

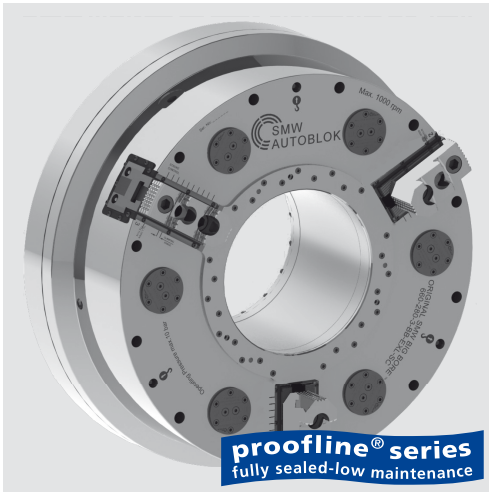
BIG BORE® BB-EXL-SC2G

INCH serration

Front-end spring clamp power chucks

Ø 191 - 390 mm

- EXTRA LARGE THROUGH HOLE
- Clamping with gas spring
- Extra long rapid and clamping stroke



Application/customer benefits

- End machining of long pipe/self centering clamping
- Long jaw stroke to clear upset piping
- Highest productivity/open and clamp time < 3 sec.
- Low maintenance = high availability of the machine
- Step mode for partial opening/clamping for shimming
- Full spindle bore can be used

Technical features

- Self centering clamping with either 9/6/3 gas spring
- Encapsulated gas spring
- Opening via integrated cylinder
- Permanent grease lubricated for constant grip force
- Step mode for opening/clamping for shimming
- Long jaw stroke with rapid and clamping stroke
- Low air consumption
- Stroke control
- Extra long jaw stroke (1 1/2" total)
- **proofline® chucks** = fully sealed – low maintenance

Standard equipment

- Chuck with mounting bolts
- 1 set of soft top jaws
- 1 set of T-nuts and bolts

Ordering example

Big Bore BB-EXL-SC2G 900-390
Id. No. 77784388

Accessories

Air control

The reliable principle: Clamping via spring/opening via air cylinder

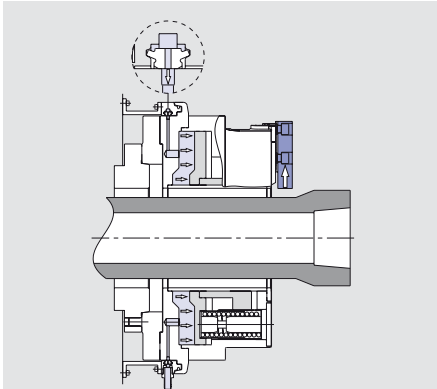


Fig. 1

Chuck open (only at stopped spindle). The SMW profile seal collapses radial under the air pressure and seals against the chuck body. The cylinder chamber is filled. The piston is compressing the springs, the jaws open.

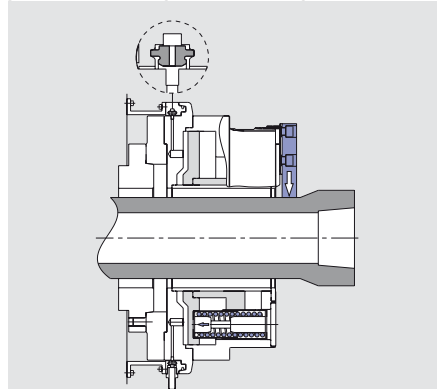


Fig. 2

Chuck clamped. The SMW profile seal lifts off the chuck body due to elastic force. The springs expand and transmit their force onto the jaws via the wedge hook drive. The spindle can rotate.

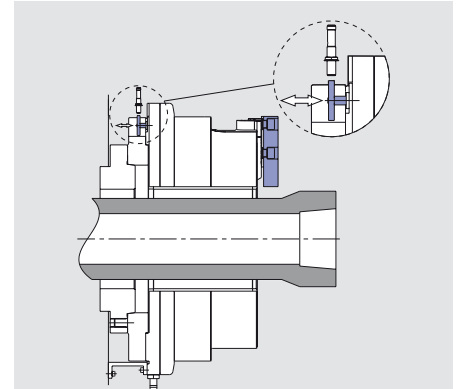
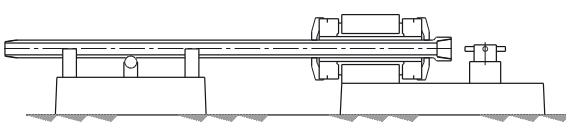
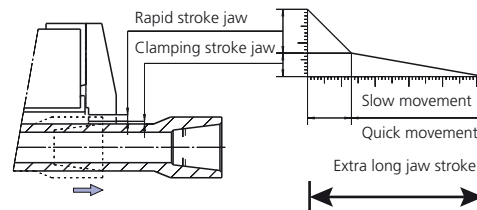


Fig. 3

Stroke control. The position of the jaws can be monitored via a mechanical cam by 1 or 2 proximity switches.



End machining of tubes with front and rear chucks



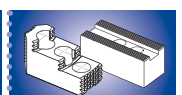
Technical data

SMW-AUTOBLOK Type		BB-EXL-SC2G 510-191	BB-EXL-SC2G 660-280	BB-EXL-SC2G 900-390
Id. No.		77784353	77784366	77784388
Chuck trough hole	mm	191	280	390
Total stroke per jaw	mm	38.5	38.5	38.5
Rapid stroke per jaw*	mm	30	30	30
Clamping stroke per jaw	mm	8.5	8.5	8.5
Opening pressure with all springs	bar	5	5	5
Max. gripping force at 3/6/9 springs	kN	57 114 -	82 164 -	82 164 245
Max. speed	r.p.m	1100	1000	680
Air consumption to open at 6 bar (73 psi)	l	37	92	125
Weight (without top jaws)	kg	318	500	950
Moment of inertia	kg-m ²	14	36	117

*must not be used for clamping



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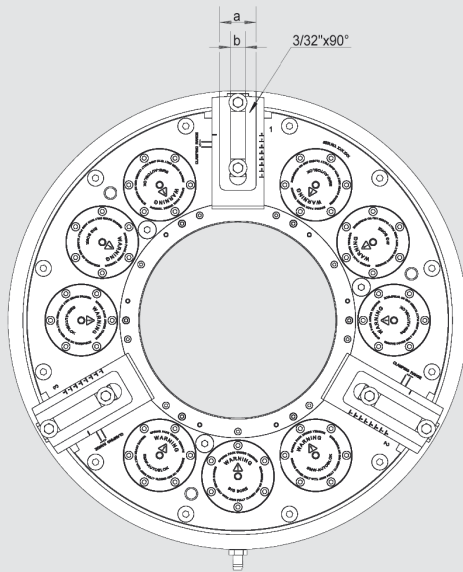


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BIG BORE® BB-EXL-SC2G

INCH serration

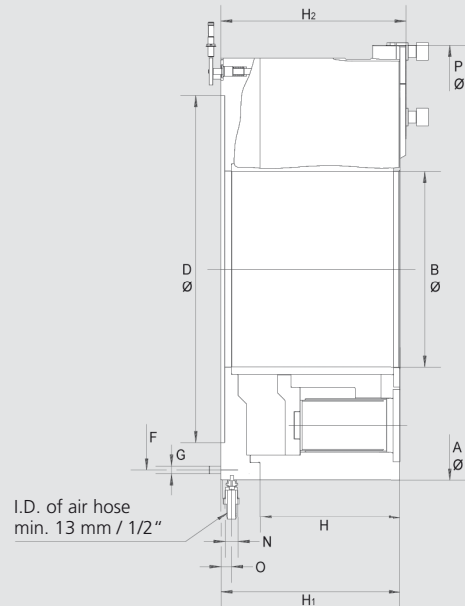
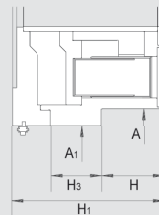
Main dimensions and technical data



Opening pressure with all springs mounted
min. 5 bar, max. 8 bar

Subject to technical changes
For more detailed information please ask for customer drawing

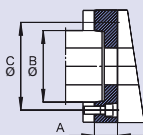
BB-EXL-SC-600-900



SMW-AUTOBLOK Type			BB-EXL-SC2G 510-191		BB-EXL-SC2G 660-280		BB-EXL-SC2G 900-390	
Mounting			Z310		Z450		Z700	
Through hole	A	mm	520		673		900	
	A1	mm	596		738		-	
	B	mm	191		280		390	
	DH6	mm	310		460		700	
	F	mm	494		632		780	
	G		M12 (9x)		M12 (12x)		M16 (12x)	
	H	mm	158		152		-	
	H1	mm	272		272		301	
	H2	mm	279		279		310	
	N	inch	G 1/2"		G 1/2"		G 1/2"	
max. swing	O	mm	39		47		57	
	P	mm	596		760		986	
	a	mm	57		62		75	
	b	mm	25.5		25.5		30	
Rapid stroke		mm	30		30		30	
Clamping stroke		mm	8.5		8.5		8.5	
Total clamping stroke		mm	38.5		38.5		38.5	

Spindle adapters

Mounting
ISO-A
DIN 55026



SMW-AUTOBLOK Type	BB-EXL-SC2G 510-191			BB-EXL-SC2G 660-280			BB-EXL-SC2G 900-390	
Spindle nose	A11	A15	A20	A11	A15	A20	A15	A20
Id. No.	24115130	24125130	24175130	24116630	24126630	24176630	24128830	24178830