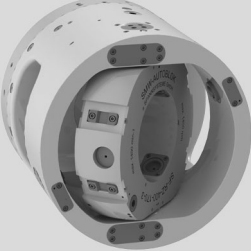
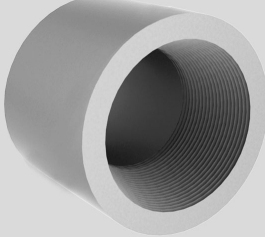
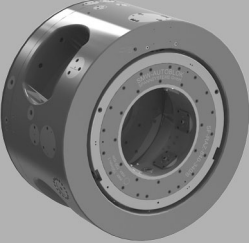
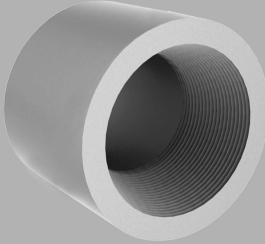
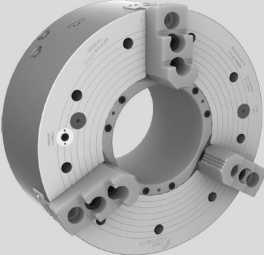
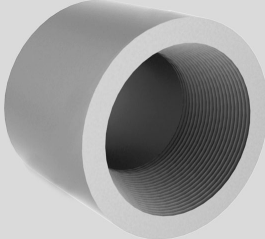
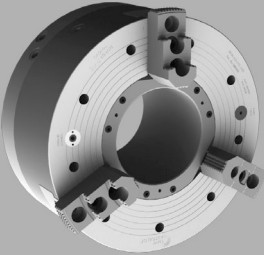
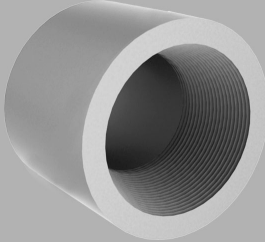
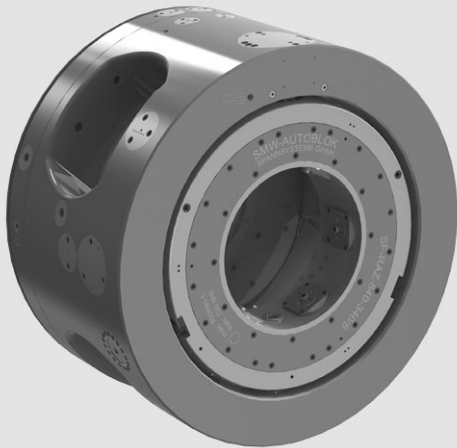


CHUCK	APPLICATION	OCTG PRODUCT	CUSTOMER BENEFITS
<b>SF-RZ</b> Page 28 	<b>NEW</b> Hydraulic ring indexing chuck for threading of couplings in <b>1 set up</b> with the original SMW Type SF-RZ (3 jaw self centering clamping).		<ul style="list-style-type: none"> <li>▪ <b>3 jaw self centering clamping</b></li> <li>▪ <b>Quick jaw movement</b> more couplings per hour</li> <li>▪ Compact design and light weight</li> <li>▪ Easy retrofit on existing machines</li> </ul>
<b>SF-RAZ</b> Page 30 	Hydraulic ring indexing chuck for threading of couplings in <b>1 set up</b> with the original SMW Type SF-RAZ (6 jaw clamping: 3 jaw self centering, 3 jaw compensating).		<ul style="list-style-type: none"> <li>▪ <b>6 jaw clamping for low deformation of coupling</b></li> <li>▪ <b>Quick jaw movement</b> more couplings per hour</li> <li>▪ Rigid strong design and highest accuracy for all premium couplings</li> </ul>
<b>BB-N</b> Page 32 	Threading of couplings in 2 set ups with the original SMW Big Bore Type BB-N (3-jaw clamping).		<ul style="list-style-type: none"> <li>▪ <b>Quick jaw movement</b> more couplings per hour</li> <li>▪ Can be used for other work pieces besides coupling</li> <li>▪ O.D. and I.D. clamping</li> </ul>
<b>BB-N ES</b> Page 34 	Threading of couplings in 2 set ups with the original SMW Big Bore Type BB-N ES (3-jaw clamping).		<ul style="list-style-type: none"> <li>▪ <b>Quick jaw movement</b> more couplings per hour</li> <li>▪ Large jaw stroke for easy loading of couplings</li> </ul>

## 2 Position hydraulic ring indexing chuck

- 3 self centering and 3 compensating jaws
- Large evacuation windows for easy chip flow
- Fully automatic and controlled indexing
- Hydraulic actuation



### Application/customer benefits

- Machining of couplings in one set up
- Indexing 180° in 2 seconds
- 6 jaw clamping for perfect roundness of the coupling = ideal for premium threads
- High-Low clamping (roughing-finishing)

### Technical features

- Hydraulic, automatic ring indexing chuck
- All functions controlled by proximity switches
- Extremely accurate and rigid indexing mechanism
- For external clamping only
- Automatic central lubrication

### Standard equipment

Chuck with mounting bolts

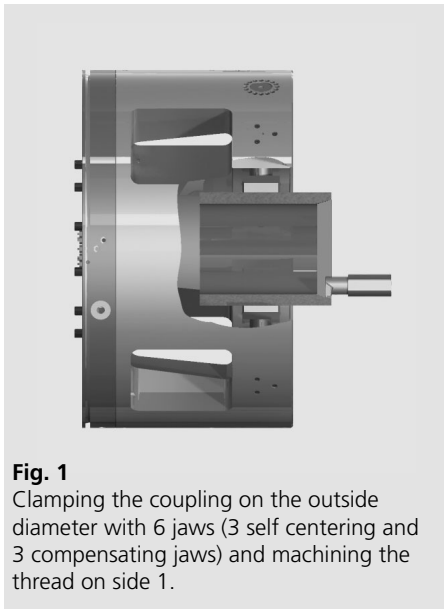
### Ordering example

SF-RAZ 950-3+3 A 20

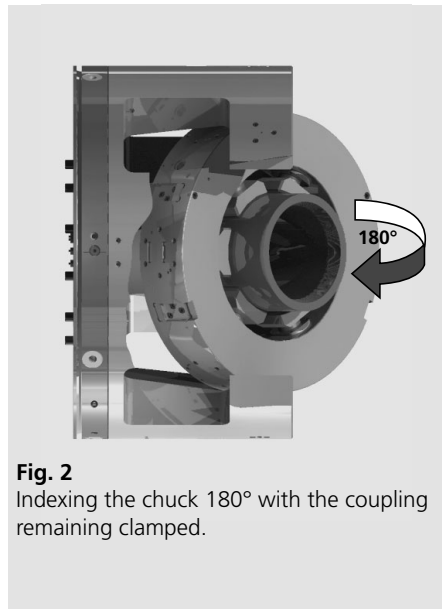
### Accessories

Hydraulic manifold including electric manifold, hose kit

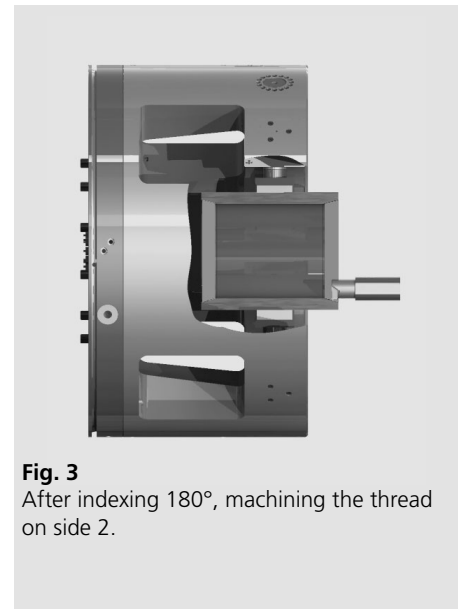
## Machining of a coupling in 1 set up:



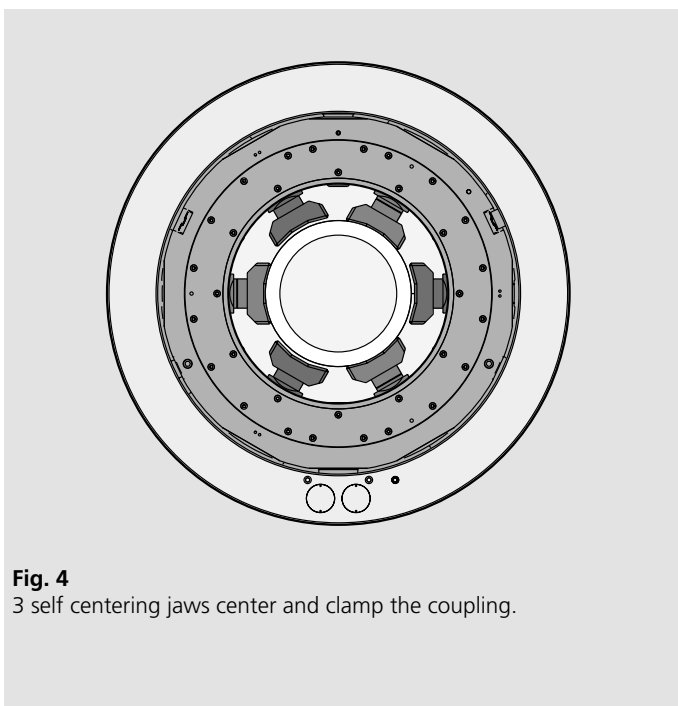
**Fig. 1**  
Clamping the coupling on the outside diameter with 6 jaws (3 self centering and 3 compensating jaws) and machining the thread on side 1.



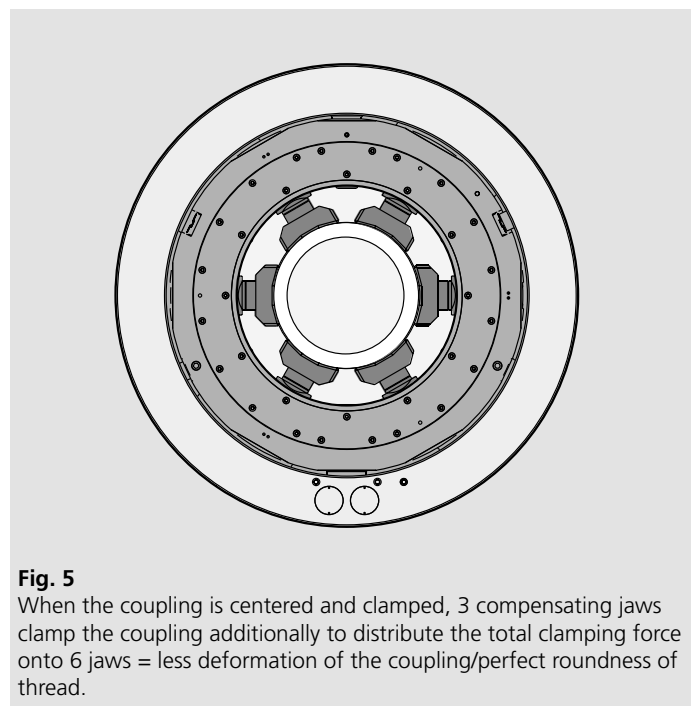
**Fig. 2**  
Indexing the chuck 180° with the coupling remaining clamped.



**Fig. 3**  
After indexing 180°, machining the thread on side 2.



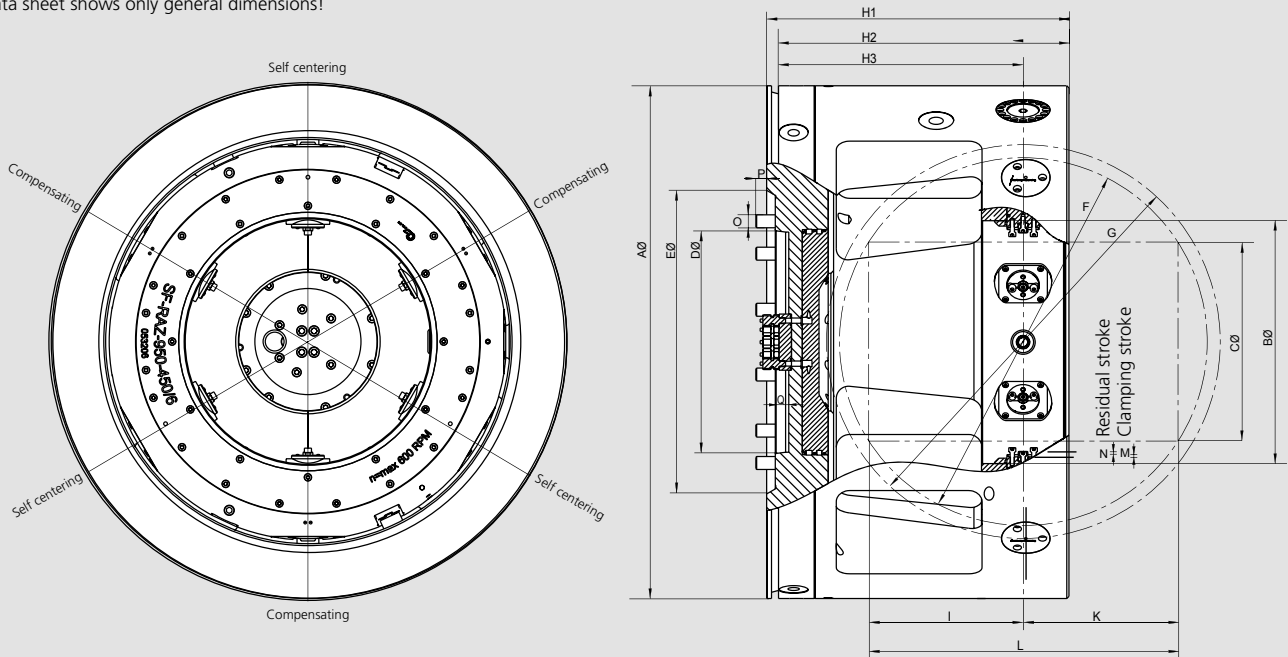
**Fig. 4**  
3 self centering jaws center and clamp the coupling.



**Fig. 5**  
When the coupling is centered and clamped, 3 compensating jaws clamp the coupling additionally to distribute the total clamping force onto 6 jaws = less deformation of the coupling/perfect roundness of thread.

### Main dimensions and technical data

Data sheet shows no jaw dimensions and radial covers for switches and adjustments.  
Data sheet shows only general dimensions!



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

SMW-AUTOBLOK Type			SF-RAZ 750	SF-RAZ 840	SF-RAZ 950	SF-RAZ 1050
Id. No.			053090	053097	053206	053900
Chuck O.D.	<b>A</b>	mm	750	840	950	1050
Indexing ring I.D.	<b>B</b>	mm	250	340	450	550
Max. workpiece O.D.	<b>C</b>	mm	185	275	368	468
Spindle mounting	<b>D</b>		A15	A15	A20	A20
Recess for spindle O.D.	<b>E</b>	mm	435	435	562	562
Max. swing workpiece	<b>F</b>	mm	480	570	680	780
Swing indexing ring	<b>G</b>	mm	526	618	728	828
	<b>H1</b>	mm	456	501	560	610
	<b>H2</b>	mm	440	485	544	594
	<b>H3</b>	mm	355	400	459	509
	<b>I</b>	mm	221.5	250	286	312
	<b>K</b>	mm	221.5	250	286	312
Max. length of workpiece	<b>L</b>	mm	443	500	572	624
Clamping at rec. clamping stroke	<b>M</b>	mm	5.5	5.5	5.5	5.5
Recom. residual stroke	<b>N</b>	mm	4.5	4.5	4.5	4.5
Total jaw stroke	<b>S</b>	mm	10	10	10	10
Mounting bolts	<b>O</b>	mm	M24	M24	M24	M24
	<b>P</b>	mm	37	37	36	36
Max. speed		r.p.m.	800	700	600	530
Max. pressure		bar (psi)	70 (1015)	70 (1015)	70 (1015)	70 (1015)
Max. grip force		kN (lbf)	250 (56202)	250 (56202)	250 (56202)	250 (56202)
Weight		kg (lbs)	1018 (2244)	1200 (2646)	1650 (3638)	2155 (4751)

### Installation of SF-RAZ with hydraulic manifold, electric manifold and hose kit: (All these accessories must be ordered separately)

