

CUSTOMER BENEFITS

SMW-AUTOBLOK is the inventor



SMW-AUTOBLOK - the inventor and pacemaker in technology for OCTG chucks. More than 40 years of experience ensure the highest productivity for all of our customers.

Worldwide Service + Support



Our worldwide SMW-AUTOBLOK network guarantees immediate service, availability of parts and support wherever needed.

Partner of oil industry



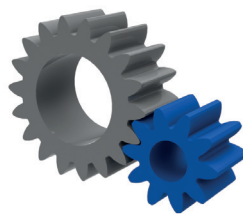
Working closely with our customers, we are able to provide new and innovative solutions as challenges arise.

Widest range of OCTG products



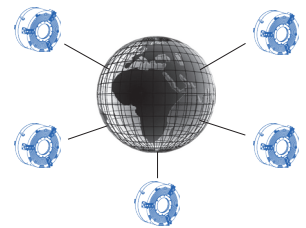
SMW-AUTOBLOK offers a complete range of OCTG chucks as standard products. The need for expensive "special product" chucks with long lead times is eliminated.

Fast time and high accuracy



Improving production processes with rapid chuck actuation, SMW-AUTOBLOK's OCTG chucks increase productivity and decrease machine downtimes.

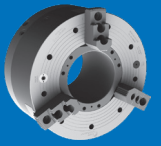


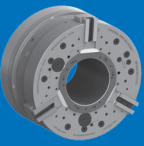

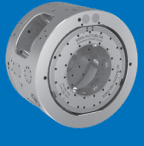
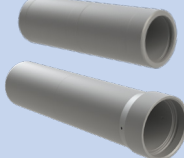




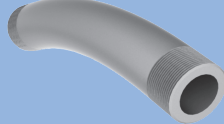




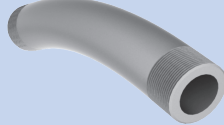

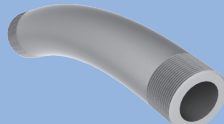

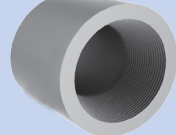

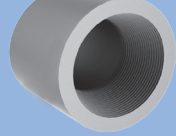




Applications worldwide



5 continents - 1 partner: All major players in the OCTG industry on 5 continents trust in SMW-AUTOBLOK as their reliable workholding partner.

Chuck finder for Oil Country Tubular Goods: Introduction

- Straight pipes
- Bent pipes
- Couplings

Chuck type						
Machining OCTG product	BB-N / BB-N-ES	BB-EXL2G	BB-SC	BB-AZ2G	BB-FZA2G	SF-RAZ2G
 Straight pipes	 Page 12 / 14	 Page 16	 Page 18	 Page 20		
 Bent pipes with shimming	 Page 12 / 14	 Page 16	 Page 18	 Page 20		
 Bent pipes with external centering chuck				 Page 20		
 Bent pipes with integrated centering chuck					 Page 24	
 Threadings of couplings in 1 set-up						 Page 30
 Threadings of couplings in 2 set-ups	 Page 12 / 14	 Page 16	 Page 18			 Page 30



Ideal



Possible

Big Bore



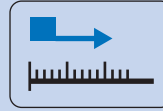
Big Bore is synonymous for **self contained air chucks with large through holes**. Big Bore chucks allow for the full spindle bore of the machine to be utilized.

Quick clamping circle



Optimal sized air feeds and valve systems guarantee a **quick clamping cycle**.

ES



ES chucks offer **extended jaw stroke** for greater clearance to ensure safe loading and unloading of pipe.

Spring clamp



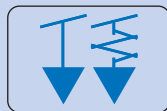
Spring clamp technology ensures the quickest clamping cycles and the highest degree of safety under any conditions.

Low maintenance



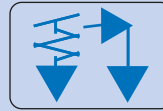
Proofline chucks are **fully sealed** and **low maintenance** allowing for long service intervals, minimizing machine downtime.

AZ-2G

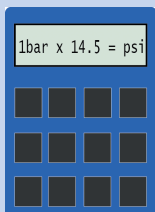


AZ-2G chucks offer the versatility of clamping either **compensating** or **self centering**.

FZA-2G



FZA-2G chucks **sequence 3 centering jaws** along with **3 compensating jaws** integrated within the same chuck body.



Conversion table (US)

1 mm	=	0.03937 Inch	1 cm ²	=	0.155 square inches
1 bar	=	14.5 psi	1 liter	=	1.05 quarts (qt)
1 kN	=	220.46 lbf	1 kg·m ²	=	3417 lb square inches
1 kg	=	2.2046 lbs	1 liter / min	=	0.264 gallon / min

Data sheet						Performance characteristics		
OCTG chuck	Size	Outside dia. max	Work piece capacity	Time for a full clamping	Time for a full opening	Max. grip force (at max. pressure)	Height of chuck without adapter	Weight without jaws and adapter
	mm	mm	mm	max.	max.	kN	mm	kg
BB-N ■ Big Bore ■ Quick clamping circle	400 - 140	467	140	-	-	266	196	155
	470 - 191	470	191	4.5	3.0	191	196	160
	500 - 205	570	205	6.0	6.0	350	225	230
	500 - 230	570	230	6.0	6.0	316	225	200
	600 - 275	605	275	6.0	6.0	333	225	270
	630 - 310	685	310	6.5	6.5	366	263	420
	800 - 410	850	410	7.0	5.5	550	305	650
BB-N-ES ■ Big Bore ■ Quick clamping circle ■ Extended stroke	400 - 140	467	140	on request	on request	216	240	200
	470 - 191	470	191	4.5	3.0	191	240	195
	500 - 205	570	205	6.0	4.5	316	280	340
	500 - 230	570	230	6.0	4.5	283	280	325
	600 - 275	605	275	6.0	4.5	308	280	350
	630 - 325	685	325	6.0	4.5	333	307.5	630
	850 - 375	850	375	7.0	5.5	333	354	970
	1000 - 560	1000	560	7.5	6.0	283	332	960
BB-SC ■ Big Bore ■ Spring clamp ■ Low maintenance	600 - 275	750	275	3	3	150	320.5	516
	850 - 395	925	395	3	3	170	375.5	1025
	1020 - 565	1095	565	4.5	4.5	170	375.5	1256
BB-AZ2G ■ Big Bore ■ Self centering or compensating ■ Extended stroke	685 - 275	685	275	on request	on request	266	380.5	800
	740 - 330	740	330	on request	on request	266	380.5	875
	800 - 390	800	800	on request	on request	300	380.5	1000
	1000 - 560	1000	560	on request	on request	300	380.5	1420
BB-FZA2G ■ Big Bore ■ Sequence chuck	740 - 275	740	275	on request	on request	149	516.5	1100
	800 - 330	800	330	on request	on request	133	516.5	1080
	920 - 390	920	390	on request	on request	255	546.5	1900
SF-RAZ2G ■ Hydraulic indexing chuck ■ Low maintenance	750	750	185	2	2	250	456	1018
	840	840	275	2	2	250	501	1286
	950	950	368	2	2	250	560	1650

Clamping times have been measured with the corresponding original SMW-AUTOBLOK air control unit on the SMW-AUTOBLOK test stand. For more information please contact SMW-AUTOBLOK.



Overview Pipes

Customer's OCTG product:

- Straight pipes
- Bent pipes

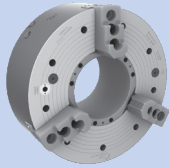
CHUCK

APPLICATION

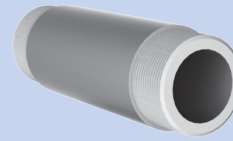
OCTG PRODUCT

CUSTOMER BENEFITS

BB-N
Page 12

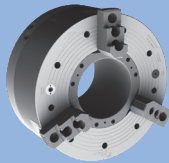


Threading of straight pipes with the original SMW Big Bore type BB-N.

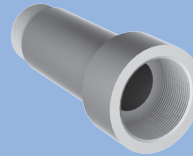


- **Quick jaw movement**
more pipes per hour
- Can be used for other work pieces besides piping
- O.D. and I.D. clamping

BB-N-ES
Page 14

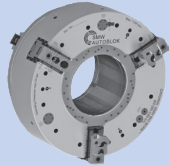


Threading of straight pipes with upset ends with the original SMW Big Bore type BB-N-ES.



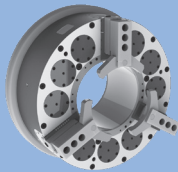
- **Quick jaw movement**
more pipes per hour
- Large jaw stroke for easy loading of pipe and less danger of damaging threads when unloading

BB-EXL2G
Page 16

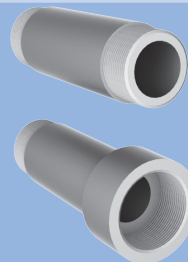


Threading of straight pipes with collars with the original SMW Big Bore Type BB-EXL2G.

BB-SC
Page 18

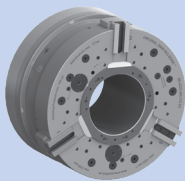


High production **spring clamp** chuck for threading of straight pipes with or without upset ends with the original SMW Big Bore type BB-SC.



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

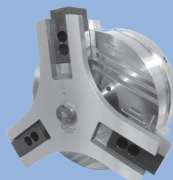
BB-AZ2G
Page 20



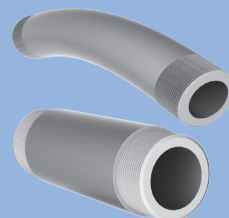
Threading of straight and bent pipes with the original SMW Big Bore type BB-AZ2G.

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

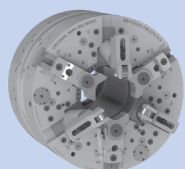
CC
Page 22



Threading of straight pipes with upset ends with the original SMW Big Bore type CC.



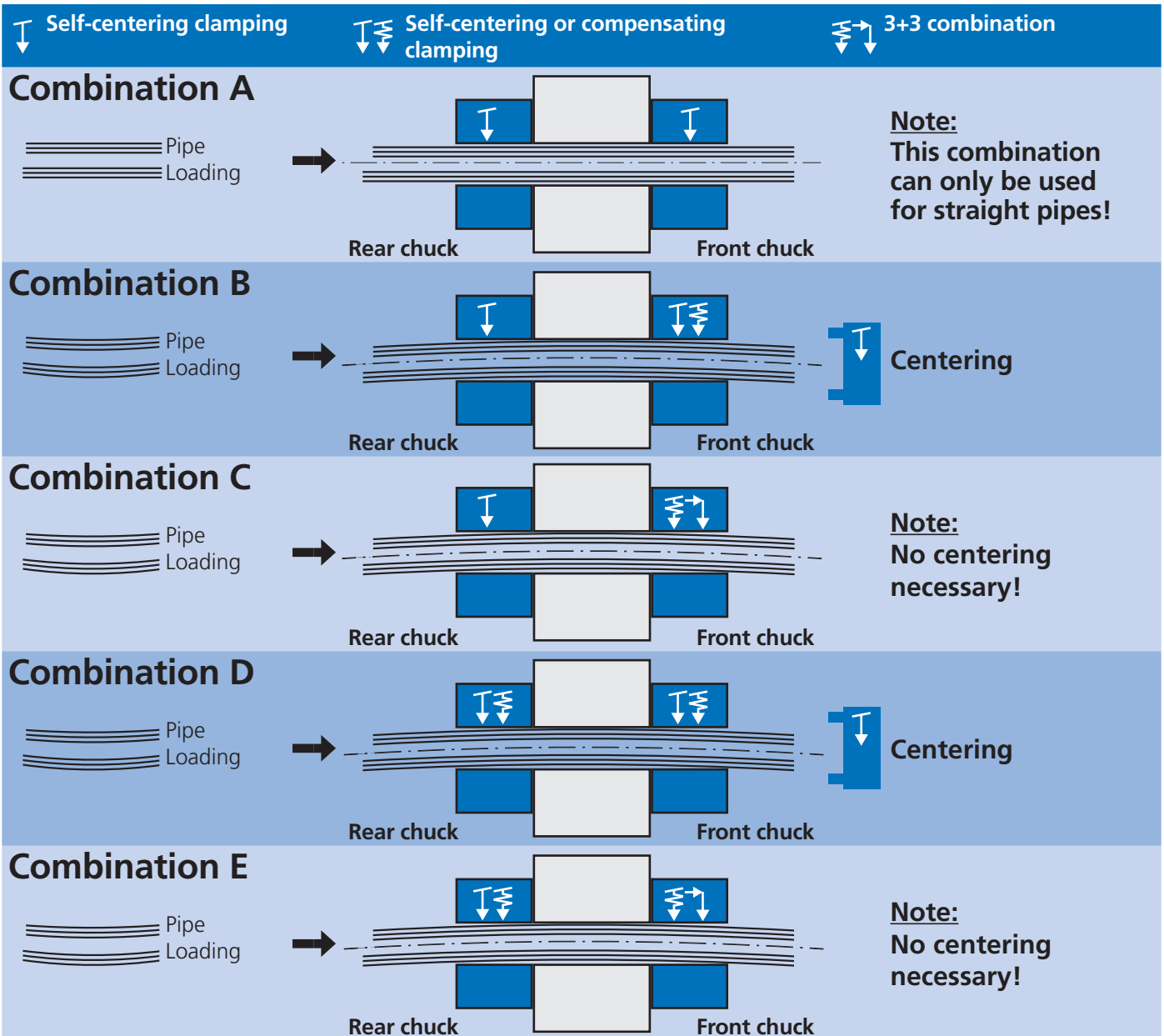
BB-FZA2G
Page 24



Threading of straight and bent pipes 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 programable cycle

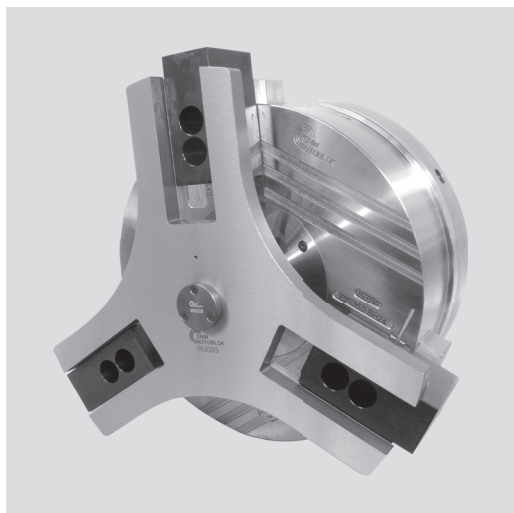


Respective chuck matrix:

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-EXL2G Page 16</p>	 <p>BB-AZ2G Page 20</p>	 <p>BB-FZA2G Page 24</p>
 <p>BB-SC Page 18</p>		

Centering options:

  <p>Chuck CC Page 22</p>	<p>Turret by customer</p>
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Applicazioni

- Posizionamento assiale e centraggio di tubi per il bloccaggio autocompensante in accoppiamento con i mandrini BB-AZ2G
- Ammortizzatore idraulico incorporato con battuta di arresto per frenata controllata e posizionamento finale dei tubi
- Adatti al centraggio interno ed esterno dei tubi

Caratteristiche tecniche

- Unità di serraggio ad azionamento pneumatico con ammortizzatore / battuta di arresto incorporati
- Pressione di esercizio 2-10 bar (29-145 psi)
- Controllo della posizione finale della battuta di arresto tramite detettori (detettore opzionale non incluso nel mandrino)

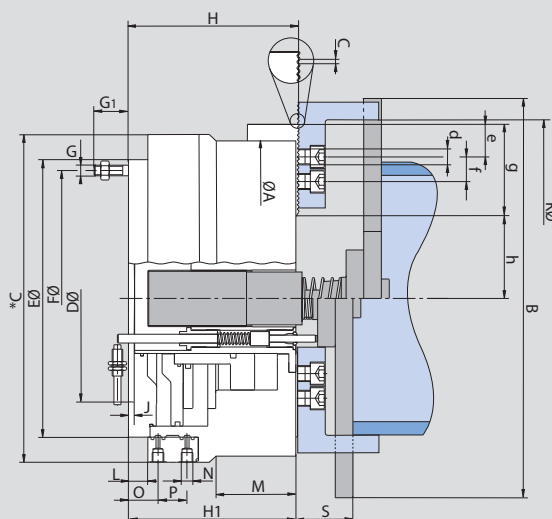
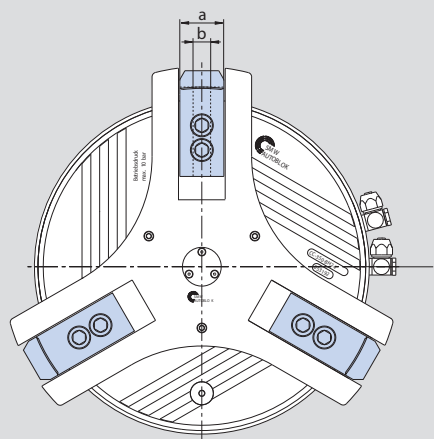
Dotazione standard

Mandrino di centraggio a 3 griffe
1 Serie di morsetti teneri

Esempio di ordine

Base di centraggio CC-350

* CC-240 non presenta l'anello di distribuzione



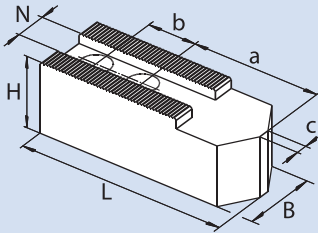
Con riserva di modifiche tecniche.
Per maggiori informazioni contattare l'ufficio tecnico SMW-AUTOBLOK.

Modello SMW-AUTOBLOK			CC 240 Z	CC 350 Z	CC 470 Z
Cod.			053290	053192	054470
	A	mm	240	360	470
	B	mm	306	446	550
	C	mm	250	372	n.a.
	D H6	mm	195	235	310
	E	mm		315	400
	F	mm	223.8	290.5	374
	G/G1	mm	M12 / 39	M12 / 39	M12 / 26
	H	mm	135.5	191.5	239.5
	H1	mm	134	190	238
	J	mm	6.5	6.5	8
Ø di serraggio	K	mm	245	365	507
	L	mm	-	21	20
	M	mm	49	92	n.a.
Raccordi pneumatici	N	pollici	G 1/4"	G 1/4"	G 1/2"
min./max.	S	mm	45 / 95	47 / 97	50.5 / 152.5
	a	mm	40	44	60
	o	mm	74	33	37
	p	mm	-	33	26
	b f7	mm	17	21	25.5
Dentatura	c	pollici	1/16" x 90°	1/16" x 90°	3/32" x 90°
Viti ISO 4762 12.9	d	mm	M12 x 30	M16 x 35	M20 x 45
min.	e	mm	9.5	12	15
Distanza tasselli min./max.	f	mm	22 / 41.5	25 / 72	35 / 68
Lunghezza della dentatura	g	mm	59	95	99
min./max.	h	mm	53 / 66	85 / 109	128 / 153
Corsa per griffa		mm (poll.)	12.7 (0.5")	24 (0.94")	25 (0.98")
Pressione min./max.		bar (psi)	2 / 10 (29 / 145)	2 / 10 (29 / 145)	2 / 10 (29 / 145)
Superficie pistone		cm ²	290	486	652
Forza di serraggio max. a 6 bar (in chiusura)		kN (lbf)	20 (4496)	31 (6969)	40 (8992)
Consumo d'aria/corsa delle griffe a 6 bar		litri	5.5	13.5	21
Massa (senza morsetti)		kg (lbs)	53 (11915)	115 (25853)	260 (58450)

- Morsetti
- Tasselli a T

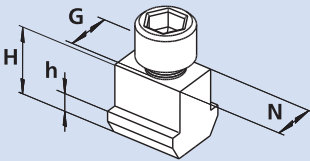
Dentatura in
POLLICI

MWB-D / MAB-D
Morsetti teneri



Mandrino	CC 240 Z	CC 350 Z	CC 470 Z
Tipo morsetto	MWB-D 240	MWB-D 250	MAB-D 2505
Cod. Mors. (serie di 3)	233462	013491	081603
B	40	50	60
H	80	80	120
L	90	120	155
N	17	21	25.5
Dentatura	1/16" x 90°	1/16" x 90°	3/32" x 90°
a	20	62	94
b	22	28	35
kg / serie	4.2	10.5	21.5

NST
Tasselli a T



Mandrino	CC 240 Z	CC 350 Z	CC 470 Z
Tipo tassello	NST 17-4	NST 21-5	NST 21-5
Cod. Tassello / pz.	013864	033429	014812
N	17	21	25.5
H	26.5	30	29
h	9.5	11	11
G	M12	M16	M20
Vite ISO 4762 12.9	M12 x 30	M16 x 35	M20 x 40



CATALOGO
MORSETTI

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