

# HB-D

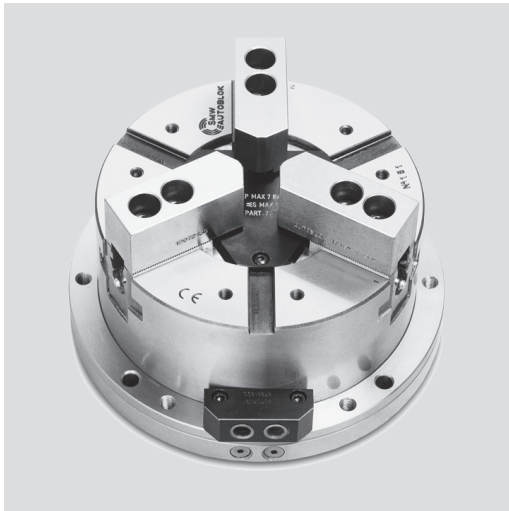
INCH SERRATION  
2 or 3 jaws

# HB-C

TONGUE & GROOVE  
3 jaws

## Stationary chuck, hydraulic Ø 130 - 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 and 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 from Ø 165**

### Technical features

- Stationary chuck consisting of a 2- or 3-jaw self centering chuck with built-in hydraulic cylinder
- Compact design
- Case hardened body to assure consistent high 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)

### Ordering example

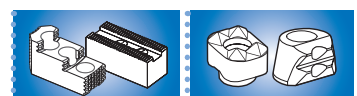
Stationary chuck HB-C 250 (3 jaws)  
or  
Stationary chuck HBL-D2 165 (2 jaws)

## Technical data

SMW-AUTOBLOK Type		HB-D 130	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	3.2	4	4.6	5.5
Radial jaw stroke HBL-D2 (2 jaws)*	mm	5.6	6	7.5	8.8	10.5
Piston area	cm <sup>2</sup>	63	79	114	167	203
Max. operating pressure	bar	30	30	30	30	30
Gripping force at 25 bar	kN	50	55	85	125	150
Gripping force at 25 bar HBL-D2 (2 jaws)*	kN	28	35	52	75	90
Weight (without top jaws)	kg	9.5	18	30	44	69
Id. No. HB-D 3 jaws		77271113	77271116	77271121	77271125	77271131
Id. No. HB-C 3 jaws		-	77277516	77277521	77277525	77277531
Id. No. HBL-D 2 jaws		-	77271716	77271721	77271725	77271731

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

JAWS-CATALOG  
Request or  
download:  
[www.smw-autoblok.de](http://www.smw-autoblok.de)



SMW-AUTOBLOK  
468

SMW-AUTOBLOK  
472

# Stationary chuck, hydraulic Ø 130 - 315 mm

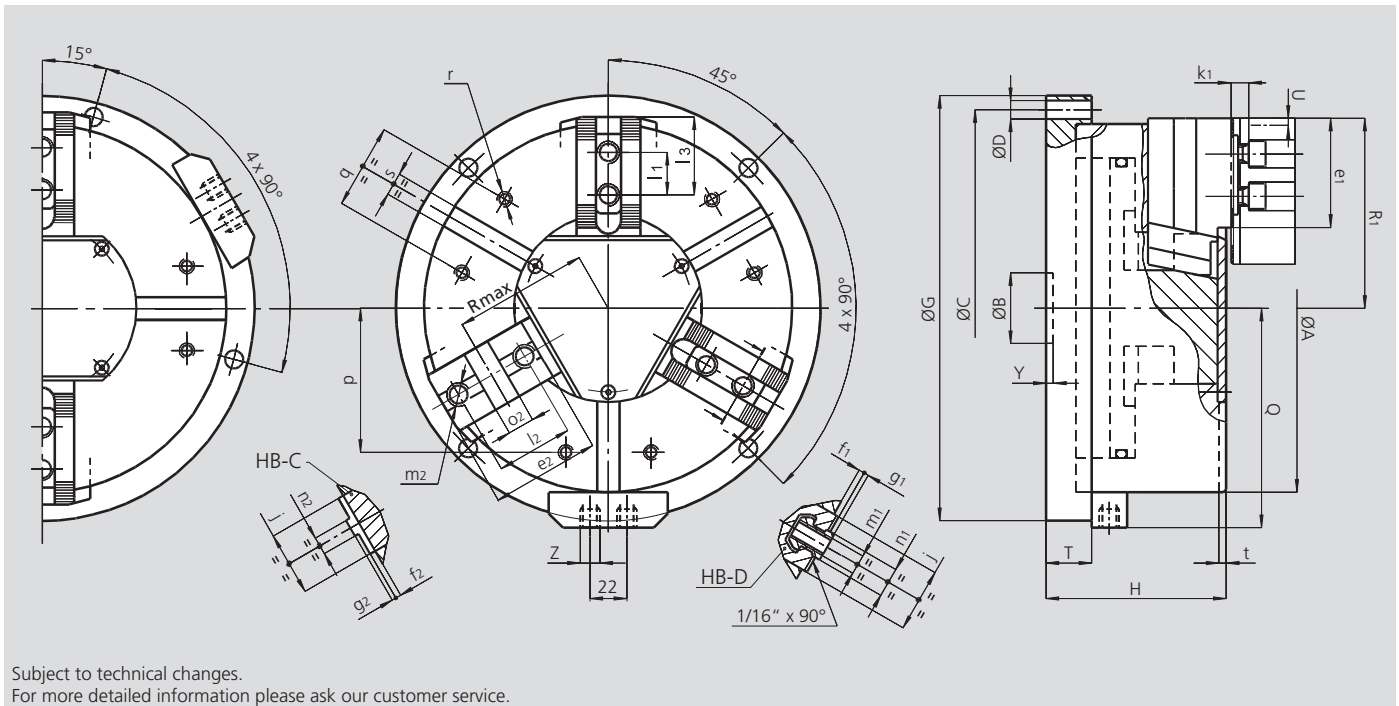
- Built-in hydraulic cylinder
- 2 and 3 jaws

## HB-D

INCH SERRATION  
2 or 3 jaws

## HB-C

TONGUE & GROOVE  
3 jaws



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

### Common dimensions

SMW-AUTOBLOK Type		HB-D 130	HB-D 165 HB-C 165	HB-D 210 HB-C 210	HB-D 250 HB-C 250	HB-D 315 HB-C 315
	<b>A</b>	mm	135	170	215	260
	<b>B</b>	mm	30	30	35	50
Fixing holes circle	<b>C</b>	mm	155	190	235	280
Fixing holes diameter	<b>D</b>	mm	9	11	11	13
	<b>G</b>	mm	175	210	255	300
	<b>H</b>	mm	89	100	117	127
	<b>Q</b>	mm	92.5	110	133	155
	<b>T</b>	mm	25	27	30	32
Radial jaw stroke (3 jaws)	<b>U</b>	mm	3	3.2	4	4.6
Radial jaw stroke HBL-D2 (2 jaws)	<b>U</b>	mm	5.6	6	7.5	8.8
	<b>Y</b>	mm	5	5	5	5
Hydraulic connections	<b>Z</b>	inch	R1/4"	R1/4"	R1/4"	R1/4"
	<b>j</b>	mm	26	30	36	45
	<b>k1</b>	mm	10	10	11	12
	<b>p</b>	mm	52	65	80	102
	<b>q</b>	mm	30	36	45	60
	<b>r</b>	mm	M6	M8	M8	M10
	<b>s H12</b>	mm	12	16	16	16
	<b>t</b>	mm	3.5	5	5	5

### HB-D and HBL-D2 fixtures specific dimensions

SMW-AUTOBLOK Type		HB-D 130	HB-D 165	HB-D 210	HB-D 250	HB-D 315
	<b>e1</b>	mm	45	48	60	77
	<b>f1</b>	mm	3	4	3	4
	<b>g1</b>	mm	2.5	2.5	2.5	3.5
	<b>l1</b>	mm	16	16.5	23	30
T-nut position min. / max.	<b>l3</b>	mm	23 / 30	24 / 40	33 / 50	43 / 84
	<b>m1</b>	mm	M8	M10	M12	M16
	<b>n1 h8</b>	mm	12	14	17	21
Chuck open HB-D (3 jaws)	<b>R1</b>	mm	71	89	110	134
Chuck open HBL-D2 (2 jaws)	<b>R1</b>	mm	74	92	114	138.5

### HB-C fixtures specific dimensions (available only as 3-jaw chuck version)

SMW-AUTOBLOK Type		HB-C 165	HB-C 210	HB-C 250	HB-C 315
	<b>e2</b>	mm	54	71	77
	<b>f2</b>	mm	4	4	4
	<b>g2</b>	mm	3	3	3
	<b>l2</b>	mm	38	44.4	54
	<b>m2</b>	mm	M10	M12	M16
	<b>n2 h8</b>	mm	7.94	7.94	12.70
	<b>o2H7</b>	mm	12.68	12.68	19.03
Chuck open	<b>R1</b>	mm	89	110	134
Chuck open	<b>Rmax</b>	mm	62	77	94