

HB-D

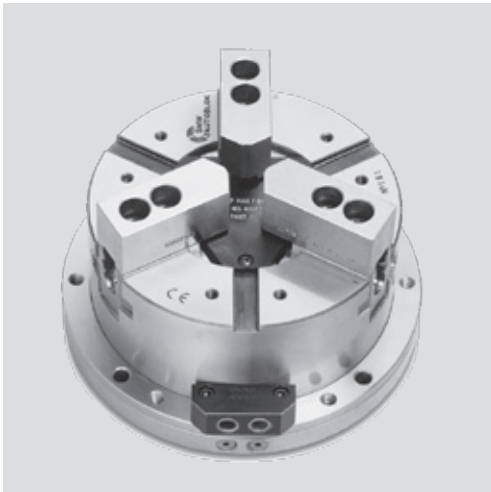
INCH serration
2 or 3 jaws

HB-C

Tongue & groove
3 jaws

Stationary chuck, hydraulic Ø 165 - 315 mm

- built-in hydraulic cylinder
- 2 and 3 jaws



Application/customer benefits

- Stationary hydraulic chuck for self centering clamping of parts on milling machines/machining centers/special machines

HB-D: inch serrated master jaws (1/16" x 90°)

HB-C: tongue & groove master jaws (American standard)

HB-M: metric serrated master jaws (1.5 mm x 60°) **on request**

Technical features

- Stationary chuck consisting of a 2/3 jaw self centering chuck with built-in hydraulic cylinder
- Compact design
- Case hardened body to assure highest precision and long chuck life

Standard equipment

Stationary chuck
 1 set T-nuts with bolts (HB-C excluded)
 1 set of soft blank top jaws (HB-C excluded)
 Grease gun

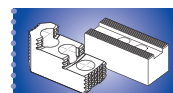
Ordering example

3 jaw chuck HB-C 250
 or
 2 jaw chuck HBL-D2 165

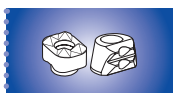
Technical data

| SMW-AUTOBLOK Type | | HB-D 165 HB-C 165 | HB-D 210 HB-C 210 | HB-D 250 HB-C 250 | HB-D 315 HB-C 315 |
|---|-----------------|----------------------|----------------------|----------------------|----------------------|
| Radial jaw stroke | mm | 3.2 | 4 | 4.6 | 5.5 |
| Radial jaw stroke HBL-D2 (2 jaws)* | mm | 6 | 7.5 | 8.8 | 10.5 |
| Piston area | cm ² | 79 | 114 | 167 | 203 |
| Max. operating pressure | bar | 30 | 30 | 30 | 30 |
| Gripping force at 25 bar | kN | 55 | 85 | 125 | 150 |
| Gripping force at 25 bar HBL-D2 (2 jaws)* | kN | 35 | 52 | 75 | 90 |
| Weight (without top jaws) | kg | 18 | 30 | 44 | 69 |

*The 2 jaw fixture is available with serrated master jaws (inch or metric) and long stroke only.



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Stationary chuck, hydraulic Ø 165 - 315 mm

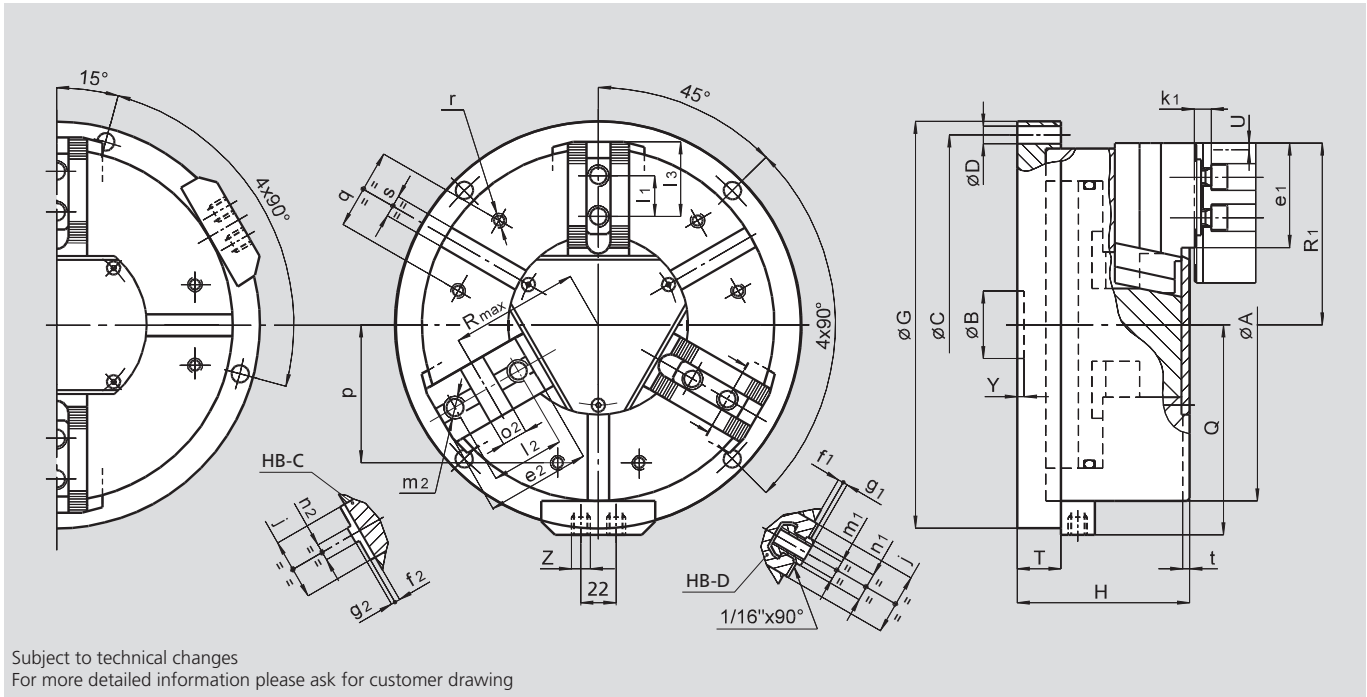
- built-in hydraulic cylinder
- 2 and 3 jaws

HB-D

INCH serration
2 or 3 jaws

HB-C

Tongue & groove
3 jaws



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

Common dimensions

| SMW-AUTOBLOK Type | | HB-D 165 HB-C 165 | HB-D 210 HB-C 210 | HB-D 250 HB-C 250 | HB-D 315 HB-C 315 |
|-----------------------------------|--------------|----------------------|----------------------|----------------------|----------------------|
| | A | mm | 170 | 215 | 315 |
| | B | mm | 30 | 35 | 50 |
| Fixing holes circle | C | mm | 190 | 235 | 340 |
| Fixing holes diameter | D | mm | 11 | 11 | 13 |
| | G | mm | 210 | 255 | 360 |
| | H | mm | 100 | 117 | 141 |
| | Q | mm | 110 | 133 | 183 |
| | T | mm | 27 | 30 | 32 |
| Radial jaw stroke (3 jaws) | U | mm | 3.2 | 4 | 5.5 |
| Radial jaw stroke HBL-D2 (2 jaws) | U | mm | 6 | 7.5 | 10.5 |
| | Y | mm | 5 | 5 | 5 |
| Hydraulic connections | Z | inch | R1/4" | R1/4" | R1/4" |
| | j | mm | 30 | 36 | 45 |
| | k1 | mm | 10 | 11 | 12 |
| | p | mm | 65 | 80 | 102 |
| | q | mm | 36 | 45 | 60 |
| | r | mm | M8 | M8 | M10 |
| | s H12 | mm | 16 | 16 | 16 |
| | t | mm | 5 | 5 | 5 |

HB-D and HBL-D2 fixtures dimensions

| SMW-AUTOBLOK Type | | HB-D 165 | HB-D 210 | HB-D 250 | HB-D 315 |
|----------------------------|--------------|----------|----------|----------|----------|
| | e1 | mm | 48 | 60 | 99 |
| | f1 | mm | 4 | 3 | 4 |
| | g1 | mm | 2.5 | 2.5 | 3.5 |
| | l1 | mm | 16.5 | 23 | 30 |
| T-nut position min./max. | l3 | mm | 24/40 | 33/50 | 43/84 |
| | m1 | mm | M10 | M12 | M16 |
| | n1 h8 | mm | 14 | 17 | 21 |
| Chuck open (3 jaws) | R1 | mm | 89 | 110 | 162 |
| Chuck open HBL-D2 (2 jaws) | R1 | mm | 92 | 114 | 168 |

HB-C fixtures dimensions (available only in 3 jaw chuck version)

| SMW-AUTOBLOK Type | | HB-C 165 | HB-C 210 | HB-C 250 | HB-C 315 |
|-------------------|--------------|----------|----------|----------|----------|
| | e2 | mm | 54 | 71 | 99 |
| | f2 | mm | 4 | 4 | 4 |
| | g2 | mm | 3 | 3 | 3 |
| | l2 | mm | 38 | 44.4 | 63.5 |
| | m2 | mm | M10 | M12 | M16 |
| | n2 h8 | mm | 7.94 | 7.94 | 12.70 |
| | o2 H7 | mm | 12.68 | 12.68 | 19.03 |
| Chuck open | R1 | mm | 89 | 110 | 162 |
| Chuck open | Rmax | mm | 62 | 77 | 109 |