

Overview Pipe

Customer's OCTG product:

- Straight pipe
- Bent pipe

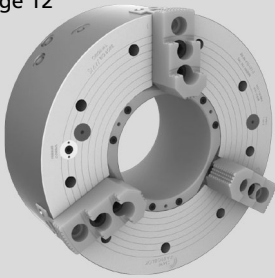
CHUCK

APPLICATION

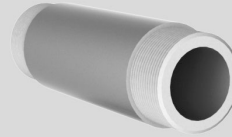
OCTG PRODUCT

CUSTOMER BENEFITS

BB-N
Page 12

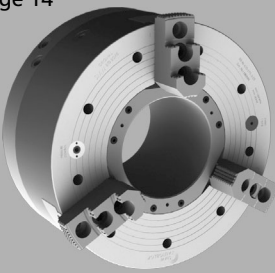


Threading of straight pipe with the original SMW Big Bore Type BB-N.

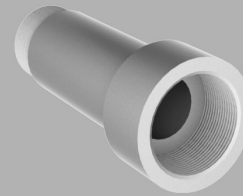


- **Quick jaw movement** more pipe per hour
- Can be used for other work pieces besides piping
- O.D. and I.D. clamping

BB-N-ES
Page 14

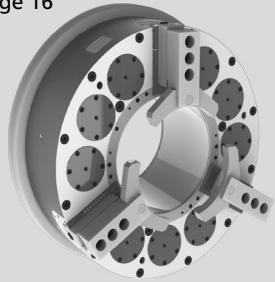


Threading of straight pipe with upset ends with the original SMW Big Bore Type BB-N-ES.

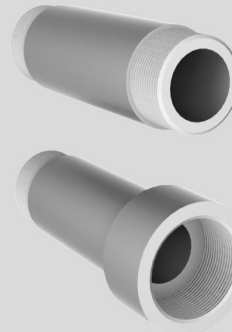


- **Quick jaw movement** more pipe per hour
- Large jaw stroke for easy loading of pipe and less danger of damaging threads when unloading

BB-SC
Page 16

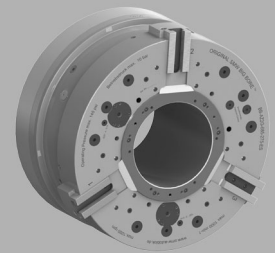


High production **spring clamp** chuck for threading of straight pipe with or without upset ends with the original SMW Big Bore Type BB-SC.



- **Full jaw stroke in 2 seconds** for highest productivity
- Fully sealed/low maintenance for highest availability of the machine
- Safe clamping of pipe even in longer machining processes with spring clamp technology

BB-AZ2G
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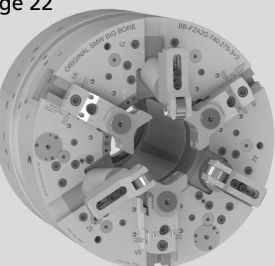


Threading of straight and bent pipe with the original SMW Big Bore Type BB-AZ2G.



- **Self centering or compensating clamping** for universal use
- Quick jaw movement
- External centering device needed when used in compensating mode
- O.D. clamping only

BB-FZA2G
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Threading of straight and bent pipe with integrated centering jaws with the original SMW Big Bore Type BB-FZA2G.



- **Integrated centering jaws for the pipe** = no external centering device needed
- Quick jaw movement
- Fully automatic programmable cycle

Pipe Clamping

Recommended Combinations

Self centering clamping	Self centering or compensating clamping	3+3-Combination
<p>Combination A</p> <p>Pipe Loading</p> <p>Rear Chuck Front Chuck</p> <p>Note: This combination can be only used for straight pipe!</p>	<p>Combination B</p> <p>Pipe Loading</p> <p>Rear Chuck Front Chuck</p> <p>Centering</p>	<p>Combination C</p> <p>Pipe Loading</p> <p>Rear Chuck Front Chuck</p> <p>Note: No centering necessary!</p>
<p>Combination D</p> <p>Pipe Loading</p> <p>Rear Chuck Front Chuck</p> <p>Centering</p>	<p>Combination E</p> <p>Pipe Loading</p> <p>Rear Chuck Front Chuck</p> <p>Note: No centering necessary!</p>	

Respective chuck matrix:

Self centering clamping	Self centering or compensating clamping	3 jaw + 3 jaw combination
<p>BB-N/ BB-N-ES Page 12/14</p>	<p>BB-AZ2G Page 18</p>	<p>BB-FZA2G Page 22</p>
<p>BB-SC Page 16</p>		

Centering options:

	<p>Chuck CC Page 20</p>	<p>Turret by customer</p>
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BIG BORE® BB-SC

INCH SERRATION

Front-end spring clamp power chucks EXTRA large through hole Ø 275 - 565 mm

- Chuck size 600 - 1020
- Clamping with spring packs
- Rapid and clamping stroke



Application/customer benefits

- End machining of long pipe/self centering clamping
- Long jaw stroke to clear upset piping
- Highest productivity/open and clamp time < 3 sec.
- Low maintenance = high availability of the machine
- Step mode for partial opening/clamping for shimming possible
- Full spindle bore can be used

Technical features

- Self centering clamping with either 9/6/3 spring packs
- Encapsulated spring packs
- Opening via integrated cylinder
- Permanent grease lubricated for constant grip force
- Step mode for opening/clamping for shimming
- Long jaw stroke with rapid and clamping stroke
- Low air consumption
- Stroke control
- **proofline® chucks** = fully sealed – low maintenance

Standard equipment

- Chuck with mounting bolts
- 1 set of soft top jaws
- 1 set of T-nuts and bolts

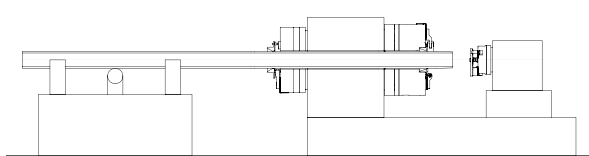
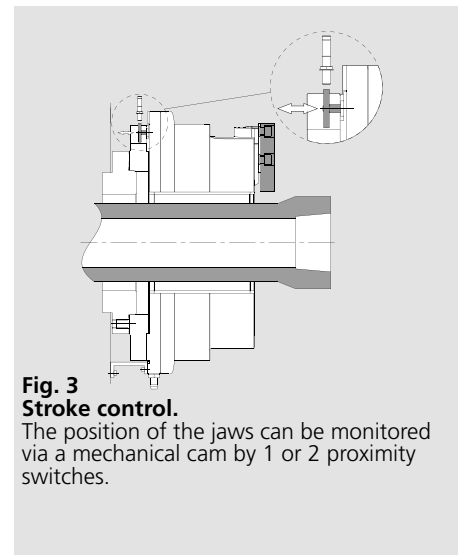
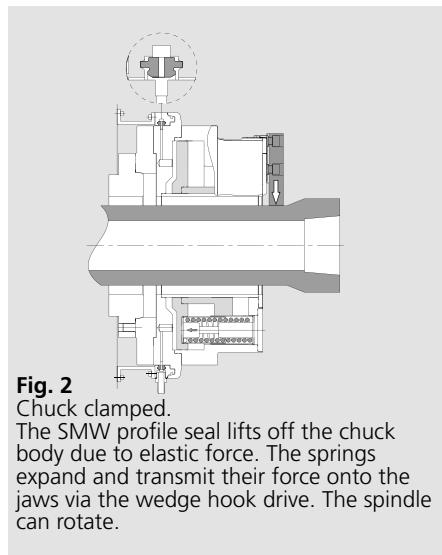
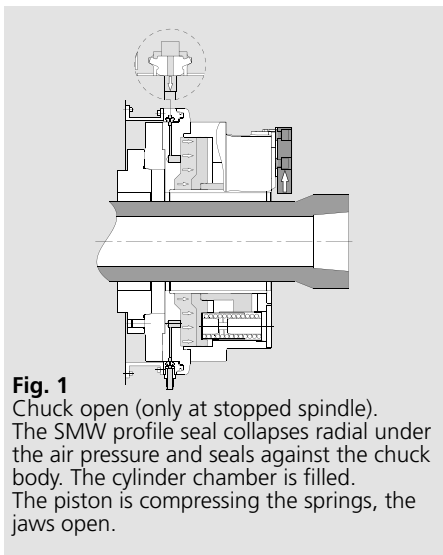
Ordering example

Big Bore SC 850-395
Id. No. 053350

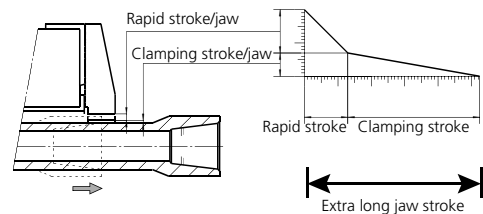
Accessories

Air control AC-SC

The reliable principle: Clamping via encapsulated spring packs/opening via air cylinder



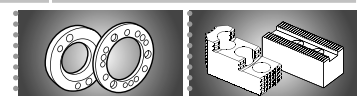
End machining of tubes with front and rear chucks



Technical data

SMW-AUTOBLOK Type		BB-SC 600-275			BB-SC 850-395			BB-SC 1020-565		
Id. No.		053540			053350			053570		
Chuck trough hole	mm (inch)	275 (10.83")			395 (15.55")			565 (22.24")		
Total stroke per jaw	mm (inch)	25.4 (1")			27 (1.06")			27 (1.06")		
Rapid stroke per jaw*	mm (inch)	16.9 (0.67")			15 (0.59")			15 (0.59")		
Clamping stroke per jaw	mm (inch)	8.5 (0.33")			12 (0.47")			12 (0.47")		
Operating pressure at 9 springs	bar (psi)	5 (73)			5 (73)			5 (73)		
Max. gripping force at 3/6/9 springs	kN (lbf)	50 (11240)	100 (22480)	150 (33721)	57 (12814)	113 (25403)	170 (38218)	57 (12814)	113 (25403)	170 (38218)
Max. speed	r.p.m.	1000			700			420		
Air consumption to open at 5 bar (73 psi)	liter	60			115			139		
Weight (without jaws)	kg (lbs)	510 (1124)			930 (2050)			1260 (2779)		
Moment of inertia	kg·m ²	34			101			223		

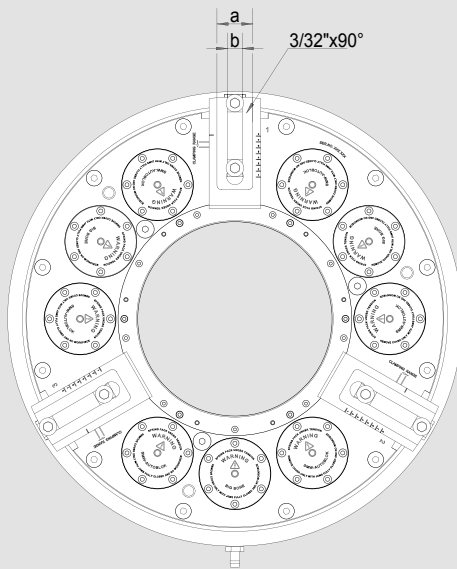
* Could not be used for clamping



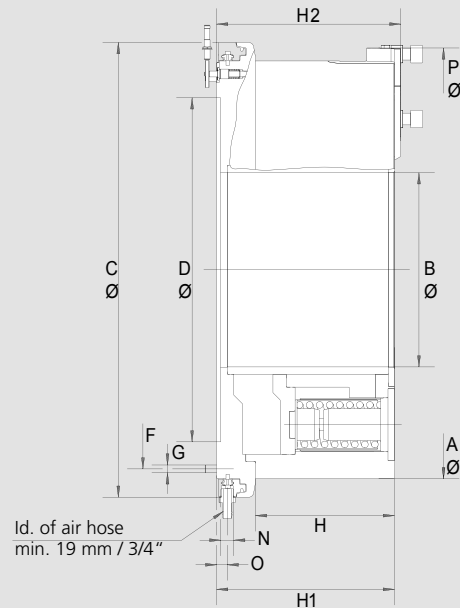
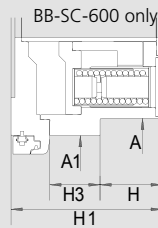
SMW-AUTOBLOK
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SMW-AUTOBLOK
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Main dimensions and technical data



Opening pressure with all springs mounted
min. 5 bar (73 psi), max. 8 bar (116 psi)



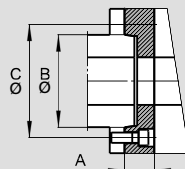
Id. of air hose
min. 19 mm / 3/4"

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

SMW-AUTOBLOK Type			BB-SC 600-275	BB-SC 850-395	BB-SC 1020-565
Mounting			Z520	Z700	Z870
	A	mm	605	850	1020
(BB-SC-600-275)	A1	mm	675	-	-
Through hole	B	mm	275	395	565
	C	mm	750	925	1095
	D H6	mm	520	700	870
	F	mm	640	810	980
	G		M12 (12x)	M16 (12x)	M16 (12x)
	H		126.7	282.5	282.5
	H1		307.5	361.5	361.5
	H2		320.5	374.5	374.5
(BB-SC-600-275)	H3		102	-	-
	N		G 3/4"	G 3/4"	G 3/4"
	O		21.5	21.5	21.5
Max. swing	P		655.8	902.8	1074
	a		58	73	73
	b		25.5	30	30
Rapid stroke		mm	16.9	15	15
Clamping stroke		mm	8.5	12	12
Total clamping stroke		mm	25.4	27	27

Spindle-Adapters

Spindle-Adapters
ISO-A DIN 55026



BB-SC	600-275			850-395		1020-565		
Spindle nose	A11	A15	A20	A15	A20	A15	A20	A28
Id. No.	on request	053590	053591	053362	053358	on request	053595	053596