

Overview Pipe

Customer's OCTG product:

- Straight pipe
- Bent pipe

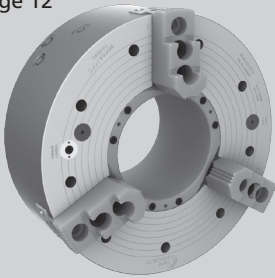
CHUCK

APPLICATION

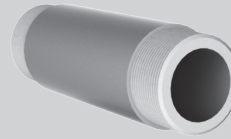
OCTG PRODUCT

CUSTOMER BENEFITS

BB-N
Page 12

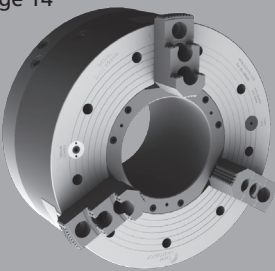


Threading of straight pipe with the original SMW Big Bore Type BB-N.

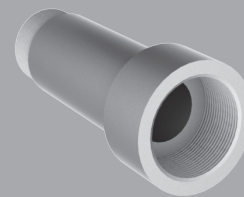


- **Quick jaw movement** more pipe per hour
- Can be used for other work pieces besides piping
- O.D. and I.D. clamping

BB-N-ES
Page 14

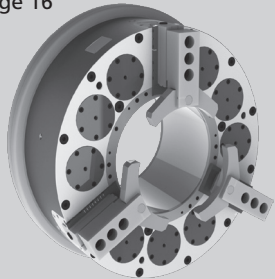


Threading of straight pipe with upset ends with the original SMW Big Bore Type BB-N-ES.

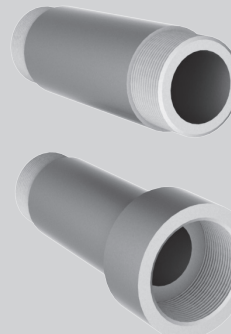


- **Quick jaw movement** more pipe per hour
- Large jaw stroke for easy loading of pipe and less danger of damaging threads when unloading

BB-SC
Page 16

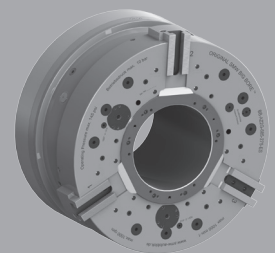


High production **spring clamp** chuck for threading of straight pipe with or without upset ends with the original SMW Big Bore Type BB-SC.

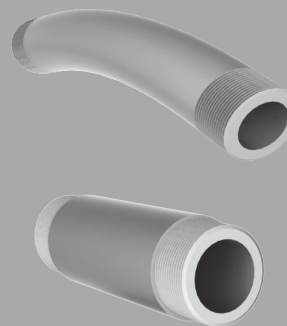


- **Full jaw stroke in 2 seconds** for highest productivity
- Fully sealed/low maintenance for highest availability of the machine
- Safe clamping of pipe even in longer machining processes with spring clamp technology

BB-AZ2G
Page 18

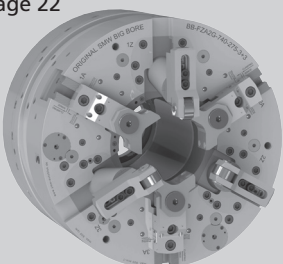


Threading of straight and bent pipe with the original SMW Big Bore Type BB-AZ2G.



- **Self centering or compensating clamping** for universal use
- Quick jaw movement
- External centering device needed when used in compensating mode
- O.D. clamping only

BB-FZA2G
Page 22



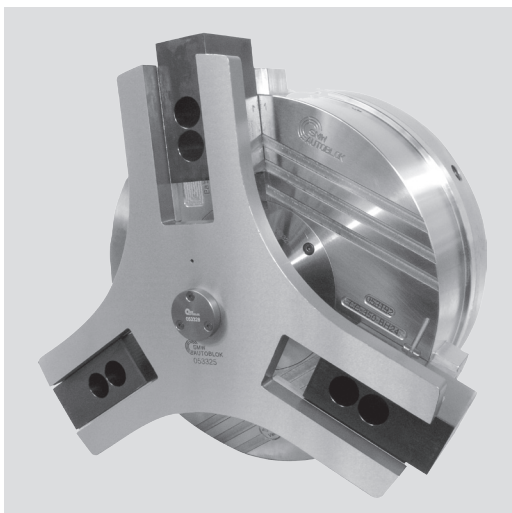
Threading of straight and bent pipe with integrated centering jaws with the original SMW Big Bore Type BB-FZA2G.



- **Integrated centering jaws for the pipe** = no external centering device needed
- Quick jaw movement
- Fully automatic programmable cycle

**Stationary centering and dampening chuck,
pneumatic Ø 240 - 470 mm**

■ with integrated dampener

**Application/customer benefits**

- Axial positioning and centering of tubes when a BB-AZ2G chuck on the main spindle is used in compensating clamping mode
- Integrated hydraulic dampener with fixed and position for controlled deceleration and positioning of tubes
- Suitable for O.D. and I.D. centering

Technical features

- Stationary pneumatic clamping unit with integrated dampener/endstop
- Operating pressure 2–10 bar (29–145 psi)
- Monitoring of endposition of the axial stop via prox. switch (prox. switch not included with the chuck)

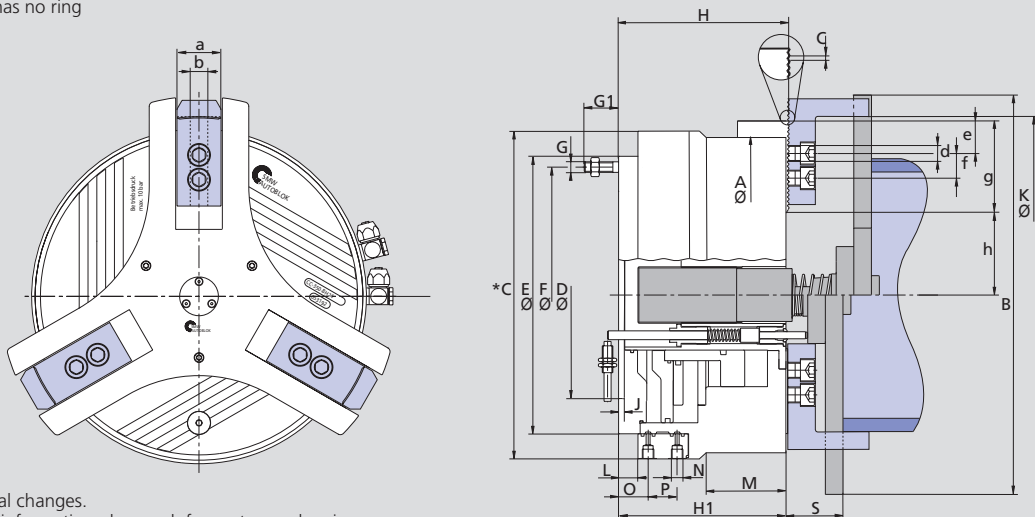
Standard equipment

3-jaw centering chuck
1 set of soft top jaws

Ordering example

Stationary centering chuck CC-350

* Chuck CC-240 has no ring

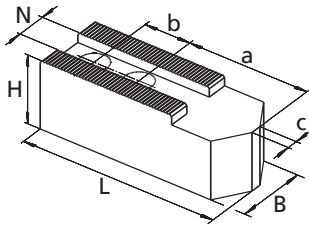


Subject to technical changes.
For more detailed information please ask for customer drawing.

SMW-AUTOBLOK Type			CC 240 Z	CC 350 Z	CC 470 Z
Id. No.			053290	053192	054470
	A	mm	240	360	470
	B	mm	306	446	550
	C	mm	250	372	n.a.
	D H6	mm	195	235	310
	E	mm		315	400
	F	mm	223.8	290.5	374
	G/G1	mm	M12/39	M12/39	M12/26
	H	mm	135.5	191.5	239.5
	H1	mm	134	190	238
	J	mm	6.5	6.5	8
Clamping Ø max.	K	mm	245	365	507
	L	mm	–	21	20
	M	mm	49	92	n.a.
Pneumatic connection	N	inch	G 1/4"	G 1/4"	G 1/2"
min./max.	S	mm	45/95	47/97	50.5/152.5
	a	mm	40	44	60
	o	mm	74	33	37
	p	mm	–	33	26
	b f7	mm	17	21	25.5
Serration	c	inch	1/16" x 90°	1/16" x 90°	3/32" x 90°
Bolts ISO 4762 12.9	d	mm	M12 x 30	M16 x 35	M20 x 45
min.	e	mm	9.5	12	15
T-nut distance min./max.	f	mm	22/41.5	25/72	35/68
Length of serration	g	mm	59	95	99
min./max.	h	mm	53/66	85/109	128/153
Stroke/jaw		mm (inch)	12.7 (0.5")	24 (0.94")	25 (0.98")
Pressure min./max.		bar (psi)	2/10 (29/145)	2/10 (29/145)	2/10 (29/145)
Piston area		cm ²	290	486	652
Air consumption/jaw stroke at 6 bar		liter	5.5	13.5	21
Weight (without top jaws)		kg (lbs)	53 (11915)	115 (25853)	260 (58450)

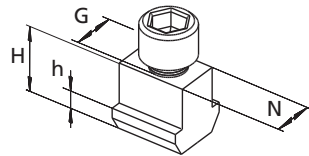
- Top jaws
- T-nuts

AWB-D Soft top jaws

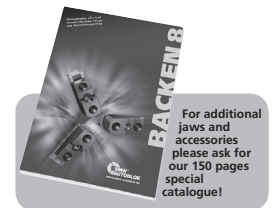


Chuck Type	CC 240 Z	CC 350 Z	CC 470 Z
Jaw type	MWB-D 240	MWB-D 250	MWB-D 470
Jaw Id. No. (set)	233462	013491	081603
B	40	50	60
H	80	80	120
L	90	120	155
N	17	21	25.5
Serration	1/16" x 90°	1/16" x 90°	3/32" x 90°
a	20	62	94
b	22	28	35
kg/set	4.2	10.5	21.5

NST T-nuts



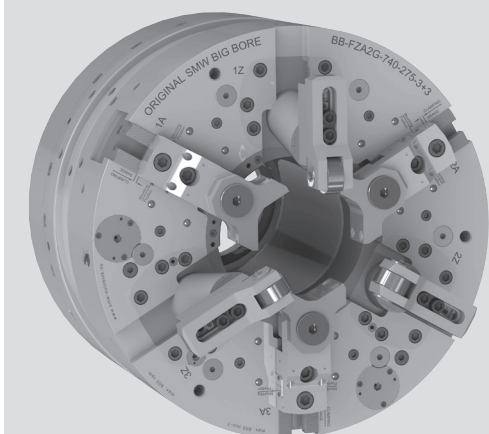
Chuck Type	CC 240 Z	CC 350 Z	CC 470 Z
T-nut type	NST 17-4	NST 21-5	NST 21-5
T-nut Id. No./piece	013864	033429	014812
N	17	21	25.5
H	26.5	30	29
h	9.5	11	11
G	M12	M16	M20
Bolt ISO 4762 12.9	M12 x 30	M16 x 35	M20 x 40



BIG BORE® BB-FZA2G

Front-end pneumatic 6-jaw sequence chucks EXTRA LARGE THROUGH HOLE Ø 275 - 390 mm

- chuck size 740 - 920
- 3 integrated centering jaws and 3 compensating jaws



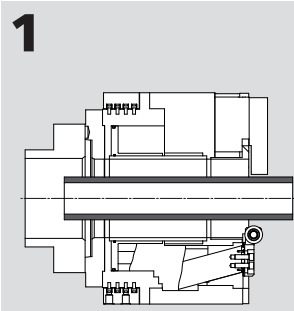
Application/customer benefits

- Extra long axial and radial stroke for centering jaws
- Adjustability of the axial centering position for pipe threading
- Extra long rapid and clamping stroke (1 1/2" total) for compensating jaws
- Stroke control for centering jaws
- Stroke control for each compensating jaw
- Pressure control

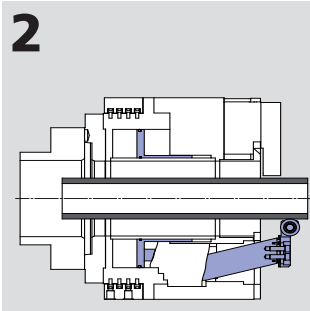
Technical features

- 3+3 jaw air chuck with 3 integrated centering jaws and 3 compensating jaws
- Integrated centering jaws move axially forward to center the pipe exactly at the area to be threaded
- For external clamping only
- Fully automatic sequence is programmable
- Extra long jaw stroke
- It is possible to adjust the axial centering position through the radial position of the centering jaws

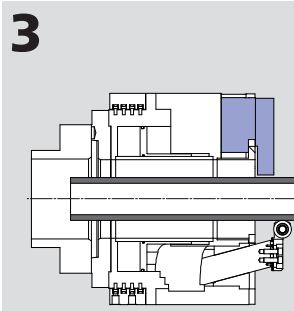
Machining of bent pipe with chuck with integrated centering jaws:



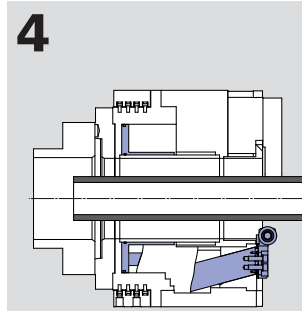
Chuck open, load pipe.



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



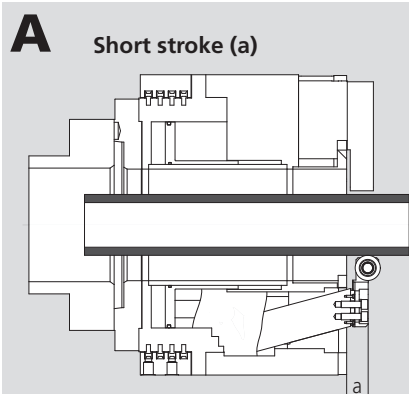
Compensating jaws pick up the pipe at the centered position.



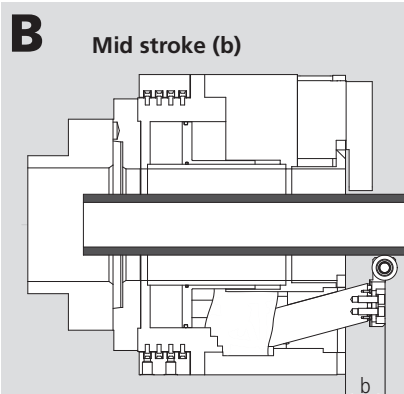
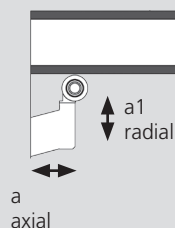
Centering jaws open and retract back axially into the chuck body. The pipe can now be machined.

Adjustability of the axial centering position

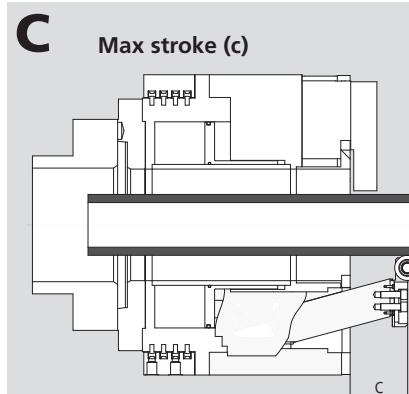
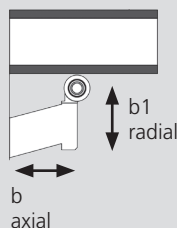
By changing the radial position of the top jaws, the axial centering position can be changed. The axial centering position is dependent from the radial adjustment of the top jaws.



Axial centering position and radial position of the top jaws.



Axial centering position and radial position of the top jaws.



Axial centering position and radial position of the top jaws.

