

- open center - QUICK JAW CHANGE
- 2 and 3 jaws



Application/customer benefits

- For open center or partial open center clamping
- From middle size to big production batches
- Shortest set-up times with jaw change in seconds

Technical features

- Gripping force transmission via wedge hook
- Quick jaw change with case hardened pallets
- High accuracy and rigidity of the quick change system allowing high repeatability
- Case hardened body to assure greatest precision and long chuck life

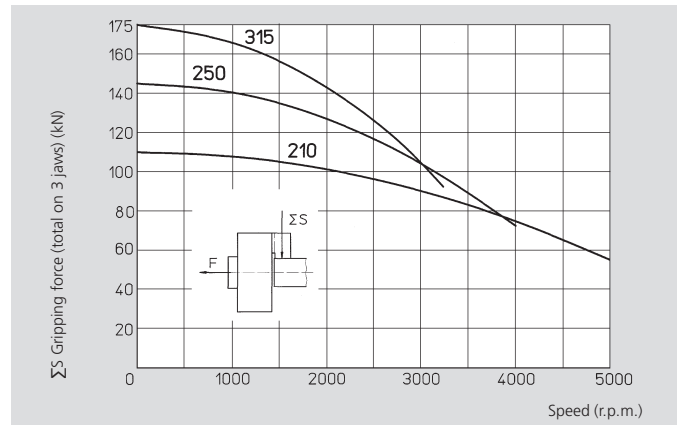
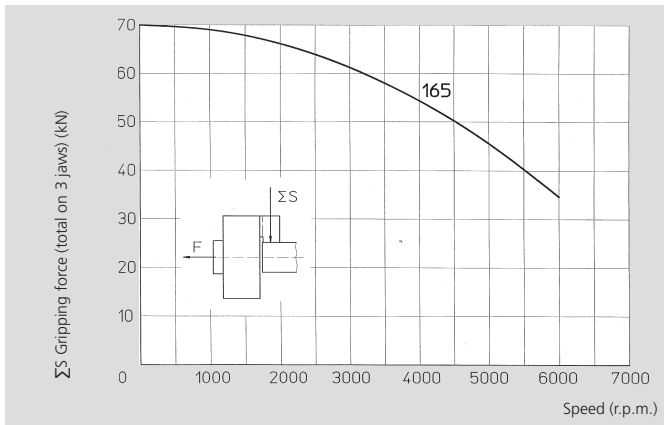
Standard equipment

- 2 or 3 jaw chuck
- 1 set quick change pallets
- Quick change key
- Mounting bolts
- Grease gun

Ordering example

- 2 jaw chuck BH-RM 250/Z220
- or
- 3 jaw chuck BH-RM 315/A8

Actual gripping force diagrams



The data in the diagrams refer to 3-jaw-chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K05 grease. The static and dynamic gripping forces have been measured using standard soft top jaws, placed in a position not exceeding the outer diameter of the chuck.

⚠ Safety advice/danger of damage:

When using taller/heavier jaws and/or clamping on a bigger diameter reduce draw pull/rotating speed accordingly.

Technical data

SMW-AUTOBLOK Type	BH-RM 165		BH-RM 210		BH-RM 250		BH-RM 315		
	2	3	2	3	2	3	2	3	
Number of jaws									
Through-hole	mm	26	36	48	66				
Radial jaw stroke	mm	3.2	4	5	5				
Axial piston stroke	mm	15	19	24	24				
Max. draw-pull**	kN	17	25	25	38	34	50	40	60
Max. gripping force**	kN	48	70	72	110	98	145	115	175
Max. speed*	r.p.m.	6000		5000		4000		3200	
Weight (without pallets and top jaws)	kg	9.5		19		30		46	
Moment of inertia	kg·m ²	0.036		0.12		0.27		0.62	
Max top jaw weight*	kg	0.55		0.8		1.45		2.4	
Recommended actuating cylinders	Type	SIN-S 100		SIN-S 100/125		SIN-S 125/150		SIN-S 125/150	
		VNK 102/46		VNK 130/52		VNK 150/67		VNK 225/95	

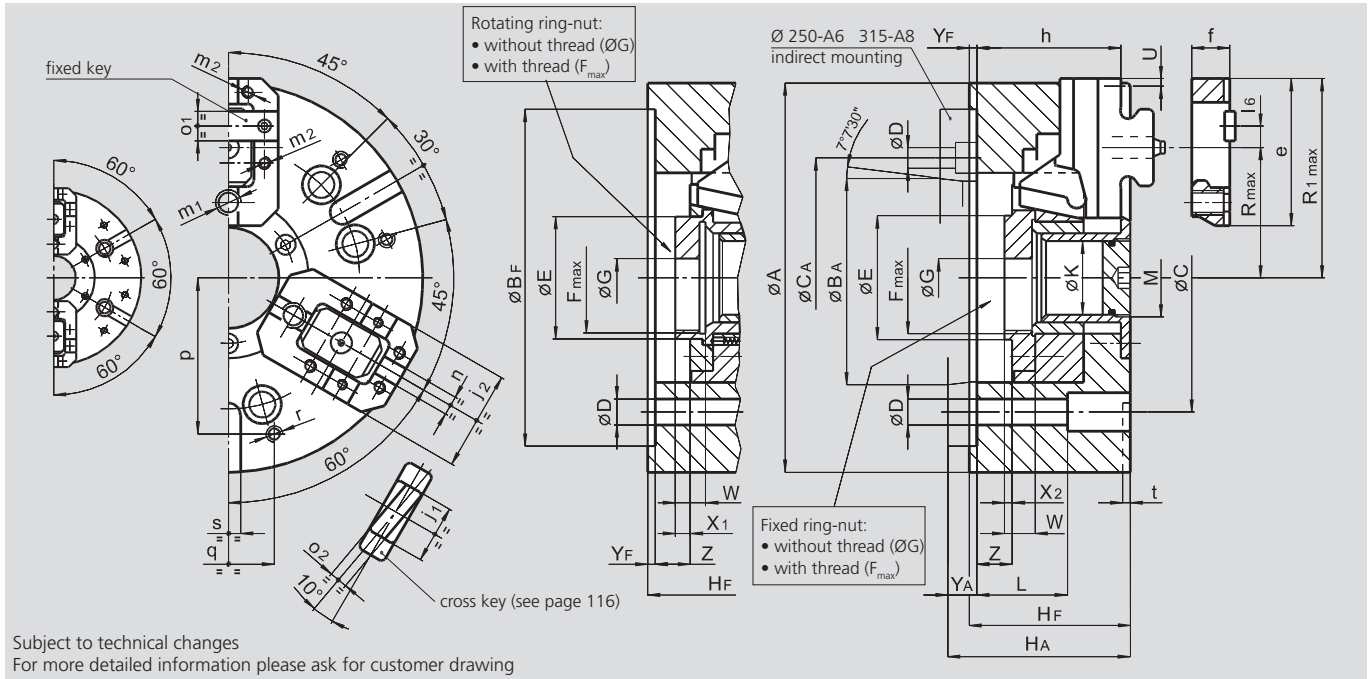
* **Attention:** max. speed can only be reached at the max draw-pull, using clamping jaws not heavier than the values shown in the above schedule and not exceeding the chuck O.D.

** For internal clamping reduce the draw pull by 30 %



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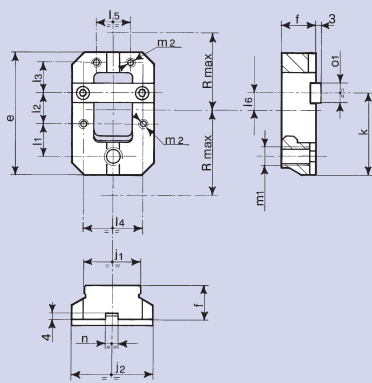
Palletized
QUICK JAW CHANGE



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

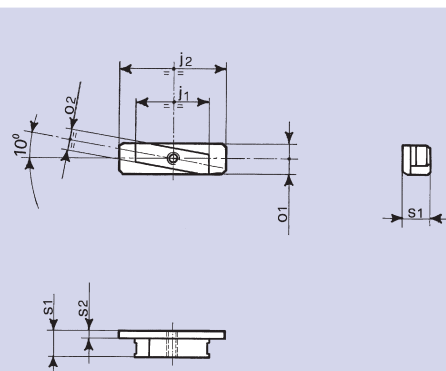
SMW-AUTOBLOK Type			BH-RM 165		BH-RM 210		BH-RM 250			BH-RM 315		
Mounting			Z140	A5	Z170	A6	Z220	A6	A8	Z300	A8	A11
	A	mm	165		210		254			315		
	Bf/BA	H6 mm	140	82.563	170	106.375	220	106.375	139.719	300	139.719	196.869
	C	mm	104.8		133.4	171.4	-	171.4	235	-	235	-
	CA	mm	-	-	-	-	-	133.4	-	-	171.4	-
	D	mm	11.5		13.5		17			21		
	E	mm	56		67		78			111		
	F _{max}	mm	M50 x 1.5		M60 x 1.5		M72 x 1.5			M102 x 2		
	G	mm	20		20		20			25		
	Hf/HA	mm	75	85	92	104	105	124	119	111	136	127
	K	mm	26		36		48			66		
	L	mm	55		66		59			33		
	M	mm	M28 x 1.5		M38 x 1.5		M50 x 2			M68 x 2		
Chuck open	R1	mm	85		107		130			160		
max.	R	mm	55		70		85			105		
Stroke per jaw	U	mm	3.2		4		5			5		
	W	mm	14		16		18			20		
	X1	mm	11		11		11			12		
	X2	mm	5		5		6			7		
	Yf/YA	mm	5	15	5	17	5	24	19	5	30	21
max./min.	Z	mm	15/0		19/0		24/0			24/0		
	e	mm	63		79		96			116		
	f	mm	19		22		25			25		
	h	mm	65		80		94			100		
	j1	mm	24		32		38			38		
	j2	mm	44		52		65			65		
	l6	mm	10		11		14			14		
	m1	mm	M10		M12		M16			M16		
	m2	mm	M5		M6		M8			M8		
	n	H7 mm	7.94		7.94		12.7			12.7		
	o1	h7 mm	12.68		12.68		19.03			19.03		
	o2	h7 mm	9		9		12			12		
	p	mm	65		80		102			100		
	q	mm	36		45		60			60		
	r	mm	M8		M8		M10			M10		
	s	H12 mm	16		16		16			20		
	t	mm	5		5		5			5		

Accessories for AN-RM + BH-RM chucks



Quick jaw change pallets for AN-RM and BH-RM chucks

Diam.	Id. No.	e	f	j2	k	l1	l2	l3	l4	l5	l6	m1	m2	n (H7)	o1 (H7)	Rmax
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
165	15701633	63	19	44	43	17	16	13	32	18	10	M10	M5	7.94	12.68	56
210	15702133	79	22	52	53	21	20	18	38	18	11	M12	M6	7.94	12.68	70
250	15702533	96	25	65	65	26	24	22	47	26	14	M16	M8	12.7	19.03	85
315	15703133	116	25	65	75	31	28	31	47	26	14	M16	M8	12.7	19.03	105
400	15704033	138	28	85	86	36	33	40	65	45	14	M20	M10	12.7	19.03	130

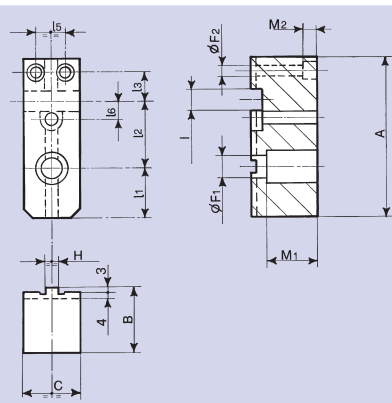


Cross key

(for radial fine adjustment of top jaws)

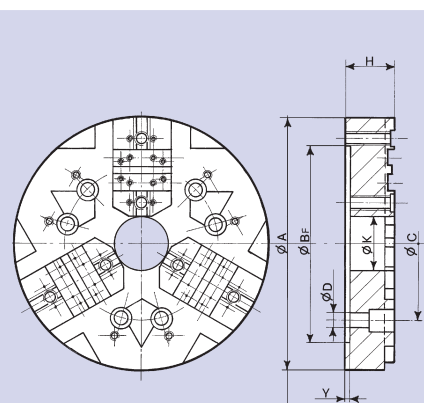
The clamping hard top jaws can be machined with the tenon slot inclined to 10°. So it is possible to use the keys on the pallets for quick, fine adjustment of component centering. In this way, it is possible to grind the clamping surfaces of the top jaws on a separate plate (see below).

Diam.	Id. No.	j1	j2	o1 (h7)	o2 (h7)	s1	s2
		mm	mm	mm	mm	mm	mm
165	15711633	24	38	12.68	9	11	3
210	15712133	32	46	12.68	9	11	3
250-315	15712533	38	56	19.03	12	11	3
400	15714033	46	70	19.03	12	14.5	4.5



Soft top jaws for AN-RM and BH-RM chucks

Diam.	Id. No.	A	B	C	F1	F2	H	I (H7)	M1	M2	l1	l2	l3	l5	l6
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
165	15771633	80	35	30	11	5.5	7.94	12.68	26	6	27	33	13	18	10
210	15772133	98	40	35	13.5	7	7.94	12.68	31	7	31	41	18	18	11
250	15772533	120	45	45	17	9	12.7	19.03	34	9	39	50	22	26	14
315	15773133	145	50	50	17	9	12.7	19.03	39	9	45	59	31	26	14
400	15774033	170	60	60	21	11	12.7	19.03	42	11	49	69	40	35	14



Plates with fixed joint for the separate grinding of hard top jaw clamping surfaces for AN-RM and BH-RM chucks

Diam.	Id. No.	A	BF (H5)	C	D	H	K	Y
		mm	mm	mm	mm	mm	mm	mm
165	41771001	185	140	104.8	11.5	43	30	5
210	41771002	230	170	133.4	13.5	53	45	5
250	41771003	280	220	171.4	17	53	60	5
315	41771004	340	300	235	21	58	80	5
400	41771005	420	300	235	21	58	80	5

Attention: When ordering, please specify Id. number. Subject to technical changes.

Important for maintenance and safe operation, to be ordered with the chuck

K05®

Special grease for manual and power chucks



Cartridge 14 Oz.
(DIN 1283)
Grease content: 500 g
Id. No. 016440

Can 1000 g
Id. No. 011881



- High adhesion
- High resistance against coolant = long lubrication intervals
- Low friction coefficient = high gripping force
- Avoids tribocorrosion

K67®

Special grease for fully sealed chucks included in proofline® series



Cartridge 14 Oz.
(DIN 1284)
Grease content: 500 g
Id. No. 10731223

Can 1000 g
Id. No. 10731224



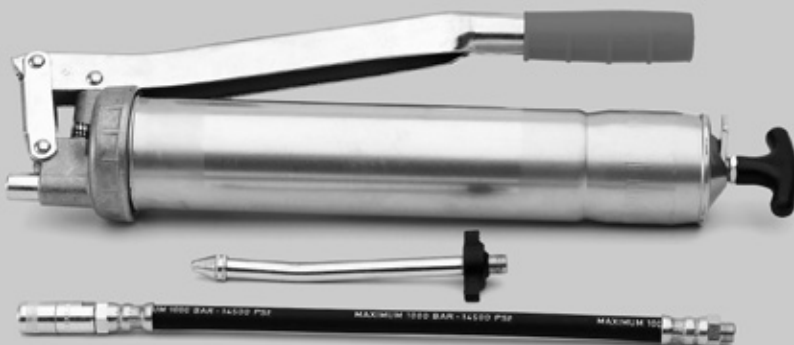
- For sealed chucks with constant grease lubrication
- Basic components: mineral oils and lithium
- Without solvents

Greasing set

Id. No. 083726

Grease gun (DIN 1283) for cartridges 14 Oz. (DIN 1284).

- also refillable from grease can 1000 g



Supply range:

- Grease gun
- 1 adapter flexible for high pressure grease fitting
- 1 adapter for cone grease fitting