

BB-DINCH
SERRATION**BB-M**METRIC
SERRATION**High precision power chuck Ø 140 - 315 mm**

- EXTRA large through-hole
- 3 jaws

Application/customer benefits

- For open center or partial open center clamping
- For machines with very large spindle bore

BB-D: Master jaws with INCH SERRATION (1/16" x 90°)**BB-M:** Master jaws with METRIC SERRATION (1.5 mm x 60°)
(Suitable for Japanese chucks top jaws)**Technical features**

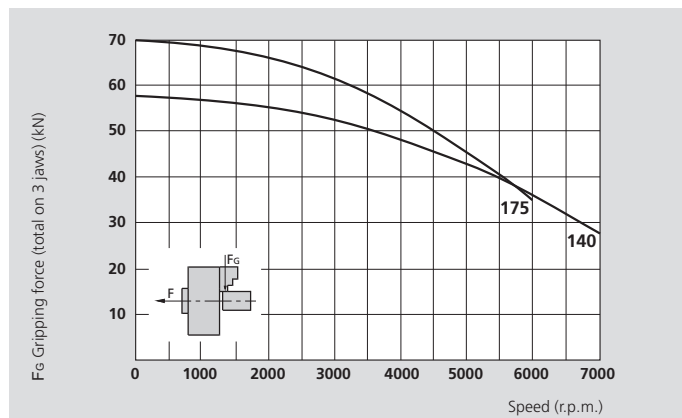
- EXTRA large through-hole
- Gripping force transmission via wedge hook
- Case hardened body to assure greatest precision and long chuck life

Standard equipment

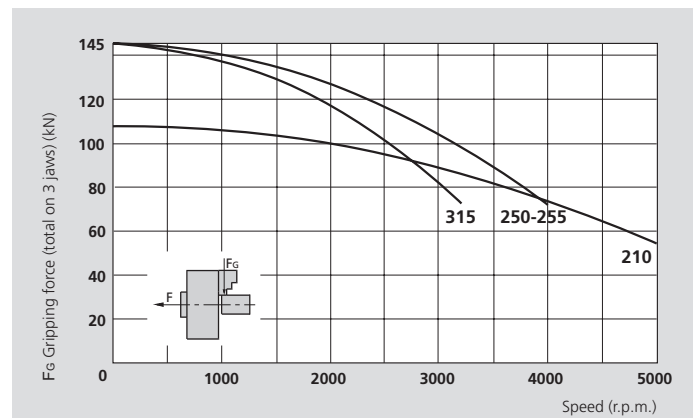
3-jaw chuck
1 set T-nuts with bolts
1 set soft top jaws
Mounting bolts

Ordering example

3-jaw chuck BB-D 175 / A6
or
3-jaw chuck BB-M 250 / Z220

**Actual gripping force diagrams**

The data in the diagrams 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

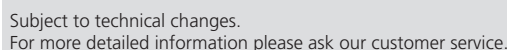
SMW-AUTOBLOK Type		BB-D 140 BB-M 140	BB-D 175 BB-M 175	BB-D 210 BB-M 210	BB-D 250 BB-M 250	BB-D 255 BB-M 255	BB-D 315 BB-M 315
Number of jaws		3	3	3	3	3	3
Through-hole	mm	39	56	66	78	82	122
Radial jaw stroke	mm	3.2	3.2	4	5	5	5
Axial piston stroke	mm	15	15	19	24	24	24
Max. draw pull*	kN	22	25	38	50	50	50
Max. gripping force*	kN	58	70	108	145	145	145
Max. speed	r.p.m.	7000	6000	5000	4000	4000	3200
Weight (without top jaws)	kg	6	11.5	19.5	30	33	44
Moment of inertia	kg·m²	0.016	0.05	0.12	0.27	0.32	0.62
Recommended actuating cylinders without hole		SIN-S 85 / 100	SIN-S 100	SIN-S 100 / 125	SIN-S 125 / 150	SIN-S 125 / 150	SIN-S 125 / 150
Recommended actuating cylinders with hole		VNK-T2 70-37	VNK-T2 130-52	VNK-T2 150-67	VNK-T2 170-77	VNK-T2 176-82	VNK-T2 320-127
Id. No. BB-D 3 jaws (Center mounting)		77150714	77150917	77150921	77150725	77150726	77150731
Id. No. BB-M 3 jaws (Center mounting)		77150814	77151117	77151121	77151025	77151026	77150831

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

SMW-AUTOBLOK
466SMW-AUTOBLOK
468SMW-AUTOBLOK
327

BB-M

**METRIC
SERRATION**



(1) Rotating ring-nut with thread	$W_1 = \text{BBD-BBM}$	(2) Blank rotating ring-nut without thread	$W_3 = \text{BBD-BBM}$
Fixed ring-nut with thread	$W_2 = \text{BBD-BBM}$	Fixed ring-nut blank without thread	$W_4 = \text{BBD-BBM}$