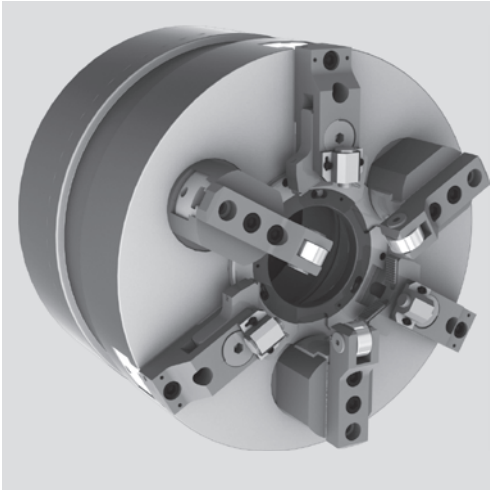


# BIG BORE® BB-FZA

Front-end pneumatic 6-jaw sequence chucks  
Ø 275 - 378 mm

■ 3 integrated centering jaws and 3 compensating jaws



## Application/customer benefits

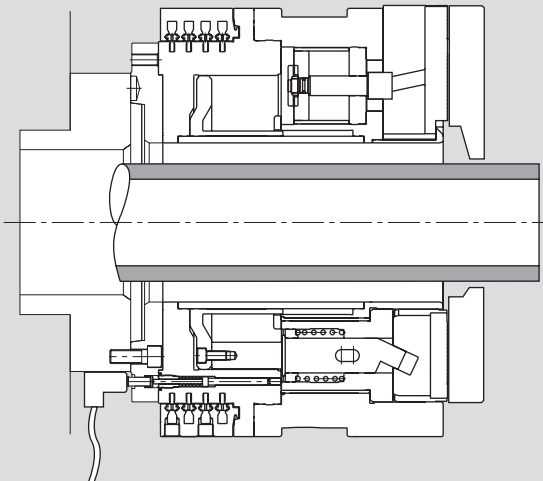
- High efficiency machining of bent or straight pipe
- Fast jaw movement for short cycle times = more pipe per hour
- Full spindle bore can be used

## Technical features

- 3+3 jaw air chuck with 3 integrated centering jaws and 3 compensating jaws
- Integrated centering jaws move axially forward to center the tube exactly at the area to be threaded
- For external clamping only
- Fully automatic sequence is programmable

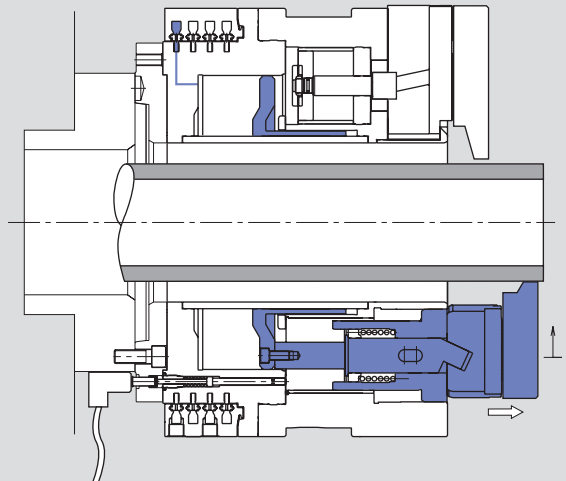
## Machining of bent pipe with chuck with integrated centering jaws:

1



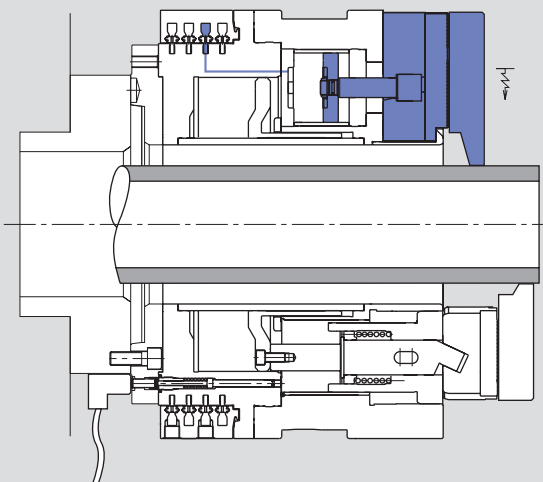
Chuck open, load pipe

2



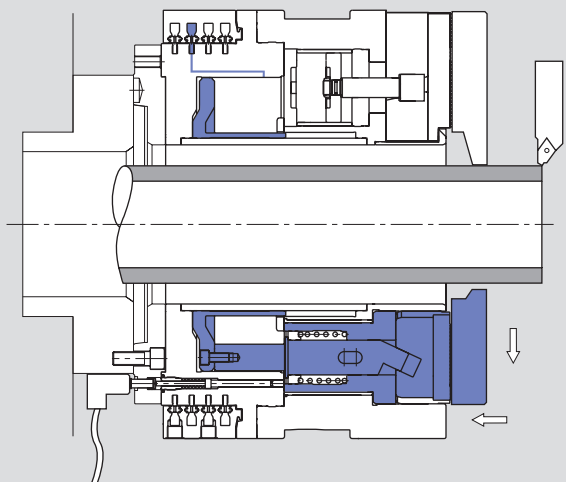
Centering jaws move forward axially to center the pipe at the threading area

3



Compensating jaws pick up the pipe in the centered position

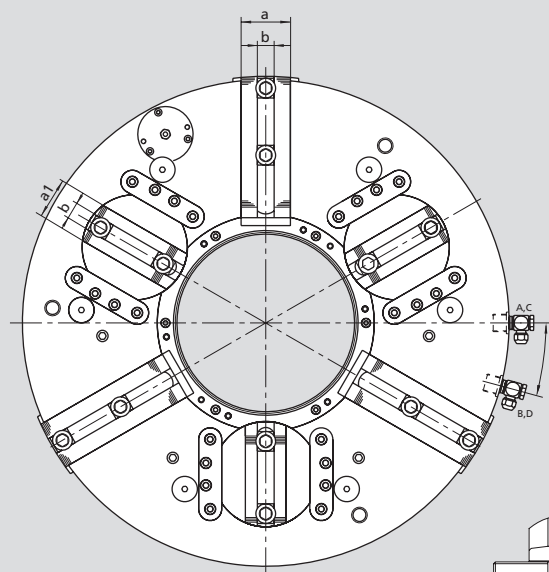
4



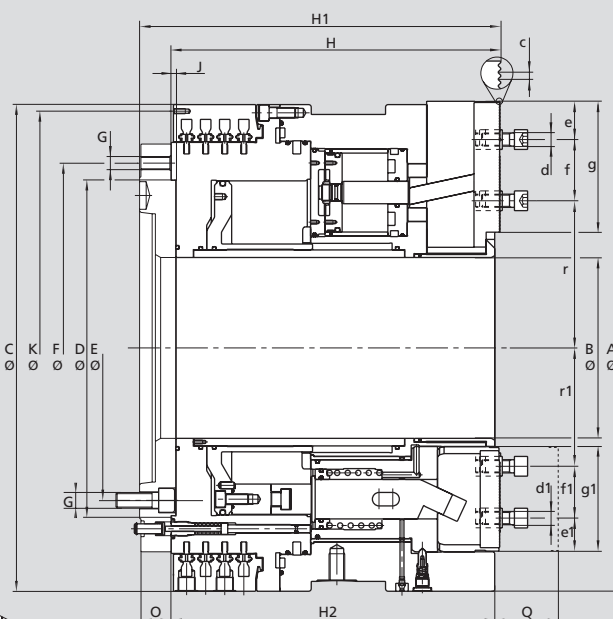
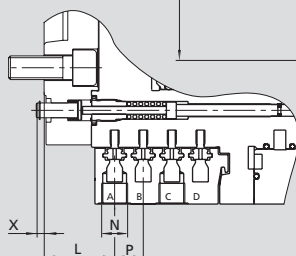
Centering jaws open and retract back axially into the chuck body. The pipe can now be machined.

# BIG BORE® BB-FZA

## 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-FZA 740-275-A20 | BB-FZA 920-378-A20 |
|-------------------------------------------|----|--------|--------------------|--------------------|
| Id. No.                                   |    |        | 053675             | 053640             |
| Chuck diameter                            | A  | mm     | 740                | 920                |
| Through hole                              | B  | mm     | 275                | 378                |
|                                           | C  | mm     | 740                | 920                |
|                                           | D  | mm     | 510                | 550                |
|                                           | E  | mm     | 463.6              | 463.6              |
|                                           | F  | mm     | 562                | 724                |
|                                           | G  | mm     | M24                | M24                |
|                                           | H  | mm     | 500                | 540                |
| Chuck height                              | H1 | mm     | 548                | 588                |
|                                           | H2 | mm     | 492                | 532                |
|                                           | J  | mm     | 7                  | 7                  |
|                                           | K  | mm     | 720/6xM8           | 890/6xM8           |
|                                           | L  | mm     | 71.5               | 73.5               |
| Connection for air hoses                  | N  | inch   | G 3/4"             | G 3/4"             |
|                                           | O  | mm     | 51.5               | 51.5               |
|                                           | P  | mm     | 3x29               | 3x31               |
| Centering jaws axial stroke               | Q  | mm     | 100                | 125                |
|                                           | a  | mm     | 75                 | 75                 |
|                                           | a1 | mm     | 62                 | 62                 |
|                                           | b  | H7     | 25.5               | 25.5               |
|                                           | c  | inch   | 3/32" x 90°        | 3/32" x 90°        |
| Jaw mounting bolts                        | d  | mm     | M20                | M20                |
| Jaw mounting bolts                        | d1 | mm     | M20                | M20                |
|                                           | e  | min.   | 18                 | 18                 |
|                                           | e1 | min.   | 20                 | 20                 |
|                                           | f  | max.   | 160                | 200                |
|                                           | f1 | max.   | 110                | 110                |
|                                           | g  | mm     | 199                | 221                |
|                                           | g1 | mm     | 160                | 160                |
|                                           | r  | min.   | 197                | 252                |
|                                           | r1 | min.   | 180                | 250                |
|                                           | α° | deg.   | 15                 | 15                 |
| Speed max.                                |    | r.p.m. | 850                | 600                |
| Gripping force compensating jaws at 6 bar |    | kN     | 90                 | 140                |
| Gripping force centering jaws at 6 bar    |    | kN     | 80                 | 110                |
| Jaw stroke compensating jaws              |    | mm     | 14 = ±7            | 16 = ±8            |
| Jaw stroke centering jaws                 |    | mm     | 9                  | 12                 |
| Weight (without top jaws)                 |    | kg     | 1000               | 1900               |
| Operating pressure min./max.              |    | bar    | 2/10               | 2/10               |