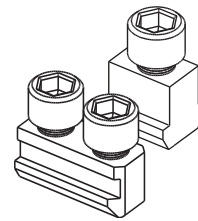
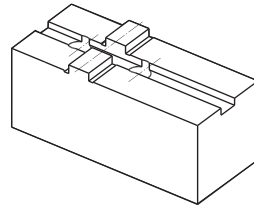
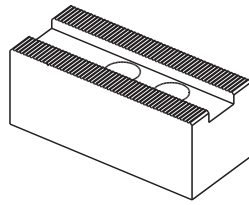
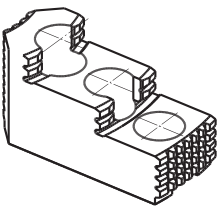


Hard top jaws, soft top jaws, T-nuts

Inch serrated
Metric serrated
Tongue & groove

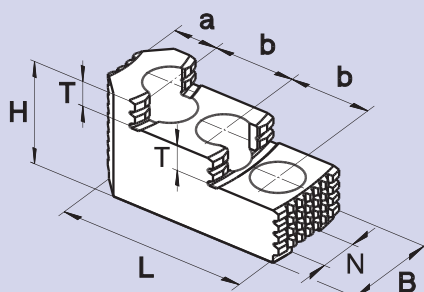


The easy way to mount the right top jaws on your SMW-AUTOBLOK chuck

	Chuck series											Hard top jaws		Soft top jaws	T-nuts		
	Chuck Ø	AN-, AL-	AP-, NT-	IN-, IL-	CL-	BH-	BH-FC	BB-	RC-	RAN	PB-, PBI-, HB-	HYN-, HYL-	Set of 3 hard top jaws Id. No.	Set of 4 hard top jaws Id. No.	Soft top jaws Id. No.	T-nut type	T-nuts Id. No. (see page 208)
INCH SERRATION "D"	125	•											12081306	12081308	12071300	3	12061200
	130					•							12081306	12081308	12071300	2	12061300
	140							•									
	165/170	•	•			•	•	•	•		•		12081636	12081638	12071680	3	73061650
	175/180							•			•	•					
	200				•								-	-	12072500	1	12062500
	210/215	•	•			•	•	•	•		•	•	12082036	12082038	12072130	3	73062150
	226											•					
	260		•										12082626	-	12072620	3	18062632
	250	•				•	•	•	•		•	•	12083036	12083038	12072500	3	73063050
	250				•								-	-	90072500	1	12065020
	315				•												
	305/315	•	•			•	•	•	•		•	•	12083036	12083038	12073000	3	73063050
	400						•		•				12084006	12084008	12074030	1	12063000
	400/450	•					•					•	12084546	12084548	12074040	1	12065020
	400		•										12084546	-	12074040	3	73065030
	500								•				12084546	-	12075050	3	73065030
	500						•	•					12084546	-	12075050	1	12065020
	500-550																
	630											•	12084546	12084548	12075050	1	12065082
500			•														
630			•									12086346	12086348	12075040	1	12065002	
630						•						12084546	-	12075050	1	12065020	
630						•						12086346	12086348	12075040	1	12065020	
800					•												
800			•								•	12086346	12086348	12075040	1	12065002	
METRIC SERRATION "M"	125	•											12081307	12081309	12071301	3	12061200
	130					•							12081307	12081309	12071301	2	12061300
	140							•									
	165/170	•	•			•		•	•		•		12081627	12081629	12071621	4	73061602
	175							•									
	210/215	•	•			•		•	•		•		12082127	12082129	12072121	4	73062101
	250	•				•		•	•		•		12082627	12082629	12072621	4	73062501
	260		•										12082627	-	12072621	4	18062633
	305/315	•	•			•		•	•		•		12083037	12083039	12073001	3	73063050
	400								•				12084007	12084009	12074031	1	12063000
400		•										12084527	-	12074021	2	12064520	
400/450	•					•						12084527	12084529	12074021	1	12064020	
TONGUE & GROOVE "C"	80				•								-	-	90040800	-	-
	100				•								-	-	90041000	-	-
	125				•								-	-	90041300	-	-
	160				•								-	-	90041600	-	-
	160										•		-	-	12041660	-	-
	165/170	•	•							•	•		-	-	12041660	-	-
	200								•	•			-	-	12042060	-	-
	210/215	•	•								•		-	-	12042060	-	-
	250/260	•	•						•	•	•		-	-	12042560	-	-
	305/315	•	•						•	•	•		-	-	12043060	-	-
	400	•	•							•			-	-	12044050	-	-
500												-	-		-	-	
630			•									-	-	12045050	-	-	
800			•									-	-	12045050	-	-	

Hard top jaws, soft top jaws

Inch serrated
Metric serrated
Tongue & groove

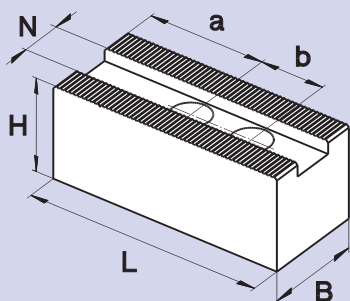


Inch serrated hard top jaws "D"

■ If high concentricity is required jaws have to be ground on the chuck at clamping pressure

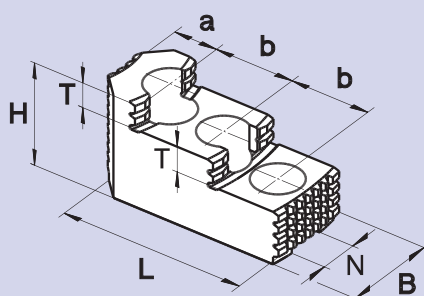
Id. No.*	Serration inch	B mm	H mm	L mm	N mm	T mm	a mm	b mm	Mass kg/jaw
12081306	1/16" x 90°	30	34	58	12	8.5	13	16	0.2
12081636	1/16" x 90°	34	39	65	14	10	18	16.5	0.3
12082036	1/16" x 90°	40	45	82	17	10.5	19	23	0.57
12082626	1/16" x 90°	45	56	100	17	15.5	23	30	0.85
12083036	1/16" x 90°	45	56	105	21	13.5	26	30	0.95
12084006	1/16" x 90°	55	73	120	21	22	30	34	1.70
12085046	3/32" x 90°	55	73	145	25.5	32	46	38	2.2
12084546	3/32" x 90°	60	75	140	25.5	19	38	38	2.5
12086346	3/32" x 90°	70	75	145	25.5	32	46	38	3

* The number refers to a set of 3 jaws; for the set of 4 jaws the final number is not 6 but 8



Inch serrated soft blank top jaws "D"

Id. No.	Serration inch	B mm	H mm	L mm	N mm	a mm	b mm	Mass kg/jaw
12071300	1/16" x 90°	30	30	60	12	29	16	0.3
12071680	1/16" x 90°	30	35	70	14	38	16.5	0.42
12072130	1/16" x 90°	35	40	90	17	47	23	0.85
12072620	1/16" x 90°	40	45	110	17	60	30	1.23
12072500	1/16" x 90°	45	45	110	21	60	30	1.25
90072500	1/16" x 90°	60	60	120	25.5	64	34	2.6
12073000	1/16" x 90°	50	50	125	21	73	30	1.85
12074030	1/16" x 90°	60	60	140	21	81	34	3.2
12074040	3/32" x 90°	60	60	140	25.5	75	38	3.2
12075050	3/32" x 90°	60	60	170	25.5	105	38	3.6
12075040	3/32" x 90°	75	75	160	25.5	97	38	5.5
12075140	3/32" x 90°	60	60	205	25.5	104	38	4.5

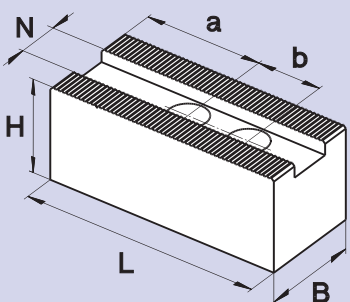


Metric serrated hard top jaws "M"

■ If high concentricity is required jaws have to be ground on the chuck at clamping pressure

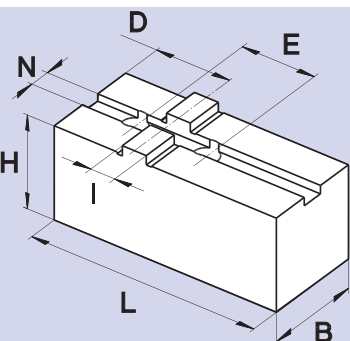
Id. No.*	Serration mm	B mm	H mm	L mm	N mm	T mm	a mm	b mm	Mass kg/jaw
12081307	1.5 x 60°	30	34	58	12	8.5	13	16	0.2
12081627	1.5 x 60°	34	39	67	12	10	14	20	0.31
12082127	1.5 x 60°	40	45	86	14	10.5	19	25	0.60
12082627	1.5 x 60°	45	56	100	16	15.5	23	30	0.85
12083037	1.5 x 60°	45	56	105	21	13.5	26	30	0.95
12084007	1.5 x 60°	55	73	120	21	22	30	34	1.70
12084047	1.5 x 60°	55	73	145	25.5	32	46	38	2.2
12084527	1.5 x 60°	60	75	140	22	19	38	38	2.5

* The number refers to a set of 3 jaws; for the set of 4 jaws the final number is not 7 but 9



Metric serrated soft blank top jaws "M"

Id. No.	Serration mm	B mm	H mm	L mm	N mm	a mm	b mm	Mass kg/jaw
12071301	1.5 x 60°	30	30	60	12	29	16	0.3
12071621	1.5 x 60°	30	35	70	12	34	20	0.42
12072121	1.5 x 60°	35	40	90	14	47	25	0.85
12072621	1.5 x 60°	45	45	110	16	60	30	1.3
12073001	1.5 x 60°	50	50	125	21	73	30	1.85
12074021	1.5 x 60°	60	60	140	22	75	38	3.2
12074031	1.5 x 60°	60	60	140	21	81	34	3.2
12074041	1.5 x 60°	60	60	140	25.5	75	38	3.2



Tongue & groove soft blank top jaws "C"

■ American Standard Tongue & groove

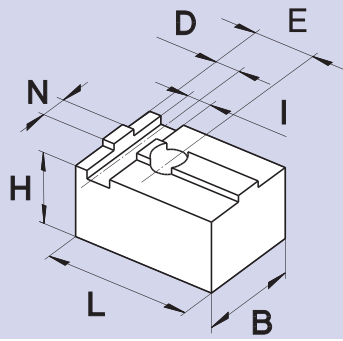
Id. No.	B mm	H mm	L mm	N mm	D mm	E mm	I mm	Mass kg/jaw
12041660	30	35	80	7.94	30	38.1	12.68	0.58
12042060	40	40	100	7.94	35	44.4	12.68	0.92
12042560	50	50	120	12.70	42	54	19.03	1.25
12043060	50	50	140	12.70	50	63.5	19.03	2.15
12044050	60	60	165	12.70	60	76.2	19.03	3.6
12045050	75	75	165	12.70	60	76.2	19.03	5.5

Soft top jaws, T-nuts

Tongue & groove



For further jaws and accessories please ask for our 150 pages special catalogue!

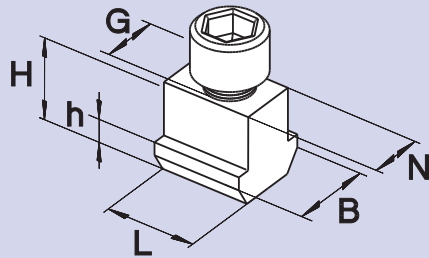


Tongue & groove soft blank top jaws "C"

- DIN standard tongue & groove
- For CL-C chucks

Id. No.	B mm	H mm	L mm	N mm	D mm	E mm	I mm	Mass kg/jaw
90040800	30	30	38	8	8	14	8	0.18
90041000	30	30	48	8	8	20	8	0.23
90041300	35	35	57	14	27	27	16	0.40
90041600	40	40	75	18	34	34	18	0.72

NST



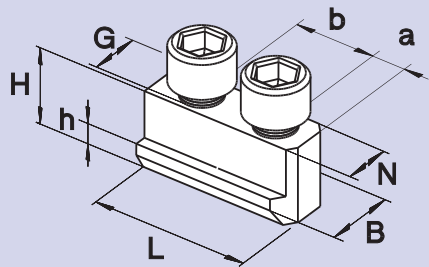
Single T-nut NST

- Type 1 (see table at page 244)

Id. No.	B mm	H mm	L mm	N mm	G mm	h mm
12063000	29	25	24	21	M16	11
12064020	35	34.5	30	22*	M20	15
12065020	35	34	30	25.5	M20	15
12065082	36	34	30	25.5**	M20	15
12065002	40	40	32	25.5**	M20	15.5

*22 mm guide in the top jaw and 25.5 mm guide in the master jaw
**25.5 mm guide in the top jaw and 28 mm guide in the master jaw

NSTE

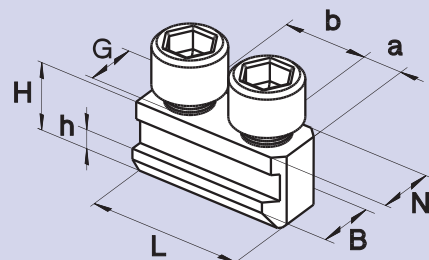


Double T-nut NSTE

- Type 2 (see table at page 244)

Id. No.	B mm	H mm	L mm	N mm	G mm	a mm	b mm	h mm
12061300	17	15	30	12	M8	7	16	6.5
73064030	31	33	60	21	M16	13	34	14.5
12064520	31	33	70	22	M20	16	38	14.5

NSTE

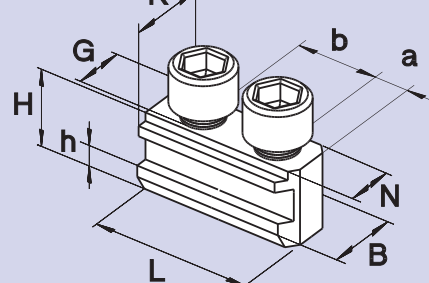


Double T-nut NSTE

- Type 3 (see table at page 244)

No.	Id. No.	B mm	H mm	L mm	N mm	G mm	a mm	b mm	h mm
	12061200	15	15	32	12	M8	6.5	16	6.5
	73061650	17	18.5	32	14	M10	8	16.5	6.5
	73062150	19	20.5	43	17	M12	10	23	7.5
	18062632	19	20.5	50	17	M12	10	30	7.5
	73063050	25	26.5	56	21	M16	13	30	10
	73065030	31	33	70	25.5	M20	16	38	14.5

NSTE-M



Double T-nut NSTE-M

- Type 4 (see table at page 244)
- For metric serrated master jaws to use existing Kitagawa top jaws

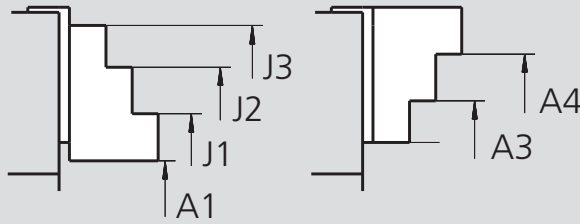
No.	Id. No.	B mm	H mm	L mm	N mm	K mm	G mm	a mm	b mm	h mm
	73061602	17	18.5	36	12	14	M10	8	20	6.5
	73062101	19	20.5	45	14	17	M12	10	25	7.5
	18062633	19	20.5	50	16	17	M12	10	30	7.5
	73062501	25	26.5	56	16	21	M12	13	30	10

Clamping ranges with standard stepped hard top jaws

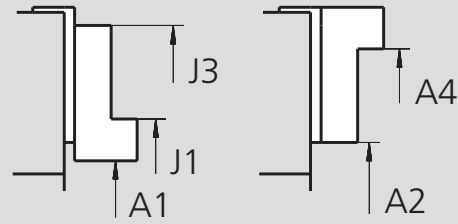
■ Standard chucks Ø 125 - 800 mm



2 step top jaws



1 step top jaws*



Chuck diameter	Chuck type	Top jaws Id. No.		A1 mm	A2 mm	A3 mm	A4 mm	J1 mm	J2 mm	J3 mm
		Serr. "D"	Serr. "M"							
125	AN-, AL-,	12081306	12081307	10-54	-	54-92	90-120	56-100	90-135	125-170
165-170	AN-, AL-, AP-, NT-,	12081636	12081627	14-80	-	62-125	110-155	65-125	115-175	145-210
210-215	AN-, AL-, AP-, NT-,	12082036	12082127	20-100	-	72-150	150-200	75-150	145-230	190-265
250	AN-, AL-,	12083036	12082627	20-115	-	105-205	190-235	80-165	155-250	230-325
260	AP-, NT-,	12082626	12082627	20-130	-	105-215	180-245	80-180	155-260	220-330
315	AN-, AL-, AP-, NT-,	12083036	12083037	30-170	-	120-265	205-300	95-225	165-310	240-380
400	AN-, AL-,	12084546	12084527	52-205	-	180-330	280-370	140-285	240-385	330-480
400	AP-, NT-,	12084546	12084527	35-200	-	165-325	260-370	125-280	220-380	315-480
500	IN-D, IL-D	12086346*	-	80-320	125-365	-	320-475	180-420	-	370-610
630	IN-D, IL-D	12086346*	-	80-440	125-485	-	320-600	180-540	-	370-730
800	IN-D, IL-D	12086346*	-	80-610	125-655	-	320-760	180-710	-	370-900
130	BH-, BH-	12081306	12081307	10-58	-	55-97	90-120	58-105	90-140	125-175
140	BB-, BB-	12081306	12081307	16-65	-	55-105	90-130	65-110	98-148	132-182
165	BH-, BH-FC, RC-	12081636	12081627	12-80	-	62-125	110-155	62-125	105-170	145-210
175	BB-D, BB-M	12081636	12081627	25-92	-	74-138	120-165	74-138	118-185	155-220
180	HYND-S	12081636	12081627	27-95	-	77-140	125-170	77-140	120-185	160-225
210	BH-, BH-FC, RC-, HYND-S	12082036	12082127	14-100	-	65-150	140-200	65-150	135-230	180-265
210	BB-D, BB-M	12082036	12082127	25-100	-	80-150	155-200	80-150	150-230	195-265
226	HYND-S	12082036	12082127	24-110	-	75-160	150-215	75-160	145-240	190-275
250	BH-, BH-FC, RC-, HYND-S	12083036	12083037	20-115	-	105-205	190-235	80-165	155-250	230-325
250	BB-D, BB-M	12083036	12083037	25-115	-	115-205	200-235	85-165	165-250	240-325
305	RC-D, RC-M	12083036	12083037	25-160	-	120-250	205-290	85-215	165-300	240-370
315	BH-, BH-FC, HYND-S	12083036	12083037	40-170	-	135-265	220-300	100-225	180-310	250-380
315	BB-D, BB-M	12083036	12083037	75-170	-	165-265	250-300	130-225	210-310	320-415
400	RC-	12084006	12084007	90-250	-	195-355	285-380	155-315	240-400	330-490
400	BH-, BH-FC, HYND-S	12084546	12084527	52-205	-	180-330	280-370	140-285	240-385	330-480
450	BH	12084546	12084527	52-265	-	180-390	280-430	140-345	240-445	330-540
500	BH	12084546	-	115-325	-	240-450	340-480	200-410	300-510	395-610
500	BH-FC	12084546	-	90-320	-	220-445	320-480	175-400	275-500	370-600
500	HYDL-S	12084546	-	150-320	-	275-445	375-480	230-400	330-500	430-600
550	HYDL-S	12084546	-	200-370	-	330-500	430-535	285-455	385-555	485-655
630	BH	12086346	-	195-420	240-465	-	440-600	295-520	-	490-715
630	BH-FC	12084546	-	135-440	-	260-565	360-600	220-520	315-620	415-720
630	HYDL-S	12084546	-	230-450	-	360-575	460-600	315-530	415-630	515-730
800	BH	12086346	-	195-590	240-635	-	440-760	295-690	-	490-880
800	HYDL-S	12086346	-	245-595	295-640	-	490-760	345-695	-	540-890

Note: AN means AN-D, AN-M; AL means AL-D, AL-M; AP means AP-D, AP-M; NT means NT-D, NT-M; BH means BH-D, BH-M; BH-FC means BH-D-FC, BH-M-FC; RC means RC-D, RC-M.