
• Safety jaw release
with interlock

• Jaw system SMW



• Safety pin
indicates correct
jaw stroke position

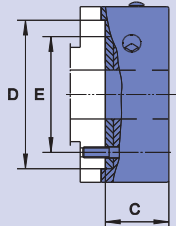
• Chuck body is **case hardened**
for highest rigidity, precision
and durability



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

SMW-AUTOBLOK Type		HG-N 160-46	HG-N 210-60	HG-N 260-81	HG-N 315-102	HG-N 400-128	HG-N 500-165	HG-N 630-254
Mounting	Size	Z140	Z170	Z220	Z300	Z380	Z380	Z380
H6	A	165	210	260	315	400	500	630
	B	46	60	81	102	128	165	254
	C	64	85.5	93.7	110.8	125	136	143
	C1	71	90.4	102	120.1	134.3	146	153
	D	140	170	220	300	380	380	380
	E	104.8	133.4	171.4	235	330.2	330.2	330.2
	F	5	6	6	6	6	8	8
	G1	M10	M12	M16	M20	M24	M24	M24
	G2	-	M10 / 3 x 120°	M10 / 3 x 120°	M10 / 3 x 120°	M12 / 3 x 120°	M16 / 9 x 40°	M16 / 6 x 60°
	G3	M5 / 3 x 120°	M6 / 3 x 120°	M8 / 3 x 120°	M10 / 3 x 120°	M12 / 3 x 120°	M12 / 3 x 120°	M12 / 3 x 120°
Swing dia.	H	194	244	300	358	426	530	685
	K2	-	168	210	268	330	420	550
	K3	75	75	95	120	152	195	290
	α	76°	74°	71°	71°	71°	71°	74°
	β	-	60°	60°	60°	60°	20°	30°
Master jaw		GBK 160	GBK 200	GBK 250	GBK 315	GBK 400	GBK 500	GBK 630
f7	a	20	22	26	32	32	45	45
	b	8	10	12	12	12	18	18
	c	65	85	104	115	125	160	200
	d	28	33	36	36	43	50	50
H7	f	18	20	20	20 (26)	26	30	30
	g	32	40	40	40 (54)	54	60	60
Thread / thread depth		k	M8 / 12	M8 / 13	M12 / 15	M12 / 17	M16 / 34	M16 / 34
	l	6	4.9	8.3	9.3	9.3	10	10
	m	2.5	2.5	3	3	3	4	4
	n	5	4.5	5.5	6	7	9	9
Max. / min.	o	68.5 / 49.5	88 / 64.5	112.4 / 79.4	141.3 / 102.8	168.8 / 113.8	211 / 141	291.5 / 200.5
Max. / min.	p	59.3 / 40.5	69 / 45.5	80.6 / 47.6	98.3 / 59.8	129.8 / 74.8	150 / 80	191.5 / 100.5
Base jaw tooth pitch		-	4.7	4.7	5.5	5.5	7	7
Master jaw offset		r	18.8	23.5	33	38.5	55	70
Master jaw offset		teeth	4	5	6	7	10	13
Usable jaw stroke		mm	5.9	6.4	7.4	9.6	11.4	11.5
Max. total gripping force		kN	60	75	130	180	220	250
At max. torque Md		Nm	80	120	160	200	250	260
Speed		r.p.m.	5500	4800	4200	3500	2700	1500
Weight without jaws		kg	8.3	19	32	53	103	161
Moment of inertia		kg·m²	0.03	0.09	0.25	0.60	1.9	4.5

Chuck with center mounting DIN 6350



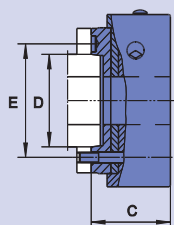
Chuck	HG-N 160-46	HG-N 210-60	HG-N 260-81	HG-N 315-102	HG-N 400-128	HG-N 500-165	HG-N 630-254
Mounting	Z140	Z170	Z220	Z300	Z380	Z380	Z380
C	81	85.5	94	111	125	136	136
D	140	170	220	300	380	380	380
E	104.8	133.4	171.4	235	330.2	330.2	330.2

Chuck with GBK + WAK							
Id. No.	089310	089538	089550	089562	089574	089584	089708

Chuck with GST							
Id. No.	089312	089313	089317	089321	089325	089328	089709

Chuck with GBK + GUA							
Id. No.	089331	089539	089551	089563	089575	089585	089710

Chuck with ISO-A mounting DIN 55026



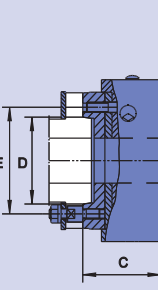
Chuck	HG-N 160-46		HG-N 210-60			HG-N 260-81		HG-N 315-102		HG-N 400-128		HG-N 500-165		HG-N 630-254	
Mounting	A4	A5	A5	A6	A8	A6	A8	A8	A11	A11	A15	A11	A15	A11	A15
C	101	101	109.5	107.5	125.5	118	119	141	141	165	161	176	172	176	172
D	63.52	82.57	82.57	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77	196.88	285.77	196.88	285.77
E	82.6	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2	235.0	330.2	235.0	330.2

Chuck with GBK + WAK															
Id. No.	089332	089342	090458	089540	089542	089552	089554	089564	089566	089576	089578	089586	089588	089711	089713

Chuck with GST															
Id. No.	089962	089346	090459	089314	089315	089318	089319	089322	089323	089326	089327	089329	089330	089715	089732

Chuck with GBK + GUA															
Id. No.	089427	089434	090460	089541	089543	089553	089555	089565	089567	089577	089579	089587	089589	089749	089760

Chuck with bayonet mounting DIN 55027 Type C

	Chuck	HG-N 160-46		HG-N 210-60			HG-N 260-81		HG-N 315-102		HG-N 400-128		HG-N 500-165		HG-N 630-254	
	Mounting	C4	C5	C5	C6	C8	C6	C8	C8	C11	C11	C15	C11	C15	C11	C15
	C	101	101	107.5	107.5	125.5	119	119	141	141	161	161	172	172	172	172
	D	63.52	82.57	82.57	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77	196.88	285.77	196.88	285.77
	E	85	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2	235.0	330.2	235.0	330.2
	Chuck with GBK + WAK															
	Id. No.	089464	089487	090461	089544	089546	089556	089558	089568	089570	089580	089582	089590	089592	089761	089762
	Chuck with GST															
	Id. No.	089488	089489	090462	089478	089479	089480	089476	089481	089482	089483	089484	089485	089486	089765	089766
	Chuck with GBK + GUA															
	Id. No.	089518	089519	090463	089545	089547	089557	089559	089569	089571	089581	089583	089591	089593	089786	089802

Chuck with Camlock mounting DIN 55029 Type S

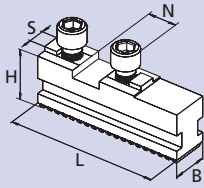
		Chuck	HG-N 160-46		HG-N 210-60		HG-N 260-81		HG-N 315-102		HG-N 400-128		HG-N 500-165		HG-N 630-254		
		Mounting	S4	S5	S5	S6	S8	S6	S8	S8	S11	S11	S15	S11	S15	S11	S15
		C	109	109	118.5	118.5	125.5	132	132	154	154	175	175	186	186	186	186
		D	63.52	82.57	82.57	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77	196.88	285.77	196.88	285.77
		E	82.6	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2	235.0	330.2	235.0	330.2
		Chuck with GBK + WAK															
		Id. No.	089520	089528	090464	089901	089905	089909	089913	089917	089921	089925	089929	089933	089937	089803	089832
		Chuck with GST															
		Id. No.	089602	089663	089996	089899	089903	089907	089911	089915	089919	089923	089927	089931	089935	089843	089897
		Chuck with GBK + GUA															
		Id. No.	089668	089674	090466	089902	089906	089910	089914	089918	089922	089926	089930	089934	089938	089942	089955

Parts included: Fixing elements (screws resp. studs resp. camlock bolts).

QUICK JAW CHANGE

GBK

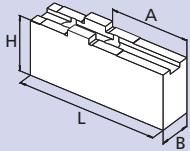
Hardened base jaws



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	GBK 160	GBK 200	GBK 250	GBK 315	GBK 400	GBK 500	GBK 630
Id. No.	012439	012440	012441	012442	012443	012444	012445
B	20	22	26	32	32	45	45
H	27.5	29.5	37	43	43	57	57
L	65	85	104	115	125	160	200
N	18	20	20	20	26	30	30
S	8	10	12	12	12	18	18
kg / set	0.7	1.0	1.8	2.7	3.0	7.1	9.0

WAK

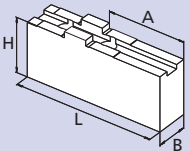
Soft top jaws



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	WAK 160-10	WAK 200-10	WAK 250-10	WAK 250-10	WAK 400-10	WAK 500-10	WAK 500-10
Id. No.	012491	012492	012493	012493	012494	012495	012495
B	20	22	30	30	35	50	50
H	35.5	42	50	50	54	73	73
L	85	105	125	125	145	180	180
A	42	50	70	70	74	100	100
kg / set	1.2	2.0	3.6	3.6	5.8	13.7	13.7

WAKS

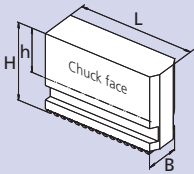
Wide soft top jaws



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	WAKS 140-10	WAKS 200-30	WAKS 250-20	WAKS 250-30	WAKS 400-30	WAKS 500-30	WAKS 500-30
Id. No.	012496	012497	012498	012499	012500	012501	012501
B	35	40	60	80	80	90	90
H	35.5	36	55	55	64	73	73
L	63	70	90	90	100	130	130
A	25	27	44	44	44	65	65
kg / set	1.5	1.9	6.2	8.5	11.0	16.4	16.4

UVB

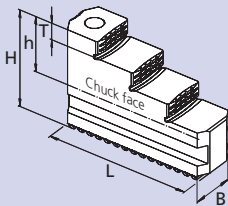
Soft monoblock jaws



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	UVB 160	UVB 200	UVB 250	UVB 315	UVB 400	UVB 500	UVB 630
Id. No.	012447	012448	012449	012450	012451	012452	012453
B	20	22	26	32	32	45	45
H	60	70	90	100	100	134	134
h	39.4	45	61	66	66	87	87
L	69	83	108	119	146.5	175	230
kg / set	1.8	2.8	5.5	8.2	10	23	30

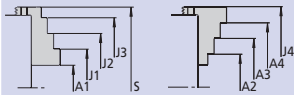
GST

Hardened stepped monoblock jaws



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	GST 170	GST 210	GST 260	GST 315	GST 400	GST 500	GST 500
Id. No.	035867	035863	037623	012457	012458	012459	012459
B	20	22	26	32	32	45	45
H	43.5	51	60	66	70	93	93
h	22	26	31.3	32	36	46	46
L	67	84	100	116.2	136.4	175	175
T	7	8	10	10	11	20	20
kg / set	0.82	1.4	2.23	3.48	4.4	11.47	11.47
A1	6-59	10-96	10-98	20-115	53-173	65-195	153-313
A2	42-89	56-130	62-150	85-180	116-238	160-285	241-401
A3	73-120	96-170	111-200	140-235	184-308	310-435	391-551
A4	104-151	136-210	161-250	195-290	252-378	-	-
J1	44-78	70-147	63-149	80-170	118-243	-	-
J2	74-110	109-187	112-199	135-225	186-310	170-295	254-414
J3	105-141	149-228	161-249	190-282	253-378	320-445	404-564
J4	135-182	186-260	212-300	255-350	328-448	-	-
S	198	244	303	350	456	540	660

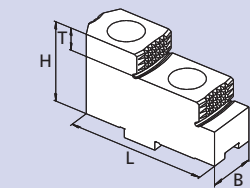
Clamping ranges



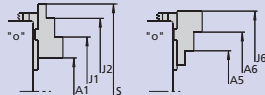
JAWS-CATALOG

Request or
download:
www.smw-autoblok.de

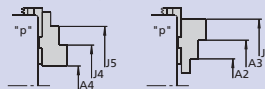


GUA**Hardened reversible stepped top jaws****Clamping ranges**

Base jaw position "o"



Base jaw position "p"



Chuck	HG-N 160	HG-N 210	HG-N 260	HG-N 315	HG-N 400	HG-N 500	HG-N 630
Jaw type	GUA 160	GUA 200	GUA 250	GUA 250	GUA 400	GUA 500	GUA 500
Id. No.	012484	012485	012486	012486	012487	012488	012488
B	20	22	30	30	36	45	45
H	36.5	38	50	50	56	70	70
L	63	72	90	90	105	130	130
T	7.5	10	14	14	15	20	20
kg / set	0.6	0.8	1.9	1.9	3.2	10.8	10.8
A1	32-69	55-111	73-161	120-205	138-258	150-308	265-469
A2	60-98	69-125	45-101	48-120	78-188	37-181	58-262
A3	85-123	96-152	125-181	130-200	186-298	144-302	179-383
A4	13-51	17-73	20-97	36-188	60-183	33-191	65-269
A5	78-116	104-163	76-165	120-205	143-268	143-301	258-462
A6	103-141	131-190	156-245	205-285	253-378	264-422	379-583
J1	91-129	117-174	152-240	202-285	218-338	259-417	374-578
J2	116-154	144-201	233-321	280-365	328-448	380-538	495-699
J3	144-181	158-215	204-259	208-280	263-380	253-411	288-492
J4	74-111	80-136	101-177	110-200	138-263	139-297	174-378
J5	99-136	107-163	180-257	198-280	248-373	260-418	295-499
J6	162-200	193-253	235-323	276-365	333-458	373-531	488-692
S	198	196-253/255	333	390	-	570	732

JAWS-CATALOG

Request or
download:
www.smw-autoblok.de

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. 016440Can 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)****Lubrication set Id. No. 083726**

Supply range

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

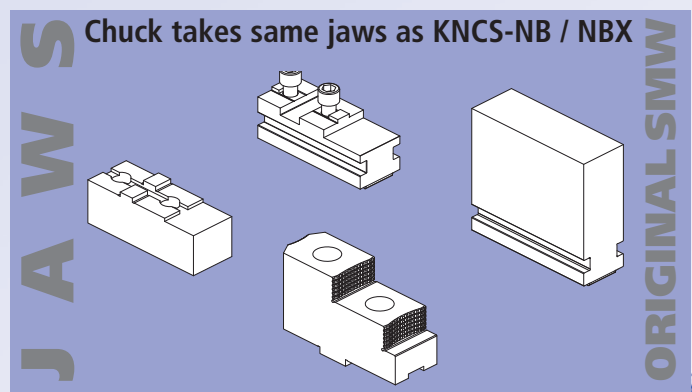
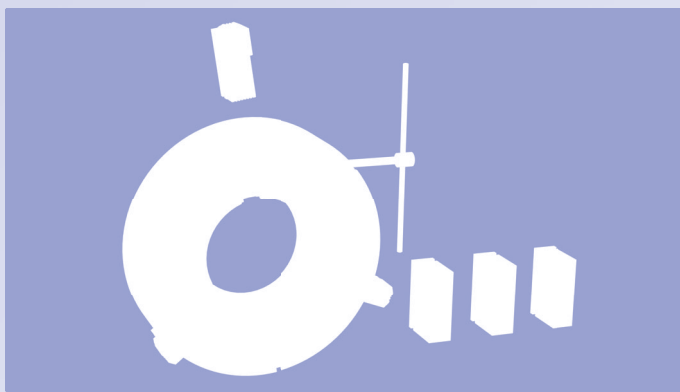
Fast changeover, fast payback:

The original quick jaw change manual chuck

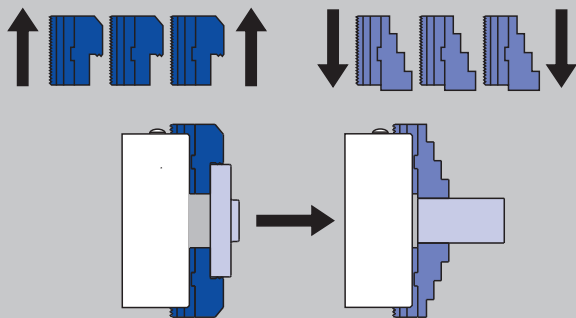
HG-NB

EXTRA LARGE
THROUGH-HOLE

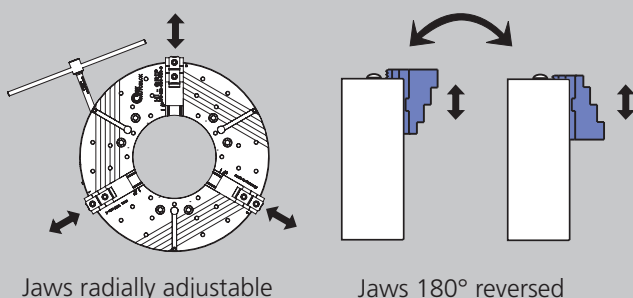
► ALL EXISTING TOP JAWS CAN BE USED



- Jaw change in less than 1 minute



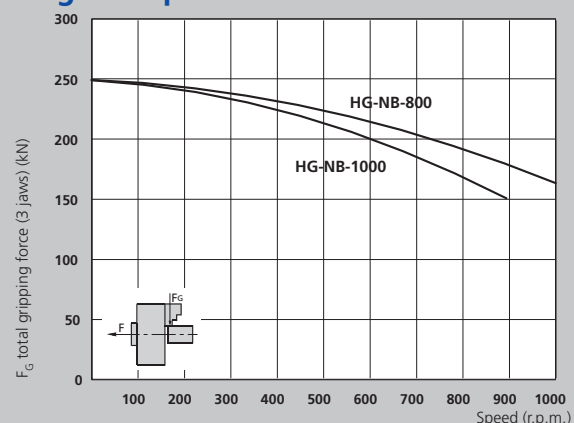
- Universal, because jaws can be radially adjusted and reversed = less jaw sets



Jaws radially adjustable

Jaws 180° reversed

Flat gripping force curve for highest speeds



- The max. gripping force is the total, acting on the 3 jaws, obtained by applying to the chuck the max. allowed driving torque. The data refers to a chuck newly maintained according to their service manual, using SMW K05 grease.
- The dynamic gripping forces have been measured using hardened standard stepped monoblock jaws placed in a position not exceeding the outer diameter of the chuck.

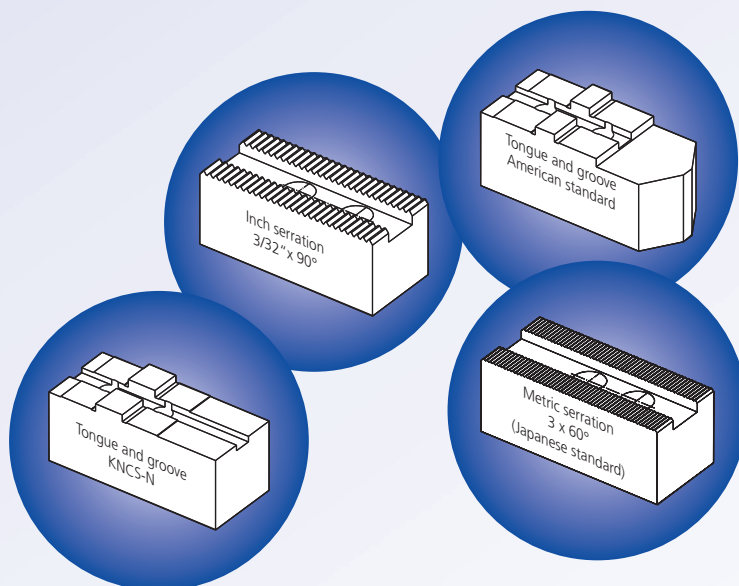
⚠ Safety advice / danger of damage:

When using taller / heavier jaws and / or clamping on a more external position reduce driving torque / rotating speed accordingly.

Less costs by using all existing top jaws from:

- SMW-AUTOBLOK
- Autoblok
- Buck
- Forkardt
- Gamet
- Howa
- Kitagawa
- Logansport
- Mario Pinto
- Matsumoto
- Pratt Burnerd
- Röhmm
- Rotomors
- Schunk
- Berg
- Woodworth

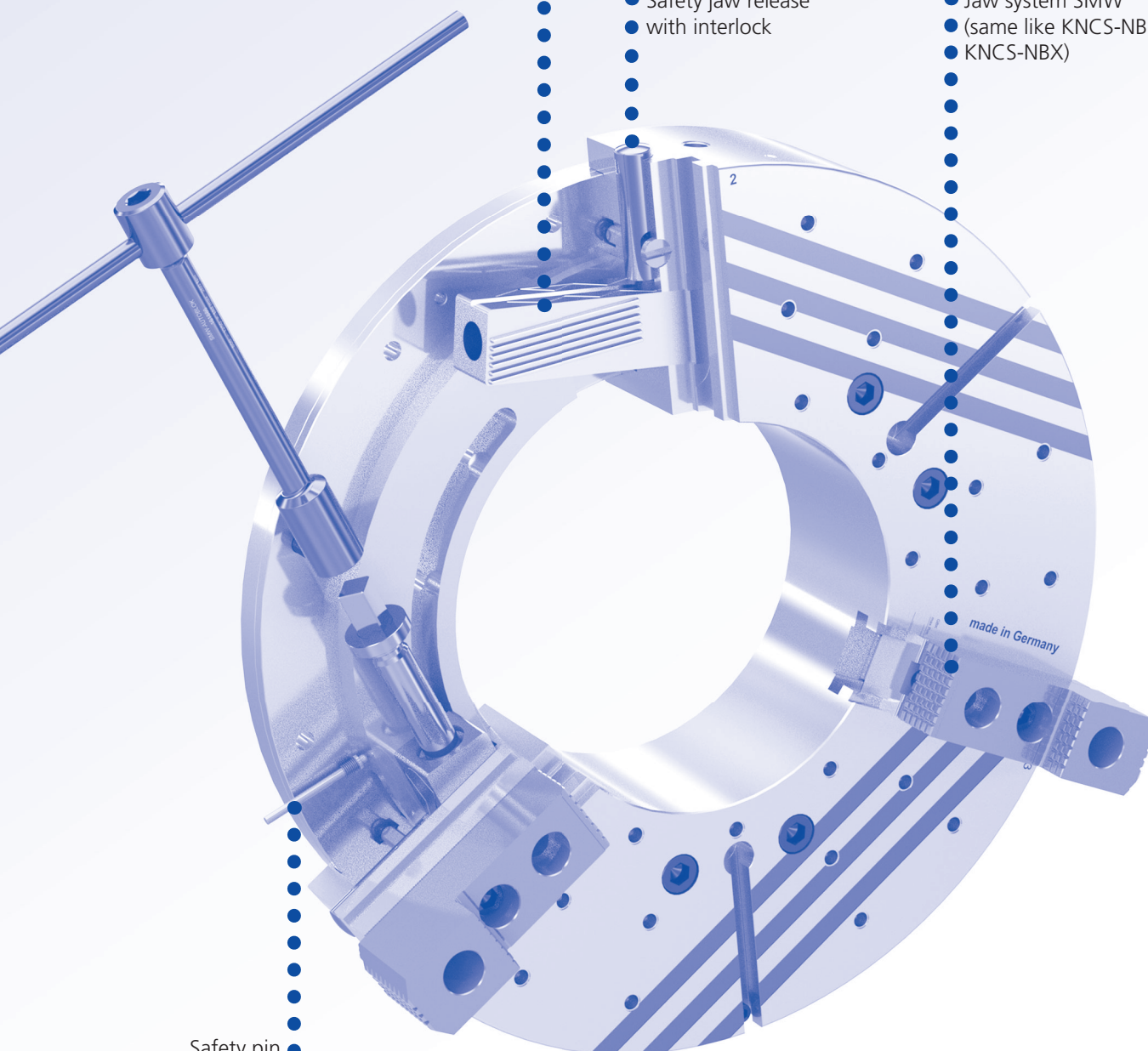
If your jaw type is not included, please contact us.



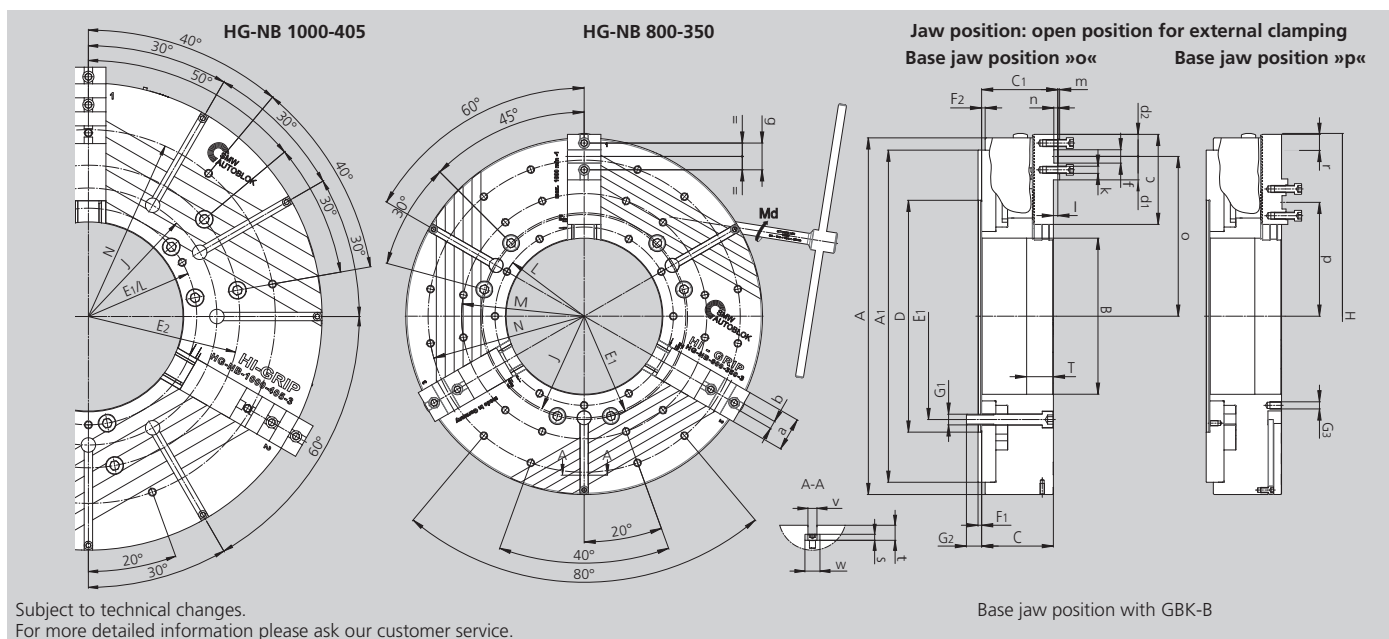
Wedge bar design
guarantees highest precision,
concentricity and repeatability
as well as highest
gripping forces

● Safety jaw release
● with interlock

● Jaw system SMW
● (same like KNCS-NB /
● KNCS-NBX)

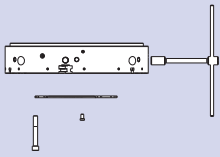


● Safety pin
● indicates correct
● jaw stroke position



SMW-AUTOBLOK Type		HG-NB 800-350	HG-NB 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	839	1070
	J	456	550
	L	400	463.6
	M	550	-
	N	700	800
	T	60	60
Base jaw	-	GBK-B 630	GBK-B 800
	a	75	75
	b	18	18
	c	202	286
	d1	52.5	113
	d2	49.5	50.5
	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	293 / 118
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	260	260
Speed	r.p.m.	1000	900
Weight without jaws	kg	475	745
Moment of inertia	kg·m²	45.5	109

Ordering review



Size	Spindle mounting
Centering rim	

HG-NB 800-350
Z520
161880

HG-NB 1000-405
Z720
161910

Supply range

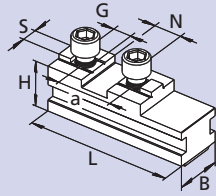
Chuck + actuation wrench + mounting bolts + 1 set of coverplates without base jaws

Base jaw type

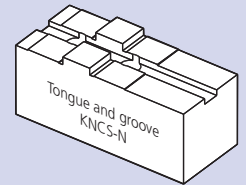
GBK-B

TONGUE & GROOVE KNCS-N standard

Existing top jaw



Chuck	HG-NB 800-350	HG-NB 1000-405
Id. No.	035902	064604
B	75	75
H	57	57
L	202	286
N	30	30 (2x)
S	18	18
G (metric)	M16	M16
a	60	2 x 60

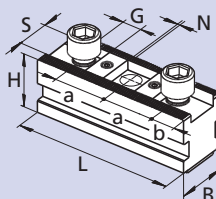


Base jaw type

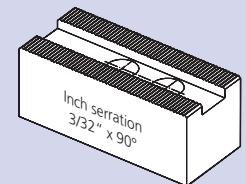
GBK-BD

INCH SERRATED (for SMW-AUTOBLOK standard jaws)

Existing top jaw



Chuck	HG-NB 800-350	HG-NB 1000-405
Id. No.	036295	036296
B	75	75
H	61	61
L	202	286
N	3/32" x 90°	3/32" x 90°
S (ridge)	25.5	25.5
G	M20	M20
a	38 / 38 / 52 / 38	3x38 / 60.7 / 2x38
b	18	17.5

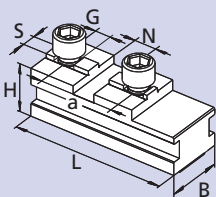


Base jaw type

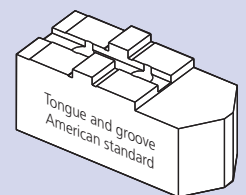
GBK-BA

TONGUE & GROOVE American standard

Existing top jaw



Chuck	HG-NB 800-350	HG-NB 1000-405
Id. No.	060562	064590
B	75	75
H	57	57
L	202	286
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

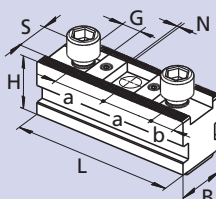


Base jaw type

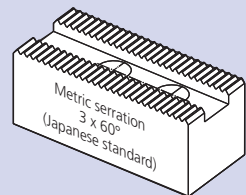
GBK-BM

METRIC SERRATION

Existing top jaw



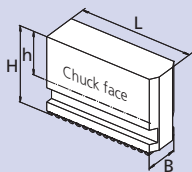
Chuck	HG-NB 800-350	HG-NB 1000-405
Id. No.	035917	036708
B	75	75
H	61	61
L	202	286
N	3 x 60°	3 x 60°
S	25	25
G (metric)	M20	M20
a	2 x 60	60 / 60 / 70.5 / 60
b	18	17.5



Jaw type

UVB-B

Soft wide monoblock jaws



Chuck	HG-NB 800/1000
Jaw type	UVB-B 630
Id. No.	5301060
B	75
H	160
h	105
L	230
kg / set	61.5

JAWS-CATALOG

Request or download:
www.smw-autoblok.de



NEW GENERATION

The sealed quick jaw change manual chuck

HG-2G

► ALL EXISTING TOP JAWS CAN BE USED

Customer Benefits

	HG-N	HG-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-N	HG-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 *		€ 1.533.–
	at 1-shift operation	€ 3.066.–
	at 2-shift operation	€ 4.599.–
	at 3-shift operation	

* 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-2G: Evolution of the quick jaw change power chuck HG-N.

The HG-2G features additional seals and an improved lubrication system for low maintenance. **The chuck still offers all the same advantages as the HG-N.**

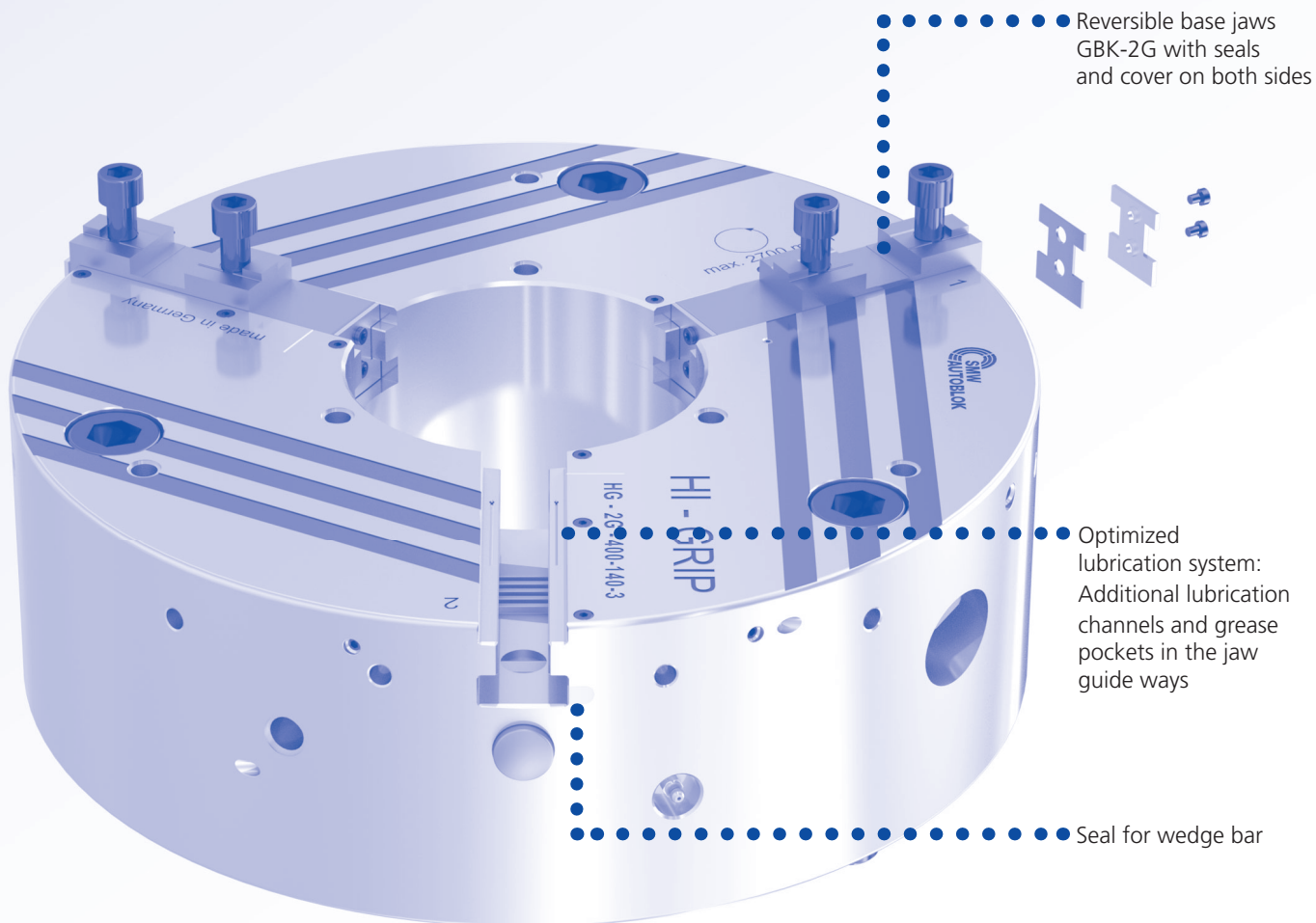
The proven wedge bar drive guarantees unmatched accuracy and rigidity. A low loss of grip force due to centrifugal force makes the chuck ideal for high speed applications.

Sealing: The HG-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-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-2G also suitable for use on machining centers or turning and milling centers in vertical operation.

Compatibility: The HG-2G is interchangeable with the standard series of quick jaw change chucks HG-N. 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.

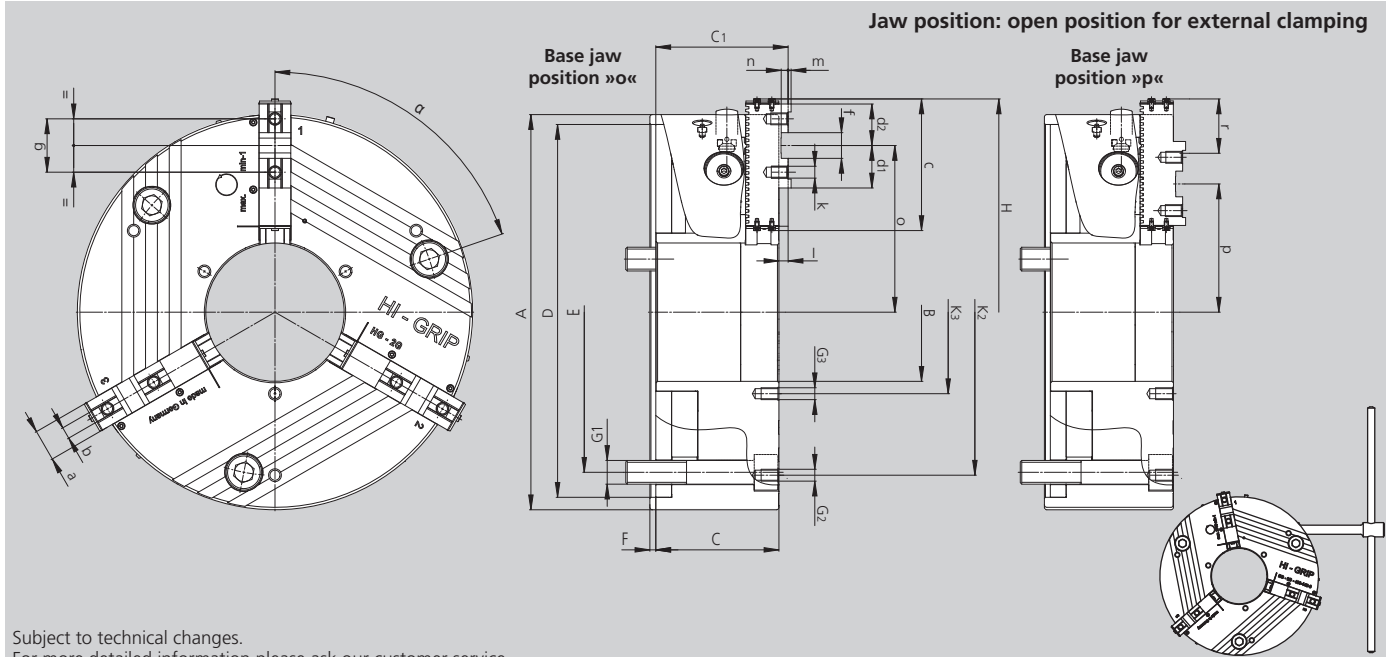


HG-2G

QUICK JAW CHANGE
Jaw system original SMW

Manual chuck Ø 400 - 630 mm

Main dimensions and technical data

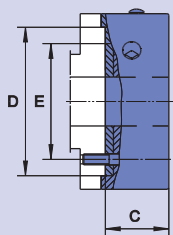


Subject to technical changes.
For more detailed information please ask our customer service.

SMW-AUTOBLOK Type		HG-2G 400-140	HG-2G 500-165	HG-2G 630-254
Mounting	Size	Z380	Z380	Z380
H6	A	400	500	630
	B	140	165	254
	C	124.6	136	143
	C1	133.9	146	153
	D	380	380	380
	E	330.2	330.2	330.2
	F	6	8	8
	G1	M24	M24	M24
	G2	M12 / 3 x 120°	M16 / 9 x 40°	M16 / 6 x 60°
	G3	M12 / 3 x 120°	M12 / 3 x 120°	M12 / 3 x 120°
Swing dia.	H	432	on request	on request
	K2	330	420	550
	K3	165	195	290
	α	71°	71°	74°
Master jaw		GBK-2G 400	GBK-2G 500	GBK-2G 630
	a	32	45	45
	b	12	18	18
	c	133.2	167.7	209.7
	d1	43	53	53
	d2	42	48.25	49.7
	f	26	30	30
	g	54	60	60
	k	M12 / 17	M16 / 34	M16 / 34
	l	9.3	10	10
Thread / thread depth	m	3	4	4
	n	7	9	9
	o	168.8 / 113.8	211 / 141	291.5 / 200.5
	p	129.8 / 74.8	150 / 80	191.5 / 100.5
	-	5.5	7	7
	r	55	70	91
	teeth	10	10	13
Usable jaw stroke	mm	8.5	11.5	13
Max. total gripping force	kN	220	250	250
At max. torque Md	Nm	250	260	260
Speed	r.p.m.	2700	1500	1000
Weight without jaws	kg	99	161	270
Moment of inertia	kg·m²	1.9	4.5	12

Further sizes on request.

Chuck with center mounting DIN 6350



Chuck	HG-2G 400-140	HG-2G 500-165	HG-2G 630-254
Mounting	Z380	Z380	Z380
C	125	136	136
D	380	380	380
E	330.2	330.2	330.2



Chuck with GBK-2G + WAK

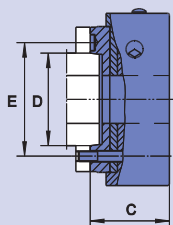
Id. No.	161729	161813	161827
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Chuck with GBK-2G + GUA

Id. No.	161800	161814	161828
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Chuck with ISO-A mounting DIN 55026



Chuck	HG-2G 400-140		HG-2G 500-165		HG-2G 630-254	
Mounting	A11	A15	A11	A15	A11	A15
C	165	161	176	172	176	172
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2



Chuck with GBK-2G + WAK

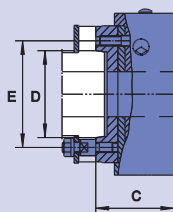
Id. No.	161801	161807	161815	161821	161829	161835
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Chuck with GBK-2G + GUA

Id. No.	161802	161808	161816	161822	161830	161836
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Chuck with bayonet mounting DIN 55027 Type C



Chuck	HG-2G 400-140		HG-2G 500-165		HG-2G 630-254	
Mounting	C11	C15	C11	C15	C11	C15
C	161	161	172	172	172	172
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2



Chuck with GBK-2G + WAK

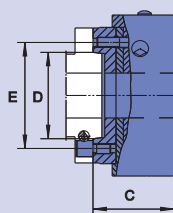
Id. No.	161803	161809	161817	161823	161831	161837
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Chuck with GBK-2G + GUA

Id. No.	161804	161810	161818	161824	161832	161838
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Chuck with Camlock mounting DIN 55029 Type S



Chuck	HG-2G 400-140		HG-2G 500-165		HG-2G 630-254	
Mounting	S11	S15	S11	S15	S11	S15
C	175	175	186	186	186	186
D	196.88	285.77	196.88	285.77	196.88	285.77
E	235.0	330.2	235.0	330.2	235.0	330.2



Chuck with GBK-2G + WAK

Id. No.	161805	161811	161819	161825	161833	161839
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Chuck with GBK-2G + GUA

Id. No.	161806	161812	161820	161826	161834	161840
---------	--------	--------	--------	--------	--------	--------

Parts included: Fixing elements (screws resp. studs resp. camlock bolts).
Further sizes on request.

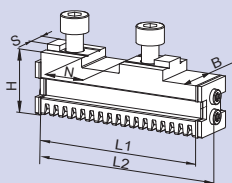
HG-2G

Jaws

QUICK JAW CHANGE

GBK-2G

Hardened base jaws

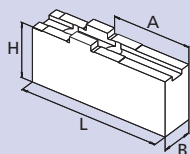


Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	161605	161843	161846
B	32	45	45
H	43	57	57
L1	123	158	198
L2 *	133.2	168.2	208.2
N	26	30	30
S	12	18	18
kg / set	3.0	7.1	9.0

* Dimension incl. seals, cover and screws

WAK

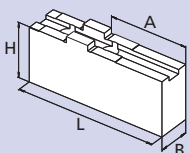
Soft top jaws



Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	WAK 400-10	WAK 500-10	WAK 500-10
Id. No.	012494	012495	012495
B	35	50	50
H	54	73	73
L	145	180	180
A	74	100	100
kg / set	5.8	13.7	13.7

WAKS

Wide soft top jaws

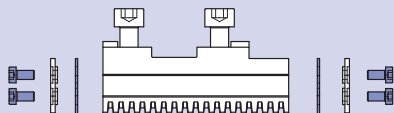


Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	WAKS 400-30	WAKS 500-30	WAKS 500-30
Id. No.	012500	012501	012501
B	80	90	90
H	64	73	73
L	100	130	130
A	44	65	65
kg / set	11.0	16.4	16.4

Seal Kit

for hardened base jaws GBK-2G

Consisting of seals (6 pcs.)
and mounting screws (12 pcs.)

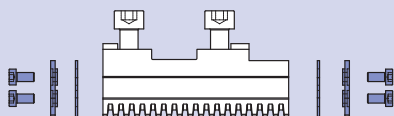


HG-2G	400	500	630
Seal kit type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	205385	206915	206915

Mounting Kit

for hardened base jaws GBK-2G

Consisting of seals (6 pcs.), covers (6 pcs.)
and mounting screws (12 pcs.)



HG-2G	400	500	630
Mounting kit type	GBK-2G 400	GBK-2G 500	GBK-2G 630
Id. No.	205389	206916	206916

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).

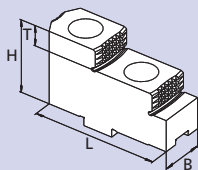
JAWS-CATALOG

Request or
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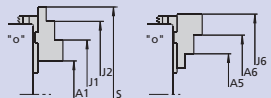


GUA

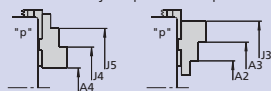
Hardened reversible stepped top jaws

**Clamping ranges**

Base jaw position "o"



Base jaw position "p"



Chuck	HG-2G 400	HG-2G 500	HG-2G 630
Jaw type	GUA 400	GUA 500	GUA 500
Id. No.	012487	012488	012488
B	36	45	45
H	56	70	70
L	105	130	130
T	15	20	20
kg / set	3.2	10.8	10.8
A1	138-258	150-308	265-469
A2	78-188	37-181	58-262
A3	186-298	144-302	179-383
A4	60-183	33-191	65-269
A5	143-268	143-301	258-462
A6	253-378	264-422	379-583
J1	218-338	259-417	374-578
J2	328-448	380-538	495-699
J3	263-380	253-411	288-492
J4	138-263	139-297	174-378
J5	248-373	260-418	295-499
J6	333-458	373-531	488-692
S	-	570	732

JAWS-CATALOG

Request or
download:
www.smw-autoblok.de

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

Grease K05®Special grease for
manual and power chucksCartridge 14 Oz. (DIN 1284)
Grease content 500 g
Id. No. 016440Can 1000 g
Id. No. 011881

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

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

Lubrication set Id. No. 083726

Supply range

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

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 *		€ 1.533.–
	at 1-shift operation	€ 3.066.–
	at 2-shift operation	€ 4.599.–
	at 3-shift operation	

* 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.**

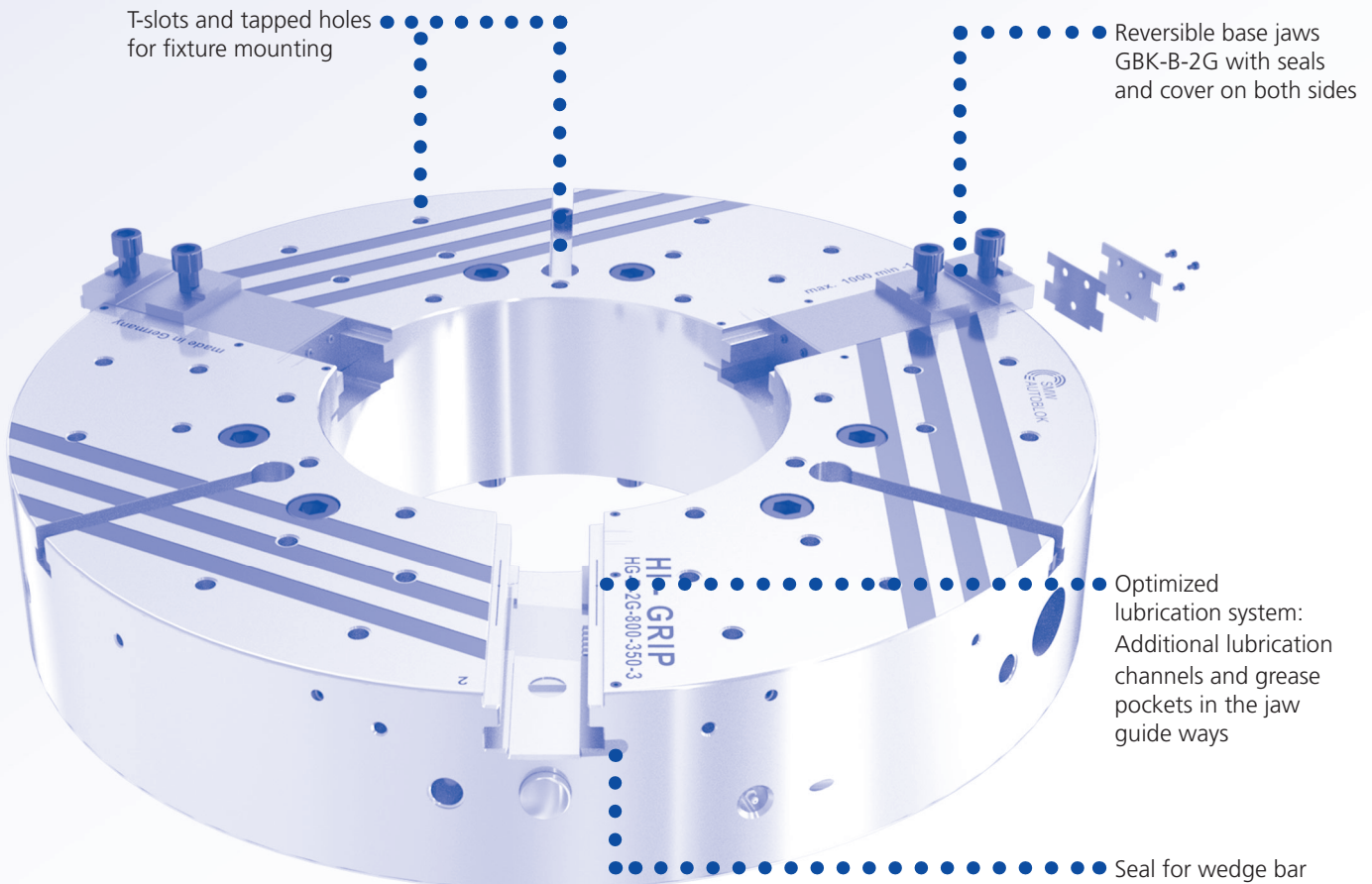
The proven wedge bar drive guarantees unmatched accuracy and rigidity. A low loss of grip force due to centrifugal force makes the chuck ideal for high speed applications.

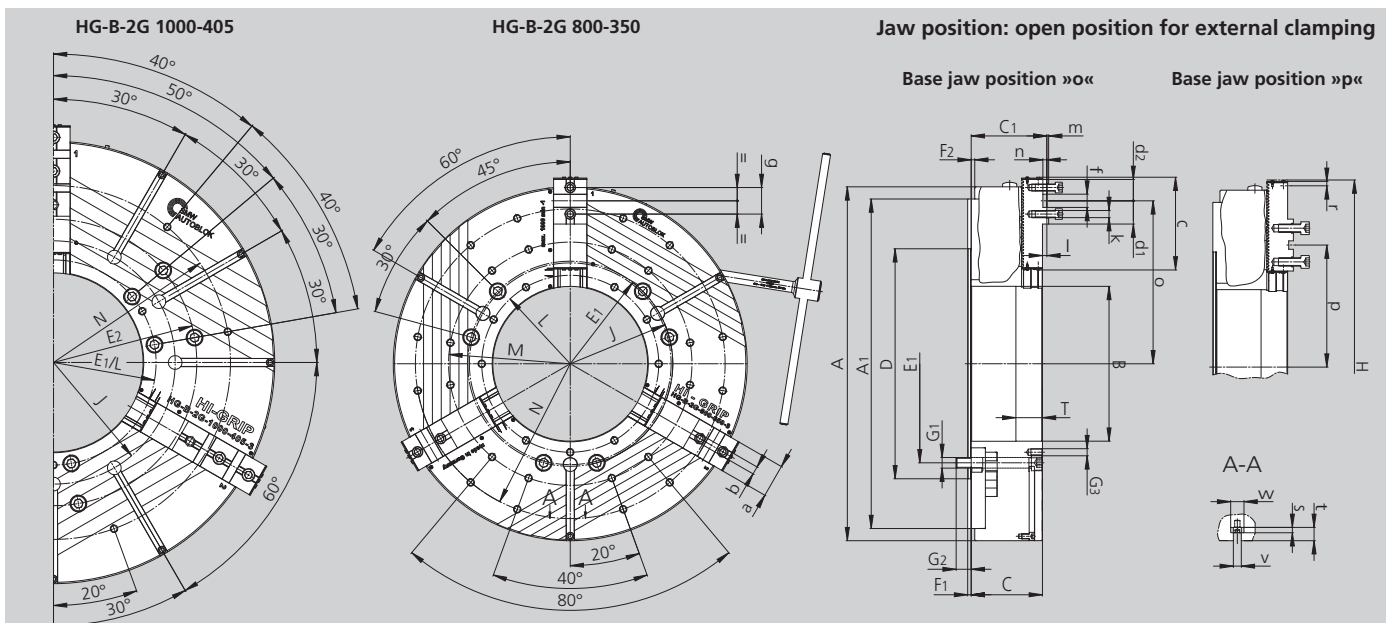
Sealing: The HG-B-2G is sealed by seals attached to both faces of the base jaws. Also the wedge bars are protected by mechanical seals. The seals **protect the chuck** against penetration of dirt and swarf.

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.





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

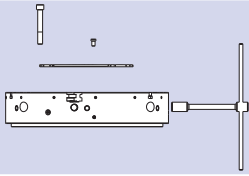
Base jaw position with GBK-B-2G

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	260	260
Speed	r.p.m.	1000	900
Weight without jaws	kg	475	745
Moment of inertia	kg·m²	45.5	109

HG-B-2G

QUICK JAW CHANGE
Wide master jaws

Ordering review



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

Supply range

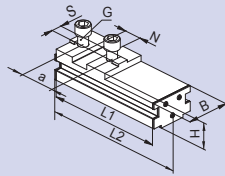
Chuck + actuation wrench + mounting bolts + set of coverplates without base jaws

Base jaw type

GBK-B-2G

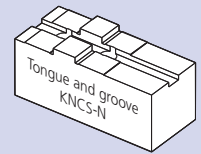
TONGUE & GROOVE KNCS-N standard

Existing top jaw



* Dimensions incl. seals, covers and mounting screws

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

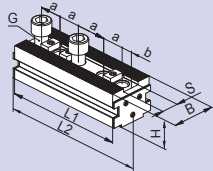


Base jaw type

GBK-BD-2G

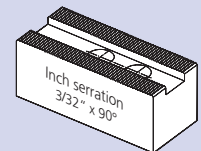
INCH SERRATED (for SMW-AUTOBLOK standard jaws)

Existing top jaw



* Dimensions incl. seals, covers and mounting screws

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

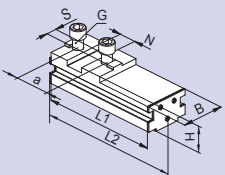


Base jaw type

GBK-BA-2G

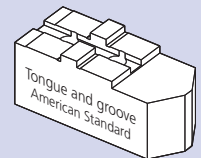
TONGUE & GROOVE American standard

Existing top jaw



* Dimensions incl. seals, covers and mounting screws

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

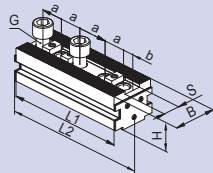


Base jaw type

GBK-BM-2G

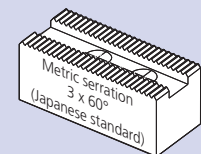
METRIC SERRATION

Existing top jaw



* Dimensions incl. seals, covers and mounting screws

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

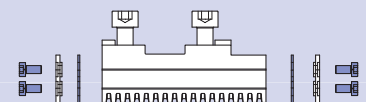


Seal Kit

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

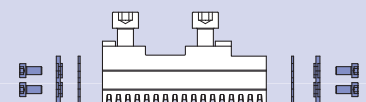


Mounting Kit

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.)

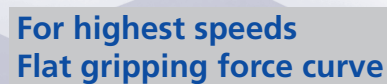
Chuck	HG-B-2G 800-350	HG-B-2G 1000-405
Mounting Kit Type	GBK-B-2G 630	GBK-B-2G 800
Id. No.	207674	207674



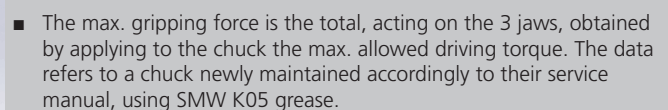
Advice:

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).

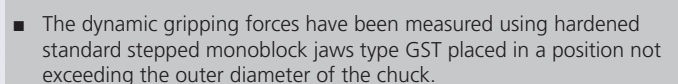
HG-F



-
- The graph shows the total gripping force F_g in kN on the y-axis (ranging from 0 to 180) against the speed in r.p.m. on the x-axis (ranging from 0 to 7000). Four curves are plotted, representing different jaw configurations: 315, 260, 210, and 160. All curves show a decrease in gripping force as speed increases. An inset diagram shows a jaw assembly with a maximum moment $Md_{max.}$ and a gripping force F_g .
- | Speed (r.p.m.) | 315 (kN) | 260 (kN) | 210 (kN) | 160 (kN) |
|----------------|----------|----------|----------|----------|
| 0 | 180 | 135 | 75 | 50 |
| 1000 | 175 | 130 | 72 | 48 |
| 2000 | 170 | 125 | 68 | 45 |
| 3000 | 165 | 120 | 65 | 43 |
| 4000 | 160 | 115 | 62 | 41 |
| 5000 | 155 | 110 | 58 | 38 |



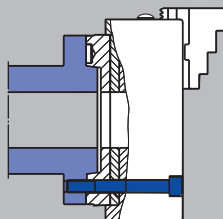
-
- The graph shows the total gripping force F_g in kN on the y-axis (0 to 260) against speed in r.p.m. on the x-axis (0 to 3500). The force starts at approximately 220 kN at 0 r.p.m. and decreases to 400 kN at 3000 r.p.m. An inset schematic shows a gripper mechanism with a horizontal bar, a vertical rod, and a gripper head. Labels include Md_{max} for maximum torque and F_g for gripping force.
- | Speed (r.p.m.) | F_g total gripping force (3 jaws) (kN) |
|----------------|--|
| 0 | 220 |
| 500 | 215 |
| 1000 | 205 |
| 1500 | 195 |
| 2000 | 180 |
| 2500 | 160 |
| 3000 | 400 |



Safety advice / danger of damage:
When using taller / heavier jaws and / or clamping on a more external position reduce driving torque/rotating speed accordingly.

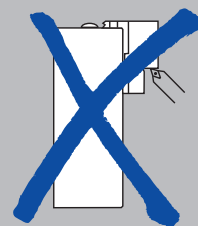
manual chuck HI-GRIP®

Direct mounting



Recess and bolt circle to
DIN 55026 / ISO-A 702/1

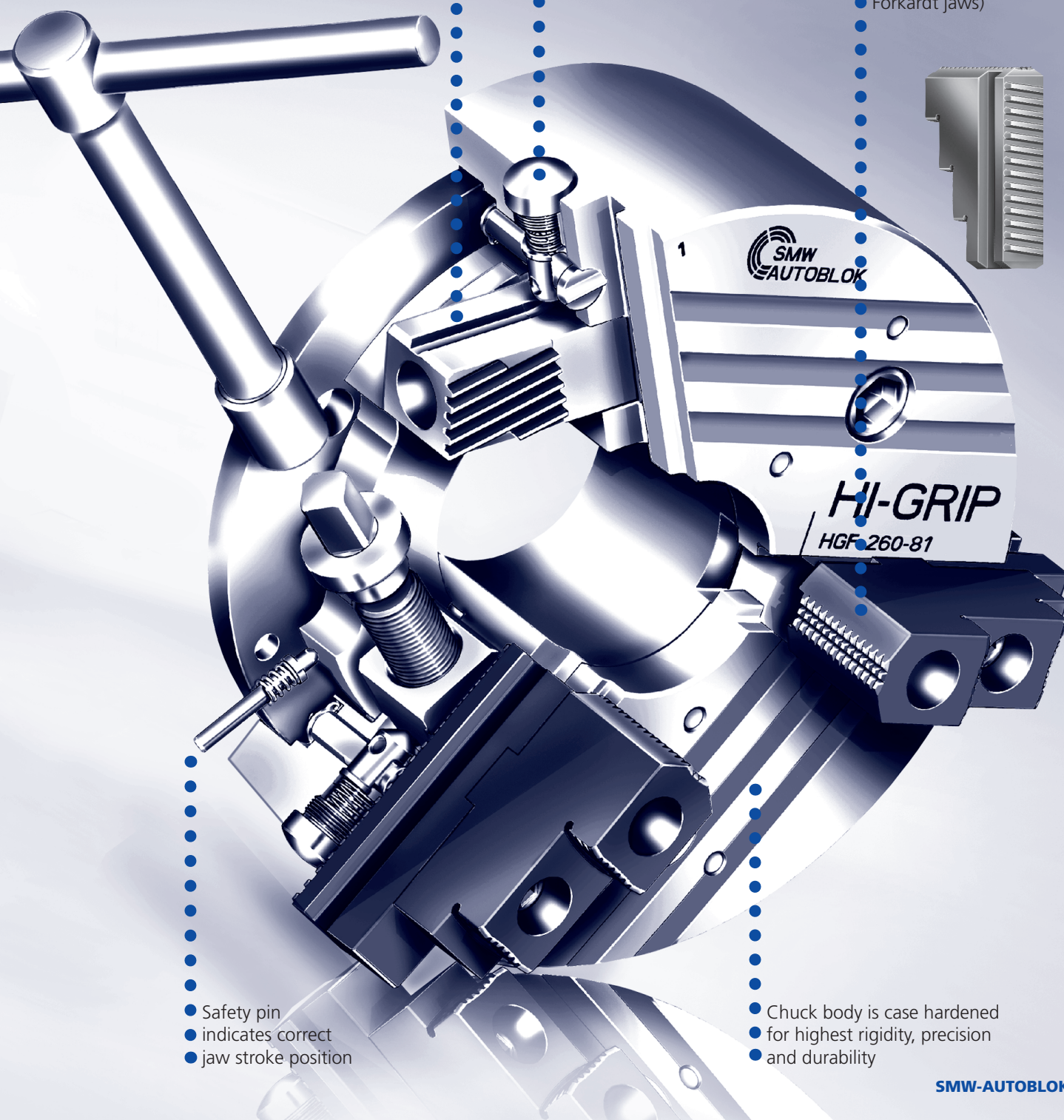
■ No reboring of already machined jaws necessary because of runout < 0.02 (e.g. HG-F 210)



Wedge bar design
guarantees highest precision,
concentricity and repeatability
as well as highest
gripping forces

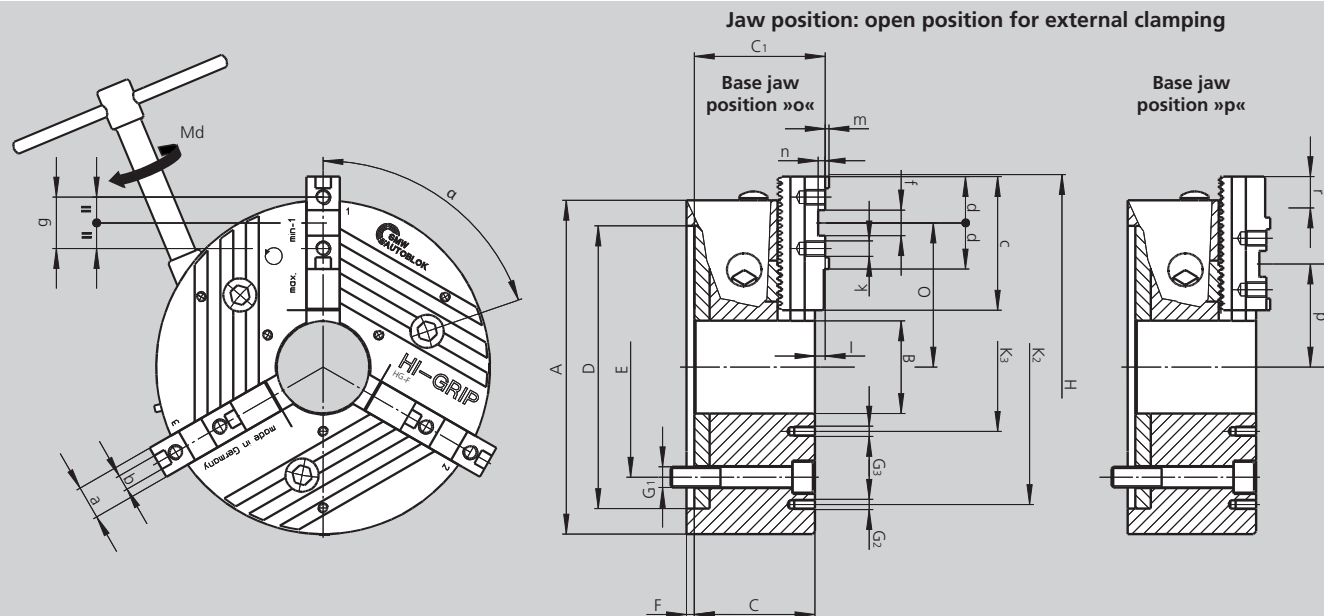
● Safety jaw release
● with interlock

● Jaw system "F"
● (compatible with
● Forkardt jaws)



● Safety pin
● indicates correct
● jaw stroke position

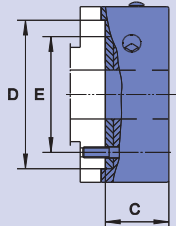
● Chuck body is case hardened
● for highest rigidity, precision
● and durability



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

SMW-AUTOBLOK Type		HG-F 160-46	HG-F 210-60	HG-F 260-81	HG-F 315-102	HG-F 400-128
Mounting	Size	Z140	Z170	Z220	Z300	Z380
	A	165	210	260	315	400
	B	46	60	81	102	128
	C	64	85.5	94	111	132
	C1	71	92.7	101.7	120.1	141.9
H6	D	140	170	220	300	380
	E	104.8	133.4	171.4	235	330.2
	F	5	6	6	6	6
	G1	M10	M12	M16	M20	M24
	G2	-	M10 / 3 x 120°	M10 / 3 x 120°	M10 / 3 x 120°	M12 / 3 x 120°
	G3	M5 / 3 x 120°	M6 / 3 x 120°	M8 / 3 x 120°	M10 / 3 x 120°	M12 / 3 x 120°
Swing dia.	H	195	250	300	372	492
	K2	-	168	210	268	330
	K3	75	75	95	120	160
	α°	68	64	66	65.5	64.5
	β°	-	60	60	55	45
Master jaw		MFG 160	MFG 200	MFG 250	MFG 315	MFG 400
	a	20	22	26	32	45
f7	b	8	10	12	12	18
	c	74	90	110	125	160
	d	28	33	36	36	50
H7	f	18	20	20	26	30
	g	32	40	40	54	60
Thread / thread depth	k	M8 x 1 / 12	M8 x 1 / 13	M12 x 1.5 / 15	M12 x 1.5 / 17	M16 / 30
	l	6	7.2	7.7	9.3	9.9
	m	2.5	3	3	3	4
	n	5	6	6	8	9
Max. / min.	o	69.5 / 55.1	86.5 / 62	112.2 / 82.4	149 / 93	193.6 / 125.6
Max. / min.	p	51.5 / 37.1	67.3 / 42.8	74.3 / 44.3	103 / 54	134.3 / 66.3
Base jaw tooth pitch	-	4.8	4.9	6	7	8.5
Master jaw offset	r	14.4	24.5	30	56	68
Master jaw offset	teeth	3	5	5	8	8
Usable jaw stroke	mm	5.9	6.2	7.4	9.6	11.4
Max. total gripping force	kN	60	75	130	180	220
At max. torque Md	Nm	80	120	160	200	250
Speed	r.p.m.	5500	4800	4200	3500	2700
Weight without jaws	kg	8.3	19	32	53	103
Moment of inertia	kg·m²	0.03	0.09	0.25	0.60	1.9

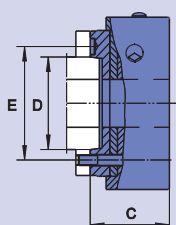
Chuck with center mounting DIN 6350



Chuck	HG-F 160-46	HG-F 210-60	HG-F 260-81	HG-F 315-102	HG-F 400-128
Mounting	Z140	Z170	Z220	Z300	Z380
C	64	85.5	94	111	132
D	140	170	220	300	380
E	104.8	133.4	171.4	235	330.2

	Chuck with MFG + WAK
Id. No.	090521 090026 090058 090090 090122
	Chuck with FST
Id. No.	090523 090028 090060 090092 090124
	Chuck with MFG + GUA
Id. No.	090522 090027 090059 090091 090123

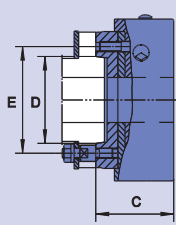
Chuck with ISO-A mounting DIN 55026



Chuck	HG-F 160-46		HG-F 210-60			HG-F 260-81		HG-F 315-102		HG-F 400-128	
Mounting	A4	A5	A5	A6	A8	A6	A8	A8	A11	A11	A15
C	84	79	109.5	107.5	125.5	118	119	141	141	168	168
D	63.51	82.56	82.56	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77
E	82.6	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2

	Chuck with MFG + WAK
Id. No.	090524 090527 090543 090030 090034 090062 090066 090094 090098 090126 090130
	Chuck with FST
Id. No.	090526 090529 090545 090032 090036 090064 090068 090096 090100 090128 090132
	Chuck with MFG + GUA
Id. No.	090525 090528 090544 090031 090035 090063 090067 090095 090099 090127 090131

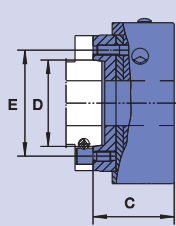
Chuck with bayonet mounting DIN 55027 Type C



Chuck	HG-F 160-46		HG-F 210-60			HG-F 260-81		HG-F 315-102		HG-F 400-128	
Mounting	C4	C5	C5	C6	C8	C6	C8	C8	C11	C11	C15
C	84	84	107.5	107.5	125.5	119	119	141	141	168	168
D	63.51	82.56	82.56	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77
E	85	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2

	Chuck with MFG + WAK
Id. No.	090530 090533 090546 090038 090042 090070 090074 090102 090106 090134 090138
	Chuck with FST
Id. No.	090532 090535 090548 090040 090044 090072 090076 090104 090108 090136 090140
	Chuck with MFG + GUA
Id. No.	090531 090534 090547 090039 090043 090071 090075 090103 090107 090135 090139

Chuck with camlock mounting DIN 55029 Type S



Chuck	HG-F 160-46		HG-F 210-60			HG-F 260-81		HG-F 315-102		HG-F 400-128	
Mounting	S4	S5	S5	S6	S8	S6	S8	S8	S11	S11	S15
C	92	92	118.5	118.5	125.5	132	132	154	154	182	182
D	63.51	82.56	82.56	106.39	139.73	106.39	139.73	139.73	196.88	196.88	285.77
E	82.6	104.8	104.8	133.4	171.4	133.4	171.4	171.4	235.0	235.0	330.2

	Chuck with MFG + WAK
Id. No.	090536 090539 090549 090046 090050 090078 090082 090110 090114 090142 090146
	Chuck with FST
Id. No.	090538 090541 090551 090048 090052 090080 090084 090112 090116 090144 090148
	Chuck with MFG + GUA
Id. No.	090537 090540 090550 090047 090051 090079 090083 090111 090115 090143 090147

Parts included: Fixing elements (screws resp. studs resp. camlock bolts).

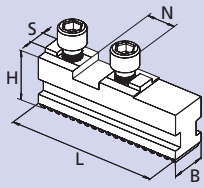
HG-F

QUICK JAW CHANGE
Jaw system Forkardt

Jaws

MFG

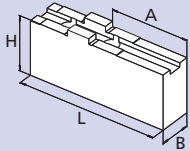
Hardened base jaws



Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	MFG 160	MFG 200	MFG 250	MFG 315	MFG 400
Id. No.	081303	081304	081305	081306	081307
B	20	22	26	32	45
H	29.5	35	40	46	55
L	74	90	110	125	160
N	18	20	20	26	30
S	8	10	12	12	18
kg / set	0.8	1.2	2.0	3.3	7.3

WAK

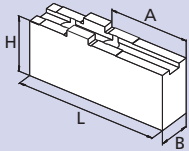
Soft top jaws



Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	WAK 160-10	WAK 200-10	WAK 250-10	WAK 400-10	WAK 500-10
Id. No.	012491	012492	012493	012494	012495
B	20	22	30	35	50
H	35.5	42	50	54	73
L	85	105	125	145	180
A	42	50	70	74	100
kg / set	1.2	2.0	3.6	5.8	13.7

WAKS

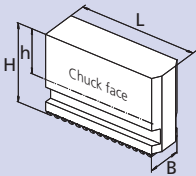
Wide soft top jaws



Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	WAKS 140-10	WAKS 200-30	WAKS 250-20	WAKS 400-30	WAKS 500-30
Id. No.	012496	012497	012498	012500	012501
B	35	40	60	80	90
H	35.5	36	55	64	73
L	63	70	90	100	130
A	25	27	44	44	65
kg / set	1.5	1.9	6.2	11.0	16.4

BFR

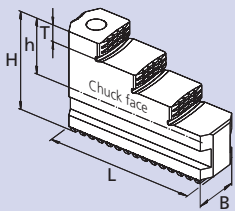
Soft monoblock jaws



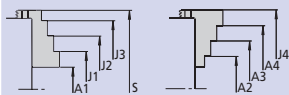
Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	BFR 160	BFR 200	BFR 250	BFR 315	BFR 400
Id. No.	081272	081273	081274	081275	081276
B	20	22	26	32	45
H	45	60	70	81	93
h	24	35	40	46	45
L	79	94	115	140	176
kg / set	1.4	2.6	4.4	7.4	15.4

FST

Hardened stepped monoblock jaws



Clamping ranges



Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	FST 170	FST 210	FST 250	FST 315	FST 400
Id. No.	081282	081283	081284	081285	081286
B	20	22	26	32	45
H	45	60	70	79	93
h	24	35	40	46	53
L	79	94	114	130	167
T	7.5	1.0	14	15	20
kg / set	1.1	1.9	3.3	5.2	10.8
A1	6-59	10-96	19-99	20-115	48-173
A2	42-89	56-130	76-142	85-180	116-238
A3	73-120	96-170	120-186	140-235	184-308
A4	104-151	136-210	164-230	195-290	252-378
J1	44-78	70-147	81-147	80-170	118-243
J2	74-110	109-187	125-191	135-225	186-310
J3	105-141	149-228	169-235	190-282	253-378
J4	135-182	186-260	211-278	255-350	328-448
S	198	244	280	350	456

JAWS-CATALOG

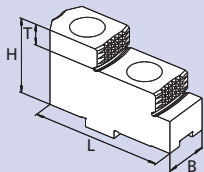
Request or
download:
www.smw-autoblok.de



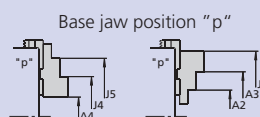
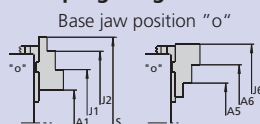
Jaws ■ Grease

GUA

Hardened reversible
stepped top jaws



Clamping ranges



Chuck	HG-F 160	HG-F 210	HG-F 260	HG-F 315	HG-F 400
Jaw type	GUA 160	GUA 200	GUA 250	GUA 400	GUA 500
Id. No.	012484	012485	012486	012487	012488
B	20	22	30	36	45
H	36.5	38	50	56	70
L	63	72	90	105	130
T	7.5	10	14	15	20
kg / set	0.6	0.8	1.9	3.2	10.8
A1	32-69	55-111	73-161	64-194	108-264
A2	60-98	69-125	45-101	44-108	70-158
A3	85-123	96-152	125-181	156-220	171-259
A4	13-51	17-73	20-97	22-100	24-146
A5	78-116	104-163	76-165	72-202	121-277
A6	103-141	131-190	156-245	134-314	222-378
J1	91-129	117-174	152-240	140-270	223-379
J2	116-154	144-201	233-321	256-382	324-480
J3	144-181	158-215	204-259	323-296	286-374
J4	74-111	80-136	101-177	93-176	138-260
J5	99-136	107-163	180-257	210-288	239-361
J6	162-200	193-253	235-323	260-390	336-492
S	198	196-253/255	333	372	492

JAWS-CATALOG

Request or
download:
www.smw-autoblok.de



**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)



Lubrication set Id. No. 083726

Supply range

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

PTF

TONGUE & GROOVE

Manual clamping and radial setting of jaws

High precision 4-jaw independent manual chuck Ø 1000 - 2000 mm

- Closed center
- 4 jaws (all diameters)

Application/customer benefits

- Clamping of large round, square and irregular parts
- Manual, radial setting of component and manual clamping
- Suitable for vertical machines. Strong body and master jaws design and option to easily mount a strong center point
- High gripping force allowed by the strong design, with the option to increase it with a torque multiplier
- Tongue & groove master jaws (type "American Standard")

Technical features

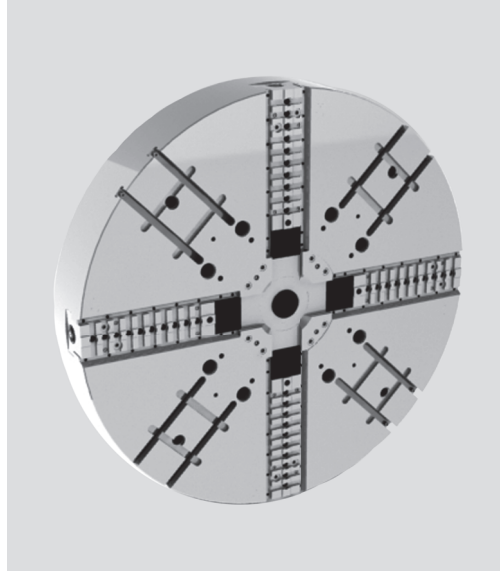
- Manual gripping force applied by a strong and protected screw on a strong and rigid master jaw
- Manual and fine setting of master jaws for workpiece centering
- Protection from contamination with seals along the master jaw profiles
- Possibility to use jaw boxes for manual clamping mounted on the T-slots between the master jaws

Standard equipment

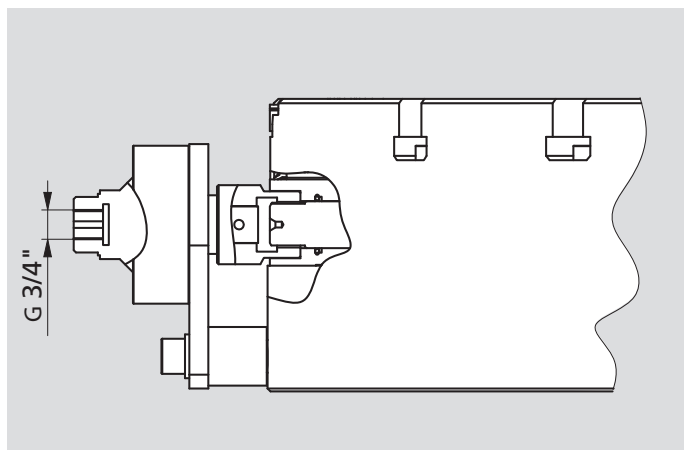
4-jaw independent manual chuck
1 set of soft top jaws
1 regulation and actuation key
1 grease gun and 500g grease

Ordering example

4-jaw independent chuck PTF 1600 / Z720
Id. No. 77137063
Option: 5:1 torque multiplier
Id. No. 13506320



Optional: 5:1 torque multiplier

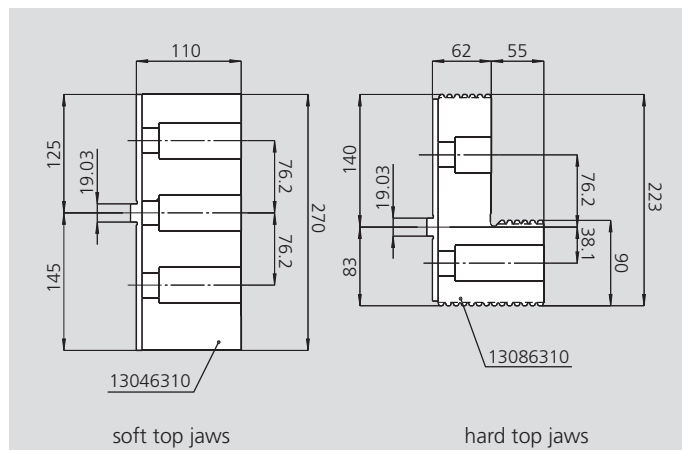


Optional 5:1 torque multiplier

To achieve the maximum gripping force and speed, the easiest and most comfortable way is to use this multiplier that will increase 5 times the input torque.

Id. No. 13506320

Soft and hard top jaws for PTF



Safety advice / danger of damage:

When using taller / heavier jaws and / or clamping on a bigger diameter reduce operating torque / rotating speed accordingly.

Technical data

SMW-AUTOBLOK Type		PTF 1000	PTF 1250	PTF 1400	PTF 1600	PTF 2000
Radial jaw stroke (manual setting)	mm	60	60	60	60	80
Max. manual operating torque	Nm	600	600	700	700	700
Max. total gripping force*	kN	360	360	360	360	360
Max. speed	r.p.m.	550	450	380	340	280
Weight (without top jaws)	kg	730	930	1435	1860	2730
Moment of inertia	kg·m ²	89	183	364	565	1380
Hard top jaw (piece)	Id. No.	13086310	13086310	13086310	13086310	13086310
Soft top jaw (piece)	Id. No.	13046310	13046310	13046310	13046310	13046310
Id. No.		77137039	77137049	77137055	77137063	77137079

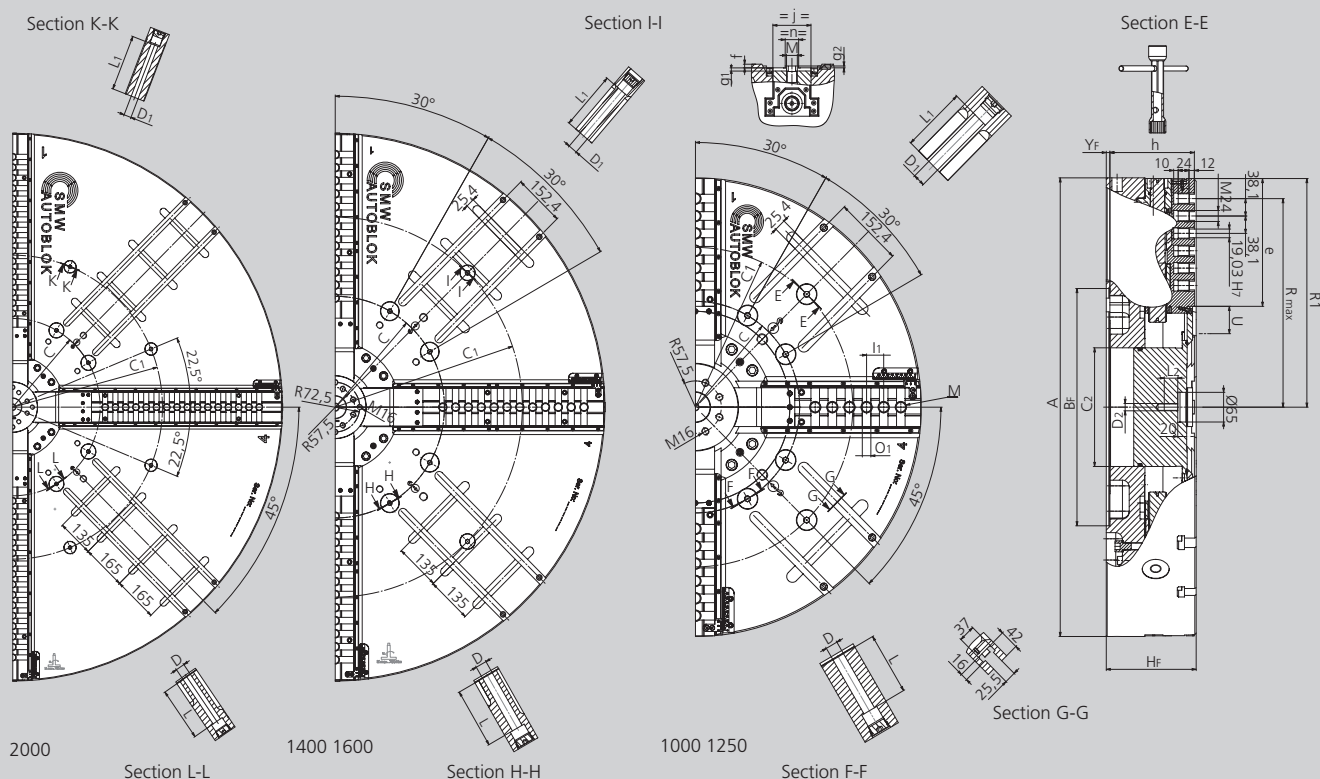
* at max. torque.

High precision 4-jaw independent manual chuck Ø 1000 - 2000 mm

- Closed center
- 4 jaws (all diameters)

PTF

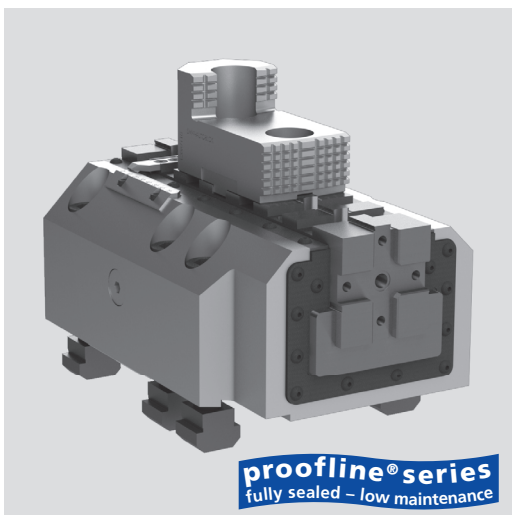
TONGUE & GROOVE
Manual clamping and radial setting of jaws



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

SMW-AUTOBLOK Type			PTF 1000	PTF 1250	PTF 1400	PTF 1600	PTF 2000
Mounting			Z520	Z520	Z720	Z720	Z720
A	mm		1005	1250	1400	1600	2000
Bf	H6	mm	520	520	720	720	720
C	mm		463.6	463.6	647.6	647.6	647.6
C1	mm		700	700	1110	1110	1110
C2	mm		260	260	300	300	300
D	mm		27	27	33	33	33
D1	mm		27	27	27	27	27
D2	mm		M16	M16	M24	M24	M24
Hf	mm		200	200	240	240	260
L	mm		137	139	177	177	197
L1	mm		145	145	177	173	205
L2	mm		30	30	24	24	24
Chuck open	R1	mm	501	623	696	796	996
Chuck open	Rmax	mm	457	563	657	738	914
Radial jaw stroke	U	mm	60	60	60	60	80
	Yf	mm	8	8	8	8	8
	e	mm	280	402	439	536	704
	f	mm	8	8	8	8	8
	g1	mm	7	7	7	7	7
	g2	mm	4	4	4	4	4
	h	mm	188	188	228	228	248
	j	mm	85	85	110	110	110
	l1	mm	38.1	38.1	38.1	38.1	38.1
	m	mm	M24	M24	M24	M24	M24
	n	h8	mm	30	30	30	30
	o1	H7	mm	19.03	19.03	19.03	19.03
Number of "o1" cross grooves			6	9	10	12	16
Number of "m" threads			6	9	11	12	16

- Accessory for face plates, 4 jaws independent manual or other chucks
- Internal or external clamping



Application/customer benefits

- JBX: Standard mounting dimensions for SMW-AUTOBLOK chucks
- JBX-2G: Semifinished body and radial reference key to be adapted by customer
- Manual radial setting and clamping of large components on large plates or chuck
- Added to chucks there is more gripping force to apply a higher torque on the workpiece
- Added to chucks there are more contact points with the workpiece to better distribute the gripping force thus reducing distortion
- Very powerful and accurate clamping allowed by strong design
- Suitable for vertical machines thanks to the fully protected body
- Use of standard hard or soft jaw on top of the master jaw or special frontal jaws on the front side of the master jaw
- TONGUE & GROOVE master jaws (type "American Standard")

Technical features

- Manual gripping force applied by a strong and protected screw on a strong and rigid master jaw
- Manual and fine setting of master jaws for workpiece centering
- Protection from contamination with seals along the master jaw profiles
- Designed to work on SMW-AUTOBLOK large manual or power chucks or on special plates
- Body designed for better chip evacuation

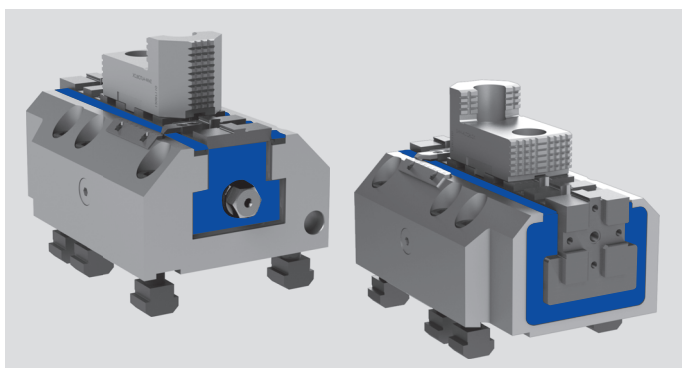
Standard equipment

Manual jaws box
1 radial key
6 T-nuts and mounting screws (only JBX)

Ordering example

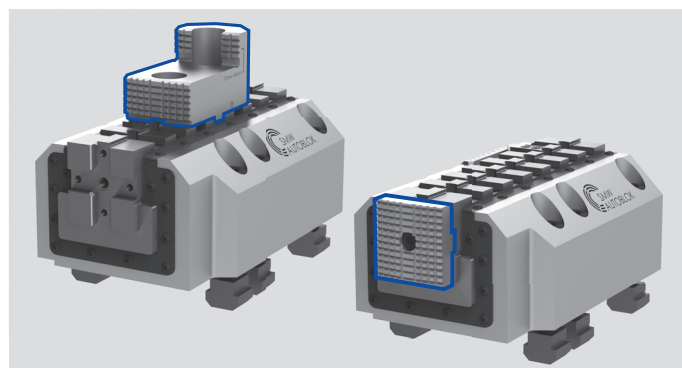
Qty. 1 / 2 / 3 / 4 manual jaw box JBX 300
Id. No. 77653003
Option: Actuation key Id. No. 11122700

Maximum protection



Master jaw protected on each side by steel profiles. Maximum protection from the penetration of chips, swarf, rubber and coolant allows less maintenance, working in bad environments and for a longer operative life.

Flexibility of use



The jaw box can carry both standard or special, hard or soft jaws mounted on the upper side of the master jaw or special jaws mounted on the front side of the master jaw. The jaws on the front side allow optimal clamping in the same axis of the master jaws thus reducing deformation of the jaw and the jaw box. This allows a more rigid and accurate clamping. Also the frontal jaw option increases the flexibility allowing the customer to clamp the component in a very low area where it would be impossible to clamp with traditional jaws mounted on the upper side of the master jaw.

Technical data

SMW-AUTOBLOK Type		JBX 300	JBX-2G 300	JBX-2G 400
Id. No.		77653003	77653009	77654003
Jaw stroke (manual setting)	mm	50	50	100
Max. manual operating torque	Nm	200	200	400
Max. gripping force	kN	50	50	100
Weight (without top jaws)	kg	50	50	90
Hard top jaw (piece)*	Id. No.	12087111	12087111	12087111
Soft top jaw (piece)*	Id. No.	12044050	12044050	12044050
Soft top jaw long (piece)*	Id. No.	12045051	12045051	12045051
Soft top jaw for master jaw front side (piece)*	Id. No.	65653007	65653007	65653007

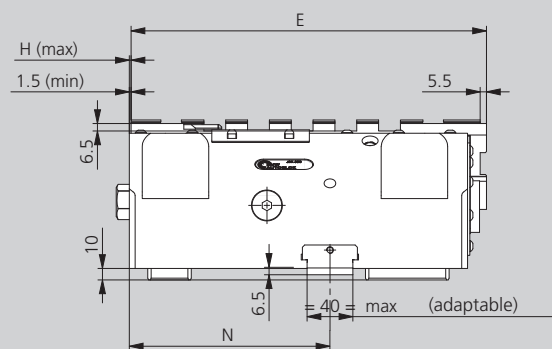
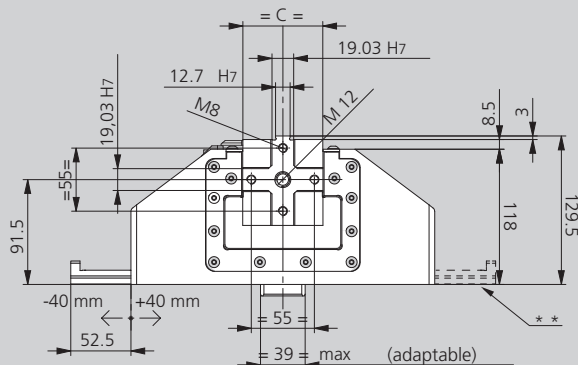
* The soft and tempered jaws are not in scope of delivery, the Id. No. are indicated in the table.

High precision, resistance and power manual jaw box

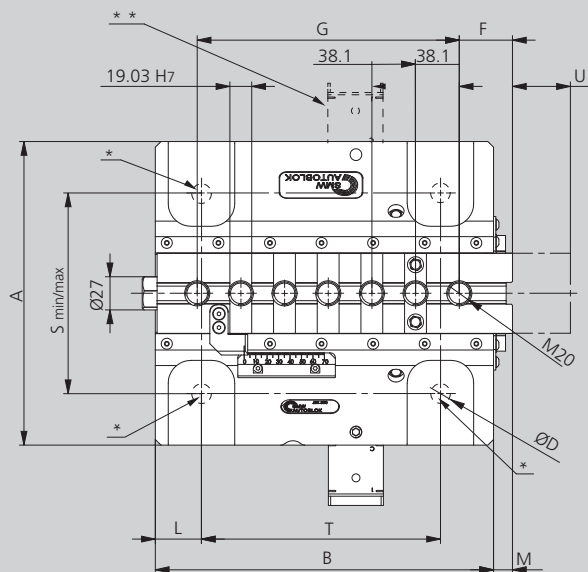
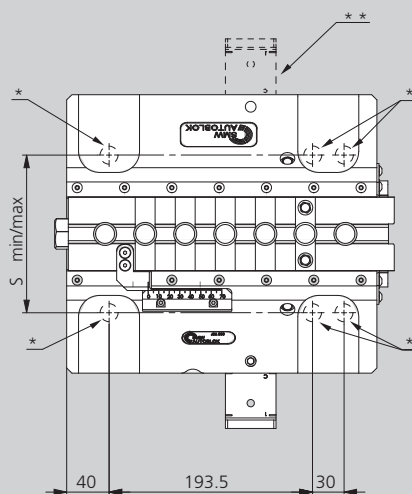
JBX-2G

- Accessory for face plates, 4 jaws independent manual or other chucks
- Internal or external clamping

Manual jaw box
with semi-finished body



JBX-2G 300



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

SMW-AUTOBLOK Type		JBX-2G 300	JBX-2G 400
A	mm	265	310
B	mm	295	380
C	mm	70	80
ØD Min. / max.	mm	17-25	21-31
E	mm	310	395
F	mm	46.4	55.2
G	mm	228.6	304.8
H	mm	51.5	101.5
L	mm	40	57.5
U Stroke	mm	50	100
M	mm	16.5	16.5
N	mm	175	225
S Screws M16-M20 min. *	mm	150	-
S Screws M16-M20 max. *	mm	230	-
S M20-M24 nuts min. *	mm	175	210
S M20-M24 nuts max. *	mm	220	260
S M30 nuts min. *	mm	-	220
S M30 nuts max. *	mm	-	260
T	mm	208.5	250

* All these elements have to be worked according to the needs of the customer. If the customer will make these modifications, they must be approved by the SMW-AUTOBLOK technical office. Before making the modifications, we suggest to request the jaw box 2D or 3D drawing.
Note that the minimum screws size must be M16 or M20.

** In case of interference, the radial reference key can be mounted on the other side of the JBX-2G.

JBX

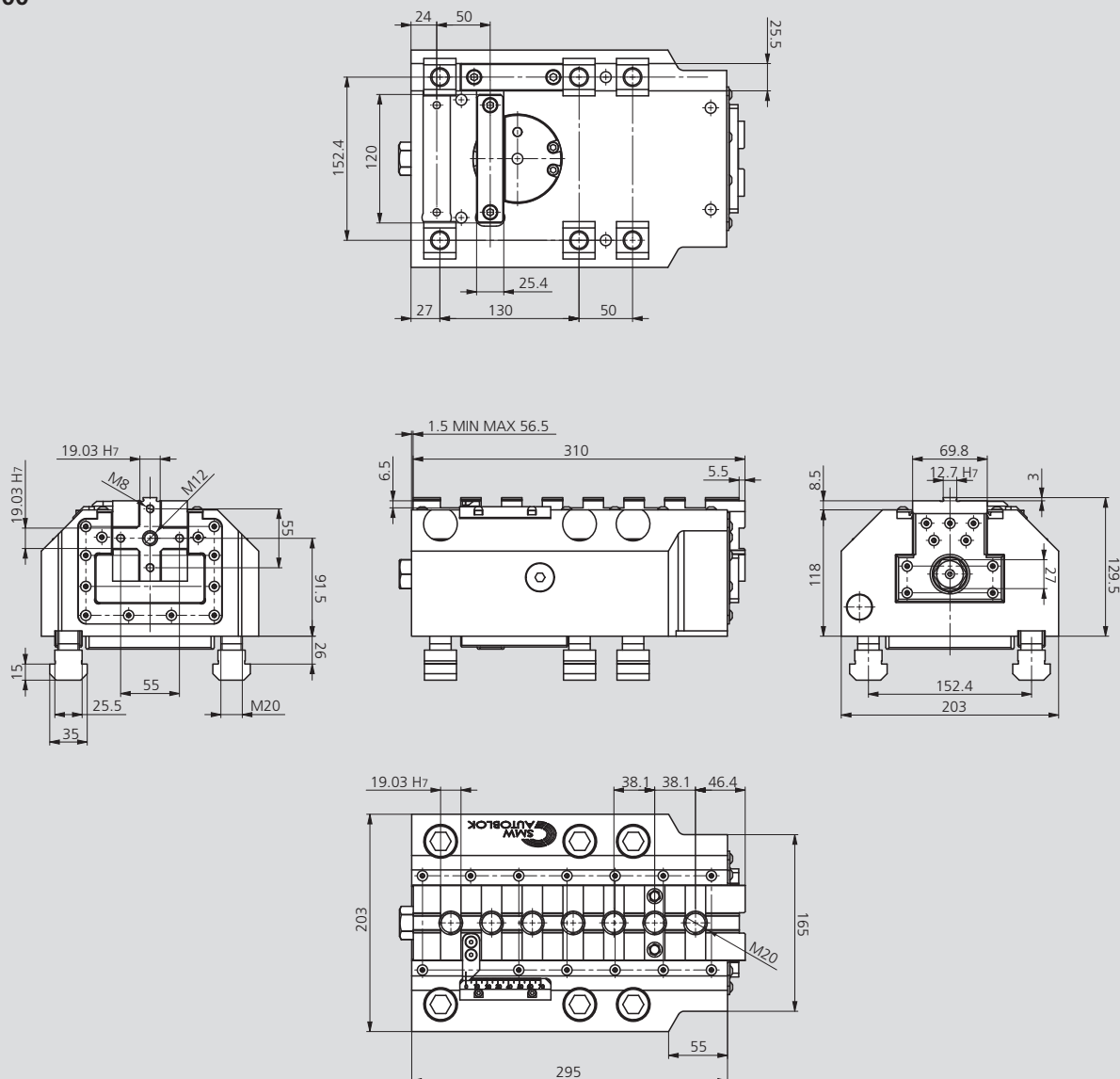
Manual jaw box
SMW-AUTOBLOK standard
mounting dimensions

JBX-2G

Manual jaw box
with semi-finished body

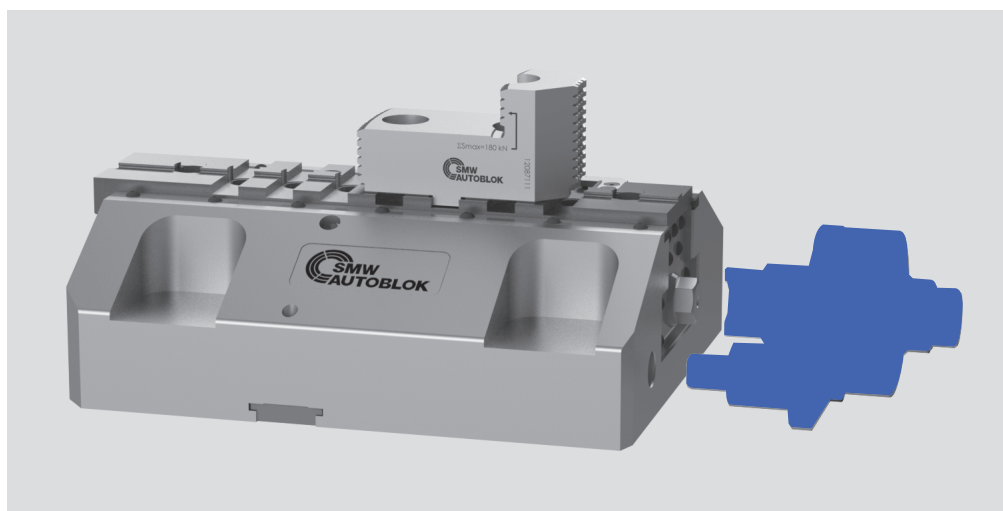
High precision, resistance and power manual jaw box

- Accessory for face plates, 4-jaw independent manual or other chucks
- Internal or external clamping

JBX 300

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

Optional 5:1 torque multiplier for JBX and JBX-2G

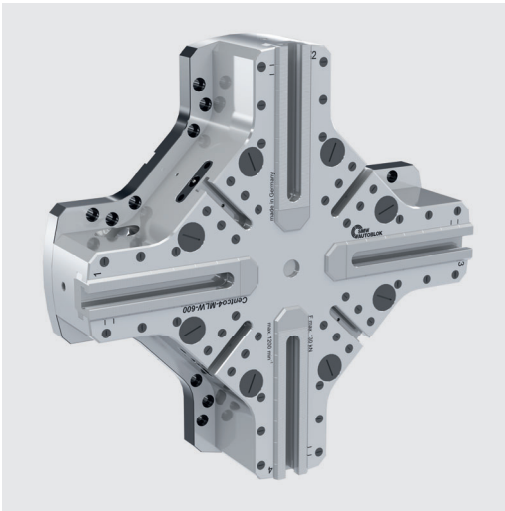


Torque multiplier Id. No. 13506320

- Transmission 5:1
- Easy operation
- For fast achievement of maximum gripping force

Notes

- 2+2 self centering
- Independent self centering clamping in 2 axis
- Weight-optimized chuck body



Application/customer benefits

- Independent self centering clamping in 2 axis via 1 central, manual actuating mechanism
- Mechanical centering of the workpiece
- Clamping of every workpiece geometry possible
- Weight-optimized chuck body
- Less workpiece deformation compared to 3-jaw chucks
- Long lifetime due to case hardened parts
- Large range of standard top jaws
- Suitable for OD and ID clamping

Technical features

- Centrifugal force compensation
- Optimized lubrication system

Standard equipment

4-jaw manual chuck,
8 pieces T-nuts and bolts
Actuation wrench

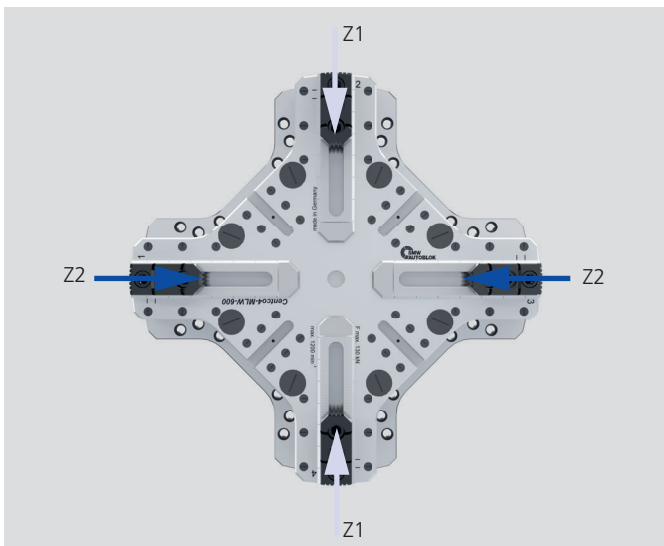
Ordering example

Centco4-MLW-D-600-4

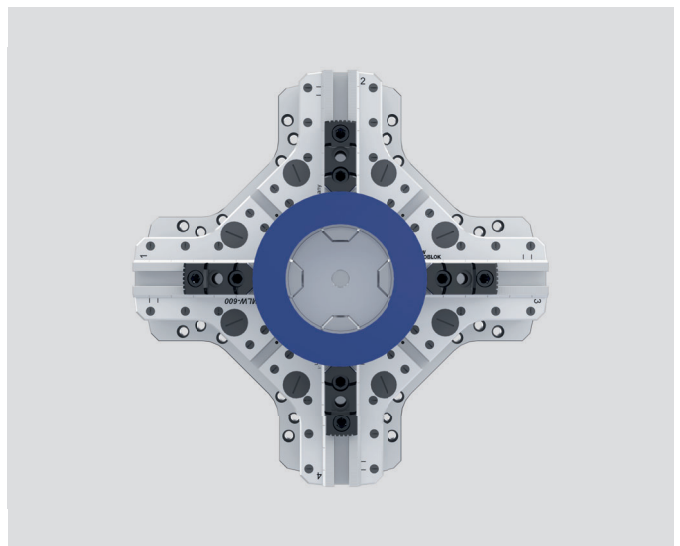
Function / Application examples

2+2 self centering and compensating clamping*

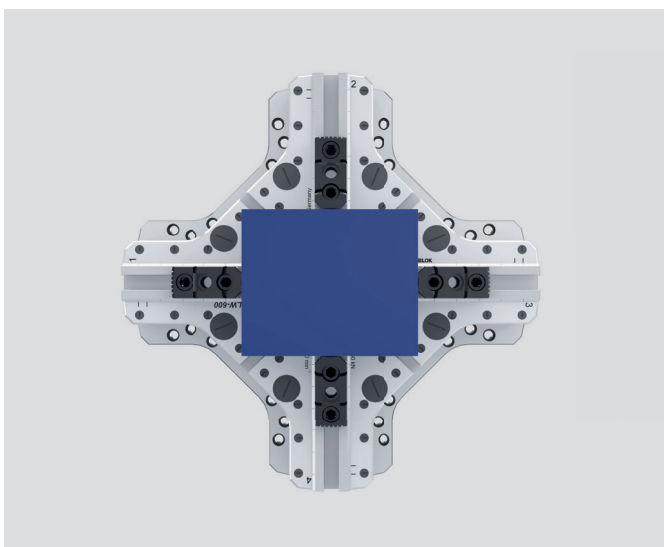
In the beginning the jaw pairs **Z1** + **Z2** only apply a centering force that is necessary to center the workpiece. Only if both jaw pairs **Z1** and **Z2** are in contact with the workpiece, the clamping force necessary for machining is applied.



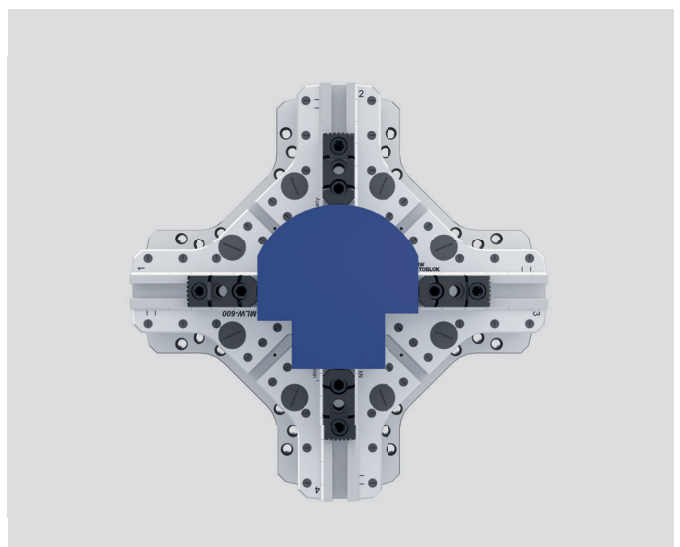
2+2 self centering clamping of round or thin-walled workpieces



2+2 self centering and compensating clamping of rectangular or square workpieces



2+2 self centering and compensating clamping of unshaped workpieces



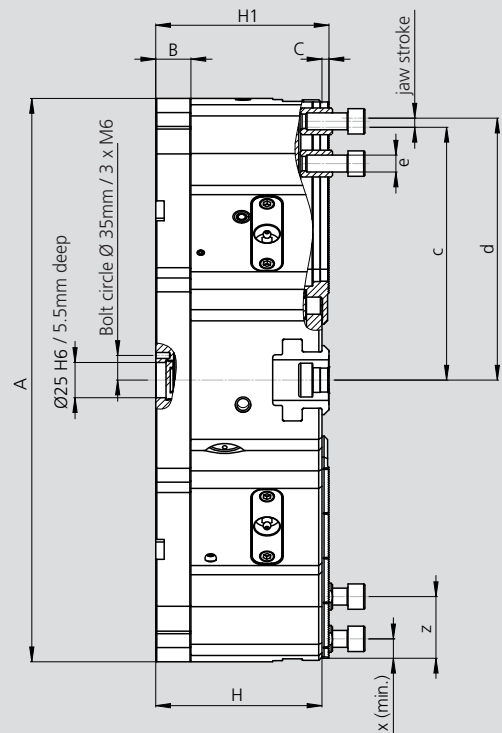
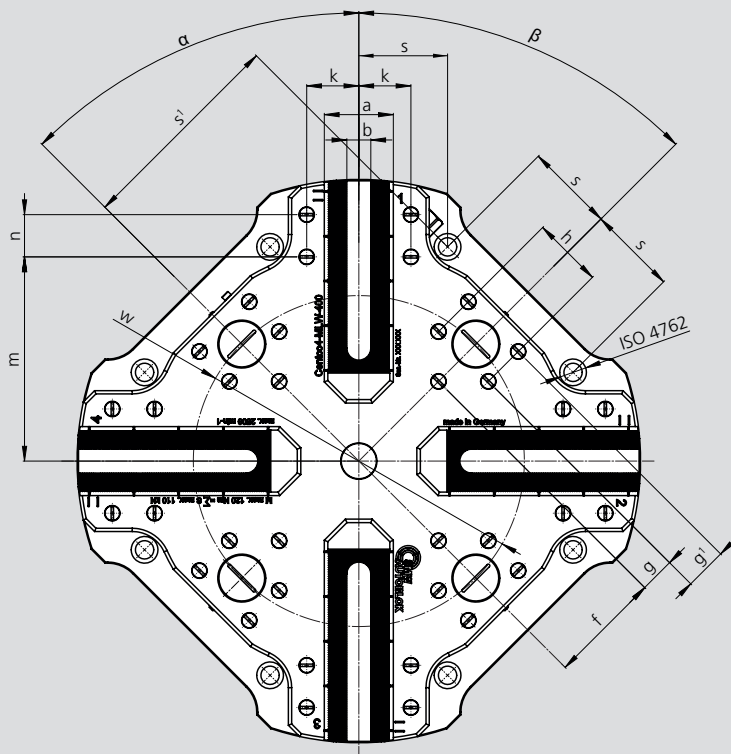
* **Z1**: Self centering clamping axis 1 / **Z2**: self centering clamping axis 2
Z1 is compensating to **Z2**

4-jaw manual chuck Ø 400 mm

- 2+2 self centering
- Independent self centering clamping in 2 axis
- Weight-optimized chuck body

Centco4-MLW-D

INCH
SERRATION



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

SMW-AUTOBLOK Type Centco4-MLW-D Id. No.

400-4
163180

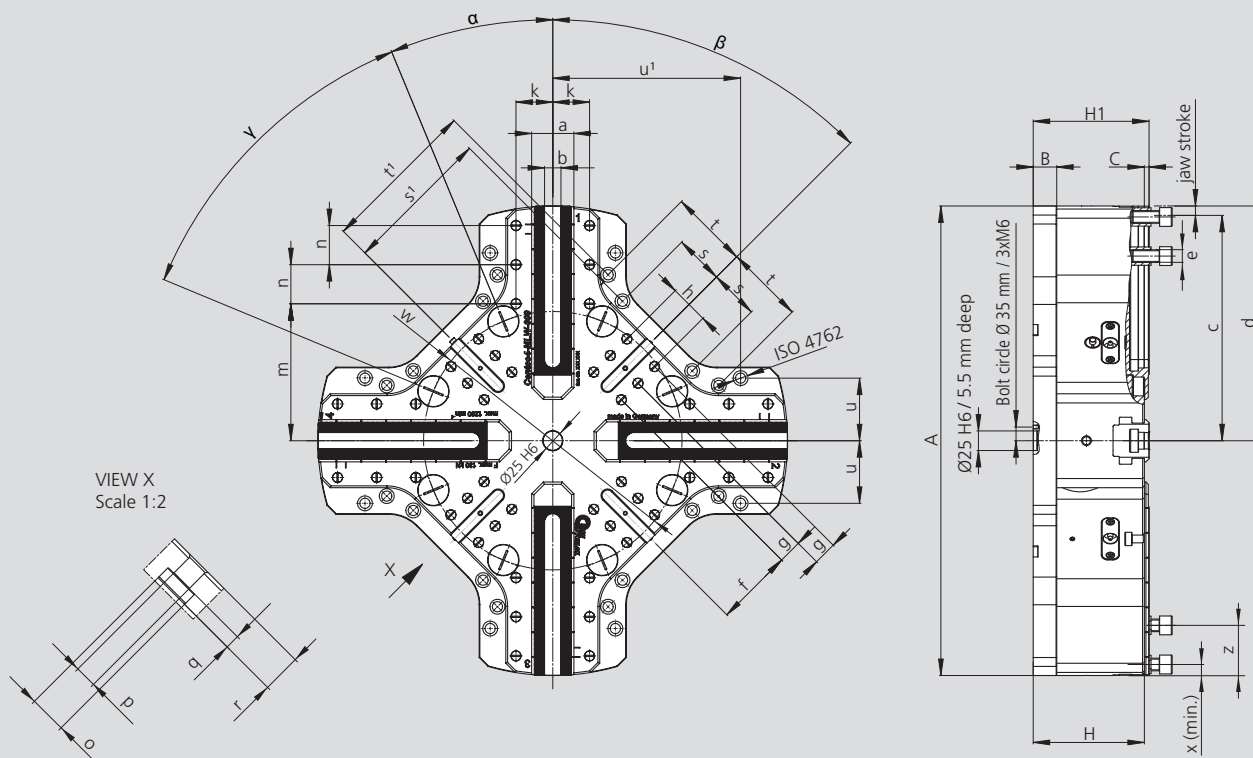
Outside diameter	A	mm	400
Base plate height	B	mm	25
	C	mm	5
Chuck height	H	mm	118
	H1	mm	123
Jaw width	a	mm	49
Slot width	b	mm	17
Min.	c	mm	179.5
Max.	d	mm	186
Bolt ISO4762-12.9	e	mm	M12
	f	mm	80
	g	mm	25
	g ¹	mm	30
	h	mm	50
	k	mm	37
	m	mm	145
	n	mm	30
	s/s ¹	mm	63 / 152.1
	w	mm	235 / 4 x 90°
Min.	x	mm	6
Min. / max.	z	mm	25 / 115
	α	deg.	45
	β	deg.	45
Serration		inch	1/16" x 90°
Max. speed		min ⁻¹	2500
Max. total clamping force		kN	110
At max. actuating torque (Md)		Nm	120
Stroke per jaw		mm	6.5
Compensation stroke per jaw		mm	5
Weight (without jaws)		kg	77
Moment of inertia		kg·m ²	1.3

Centco4-MLW-D

4-jaw manual chuck Ø 600 - 750 mm

INCH
SERRATION

- 2+2 self centering
- Independent self centering clamping in 2 axis
- Weight-optimized chuck body



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

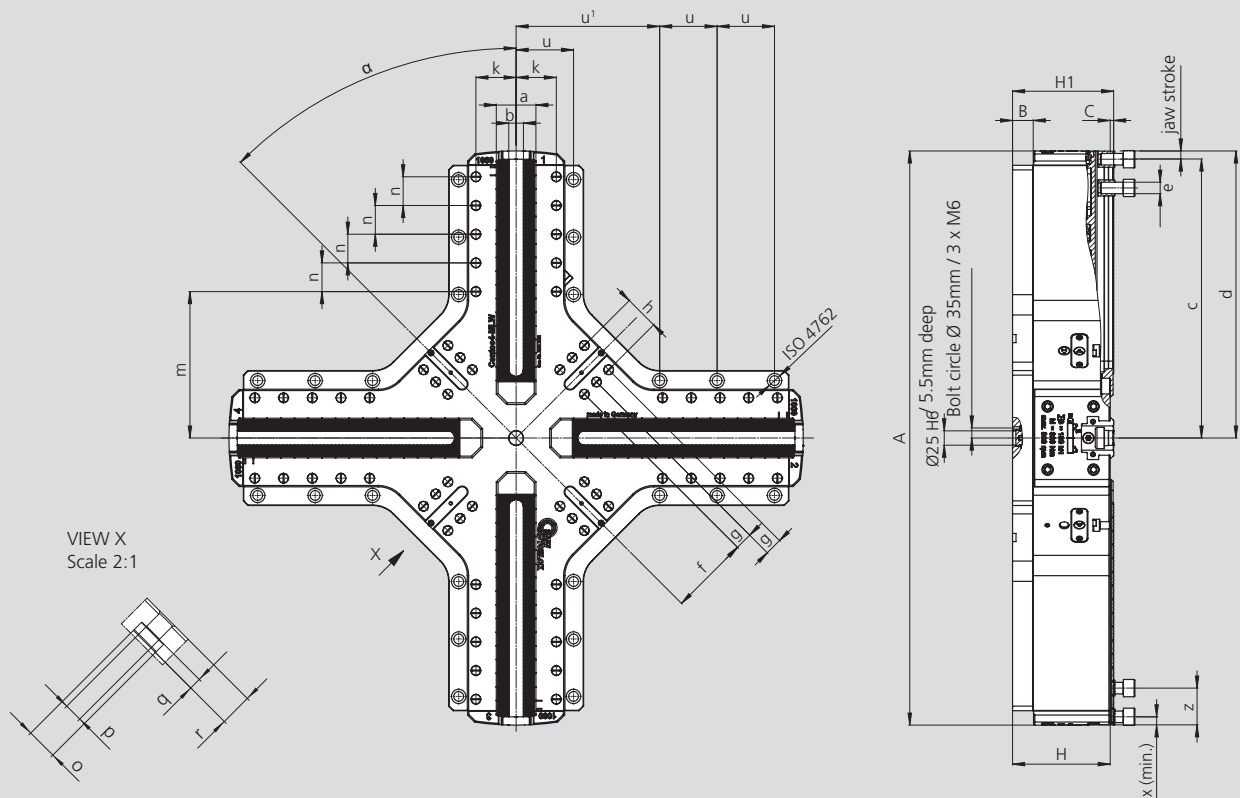
SMW-AUTOBLOK Type Centco4-MLW-D Id. No.			600-4 163210	750-4 163240
Outside diameter	A	mm	600	750
Base plate height	B	mm	30	30
	C	mm	6	6
Chuck height	H	mm	142	142
	H1	mm	148	148
Jaw width	a	mm	54	54
Slot width	H8 b	mm	21	21
Jaw position min.	c	mm	288	363
Jaw position max.	d	mm	300	375
Bolt ISO4762-12.9	e	mm	M16	M16
	f	mm	99	99
	g	mm	2 x 30	2 x 30
	h	mm	50	50
	k	mm	47	47
	m	mm	175	200
	n	mm	2 x 50	3 x 50
T-slot width	o	mm	24	24
T-slot width	p	mm	14	14
Height of width o	q	mm	9.2	9.2
Total depth T-slot	r	mm	25	25
	s/s'	mm	63 / 189	63 / 189
	t/t'	mm	100 / 200	100 / 200
	u/u'	mm	80 / 240	80 / 240
	w	mm	330.2	330.2
Min.	x	mm	12.5	12.5
Min. / max.	z	mm	25 / 177	25 / 245
	α	deg.	17.5	17.5
	β	deg.	45	45
	γ	deg.	45	45
Serration		inch	1/16"x 90°	1/16"x 90°
Max. speed		min ⁻¹	1200	1000
Max. total clamping force		kN	130	130
at max. actuating torque (Md)		Nm	200	200
Stroke per jaw		mm	12	12
Compensation stroke per jaw		mm	10	10
Weight (without jaws)		kg	165	201
Moment of inertia		kg·m ²	5.5	9.83

4-jaw manual chuck Ø 1000 - 1400 mm

- 2+2 self centering
- Independent self centering clamping in 2 axis
- Weight-optimized chuck body

Centco4-MLW-D

INCH
SERRATION



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

SMW-AUTOBLOK Type <i>Centco4</i> -MLW-D Id. No.			1000-4 163270	1200-4 163470	1400-4 163520
Outside diameter	A	mm	1000	1200	1400
Base plate height	B	mm	36	36	36
	C	mm	6	6	6
Chuck height	H	mm	170	170	170
	H1	mm	176	176	176
Jaw width	a	mm	69	69	69
Slot width	H8 b	mm	25.5	25.5	25.5
Min.	c	mm	486	586	686
Max.	d	mm	500	600	700
Bolt ISO4762-12.9	e	mm	M20	M20	M20
	f	mm	138	138	138
	g	mm	2 x 30	2 x 30	2 x 30
	h	mm	60	60	60
	k	mm	70	70	70
	m	mm	255	255	255
	n	mm	4 x 50	6 x 50	8 x 50
T-slot width	o	mm	30	30	30
T-slot width	p	mm	18	18	18
Height of width o	q	mm	12.2	12.2	12.2
Total depth T-slot	r	mm	30	30	30
	u/u'	mm	100 / 250	100 / 250	100 / 250
Min.	x	mm	14	14	14
Min. / max.	z	mm	50 / 350	50 / 450	50 / 550
	α	deg.	45	45	45
Serration		inch	3/32"x 90°	3/32"x 90°	3/32"x 90°
Max. speed		min ⁻¹	800	700	600
Max. total clamping force		kN	180	180	180
at max. actuating torque (Md)		Nm	320	320	320
Stroke per jaw		mm	14	14	14
Compensation stroke per jaw		mm	12	12	12
Weight (without jaws)		kg	410	480	530
Moment of inertia		kg·m ²	36.4	55.6	80

Ordering review

SMW-AUTOBLOK Type Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Id.-No.	163180	163210	163240	163270	163470	163520

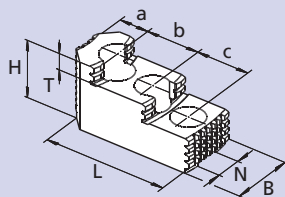
Equipment review

SMW-AUTOBLOK - Assembling tool	400-4	600-4	750-4	1000-4	1200-4	1400-4
Id.-No.	210860			210861		

Jaws

MHB-D (INCH SERRATION)

Hard, reversible stepped top jaws

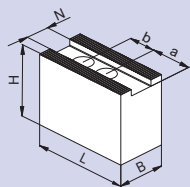


Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Jaw type	MHB-D 200	MHB-D 251	MHB-D 251	MHB-D 500	MHB-D 500	MHB-D 500
Id. No.	12082038	12083038	12083038	12084548	12084548	12084548
Serration	1/16" x 90°	1/16" x 90°	1/16" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
B	40	45	45	60	60	60
H	45	56	56	75	75	75
L	82	106.2	106.2	140.8	140.8	140.8
T	10.5	13.5	13.5	19	19	19
N	17	21	21	25.5	25.5	25.5
a	19	26	26	38	38	38
b	23	30	30	38	38	38
c	23	30	30	38	38	38
kg / set	2.3	2.9	2.9	9.5	9.5	9.5

MWB-D (INCH SERRATION)

Soft top jaws

Tall version

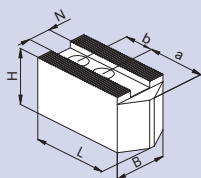


Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Jaw type	MWB-D 200	MWB-D 250	MWB-D 250	MWB-D 400	MWB-D 400	MWB-D 400
Id. No.	5318837	5319680	5319680	5319831	5319831	5319831
Serration	1/16" x 90°	1/16" x 90°	1/16" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
B	40	50	50	60	60	60
H	60	80	80	90	90	90
L	90	120	120	170	170	170
N	17	21	21	25.5	25.5	25.5
a	43	62	62	90	90	90
b	22	28	28	35	35	35
kg / set	4.1	9.2	9.2	21.6	21.6	21.6

AWB-D (INCH SERRATION)

Soft top jaws

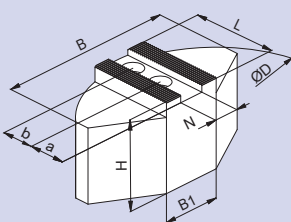
Low version



Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Jaw type	AWB-D 200	AWB-D 250	AWB-D 250	AWB-D 400	AWB-D 400	AWB-D 400
Id. No.	5318838	5319681	5319681	5319834	5319834	5319834
Serration	1/16" x 90°	1/16" x 90°	1/16" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
B	40	50	50	60	60	60
H	40	50	50	60	60	60
L	110	120	120	170	170	170
N	17	21	21	25.5	25.5	25.5
a	53	70	70	115	115	115
b	22	28	28	35	35	35
kg / set	2.7	5.4	5.4	14.5	14.5	14.5

SBS-D (INCH SERRATION)

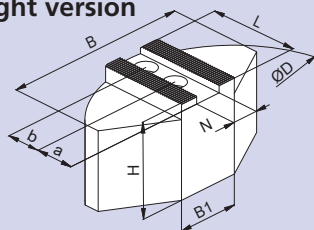
Soft pie jaws



Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Jaw type	SBS-D 200	SBS-D 600/4	SBS-D 600/4	SBS-D 1200/4	SBS-D 1200/4	SBS-D 1200/4
Id. No.	5318839	5322250	5322250	5322251	5322251	5322251
Serration	1/16" x 90°	1/16" x 90°	1/16" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
B	140	330	330	500	500	500
B1	64	50	50	60	60	60
D	200	190	190	445	445	445
H	60	85	85	85	85	85
L	70	140	140	155	155	155
N	17	21	21	25.5	25.5	25.5
a	35	75	75	85	85	85
b	22	29	29	35	35	35
kg / set	10.3	56.3	56.3	85.6	85.6	85.6

SBA-D (INCH SERRATION)

Soft pie jaws aluminium light version

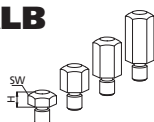


Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
Jaw type	SBA-D 200	SBS-A 600/4	SBS-A 600/4	SBA-D 1200/4	SBA-D 1200/4	SBA-D 1200/4
Id. No.	5318840	5322254	5322254	5322255	5322255	5322255
Serration	1/16" x 90°	1/16" x 90°	1/16" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
B	120	330	330	500	500	500
B1	40	50	50	60	60	60
D	200	190	190	445	445	445
H	58	85	85	85	85	85
L	72.5	140	140	155	155	155
N	17	21	21	25.5	25.5	25.5
a	35	75	75	85	85	85
b	22	29	29	35	35	35
kg / set	3.7	20.1	20.1	30.3	30.3	30.3

* SMW-AUTOBLOK is recommending not to clamp any diameters, that are larger than the chuck O.D.

SMW-AUTOBLOK Jaws-catalog
Request or download:
www.smw-autoblok.de

ALB

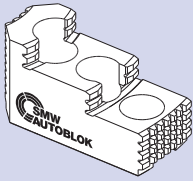


H [mm]	SW M10	SW M12	SW M16
10	210605	210058	210064
15	210606	210060	210065
20	210607	210061	210066
25	210608	210062	210067
30	210609	210063	210068

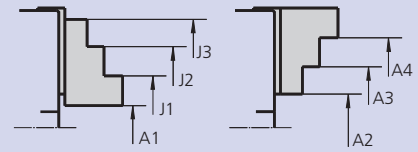
■ Clamping ranges

MHB-D (INCH SERRATION)

Hard, reversible stepped top jaws



Clamping ranges



Centco4-MLW-D	400	600	750	1000	1200	1400
Chuck Id. No.	163180	163210	163240	163270	163470	163520
MHB Id. No.	12082038	12083038	12083038	12084548	12084548	12084548
A1	74-299	87-458	101-609	96.5-814	96.5-1014	96.5-1214
A2	-	-	-	-	-	-
A3	124.5-321	178-550	236-698.5	221.5-938.5	221.5-1138.5	221.5-1338.5
A4	200-397.5	263-600	321-750*	320.5-1000*	320.5-1200*	320.5-1400*
J1	122-346	140.5-512	155-662	182.5-897	182.5-1097	182.5-1297
J2	196-400*	224.5-598	239-747.5	279.5-996	279.5-1196	279.5-1396
J3	238-400*	296.4-600*	311-750*	377-1000*	377-1200*	377-1400*

Note: min. 1 mm Residual jaw stroke
min. 1 mm Clamping stroke

* Not larger than chuck OD

JAWS-CATALOG

Request or
download:
www.smw-autoblok.de

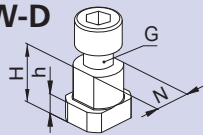


Centco4-MLW-D

INCH
SERRATION

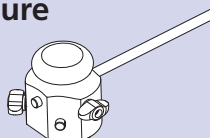
■ T-Nuts

NST T-Nuts suitable for Centco4- MLW-D



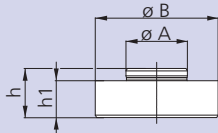
Centco4-MLW-D	400-4	600-4	750-4	1000-4	1200-4	1400-4
T-nut type	NST17	NST21	NST21	NST25	NST25	NST25
Id. No.	016021	014788	014788	014812	014812	014812
N	17	21	21	25.5	25.5	25.5
H	23	27	27	29	29	29
h	9	10	10	11	11	11
Cyl.-screw ISO 4762-12.9	G	M12 x 30	M16 x 35	M16 x 35	M20 x 40	M20 x 40
Torque Md max. (Nm)	70	150	150	250	250	250

Jaw pre-positioning fixture



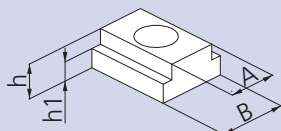
Centco4-MLW	400-4	600-4	750-4	1000-4	1200-4	1400-4
Id. No.	163518	163514	163514	163515	163516	163517

Center pin



Centco4-MLW	400-4	600-4	750-4	1000-4	1200-4	1400-4
Id. No.	163239					
Ø A	25 h6					
Ø B	50 g6					
h	20					
h1	15					

Slot-nuts



Id.-No.	209210	209194	209173
A	12	14	16
B	20	20	20
h	10	10	10
h1	5.5	5.5	5.5
Id.-No. Cyl.-screw (not included)	010166	010166	010166

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

Grease K67

Special grease for
manual and power chucks



Cartridge 14 Oz. (DIN 1284)
Grease content 500g
Id. No. 10731223

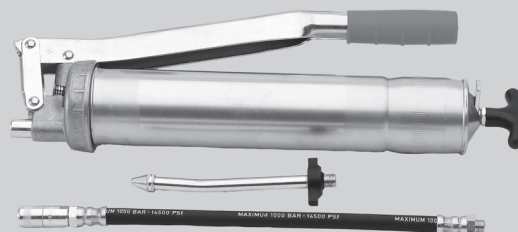
Can 1000 g
Id. No. 10731224



- 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)



Lubrication set Id. No. 083726

Supply range

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

Notes

**Germany**

SMW-AUTOBLOK Spannsysteme GmbH
Postfach 1151 • D-88070 Meckenbeuren
Wiesentalstraße 28 • D-88074 Meckenbeuren
Tel.: +49 (0) 7542 - 405 - 0
Vertrieb Inland ► vertrieb@smw-autoblok.de
Fax: +49 (0) 7542 - 3886
Sales International ► sales@smw-autoblok.de
Fax: +49 (0) 7542 - 405 - 181

**Italy**

AUTOBLOK s.p.a.
Via Duca D'Aosta n.24
Fraz. Novaretto
I-10040 Caprie - Torino
Tel. +39 011 - 9638411
Tel. +39 011 - 9632020
Fax +39 011 - 9632288
E-mail ► info@smwautoblok.it

**U.S.A.**

SMW-AUTOBLOK Corporation
285 Egidi Drive - Wheeling, IL 60090
Tel. +1 847 - 215 - 0591
Fax +1 847 - 215 - 0594
E-mail ► autoblok@smwautoblok.com

**France**

SMW-AUTOBLOK
17, Avenue des Frères Montgolfier - Z.I. Mi-Plaine
F-69680 Chassieu
Tel. +33 (0) 4 - 727 - 918 18
Fax +33 (0) 4 - 727 - 918 19
E-mail ► autoblok@smwautoblok.fr

**Japan**

SMW-AUTOBLOK Japan Inc.
1-56 Hira, Nishi-Ku
461-Nagoya
Tel. +81 (0) 52 - 504 - 0203
Fax +81 (0) 52 - 504 - 0205
E-mail ► japan@smwautoblok.co.jp

**Great Britain**

SMW-Autoblok Telbrook Ltd.
7 Wilford Industrial Estate
Ruddington Lane, Wilford
GB-Nottingham, NG11 7EP
Tel. +44 (0) 115 - 982 1133
E-mail ► info@smw-autoblok-telbrook.co.uk

**China**

SMW-AUTOBLOK (Shanghai) Work Holding Co.,Ltd.
Building 6, No.72, JinWen Road, KongGang
Industrial Zone, ZhuQiao Town, Pudong District
201323, Shanghai P.R. China
Tel. +86 21 - 5810 - 6396
Fax +86 21 - 5810 - 6395
E-mail ► china@smwautoblok.cn

**Spain**

SMW-AUTOBLOK IBERICA, S.L.
Ursalto 4 – Pab. 9-10 Pol. 27
20014 Donostia - San Sebastián (Gipuzkoa)
Tel.: +34 943 - 225 079
Fax: +34 943 - 225 074
E-mail ► info@smwautoblok.es

**Mexico**

SMW-AUTOBLOK Mexico, S.A. de C.V.
Acceso III No. 16 Int.9,
Condominio Quadrum
Industrial Benito Juárez
Querétaro, Qro. C.P. 76120
Tel. +52 (442) 209 - 5118
Fax +52 (442) 209 - 5121
E-mail ► smwmex@smwautoblok.mx

**Russia**

SMW-AUTOBLOK Russia
B.Tulskaya str., 10, bld.3, off. 323,
115191 Moscow (Russia)
Tel. +7 495 -231-1011
Fax +7 495 -231-1011
E-mail ► info@smw-autoblok.ru

**India**

SMW-AUTOBLOK Workholding Pvt. Ltd.,
Plot No. 4, Weikfield Industrial Estate,
Gat No. 1251, Sanaswadi, Tal - Shirur,
Dist – Pune, 412 208
Tel. +91 2137 - 616 974
Fax +91 2137 - 616 972
E-mail ► info@smwautoblok.in

**Taiwan**

AUTOBLOK Company Ltd.
No.6, Shuyi Rd., South Dist.,
Taichung, Taiwan
Tel. +886 4-226 10826
Fax +886 4-226 12109
E-mail ► taiwan@smwautoblok.tw

**Turkey**

SMW AUTOBLOK Makina San. Ve Tic. Ltd. Şti.
Yenişehir Mah, Osmanlı Blv, Volume Kurtköy Ofis
No:9, Kat:1, D:4, PK: 34912, Pendik, İstanbul
Tel. +90 216 629 - 2019
E-mail ► info@smwautoblok.com.tr

**Czech Republic / Slovakia**

SMW-AUTOBLOK s.r.o.
Merhautova 20
CZ - 613 00 Brno
Tel. +420 513 034 157
Fax +420 513 034 158
E-mail ► info@smw-autoblok.cz

**Sweden / Norway**

SMW-Autoblok Scandinavia AB
Kasernvägen 2
SE - 281 35 Hässleholm
Tel. +46 (0) 761 420 111
E-mail ► info@smw-autoblok.se

**Poland**

SMW-AUTOBLOK Poland Sp. z o.o.
Ul Ligocka 103 - Building 8
40-568 Katowice
Tel. +48 (0) 664 673 428
E-mail ► info@smwautoblok.pl

**Korea**

SMW-AUTOBLOK KOREA CO., LTD.
1108 ho, Baeksang Startower 1st,
65, Digital-ro 9-gil, Geumcheon-gu
Seoul, ROK-08511, Korea
Tel. +82 2 6267 9505
Fax +82 2 6267 9507
E-mail ► info-korea@smw-autoblok.net