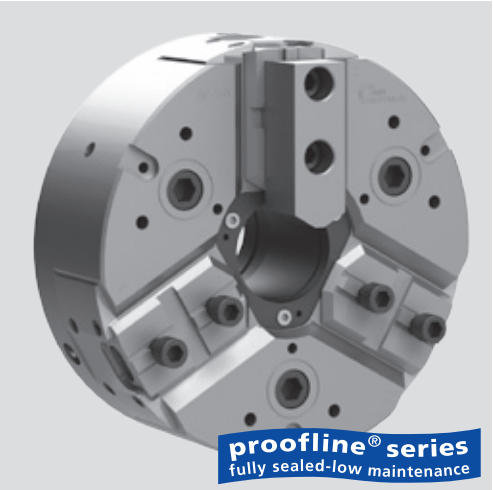
BP-C

Tongue & groove

High precision power chucks Ø 220 - 320 mm

■ LARGE THROUGH HOLE
■ 3 jaws



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

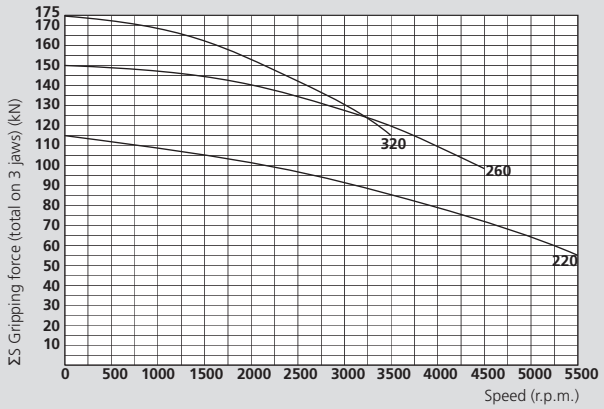
Standard equipment

3 jaw chuck
Mounting bolts

Ordering example

3 jaw chuck BP-C 220/Z170

Actual gripping force diagrams



The data in the diagram refer 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. draw pull*	kN	38	60	68
Max. gripping force*	kN	115	150	175
Max. speed	r.p.m.	5500	4500	3500
Weight (without top jaws)	kg	22	35	59
Moment of inertia	kg·m²	0.14	0.34	0.85
Recommended actuating cylinders		**SIN-S 100/125**	**SIN-S 125/150**	**SIN-S 125/150**
		VNK 130-52	**VNK 150-67**	**VNK 225-95**

* For internal clamping reduce the draw pull by 30 %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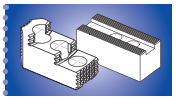
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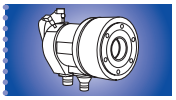
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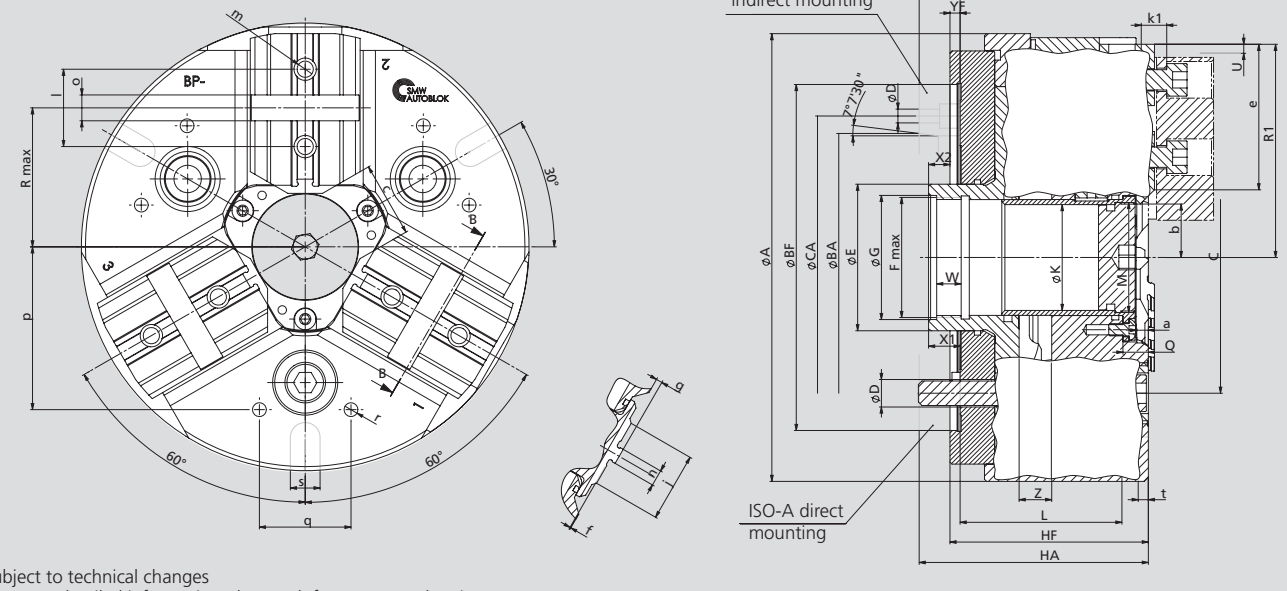

Subject to technical changes
For more detailed information please ask for customer drawing

SMW-AUTOBLOK Type			BP-C 220		BP-C 260			BP-C 320		
Mounting			Z170	A6	Z220	A6	A8	Z300	A8	A11
	A	mm	220			262			320	
	B_F/B_A H6	mm	170	106.375	220	106.375	139.719	300	139.719	196.869
	C	mm	133.4			171.4			235	
	C_A	mm	-	-	-	133.4	-	-	171.4	-
	D	mm	13.5		17	13.5	17		21	
	E	mm	72			88			115	
	Fmax	mm	M60 x 1.5			M75 x 2			M102 x 2	
	G	mm	61			76			102.5	
	H_F/H_A	mm	97.5	109.5	114	149	128	121	163	137
	K	mm	52			66			95	
	L	mm	79.5			92			95	
	M	mm	M54 x 1.5			M68 x 2			M98 x 2	
	Q	mm	12.5			16.5			16.5	
Chuck open	R1	mm	109			131			159	
Jaw stroke	R	mm	72.5			89			115	
	U	mm	4.3			5			5	
	W	mm	12			14			16.5	
	X_1/X_2	mm	15.5 / 10.5			22 / 17			25 / 20	
max./min.	Y_F/Y_A	mm	5	17	5	40	19	5	47	21
	Z	mm	16 / 0			19 / 0			19 / 0	
Serration	a	mm	5.7			9.7			9.7	
	b	mm	26.5			36			48	
	c	mm	37			52			70	
	e	mm	74.5			82			98	
	f	mm	0			3			4	
	g	mm	3			0			-1	
	j	mm	34			46			58	
max./min.	k_1	mm	9			13.5			15.5	
	l	mm	38			44.4			54	
	m	mm	M10			M12			M16	
	n h7	mm	7.94			7.94			12.7	
	o H7	mm	12.68			12.68			19.03	
	p	mm	80			102			100	
	q	mm	45			60			60	
	r	mm	M8			M10			M10	
	s H12	mm	-			16			-	
	t	mm	-			5			-	