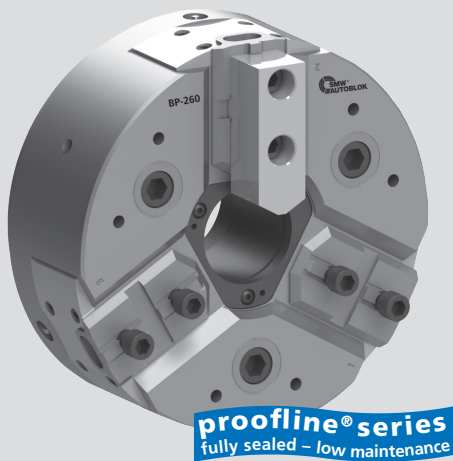


- Large through-hole
- 3 jaws
- proofline® chucks = fully sealed - low maintenance



### Application/customer benefits

- General use on standard lathes due to the through-hole, but with advantage of minimum maintenance and use also in extreme environments
- Longer life at high precision due to less wear
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used

**BP-C:** TONGUE & GROOVE master jaws (American Standard)

### Technical features

- Constant gripping force with permanent grease lubrication
- Large through-hole compatible with the standard machines
- 3-jaw version available in all diameters
- Proofline chucks = fully sealed - low maintenance

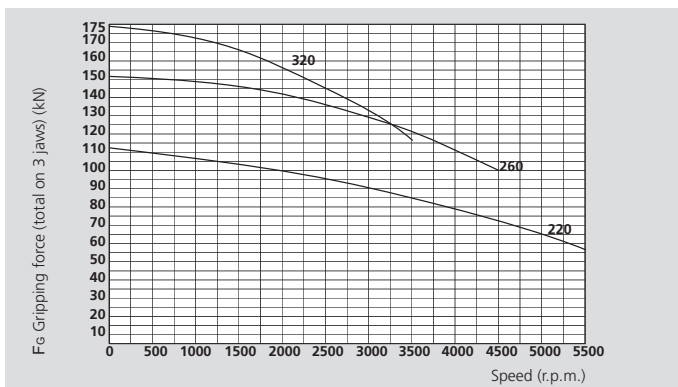
### Standard equipment

3-jaw chuck  
Mounting bolts

### Ordering example

3-jaw chuck BP-C 220 / Z170

## Actual gripping force diagram



The data in the diagram refers to 3-jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 grease. The static and dynamic gripping forces have been measured using standard soft top 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 bigger diameter reduce draw pull / rotating speed accordingly.

## Technical data

| SMW-AUTOBLOK Type                            |                   | BP-C 220        | BP-C 260        | BP-C 320        |
|----------------------------------------------|-------------------|-----------------|-----------------|-----------------|
| Number of jaws                               |                   | 3               | 3               | 3               |
| Through-hole                                 | mm                | 52              | 66              | 95              |
| Radial jaw stroke                            | mm                | 4               | 5               | 5               |
| Axial piston stroke                          | mm                | 16              | 19              | 19              |
| Max. actuation force*                        | kN                | 44              | 60              | 68              |
| Max. gripping force*                         | kN                | 110             | 150             | 175             |
| Max. speed                                   | r.p.m.            | 5500            | 4500            | 3500            |
| Weight (without top jaws)                    | kg                | 22              | 35              | 59              |
| Moment of inertia                            | kg·m <sup>2</sup> | 0.14            | 0.34            | 0.85            |
| Recommended actuating cylinders without hole |                   | SIN-S 100 / 125 | SIN-S 125 / 150 | SIN-S 125 / 150 |
| Recommended actuating cylinders with hole    |                   | VNK-T2 130-52   | VNK-T2 150-67   | VNK-T2 225-95   |
| Id. No. BP-C 3 jaws (Center mounting)        |                   | 77189322        | 77189326        | 77189332        |

\* For internal clamping reduce the draw pull by 30%.



SMW-AUTOBLOK  
466



SMW-AUTOBLOK  
468



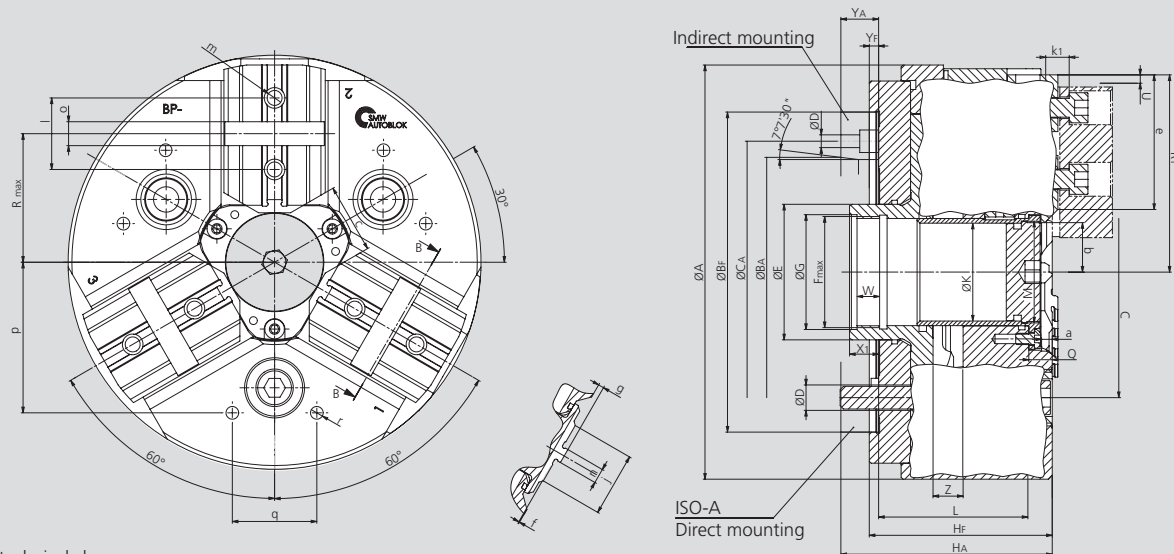
SMW-AUTOBLOK  
327

# High precision power chuck Ø 220 - 320 mm

- Large through-hole
- 3 jaws
- proofline® chucks = fully sealed - low maintenance

## BP-C

TONGUE & GROOVE



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

| SMW-AUTOBLOK Type |                 |    | BP-C 220  |         | BP-C 260 |         |         | BP-C 320 |         |         |
|-------------------|-----------------|----|-----------|---------|----------|---------|---------|----------|---------|---------|
| Mounting          |                 |    | Z170      | A6      | Z220     | A6      | A8      | Z300     | A8      | A11     |
|                   | <b>A</b>        | mm | 220       |         | 262      |         |         | 320      |         |         |
|                   | <b>Bf/BA</b> H6 | mm | 170       | 106.375 | 220      | 106.375 | 139.719 | 300      | 139.719 | 196.869 |
|                   | <b>C</b>        | mm | 133.4     |         | 171.4    |         |         | 235      |         |         |
|                   | <b>CA</b>       | mm | -         | -       | -        | 133.4   | -       | -        | 171.4   | -       |
|                   | <b>D</b>        | mm | 13.5      |         | 17       | 13.5    | 17      | 21       |         |         |
|                   | <b>E</b>        | mm | 72        |         | 88       |         |         | 115      |         |         |
|                   | <b>Fmax</b>     | mm | M60 x 1.5 |         | M75 x 2  |         |         | M102 x 2 |         |         |
|                   | <b>G</b>        | mm | 61        |         | 76       |         |         | 102.5    |         |         |
|                   | <b>Hf/HA</b>    | mm | 97.5      | 109.5   | 114      | 149     | 128     | 114      | 149     | 130     |
|                   | <b>K</b>        | mm | 52        |         | 66       |         |         | 95       |         |         |
|                   | <b>L</b>        | mm | 79.5      |         | 92       |         |         | 88       |         |         |
|                   | <b>M</b>        | mm | M54 x 1.5 |         | M68 x 2  |         |         | M98 x 2  |         |         |
|                   | <b>Q</b>        | mm | 12.5      |         | 16.5     |         |         | 16.5     |         |         |
| Chuck open        | <b>R1</b>       | mm | 109       |         | 131      |         |         | 159      |         |         |
| Max.              | <b>R</b>        | mm | 72.5      |         | 89       |         |         | 115      |         |         |
| Jaw stroke        | <b>U</b>        | mm | 4.3       |         | 5        |         |         | 5        |         |         |
|                   | <b>W</b>        | mm | 12        |         | 14       |         |         | 16.5     |         |         |
|                   | <b>X1</b>       | mm | 15.5      |         | 22       |         |         | 25       |         |         |
|                   | <b>Yf/YA</b>    | mm | 5         | 17      | 5        | 40      | 19      | 5        | 40      | 21      |
| Max. / min.       | <b>Z</b>        | mm | 16 / 0    |         | 19 / 0   |         |         | 19 / 0   |         |         |
|                   | <b>a</b>        | mm | 5.7       |         | 9.7      |         |         | 9.7      |         |         |
| Min.              | <b>b</b>        | mm | 26.5      |         | 36       |         |         | 48       |         |         |
| Min.              | <b>c</b>        | mm | 37        |         | 52       |         |         | 70       |         |         |
|                   | <b>e</b>        | mm | 74.5      |         | 82       |         |         | 98       |         |         |
|                   | <b>f</b>        | mm | 0         |         | 3        |         |         | 4        |         |         |
|                   | <b>g</b>        | mm | 3         |         | 0        |         |         | -1       |         |         |
|                   | <b>j</b>        | mm | 34        |         | 46       |         |         | 58       |         |         |
|                   | <b>k1</b>       | mm | 9         |         | 13.5     |         |         | 15.5     |         |         |
|                   | <b>l</b>        | mm | 38        |         | 44.4     |         |         | 54       |         |         |
|                   | <b>m</b>        | mm | M10       |         | M12      |         |         | M16      |         |         |
|                   | <b>n</b> h7     | mm | 7.94      |         | 7.94     |         |         | 12.7     |         |         |
|                   | <b>o</b> H7     | mm | 12.68     |         | 12.68    |         |         | 19.03    |         |         |
|                   | <b>p</b>        | mm | 80        |         | 102      |         |         | 100      |         |         |
|                   | <b>q</b>        | mm | 45        |         | 60       |         |         | 60       |         |         |
|                   | <b>r</b>        | mm | M8        |         | M10      |         |         | M10      |         |         |