

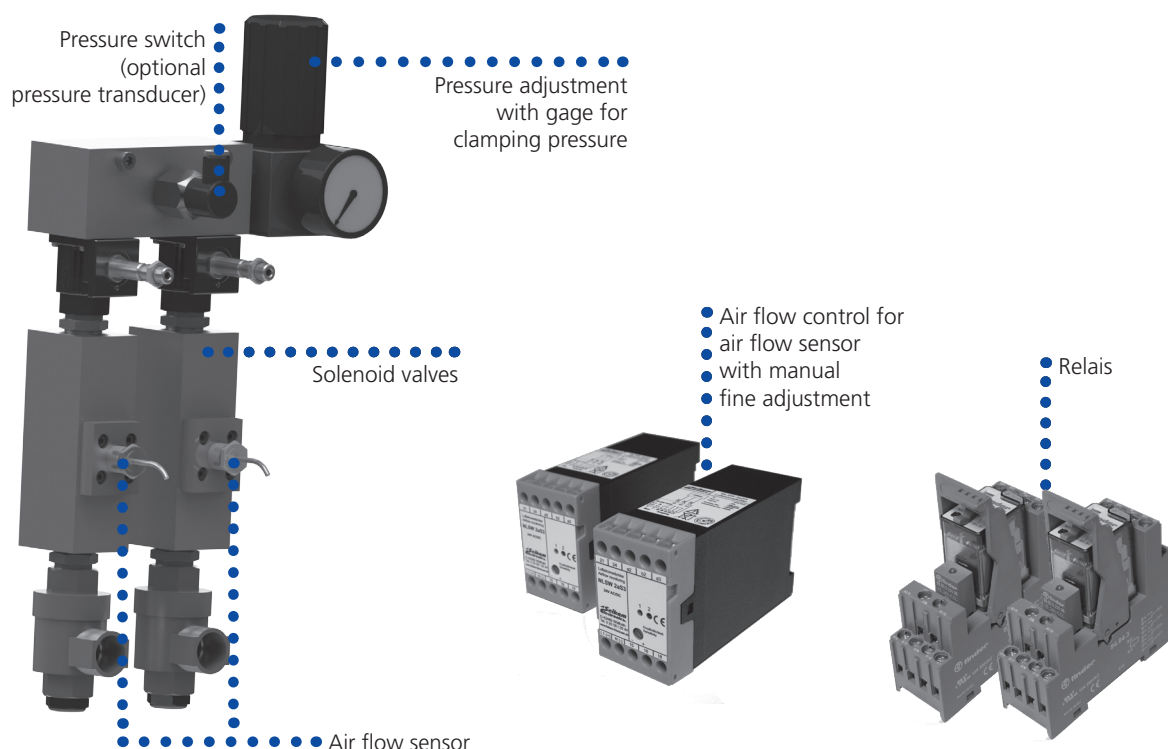
AC-BB

Control unit for
SP and Big Bore chucks

- Electronic safety control unit
- for SP and Big Bore chucks
- without pressure control
- without stroke control

Electropneumatic control unit for SP and Big Bore® chucks

- 1/2" or 3/4" design for SP and Big Bore chucks
- Actuation via foot pedal or push button (not included in the supply range)
- Clamping control via air flow sensors
- Quick chuck actuation via diaphragm valves with quick exhaust
- Airflow control with LED for ready and air flow. Adjustable air flow sensor sensitivity



SMW-AUTOBLOK Type	Voltage	Size	Id. No.
AC-BB	24 V	1/2"	202342
AC-BB	110 V	1/2"	202343
AC-BB	220 V	1/2"	202344
AC-BB	24 V	3/4"	202837
AC-BB	110 V	3/4"	202838
AC-BB	220 V	3/4"	202839

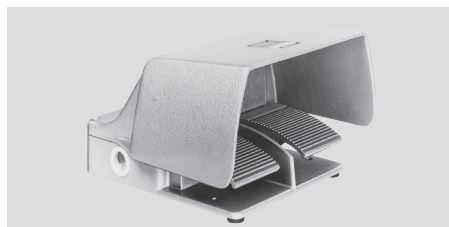
Standard equipment:

as shown, without hoses and fittings

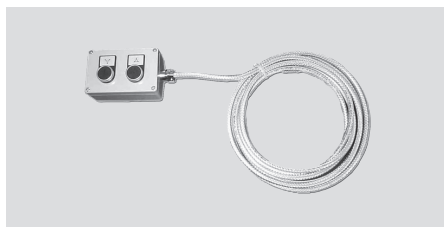
Approx. dimensions (w x h x d)
222 x 465 x 128 mm

Accessories:

Foot pedal F2 with 4 m cable
Id. No. 013324



Push button with 5 m cable
Id. No. 192942



Air service unit
Id. No. 1/2" 192074,
Id. No. 3/4" 199790



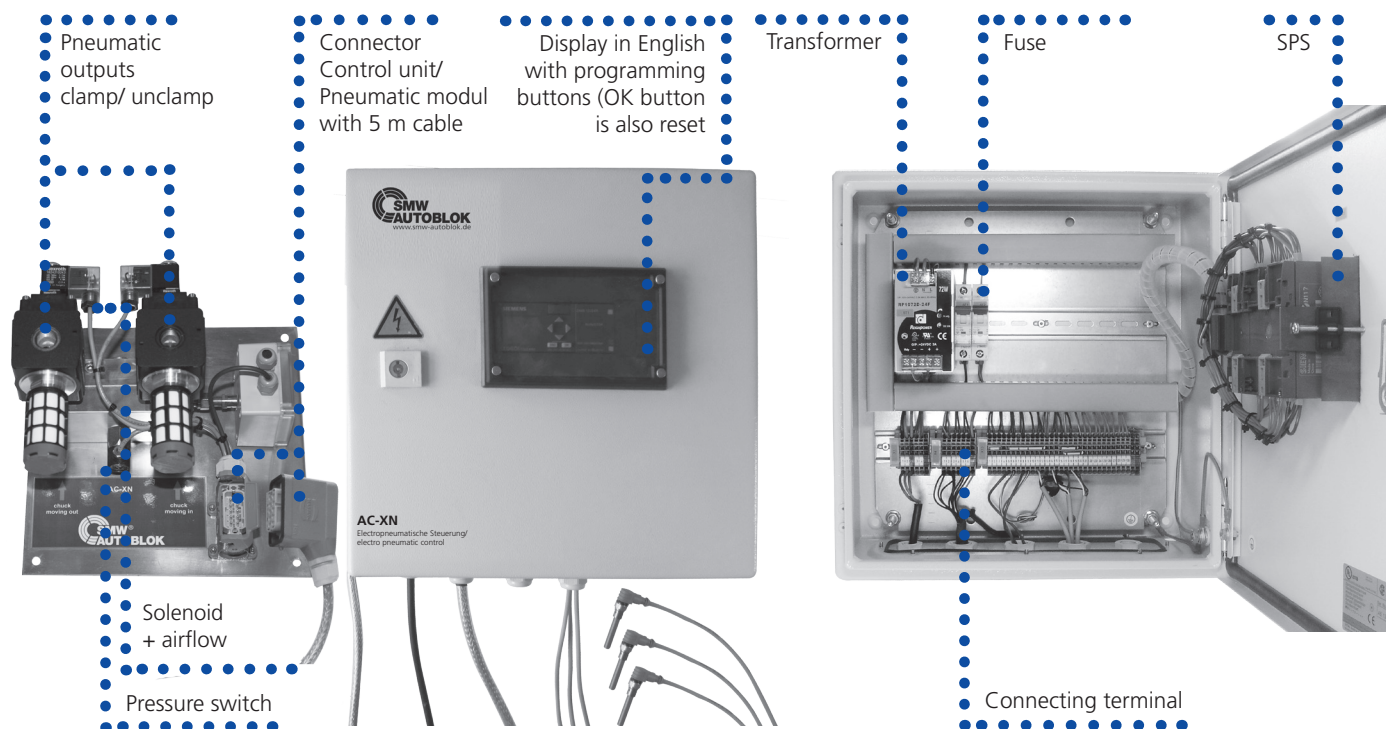
AC-XN

Control unit
for pneumatic chucks

- Electronic safety control unit
- for Big Bore chucks
- proximity switch for pressure and stroke control signals

Universal, electronic micro-processor compact control unit for Big Bore chucks in 1/2" / 3/4" design

- All safety systems integrated
- Easy installation - no other devices needed
- Can be connected to all common voltages
- LCD display in English
- Quick chuck actuation by 1/2" / 3/4" pneumatic parts
- To be actuated by an external signal

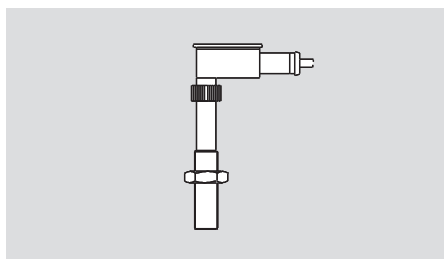


Accessories:

Foot pedal F2
with 4 m cabel
Id. No. 013324

**Proximity switch for pressure
and stroke control signals
M8x1**
Id. No. 203500

Air service unit 1/2"
Id. No. 192074
Air service unit 3/4"
Id. No. 199790



Order review:

Control unit AC-XN complete 1/2"	Id. No. 203491
Control unit AC-XN complete 3/4"	Id. No. 203490

Standard equipment:

Control unit
WxHxD = 380 x 380 x 220 mm
Pneumatic module 1/2" or 3/4"
WxHxD = 300 x 300 x 130 mm
3 pcs. Proximity switch M8x1
(Id. No. 203500) included

Pneumatic Diagrams

Summary of pneumatic cycles and parts

- Cycle clamp BB-N/ BB-N ES
- Cycle clamp BB-SC

Common parts for all Big Bore air circuits:

V	non return valve towards the pneumatic system
S	accumulator (approx. 90 normal liter/ 23 gallon)
W	air service unit 3/4" with filter, dryer, oiler and pressure regulator (0-10 bar), min. flowrate 3100 l/min (819 gallon/ min); rec. Type: FRL 34S; Riegler & Co. KG, Bad Urach, Germany
D	silencer 3/4", min. flowrate 15000 l/min (3963 gallon/min); rec. Type: 2311; Festo, Esslingen, Germany
F	Air flow sensor

Used connection parts for time measuring according to page 7:

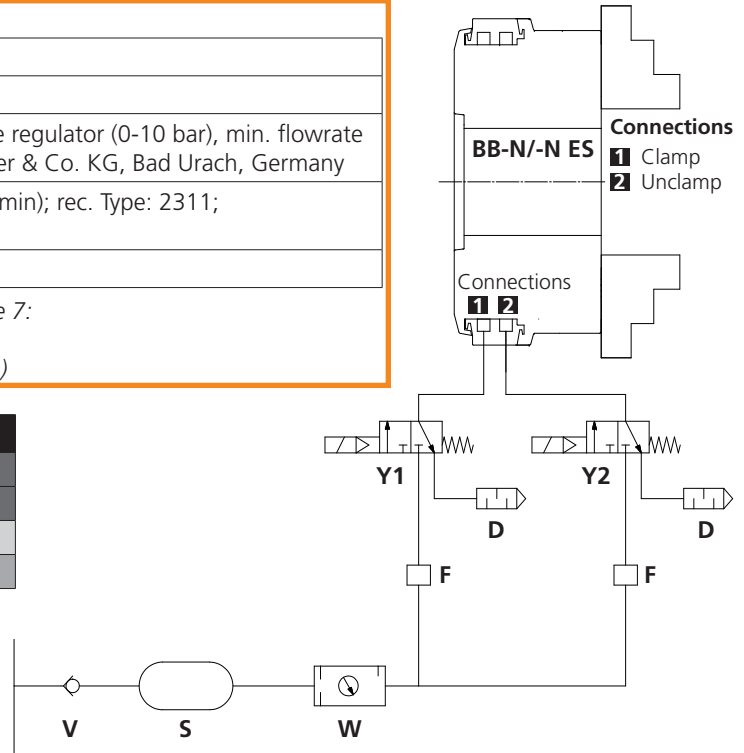
- Length of hoses from air control to chuck: 3000mm
- Inside dia. of hoses from air control to chuck 3/4" (19mm)

Cycle clamp BB-N/ BB-N ES

action	Valve Y1	Valve Y2
clamp / unclamp	clamp	unclamp
1. chuck open		O
2. chuck clamp	O	

O = Valve actuated for jaw movement

- NOTE:**
All valves, hoses and fittings must be at least:
1/2" inside dia. per function up to chuck size 600
3/4" inside dia. per function on larger chuck sizes



Cycle standard clamp BB-SC

action	Valve Y1	Valve Y2
clamp / unclamp	unclamp	clamp
1. chuck open	X	
2. chuck clamp		O

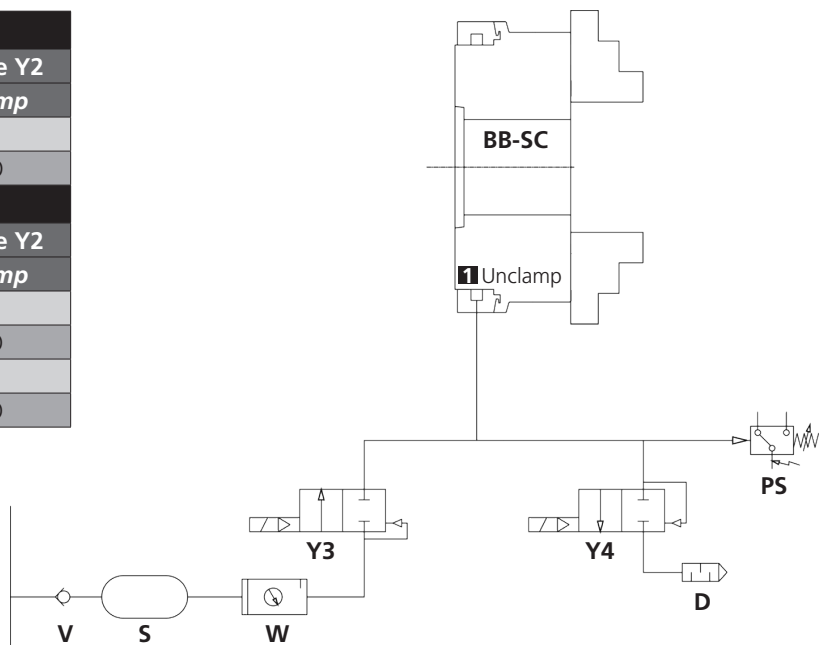
Cycle step mode/ inching BB-SC

action	Valve Y1	Valve Y2
clamp / unclamp	unclamp	clamp
1. chuck open	X	
2. chuck clamp		O
3. step open	O	
4. step close		O

X = Valve permanently actuated

O = Valve actuated for jaw movement

- NOTE:**
All valves, hoses and fittings must be at least 3/4"



Pneumatic connection parts for BB-N/-N ES and BB-SC:

Y1/Y2	3/2 solenoid valve 1", min. flowrate 3900 l/min (1031 gallon/min); rec. Type: NL6-SOV; Bosch Rexroth, Germany
Y3/Y4	2/2 solenoid valve 3/4", min. flowrate 3100 l/min (819 gallon/min); rec. Type: EGV 121/C78/3/4" BN; AVS Roemer GmbH, Koenigsdorf, Germany
PS	pressure switch, 0-10 bar, 4-20 mA; rec. Type: A-10-6-BG410-HD1Z-AA-AGZ; WIKA, Klingenberg, Germany
Q	Quick exhaust valves, min. flowrate 6800 l/min (1765 gallon/min) rec. Type: 573, 1"; Bosch Rexroth, Germany

Summary of pneumatic cycles and parts

Pneumatic Diagrams

- Cycle clamp BB-AZ2G
- Cycle clamp BB-FZA2G

Cycle compensating clamp BB-AZ2G

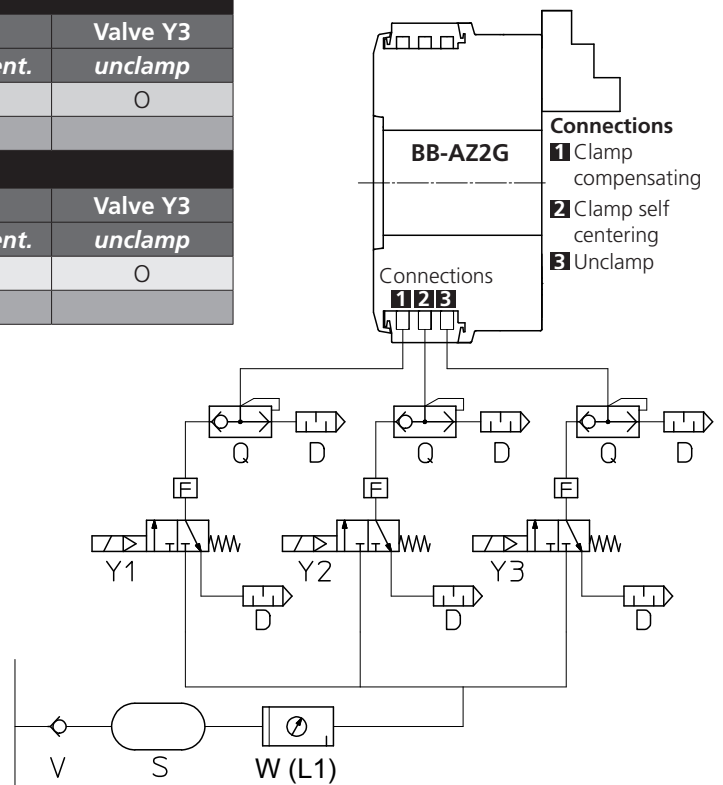
action	Valve Y1	Valve Y2	Valve Y3
clamp/ unclamp	clamp comp.	clamp self cent.	unclamp
1. chuck open		-	O
2. chuck compensating clamp	O	-	

Cycle self centering clamp BB-AZ2G

action	Valve Y1	Valve Y2	Valve Y3
clamp/ unclamp	clamp comp.	clamp self cent.	unclamp
1. chuck open	-		O
2. chuck centering clamp	-	O	

O = Valve actuated for jaw movement

NOTE:
All valves, hoses and fittings must be at least 3/4"

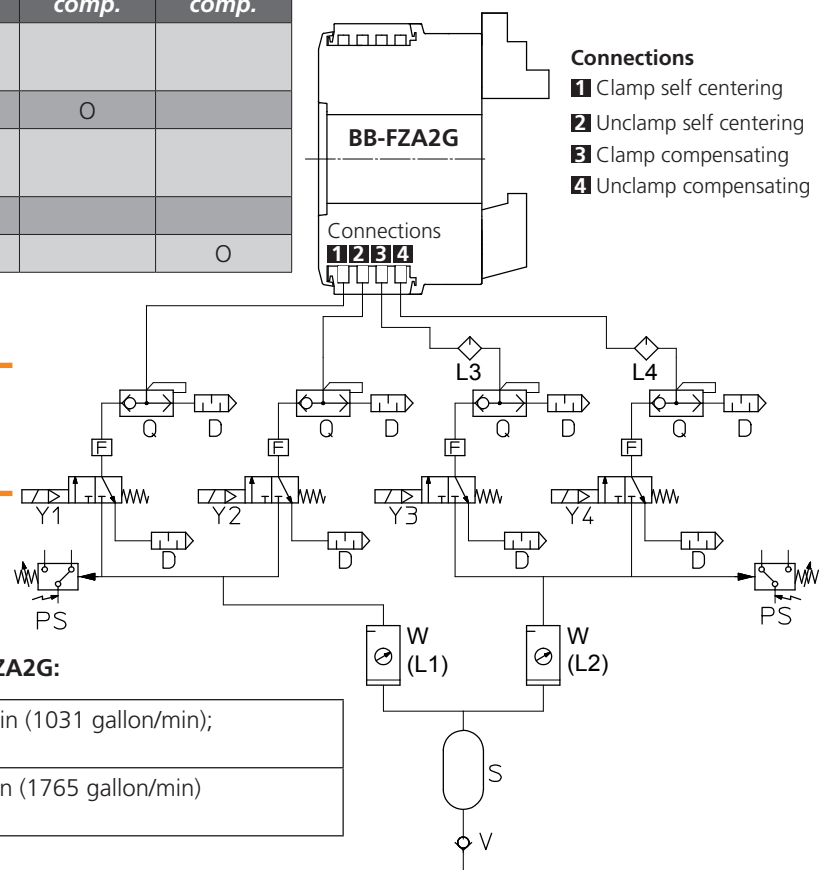


Cycle BB-FZA2G

action when pipe is loaded	Valve Y1 clamp cent.	Valve Y2 unclamp cent.	Valve Y3 clamp comp.	Valve Y4 unclamp comp.
1. self centering jaws forward and clamp	O			
2. compensating jaws clamp			O	
3. centering jaws open and retract		O		
4. machining of pipe				
5. compensating jaws open				O

O = Valve actuated for jaw movement

NOTE:
All valves, hoses and fittings must be at least 3/4"



Pneumatic connection parts for BB-AZ2G and BB-FZA2G:

Y1/Y2/ Y3/Y4	3/2 solenoid valve 1", min. flowrate 3900 l/min (1031 gallon/min); rec. Type: NL6-SOV; Bosch Rexroth, Germany
Q	Quick exhaust valves, min. flowrate 6800 l/min (1765 gallon/min) rec. Type: 573, 1"; Bosch Rexroth, Germany