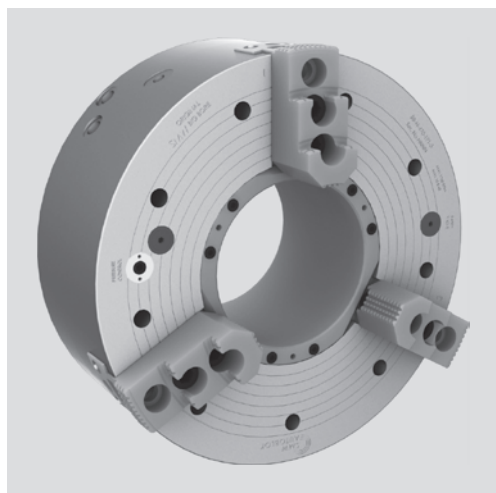




Application/customer benefits

- End machining of long pipe
- Full spindle bore can be used

Technical features

- Air chuck for external/internal clamping with built-in pneumatic cylinder
- Air feed via distributor ring and SMW-profile seals, at stopped spindle
- Built in non-return valves maintain the air pressure during machining
- Clamping pressure level constantly checked by a safety control system (only for external clamping)
- Stroke control system (not for BB-N 400-140)

Standard equipment

- 3 jaw chuck
- 2 elbow unions G 1/2"
- 12 mounting bolts (9 for the BB-N 400)
- 1 lifting eye bolt
- 1 set T-nuts with bolts
- 1 set soft top jaws
- without distributor ring bracket

Ordering example

BIG BORE BB-N 470-191/Z310

Accessories

Control unit AC-BB/AC-XN
(see pages 258-261)

The principle invented by SMW: air supply via distributor ring and SMW-profile seal rings

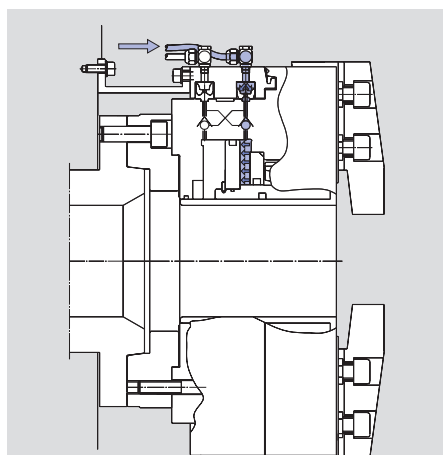


Fig. 1

Open/close movement (only possible at stopped spindle). The profile seals deform radially under the pneumatic pressure, sealing on the chuck body and filling the cylinder chamber. When the clamping pressure is reached, the air feed is stopped, closing the twin non-return valve.

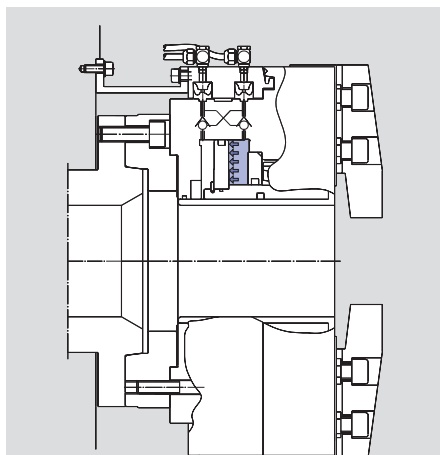


Fig. 2

The SMW-profile seals lift to the expanded position, not touching the chuck body anymore. The clamping pressure is maintained by the twin non-return valve. The chuck can start to rotate.

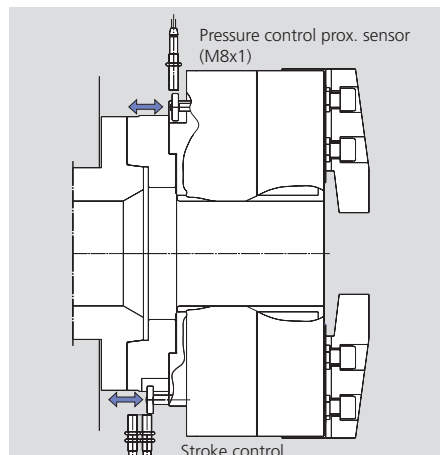
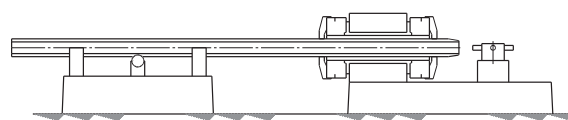


Fig. 3

Pressure control: if the pressure is less than a pre-set safety level, the switch ring moves into the proximity-switch field, sending an alarm signal.

Stroke control: The proximity switches monitor the following jaw positions: Jaws cpl. open/ Jaws cpl. closed.*

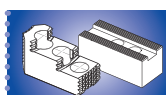
*BB-N-400-140 has no stroke control



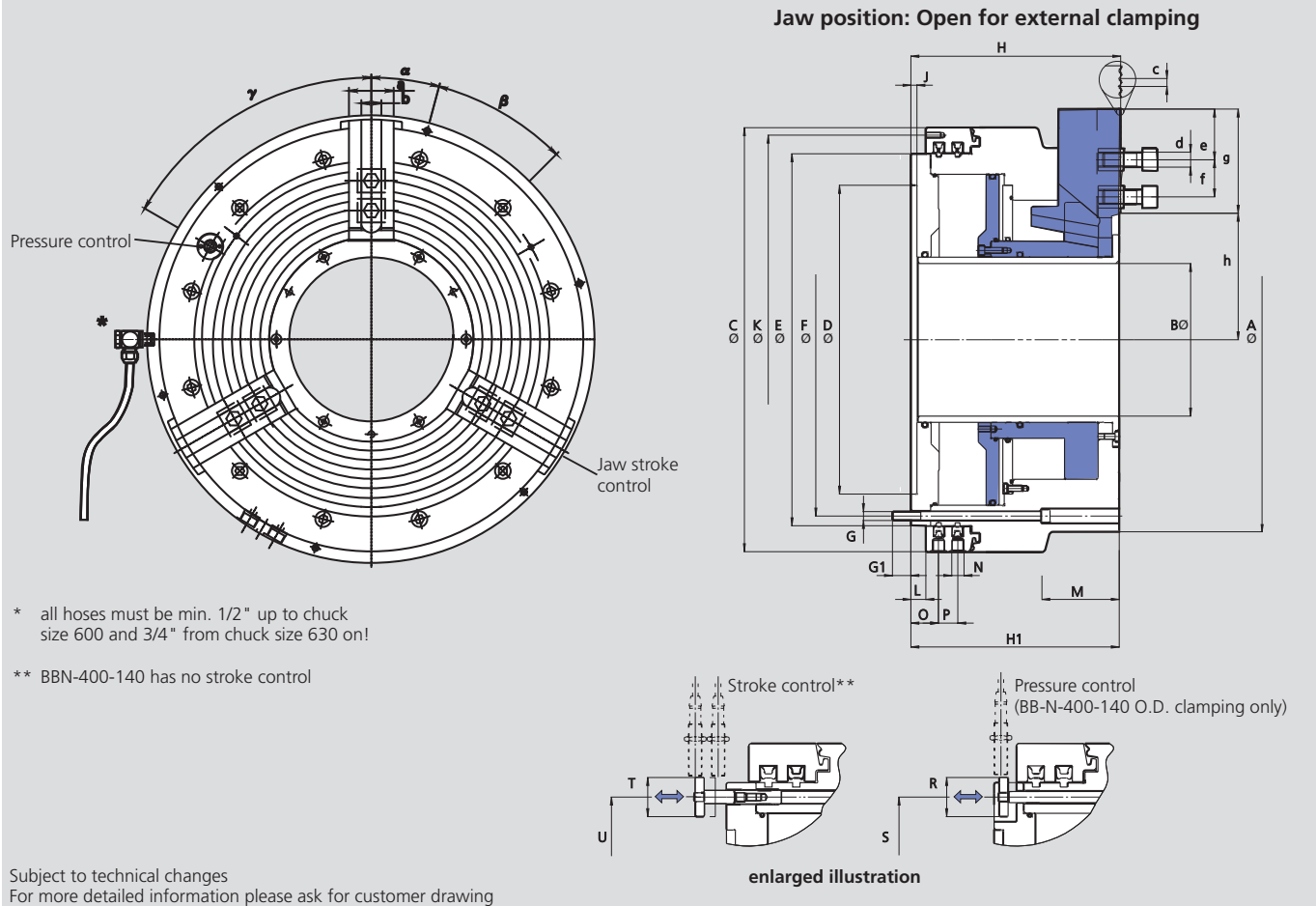
End machining of pipe with front and rear chucks

Technical data

SMW-AUTOBLOK BB-N Type		400-140	470-191	500-205	500-230	600-275	630-310	800-410
Id. No.		052300	053535	053830	053832	053834	053836	053838
Through-hole	mm	140	191	205	230	275	310	410
Stroke per jaw	mm	7	7	8.5	8.5	8.5	10	12
Operating pressure min./max.	bar	2/10	2/10	2/10	2/10	2/10	2/10	2/10
Piston area	cm ²	710	565	1024	940	990	1270	2064
Gripping force at 6 bar	kN	160	115	210	190	200	220	330
Max. speed	r.p.m.	1700	1700	1300	1300	1300	1000	750
Air consumption/jaw stroke at 6 bar	liter	21	16	36	32	34	52	108
Weight (without top jaws)	kg	150	150	230	200	270	420	650
Moment of inertia	kg·m ²	3.22	5.66	8.53	8	15	28	71.25



Main dimensions and technical data



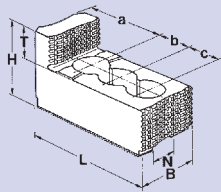
SMW-AUTOBLOK BB-N Type			400-140	470-191	500-205	500-230	600-275	630-310	800-410
Id. No.			052300	053535	053830	053832	053834	053836	053838
Mounting			Z310	Z310	Z415	Z415	Z450	Z510	Z700
	A	mm	422	470	540	570	605	662	800
	B	mm	140	191	205	230	275	310	410
	C	mm	467	467	570	570	605	685	850
	D H6	mm	310	310	415	415	450	510	700
	E	mm	400	400	500	500	535	610	775
Fixing bolts circle	F	mm	374	374	474	474	508	580	745
	G	mm	M12	M12	M12	M12	M12	M16	M16
	G1	mm	26	26	27	27	27	30	30
	H	mm	196	196	225	225	225	263	305
	H1	mm	194	194	223	223	223	261	303
	J	mm	8	8	8	8	8	8	8
Thread circle 6x M8	K	mm	448	448	550	550	585	666	830
	L	mm	20	20	20	20	20	20	25
	M	mm	70	-	98	98	-	115	154
Pneumatic connection	N	inch	G 1/2"	G 1/2"	G 1/2"	G 1/2"	G 1/2"	G 1/2"	G 1/2"
	O	mm	37	37	37	37	37	39.5	44.5
	P	mm	26	26	26	26	26	33	33
	R	mm	35	35	35	35	35	42	35
	S	mm	374	374	474	474	508	575	745
	T	mm	35	35	35	35	35	35	35
	U	mm	374	374	474	474	508	580	745
	a	mm	57	57	57	57	57	75	75
	b	mm	25.5	25.5	25.5	25.5	25.5	30	30
Serration	c	inch	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
Bolt ISO 4762 12.9	d	mm	M20	M20	M20	M20	M20	M24	M24
	min. e	mm	13	13	14	14	14	16	16
T-nuts distance	min./max. f	mm	38/85	38/85	38/102	38/102	38/94	47/103	47/130
Serration length	g	mm	117.5	117	138	138	130	142	171.5
	min./max. h	mm	94.5/101.5	124/131	133.5/142	143.5/152	165/173.5	190.5/200.5	243/255
	α°		20	20	15	15	15	15	15
	β°		9 x 40	9 x 40	12 x 30	12 x 30	12 x 30	12 x 30	12 x 30
(Pressure control)	γ°		83	83	60	60	60	60	60

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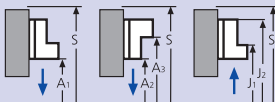
INCH
serration

■ Top jaws
■ T-nuts

GUB Hard reversible top jaws

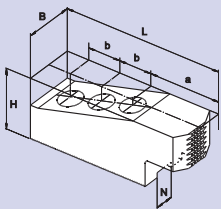


Gripping ranges

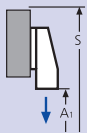


Chuck BB-N	400-140	470-191	500-205	500-230 600-275	630-310	800-410
Jaw type	GUB 500	GUB 500	GUB 500	GUB 500	GUB 630	GUB 800
Id. No.	12084546	12084546	12084546	12084546	12086446	12088046
B	60	60	60	60	75	75
H	75	75	75	75	85	85
L	140	140	140	140	160	220
T	2x19	2x19	2x19	2x19	30	30
N	25.5	25.5	25.5	25.5	30	30
Serration	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
a	46	46	46	46	30	51
b	38	38	38	38	50	62
c	38	38	38	38	50	62
kg/set	6.6	6.6	6.6	6.6	13.5	19.5
A1	65-238	100-273	150-358	175-378	275-485	320-590
A2	110-284	145-320	200-405	225-425	275-485	330-600
A3	294-470	330-505	385-590	410-610	475-685	590-865
J1	175-350	210-385	265-470	285-490	395-610	500-770
J2	355-530	390-565	445-650	465-670	595-810	760-1030
S	585	620	705	725	820	1050

GAB Hard top jaws

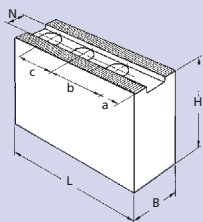


Gripping ranges

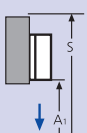


Chuck BB-N	400-140	470-191	500-205	500-230 600-275	630-310	800-410
Jaw type	GAB 500	GAB 500	GAB 500	GAB 500	GAB 630	GAB 800
Id. No./set	12085146	12085146	12085146	12085146	12086546	12089046
B	55	55	55	55	75	75
H	73	73	73	73	82	82
L	195	195	195	195	245	320
N	25.5	25.5	25.5	25.5	30	30
Serration	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
a	96	96	96	96	113	165
b	38	38	38	38	50	60
c	38	38	38	38	50	60
kg/set	16.5	16.5	16.5	16.5	31.5	40.5
A1	25-140	60-175	50-260	70-280	105-320	95-365
S	585	620	705	725	820	1010

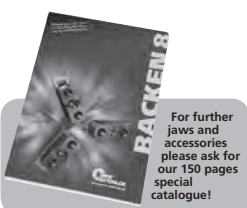
WBSA-D/WBC-D Soft top jaws



Gripping ranges



Chuck BB-N	400-140	470-191	500-205	500-230 600-275	630-310	800-410
Jaw type	WBSA-D 500	WBSA-D 500	WBSA-D 500	WBSA-D 500	WBC-D 630	WBC-D 800
Id. No./pc.	12075050	12075050	12075050	12075050	12076440	12078040
B	60	60	60	60	80	80
H	60	60	60	60	80	80
L	170	170	170	170	240	320
N	25.5	25.5	25.5	25.5	30	30
Serration	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
a	69	69	69	69	110	165
b	38	38	38	38	50	60
c	38	38	38	38	50	60
kg/piece	3.6	3.6	3.6	3.6	11	15
A1	25-195	60-230	105-315	125-325	110-325	95-365
S	545	580	660	680	815	1010

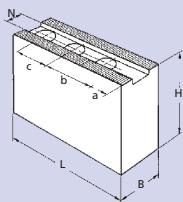


- Top jaws
- T-nuts
- Adapters

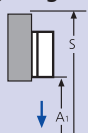
BIG BORE®

INCH
serration

WBCL Soft top jaws long version

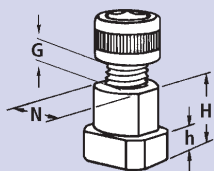


Gripping ranges



Chuck BB-N	400-140	470-191	500-205	500-230 600-275	630-310	800-410
Jaw type	WBC-D 502	WBC-D 502	WBC-D 502	WBC-D 502	WBC-D 800	WBC-LD 800
Id. No./pc.	12075140	12075140	12075140	12075140	12078040	12079040
B	60	60	60	60	80	80
H	60	60	60	60	80	80
L	205	205	205	205	320	390
N	25.5	25.5	25.5	25.5	30	30
Serration	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°	3/32" x 90°
a	104	104	104	104	165	230
b	38	38	38	38	60	60
c	38	38	38	38	60	60
kg	4.5	4.5	4.5	4.5	15	18
A1	-	0-155	35-245	55-265	25-195	25-235
S	-	575	660	680	845	1020

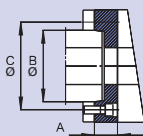
NST T-nuts



Chuck BB-N	400-140	470-191	500-205	500-230 600-275	630-310	800-410
T-nut type	NST	NST	NST	NST	NST	NST
Id. No./pc.	12065020	12065020	12065020	12065020	13063900	13063900
N	25.5	25.5	25.5	25.5	30	30
H	34	34	34	34	44	44
h	15	15	15	15	18	18
G	M20	M20	M20	M20	M24	M24
Bolt ISO 4762 12.9	M20 x 40	M20 x 40	M20 x 40	M20 x 40	M24 x 60	M24 x 60
Tighten torque Md max (Nm)	300	300	300	300	450	450

Adapters for BIG BORE chucks

ISO-A DIN 55026 mounting adapters



BB-N	400-140/470-191			500-205/500-230			600-275			630-310			800-410	
Spindle nose	A8	A11	A15	A11	A15	A20	A11	A15	A20	A11	A15	A20	A15	A20
Id. No.	24184020	24114020	24124020	24115030	24125020	24175020	24116020	24126020	24176020	24116320	24126320	24176320	24128020	24178020
A mm	40	40	40	40	40	40	40	40	40	50	50	50	50	50
B mm	139.719	196.869	285.775	196.869	285.775	412.775	196.869	285.775	412.775	196.869	285.775	412.775	285.775	412.775
C mm	171.4	235	330.2	235	330.2	463.6	235	330.2	463.6	235	330.2	463.6	330.2	463.6

Bayonet and camlock flanges are available on request



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