

HB-D	HB-C	Hydraulic chuck fixtures with built-in cylinder
INCH serration 2 or 3 jaws	Tongue & groove 3 jaws	■ Ø 130 - 315 mm ■ 2 or 3 jaws



Application/customer's benefit

Self centering chuck fixtures used on milling machines, machining centers or 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**

Technical features

Independent units consisting of a 2/3 jaw chuck with an built in hydraulic cylinder

Reduced overall dimensions on the machine

High gripping force and very high precision

Case hardened body to assure highest precision and long chuck life

Standard equipment

Clamping unit

1 set T-nuts with bolts (HB-C excluded)

Grease gun

Ordering example

3 jaw chuck fixture HB-C 250

or

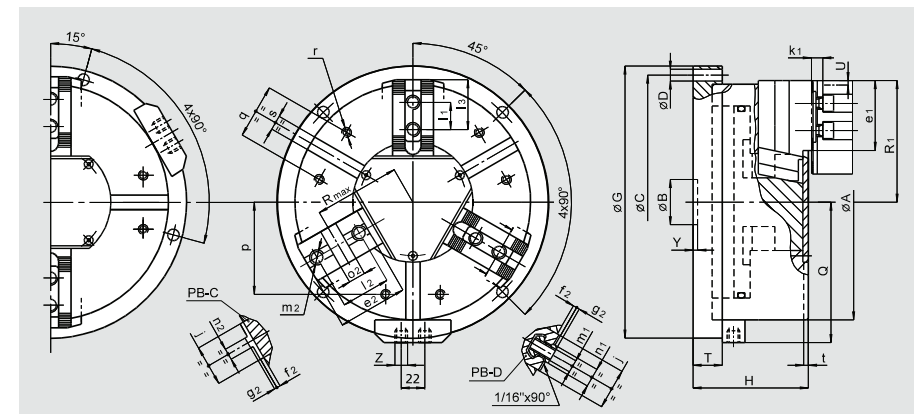
2 jaw chuck fixture HBL-D2 165

Technical data

SMW-AUTOBLOK Type Code		HB-D 3 (3 jaws) 130 77271113	HB-D 3 (3 jaws) 165 77271116	HB-D 3 (3 jaws) 210 77271121	HB-D 3 (3 jaws) 250 77271125	HB-D 3 (3 jaws) 315 77271131
SMW-AUTOBLOK Type Code		HBL-D 2 (2 jaws) 130 77271713	HBL-D 2 (2 jaws) 165 77271716	HBL-D 2 (2 jaws) 210 77271721	HBL-D 2 (2 jaws) 250 77271725	HBL-D 2 (2 jaws) 315 77271731
SMW-AUTOBLOK Type Code		HB-C 3 (3 jaws) 130 N.D.	HB-C 3 (3 jaws) 165 77277516	HB-C 3 (3 jaws) 210 77277521	HB-C 3 (3 jaws) 250 77277525	HB-C 3 (3 jaws) 315 77277531
Radial jaw stroke	mm	2.8	3.2	4	4.6	5.5
Radial jaw stroke HBL-D2 (2 jaws)*	mm	5.2	6	7.5	8.8	10.5
Piston area	cm²	59	79	114	167	203
Max. operating pressure	bar	30	30	30	30	30
Gripping force at 25 bar	kN	42	55	85	125	150
Gripping force at 25 bar HBL-D2 (2 jaws)*	kN	26	35	52	75	90
Mass (without top jaws)	kg	10	18	30	44	69

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

Hydraulic chuck fixtures with built-in cylinder	HB-D	HB-C
■ Ø 130 - 315 mm ■ 2 or 3 jaws	INCH serration 2 or 3 jaws	Tongue & groove 3 jaws



Subject to technical changes

Common dimensions

SMW-AUTOBLOK Type		HB-D 130 HB-C 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
C	mm	155	190	235	280	340
D	mm	9	11	11	13	13
G	mm	175	210	255	300	360
H	mm	89	100	117	127	141
O	mm	93	110	133	155	183
T	mm	25	27	30	32	32
Radial jaw stroke (3 jaws)	U mm	2.8	3.2	4	4.6	5.5
Radial jaw stroke HBL-D2 (2 jaws)	U mm	5.2	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	5	5	5	5	5

HB-D and HBL-D2 fixtures dimensions

SMW-AUTOBLOK Type		HB-D 130	HB-D 165	HB-D 210	HB-D 250	HB-D 315
e1	mm	37	48	60	77	99
f1	mm	3	4	3	4	4
g1	mm	2.5	2.5	2.5	3.5	3.5
h1	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 (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 dimensions (available only in 3 jaw chuck version)

SMW-AUTOBLOK Type		HB-C 130	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