

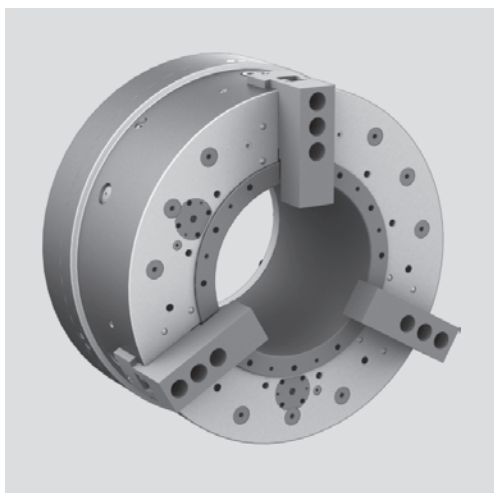
BIG BORE® BB-AZ-ES

INCH serration

Front-end pneumatic power chucks

Ø 220 - 370 mm

- EXTRA LARGE THROUGH HOLE
- self centering or compensating clamping
- chuck with rapid and clamping stroke



Application/customer benefits

- End machining of straight or bent pipe
- Tubes can be clamped self centering or with radial jaw compensation at bent pipe, using a retractable centering chuck
- Full spindle bore can be used

Technical features

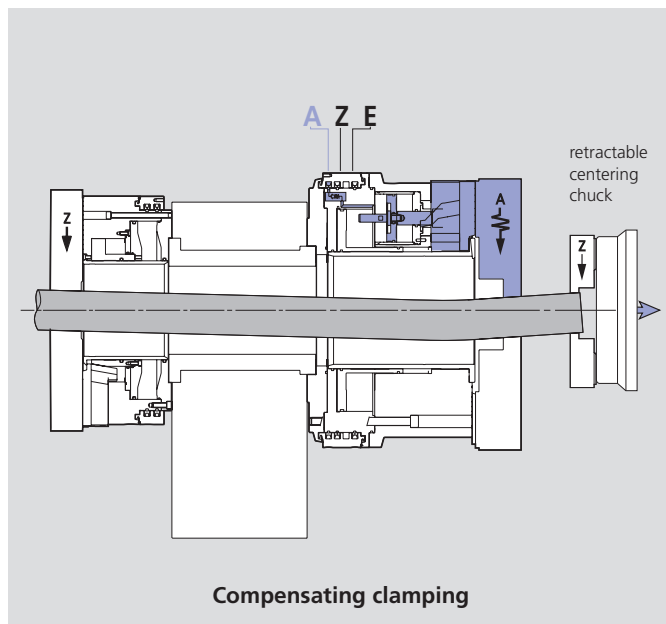
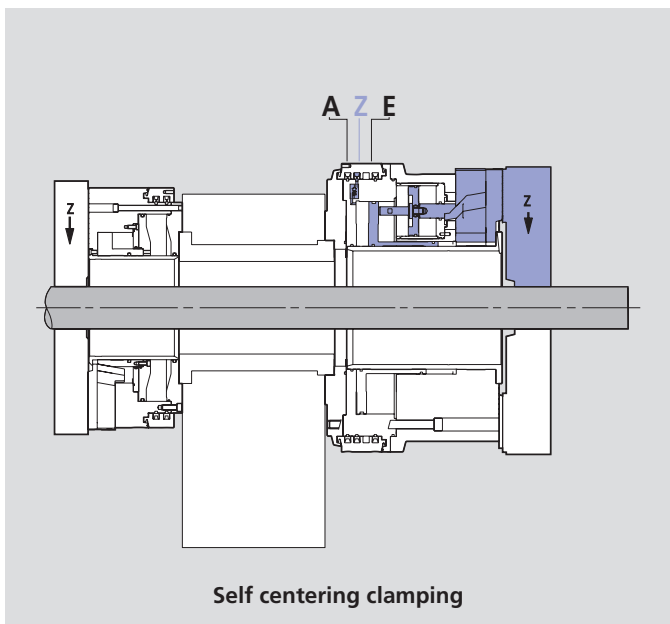
- Air chuck with built-in pneumatic cylinders for self centering or compensating clamping mode
- Air feed for both functions via distributor ring and SMW-AUTOBLOK profile seals at stopped spindle
- Built-in non return valves maintain the air pressure during machining
- Rapid and clamping stroke
- For external clamping only

Standard equipment

Chuck with mounting bolts
1 set of T-nuts with bolts

Ordering example

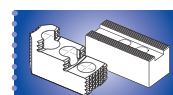
Big Bore BB-AZ-ES 630-270-3 A15



Technical data

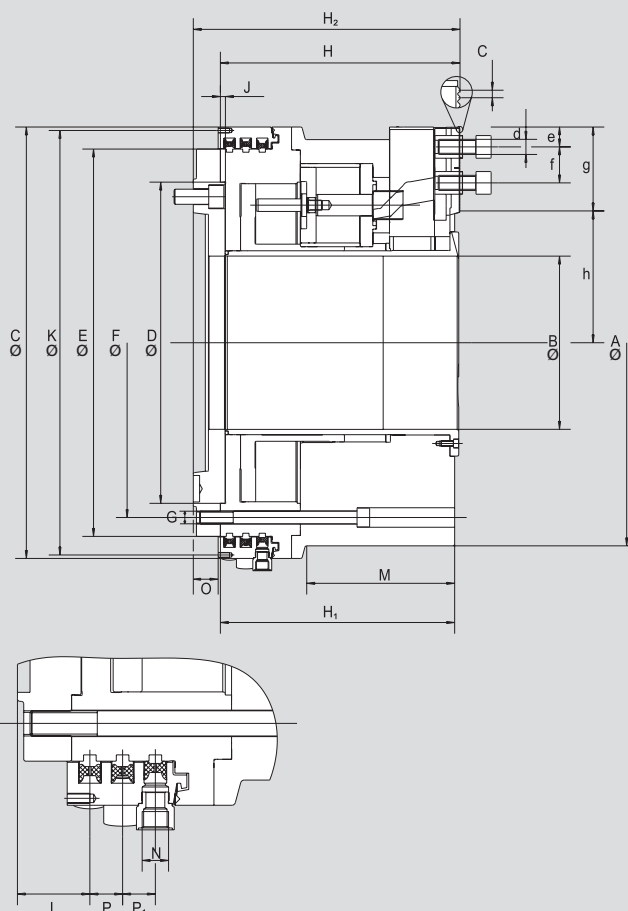
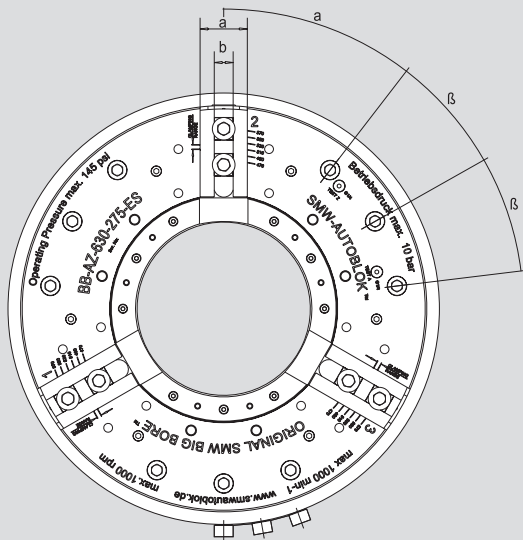
SMW-AUTOBLOK Type		BB-AZ-ES 590-220	BB-AZ-ES 630-275	BB-AZ-ES 750-370
Through-hole	mm	220	275	370
Total stroke per jaw	mm	25.4	25.4	25.4
Rapid stroke per jaw*	mm	16	16	16
Clamping stroke per jaw	mm	9.4	9.4	9.4
Operating pressure min./max.	bar	2	2	2
Piston area	cm ²	991	1333	1505
Gripping force at 6 bar self centering	kN	160	181	240
Gripping force at 6 bar compensating	kN	78	100	100
Max. speed	r.p.m.	1100	1000	750
Air consumption/jaw stroke at 6 bar				
Centering	liter	42	57	64
Compensating	liter	22	29	29
Weight (without top jaws)	kg	548	704	900
Moment of inertia	kg·m ²	25.3	44.2	78

*must not be used for clamping



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Main dimensions and technical data



All hoses must be
min. 3/4".

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

SMW-AUTOBLOK Type			BB-AZ-ES 590-220	BB-AZ-ES 630-275		BB-AZ-ES 750-370
Id. No. A15 mounting			053510	053883	053884	053892
Id. No. A20 mounting						
Mounting			A15	A15	A20	A20
Fixing bolts circle	A	mm	570	645		750
	B	mm	220	275		370
	C	mm	590	685		775
	D H6	mm	415	510		590
	E	mm	520	615		705
	F	mm	468	555		640
	G	mm	M20	M20		M20
	H	mm	380.5	380.5		380.5
	H1	mm	372	372		372
	H2	mm	420.5	423.5		423.5
Thread circle 12 x M8	J	mm	8	8		8
	K	mm	555	674		755
	L	mm	54.5	57.5		57.5
Pneumatic connection	M	mm	235	235		235
	N	inch	G 3/4"	G 3/4"		G 3/4"
	O		33	39.5		36
	P	mm	26	26		26
Serration	P1	mm	26	26		26
	a	mm	61	75		75
	b	mm	25.5	30		30
	c	inch	3/32 x 90°	3/32 x 90°		3/32 x 90°
	d	mm	M20	M24		M24
Bolt ISO 4762 12.9	e	mm	21	25		25
T-nuts distance	min./max. f	mm	30/97	36/98		36/98
Serration length	g	mm	126	135		135
	min./max. h	mm	159.5/184.9	183.9/209.3		258.3/332.9
	α°	deg.	37.5	37.5		37.5
	β°	deg.	22.5	22.5		22.5