

HB-D

INCH SERRATION
2 or 3 jaws

HB-C

TONGUE & GROOVE
3 jaws

Stationary chuck, hydraulic Ø 130 - 315 mm

- Built-in hydraulic cylinder
- 2 and 3 jaws



Application/customer benefits

- Stationary hydraulic chuck for self centering clamping of parts on milling machines, machining centers and special machines

HB-D: INCH SERRATED master jaws (1/16" x 90°)

HB-C: TONGUE & GROOVE master jaws (American standard)

HB-M: METRIC SERRATED master jaws (1.5 mm x 60°) **on request from Ø 165**

Technical features

- Stationary chuck consisting of a 2- or 3-jaw self centering chuck with built-in hydraulic cylinder
- Compact design
- Case hardened body to assure consistent high precision and long chuck life

Standard equipment

Stationary chuck
1 set T-nuts with bolts
(HB-C excluded)
1 set of soft blank top jaws
(HB-C excluded)

Ordering example

Stationary chuck HB-C 250 (3 jaws)
or
Stationary chuck HBL-D2 165 (2 jaws)

Technical data

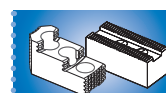
SMW-AUTOBLOK Type		HB-D 130	HB-D 165 HB-C 165	HB-D 210 HB-C 210	HB-D 250 HB-C 250	HB-D 315 HB-C 315
Radial jaw stroke	mm	3	3.2	4	4.6	5.5
Radial jaw stroke HBL-D2 (2 jaws)*	mm	5.6	6	7.5	8.8	10.5
Piston area	cm²	63	79	114	167	203
Max. operating pressure	bar	30	30	30	30	30
Gripping force at 25 bar	kN	50	55	85	125	150
Gripping force at 25 bar HBL-D2 (2 jaws)*	kN	28	35	52	75	90
Weight (without top jaws)	kg	9.5	18	30	44	69
Id. No. HB-D 3 jaws		77271113	77271116	77271121	77271125	77271131
Id. No. HB-C 3 jaws		-	77277516	77277521	77277525	77277531
Id. No. HBL-D 2 jaws		-	77271716	77271721	77271725	77271731

* The HBL-D 2 jaw fixture is available with serrated master jaws (inch or metric) and long stroke only.

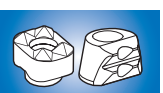


JAWS-CATALOG

Request or
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SMW-AUTOBLOK
468



SMW-AUTOBLOK
472

Stationary chuck, hydraulic Ø 130 - 315 mm

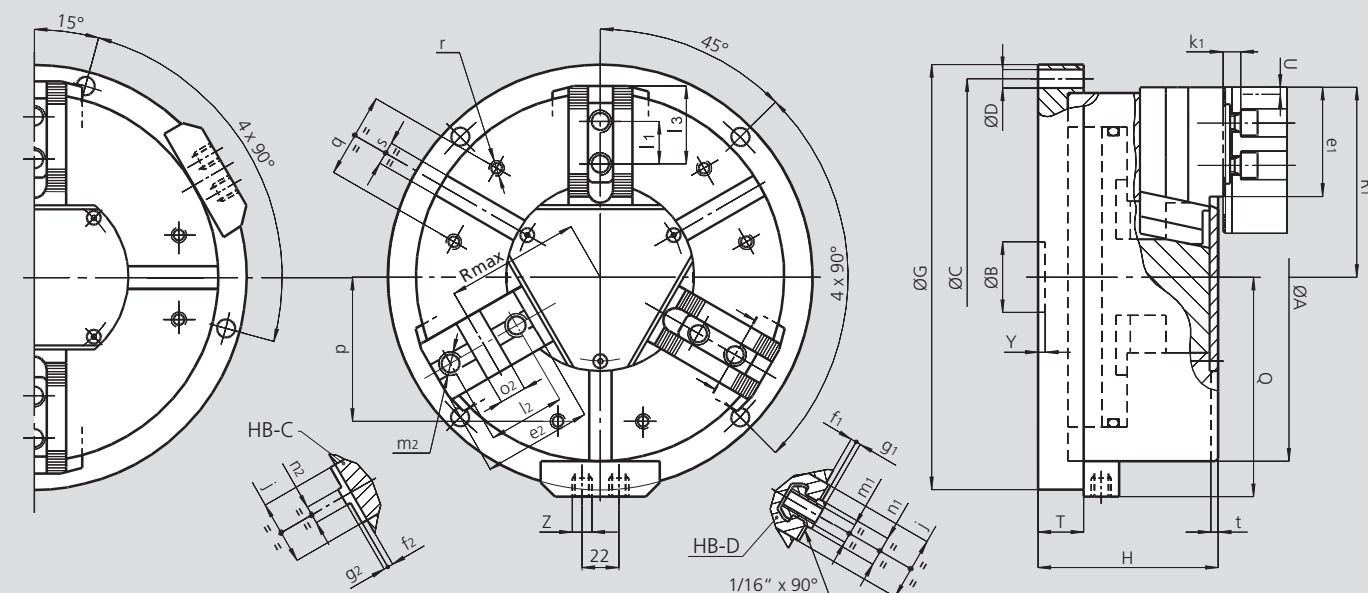
- Built-in hydraulic cylinder
- 2 and 3 jaws

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Subject to technical changes.
For more detailed information please ask our customer service.

Common dimensions

SMW-AUTOBLOK Type			HB-D 130	HB-D 165 HB-C 165	HB-D 210 HB-C 210	HB-D 250 HB-C 250	HB-D 315 HB-C 315
	A	mm	135	170	215	260	315
	B	mm	30	30	35	50	50
Fixing holes circle	C	mm	155	190	235	280	340
Fixing holes diameter	D	mm	9	11	11	13	13
	G	mm	175	210	255	300	360
	H	mm	89	100	117	127	141
	Q	mm	92.5	110	133	155	183
	T	mm	25	27	30	32	32
Radial jaw stroke (3 jaws)	U	mm	3	3.2	4	4.6	5.5
Radial jaw stroke HBL-D2 (2 jaws)	U	mm	5.6	6	7.5	8.8	10.5
	Y	mm	5	5	5	5	5
Hydraulic connections	Z	inch	R1/4"	R1/4"	R1/4"	R1/4"	R1/4"
	j	mm	26	30	36	45	45
	k1	mm	10	10	11	12	12
	p	mm	52	65	80	102	120
	q	mm	30	36	45	60	60
	r	mm	M6	M8	M8	M10	M10
	s H12	mm	12	16	16	16	16
	t	mm	3.5	5	5	5	5

HB-D and HBL-D2 fixtures specific dimensions

SMW-AUTOBLOK Type			HB-D 130	HB-D 165	HB-D 210	HB-D 250	HB-D 315
	e1	mm	45	48	60	77	99
	f1	mm	3	4	3	4	4
	g1	mm	2.5	2.5	2.5	3.5	3.5
	l1	mm	16	16.5	23	30	30
T-nut position min. / max.	l3	mm	23 / 30	24 / 40	33 / 50	43 / 62	43 / 84
	m1	mm	M8	M10	M12	M16	M16
	n1 h8	mm	12	14	17	21	21
Chuck open HB-D (3 jaws)	R1	mm	71	89	110	134	162
Chuck open HBL-D2 (2 jaws)	R1	mm	74	92	114	138.5	168

HB-C fixtures specific dimensions (available only as 3-jaw chuck version)

SMW-AUTOBLOK Type			HB-C 165	HB-C 210	HB-C 250	HB-C 315
	e2	mm	54	71	77	99
	f2	mm	4	4	4	4
	g2	mm	3	3	3	3
	l2	mm	38	44.4	54	63.5
	m2	mm	M10	M12	M16	M16
	n2 h8	mm	7.94	7.94	12.70	12.70
	o2 H7	mm	12.68	12.68	19.03	19.03
Chuck open	R1	mm	89	110	134	162
Chuck open	Rmax	mm	62	77	94	109