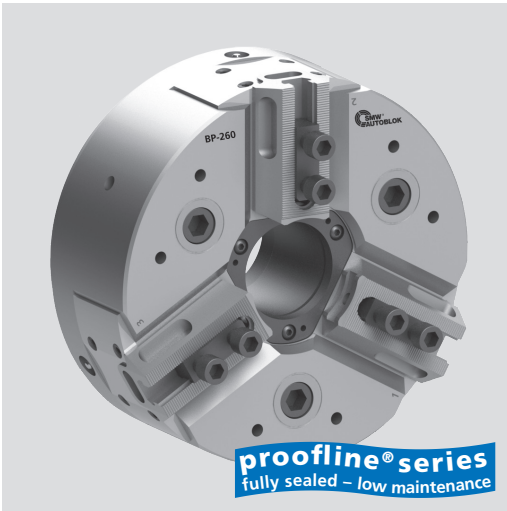


BP-D	BP-M	High precision power chuck Ø 220 - 320 mm
INCH SERRATION	METRIC SERRATION	■ Large through-hole ■ 3 jaws ■ proofline® chucks = fully sealed - low maintenance



Application/customer benefits

- General use on standard lathes due to the through-hole, but with advantage of minimum maintenance and use also in extreme environments
- Longer life at high precision due to less wear
- Fully sealed, ideal for dry machining of castings and forgings or if high pressure coolant is used

BP-D: Master jaws with INCH SERRATION (1/16" x 90°)
BP-M: Master jaws with METRIC SERRATION (1.5 mm x 60°)
(suitable for japanese jaws)

Technical features

- Constant gripping force with permanent grease lubrication
- Large through-hole compatible with the standard machines
- Chuck body and internal parts case hardened
- **Proofline® chucks** = fully sealed - low maintenance

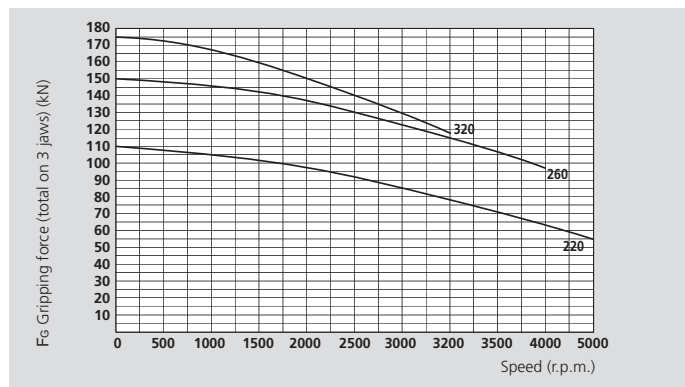
Standard equipment

- 3-jaw chuck
- 1 set T-nuts and bolts
- 1 set soft top jaws
- Mounting bolts

Ordering example

3-jaw chuck BP-D 220 / Z170
or
3-jaw chuck BP-M 220 / A6

Actual gripping force diagram



The data in the diagram refers to 3-jaw chucks, newly maintained according to their service manuals using SMW-AUTOBLOK K67 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.

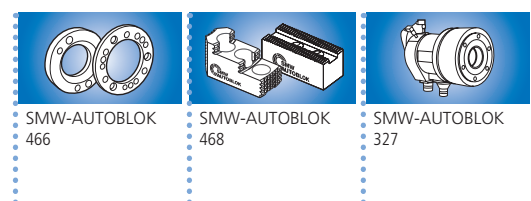
⚠ Safety advice / danger of damage:

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

Technical data

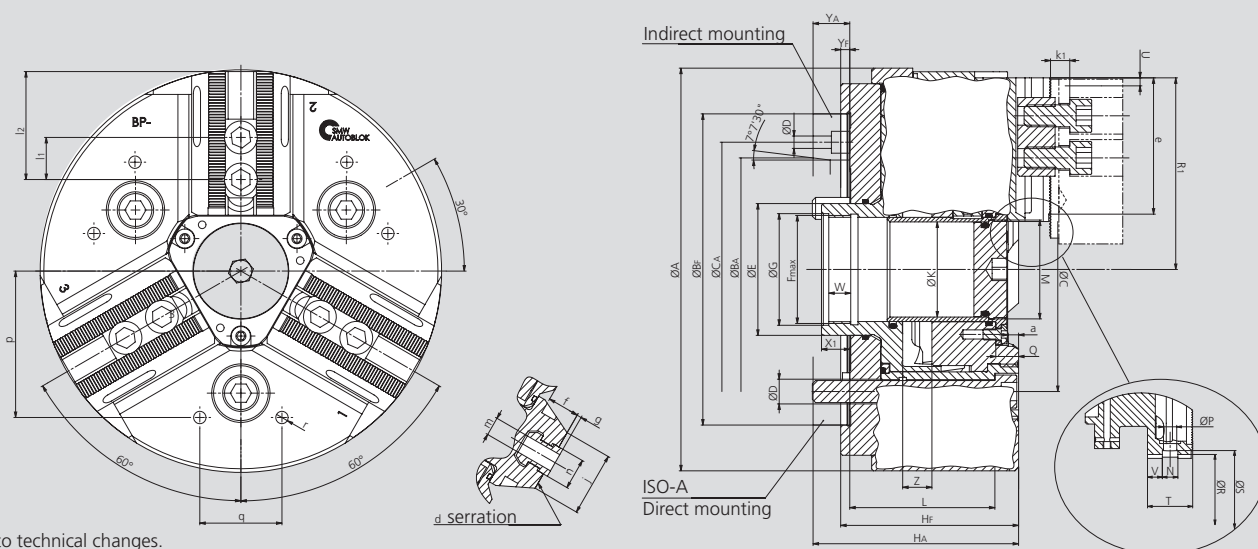
SMW-AUTOBLOK Type		BP-D 220 BP-M 220	BP-D 260 BP-M 260	BP-D 320 BP-M 320
Number of jaws		3	3	3
Through-hole	mm	52	66	95
Radial jaw stroke	mm	4	5	5
Axial piston stroke	mm	16	19	19
Max. actuating force*	kN	44	60	68
Max. gripping force*	kN	110	150	175
Max. speed	r.p.m.	5000	4000	3200
Weight (without top jaws)	kg	23	36	60
Moment of inertia	kg-m²	0.14	0.34	0.85
Recommended actuating cylinders without hole		SIN-S 100 / 125	SIN-S 125 / 150	SIN-S 125 / 150
Recommended actuating cylinders with hole		VNK-T2 130-52	VNK-T2 150-67	VNK-T2 225-95
Id. No. BP-D 3 jaws (Center mounting)		77185122	77185126	77185132
Id. No. BP-M 3 jaws (Center mounting)		77185222	77185226	77185232

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



BP-M

- METRIC
SERRATION**



SMW-AUTOBLOK Type			BP-D 220 BP-M 220		BP-D 260 BP-M 260			BP-D 320 BP-M 320			
Mounting			Z170	A6	Z220	A6	A8	Z300	A8	A11	
	A	mm	220		262			320			
	Bf/BA	H6	mm	170	106.375	220	106.375	139.719	300	139.719	196.869
	C	mm	133.4		171.4			235			
	CA	mm	-	-	-	133.4	-	-	171.4	-	
	D	mm	13.5		17	13.5	17	21			
	E	mm	72		88			115			
	Fmax	mm	M60 x 1.5		M75 x 2			M102 x 2			
	G	mm	61		76			102.5			
	Hf/HA	mm	97.5	109.5	114	149	128	114	149	130	
	K	mm	52		66			95			
	L	mm	79.5		92			88			
	M	mm	M54 x 1.5		M68 x 2			M98 x 2			
	N	H8	mm	8		10			10		
	P	mm	6.5		8.5			8.5			
	Q	mm	12.5		16.5			16.5			
	R	H7	mm	59		76			108		
Chuck open	R1	mm	109		131			159			
	S	mm	63		81			113			
	T	mm	23.5		22			29			
Jaw stroke	U	mm	4.3		5			5			
	V	mm	7.75		6			9.5			
	W	mm	12		14			16.5			
	X1	mm	15.5		22			21			
	Yf/YA	mm	5	17	5	40	19	5	40	21	
Max. / min.	Z	mm	16 / 0		19 / 0			19 / 0			
	a	mm	5.7		9.7			9.7			
BP-D Serration	d	inch	1/16" x 90°		1/16" x 90°			1/16" x 90°			
BP-M Serration	d	mm	1.5 x 60°		1.5 x 60°			1.5 x 60°			
	e	mm	74.5		89			100.5			
	f	mm	17.5		12			19			
	g	mm	2.5		2.5			3.5			
	j	mm	34		35.22			35			
	k1	mm	10.5		12			12			
BP-D/BP-M	l1	mm	23 / 25		30			30			
Max. / min.	l2	mm	55.5 / 33		67 / 43			78 / 43			
BP-D/ BP-M	m	mm	M12		M12			M16			
BP-D	n	h8	mm	17		17			21		
BP-M	n	h8	mm	14		16			21		
	p	mm	80		102			100			
	q	mm	45		60			60			
	r	mm	M8		M10			M10			