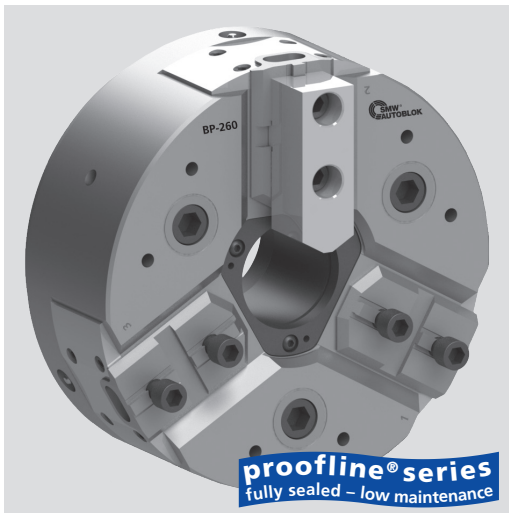


- Large through hole
- 3 jaws
- proofline® chucks = fully sealed – low maintenance



### 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

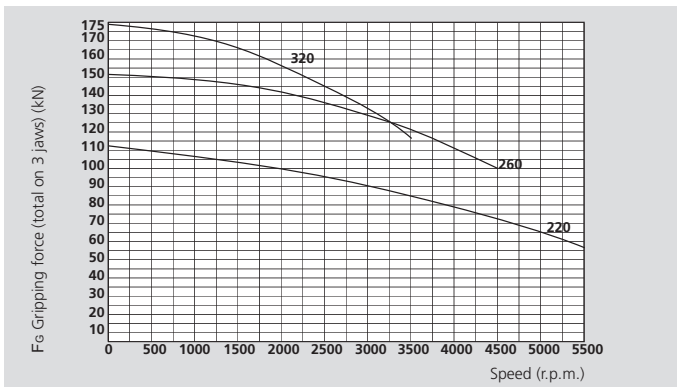
### Standard equipment

3 jaw chuck  
Mounting bolts

### Ordering example

3 jaw chuck BP-C 220 / Z170

## Actual gripping force 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.

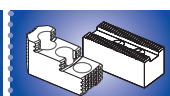
## Technical data

SMW-AUTOBLOK Type		BP-C 220	BP-C 260	BP-C 320
<b>Number of jaws</b>		<b>3</b>	<b>3</b>	<b>3</b>
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
<b>Recommended actuating cylinders</b>		<b>SIN-S 100 / 125</b> <b>VNK-T2 130-52</b>	<b>SIN-S 125 / 150</b> <b>VNK-T2 150-67</b>	<b>SIN-S 125 / 150</b> <b>VNK-T2 225-95</b>

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



SMW-AUTOBLOK  
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SMW-AUTOBLOK  
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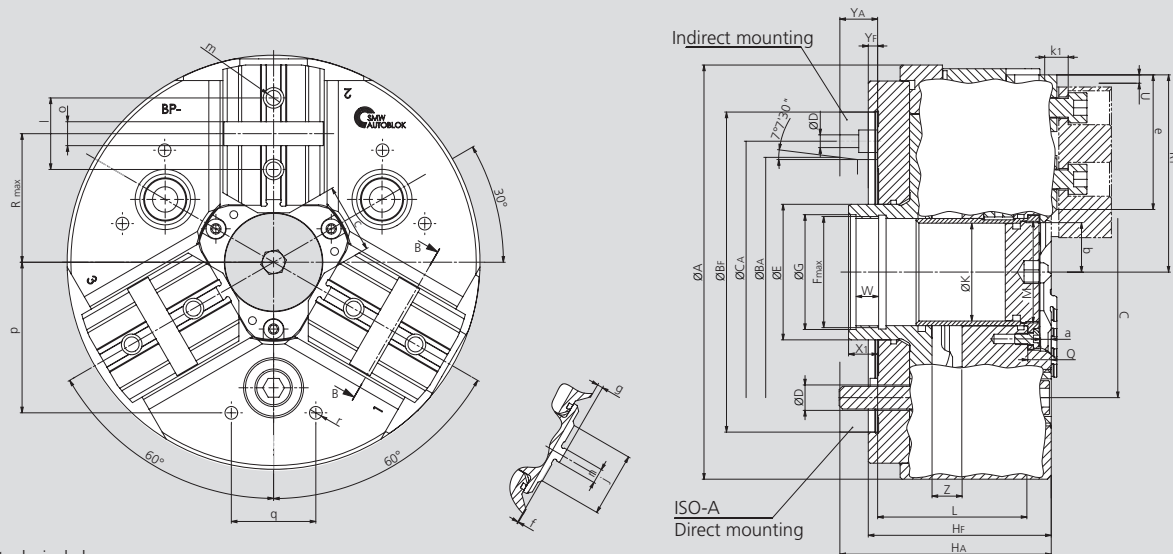
SMW-AUTOBLOK  
297

# High precision power chucks Ø 220 - 320 mm

# BP-C

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

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>X<sub>1</sub></b>	mm	15.5		22			25		
Max. / min.	<b>YF/YA</b>	mm	5	17	5	40	19	5	40	21
	<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>k<sub>1</sub></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		